



GLOBAL

100-P / 100-S

Single thread chainstitch, hand-stitch
machine

Spare parts & Instruction
manual

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1.Introduction

chains-type hand-stitch machine is one single-thread chainstitch industrial sewing machine with single straight needle and crochet hook. Its stitch is similar to handmade type, it is suitable for medium--thickness fabric, such as cotton, wool, chemical fibre etc. And it is the perfect products for sewing advanced suit, western-style trousers, woman overcoat and fashionable dress etc.

The machine adopt link-type thread take-up, crochet hook thread catching, linear reciprocating looper pushing and spiral bevel gear driving, thus guarantee that the machine working steadily, low noise, operating easily and long life.

II .Main technical specification

1. Max.Sewing Speed: 1000 r.p.m
2. Max.needle gauge: 5-8mm
3. Hand-stitch length: 2-5mm
4. Presser foot lift: 6mm(by knee 10mm)
5. Max.Permitting Thickness: 5mm (woolen cloth or similar stitching material under free condition)
6. Suture specification: 20S 60 S * 3 dacron thread.
7. Needle No.: DP * 5 16#~20#
8. Straight crochet hook No.: 151 S(CP*12) 12-21#
9. Needle bar right-side work space: 270 * 135mm(length * height)
10. Motor power: 380V / 370 W four grade (220V250 W four grade)

III. Adjustment of the machine

1. The adjustment of the hooking looper

When the needle moves downward the lowest position and goes up 1.5mm, the hooking looper point should just reach the center line of the needle, which the hooking looper point is higher than the needle hole 2mm and the intervals between the looper point plane and jag bottom of the needle is 0.05-0.1 mm, the regulating method is to unclamp and regulate screws of hook cam and hook rack.

2. The adjustment of feeding looper

It moves the feeding looper rack to the left limit by rotating upper wheel, then loosens the feeding looper to regulate the screws and adjust the right-and-left position, at last it loosens the feeding looper to regulate the screws to adjust its around position.

3.The synchronous adjustment of the feeding & hook looper

Please unclamp two fastening screws of the feeding cam and rotate the upper wheel until the hook looper point reaches the centerline of the needle, then rotate the feeding looper cam along the lower shaft until the feeding looper point moves to the centerline of the straight needle to fasten the two tightening screws of feeding looper cam. It is vital for the machine to assort the feeding looper with hook looper carefully and iteratively.

V. Malfunctions and treatments :

Malfunction Category		Possible reason	Advised treatment
Stitch is uneven Or incorrect		①there are dusts or fibres among cramps so that the cramp is out of order ②the hook on the wrong position	①take apart cramp to put out dusts and fibres ②regulate the hook
Needle	Upper Jumping	①the needle rod position is incorrect,so as to the direction and position of the hook②the needle point or petiole curved and the needle point dull③ the needle type or number is incorrect④a pair of needles is not on the same vertical plane ⑤hook is on the wrong position⑥the needle rod and hook is on the wrong position⑦the tightness of the thread is too strong, the clamp pressure is large and the straight needle turn left.	①make sure the needle rod is parallel ②make sure the hook point aiming at the straight needle③when the thread tightness is too strong and the straight needle turn left, you should make sure the hook turn left only a little, the thread winding move left, the straight needle point aims at the hook thus the needle will not jump away.
	Lower Jumping	①readjust the needle rod position②change the needle③select fit needle type④readjust a pair of needles on the same vertical plane⑤turn the hook s right-and-left direction⑥is there any standard for the needle rod? Key:on the vertical punch of the needle rod,the distance from looper point is3-4mm ⑦is there any standard for horizontal needle? Key:the horizontal needle reaches the left stop point,the distance from the straight needle is 5-6mm⑧looper position standard:When rotating looper to straight needle centre,the distance between the horizontal needle and the midst of two needle is 1.5-1.8mm	⑨the standard between the needle rod and lower looper: The distance is 4-5mm
Hook silk		①some fabres as silk, nylon,flax, imported cloth etc.with strong performance are easily hooked	②make sure to flat the hook point in time under the condition of too many crooks,the distance is 0.5-1mm
The needle break the thread		①the needle number is not agree with the thread number②pinhole is coarse or the needle is bad③suture are not good④thread-needle is wrong and too tight⑤there is obstruction in the thread rack⑥the clip is too tight	①change the suture ②change the needle ③ put on a better suture ④ thread the needle correctly and unclamp the thread ⑤regulate the rack position⑥ loose clip
Break or reverse needle		①the needle type is incorrect②the upper and the lower cloth edge is not homologous③the curved part is too thick④the take-up rod turns under the highest position⑤too hard or the needle is easy broke⑥the workers operating is unexperienced.	①change the needle②level the upper and the lower cloth edge③reduce the speed④make the take-up rod turn at the highest position⑤rotate the leather belt wheel by hand⑥the needle type should be over 18-20#

IV.Parts sample and fig.No.:

Serial number	number	Name	Quantity	Remark
1	ST128-1	Feeding looper	1	
2	ST128-2	Feeding looper screw	3	1/8*44*5
3	ST128-3	Feeding looper rack	1	
4	ST128-4	Feeding looper regulating block	1	
5	ST128-5	Feeding looper nobbing	1	
6	ST128-6	Feeding looper nobbing screw	1	4*12 Hexagon
7	ST128-7	Feeding looper regulating screw	1	4*16 Hexagon
8	ST128-8	Feeding looper fixed axis	1	
9	ST128-9	Feeding looper cam	1	
10	ST128-10	Feeding looper billiards	2	
11	ST128-11	Feeding cam cotter	1	
12	ST128-12	Bracket	1	
13	ST128-13	Bracket screw	2	5*16 Hexagon
14	ST128-14	Hook cam cotter	1	
15	ST128-15	Hook cam	1	
16	ST128-16	Hook connecting rod	1	
17	ST128-17	Cam fastening screw	4	6*6 fastening

Serial number	number	Name	Quantity	Remark
18	ST128-18	Hook link nobbing screw	1	4*10 Hexagon
19	ST128-19	Hook looper axis	1	
20	ST128-20	Hook looper axis gasket	1	8*13*1 gasket
21	ST128-21	Hook looper rack	1	
22	ST128-22	Hook looper rack nobbing screw	1	4*10 Hexagon
23	ST128-23	Hook looper	1	
24	ST128-24	Hook looper fastening screw	1	4*12 Hexagon
25	ST128-25	Cotter screw	4	19/64*40*8
26	ST128-26	Feeding billiards fixed screw	1	4*10 Hexagon
27	ST128-27	Hook link fixed screw	1	4*8 Hexagon
28	ST128-28	The lower shaft	1	
29	ST128-29	Feeding looper rack gasket	1	8*13*0.5
30	ST128-30	Needle rod	1	
31	ST128-31	Needle gauge	1	
32	ST128-32	Hook needle	1	151S(CP*12)
33	ST128-33	Straight needle	1	
34	ST128-34	Needle plate	1	



