

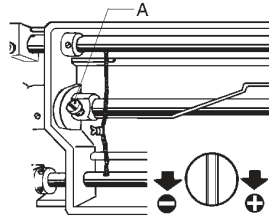
GC6717MD DIRECT DRIVE LOCKSTITCH SEWING MACHINE WITH VERTICAL EDGE TRIMMER

INSTRUCTION BOOK /PARTS CATALOGUE

※MAIN TECHNICAL DATA

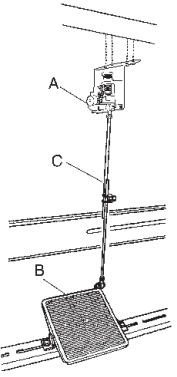
Application	Common materials
Sewing speed	4500spm
Max. Stitch length	4 mm
Presser foot lifting height	6-11mm
Rotating shuttle	Standard automatic oiling
Needle	DB x1 14#-16#
Trimedge width (mm)	Normal 3.2(mm) special 2.4 4.0 4.8 6.4 7.9 9.5

1.ROTATING HOOK OIL AMOUNT ADJUSTMENT



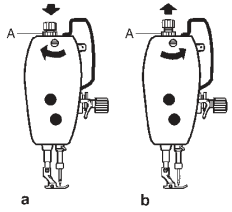
Adjust the oil amount of the rotating hook by turning the oil amount adjusting screw (A). Turn the screw (A) clockwise (in the "+" direction) to increase the oil amount; turn it counter-clockwise (in the "-" direction) to decrease the oil amount.

3.CONNECTION OF THE CLUTCH LEVER WITH THE PEDAL



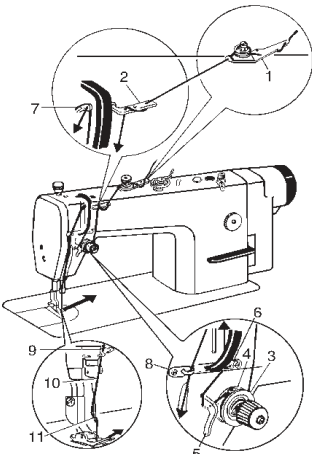
(1) Install speed governor A, link speed governor A and pedal B with tie bar, keep tie bar C vertical.
(2) The optimum tilt angle of pedal is approximately 15 deg.

5.ADJUST THE PRESSURE OF PRESSER FOOT



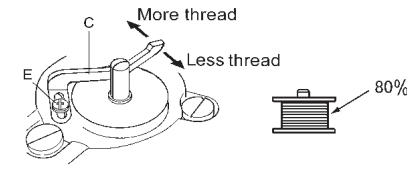
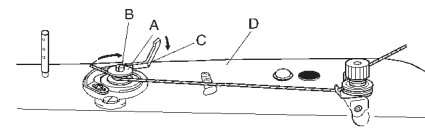
Pressure of the presser foot is adjusted in accordance with thickness of materials to be sewn.
First loosen the lock nut (A), for heavy materials, turn the pressure regulating thumb screw as shown in Fig.(a) to increase the pressure, while for light materials, turn the pressure regulating thumb screw as shown in Fig.(b) to decrease the pressure, the tighten the lock nut (A). The pressure of the presser foot is recommended to be less as long as normal feeding is ensured.

7.THREADING



To thread the needle thread, raise the needle bar to the upper end of its stroke, lead the thread from the spool and perform. Threading as shown in To draw the bobbin thread, hold the end of the needle thread and turn the balance wheel to lower the needle bar and then lift it to its highest position. Pull the ends of needle thread and bobbin thread forward under presser foot.

8.WINDING THE LOWER THREAD

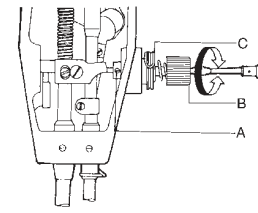
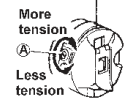
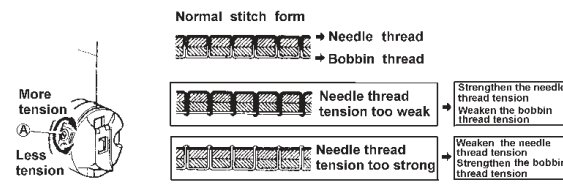


Turn on the power switch. Place the bobbin (A) onto the bobbin winder shaft (B). Wind the thread several times around the bobbin (A) in the direction indicated by the arrow. Push the bobbin presser arm (C) toward the bobbin (A). Raise the presser foot with the lifting lever. Depress the treadle. Lower thread winding will then start. Once winding of the lower thread is completed, the bobbin presser arm (C) will return automatically. After the thread has been wound on, remove the bobbin and cut the thread with the knife (D).

NOTE:

- Loosen the screw (E) and move the bobbin presser (C) to adjust the amount of thread wound onto the bobbin.
- The amount of thread wound onto the bobbin should be a maximum of 80% of the bobbin capacity.

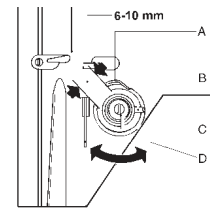
9.THREAD TENSION ADJUSTMENT



Thread tension should be determined in accordance with the stitch obtained by adjusting the tension of the bobbin thread and needle thread.

The tension of the bobbin thread: to be adjusted by turning the tension spring regulating screw of the bobbin case. After adjusting, insert the bobbin into the bobbin case and hold the end of the thread from the bobbin case to hang the bobbin case. If the bobbin case falls slowly and evenly, the proper tension of the bobbin thread is obtained.

The tension of needle thread: to be adjusted by turning the thumb nut.

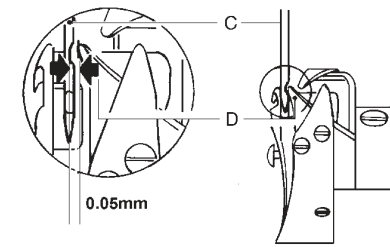
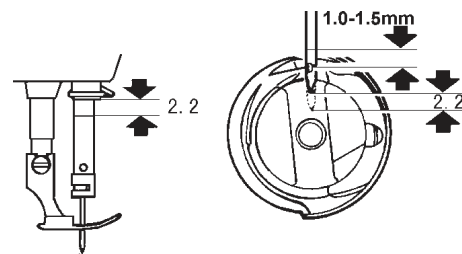


The stroke of the thread take-up spring runs from 6mm to 10mm, when sewing very thin fabrics, reduce the thread take-up spring tension and increase the thread take-up spring stroke, where as increase the thread take-up spring tension and reduce the thread take-up stroke when sewing very thick fabrics.

Adjusting the thread take-up spring tension: First loosen the set screw (A), Turn the tension stud (B) counter-clockwise to decrease the tension of the thread take-up spring (C) to zero. Then turn the tension stud (B) clockwise till the spring (C) comes to the notch of the tension regulating bushing, and again turn the tension stud (B) halfway back (counter clockwise). After the adjustment, tighten the set screw (A).

Adjusting the thread take-up spring stroke: loosen the set screw (B) turn the stud (C) clockwise to increase the stroke or turn stud (C) counter-clockwise to decrease the stroke after the adjustment. Tighten the set screw (B).

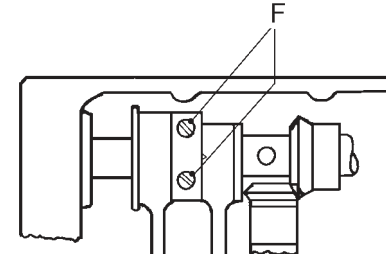
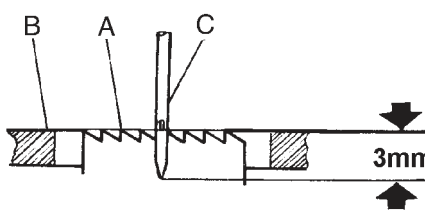
10.ADJUST THE SYNCHRONIZATION OF THE NEEDLE WITH ROTATING HOOK



When lifting the needle bar from its lowest position of the stroke to the distance A, the hook point D of the bobbin should align with the center line of the needle and be 1.0-1.5 mm above upper end of the needle eye.

The clearance between the bottom of the needle notch and the hook tip should be 0.05 mm.

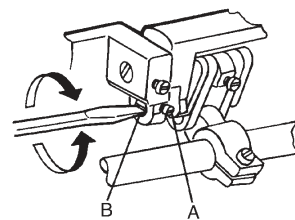
11.ADJUSTING THE POSITION OF FEED DOG AND NEEDLE



Turn the balance wheel, and lower Feed Dog (A). When the top of the feed dog is flush with needle Plate Surface (B), Needle Point (C) should be 3mm below the needle plate surface.

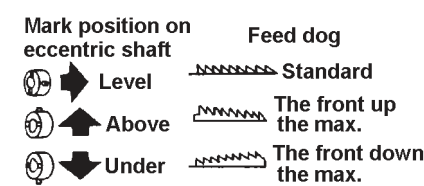
Loosen eccentric wheel screw, turn eccentric wheel and balance wheel separately to adjust the position of needle and feed dog. Then tighten the screw.

12.STITCH LENGTH ERROR ADJUSTMENT

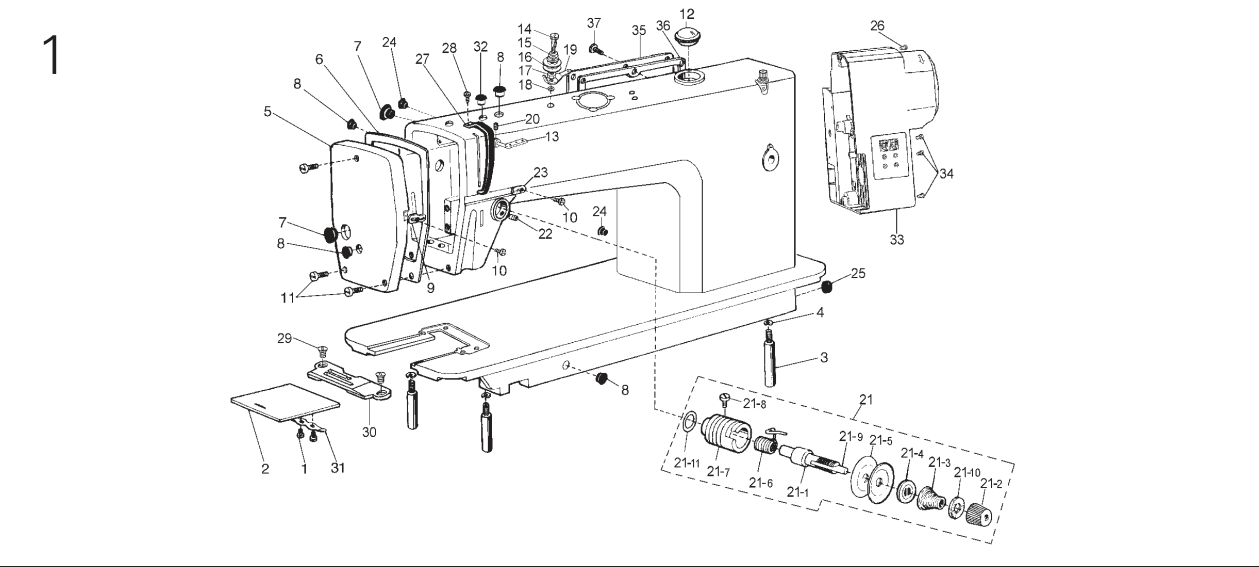


Loosen screw (A) to adjust the stitch length adjusting cam (B). Turn it rightward to narrow the stitch length as forward sewing, and widen it as reverse sewing; turn it leftward to widen the stitch length as forward sewing, and narrow it as reverse sewing.

13.FEED DOG HORI ONTALTY ADJUSTMENT

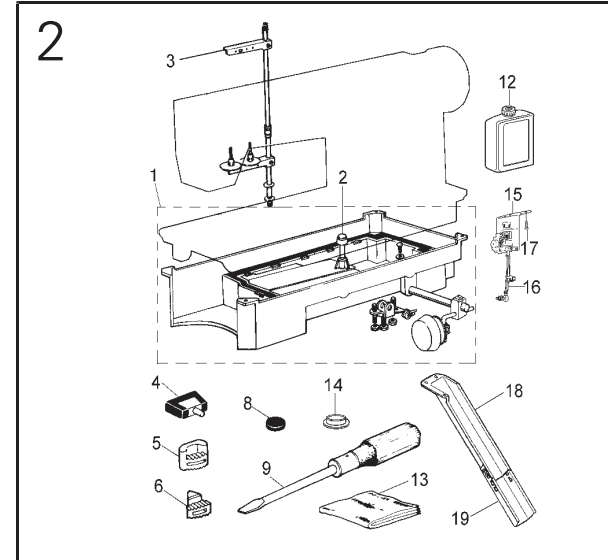


Heighten the front of feed dog to prevent fabric from wrinkling, lower the front of feed dog to prevent fabric from deflection, breaking of hook thread.



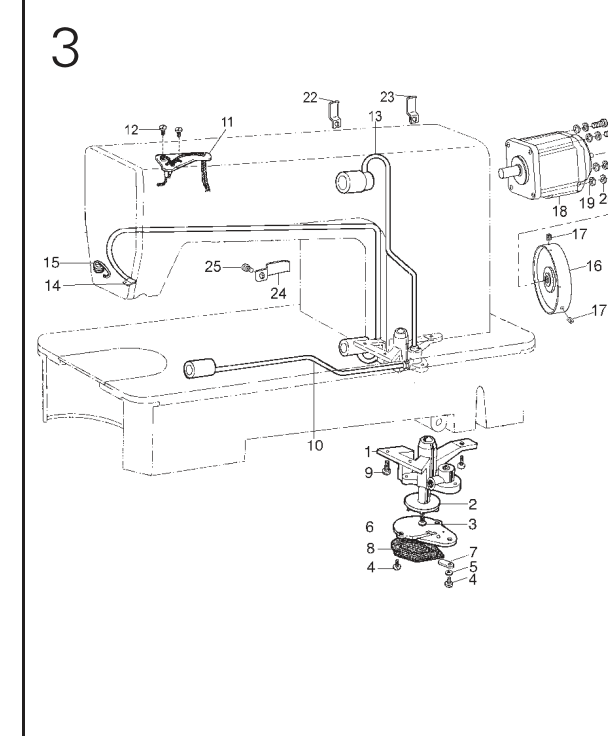
1. ARM AND BED MECHANISM

No.	Ref.No.	Description	Qt.	No.	Ref.No.	Description	Qt.
1	022170003	Screw	2	21-4	022160004	Thread tension releasing disc	1
2	022170001	Slide plate	1	21-5	022160005	Thread tension disc	2
3	048100005	Leg	3	21-6	022160006	Thread take-up spring	1
4	S150601004	Spring washer	3	21-7	022160007	Thread tension regulator bushing	1
5	258100001	Face plate	1	21-8	022160008	Screw	1
6	258100002	Face plate gasket	1	21-9	238100004	Thread tension releasing pin	1
7	022130003--V	Rubber plug(Φ 19)	2	21-10	022160010	Stop disc	1
8	022130004--V	Rubber plug(Φ 11.8)	4	21-11	022160011	O-type ring	1
9	022130005	Thread guide on face plate	1	22	022100013--D	Set screw	1
10	022130006	Screw	2	23	022100014	Thread guide	1
11	022100004	Screw	1	24	022100015--V	Rubber plug(Φ 8.8)	4
12	022180001--V	Oil check window	1	25	022100016	Rubber plug(Φ 27)	1
13	022100010	Thread guide	1	26	S150216033	Screw M5X25	2
14	022150001	Screw	1	27	BXF9768001--W	Thread take-up lever guard	1
15	022150002	Tension spring for pretension	1	28	022200004--D	Screw	1
16	022150003	Thread tension disc	1	29	029100003	Needle plate 1/8"(3.2)	1
17	022150004	Pretension thread guide pad	2	30	022100020	Screw	2
18	S150620001	Spacer	1	31	022170002	Slide plate spring	1
19	022150005	Pretension thread guide	1	32	022100017--V	Rubber plug(Φ 5.7)	1
20	022100011--D	Screw	1	33	258510000	Controller assy	1
21	124130000--W	Thread tension bracket assy	1	34	S150237001	Screw M5X18	3
21-1	022160001	Thread tension stud	1	35	022140001--W	Slide plate	1
21-2	124130001--W	Thread tension nut	1	36	022140002	Washer	1
21-3	124130002	Thread tension spring	1	37	022100006	Screw	8



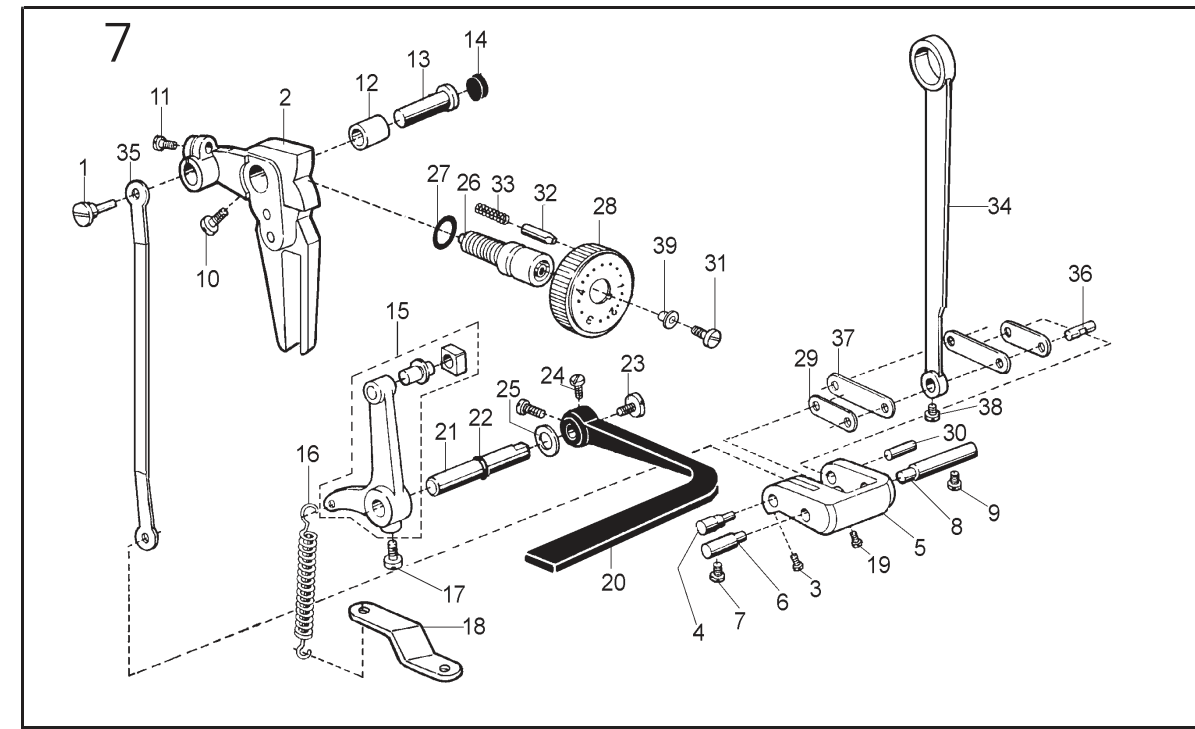
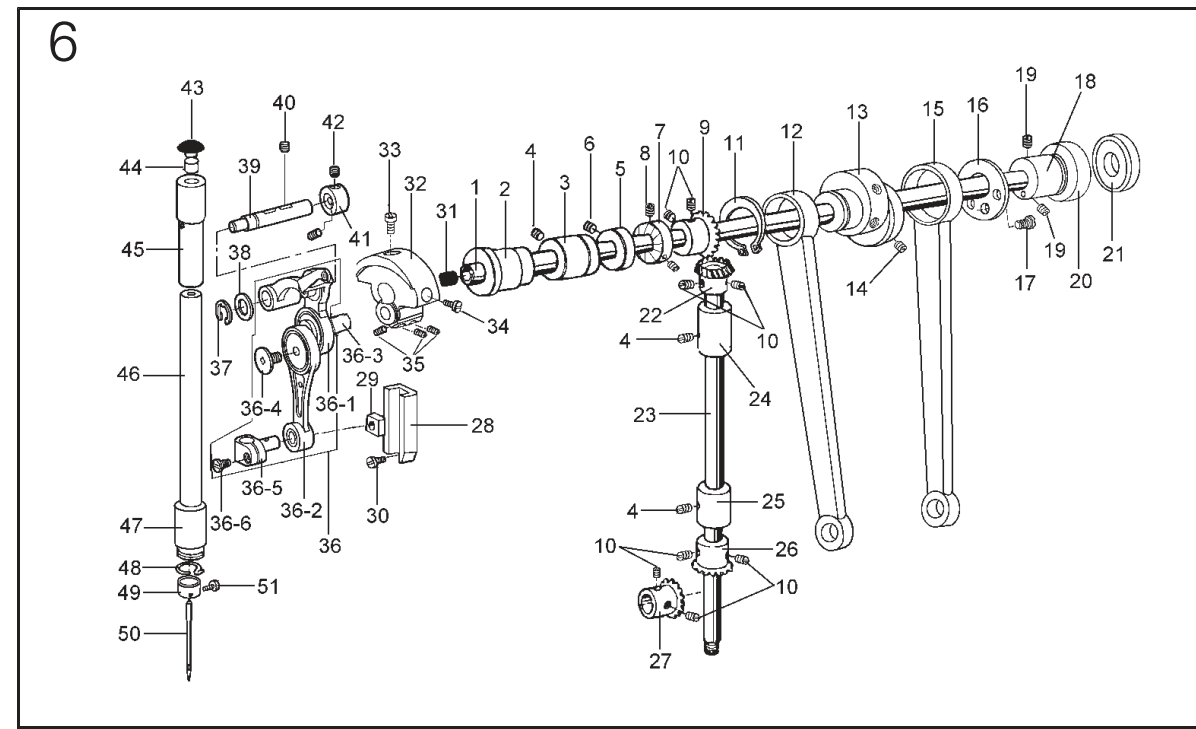
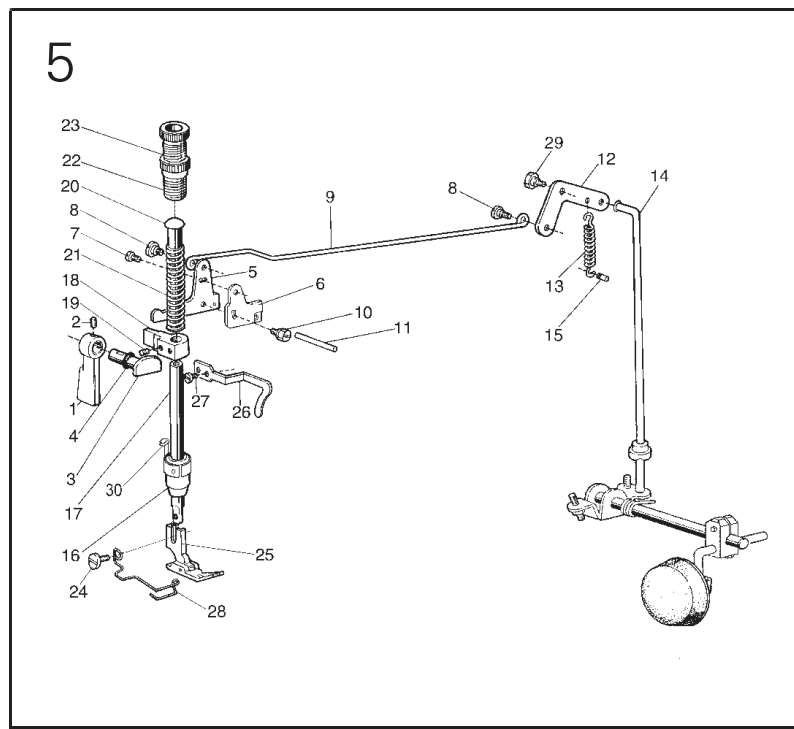
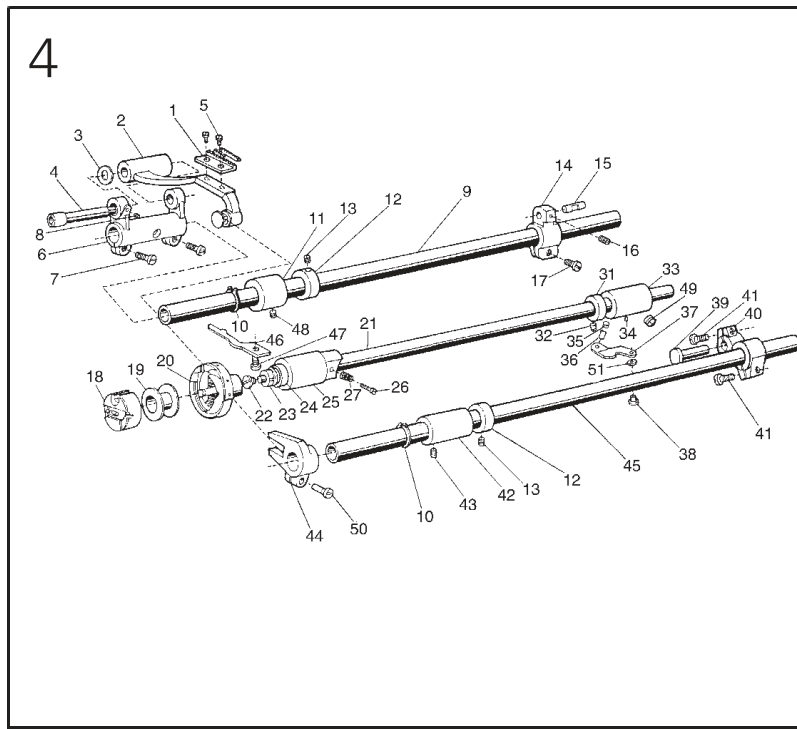
2. OIL RESERVOIR AND ACCESSORIES

No.	Ref.No.	Description	Qt.
1	029F00000	Oil reservoir asm	1
2	165F01001	Knee lifter lifting pin	1
3	006F00030--W	Thread spool asm	1
4	022990000	Hinge with rubber cushion	2
5	022900009--V	Cushion(B)	2
6	022900010--V	Cushion(S)	2
8	W050103001	Magnet block	1
9	W060401018	Screw driv(long)	1
12	022900017	Oil tank	1
13	W060302036	Machine head cover	1
14	238C00006	Magnets	1
15	238C14000	Governor	1
16	238C15000	Rod complete	1
17	S150221002	Wood screw M5x12	4
18	029F00002	Waste bucket (upper)	1
19	028800008	Waste bucket (lower)	1



3. OIL PUMP AND MOTOR MECHANISM

No.	Ref.No.	Description	Qt.
1	022800001	Oil pump	1
2	022800002	Oil pump impeller	1
3	022800003	Screw	1
4	022800004	Screw	3
5	S150601003	Springee washer 3	1
6	022800006	Oil pump fitting plate	1
7	022800007	Oil adjusting plate	1
8	022810000	Oil pump screen asm	1
9	022800009	Screw	3
10	036A20N	Oil pump for hook shaft	1
11	022831	Oil braid fitting plate	1
12	022700015	Screw	2
13	022840N	Oil pump for arm shaft	1
14	022800015	Oil return pipe	1
15	036A00002	Oil filter holder	1
16	238710001	Hand wheel	1
17	S150215001	Screw M5x8	2
18	258500001	Motor	1
19	B084050974	Flat Washer S5	4
20	B082050864	Spring Washer	4
21	B048509294	Screw M5x18	4
22	238C00008	Cord holder	1
23	238C00003	Cord holder	1
24	BXF8423009	Cord holder	1
25	022200019	Screw	1



4. FEEDING AND FEED LIFTING AND ROTATING HOOK MECHANISM

No.	Ref.No.	Description	Qt.
1	029600001	Feed dog	1
2	036411000	Feed bar	1
3	022610006	Washer	1
4	036410002	Shaft for feed bar	1
5	022610004	Screw	2
6	022611001	Feed rock shaft crank	1
7	022612001	Screw	2
8	022200019	Screw	1
9	124600002	Feed rock shaft	1
10	S150617006	C-type stop ring 15	2
11	022600004	Bushing for feed rock shaft	1
12	022620001	Collar for feed rock shaft	2
13	022320002	Screw	4
14	036400003	Feed rock shaft crank(right)	1
15	036400204	Pin	1
16	036550005	Screw	1
17	022640003	Screw	1
18	054A00004	Bobbin case complete	1
19	036400006	Bobbin	1
20	022471000	Rotating hook complete	1
21	036400001	Hook shaft	1
22	022411001	Filter screw	1
23	022411002	Filter	1
24	036470001	Oil seal	1
25	036400010	Hook shaft bushing(left)	1
26	022400005	Oil adjusting screw	1
27	022400006	Coil spring	1
31	022420001	Collar for hook shaft	1
32	022200009	Screw	2
33	036460001	Hook shaft bushing(right)	1
34	022430002	Oil pipe for hook shaft bushing	1
35	036400015	Plunger	1
36	036400016	Plunger spring	1
37	022400010	Guide plate	1
38	022820001	Screw	1
39	022600007	Hinge pin	1
40	036400017	Feed lifting rock shaft crank(R)	1
41	022600016	Screw	2
42	022600012	Bushing for feed lifting shaft(L)	1
43	022200002	Screw	1
44	036484001	Feed lifting fork	1
45	124600003	Feed lifting rock shaft	1
46	022400013	Hook positioner	1
47	022400015	Screw	1
48	022200009	Screw	1
49	022200002	Screw	1
50	022640003	Screw	1
51	S150601004	Washer6	1

5. PRESSER FOOT MECHANISM

No.	Ref.No.	Description	Qt.
1	022710001--w	Presser bar lifter	1
2	B040600294	Screw	1
3	036620001	Presser bar lifting cam	1
4	S150651010	Oil seal(4.5 x 1.8G)	1
5	036631001	Knee lifter lever (left)	1
6	022722001	Tension relasing cam	1
7	022723000	Screw	1
8	022720002	Screw	2
9	022720003	Knee lifter rod	1
10	022700005	Screw	1
11	022700006	Thread releasing pin	1
12	022730001	Knee lifter lever (right)	1
13	022730002	Coil spring	1
14	022730003	Knee lifter connecting rod	1
15	022700008	Pin for spring	1
16	022700009	Bushing for presser bar	1
17	029700001	Presser bar	1
18	022740001	Presser bar guide bracket	1
19	022100013	Screw	1
20	022700012	Presser bar spring guide	1
21	022700013	Presser bar spring	1
22	022750001--w	Thumb screw	1
23	022750002--w	Lock nut	1
24	022700015	Screw	1
25	029701000	Presser foot asm	1
26	022700016	Thread guide	1
27	022200004	Screw	1
28	057700002	Presser foot spring	1
29	022730004	Screw	1

6. ARM SHAFT AND VERTICAL SHAFT THREAD TAKE-UP MECHANISM

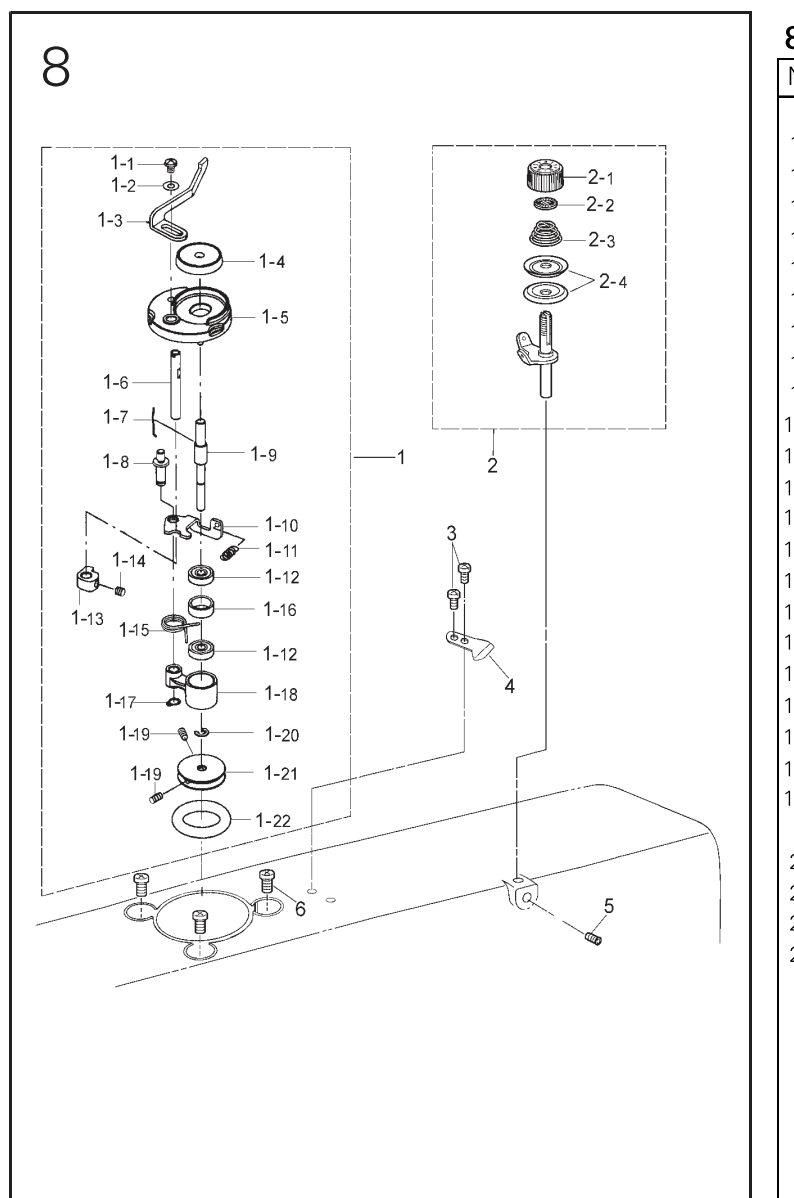
No.	Ref.No.	Description	Qt.
1	258200001	Arm shaft	1
2	022320003	Arm shaft bushing(left)	1
3	022320004	bushing(middle)	1
4	022200002	Screw	3
5	022320001	Collar for arm shaft	1
6	022320002	Screw	2
7	207302001	Friction wheel	1
8	S150212006	Screw M5 x 6	2
9	Z0A180891	Bevel gear for arm shaft	1
10	022220003	Set screw	8
11	022342001	Spacer	1
12	022343001	shaft	1
13	036340001	Eccentric whell	1
14	022200002	Screw	2
15	036550002	rod	1
16	036300004	Spacer	1
17	165330001	Screw	3
18	257200002	Bearing	1
19	BX87459009	Screw M6 x 6	2
20	S150801006	Bearing	1
21	238200004	oil seal	1
22	Z0A180892	shaft(upper)	1
23	022350001	Vertical shaft	1
24	022300011	bushing(upper)	1
25	022300012	bushing(lower)	1
26	Z0A180885	shaft(lower)	1
27	Z0A180886	shaft	1
28	022200018	Guide rail for slide block	1
29	022200020	Slide block	1
30	022200019	Set screw	2
31	022310002	Rubber plug(Φ7.4x10)	1
32	029200001	Needle bar crank	1
33	022200007	Set screw	1
34	022200006	Screw	1
35	BX87459009	Screw M6 x 6	3
36	230221100	Thread take-up crank	1
36-1	BXF9970009	components	1
36-2	BXF8914009	assembly	1
36-3	230100016	Set screw	1
36-4	BXF8688009	Screw SM3.57-40 x 6	1
36-5	BX85863009	Needle rod joints	1
36-6	B96006009	Screw SM3.57-40 x 7	1
37	B062040768	Spacer E6	1
38	BXF8949009	Grommet	1
39	BXF9986009	axis	1
40	B098049074	Screw M6 x 10	1
41	BXF9985009	Shrink-ring	1
42	B098600674	Screw M4 x 4	2
43	022200011--v	Rubber plug	1
44	022200010	Felt plug	1
45	153200004	Needle bar bushing(upper)	1
46	029200002	Needle bar	1
47	153200005	Needle bar bushing(lower)	1
48	022300002	Thread guide	1
49	029200003	Thread guide for needle bar	1
50	S150901001	Needle	1
51	022200017	Screw	1

7. STITCH LENGTH REGULATING MECHANISM

No.	Ref.No.	Description	Qt.
1	036500001	Connecting stud	1
2	057500001	Feed regulator	1
3	036550008	Screw	1
4	036550009	Lever link eccentric shaft	1
5	036550010	Lever regulator	1
6	036580002	Pin(left)	1
7	022640003	Screw	1
8	036580001	Pin(right)	1
9	022640003	Screw	1
10	022540004	Screw of feed regulator	1
11	022640003	Screw	1
12	238300001	Feed regulator bushing	1
13	022500004	Feed regulator shaft	1
14	238300002	Rubber plug (Φ16)	1
15	022550001	Back tacking crank	1
16	022551001	Slide block pin	1
17	057520001	Lever spring	1
18	022500013	Set screw	1
19	057500005	Bracket for spring	1
20	036550007	Screw	1
21	124500004--w	Backtacking lever	1
22	036531001	Backtacking lever shaft	1
23	S150651007	O-ring 6.3 x 1.8G	1
24	022540003	Screw	1
25	022500011	O-ring	1
26	238300003	Feed regulator screw	1
27	124510003	regulating screw	1
28	238300005	Knob	1
29	036558001	Feed rock link	1
30	036550006	Pin	1
31	238300004	Screw	1
32	238300007	Stopper pin	1
33	022500009	Spring for stopper pin	1
34	036550002	rod	1
35	036550003	Feed regulator link	1
36	036400104	Sink shaft	1
37	036558002	Feed rock arm link	2
38	036550005	Screw	1
39	036540004--d	Bush	1

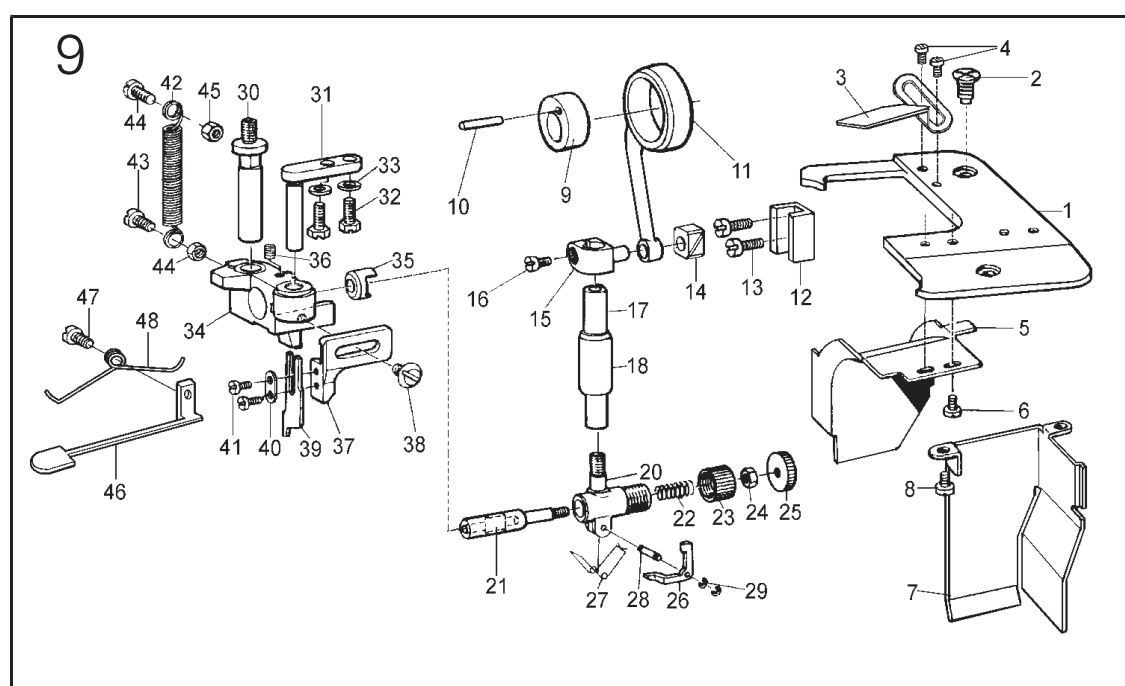
OPTIONAL PARTS LIST

Edge cutting width	Pressure finger	Needle plate	Feed dog	The hopper
2.4mm(3/32) choose	029701000	029100002	029600001	029800003
3.2mm(1/8) choose		029100003		
4.0mm(5/32) choose		029100004		
4.8mm(3/16) choose	029702000	029100005	029600002	029800004
6.4mm(1/4) choose	02276	029100006		
7.9mm(5/16) choose	153720000	029100007		
9.5mm(3/8) choose		029100008		



8. BOBBIN WINDER MECHANISM

No.	Ref.No.	Description	Qt.
1	207107000--w	Bobbin winder complete	1
1-1	S150237046	Screw M4X5	1
1-2	S150633007	Washer 4	1
1-3	207107015	Wrench	1
1-4	207107003	Bobbin support	1
1-5	207107004	Bobbin winder support	1
1-6	207107010	Bobbin winder cam shaft	1
1-7	207107002	Spring	1
1-8	207107012	Bobbin winder lever shaft	1
1-9	207107001	Bobbin winder shaft	1
1-10	207107014	Bobbin winder lever	1
1-11	207107005	Spring	1
1-12	S150866067	Bear 625ZZNR	2
1-13	207107011	Bobbin winder cam	1
1-14	S150212013	Screw M5X5	1
1-15	207107013	Spring	1
1-16	207107007	Bear bushing	1
1-17	S150617001	Retaining ting C6	1
1-18	207107006	Bobbin winder crank	1
1-19	S150299012	Screw M4x6	2
1-20	B062060768	Retaining ting E4	1
1-21	207107008	Bobbin winder wheel	1
1-22	207107009	Rubber ring	1
2	BXF9116009--w	Thread tension complete(S)	1
2-1	BX79078009--w	Nut	1
2-2	BX98669009	Washer	1
2-3	B900609089--d	Spring	1
2-4	B965664009	Tension disc	2
3	022830004	Screw SM3.57	2
4	001100009	Knife	1
5	0222100013--d	Screw	1
6	BXF9118909	Screw M5x6	3



9. CUTTER MECHANISM

No.	Ref.No.	Description	Qt.
1	029800001	Throat plate	1
2	022100020	Screw	2
3	029800002	Waste material guide	1
4	022830004	Screw	2
5	029800101	Waste material chute	1
6	028300034	Screw	2
7	029800104	Waste material guard	1
8	022210009	Screw	2
9	029800006	eccentric cam	1
10	S150403005	eccentric cam pin	1
11	029800007	Knife driving rod	1
12	029800008	Slide block guide	1
13	022200019	Screw	2
14	022200020	Crank slide block	1
15	029800009	connection asm	1
16	036550008	Screw	1
17	029800010	Knife driving stud	1
18	029800011	Bushing	1
20	029800012	retainer	1
21	029800013	Knife driving rod clutch pin	1
22	029800014	Spring	1
23	029800015	Cap	1

24	028100035	Nut	1
25	029800016	Knob	1
26	029800017	Knife release lever	1
27	029800018	Spring	1
28	029800019	Pin	1
29	S150620008	Snap ring	2
30	029800020	Knife driving block stud	1
31	029800021	block	1
32	S150209033	Screw	2
33	217100024	Washer	2
34	029801000	Knife driving block asm	1
35	029801004	Clutch pin bushing	1
36	028700004	Screw	1
37	029800022	Knife holder	1
38	029800023	Screw	1
39	029800024	Knife	1
40	029800025	Washer	1
41	036710006	Screw	2
42	029800026	Tension spring	1
43	022100006	Screw	1
44	022510004	Screw	1
45	022900010	Nut	1
46	029700004	Wrench for knife driving blk	1
47	029700005	Screw	1
48	029700006	Spring	1