



TYPICAL

GK335/1

HIGH SPEED FLAT-BED INTERLOCK MACHINE
FOR ATTACHING ELASTIC LACE WITH CUTTING KNIFE

INSTRUCTION BOOK/PARTS CATALOGUE

XI'AN TYPICAL INDUSTRIES CO.,LTD.

335/1 machine's main technical data

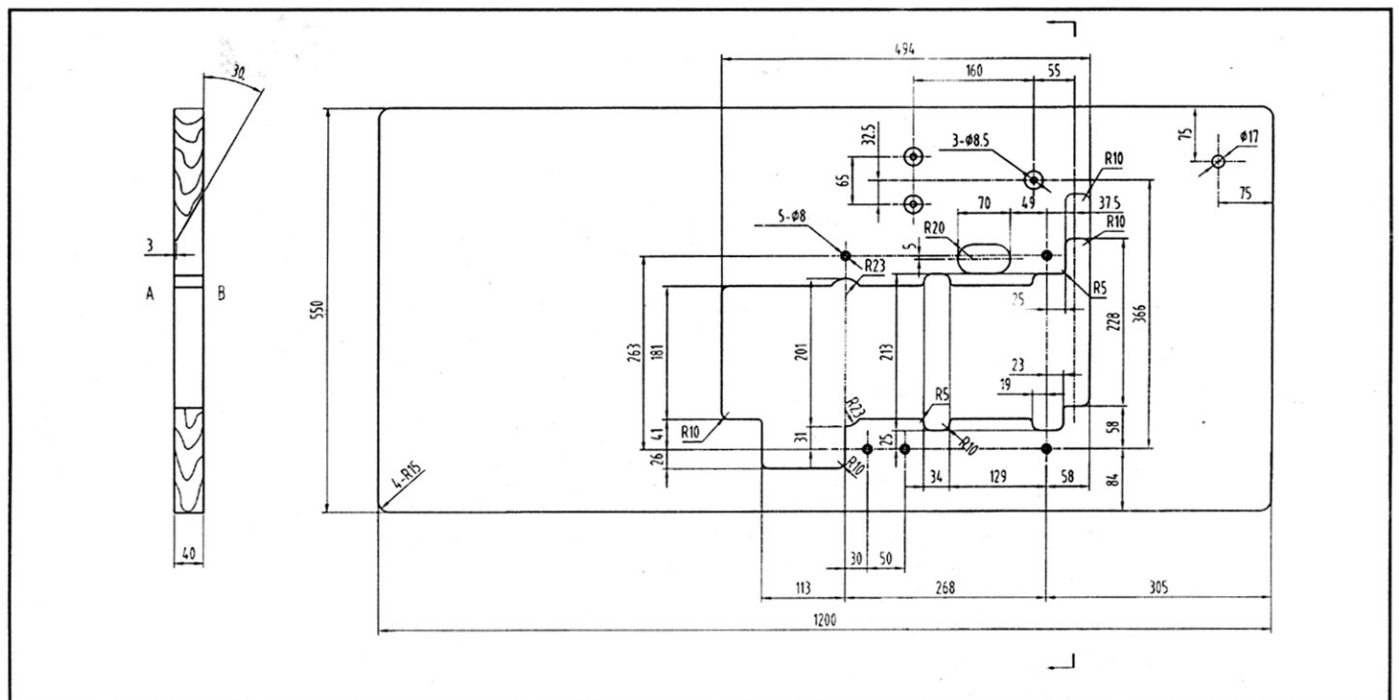
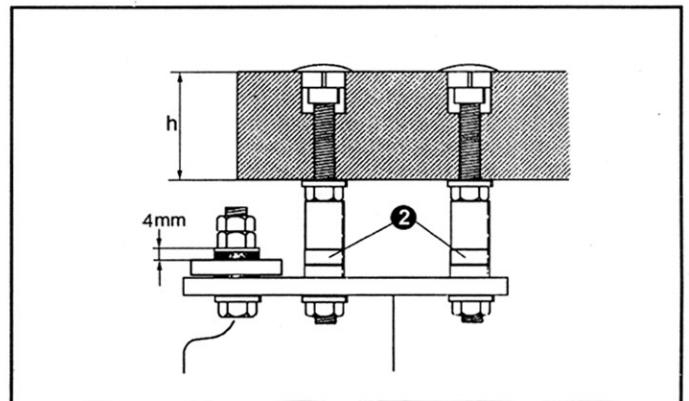
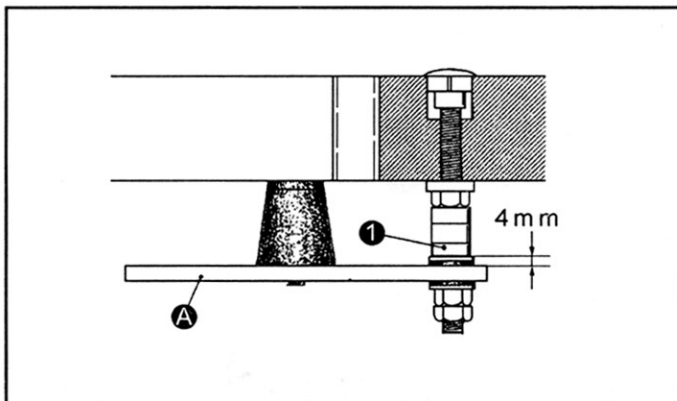
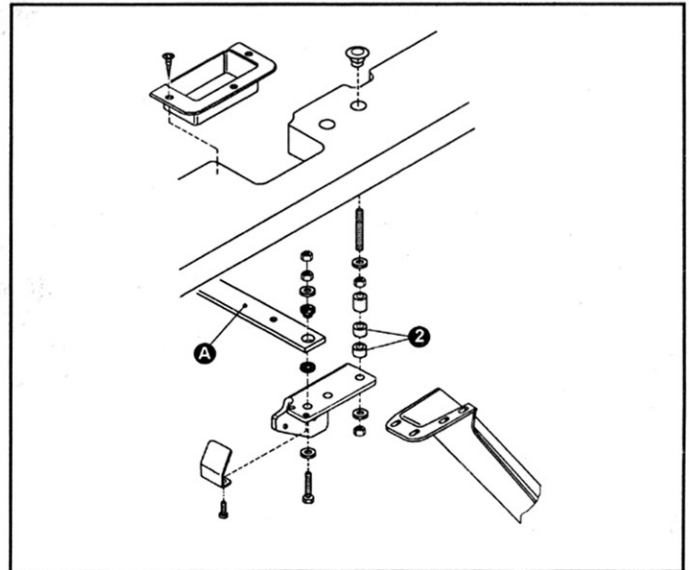
needle gauge: 6.4 5.6 (three - needle) 3.2 4.0 (two - needle)
 max. speed: 4500 rpm
 speed: 4000 rpm

1. Installation

The installation of the supporting board
 Install the supporting board and A machine head
 refers to the illustration.

The quantity of the washer ①②

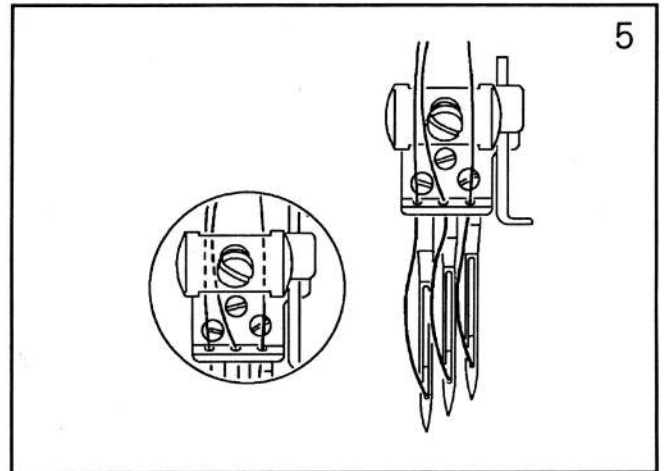
	①	②
40mm	3 × 3 = 9	2 × 2 = 4
45mm	2 × 3 = 6	1 × 2 = 2
50mm	1 × 3 = 3	0



2. Operation

2-1 Adjusting of the thread tension

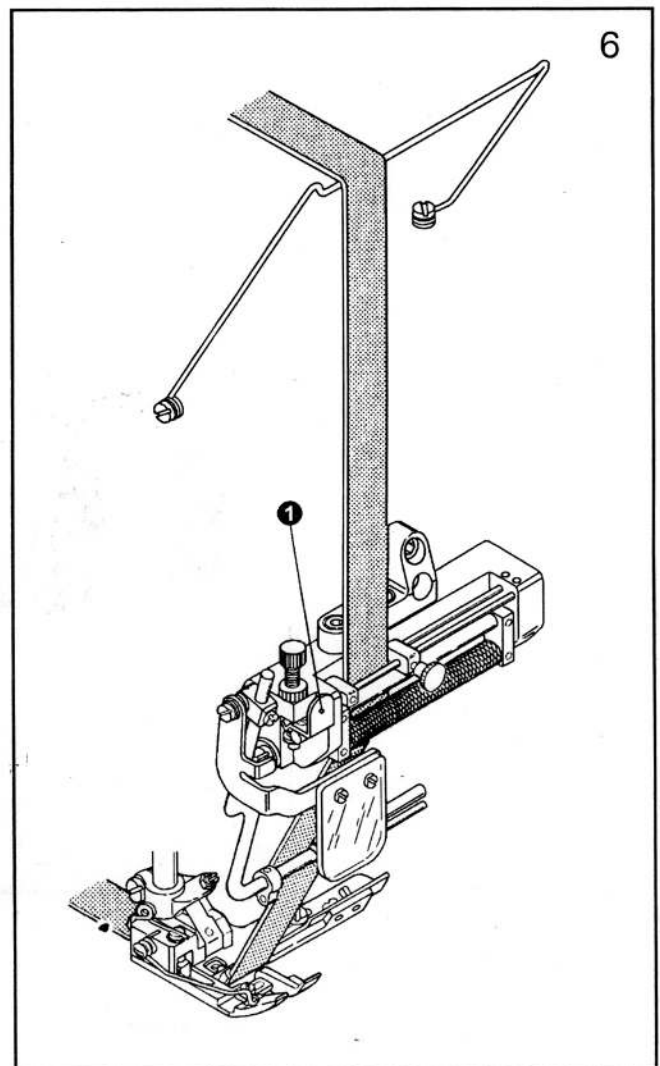
The needle thread retainer support is installed on the needle clamp. Threading the needle thread according to the fig.



2-2 Tape feeding device and cutting knife device

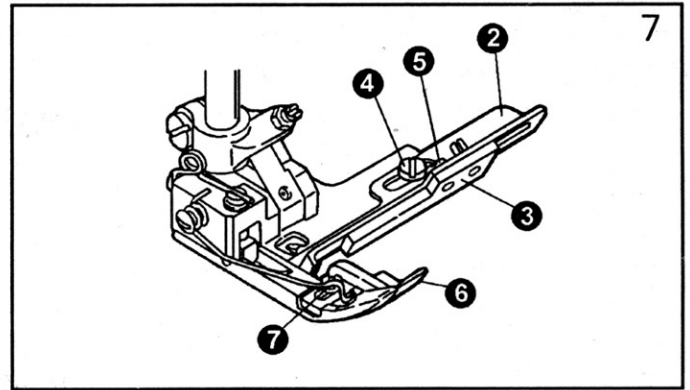
2-2-1 Threading of the elastic tape

Thread the elastic tape in order just as the fig. The clearance will increase when push down the wrench.



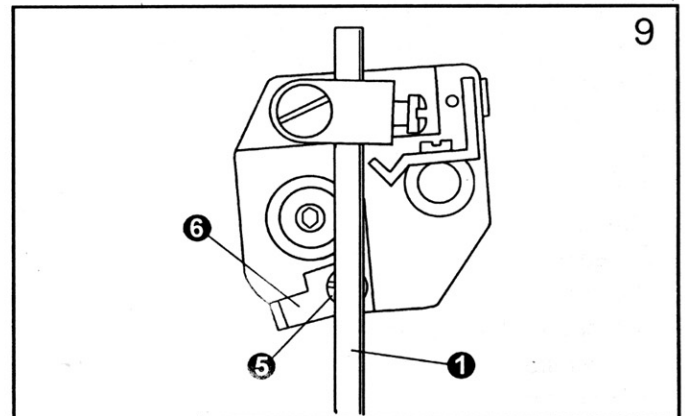
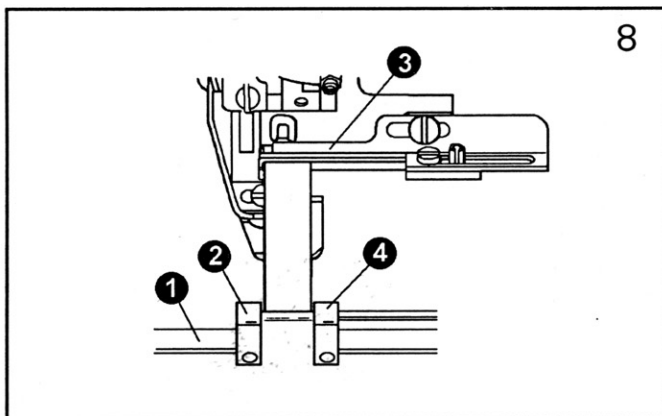
2-2-2 Tape guide clasp and material position guide

Adjusting the position of the tape guide clasp ② according to the gauge and the position of the stitch. Loosen the set screw ④ and ⑤ to move the tape limiter ③ to right position, which according to the width of the tape. Material position guide should near the cutting knife most possibly. And loosen the screw ⑦ to adjust it.



2-2-3 Installation of the lower tape guide support

1. The position of the lower tape guide support ① is not strict, but it should not obstruct the sewing operation, while the lower the better.
2. Align the inside of the lower tape guide block ② to the inside of the tape guide clasp ③. Adjust the position of the lower tape guide block ④ according to the width of tape. Be sure not to produce resistance.
3. After fix the lower tape guide support ①, loosen the set-screw ⑤ and make the position limiter ⑥ come into operation. The position limiter ⑥ can prevent the needle bar from colliding with the tape guide block asm.

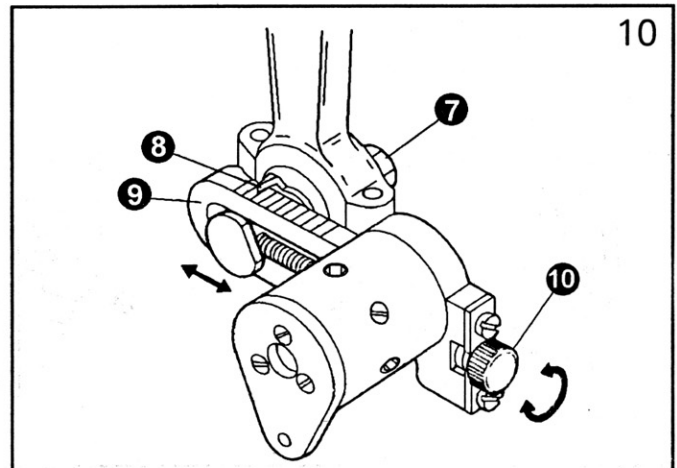


2-2-4 Adjusting of the feeding tape

After loosen the nut ⑦, observe the pointer ⑧ and the scale of feeding adjuster ⑨, then turn the adjust screw ⑩ to adjust the tape feeding.

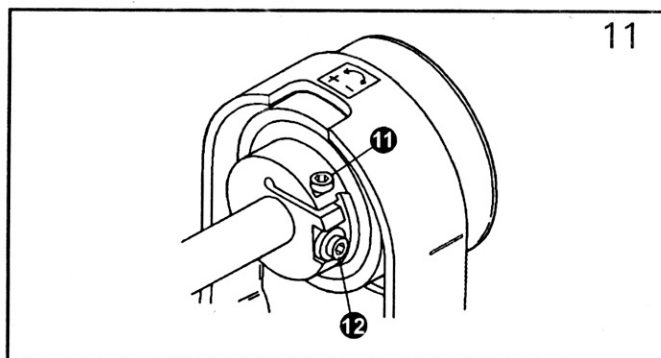
Turn the adjust screw ⑩ clockwise, make the pointer ⑧ move forward, the feeding will increase. Turn the adjust screw ⑩ counterclockwise, make the pointer ⑧ move backward, the feeding will decrease. Lock the nut ⑦ at a proper position.

(NOTE) After tighten the nut ⑦, turn the adjust screw ⑩ clockwise so as to make the clearance to zero.



If the right feeding is not available in the scope, loosen the screw ⑪, and turn the screw ⑫ to obtain the corresponding feeding.

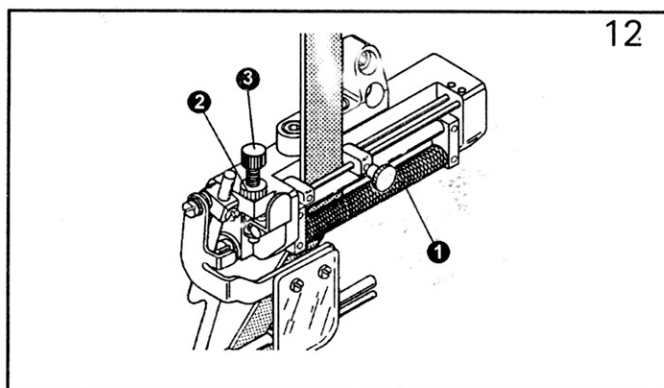
Turn the screw clockwise, the feeding will decrease; turn the screw counterclockwise, the feeding will increase.



2 – 2 – 5 Adjusting of the tension of the pulley

Loosen the tension adjust nut ②, turn the tension adjust screw ③ to adjust the tension of the passive pulley ①. Turn the screw clockwise, the tension will decrease; turn the screw counterclockwise, the tension will

increase. The tape feeding will be uneven for the tension being too strong or too weak.



2 – 2 – 6 The test and lubricating of the tape feeding device

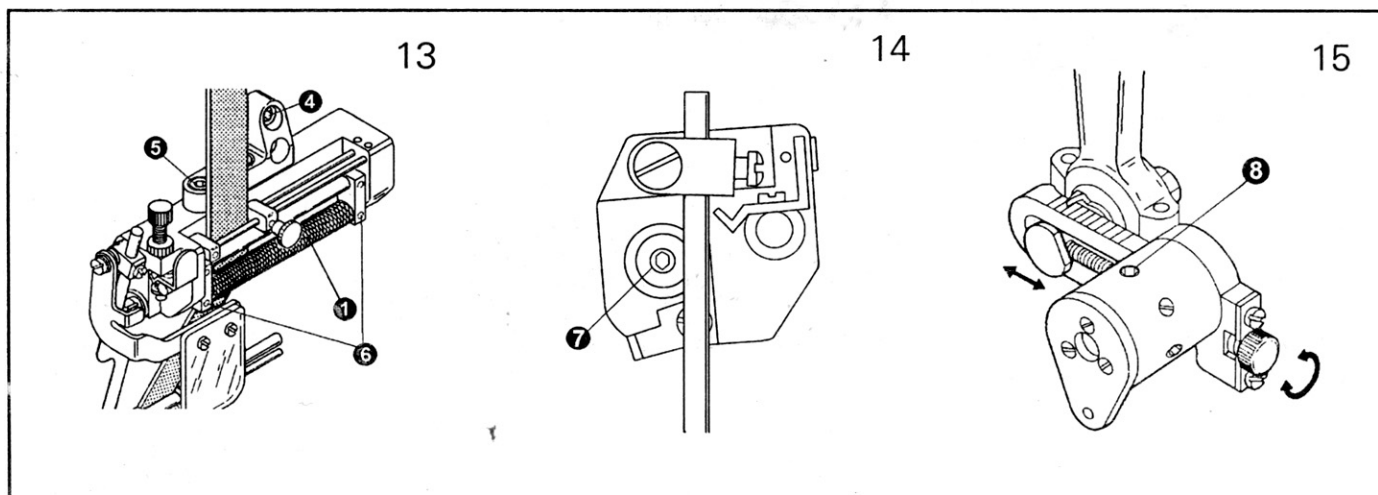
1. Repairing and replacing

If the assembling of the tape feeding device is not correct, the tape feeding will not be smooth, and it may result in the skip stitch, needle breaking and unsuccessful sewing. So pay attention to these problems as follow.

- A. After assemble the pulley shaft, test whether the pulley turn smoothly. If not, loosen the set screw ④ and ⑤, adjust the shaft and the hole aligning.
- B. The turn of the passive pulley should be fluent. If not, it will make the tape feeding uneven.
- C. The bracket and its shaft should be turn fluently.
- D. The tension of the adjust spring should be light.

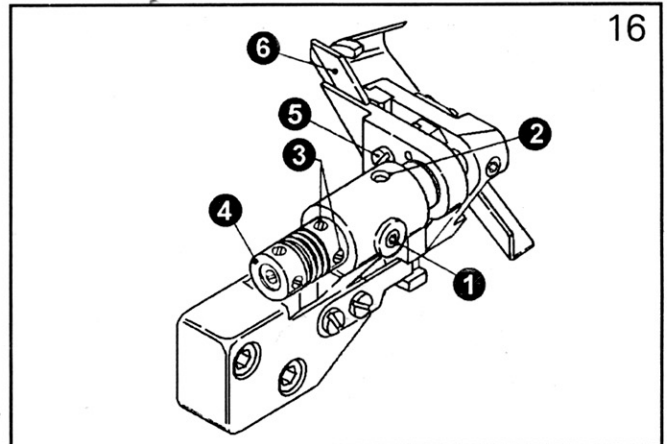
2. Lubrication

Oiling should be operating 2 or 3 times per year, it depends on the use frequency. Remove the screw ⑦ and screw ⑧, and puts the lubricating oil into the hole.



2-2-7 Adjusting of the cutting width

Open the front cover, then loosen set screw ①, and move the cutting knife bracket right and left. After adjusting, tighten the set screw. (Please often oil the oil hole ②)



2-2-8 The lower cutting knife

● Replacing

1. Replacing Loosen the set screw ③ of the right collar.
2. Push the left collar to the right, produce clearance between upper cutting knife and lower cutting knife.
3. Lock the right collar by the set screw ③.
4. Loosen the set screw ⑤, pull out the lower cutting knife ⑥ downward.

● Installation

1. Keep the knife point align with the stitch plate, then lock the set screw ⑤
2. Loosen the set screw ③ of the right collar. Make the upper cutting knife and lower cutting knife be in mesh through the spring.
3. Put a thread between upper cutting knife and lower cutting knife, then turn the handwheel to test whether the cutting knives are sharp.
4. Lock the set screw ③ of the right collar.
5. Test the cutting knives whether sharp again.

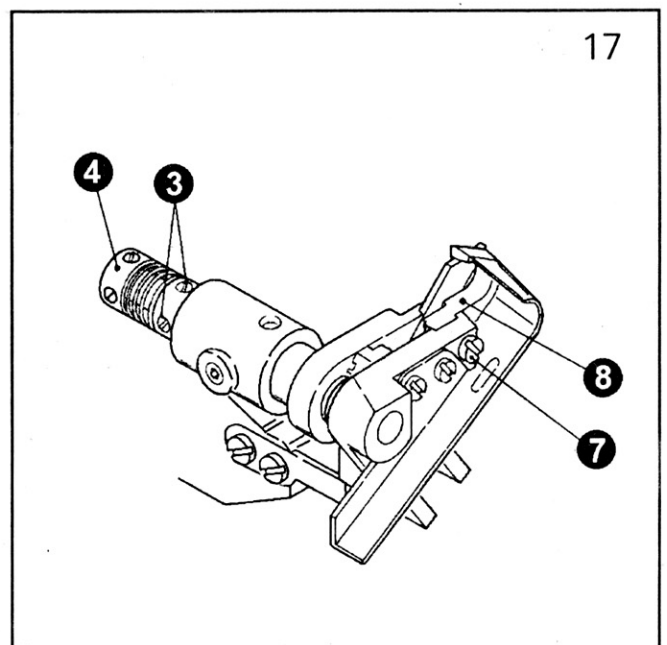
2-2-9 lower cutting knife

● Replacing

1. Loosen the set screw ③ of the right collar.
2. Push the left collar to the right, produce clearance between upper cutting knife and lower cutting knife.
3. Lock the right collar by the set screw ③.
4. Loosen the set screw ⑦, remove the upper cutting knife ⑥.

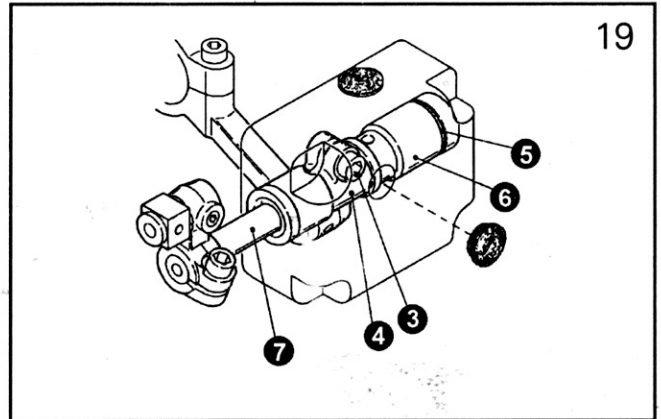
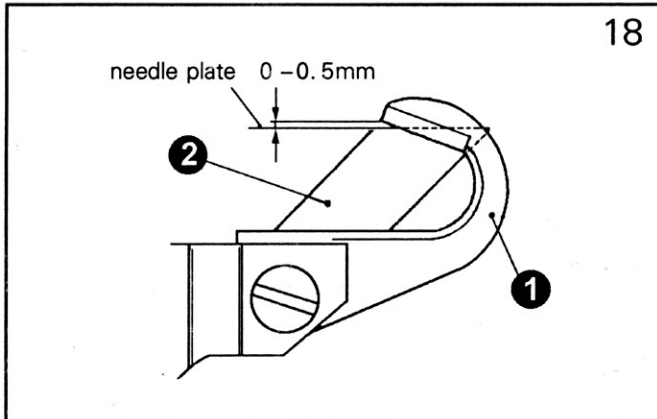
● Installation

1. Install the upper cutting knife 8 with the set screw ⑦.
2. Loosen the set screw ③ of the right collar. Make the upper cutting knife and lower cutting knife be in mesh through the spring.
3. Put a thread between upper cutting knife and lower cutting knife, turn the handwheel to test whether the cutting knives are sharp.
4. Lock the set screw ③ of the right collar.
5. Test the cutting knives whether sharp again.



2-2-10 The mesh of the cutting knives

The mesh position is shown as fig. when upper cutting knife is down to its lowest position. Loosen the set screw ③ of the left upper cutting knife crank, move the upper cutting knife and upper cutting knife bracket simultaneous up and down. After adjusting, tighten the set screw ③. As tighten the set screw ③, clamp the right bushing with the left upper cutting knife crank ④ and the washer ⑤, which fixed the upper cutting knife shaft ⑦.

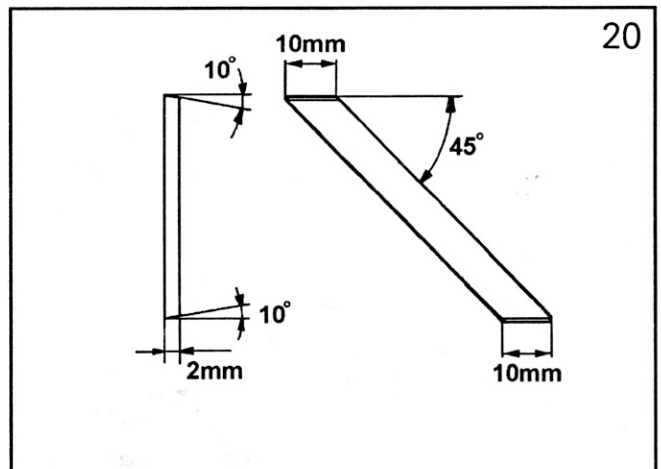


2-2-11 Rubbing of the cutting knives

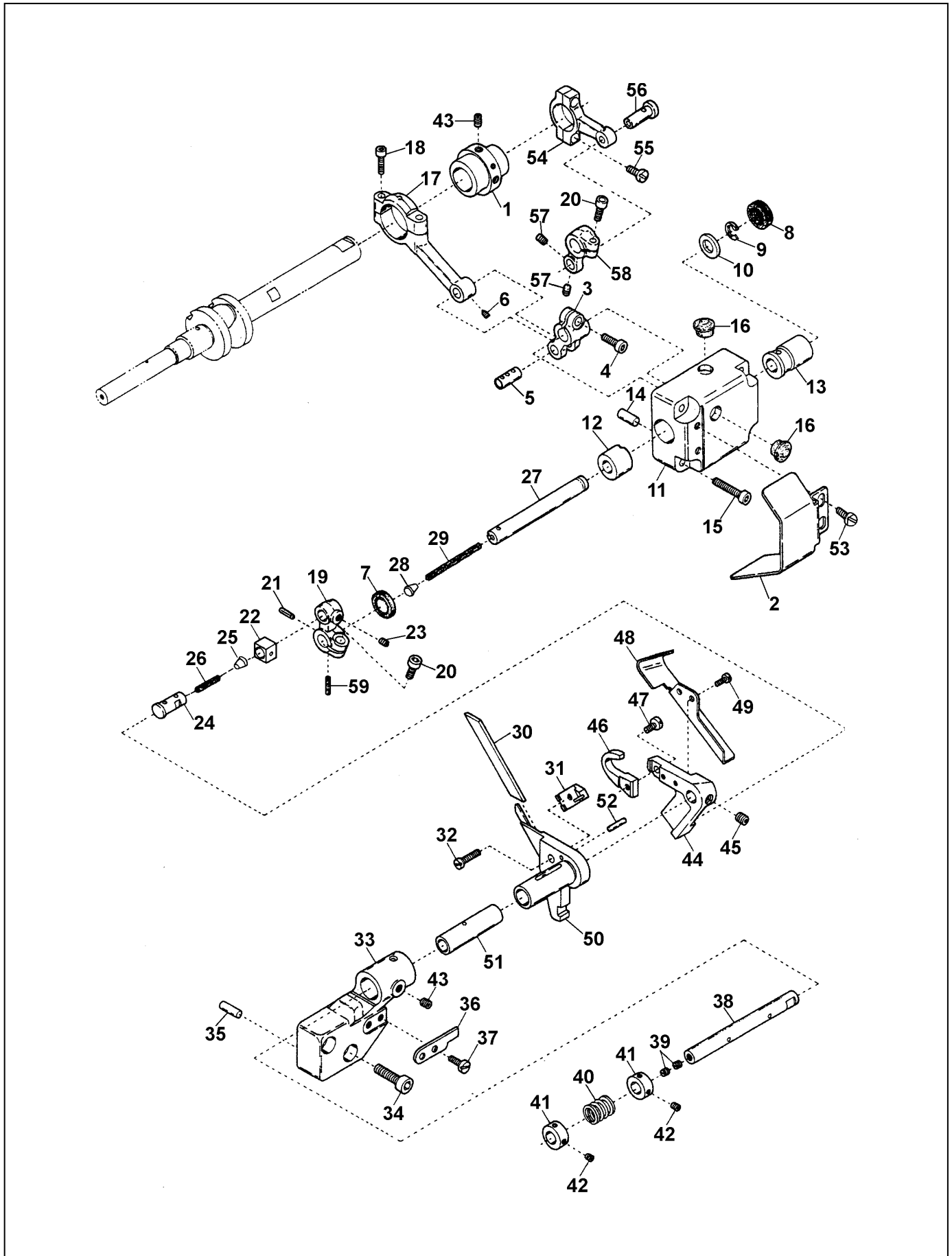
It's not necessary to rub the upper cutting knife in one year.

If the effect is not good, rub the lower cutting knife as fig.

Cooling water is necessary while rubbing the lower cutting knife.



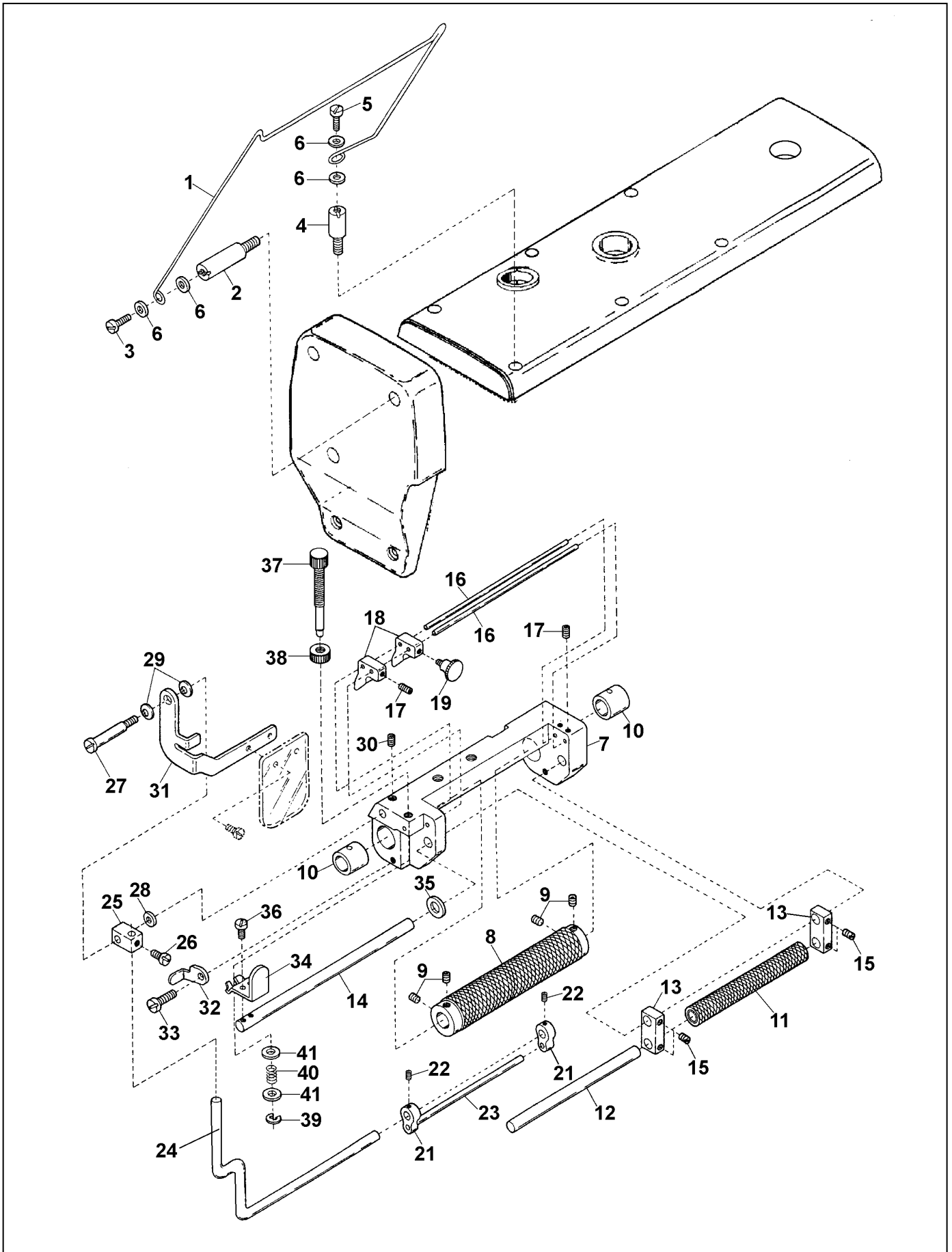
1. SPECIAL PARTS (1)



1. SPECIAL PARTS (1)

No.	Ref.No.	Description	Qt	Remark
1	110E00001	Cam	1	
2	110E00002	Oil protected plate for upper cutter	1	
3	110E10001	Right crank for upper cutter	1	
4	S150299002	Screw	1	
5	110E10002	Pin	1	
6	S150299019	Screw	1	
7	110500024	Seal ring	1	
8	110500025	Rubber plug	1	
9	S150620005	Retaining ring	2	
10	110E10003	Washer	1	
11	110E11001	Shaft pedestal	1	
12	110E11002	Left bushing	1	
13	110E11003	Right bushing	1	
14	S150403008	Pin	2	
15	S150209051	Screw	4	
16	110100003	Rubber plug	2	
17	110E12001	Lever link	1	
18	S150209049	Screw	2	
19	110E13001	Left crank for upper cutter	1	
20	S150299002	Screw	1	
21	S150405027	Pin	1	
22	110E13002	Slide block for left crank	1	
23	S150299027	Screw	1	
24	110E13101	Shaft	1	
25	1105A1002	Seal plug	1	
26	1105A1003	Oil wick	1	
27	110E14001	Shaft	1	
28	110E14002	Seal plug	1	
29	1105A1003	Oil wick	1	
30	110E20001	Lower cutter	1	
31	110E20002	Plate for lower cutter	1	
32	028400047	Screw	1	
33	110E20003	Lower cutter support pedestal	1	
34	S150209058	Screw	2	
35	S150403008	Pin	2	
36	110E20004	Stopping plate	1	
37	S150299035	Screw	2	
38	110E20005	Shaft for upper cutter support	1	
39	022710002	Screw	2	
40	110E20006	Spring	1	
41	110500006	Straining ring	2	
42	S150299008	Screw	4	
43	S150299028	Screw	1	
44	110E20007	Upper cutter support	1	
45	S150299029	Screw	1	
46	110E20008	Upper cutter	1	
47	028100027	Screw	1	
48	110E20009	Cleaning plate	1	
49	S150216001	Screw	2	
50	110E21001	Lower cutter support	1	
51	110E21002	Bushing	1	
52	S150405033	Pin	1	
53	S150202009	Screw	2	
54	110550001	Lever link	1	
55	110550005	Screw	2	
56	110550003	Pin	1	
57	S150299008	Screw	2	
58	110550004	Crank	1	
59		Oil wick	1	

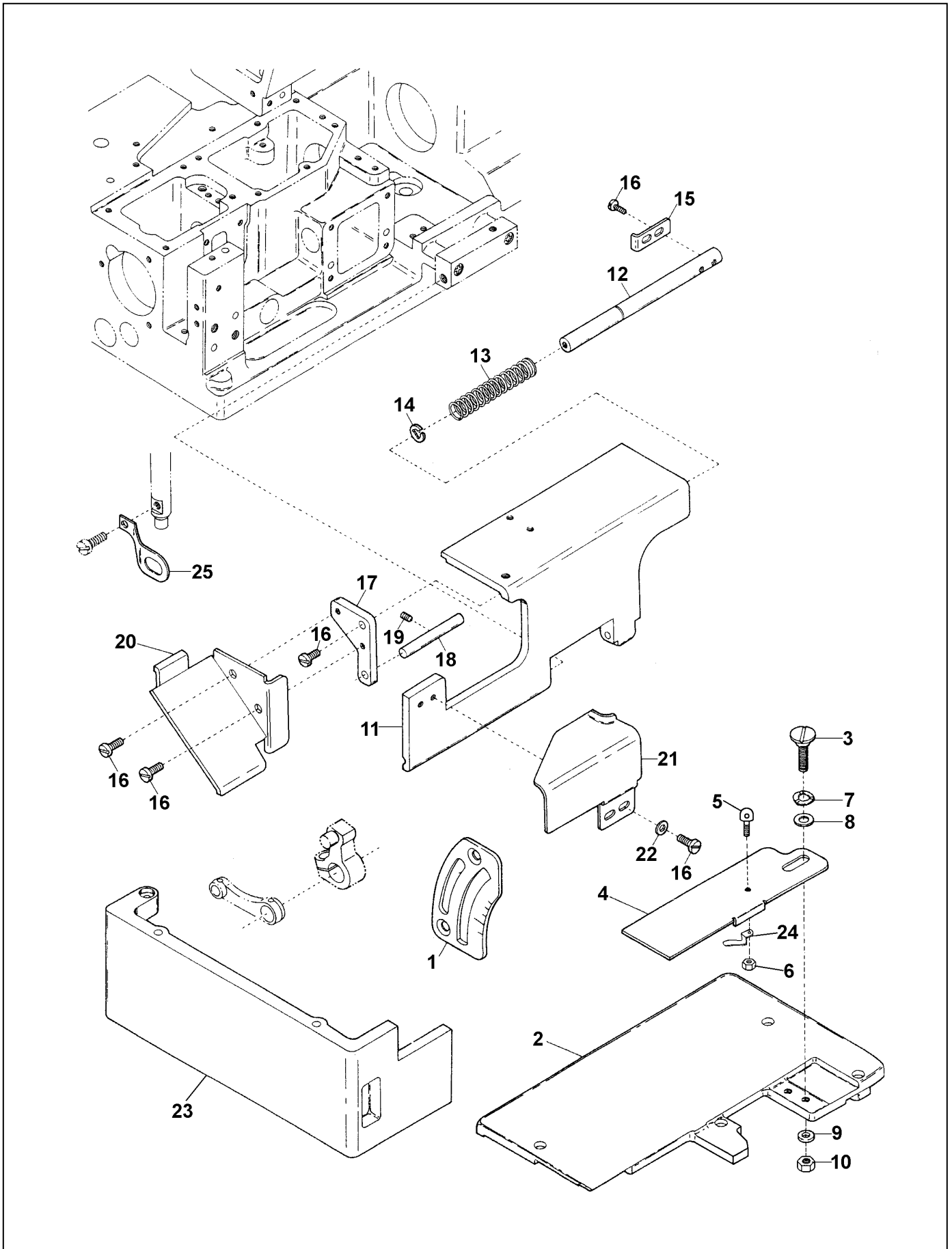
2. SPECIAL PARTS (2)



2. SPECIAL PARTS (2)

No.	Ref.No.	Description	Qt	Remark
1	182F60020	Guide rod	1	
2	182F60021	Lefter washer	1	
3	S150299035	Screw	1	
4	182F60022	Right washer	1	
5	S150299035	Screw	1	
6	008230003	Washer	4	
7	182F60023	Active wheel support	1	
8	182F60025	Active wheel	1	
9	S150299027	Set screw	4	
10	182F60026	Bushing	2	
11	182F60027	Passive wheel	1	
12	182F60028	Shaft	1	
13	182F60029	Passive wheel support	2	
14	182F60030	Shaft for passive wheel support	1	
15	S150299027	Screw	4	
16	182F60031	Shaft	2	
17	S150299008	Set screw	3	
18	182F60032	Upper stopping block	2	
19	182F60033	Screw	1	
21	182F60034	Lower stopping block	2	
22	S150299008	Screw	2	
23	182F60035	Stopping rod	1	
24	182F60036	Stopping support	1	
25	182F60037	Stopping support pedestal	1	
26	S150299035	Set screw	1	
27	110150003	Screw	1	
28	S150607009	Washer	1	
29	S150603002	Washer	2	
30	S150299027	Set screw	1	
31	182F60039	Guard plate pedestal	1	
32	182F60040	Stopping plate	1	
33	S150216017	Set screw	1	
34	182F60041	Adjusting wrench	1	
35	SFB0601024	Washer	1	
36	S150216029	Set screw	2	
37	182F60042	Screw	1	
38	182F60043	Nut	1	
39	S150620004	Collar	1	
40	182F60044	Adjusting spring	1	
41	S150607009	Washer	2	

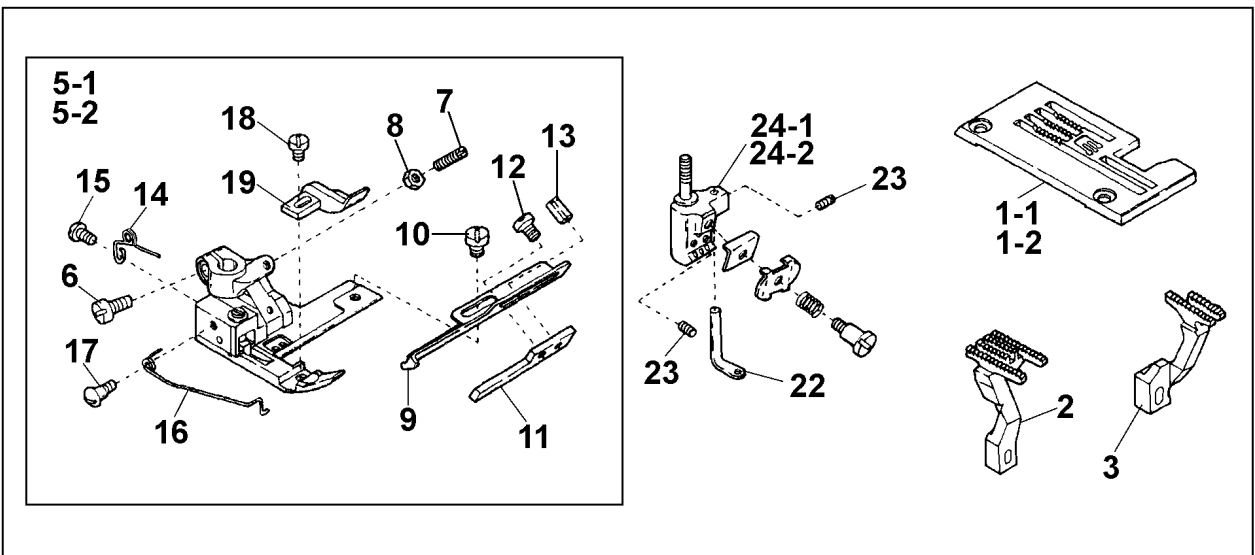
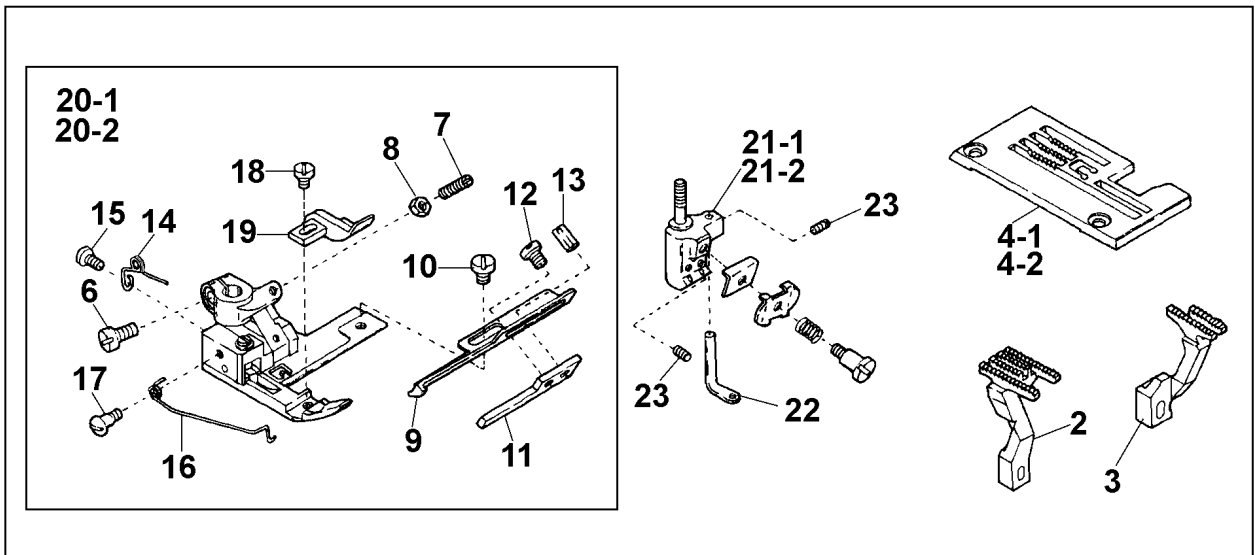
3. SPECIAL PARTS (3)



3. SPECIAL PARTS (3)

No.	Ref.No.	Description	Qt	Remark
1	110E00007	Scale plate	1	
2	110E30001	Cloth plate	1	
3	110E30002	Screw	1	
4	110E31001	Slide plate	1	
5	110E31002	Slide plate wrench	1	
6	S150559005	Nut	1	
7	S150603003	Saddle shaped washer	2	
8	SFB0601024	Washer	1	
9	008230003	Washer (BQ10008)	1	
10	S150559004	Nut (GB6170- 86)	1	
11	110E40001	Front cover	1	
12	110E40002	Shaft for chipping guide plate(long)	1	
13	110E40003	Spring	1	
14	S150620005	C- type stop ring	1	
15	110E40004	Position limiter	1	
16	S150299035	Screw	7	
17	110E40005	Chipping guide plate support	1	
18	110E40006	Shaft for chipping guide plate(short)	1	
19	S150299027	Screw	1	
20	110E40007	Chipping guide plate	1	
21	110E40008	Material guide plate	1	
22	S150613005	Washer	1	
23	110E50001	Left cover	1	
24	110E31003	Spring	1	
25	110E00016	Finger guard	1	

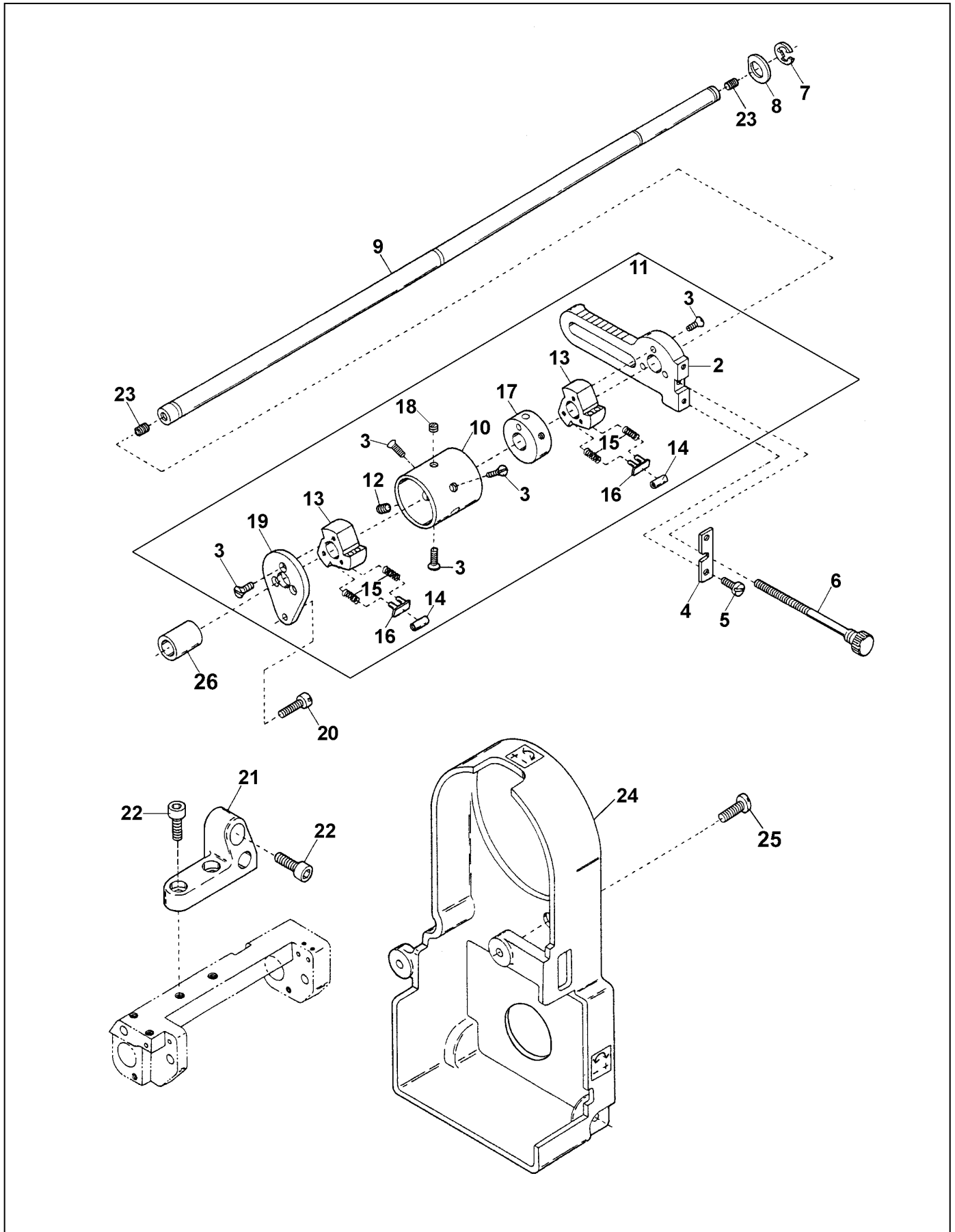
4. SPECIAL PARTS (4)



4. SPECIAL PARTS (4)

No.	Ref.No.	Description	Qt	Remark
1- 1	249101002	Stitch plate (5.6)	1	
1- 2	249101001	Stitch plate (6.4)	1	
2	110E00005	Feed dog	1	
3	110E00006	Differential feed dog	1	
4- 1	110E00013	Stitch plate(double needle 3.2)	1	
4- 2	110E00014	Stitch plate(double needle 4.0)	1	
5- 1	110E60000	Presser foot complete(5.6)	1	
5- 2	110E90000	Presser foot complete(6.4)	1	
6	028100027	Screw	1	
7	S150222002	Set screw	1	
8	S150503002	Nut	1	
9	110E60008	Tape guide clasp	1	
10	110E60009	Screw	1	
11	110E60010	Tape guide plate	1	
12	S150202028	Screw	1	
13	S150446016	Pin	1	
14	110E60011	Spring	1	
15	028400068	Screw	1	
16	110E60012	Sping	1	
17	110E60013	Screw	1	
18	110E60014	Screw	2	
19	110E60005	Guide plate	1	
20- 1	110EA0000	Presser foot complete(double needle 3.2)	1	
20- 2	110Eb0000	Presser foot complete(double needle 4.0)	1	
21- 1	182610001	Needle clamp(double needle 3.2)	1	
21- 2	182610002	Needle clamp(double needle 4.0)	1	
22	182610009	Thead guide	1	
23	182610010	Screw	4 (3)	
24- 1	182610006	Needle clamp(5.6)	1	
24- 2	182610007	Needle clamp(6.4)	1	

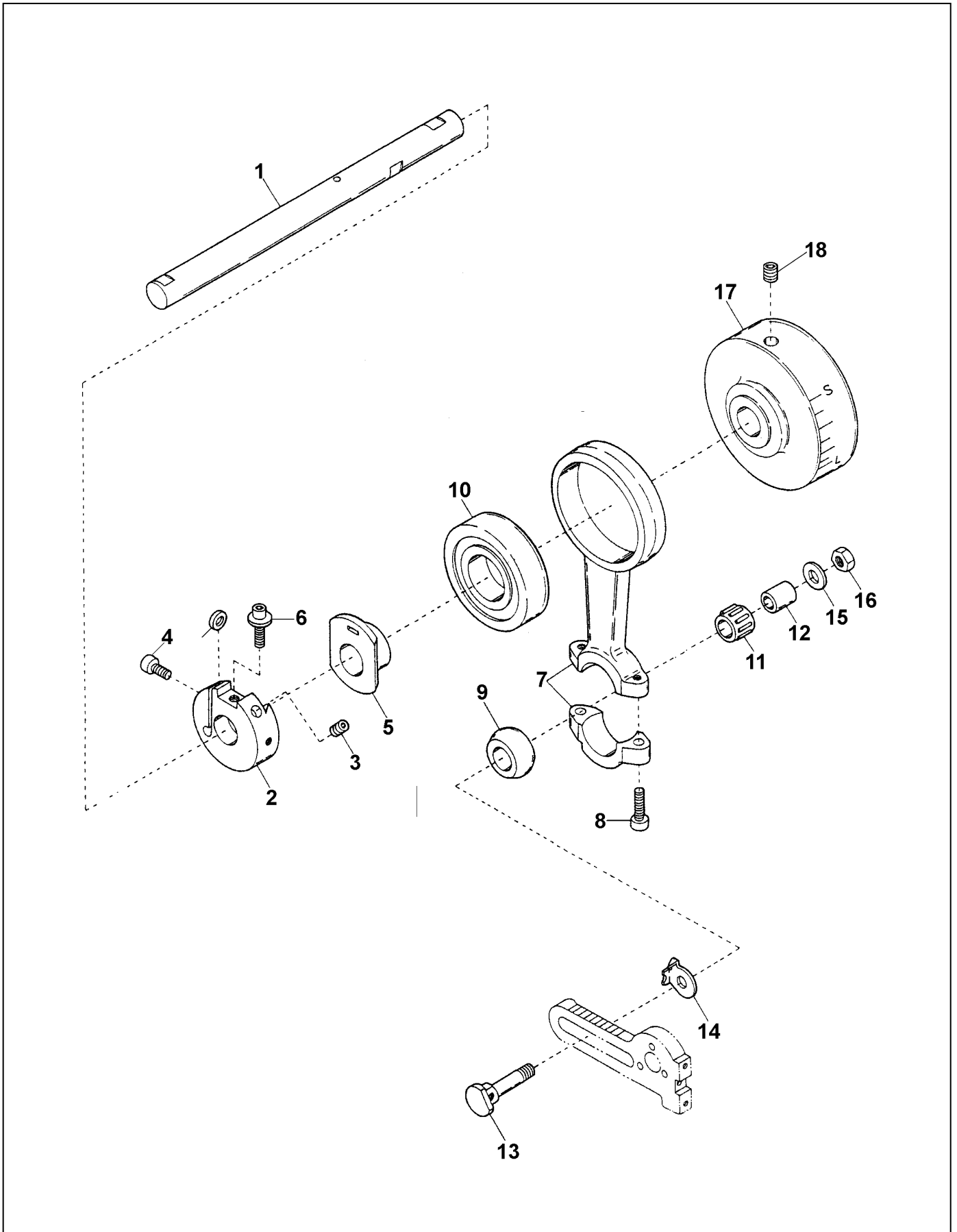
5. SPECIAL PARTS (5)



5. SPECIAL PARTS (5)

No.	Ref.No.	Description	Qt	Remark
2	182F60012	Adjusting pedestal	1	
3	182F60048	Screw	9	
4	182F60013	Adjusting plate	1	
5	S150216029	Set screw	2	
6	182F60014	Screw	1	
7	S150651002	C- type stop ring	1	
8	182F60015	Washer	1	
9	182F60016	Feeding shaft	1	
10	182F60017	Clutch fellowe	1	
11	182F62000	Clutch fittings	1	
12	S150299029	Screw	1	
13	182F40026	Clutch inside wheel	2	
14	182F40027	Roller	6	
15	182F40028	Spring	12	
16	182F60047	Washer	6	
17	182F60018	Spacer	1	
18	S150299029	Set screw	2	
19	182F60019	Clutch stoper	1	
20	S150299035	Set screw	1	
21	182F60024	Connecting block	1	
22	S150209055	Set screw	4	
23	S150299028	Screw	2	
24	182F60049	Link cover	1	
25	S150299031	Screw	2	
26	182F60026	Bushing	1	

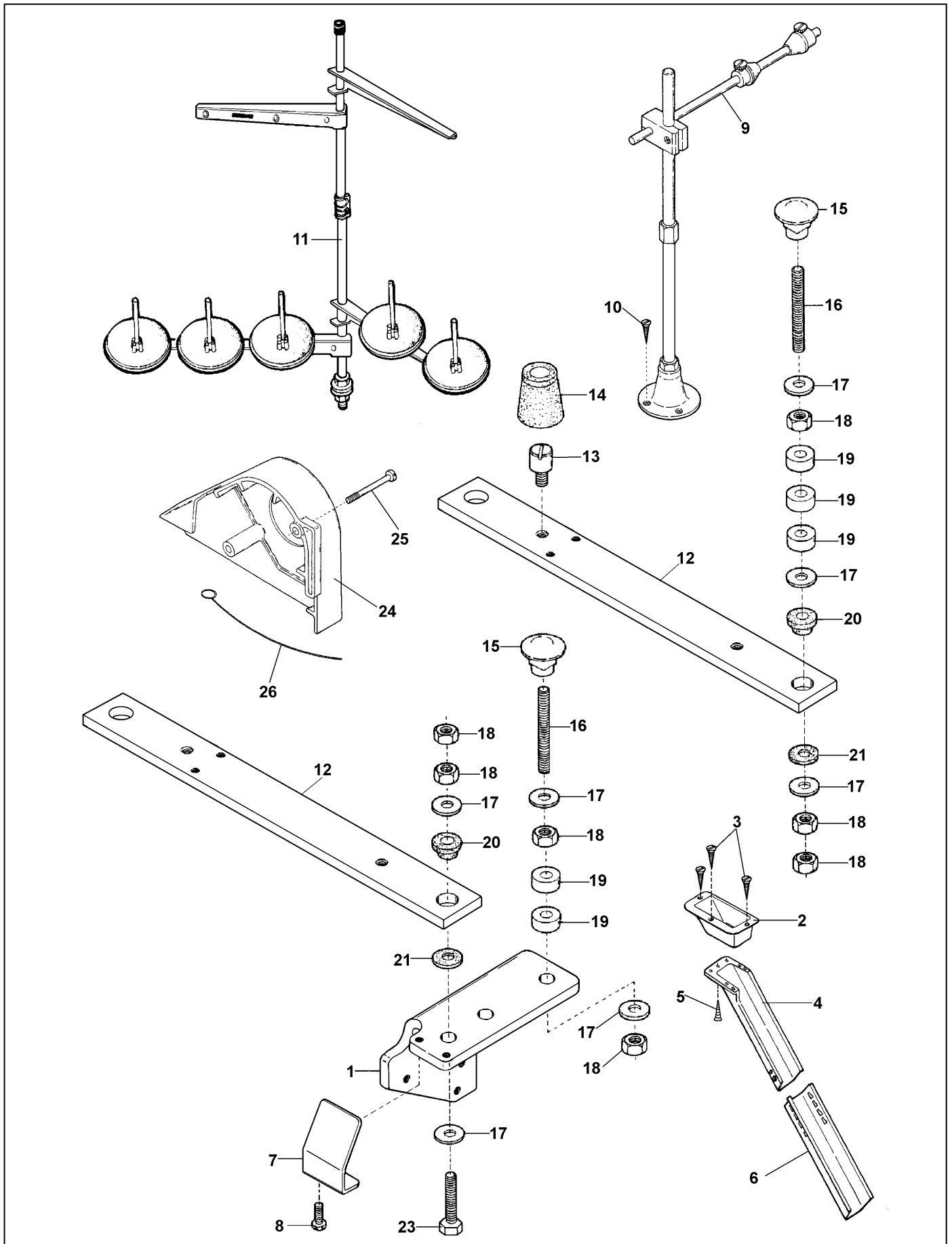
6. SPECIAL PARTS (6)



6. SPECIAL PARTS (6)

No.	Ref.No.	Description	Qt	Remark
1	182F60001	Upper shaft	1	
2	182F60003	Adjusting pedestal	1	
3	S150299028	Set screw	2	
4	S150209044	Screw	1	
5	182F60004	Slide block	1	
6	182F60005	Adjusting screw	1	
7	182F60006	Lever link	1	
8	S150209050	Screw	2	
9	182F60007	Bushing	1	
10	S150801010	Upper bearing	1	
11	S150801114	Lower bearing	1	
12	182F60008	Bushing	1	
13	182F60009	Adjusting pole	1	
14	182F60010	Inside washer	1	
15	182F60011	Outside washer	1	
16	S150503005	Nut	1	
17	249101006	Hand wheel	1	
18	S150299029	Screw	1	

7. SPECIAL PARTS (7)



7. SPECIAL PARTS (7)

No.	Ref.No.	Description	Qt	Remark
1	110E00009	Waste chute support	1	
2	028800006	Waste funnel	1	
3	S150224003	Wood screw 3x18	1	
4	110E00010	Waste chute(upper)	1	
5	S150227001	Wood screw 4x16	1	
6	028800008	Waste chute(lower)	1	
7	110E00011	Chipping guide plate	1	
8	S150202034	Screw	1	
9	110E80000	Tape guide support	1	
10	S150224004	Wood screw 4x25	3	
11	031380002	Thread spool	1	
12	110F10001	Support	2	
13	110F10003	Screw	4	
14	110F10002	Cushion	4	
15	110F10005	Screw head	5	
16	110F10004	Screw arbor	5	
17	S150607013	Washer	15	
18	S150503007	Nut	15	
19	110F10006	Spacer	13	
20	110F10008	Washer	4	
21	110F10007	Washer	4	
23	S150280001	Screw M8x35	1	
24	110F00001	Belt cover	1	
25	S150201001	Screw GB65- 85 M6× 45	2	
26	039A00001	Tweezer	1	

- Besides adjusting stitch, please laypeople don't debug or maintain.
- Parts are subject to changes in design without prior notice.

XI'AN TYPICAL INDUSTRIES CO.,LTD.

Add: No.335 Taibai South Road,
Xi'an, P.R. China-710068
Tel: +86-29-88279091 88279150
Fax: +86-29-88279715 88275215
E-mail: typical@chinatypical.com
[Http://www.chinatypical.com](http://www.chinatypical.com)
[Http://www.chinatypical.com](http://www.chinatypical.com)