



# TYPICAL

---

## GK335-12Q

AUTOMATIC CUTTING LOOP BELT LACE SEWING MACHING  
PARTS CATALOGUE

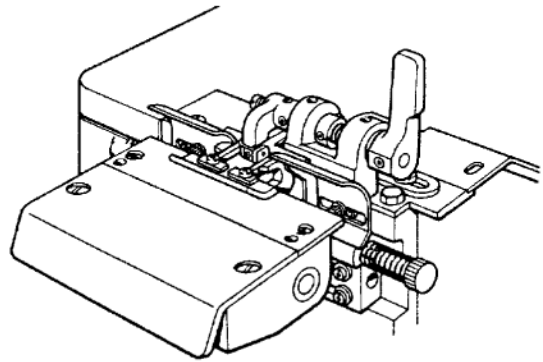
---

XI'AN TYPICAL INDUSTRIES CO.,LTD.

## The front cutter mechanism

The front cutter can cut off the two side edges of materials to make it up to the requested width, then folded to the wanted lace after through edge binder. The edge binder has six sizes available in width: 5/16in, 3/8in, 1/2in, 15mm, 20 mm.

The standard one is 3/8in and the needle gauge is 5.6 mm, for other special size, please note when order is placed.



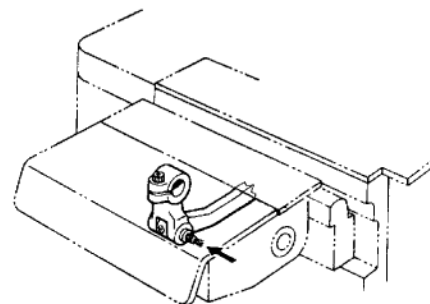
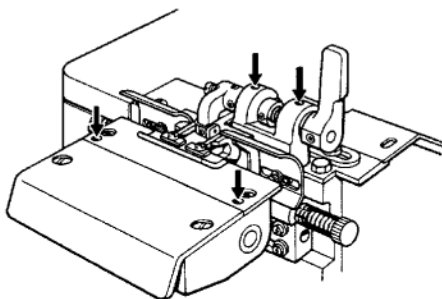
## Main specifications

Needle quantity	Thread quantity	Stitch Lengthy (mm)	Needle gauge (mm)	Looper	Differential ratio	Cloth Cutter	Presser foot lift volume (mm)	Needle type	Heavy and medium weight material	Speed (S.P.M)
2	3	1.4-4.5	4.8, 5.6, 6.4	1	0.7-1.2	*	6	UY128 GAS	*	4500

### Application

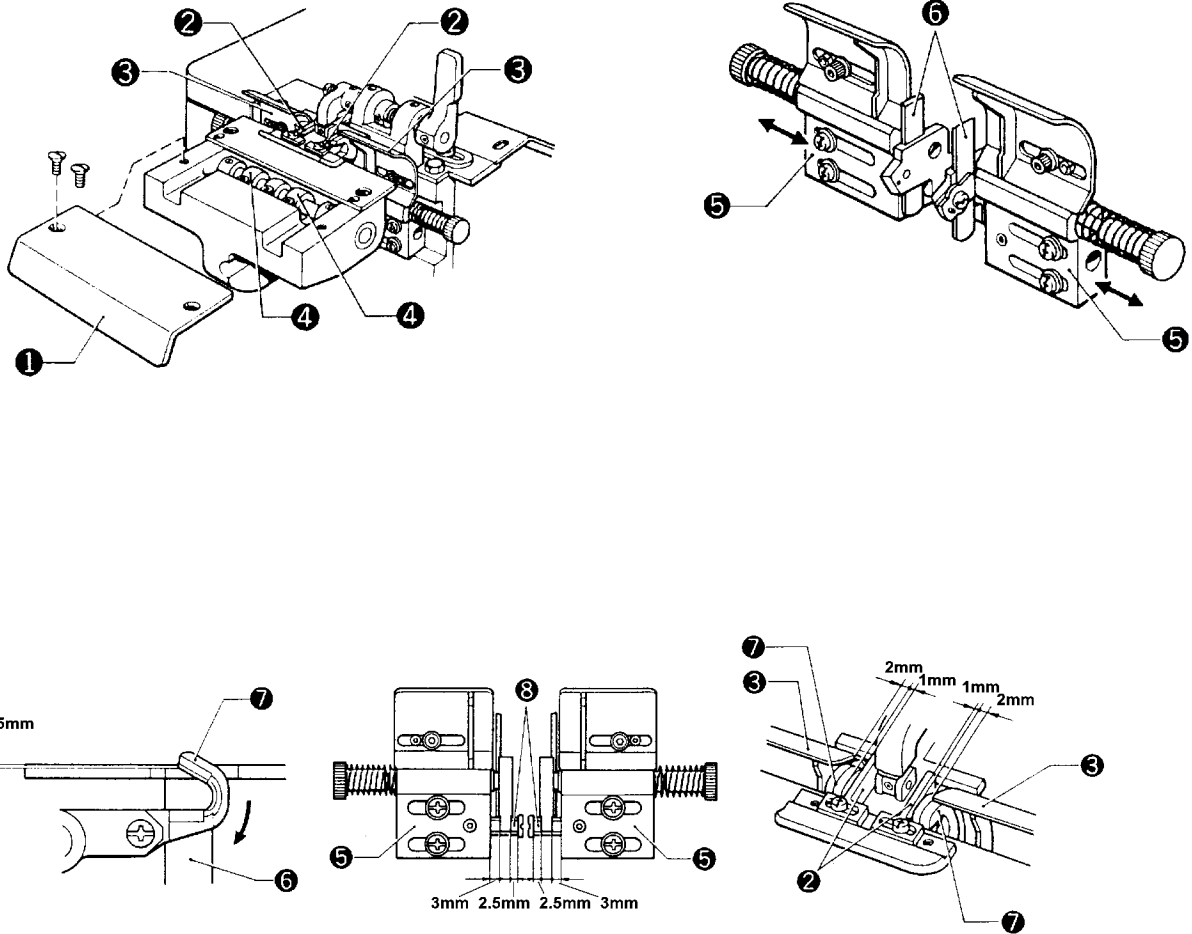
Suitable for attaching lace on tronsers and skirts of light and heavy and medium weight material.

## 1.Oil filling



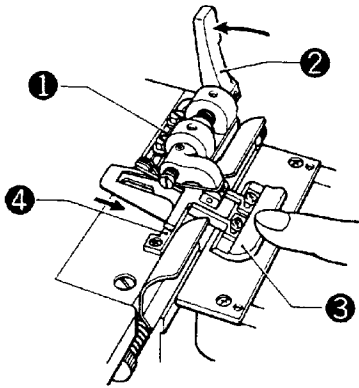
Fill 2 - 3 drops of oil in the places marked once every 2 or 3 days.

## 2.The width adjustment between the right and left cutters



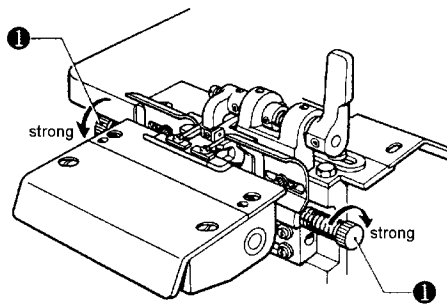
- (1) Remove off Upper ① of the support.
- (2) Loose Press Plate ②, Upper Cutter Crank ④, and Cutter Guard ③ .
- (3) Loose the support of the lower cutter, move it right and left to obtain the requested width between the two cutters, meanwhile adjust the position of Lower Cutter Guide Shaft ⑧ to get the size marked in the figure, then tighten Screw ⑤ .
- (4) Turn the upper shaft back, when the needle bar moves down the lowest position, adjust Upper Cutter ⑦ to keep about 0.5 mm in conjunction with Lower Cutter ⑥, then tighten the upper cutter.
- (5) Adjust the clearance between Press Plate ② and Upper Cutter ⑦ to about 1 mm and tighten them.
- (6) Adjust the clearance between Cutter Guard ③ and Upper Cutter to about 2 mm and tighten them.
- (7) Reset Upper Cover ① of the support.

### 3.Replacing the edge binder



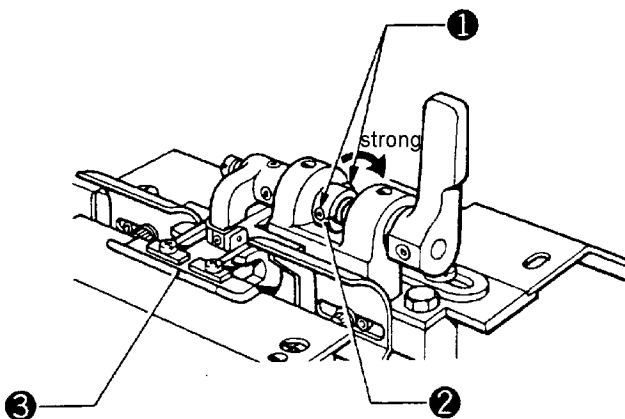
- (1) Remove Screw ① .
- (2) Turn back the balance wheel to move down the feed dog to the lowest position.
- (3) Lift the presser foot and Follow Presser Foot ③, meanwhile press down the front end of the follow presser foot, take out the edge binder.
- (4) With the same method install the necessary binder and tighten the screw .

### 4.Adjusting the cutter pressure



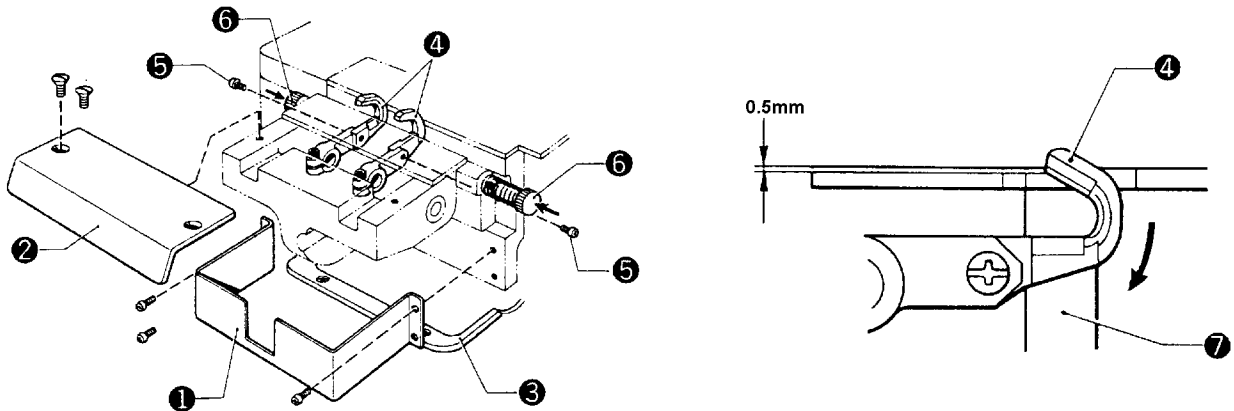
For sewing heavy weight materials such as jeans, turn Screw ① clockwise to get more pressure. Generally it is better for less pressure of the cutter.

### 5.Adjusting pressure of the follow presser foot



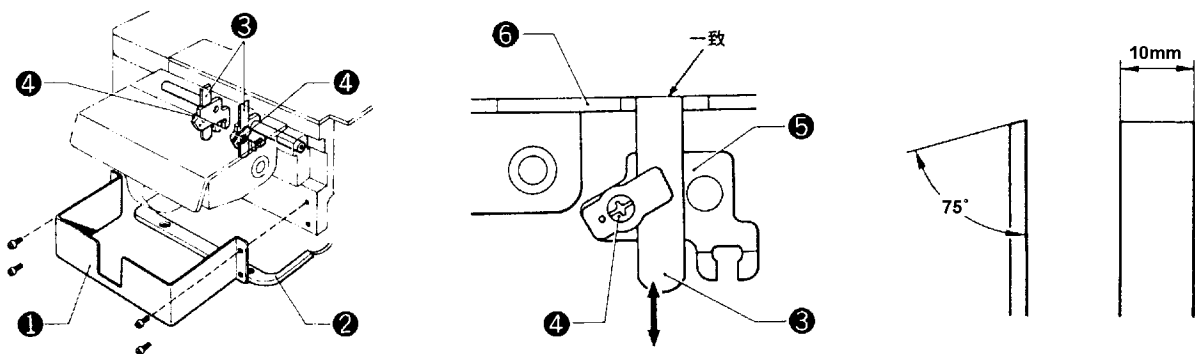
When sewing heavy weight materials such as jeans, if the pressure of the follow presser foot is too small, the material can not be folded properly through the binder, so loosen Screw ①, turn the collar in direction shown by the arrow to increase the pressure of Follow Presser Foot ③ .

## 6.Replacing the upper cutter



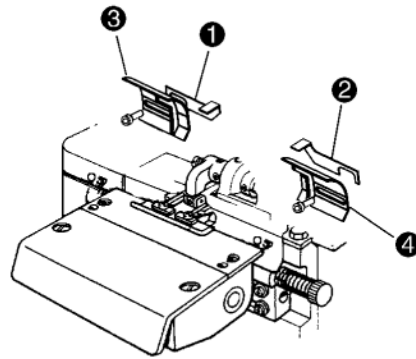
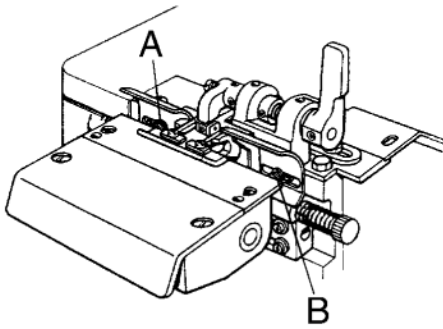
- (1) Remove off Front cover ① and Top cover ② .
- (2) Remove off Screw ⑤ .
- (3) Adjust Screw ⑥ to reduce the pressure to minimum degree, take off Upper Cutter ④ .
- (4) Replace the upper cutter in reverse steps and make sure the conjunction.

## 7.Replacing the lower cutter



- (1) Remove off Front Cover ① .
- (2) Loosen Screw ④ and take down Lower Cutter ③ .
- (3) Insert Lower Cutter ③ in the slot of lower Cutter Support ⑤, make the blade of Lower Cutter ③ horizontal with the upper surface of Throat Plate ⑥ and tighten Screw ④ .

## 8. Material tray installation

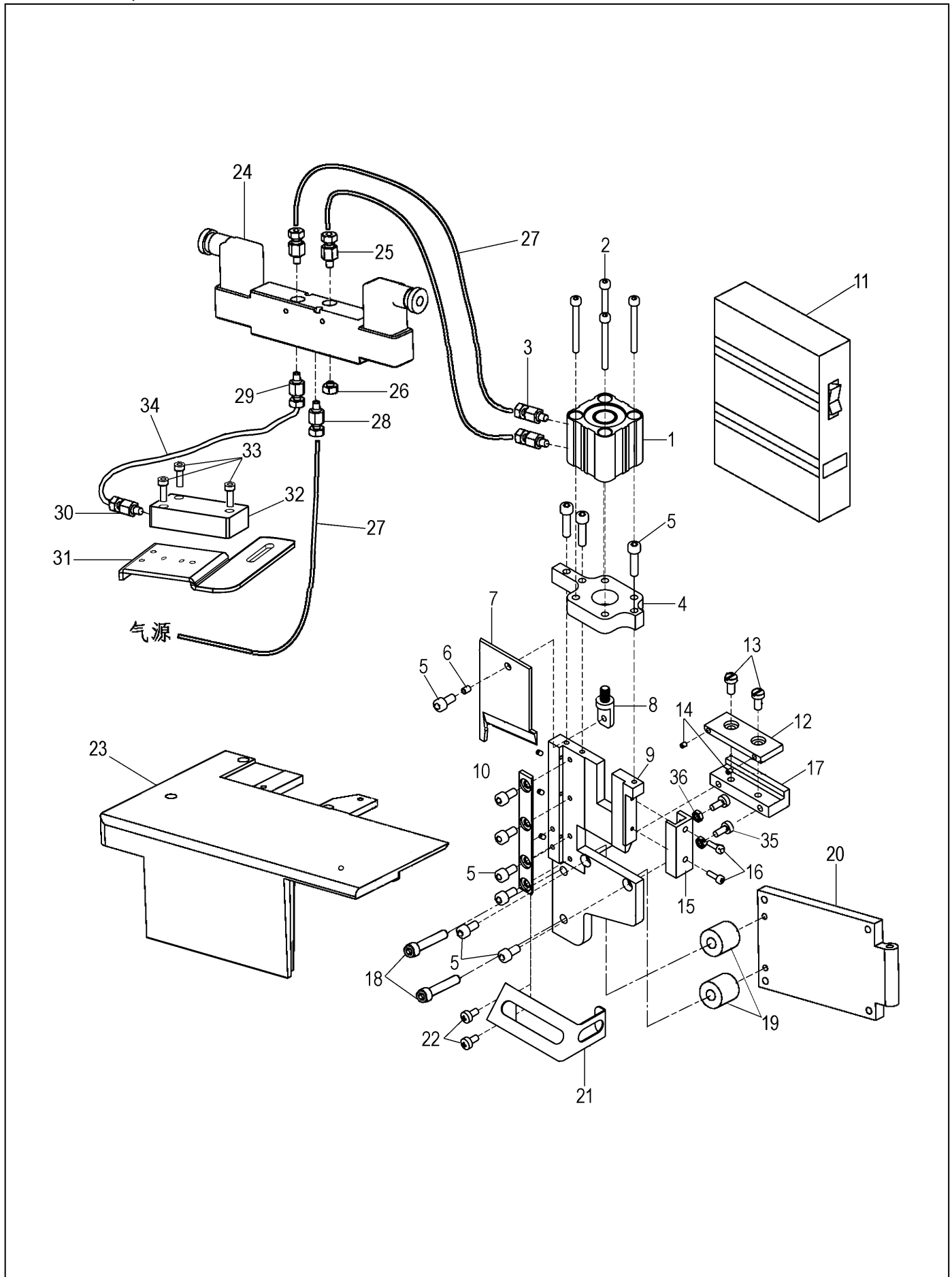


When sewing trouser loop width is greater than 15mm, need to install material plate ① and ②, as follows:

( 1 ) Loosen the screw A and B.

( 2 ) As shown on the right, the material supporting plate ① and ② respectively clamped to part ③ and ④ behind cover, due to the cutting knife gap adjustment.

# 1. 335- 12Q SPECIAL PARTS (1)



## 1. 335- 12Q SPECIAL PARTS (1)

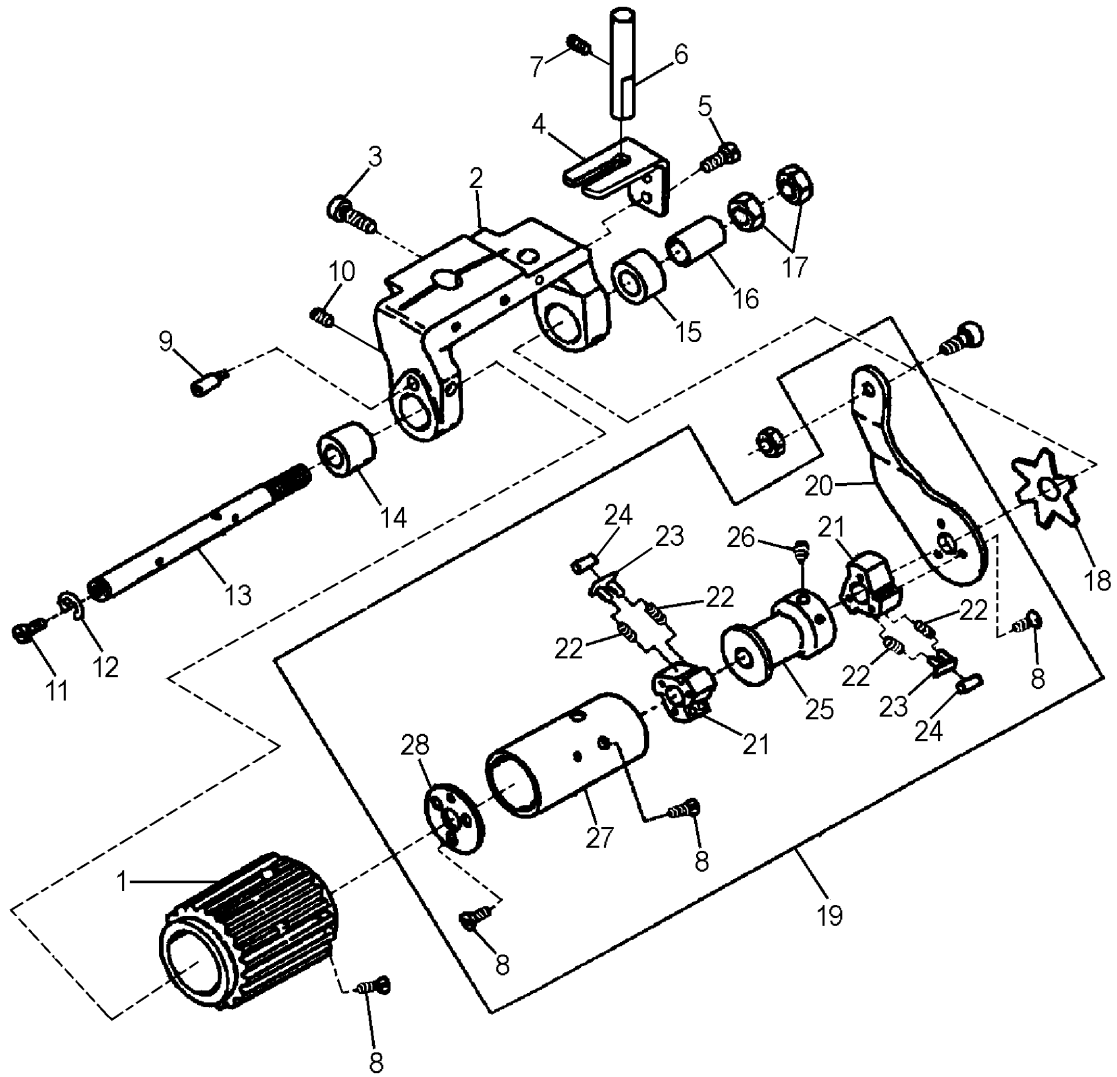
No.	Ref.No.	Description	Qt
1	S151099260	Cylinder MCJ S- 12- 32- 15	1
2	S150209098	Screw GB70.1- 2000 M4× 40	4
3	S151099230	Air cock 1/8"× Φ 6	2
4	248C00003	Cylinder plate	1
5	S150209024	Screw GB70.1- 2000 M5× 10	9
6	241482006	Roller (K322)	1
7	248A10002	Knife	1
8	248A10008	Cylinder connector	1
9	248A10001	Knife base	1
10	248A10006	Knife left board	1
11	248A12000	Control system assy	1
12	248A10003	Lower knife	1
13	SFB0201023	Screw M5× 10	2
14	S150299015	Screw GB77- 85 M3× 4	5
15	248A10005	Knife right board	1
16	S150211004	Screw GB70.3- 2000 M3× 10	2
17	248A10004	Lower knife Plate	1
18	S150209043	Screw GB70- 76 M6× 5	2
19	248A10010	Block	2
20	248A10014	Left cover hinge	1
21	248A10009	Protection cover	1
22	S150216051	Screw GB818- 85 M4× 8	2
23	248A10015	Cloth plate	1
24	S151099234	Solenoid valve AP4V220- 08	1
25	S151099232	Air cock 1/4"× Φ 6	2
26	S151099233	Baffler MSL- S- 01	2
27		Tracheal Φ 6	
28	S151099231	Air cock 1/4"× Φ 8	1
29	S151099235	Air cock 1/8"- Φ 4	1
30	S151099161	Air cock Φ 4	1
31	248A10020	Material guide	1
32	248A10022	Gas leading pieces	1
33	S150212026	Screw M3	1
34		Tracheal Φ 4	
35	S150299031	Screw M4× 10	2
36	S150503003	Nut M4	2



## 2. 335- 12Q SPECIAL PARTS (2)

No.	Ref.No.	Description	Qt
1	182F40039	Upper feed roller shaft bracket	1
2	S150209102	Screw	4
3	182F40037	Upper feed roller lever	1
4	182100037	Seal plug	1
5	182F40040	Roller shaft bushing (left)	1
6	182F40053	Upper feed roller shaft lever	1
7	S150299029	Screw	2
8	182F40055	Collar	1
9	S150299027	Screw	2
10	182F40041	Roller shaft bushing (right)	1
11	182F40022	Oil seal	1
12	182F40038	Upper feed roller shaft	1
13	182F46000	Upper feed roller lever rod assy	1
14	182F40034	Upper feed roller lever rod	1
15	S150299031	Screw	2
16	182F40033	Ball stud	1
17	190300010	Nut	2
18	182F40036	Upper feed roller lever pin	1
19	182F40035	Upper feed roller lever rod sleeve	1
20	S150607003	Washer 6	1
21	S120501011	Nut M6	1
22	182F40054	Upper feed roller driving rod pin	1
23	S150299027	Screw	1
24	182F40042	Upper feed roller driving rod	1
25	S150617007	Retaining ring 25	1
26	S150801040	Roller bearing	1
27	S150209058	Screw	1
28	182F40043	Upper feed roller eccentric	1
29	182F40045	Upper feed roller regulator	1
30	S150299027	Screw	2
31	182F40044	Adjusting screw	1
32	S150209044	Screw	1

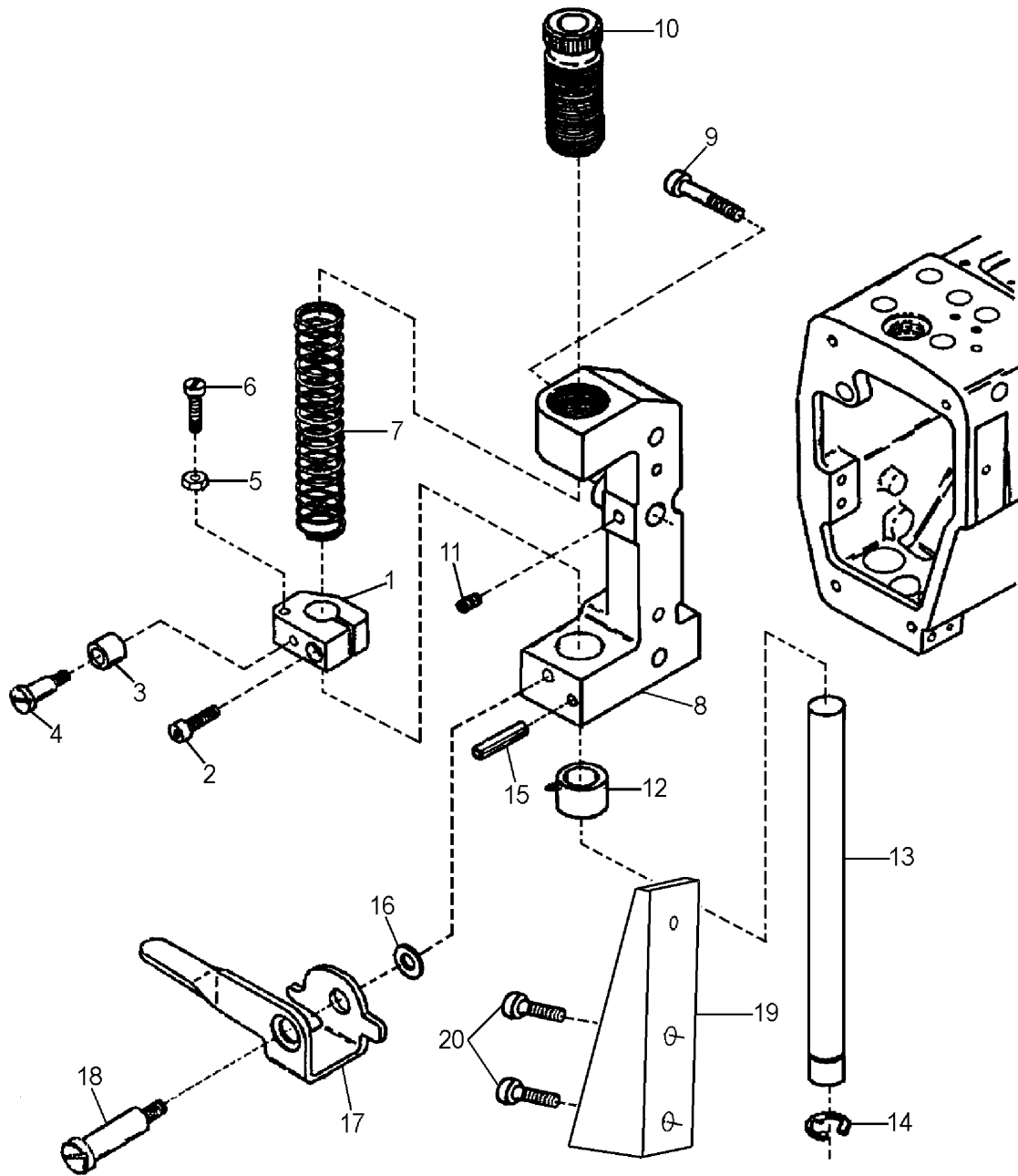
### 3. 335- 12Q SPECIAL PARTS (3)



### 3. 335- 12Q SPECIAL PARTS (3)

No.	Ref.No.	Description	Qt
1	182F40024	Upper feed roller	1
2	182F40017	Upper feed roller bracket	1
3	S150299028	Screw M5× 5	4
4	182F40018	Upper feed roller bracket guide	1
5	S150299035	Screw M4× 8	3
6	182F40019	Upper feed roller bracket pin	1
7	S150299027	Screw M4× 4	2
8	182F60048	Screw	10
9	182F40031	Screw	1
10	S150299027	Screw	1
11	S150299028	Screw	1
12	S150620003	Retaining ring	1
13	182F40022	Clutch driving shaft	1
14	182F40021	Clutch driving shaft bushing (left)	1
15	182F40020	Clutch driving shaft bushing (right)	1
16	182F40023	Clutch tension sleeve	1
17	S150503001	Adjusting nut	2
18	182F40052	Washer spring	1
19	182F49000	Clutch complete	1
20	182F40032	Clutch driving lever	1
21	182F40026	Clutch	2
22	182F40028	Spring	12
23	182F60047	Clutch spring holder	6
24	182F40027	Clutch roller	6
25	182F40029	Spacing ring	1
26	S150299027	Screw M4× 4	1
27	182F40025	Clutch sleeve	1
28	182F40030	Clutch check plate	1

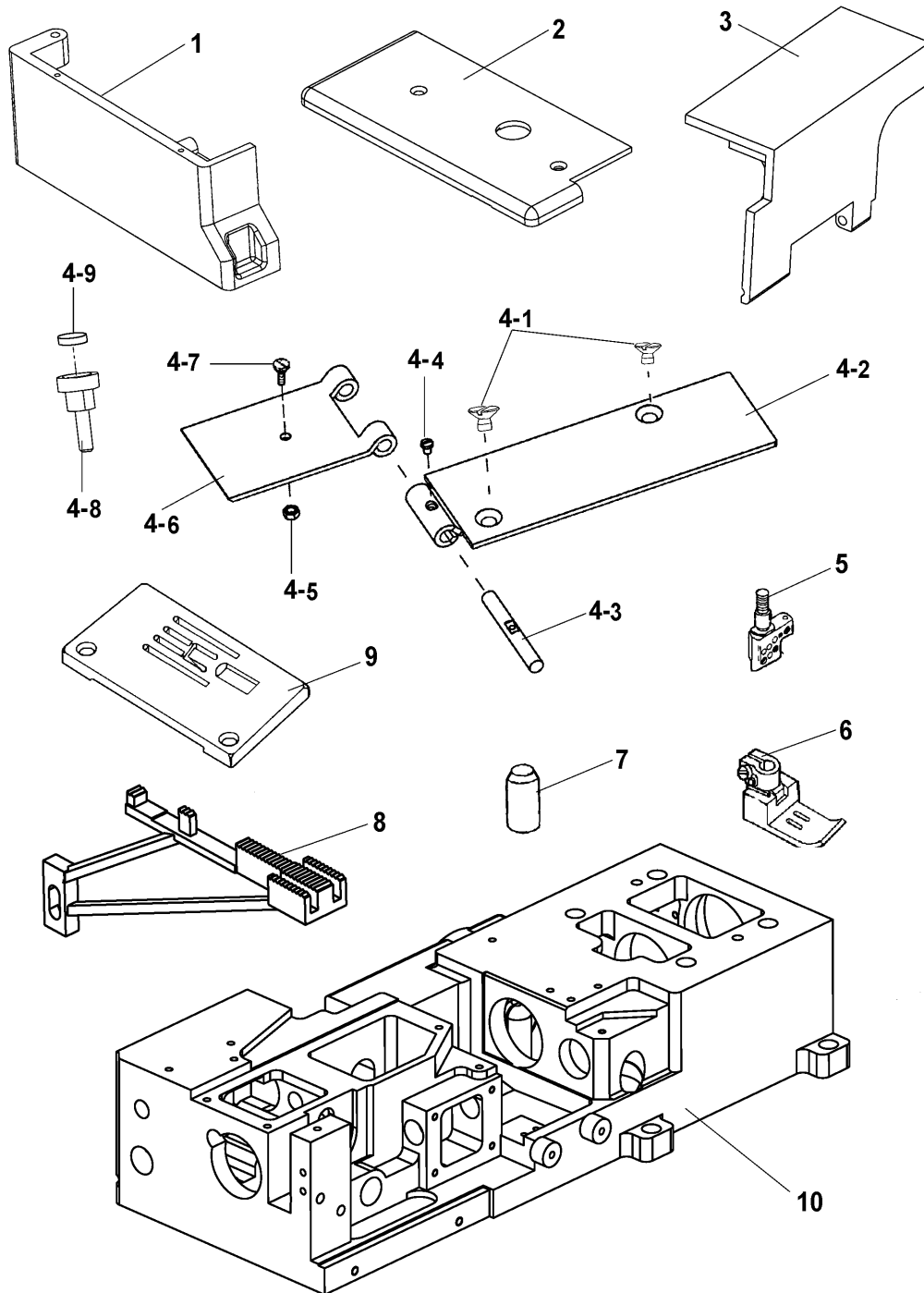
#### 4. 335- 12Q SPECIAL PARTS (4)



#### 4. 335- 12Q SPECIAL PARTS (4)

No.	Ref.No.	Description	Qt
1	182F40003	Roller press bar bracket	1
2	S150299026	Screw	1
3	182F40007	Lifting lever sleeve	1
4	182F40006	Screw	1
5	S150503003	Nut	1
6	S150216006	Screw	1
7	182F40004	Adjusting spring	1
8	182F40001	Upper feed roller bracket	1
9	S150209046	Screw	2
10	182F40049	Adjusting screw	1
11	S150299028	Screw	1
12	182F40002	Roller press bar bushing (lower)	1
13	182F40005	Upper feed roller press bar	1
14	S150617010	Retaining ring	1
15	008100018	Stop pin	1
16	022500011	Washer	2
17	182F40008	Upper feed roller lifting lever	1
18	182F40009	Screw	1
19	248A10019	Heel block	1
20	S150209056	Screw M6× 16	2

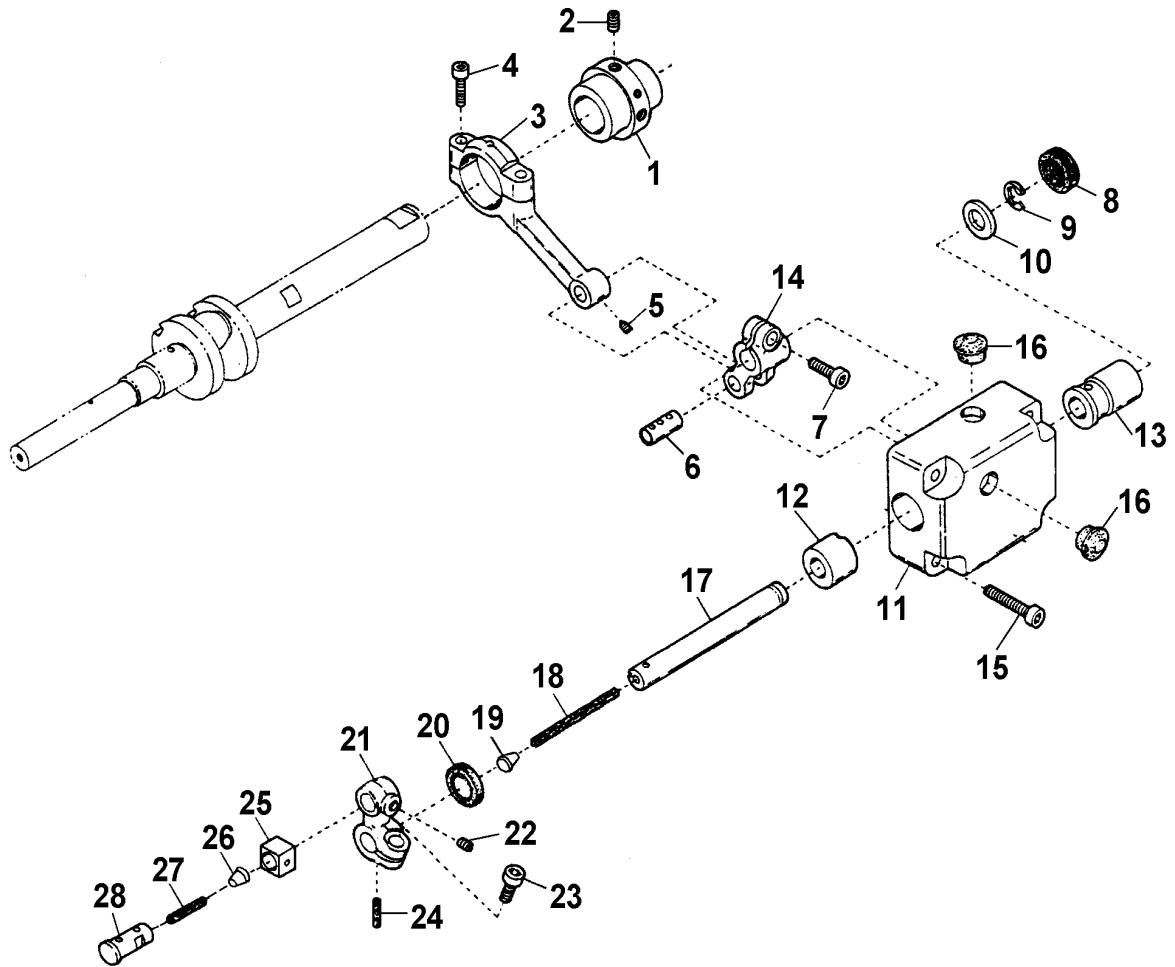
## 5. 335- 12Q SPECIAL PARTS (5)



## 5. 335- 12Q SPECIAL PARTS (5)

No.	Ref.No.	Description	Qt
1	248100003	Left cover	1
2	248100004	Left cloth plate	1
3	248100002	Front cover	1
4- 1	S150204003	Screw	2
4- 2	248101003	Right push board	1
4- 3	248101005	Pin	1
4- 4	039400020	Screw SM3/32"(2.38)× 56/4.5	1
4- 5	S150503003	Nut	1
4- 6	248101001	Left push board	1
4- 7	197120003	Screw	1
4- 8	248101004	Magnet bracket	1
4- 9	500011312	Magnet	1
5	182610003	Needle holder ( 4.8 )	1
	182610004	Needle holder ( 5.6 )	1
6	13061000048	Presser foot ( 4.8 )	1
	13061000056	Presser foot ( 5.6 )	1
7	248100010	Seal plug	1
8	248100013	Feed dog	1
9	248100007	Needle plate	1
10	248100001	Base	1

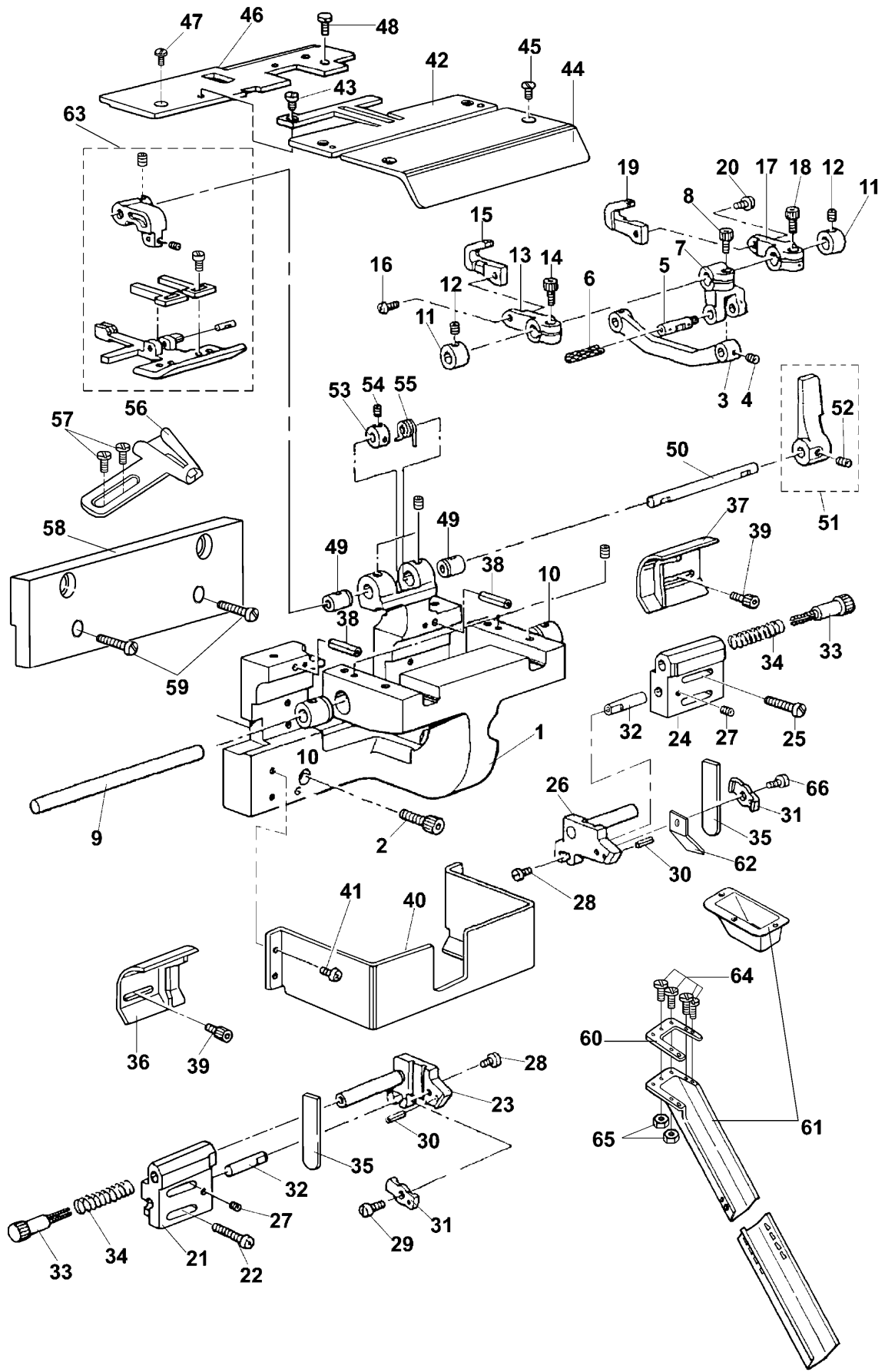
## 6. 335- 12Q SPECIAL PARTS (6)



## 6. 335- 12Q SPECIAL PARTS (6)

No.	Ref.No.	Description	Qt
1	110E00001	Double cam	1
2	S150299028	Screw GB77- 85 M5×5	1
3	110E12001	Up- knife connecting	1
4	S150209049	Screw GB70- 85 M4×14	2
5	S150299019	Screw GB78- 85,M3×4	1
6	110E10002	Pin	1
7	S150299002	Screw GB70- 85 M5×14	1
8	110500025	Rubber plug	1
9	S150620005	Retaining ring GB896- 76 φ6	1
10	110E10003	Washer	1
11	110E11001	Base	1
12	110E11002	Bushing	1
13	110E11003	Bushing	1
14	110E10001	Up- knife Right lever	1
15	S150209051	Screw GB70- 85 M4×25 ZH	4
16	110100003	Rubber plug	2
17	110E13101	Slider shaft	1
18	1105A1003	Oil wick	1
19	110E14002	Seal plug	1
20	110500024	Reservoir gasket	1
21	248100006	Left lever	1
22	S150299027	Screw GB77- 85 M4×4	1
23	S150299002	Screw GB70- 85 M5×14	1
24	110E13002	Oil wick	1
25	110E13002	Slide block	1
26	1105A1002	Seal plug	1
27	1105A1003	Oil wick	1
28	110E13101	Up- knife Slider shaft	1

# 7. 335- 12Q SPECIAL PARTS (7)



## 7. 335- 12Q SPECIAL PARTS (7)

No.	Ref.No.	Description	Qt
1	130700001	Supporting board	1
2	S150202020	Screw	2
3	248100009	Knife connecting	1
4	S150207009	Screw M4× 4	1
5	130700003	Pin	1
6	110E14001	Oil wick	1
7	130700004	Knife rest shaft crank	1
8	S150209034	Screw	1
9	130700005	Knife rest shaft	1
10	130700006	Bushing	2
11	130700007	Spring bushing	2
12	S150299027	Screw M4× 4	4
13	130700008	Left knife crank	1
14	S150206034	Screw	1
15	130700009	Up- lifter knife	1
16	S150202011	Screw	1
17	130700010	Right knife crank	1
18	S150209034	Screw	1
19	130700011	Up- righter knife	1
20	S150202011	Screw	1
21	130700012	Left knife bracket	1
22	S150202019	Screw	2
23	130700013	Left knife holder	1
24	130700014	Right knife bracket	1
25	S150202019	Screw	2
26	130700015	Right knife holder	1
27	S150202010	Screw	2
28	SFB0201001	Screw	2
29	S150209044	Screw M4× 8	1
30	130700016	Pin	2
31	130700017	Lower knife board	2
32	130700018	Lower knife shaft	2
33	130700019	Adjust screw	2
34	130700020	Spring	2
35	130700021	Lower knife	2



## 7. 335- 12Q SPECIAL PARTS (7)

No.	Ref.No.	Description	Qt
36	13071	Cover assembly of left knife	1
37	13072	Chip guide	1
38	130700024	Pin	2
39	S150299035	Screw M4× 8	2
40	130700025	Material drop plate	1
41	S150202010	Screw	4
42	130700026	Knife plate	1
43	S150103001	Screw	3
44	130700027	Front face cover	1
45	S150204003	Screw	2
46	248100008	Lapper base	1
47	S150204003	Screw	1
48	S150103008	Bolt	1
49	130700029	Bushing	2
50	130700030	Sub presser shaft	1
51	130700031	Presser bar lifter with screw	1
52	S150299028	Screw M5× 5	2
53	130700032	Front presser collar	1
54	S150299027	Screw M4× 4	2
55	130700033	Front presser spring	1
56	13074	Edge fomer (8mm)	1
	13075	Edge fomer (9mm)	1
	13076	Edge fomer (10mm)	1
	13077	Edge fomer (12mm)	1
	13078	Edge fomer (15mm)	1
	13079	Edge fomer (20mm)	1
	130711	5/16"Edge fomer	1
	130711B	5/16"Edge fomer (L)	1
	130712	3/8"Edge fomer	1
	130712B	3/8"Edge fomer (L)	1
	130713	1/2"Edge fomer	1
	130713B	1/2"Edge fomer (L)	1
	130713L	1/2"Edge fomer (H)	1
57	S150202015	Screw	2
58	248100011	Link board	1
59	008400057	Screw	2
60	130700046	Link board	1
61	13073	Waste chute slot assembly	1
62	130700048	Right material guide	1
63	13070N	Front presser assembly	1
64	S150103011	Screw	4
65	S150503003	Nut	4
66	S150299005	Screw M4× 10	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.355 Taibai South Road,  
Xi'an, P.R.China-710068  
Tel :+86-29-88279091 88279150  
Fax :+86-29-88249715 88245215  
E-mail:typical@chinatypical.com  
Http:www.chinatypical.com  
Http:www.globalsources.com