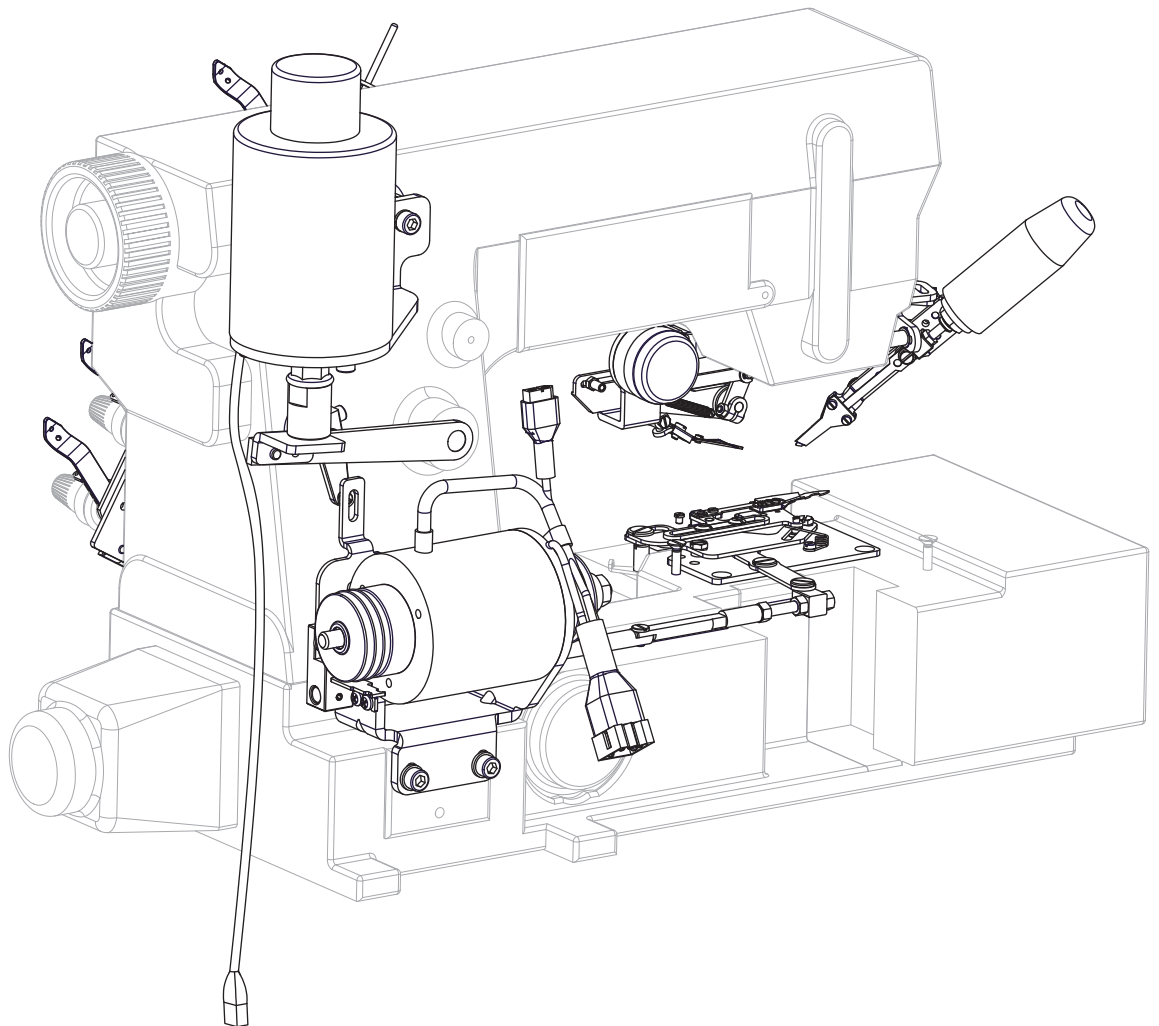


GK335D3 Series

ELECTRIC AUTOMATIC TRIMMER DEVICE

Installation Manual Parts List



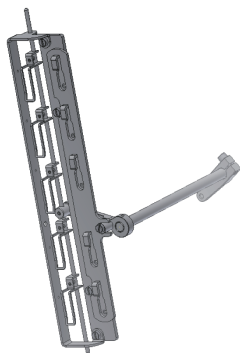
Caution

- Follow the installation manual can help you finish the installation in a short time;
- Before installation, assure the electric control box input voltage is AC220V and the output voltage is DC24V;
- After mounted, assure the trimmer electromagnet ground cable (yellow green cable) is connected to the ground.

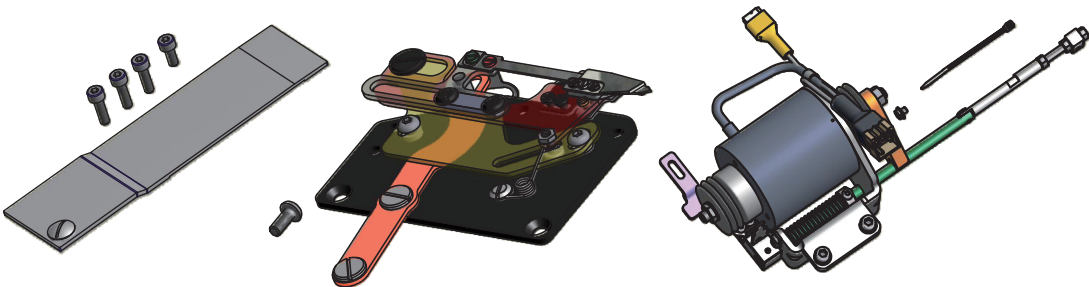
Warning

Shut down the power breaker before installation and only the technician people can operate.

The components of the automatic trimmer device:



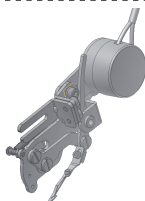
(TT)
Thread releaser



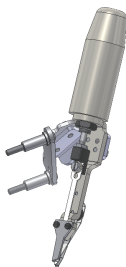
(UT)
Under-bed trimmer



(LFE)
Presser foot lifter



(WP)
Wiper device



(ST)
Top trimmer



Please check the outside package box marks. The ticks represent the devices you buy.

1、UT device adjusting:

First roll the hand wheel make the P point aligned “●”, the needle at the upper position, the looper at the forefront position.

- 【 A 】 Put the moving knife at the cutting limit position;
- 【 B 】 The distance between the tip of the moving knife and looper is 12mm, And activities on the moving knife tip and a curved needle Align the inside edge 1/3;
- 【 C 】 Loosen the nut ③ to adjust moving knife holder ④ can swing laterally movable blade tip, in order to achieve the effect of the adjustment;
- 【 D 】 After adjustment, fasten the screw nut.

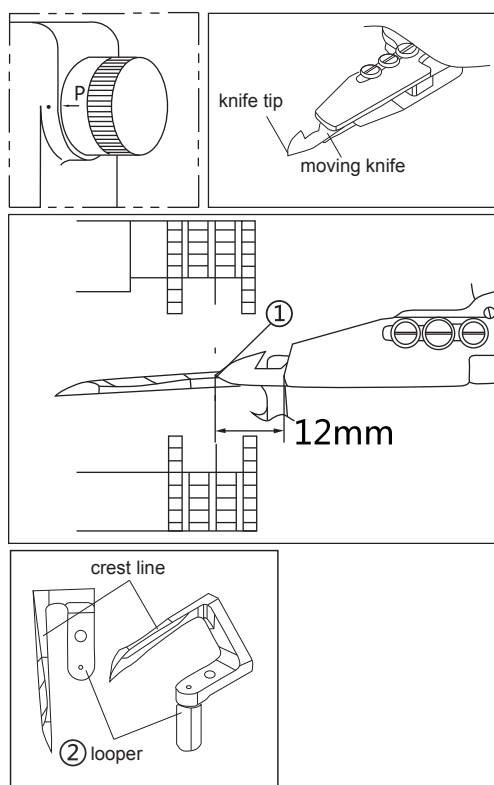


Figure 1

2、UT device Height of the knife adjustment :

Loosen the screw nut ⑤ and adjust the height adjusting screw ⑥, so activityDistance sword flank and the looper is 0-0.1 (mm), the adjustmentAfter adjustment ,fasten the screw nut ⑤.

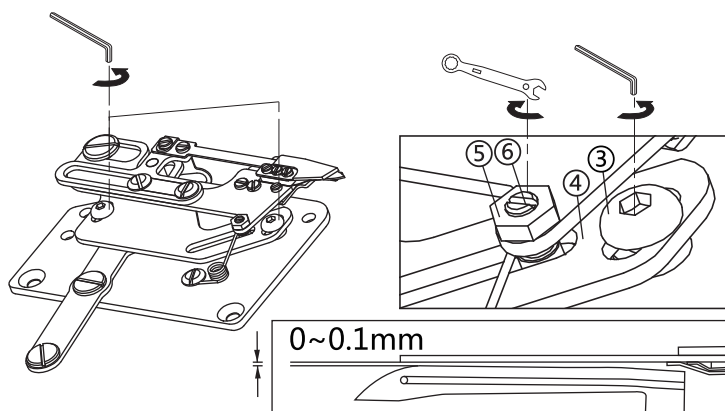


Figure 2

3、 UT device adjust position of the moving knife and needle:

- 【 A 】 Loosen the screw nut ⑦ and put the moving knife at the nearest position of the needle.
- 【 B 】 Adjust the position of the link slider ⑧, The movable knife edge over the inside of the tooth, fasten the screw nut ⑦.

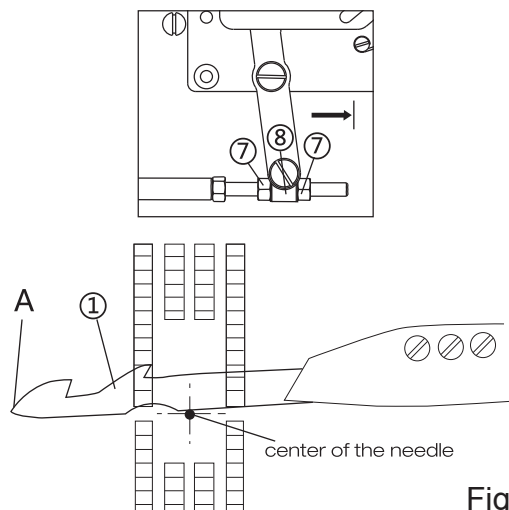


Figure 3

- 【 C 】 The position of the moving knife press spring from the fixed knife tip is 2mm, loosen the screw ⑩ can be adjusted.

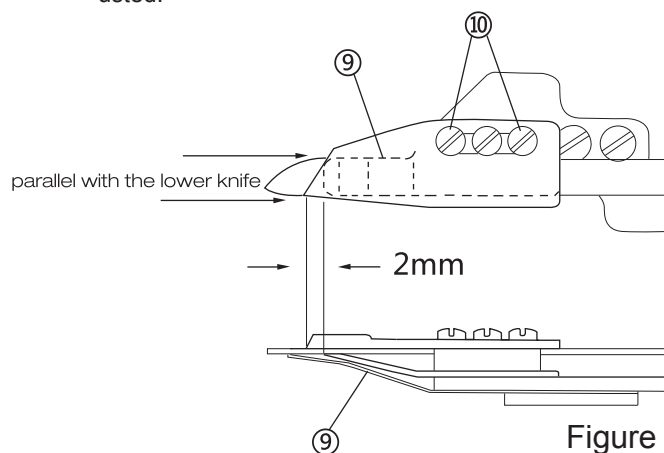


Figure 4

- 【 D 】 The installed position of the clamp at the tip of the fixed knife, loosen the screw ⑬ to adjust the position of the clamp, Make it parallel with moving knife . The pressure of the clamp can be adjust through the adjusted screw ⑫. The pressure of the clamp is 0.1kg.f, not too big or too small.

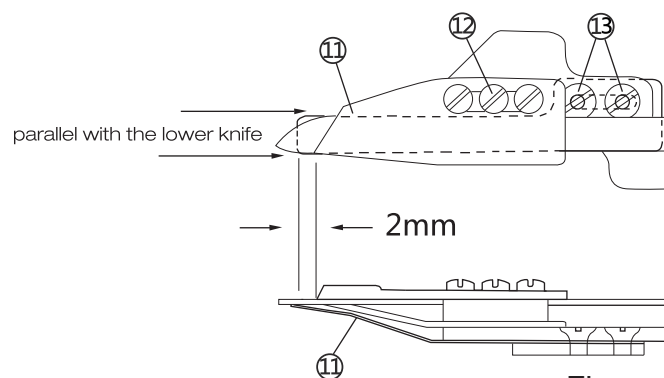


Figure 5

- 1、Put the driving lever 1 into the circle, and connect it with crank rod 2, present no need lock crank screw 3, while add lubrication into driving lever circle.

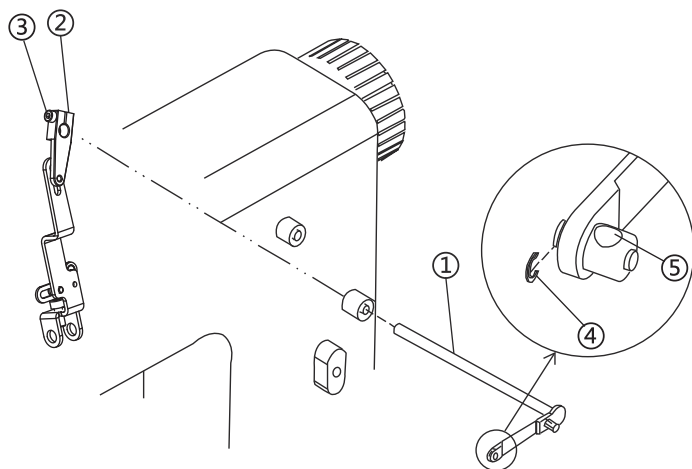


Figure 6

- 2、Install bracket 6 on thread release plate 7, and lock screw 8.

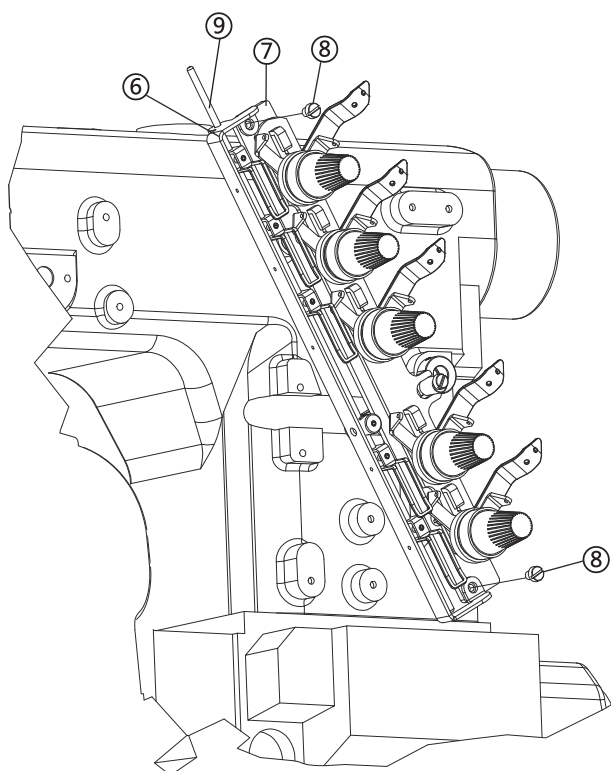


Figure 7

- 3、Pass thread release bar 9 thru thread release plate and fix into the hole of shaft 5, lift thread release bar to 30mm, lock screw 11.

- 4、Thread release device adjusting.

【 A 】 Release screw 11 , then adjust thread release bar to make sure that the distance between thread tension plate and the pawl of separation plate 10 is 0.5mm, then lock screw 3 and screw 11;

【 B 】 Adjust the thread release bar 9 to 30mm , and lock screw 11;

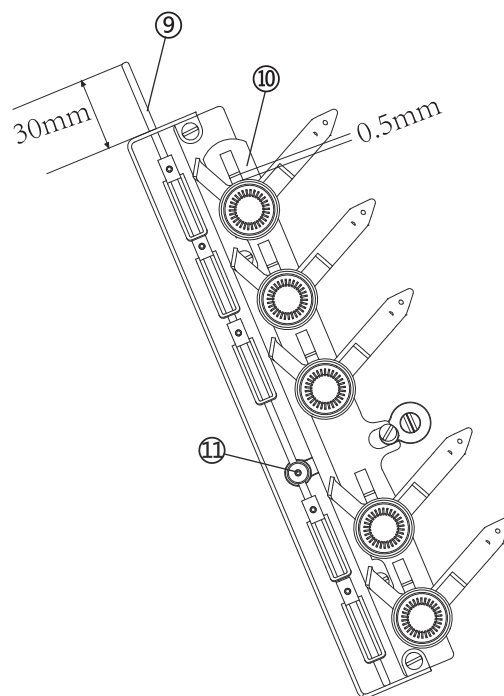


Figure 8

GK335D3

TT INSTALLATION AND ADJUSTMENT

5、Adjustment of motion sensor:

Loosen screw ① adjust the gap between motion sensor ③ (magnetic switch) and magnetic ② to 0.5mm.

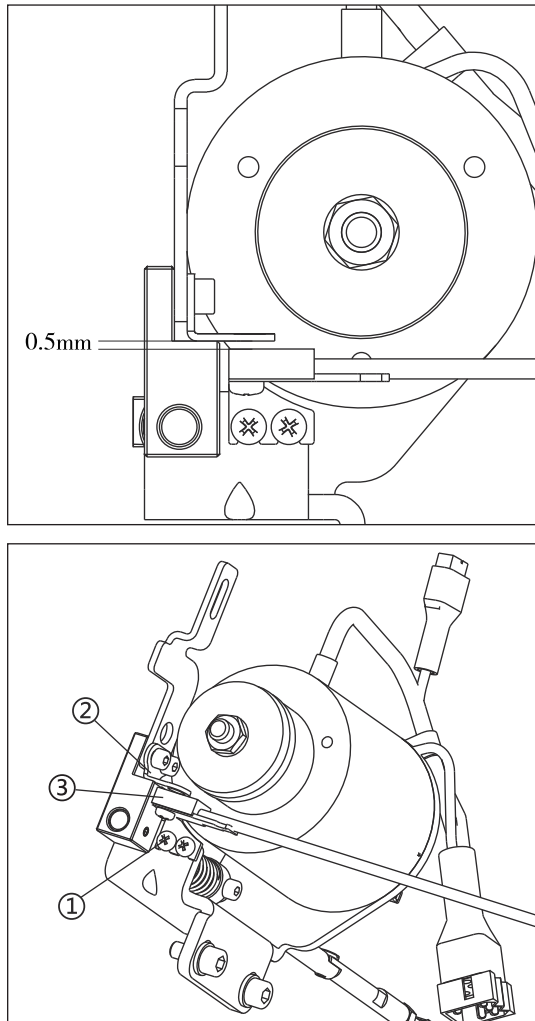


Figure 9

WP

INSTALLATION AND ADJUSTMENT

In case the hook device run into the needle, please raise the needle to the highest position during adjustment.

- 1、 Fix the hook device ② on the machine cover by screw ①.
- 2、 Adjust hook device forward, backward, upward and downward by adjust screw ③, ④.
- 3、 Adjust the position of crochet ⑤ and machine needle according picture 14. When the crochet at the far left position, its distance to the center of left needle is 10mm, the hook of crochet point A at a distance of 0.5mm to the pinpoint of machine needle, the distance between side and center of machine needle is 1.5mm.
- 4、 Locking screw ①, ③, ④ after adjustment.

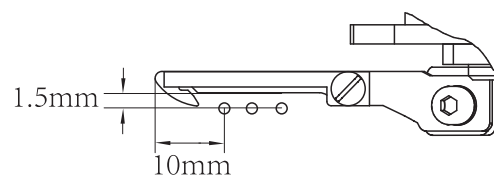
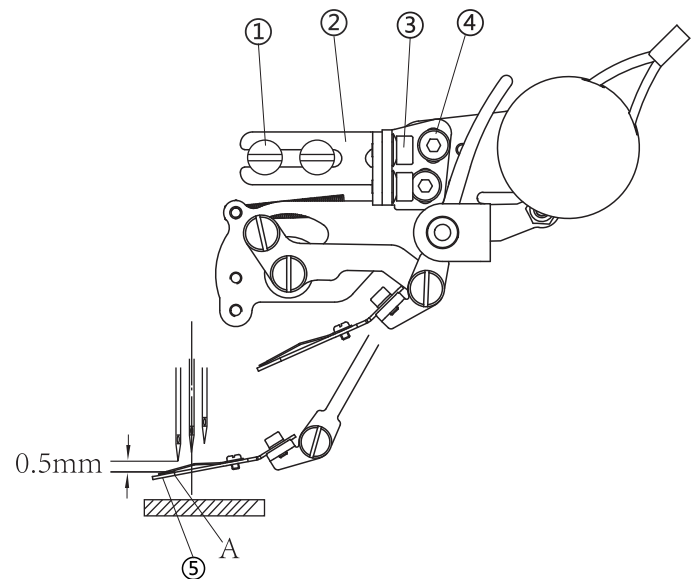


Figure10

- 1、The occlusion between movable knife and fixed knife after cutting thread is 0.5mm;
- 2、The distance between movable knife and limited point is 15mm when movable knife reach the extreme position of hooking (it means movable knife reach the limited point);
- 3、After thread cutting, upper decoration thread will be nipped by spring plate ⑤, clamping force is about 0.1kg.f, loosen the nut ③, twist the screw ④.
- 4、Loosen screw ① ② to adjust the height and left, right position of upper thread cutter.

- 5、The adjustment and checking of upper thread cutter assembly:

- 【 A 】 Lift the machine needle to the highest point , namely , P point on handwheel take aim at “●” point on the machine cover ;

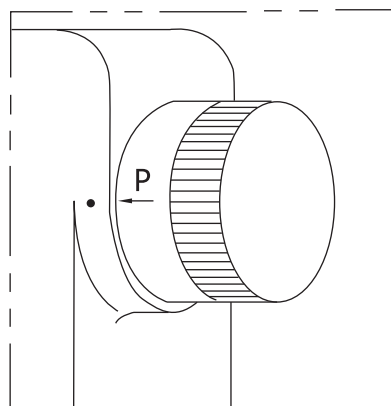


Figure 12

- 【 B 】 Adjust the stroke of movable knife ⑥ to maximum, about 15mm, the distance between movable knife and left machine needle ⑦ is 0.1-0.5mm, the highness distance between movable knife and presser foot ⑧ is 2-3mm.

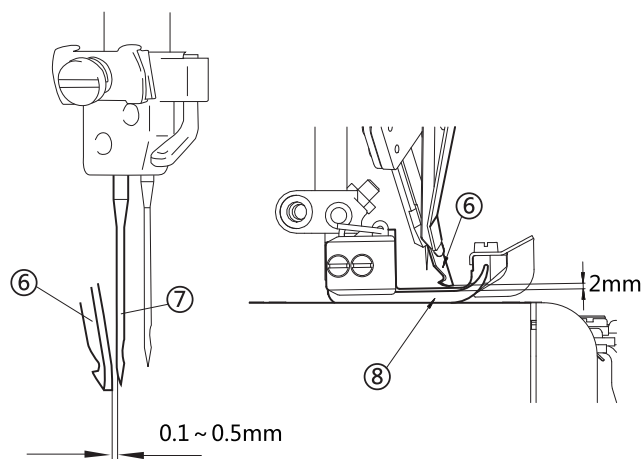


Figure 13

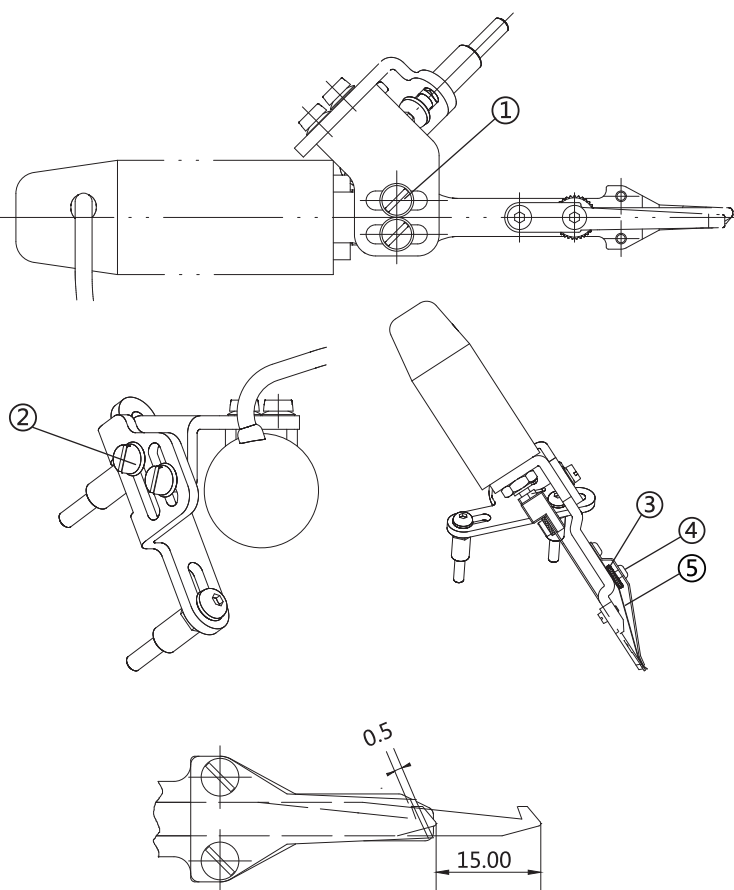


Figure 11

GK335D3

LFE INSTALLATION AND ADJUSTMENT

1、 Fix the electromagnet assembly ③ on machine cover by screw ①, washer ②. Adjust position of electromagnet nut ④ and indenter ⑤, electromagnet drive link move to the lowest position, the height of machine head presser foot lifted about 7mm, locking nut ④.

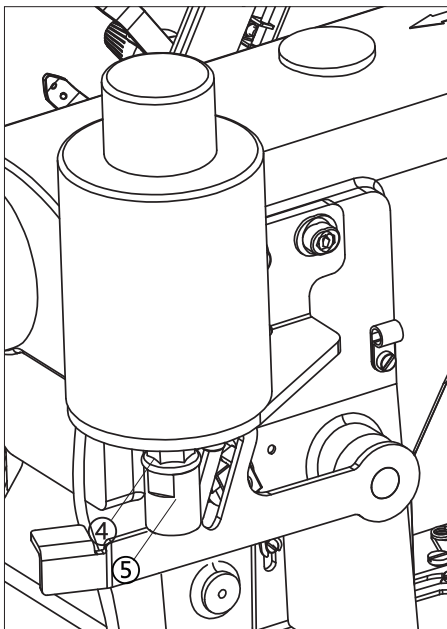
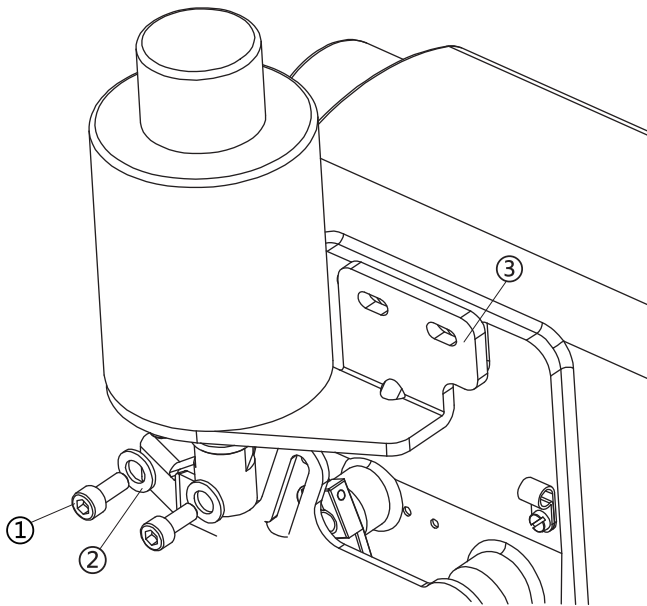


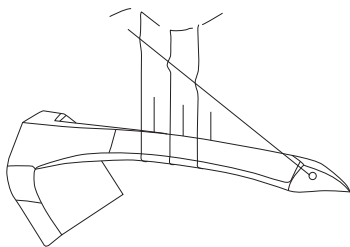
Figure 14

GK335D3

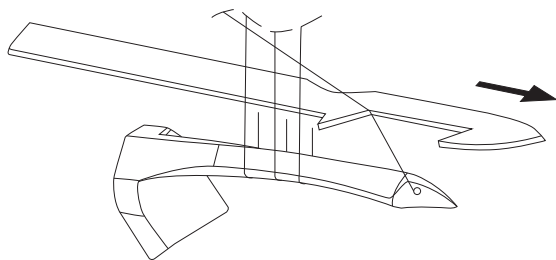
EASY OFF THE NET CORD
WINDING CAMEXCLUDE
DESCRIPTION

Normal

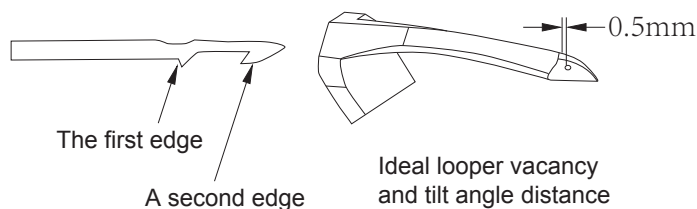
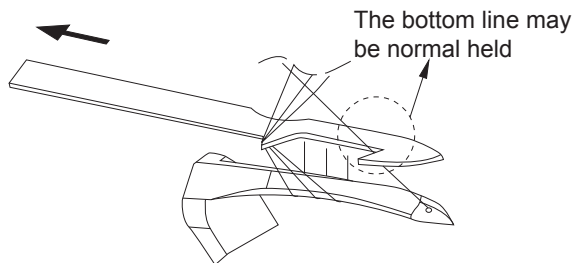
Looper positioning arrival , four -wire no wound.



When the movable knife feed , moving knife thread and the bottom line will be separated to locate .

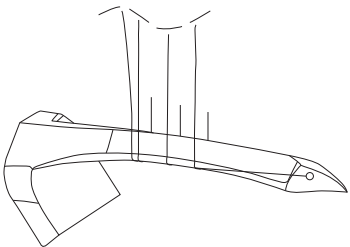


Move knife retraction , when ready cut , the first edge drive the three sewing thread for cutting , a second edge to drive the bottom line were cut move , and with the fixed blade pinching each other bottom line.

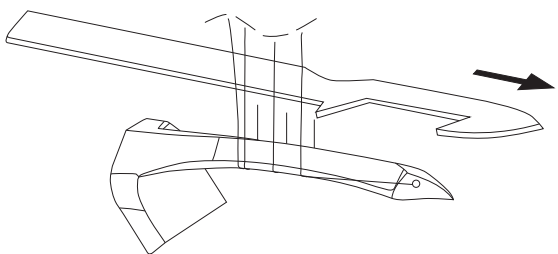


Unusual

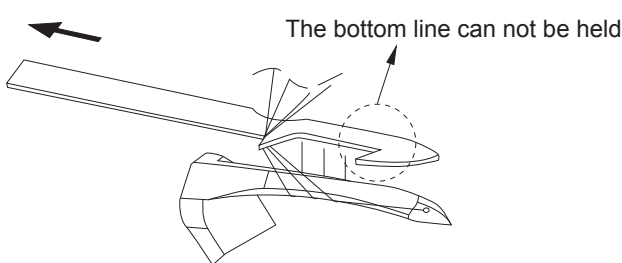
When the looper reaches the positioning , the bottom line is pulled to the bottom of the three sewing .



When the movable knife feed , moving knife does not separate the thread and the bottom line to locate.



Knife retracts , ready cut , the first cutting edge completely driven by the bottom line of sewing and cutting , forming a second edge no effect occurs and the looper thread can not be clip.

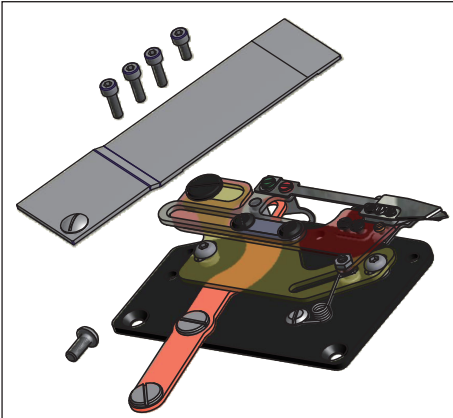
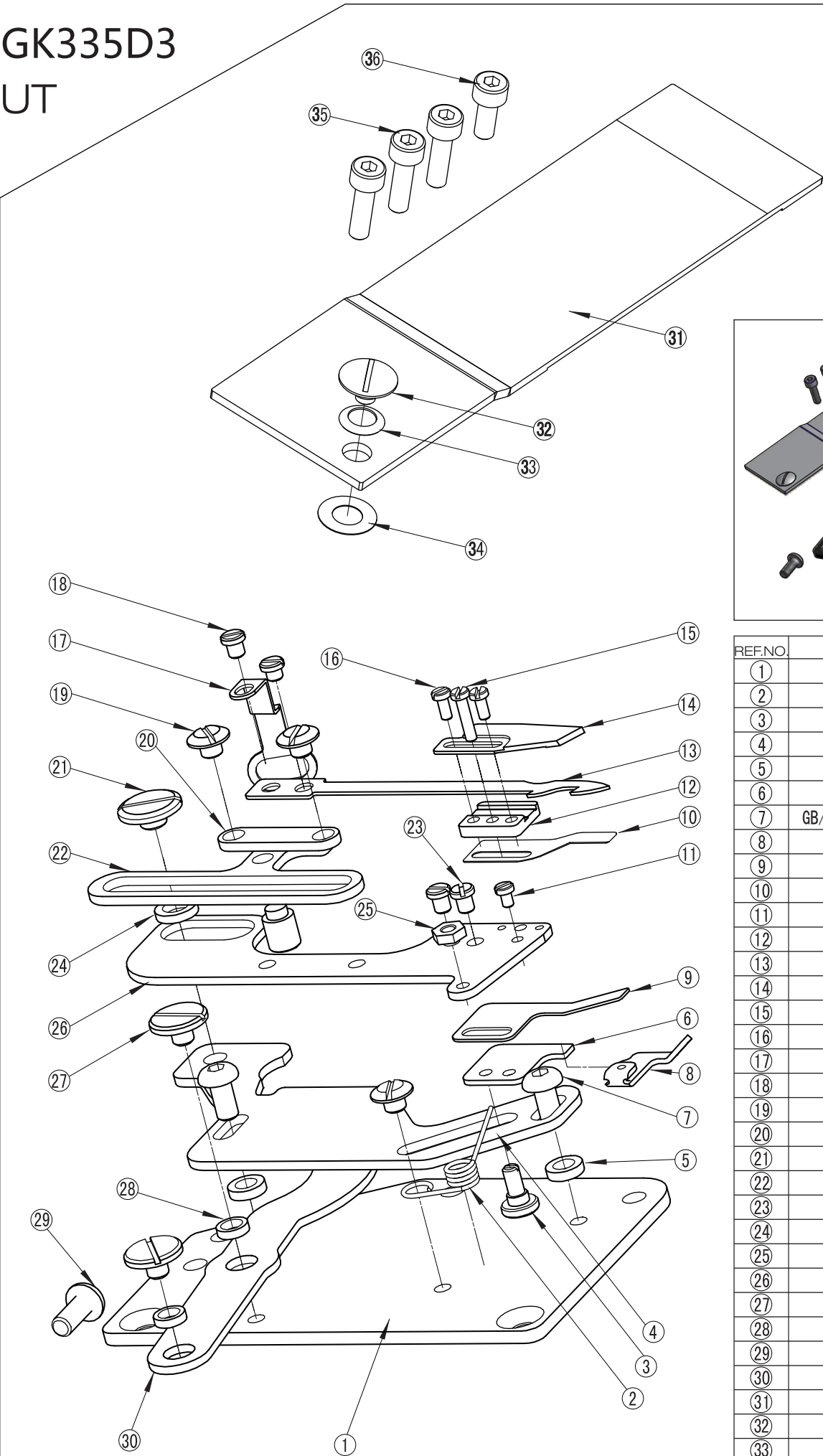


Abnormal

When the looper through thread, the lower thread friction with needle thread, causing the bottom line is drawn , moved below the looper, and can not form the normal position.

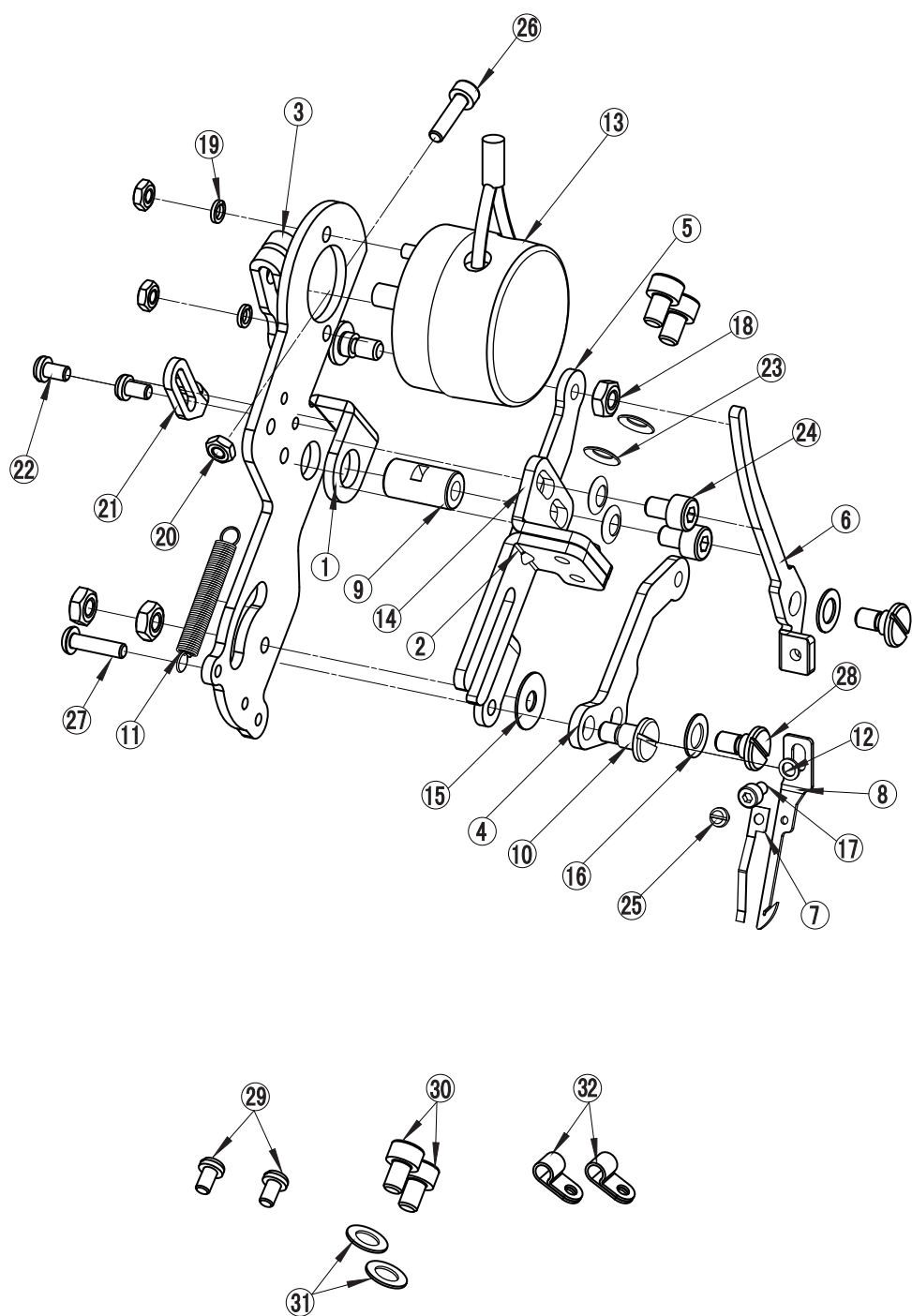
GK335D3

UT



REF.NO.	PART NO.	QTY
①	Y/VF2500EUT-001-1	1
②	Y/VF2500EUTA-001-15	1
③	TE1953	1
④	Y/VF2500EUT-001-4	1
⑤	Y/VF2500EUT-001-18	2
⑥	Y/VF2500EUT-001-10	1
⑦	GB/T 70. 2- M4 X6-12. 9-FH	2
⑧	Y/VF2500EUT-001-14	1
⑨	Y/VF2500EUT-001-11	1
⑩	Y/VF2500EUT-001-12	1
⑪	TE702	1
⑫	Y/VF2500EUT-001-13	1
⑬	Y/VF2500EUT-001-9	1
⑭	Y/VF2500EUT-001-8	1
⑮	TE1497	1
⑯	TE1962	2
⑰	T/GK335EUT-002	1
⑱	TE1081	2
⑲	TE1958	3
⑳	Y/VF2500EUT-001-6	1
㉑	TE1959	1
㉒	Y/VF2500EUT-001-5	1
㉓	SM331	2
㉔	Y/VF2500EUT-001-20	1
㉕	GB/T6172. 1-M4-04-FH	1
㉖	Y/VF2500EUT-001-3	1
㉗	TE1957	2
㉘	Y/VF2500EUT-001-19	2
㉙	TE1954	1
㉚	Y/VF2500EUT-001-2	1
㉛	T/GK335EUT-001-2	1
㉜	Y/VF2500EUT-002-3	1
㉝	GB/T1972. B-12. 5-1-FH	1
㉞	TE852 (0. 2)	1
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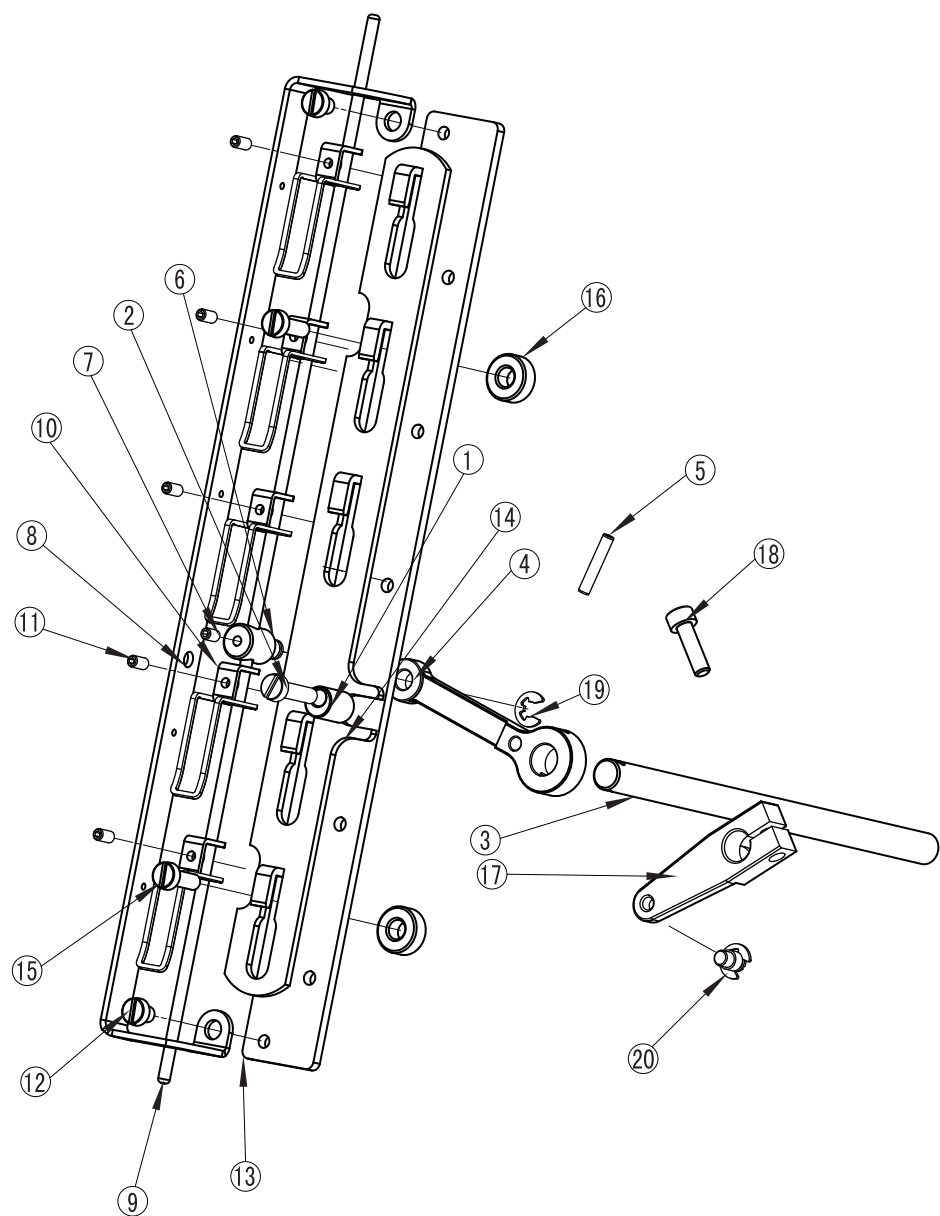
GK335D3
WP



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③	P/W600EWPC-004	1
④	P/W600EWPC-005	1
⑤	P/W600EWPC-007	1
⑥	P/W600EWPC-008	1
⑦	P/W600EWPC-009	1
⑧	P/W600EWPD-010	1
⑨	P/W600EWPC-011	1
⑩	TE2119	1
⑪	P/W600EWPC-014	1
⑫	GB/T848-3-140HV-Zn-B	1
⑬	TE2144	1
⑭	P/W600EWPC-002	1
⑮	P/W600EWPC-018	1
⑯	P/W600EWPC-015	2
⑰	GB/T70. 1-M3*4-12. 9-FH	1
⑱	GB/T6170-M4-10-FH	4
⑲	GB/T93-3-65Mn-FH	2
⑳	GB/T6170-M3-8-FH	3
㉑	P/W600EWPC-006	1
㉒	SM330/S	2
㉓	GB/T1972. B-8-FH	4
㉔	GB/T70. 1-M4*6-12. 9-FH	4
㉕	TE805	1
㉖	GB/T70. 2-M3*12-12. 9-FH	1
㉗	P/W600EWP-016	1
㉘	TE2118	3
㉙	007017A/P	2
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㉛	GB/T97.1-4-140HV-FH	2
㉜	ACC-2	2

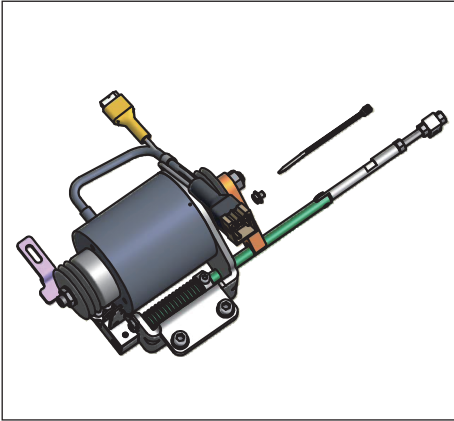
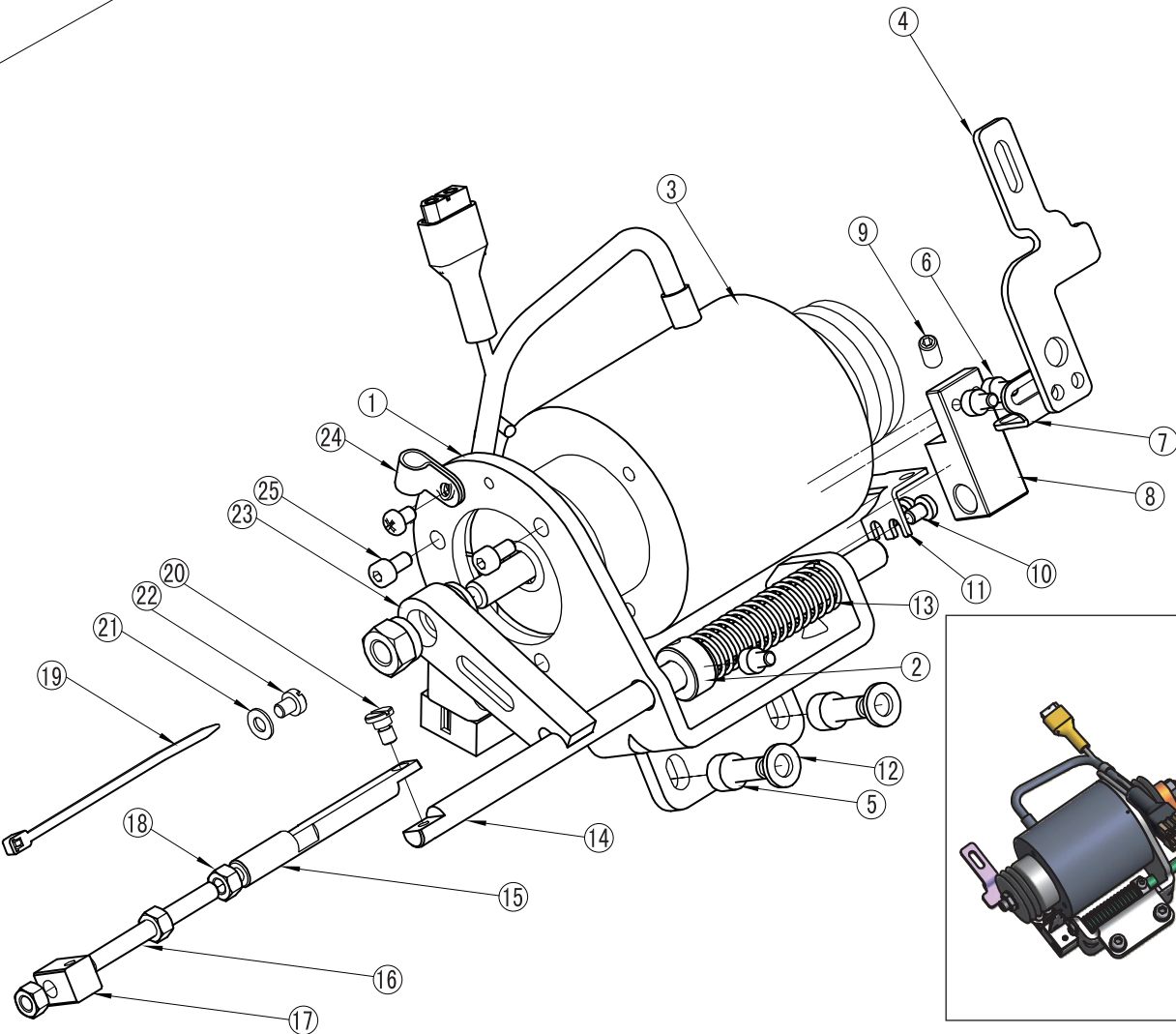
GK335D3

TT



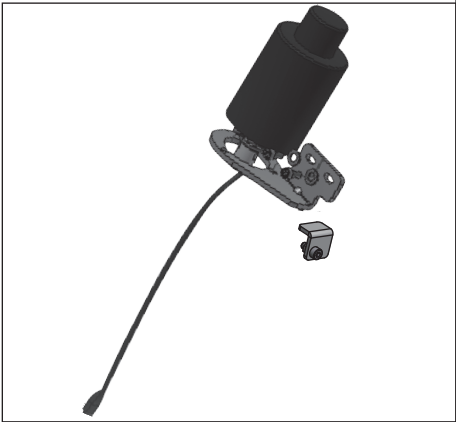
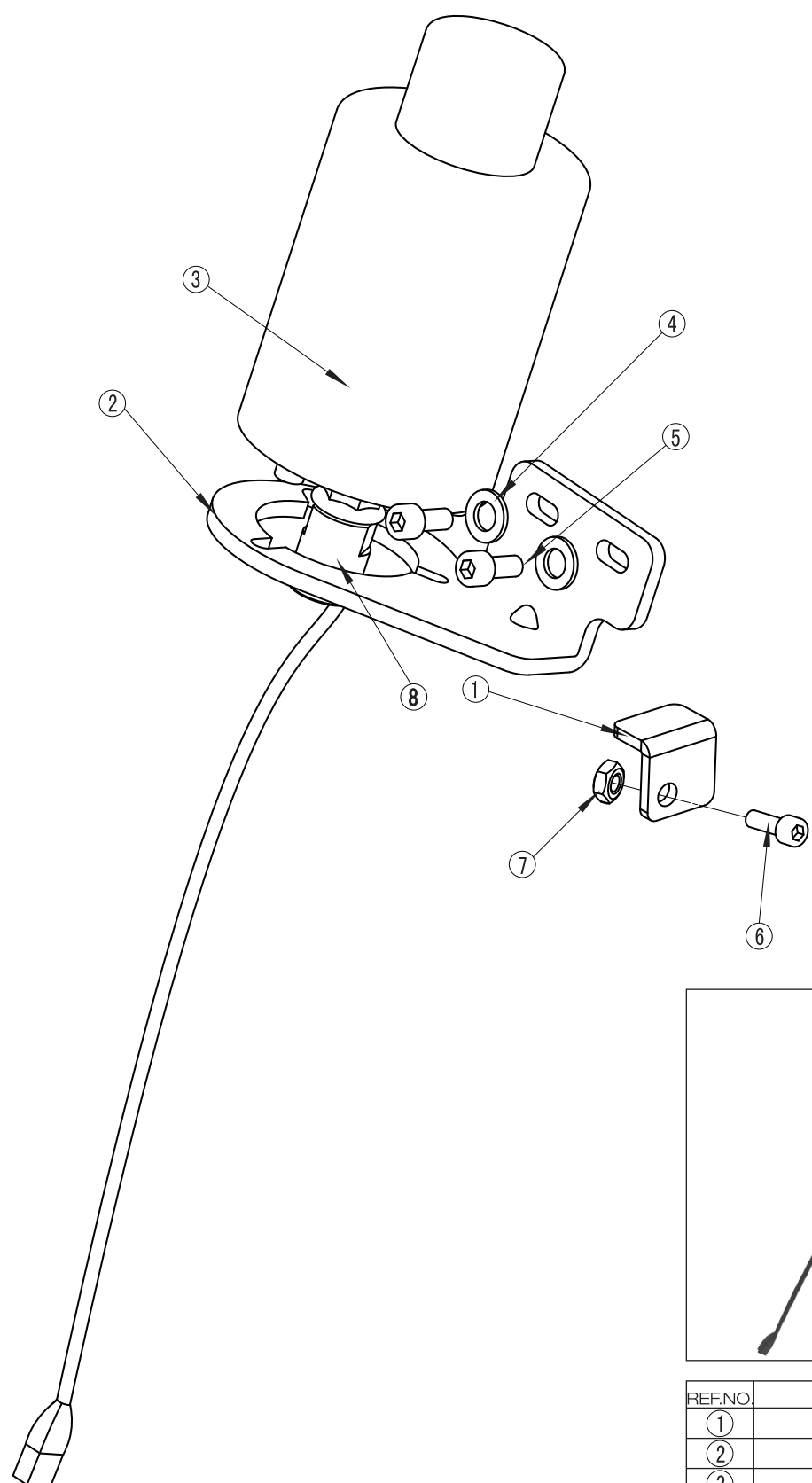
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(3)	Y/VC2700ETT-007-2-2	1
(4)	Y/VC2700ETT-007-2-1	1
(5)	GB/T879. 1-3*16	1
(6)	Y/VC2700ETT-007-1	1
(7)	GB/T77-M3*4-45H-FH	1
(8)	Y/VC2700ETT-003	1
(9)	Y/VC2700ETT-002	1
(10)	Y/VC2700ETT-006	5
(11)	GB/T77-M3*6-45H-FH	5
(12)	TE806/P	2
(13)	Y/VC2700ETT-004	1
(14)	GK370ETT-001/T	1
(15)	TE201	2
(16)	Y/VC2700ETT-001	2
(17)	Y/VC2700ETT-008-1	1
(18)	GB/T70. 1-M4*14-12. 9-FH	1
(19)	GB/T896-4-65Mn-FH	2
(20)	TE1897	1

GK335D3
DD



REF.NO.	PART NO.	QTY
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②	201665/BT	1
③	TE2389	1
④	Y/VF2500EDDA-003	1
⑤	GB/T 70.1 M6 x 14-12.9-FH	2
⑥	GB/T 70.1 M4 x 8-12.9-FH	3
⑦	Y/VF2500EDDA-005	1
⑧	Y/VF2500EDDA-004	1
⑨	GB/T 77 M4 x 5-45H-FH	1
⑩	GB/T 823 M4 x 6-12.9-FH	3
⑪	Y/VF2500EDDA-006	1
⑫	GB/T 97.1-6-140HV-FH	2
⑬	TE2246. A	1
⑭	Y/VF2500EDDA-007	1
⑮	Y/VF2500EDDA-008	1
⑯	GB/T77-M5*50-45H-FH	1
⑰	Y/VF2500EDD-001	1
⑱	GB/T 6170-M5-6-FH	3
⑲	ALT-085S-B	1
⑳	TE1290	1
㉑	GB/T97.1-4-140HV-FH	1
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㉔	ACC-2	1
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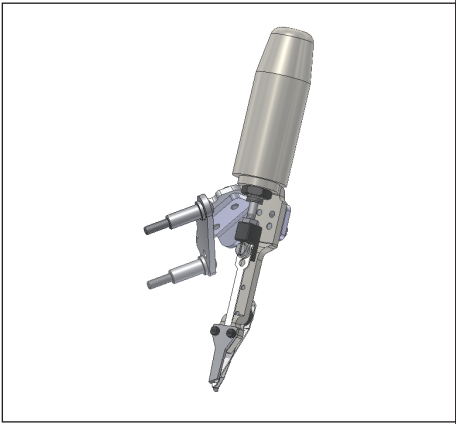
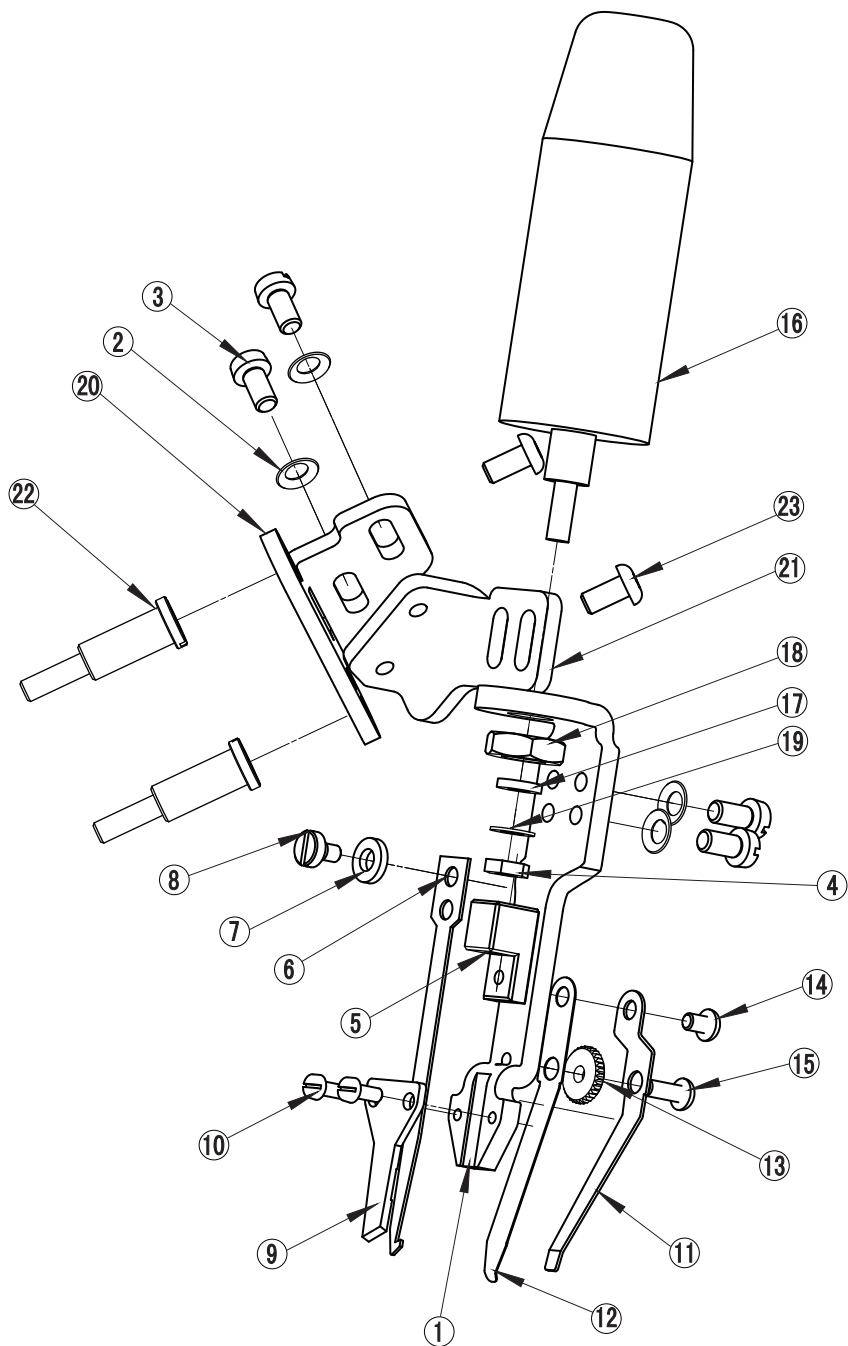
GK335D3
LFE



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②	Y/VC2700ELFE-001	1
③	TE2274.A	1
④	GB/T97. 1-6-140HV-Zn-B	2
⑤	GB/T70. 1-M6*16-12. 9-FH-A	2
⑥	GB/T70.1-M5*12-12.9-FH	1
⑦	GB/T6170-M5-6-FH	1
⑧	TE2963A	1

GK335D3

ST



REF.NO.	PART NO.	QTY
①	P/W600ESTA-001	1
②	GB/T1972. B-8-FH	4
③	P/W600PST-010	4
④	TE3353-4	1
⑤	P/W600PSTA-008	1
⑥	P/W600PST-004	1
⑦	P/W600PST-006	1
⑧	TE1513	1
⑨	P/W600PST-005	1
⑩	TE1512	2
⑪	KE233	1
⑫	KE232. A	1
⑬	P/W600EST-018	1
⑭	GB/T70. 1-M3*4-12. 9-FH	1
⑮	GB/T70. 2-M3*8-12. 9-FH	1
⑯	TE3353	1
⑰	TE3353-1	1
⑱	TE3353-2	1
⑲	TE3353-3	1
⑳	P/W600ESTB-003	1
㉑	P/W600ESTB-002	1
㉒	TE1094	2
㉓	GB/T70. 2-M4*8-12. 9-FH	2