

NEWLONG Industrial Sewing Machine

INSTRUCTION MANUAL

MODEL P-7

PORTABLE SACK SEWING MACHINE

NEWLONG MACHINE WORKS, LTD.

TOKYO, JAPAN.

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SPECIFICATIONS

TECHNICAL DETAILS

Speed	sec/bag	5 - 8
Seam		Single Thread Chain Stitch
Stitch Range	mm.	7.2 (fixed)
Revolution	rpm.	1,000
Needle		DNx1- #25
Thread	vinylon	20 x 6
Drive Motor		45 W
Power Supply		110, 120 or 220 V., A. C. 50 - 60 c/s, Single Phase
Net Weight	kgs	5.2 Including Thread Cone, Shoulder Belt.
Machine Dimension	mm.	235(L) x 245(W) x 295(H)
Packing Dimension	cft.	2.5

STANDRD ACCESSORIES

1. Needles DNx1- #25	10 pcs.
2. Thread Vinylon 20 x 6	1 cone
3. Screw Driver	2 pcs.
4. Pincette	1 pce.
5. Needle Bar Spanner	1 pce.
6. Oil	1 can
7. Oiler	1 set

I. GENERAL DESCRIPTION

This is the portable type filled bag closer, which closes any kinds of bags such as kraft paper, gunny, cotton, P. P. woven cloth, P. E. film and etc., for cement, sugar, flour, fertiliser, chemicals and etc.

You may find the closer is very convenient, since it can be used to close bags at anywhere and anytime. It is also used for re-packing of damaged bags in warehouse or during transportation.

Closed bags by the bag closer, is easily opened by just pulling the end of seam, because the seam is chain stitched.

II. DRIVE MECHANISM

Main Shaft is driven by pulley which is connected with motor pulley by means of timing-belt. The movement of Lower Shaft controls Crank Connecting Rod, Needle Bar Crank Lower, Needle Bar and Needle by intermediary of Eccentric Cam. At the same time, the Main Shaft drives Loper directly and also regulates movement of Feed Dog through Feed Shaft.

These three movements of Needle, Loper and Feed Dog are so controlled to each other that Loper picks up thread which Needle is in its upward movement and chain stitch is accomplished. At this instance, Feed Dog is protruded above the Needle Plate and put bag forward.

III. HOW TO OPERATE

1. Oiling

Oiling is important and necessary treatment to keep the machine in good condition for a long time. Put oil in oil hole of machine marked with "OIL" before operation.

2. Needle Setting

Turn the pulley or knob located at the end of motor shaft until Needle Bar reaches its highest position.

Loosen the Needle Bar Clamp Nut, and set Needle in the Needle Bar as deep as it will go.

Be sure to set a Needle so that the concave part of needle faces correctly towards the Loper side.

Fix the Clamp Nut tightly, otherwise Needle shall break during operation.

3. Threading

The machine is delivered being threaded to show you proper threading of the machine. Proper threading of the machine is shown in Fig. 1 for your reference. Follow the guide number of 1 to 6.

- ① Thread Guide
- ② Thread Tension Guide
- ③ Tension Disc
- ④ Thread Guide
- ⑤ Needle Bar
- ⑥ Needle

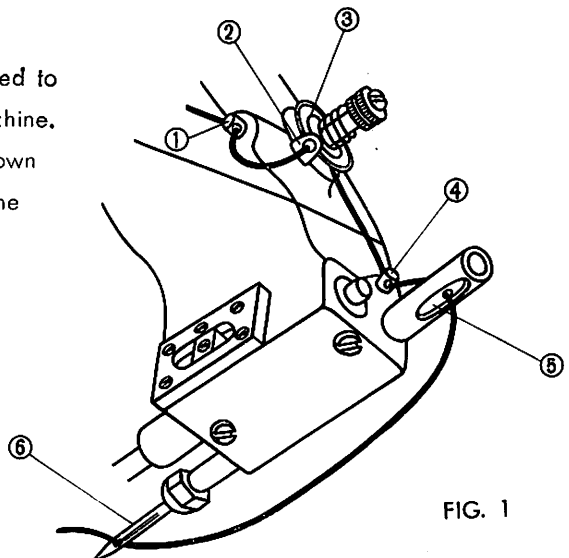


FIG. 1

IV. START

Before starting, firstly make sure that your electric supply agrees with the specification of the motor.

Suspend the machine in your right hand and put your index-finger on the switch button in the handle.

Support the bag in your left hand and lightly insert bag mouth edge between Feed Dog and Presser Foot.

Run the machine as per the photo of catalogues paying attention to make the bag straight.

After sewing, the thread is easily cut by automatic cutter on putting the thread into cutter device.

When cutting thread, leave above 3 cm thread from the end of bag to prevent the accident of opening mouth during transportation caused by the loosening of seam.

V. GENERAL CARE

1. Try the machine by using empty bags and make sure you are well used in its operation before actual work.
2. Sewing speed should not be faster than the feeding speed of the machine, that is, you should not pull bags while sewing.

VI. ADJUSTMENT

1. Thread Tension

If thread tension is not suitable, turn the Thread Tension Nut, clockwise direction is to tighter tension of thread, and the reverse is to loosen.

2. Position of Needle and Loper

When Loper is at the farthest way from Needle, Needle is at the lowest position, the clearance between Loper and Needle is to be about 3 mm as shown in Fig. 2.

If the clearance is not 3 mm, adjust the Loper position after loosening the screw of Loper Carrier ①.

When Loper pass through Needle, the clearance between Loper and concave part of Needle is to be 0.1 mm as shown in Fig. 2.

If not so, adjust the clearance after loosening the screw of Loper Carrier. FIG. 2

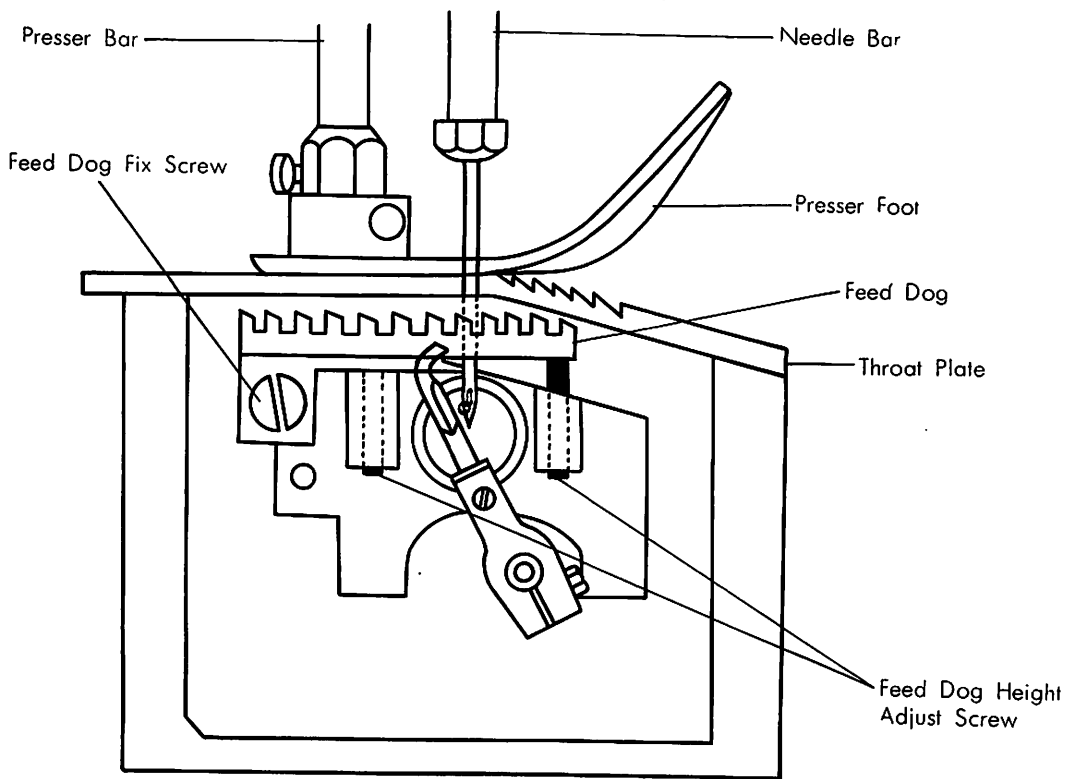
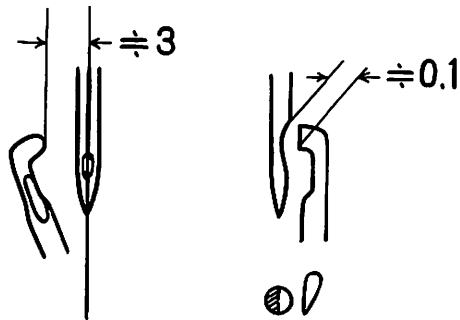


FIG. 2



3. Position of Feed Dog

Adjust Feed Dog so that the height of Feed Dog from Throat Plate is 2.5 mm when Feed Dog is at the highest position as shown in Fig. 3.

The height of Feed Dog can be adjusted by Feed Dog height adjust screw. After adjusting, fix the screw by fixing screw in double.

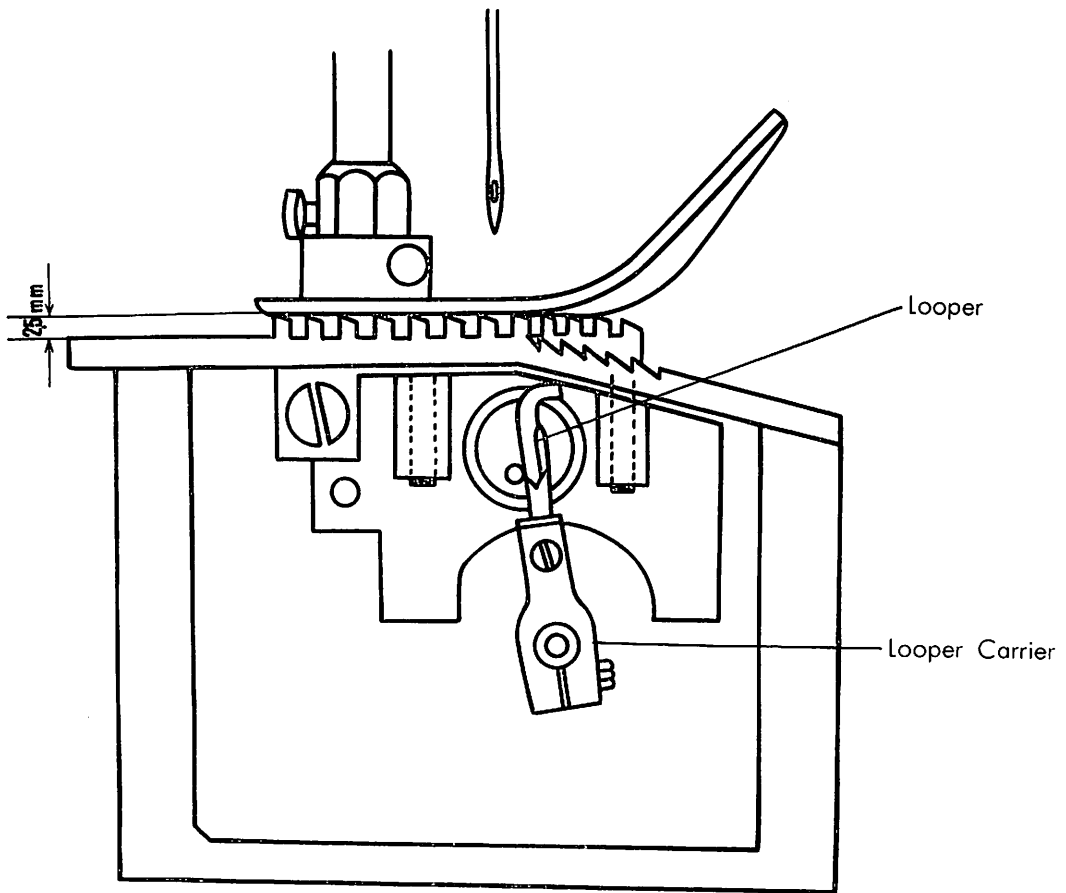


FIG. 3

4. Pressure of Presser Foot

When you adjust the pressure of presser foot, take out face plate and loosen screw of Presser Bar Bracket. If you go up Presser Bar Bracket, it shall be strong.

After adjustment, completely tighten the screw, because large pressure shall be given to the screw. **FIG. 3**

VII. MAINTENANCE & LUBRICATION

Cleaning of the machine is required after the day's work is finished.

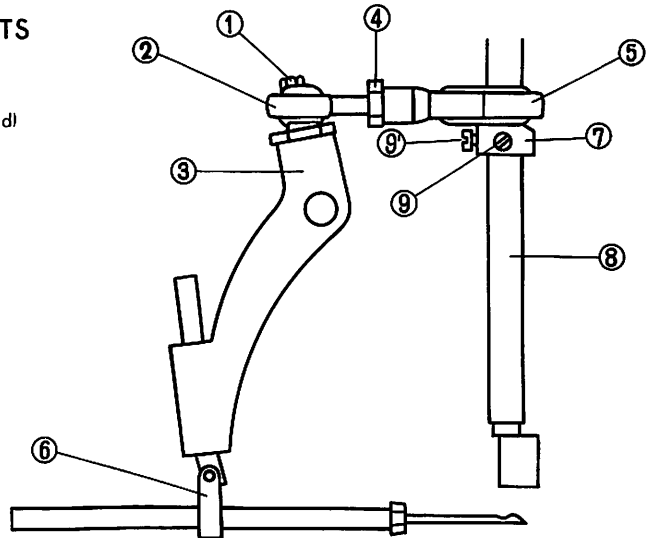
Especially wipe off fine dust and foreign matters of Feed Dog teeth, Looper and Throat Plate eyelets, where such dusts easily stacks.

Care should be taken that fine machine will be prevented against rust if to leave the machine not being used for a certain period.

For lubrication, we recommend Shell X-100, Motor Oil 10 W/30, Shell Vitria Oil 31 or the equivalent. One or two drips from hand oiler is sufficient for the closer every day.

VIII. HOW TO CHANGE PARTS

- ① Fixing Screw
- ② Crank Connecting Rod (End)
- ③ Needle Bar Lever
- ④ Nut
- ⑤ Crank Connecting Rod
- ⑥ Needle Bar Clamp
- ⑦ Eccentric Cam
- ⑧ Main Shaft
- ⑨ ⑨' Screws



When necessary to change or adjust Ball Rod, refer Fig. 4.

FIG. 4

Take out Fixing Screw ① and disconnect Crank Connecting Rod (End) ② with Needle Bar Lever ③.

After loosening Nut ④, change the distance between ⑤ and ②, so that Needle Bar works in the center of distance between upper and lower bushing.

(At the same time, Needle Bar stroke is 37 mm.)

When you disconnect Crank Connecting Rod ⑤ with Eccentric Cam ⑦, take out motor and motor base and insert your screw driver through guide hole and disconnect ⑤.

If you fix Eccentric Cam ⑦ on Main Shaft ⑧, tighten the screw ⑨ and fix the screw ⑨' on Main Shaft ⑧.

(At the same time, Eccentric Cam ⑦ should be slightly touched with bushing.) The position of Needle is adjusted so that the distance between the top of Needle and Throat Plate is to be 13 mm. by loosening Nut ⑥ in Fig.4, Needle Bar can be moved as shown in Fig.5.

When fixing Loper Drive Cam ③, adjust as follows; (Refer Fig. 6)

- i) Put the screw ② to the counter cut on Main Shaft ①.
- ii) Adjust Arm (B) ④, so that Loper Cam ③ and Arm (A) ⑤ moves smoothly. After adjusting, fix screw ⑥.
- iii) The clearance between Loper Cam ③ and Arm ⑤ is effected by Spring ⑦. Loosen screw ⑨ and turn Spring Receiver ⑧ to tighten Spring ⑦, or to loosen it to have pressure. After adjusting, tighten screw ⑨ to fix Spring Receiver ⑧.

- ① Main Shaft
- ② Screw
- ③ Looper Drive Cam
- ④ Arm (B)
- ⑤ Arm (A)
- ⑥ Screw
- ⑦ Presser Bar Spring
- ⑧ Spring Receiver
- ⑨ Screw
- ⑩ Spring Connection

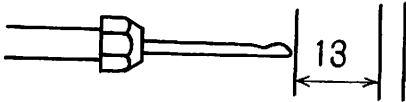


FIG. 5

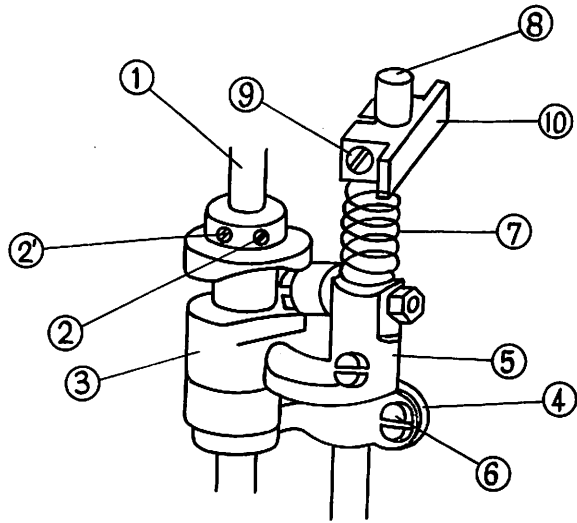


FIG. 6

