

GLOBAL

INDUSTRIAL HIGH SPEED
BLINDSTITCH MACHINE

MODEL : BM 260

INSTRUCTION MANUAL

② Adjusting Lower Knives

Turn handwheel clockwise until lower knives are at top of stroke.
Loosen nuts on ball joint connecting rod and turn connecting rod until front edge of lower knife is 1 m/m above bottom edge of top knife.
Tighten nuts (See Fig.6)

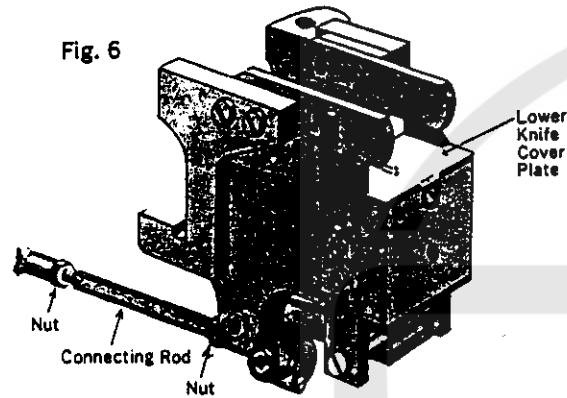


Fig. 6

③ Adjusting Folder

Loosen screw and adjust folder sideways until stitch is set at edge of top fold of belt loop (in case of single fold) or at center of top fold of belt loop (in case of double fold). (See Fig. 7)

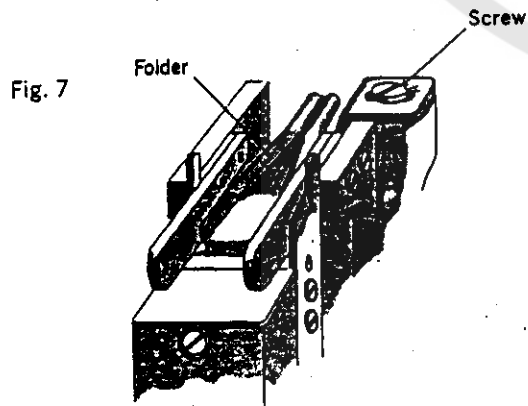


Fig. 7

I N D E X

OPERATING INSTRUCTION

1. Unpacking Machine	1
2. Setting-- up Machine (Fig. 1 & 2)	1
3. Handwheel Rotation and Speed	2
4. Oiling and Maintenance (Fig. 4)	2
5. Needle Recommendation	3
6. Replacing Needle (Fig. 5)	3
7. Threading Machine (Fig. 6)	4
8. Stitch Length Regulation (Fig. 7)	4
9. Adjustment of Needle Penetration (Fig. 8)	5
10. Removal of the work from the machine (Fig. 10)	6
11. Belt Loop Making	6

1. Unpacking Machine

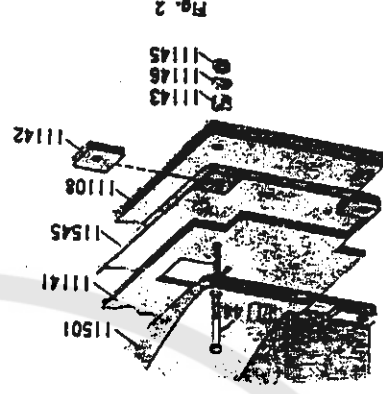
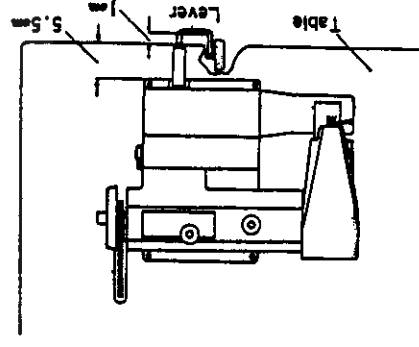
Unpack machine from its shipping box, making certain that you remove from box all component parts and accessories. Do not discard any packing material without prior scrutiny as to contents.

Clean from machine all greases, dirt, or dust.

Pay particular attention to area around the looper mechanism and looper.

2. Setting-up Machine (Figs. 1 & 2)

Assemble knee lifter lever to machine and place on sewing table so that lever is 1 cm distant from the front edge of the sewing table (The front edge of the machine frame is 5.5 cm distant from the front edge of sewing table).
Line up belt groove in belt pulley of handwheel with belt groove of motor
oil pan and felt pad assembly under machine bed before machine is tightened
down.



- 1 -

10. Removal of the work from the machine (Fig. 10)

Stop machine and turn handwheel away from operator until needle is completely out of the material.

Press the knee lifter to the right and pull

the work-piece rearward out of the machine

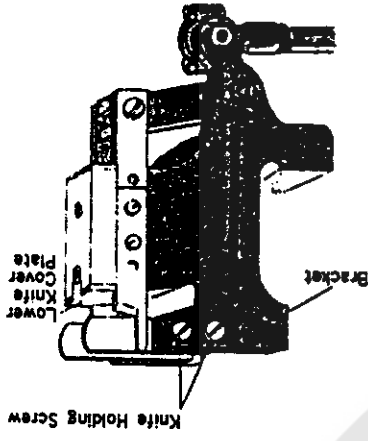
with a quick stroke. This will lock the last stitch

and break the thread.

11. Belt Loop Making

① Adjusting Top Knives

Loosen 4 knife holding screws and set top edge of knives in parallel with top edge of bracket. Then tighten screw (See Fig. 5)



- 6 -

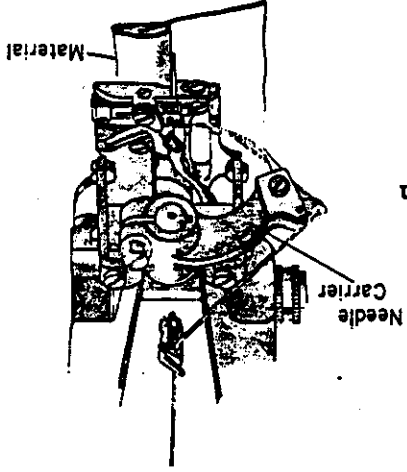
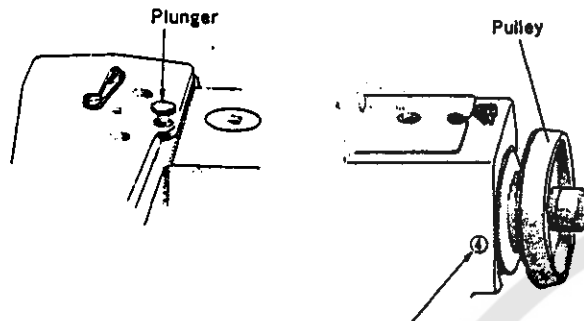


Fig. 10

Fig. 7



3. Handwheel Rotation and Speed

Turn handwheel only direction away from operator for clockwise rotation. Be sure motor drive is wired up to obtain the same clockwise rotation. However, the recommended operating speed of a brand new machine is 2,000 stitches per minute. After a breaking-in period of several weeks and after the operator has become skilled in the operation of the machine, the speed can be increased up to 3,000 stitches per minute.

4. Oiling and Maintenance (Fig. 4)

Drop oil of good quality at all points shown on the oiling chart Fig. 4 before operating machine every day. After oiling, wipe machine carefully to avoid soiling of the material. Be sure to depress knee lifter lever preventing damage to the needle and the feed dog and to operate machine without material under the presser foot for 2 or 3 minutes.

9. Adjustment of Needle Penetration (Fig. 8)

The type of material to be blindstitched governs the degree of needle penetration which is required. It is, therefore, recommended to stitch a few inches as a test and make adjustment for penetration depending on the appearance of the trial stitching.

Turn regulator clockwise for less penetration and counter-clockwise for more penetration.

The dial surrounding regulator shows the direction of turning to obtain the needle degree of needle penetration.

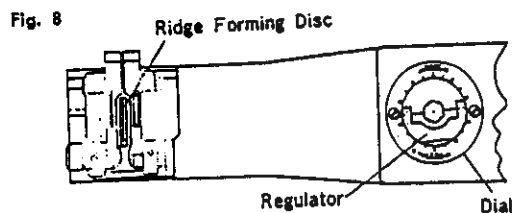
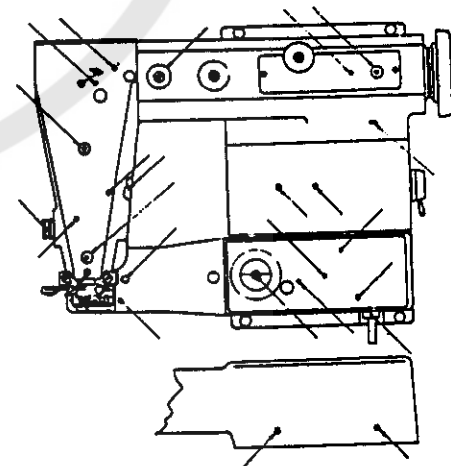


Fig. 8

Fig. 4



5. Needle Recommendation

The recommended needle is system LW x 67 blindstitch machine needle. Size range form No.3 to 4. For best results, thread and fabric must be used as suggested in the table below.

Needle	Thread	Material
Size 3 (11)	No. 80-100	Nylon, Silk and other light weight fabrics
Size 3½ (14)	No. 60-70	Cotton, Woolen and other Med. weight fabrics
Size 4 (16)	No. 50-60	Thick woolen and other thick weight fabrics

6. Replacing Needle (Fig. 5)

Turn handwheel away from operator (clockwise) until needle reaches the end of its return stroke (Extreme left hand position), adjust penetration dial to least amount of penetration (Turn clockwise toward 1).

Remove old or defective needle by loosening needle clamp screw. Insert new needle into seat in needle clamp as far as it will go. Now, tighten needle clamp screw.

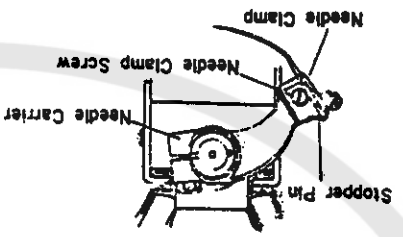


Fig. 5

Turn handwheel slowly away from operator and observe movement of needle. The curved portion of the needle should bear slightly on the needle guide groove in the left hand part of the presser foot. Always replace bent or blunt needles. They affect the satisfactory operation of the machine.

7. Threading Machine (Fig. 6)

See threading chart Fig.6

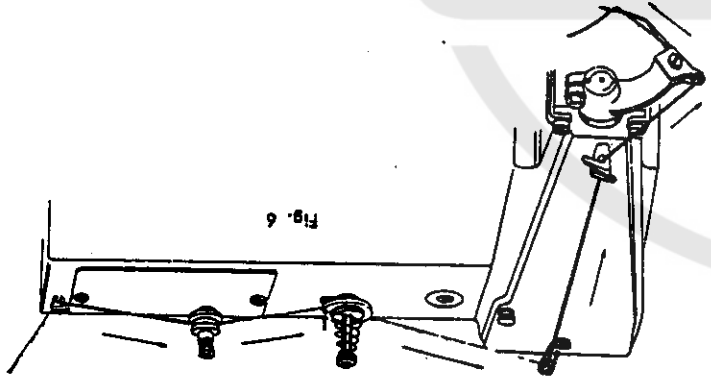


Fig. 6

8. Stitch Length Regulation (Fig.7)

To adjust length of stitch, turn handwheel away from operator and at the same time depress the plunger located on top of the machine arm. As operator turns the handwheel, the plunger is felt to drop into a recess within the mechanism inside the machine.

With the plunger remaining depressed into this recess continue turning the handwheel either forward or in reverse until the desired number (1 to 6) will come into view in the small window to the left of the handwheel.

Each number represents a certain stitch as follows.

Number appearing on Indicator :	Stitch Length (m/m)
1	3
2	4
3	5
4	6
5	7
6	8

A few trials with varied stitch lengths on different kinds of material will prove to be the best method for selection.

®

G L O B A L

INDUSTRIAL HIGH SPEED
BLINDSTITCH MACHINE

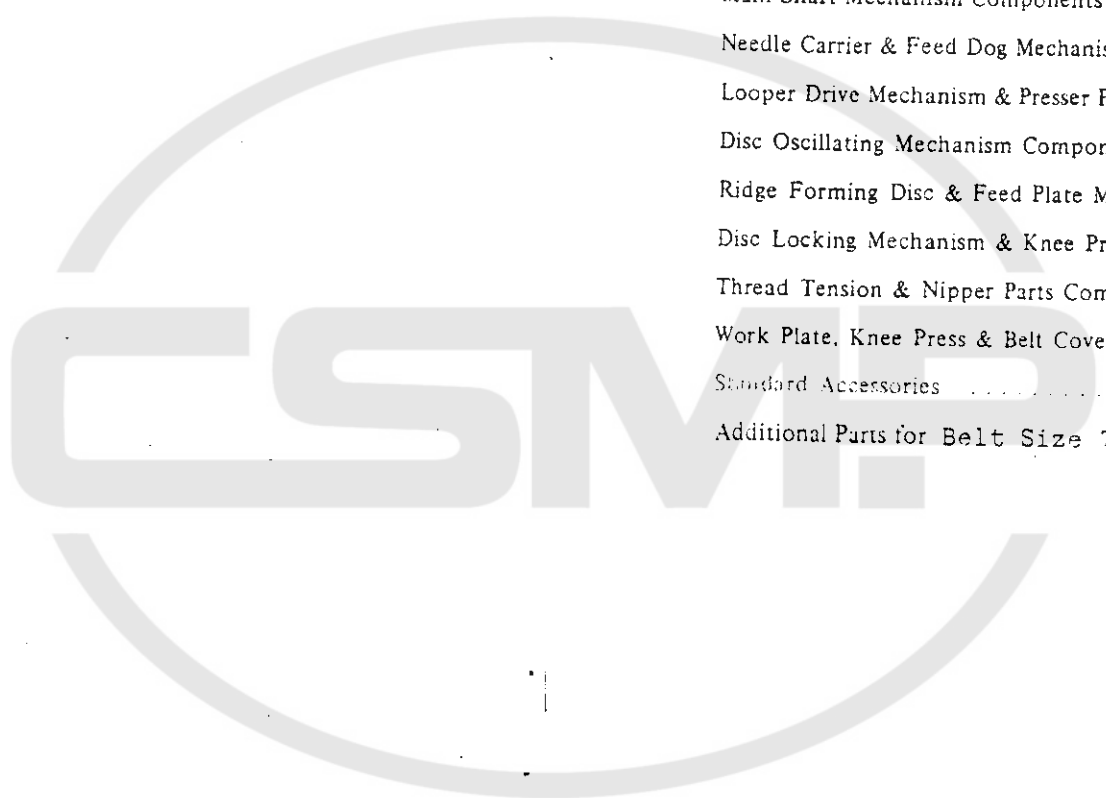
MODEL : BM 260

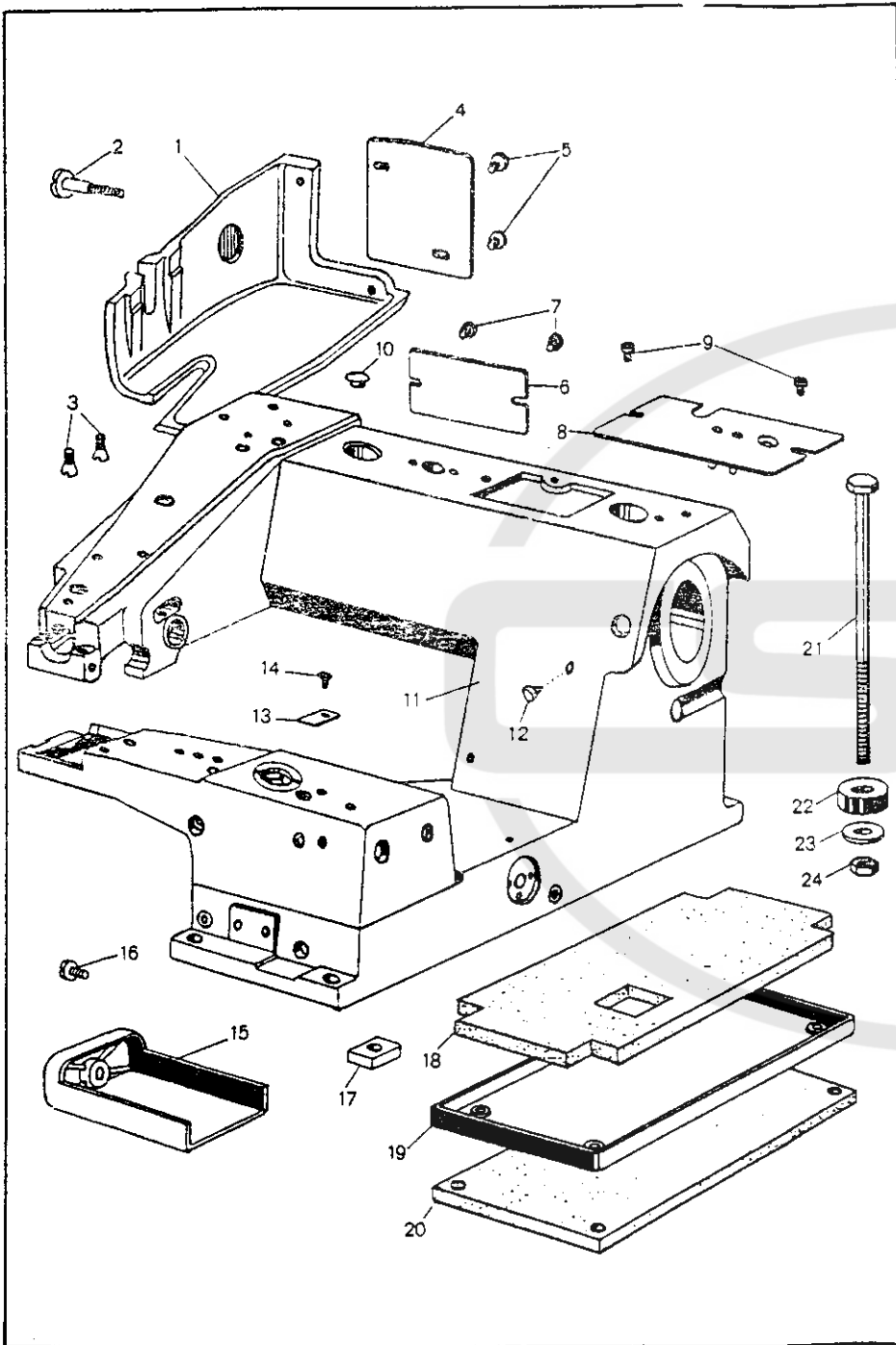
PARTS LIST



CONTENTS

	Page
Machine Frame & Covers Components	1
Main Shaft Mechanism Components	3
Needle Carrier & Feed Dog Mechanism Components	5
Looper Drive Mechanism & Presser Foot Parts Components	7
Disc Oscillating Mechanism Components	9
Ridge Forming Disc & Feed Plate Mechanism Components	11
Disc Locking Mechanism & Knee Press Shaft Parts Components	13
Thread Tension & Nipper Parts Components	15
Work Plate, Knee Press & Belt Cover Parts Components	17
Standard Accessories	19
Additional Parts for Belt Size 7, 8, 9mm	21



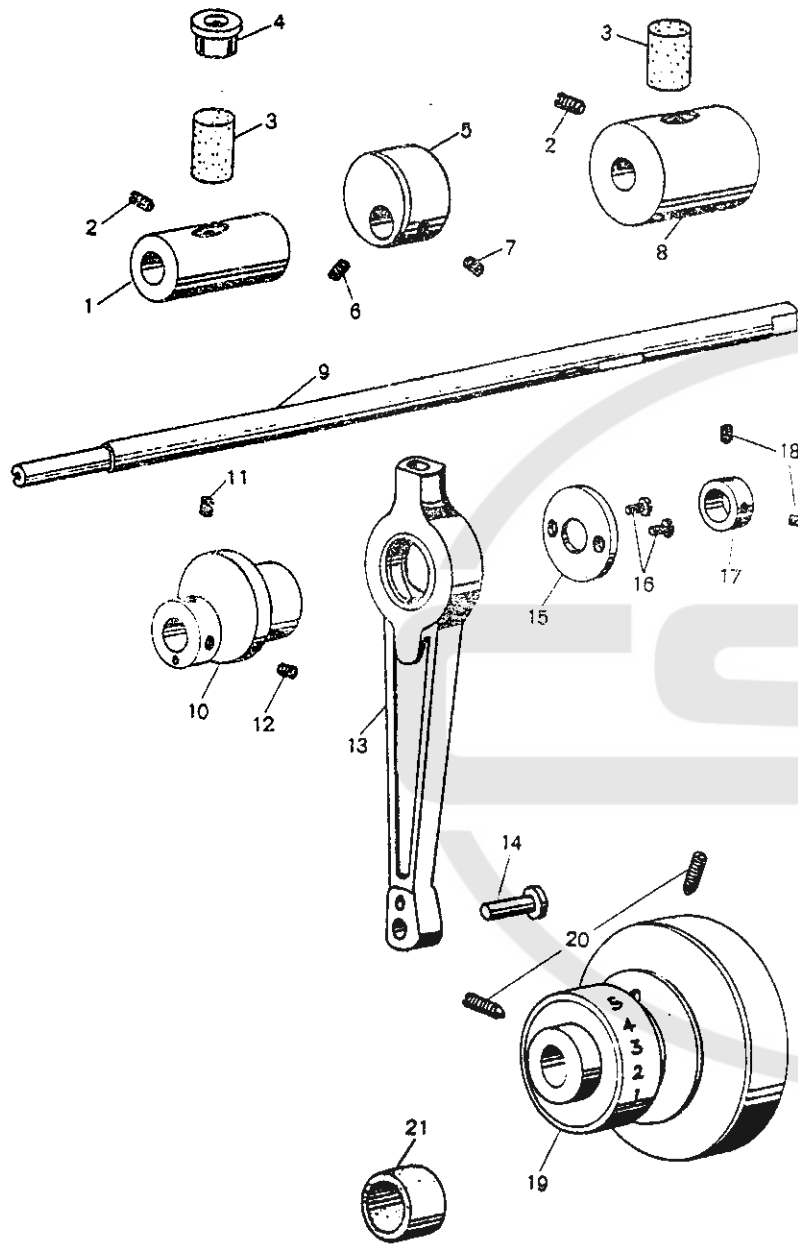


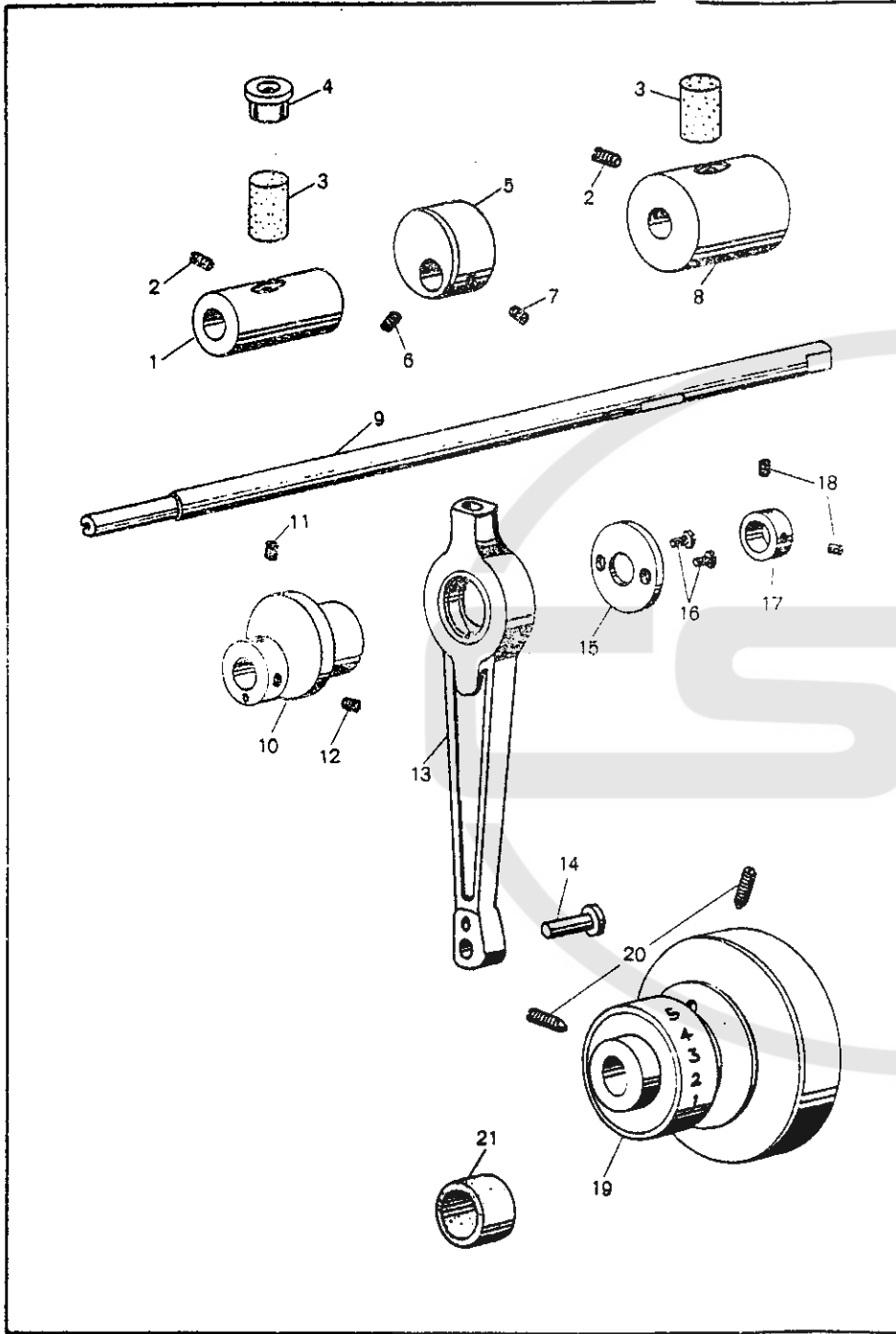
Machine Frame & Covers Components

Ref. No.	Parts No.	Description
1	11089	Arm Side Cover
2	4144	Arm Side Cover Set Screw
3	11128	Arm Side Cover Positioning Screw
4	11090	Arm Side Cover Plate
5	5227	Arm Side Cover Plate Screw
6	11088	Arm Rear Cover Plate
7	5233	Arm Rear Cover Plate Screw
8	11544	Arm Top Cover Plate
9	5233	Arm Top Cover Plate Screw
10	11163	Arm Top Rubber Cap
11	AM800	Machine Frame
12	11164	Rubber Cap
13	11546	Arm Small Cover Plate
14	124	Arm Small Cover Plate Screw
15	11091	End Cover
16	11153	End Cover set Screw
17	11142	Machine Base Rubber
18	11141	Machine Base Oil Felt
19	11545	Machine Base Oil Pan
20	11108	Machine Base Felt Pad
21	11144	Machine Base Clamp Screw
22	11143	Machine Base Rubber Ring
23	11146	Machine Base Washer
24	11145	Machine Base Nut

Main Shaft Mechanism Components

Ref. No.	Parts No.	Description
1	11005	Main Shaft Bushing (Front)
2	131	Main Shaft Bushing Set Screw
3	11124-A	Oiling Felt
4	11118	Oil Cap (Large)
5	11009	Counterweight
6	5225-C	Counterweight Set Screw(w/Flat Point)
7	11110	Counterweight Set Screw(w/Sharp Point)
8	11006	Main Shaft Bushing (Rear)
9	11504	Main Shaft
10	11010	Eccentric Bushing
11	11111	Eccentric Bushing Set Screw(w/Sharp Point)
12	5225-C	Eccentric Bushing Set Screw(w/Flat Point)
13	11601	Connecting Rod
14	11013	Connecting Rod Stud
15	11011	Eccentric Bushing Plate
16	4040	Eccentric Bushing Plate Set Screw
17	11008	Main Shaft Collar
18	5225-C	Main Shaft Collar Set Screw
19	11007-A	Hand Wheel (Pulley)
20	131	Hand Wheel Set Screw
21	4207-A	Hand Wheel Rubber Cap

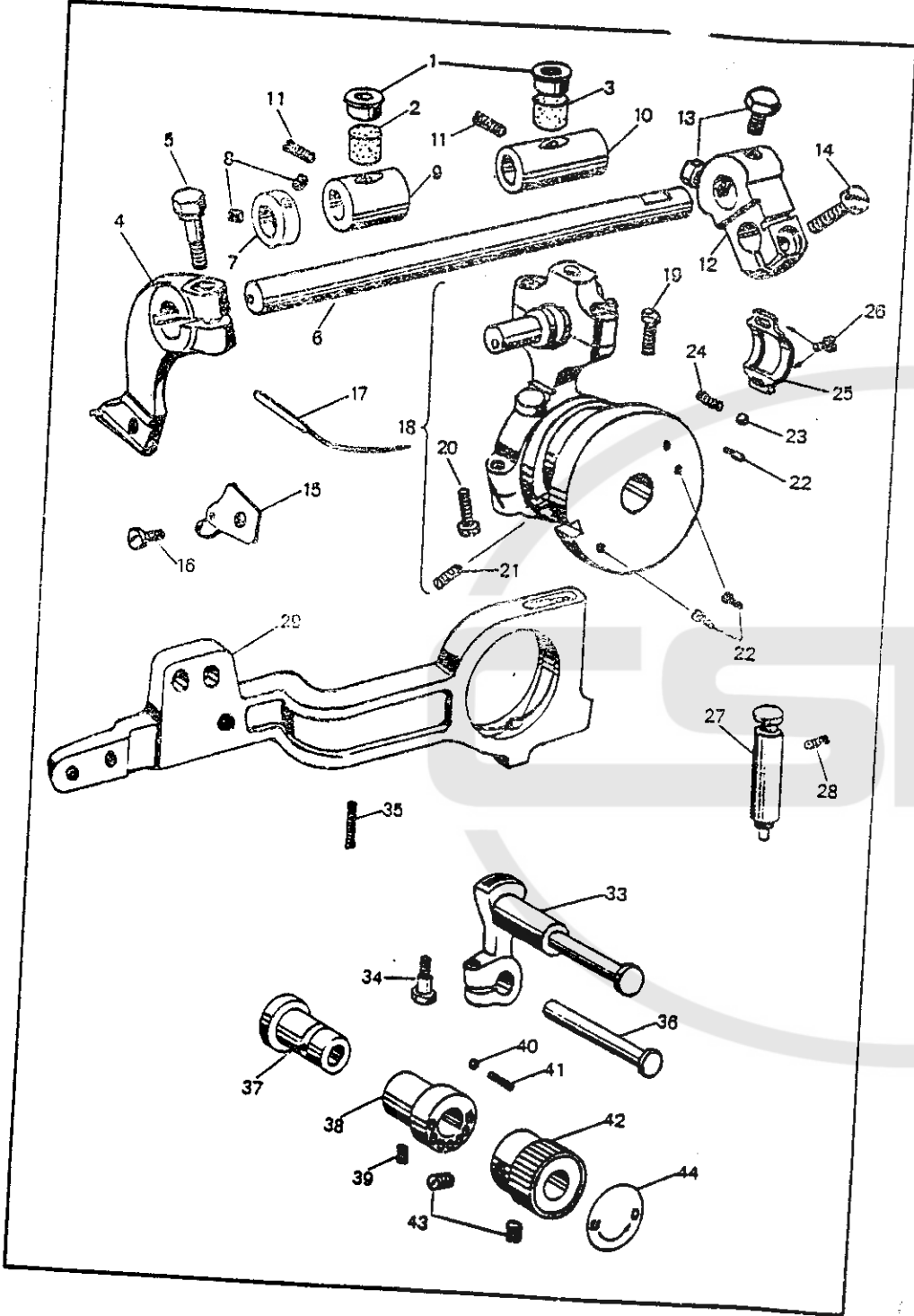




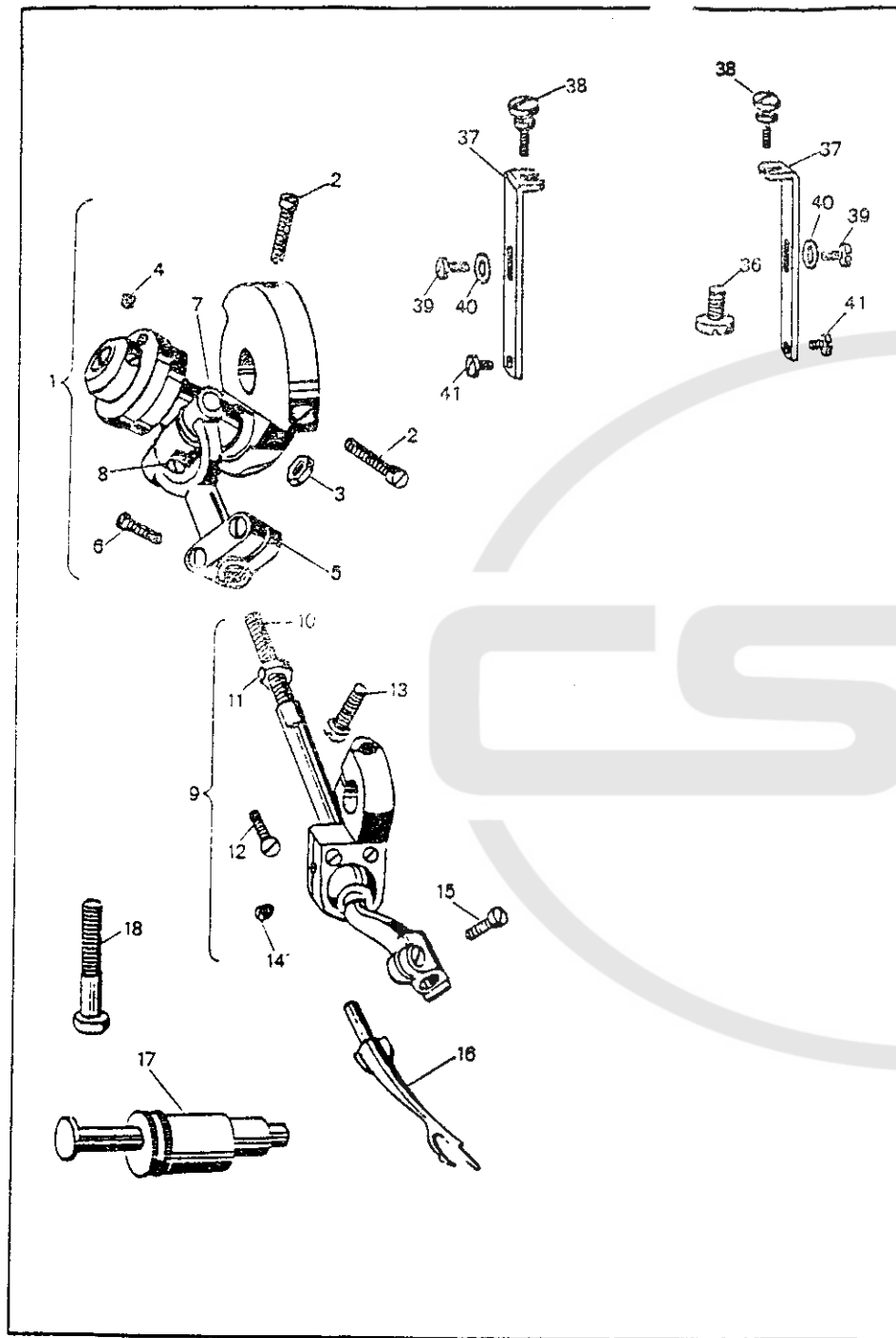
Main Shaft Mechanism Components

Ref. No.	Parts No.	Description
1	11005	Main Shaft Bushing (Front)
2	131	Main Shaft Bushing Set Screw
3	11124-A	Oiling Felt
4	11118	Oil Cap (Large)
5	11009	Counterweight
6	5225-C	Counterweight Set Screw(w/Flat Point)
7	11110	Counterweight Set Screw(w/Sharp Point)
8	11006	Main Shaft Bushing (Rear)
9	11504	Main Shaft
10	11010	Eccentric Bushing
11	11111	Eccentric Bushing Set Screw(w/Sharp Point)
12	5225-C	Eccentric Bushing Set Screw(w/Flat Point)
13	11601	Connecting Rod
14	11013	Connecting Rod Stud
15	11011	Eccentric Bushing Plate
16	4040	Eccentric Bushing Plate Set Screw
17	11008	Main Shaft Collar
18	5225-C	Main Shaft Collar Set Screw
19	11007-A	Hand Wheel (Pulley)
20	131	Hand Wheel Set Screw
21	4207-A	Hand Wheel Rubber Cap

Needle Carrier & Feed Dog Mechanism Components

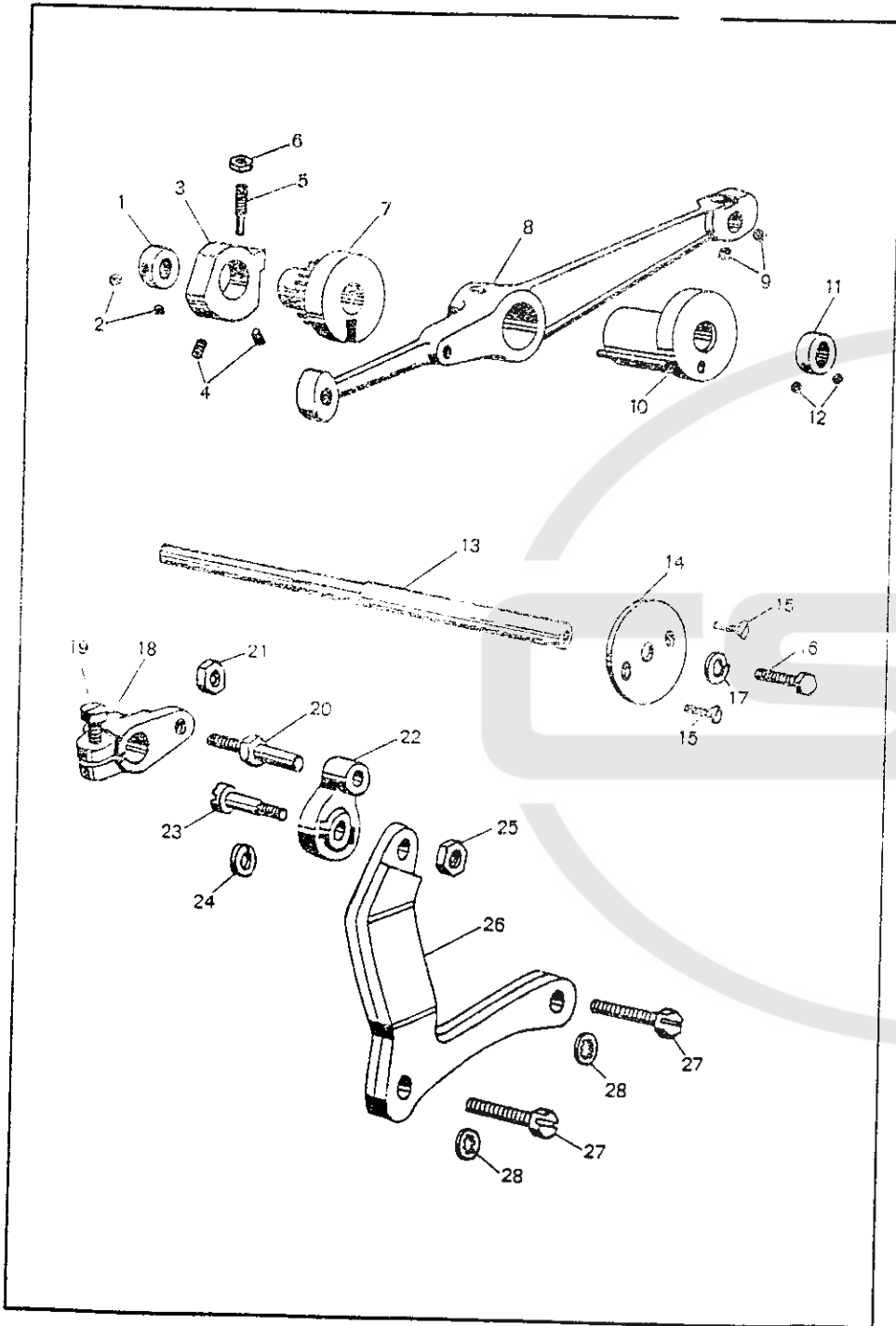


Ref. No.	Parts No.	Description
1	11119	Arm Top Oil Cap (Small)
2	11124-C	Oiling Felt
3	11124-B	Oiling Felt
4	4023-A	Needle Carrier
5	4024	Needle Carrier Set Screw
6	4019	Needle Carrier Shaft
7	4022	Needle Carrier Shaft Collar
8	129-B	Needle Carrier Shaft Collar Set Screw
9	11032	Needle Carrier Shaft Bushing (Front)
10	11033	Needle Carrier Shaft Bushing (Rear)
11	129-A	Needle Carrier Shaft Bushing Set Screw
12	4017-A	Needle Carrier Shaft Crank
13	4018-A	Needle Carrier Shaft Crank Set Screw
14	114-A	Needle Carrier Shaft Crank Clamp Screw
15	11139	Needle Clamp
16	121	Needle Clamp Set Screw
17	4181	Needle (System LW x6T)
18	1151	Needle Driving Eccentric w/Rod, Regulator & Screws (Ref. Nos. 19-27)
19	4211-B	Ball Connecting Rod Set Screw (Short)
20	4173	Ball Connecting Rod Set Screw (Long)
21	4009-A	Needle Driving Eccentric Set Screw
22	4012	Stitch Regulator Screw
23	4010	Stitch Regulator Ball
24	4011-A	Stitch Regulator Spring
25	4014	Ball Connecting Rod Cap
26	4015	Ball Connecting Rod Cap Set Screw
27	1108	Stitch Length Regulating Plunger
28	129-A	Stitch Length Regulating Plunger Set Screw
29	11902-T	Feed Lever
33	1152	Feed Link & Stud
34	11027-A	Feed Link Clamp Screw
35	4042	Feed Link Stud Set Screw
36	11905	Feed Dog Height Adjusting Stud
37	11904-B	Feed Dog Height Adjusting Stud Eccentric Sleeve
38	11903	Feed Dog Height Adjusting Stud Bushing
39	129-B	Feed Dog Height Adjusting Stud Bushing Set Screw
40	4010	Feed Dog Height Adjusting Ball
41	10052	Feed Dog Height Adjusting Spring
42	11906	Feed Dog Height Adjusting Knob
43	132	Feed Dog Height Adjusting Knob Set Screw
44	11907	Feed Dog Height Adjusting Indicator



Looper Drive Mechanism & Presser Foot Parts Components

Ref. No.	Parts No.	Description
1	538--A	Looper Drive Crank Complete w/Looper Yoke & Screws (Ref. Nos. 2-8)
2	4191	Looper Drive Crank Set Screw
3	5039--A	Looper Drive Crank Stud Nut
4	129--B	Looper Drive Crank Stud Collar Set Screw
5	4030--A	Looper Yoke
6	4031	Looper Yoke Set Screw
7	4032--A	Looper Yoke Pin
8	5263--A	Looper Yoke Pin Set Screw
9	539--A	Looper Carrier w/Ball Joint & Screws (Ref. Nos. 10-15)
10	4035--A	Looper Carrier
11	4176	Looper Carrier Nut
12	4216	Looper Carrier Ball Joint Set Screw
13	4213	Looper Carrier Ball Joint Clamp Screw
14	4179--D	Looper Carrier Ball Spot Screw
15	4040	Looper Clamp Screw
16	11837	Looper
17	505	Eccentric Sleeve & Pin
18	4038	Eccentric Sleeve Clamp Screw
36	4050	Presser Foot Set Screw
37	4061--A	Presser Foot Bracket
38	4057	Presser Foot Bracket Adjusting Screw
39	121--B	Presser Foot Bracket Holding Screw
40	11158	Presser Foot Bracket Washer
41	4186	Presser Foot Holding Screw

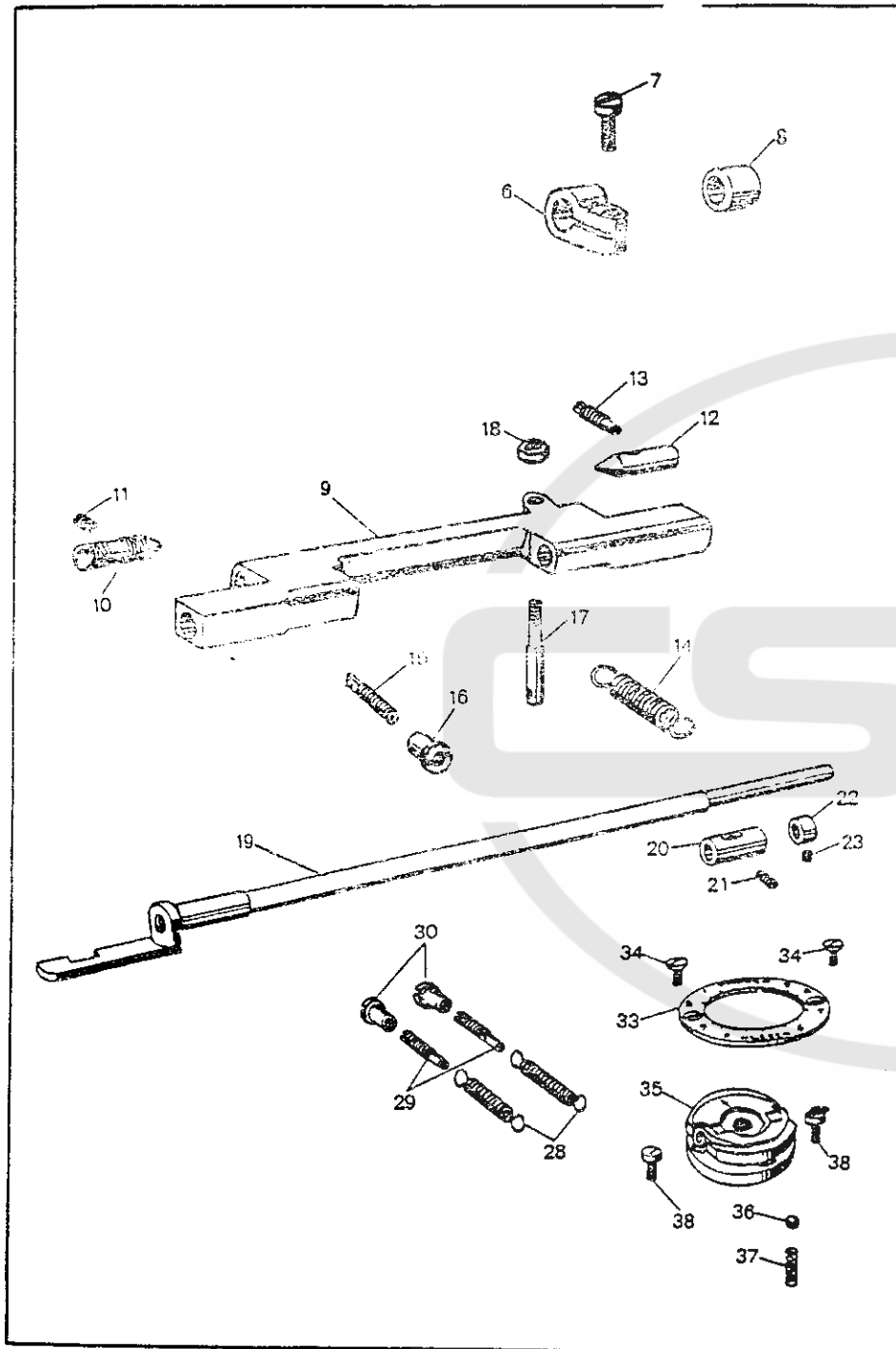


Disc Oscillating Mechanism Components

Ref. No.	Parts No.	Description
1	11513	Disc Oscillating Shaft Collar (Small)
2	132	Disc Oscillating Shaft Collar Set Screw
3	11511	Disc Locking Latch Block
4	98	Disc Locking Latch Block Set Screw
5	11528	Disc Locking Latch Block Stop Screw
6	4068	Disc Locking Latch Block Nut
7	1153	Disc Oscillating Gear (Small)
8	11506	Disc Oscillating Rod
9	98	Disc Oscillating Rod Stud Set Screw
10	11507	Disc Oscillating Eccentric Sleeve
11	11512	Disc Oscillating Shaft Collar (Large)
12	132	Disc Oscillating Shaft Collar Set Screw
13	11602	Disc Oscillating Shaft
14	11603	Disc Oscillating Shaft Plate
15	5235	Disc Oscillating Shaft Plate Set Screw
16	5220	Disc Oscillating Shaft Clamp Screw
17	13170	Disc Oscillating Shaft Spring Washer
18	11522	Disc Oscillating Crank
19	113-A	Disc Oscillating Crank Set Screw
20	11521	Disc Oscillating Crank Connecting Pin
21	4070-A	Disc Oscillating Crank Connecting Pin Nut
22	11519	Disc Oscillating Ball Joint
23	11520	Disc Oscillating Ball Joint Stud
24	8179	Disc Oscillating Ball Joint Stud Washer
25	4070-A	Disc Oscillating Ball Joint Stud Nut
26	11518-C	Disc Oscillating Lever
27	10112	Disc Oscillating Lever Clamp Screw
28	5222-B	Disc Oscillating Lever Washer

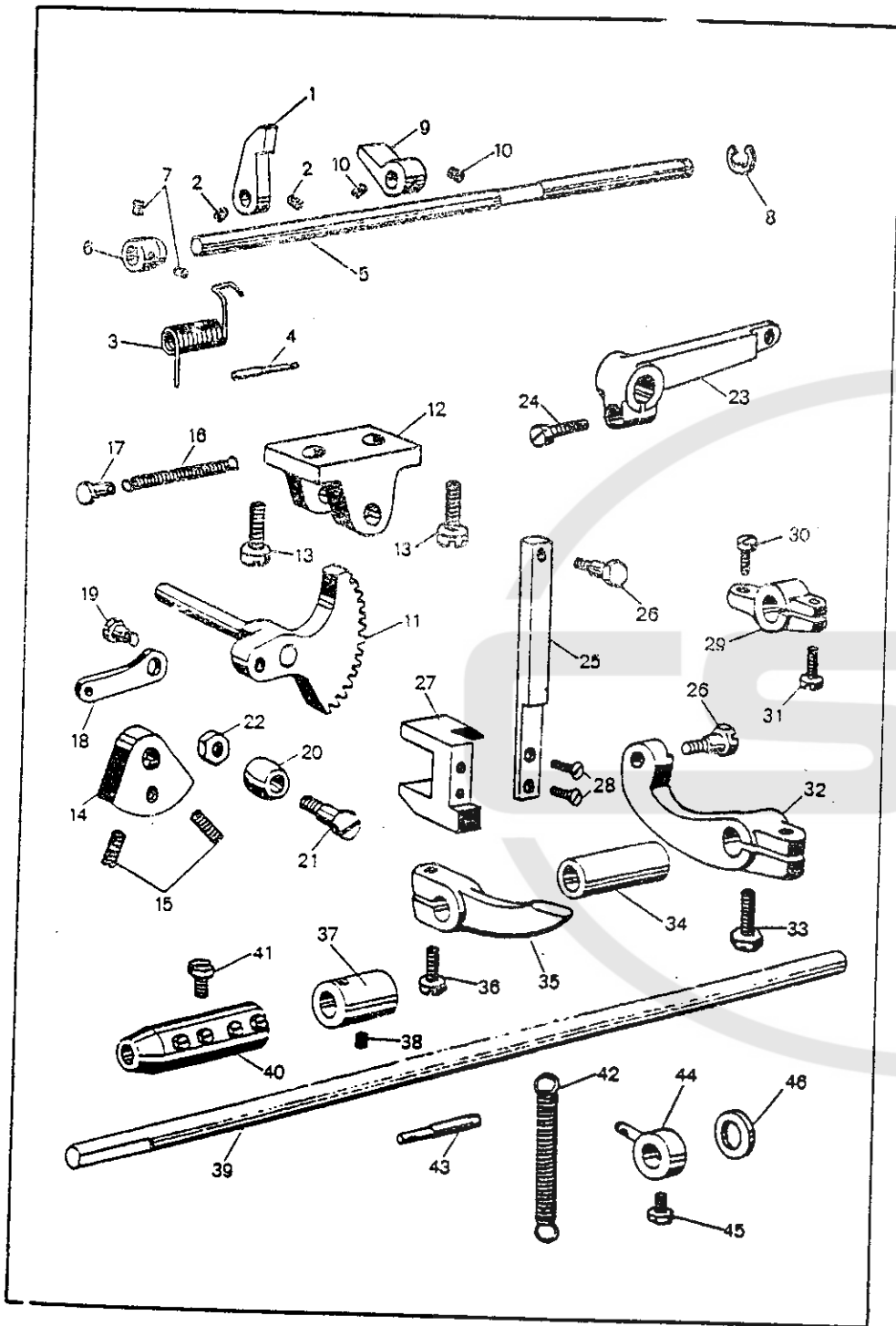
Ridge Forming Disc & Feed Plate Mechanism Components

Ref. No.	Parts No.	Description
6	10023	Ridge Forming Disc Shaft Collar
7	113-A	Ridge Forming Disc Shaft Collar Set Screw
8	11047	Ridge Forming Disc Shaft Sleeve
9	4102	Disc Adjusting Holder
10	11068	Disc Adjusting Holder Pivot Bearing Screw
11	98	Disc Adjusting Holder Pivot Bearing Set Screw
12	11049	Disc Adjusting Holder Pivot Bearing Pin
13	11050	Disc Adjusting Holder Pivot Bearing Pin Set Screw
14	4104	Disc Adjusting Holder Spring
15	4105	Disc Adjusting Holder Spring Screw
16	4106	Disc Adjusting Holder Spring Nut
17	11051	Disc Adjusting Holder Spring Stud
18	5208	Disc Adjusting Holder Spring Stud Nut
19	11075-A	Feed Plate Shaft
20	11026	Feed Plate Shaft Bushing
21	98	Feed Plate Shaft Bushing Set Screw
22	4090	Feed Plate Shaft Collar
23	129-B	Feed Plate Shaft Collar Set Screw
28	4093-BA	Feed Plate Spring
29	4094	Feed Plate Spring Screw
30	4095	Feed Plate Spring Adjusting Nut
33	11062	Disc Adjusting Dial
34	4129	Disc Adjusting Dial Set Screw
35	519-A	Disc Adjusting Regulator Complete
36	4010	Disc Adjusting Regulator Ball
37	4011	Disc Adjusting Regulator Spring
38	115	Disc Adjusting Regulator Base Set Screw



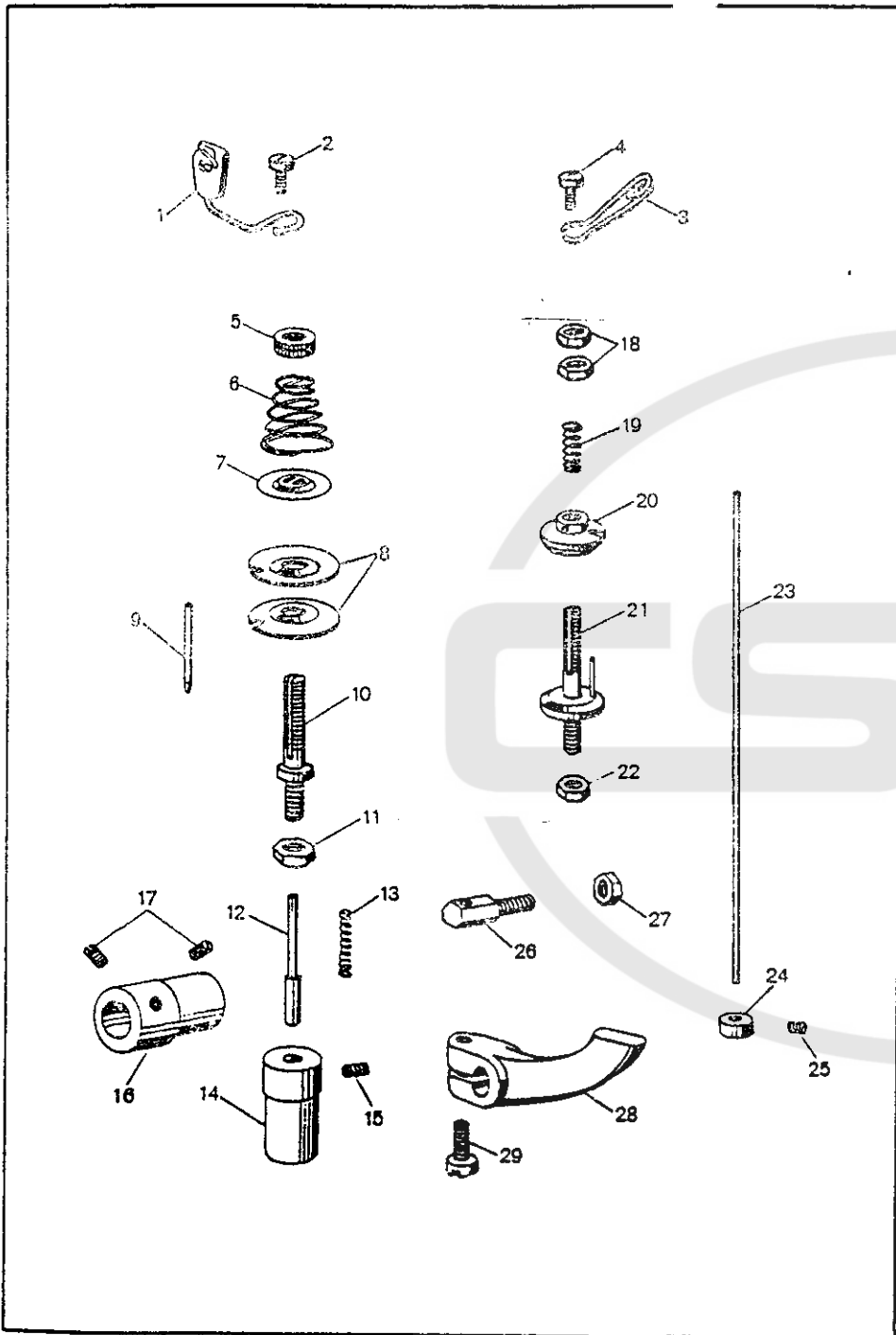
Disc Locking Mechanism & Knee Press Shaft Parts Components

Ref. No.	Parts No.	Description
1	11526	Disc Locking Latch
2	129-B	Disc Locking Latch Set Screw
3	11527	Disc Locking Latch Spring
4	11081	Disc Locking Latch Spring Pin
5	11523	Disc Locking Latch Shaft
6	11524	Disc Locking Latch Shaft Collar
7	129-B	Disc Locking Latch Shaft Collar Set Screw
8	11548	Disc Locking Latch Shaft Ring
9	11525	Disc Locking Latch Releasing Lever
10	129-B	Disc Locking Latch Releasing Lever Set Screw
11	1154	Disc Oscillating Gear (Large)
12	11535	Disc Oscillating Gear Bracket
13	8158	Disc Oscillating Gear Bracket Set Screw
14	11536	Disc Oscillating Gear Shaft Collar
15	11113	Disc Oscillating Gear Shaft Collar Set Screw
16	11537	Disc Oscillating Gear Shaft Collar Spring
17	11538	Disc Oscillating Gear Shaft Collar Spring Pin
18	11058	Disc Oscillating Gear Shaft Collar Link
19	11059	Disc Oscillating Gear Shaft Collar Link Bearing Screw
20	11055	Disc Oscillating Roller
21	11056-A	Disc Oscillating Roller Shoulder Bearing Screw
22	4070	Disc Oscillating Roller Nut
23	11074	Feed Plate Depressing Crank
24	11117	Feed Plate Depressing Crank Set Screw
25	11532-B	Feed Plate Depressing Crank Connecting Plate
26	11073	Feed Plate Depressing Crank Connecting Plate Shoulder Screw
27	11531	Roller Engaging Block
28	7095-A	Roller Engaging Block Set Screw
29	11529	Disc Locking Latch Releasing Crank
30	113-A	Disc Locking Latch Releasing Crank Stop Screw
31	114-B	Disc Locking Latch Releasing Crank Set Screw
32	11530	Knee Press Shaft Crank
33	4084	Knee Press Shaft Crank Set Screw
34	11065-A	Knee Press Shaft Sleeve
35	11068	Knee Press Shaft Stop Lever
36	11117	Knee Press Shaft Stop Lever Set Screw
37	11064	Knee Press Shaft Bushing
38	129-A	Knee Press Shaft Bushing Set Screw
39	11063	Knee Press Shaft
40	4146-A	Knee Press Rod Sleeve
41	4147-A	Knee Press Rod Sleeve Set Screw
42	11060	Knee Press Shaft Spring
43	11061	Knee Press Shaft Spring Pin
44	11067	Knee Press Shaft Spring Collar
45	4184	Knee Press Shaft Spring Collar Set Screw
46	11539	Knee Press Shaft Washer



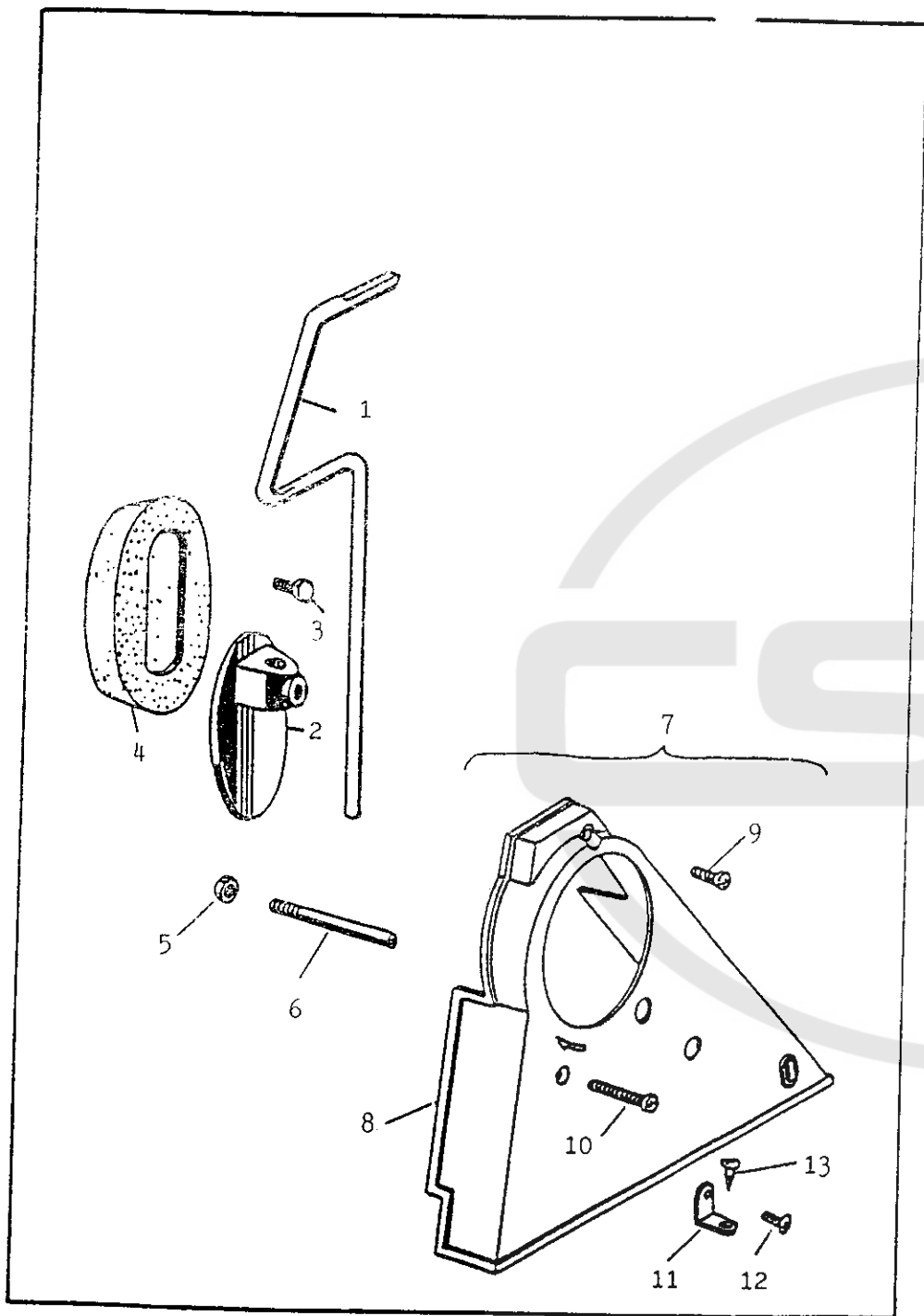
Thread Tension & Nipper Parts Components

Ref. No.	Parts No.	Description
1	11136	Thread Guide with Ceramic
2	113-B	Thread Guide Set Screw
3	4202-A	Thread Guide
4	113-B	Thread Guide Set Screw
5	81	Thread Tension Nut
6	79-B	Thread Tension Spring
7	77	Thread Tension Washer
8	5190-A	Thread Tension Disc
9	11556	Thread Tension Disc Pin
10	4209	Thread Tension Staff
11	4068	Thread Tension Staff Nut
12	11543-A	Thread Tension Releasing Pin
13	11547	Thread Tension Releasing Pin Spring
14	11542	Thread Tension Releasing Pin Bushing
15	98	Thread Tension Releasing Pin Bushing Set Screw
16	11541	Thread Tension Releasing Eccentric
17	132	Thread Tension Releasing Eccentric Set Screw
18	4068	Thread Nipper Nut
19	4198	Thread Nipper Spring
20	11552	Thread Nipper Disc
21	11551	Thread Nipper Staff
22	4068	Thread Nipper Staff Nut
23	11162	Thread Nipper Releasing Pin
24	6053	Thread Nipper Releasing Pin Collar
25	130-B	Thread Nipper Releasing Pin Collar Set Screw
26	11540	Thread Nipper Releasing Pin Prop
27	4068	Thread Nipper Releasing Pin Prop Nut
28	11068	Thread Nipper Releasing Pin Lever
29	11117	Thread Nipper Releasing Pin Lever Set Screw



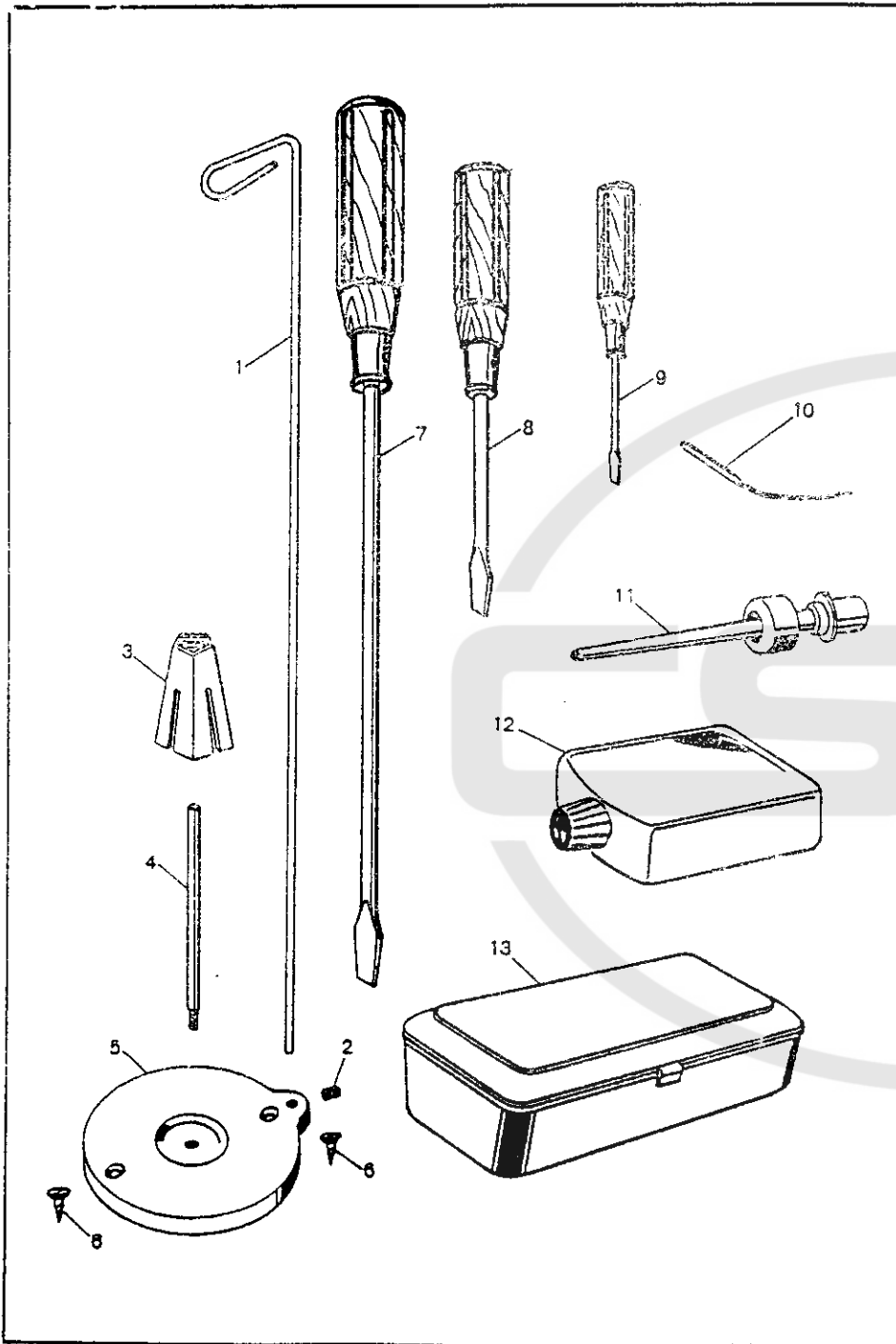
Knee Press & Belt Cover Parts Components

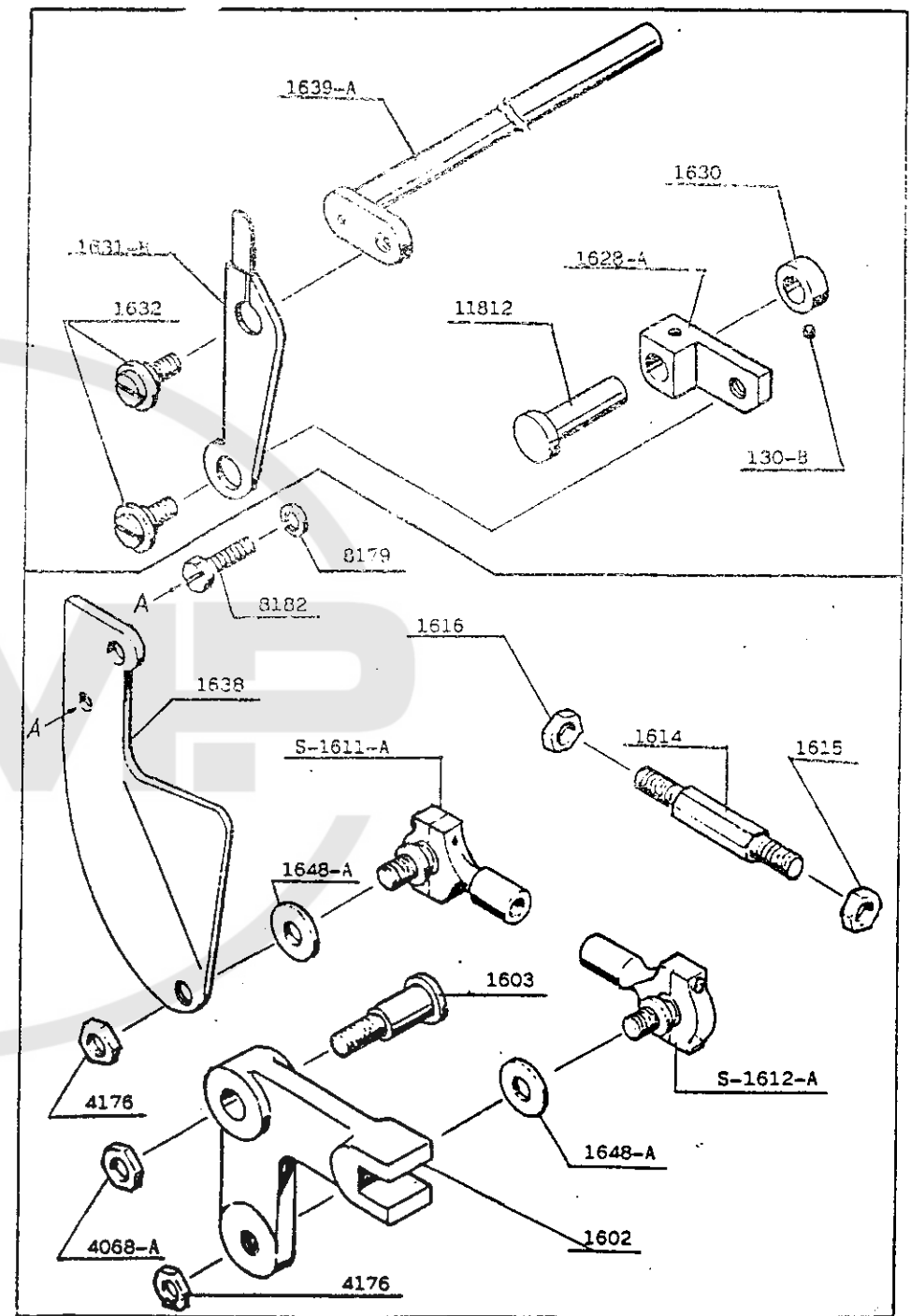
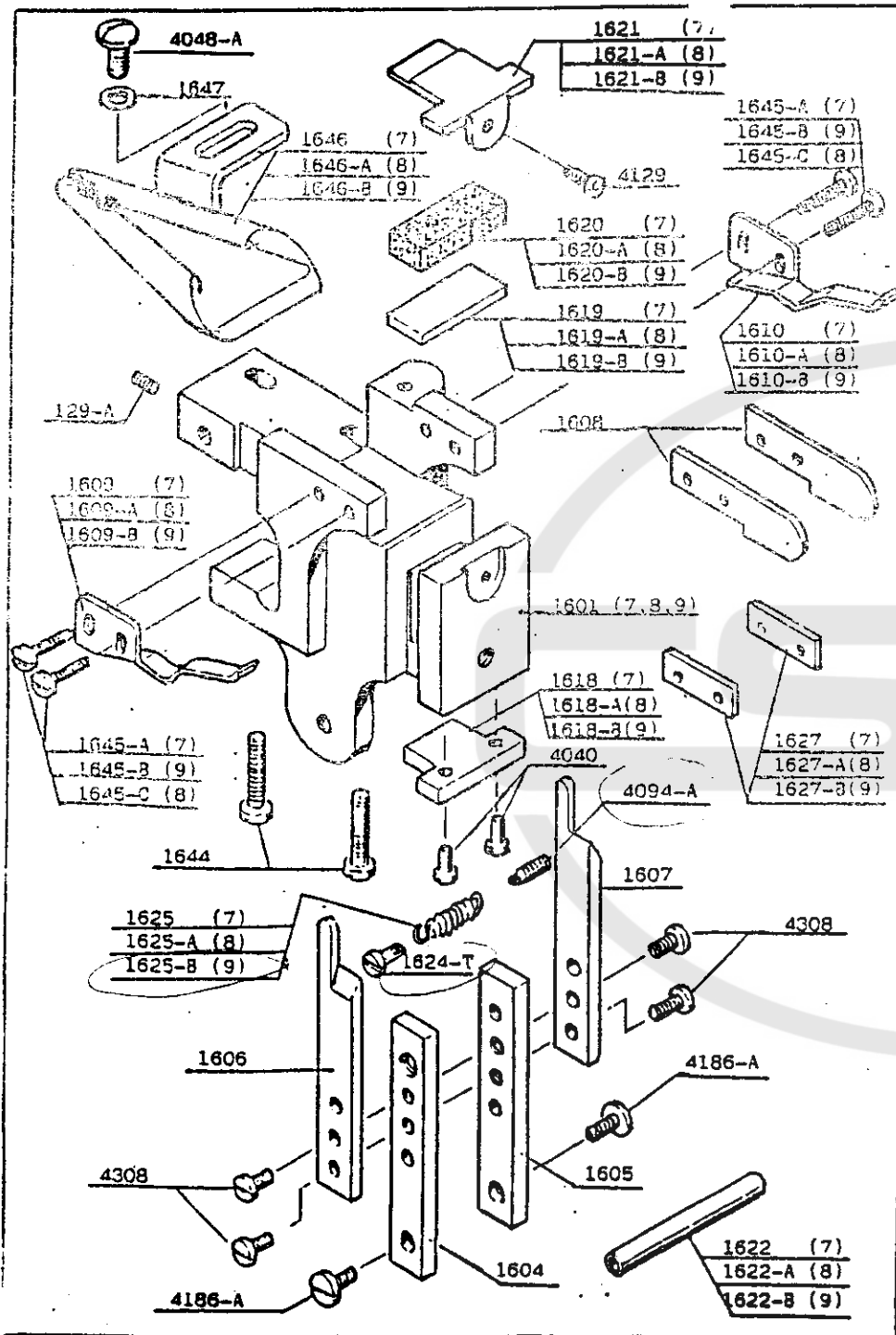
Ref. No	Parts No	Description
1	4148-A	Knee Press Rod
2	4149	Knee Press Plate
3	4147-A	Knee Press Plate Set Screw
4	4212	Knee Press Pad
5	6107	Screw
6	10071	Screw Nut
7	S-11553-B	Belt Cover Set
8	11553-B	Belt Cover
9	0174014	Belt Cover Screw (Short)
10	0174045	Belt Cover Screw (Long)
11	11558	Belt Cover Bracket
12	0173008	Belt Cover Bracket Sew Screw (Small)
13	20129	Belt Cover Bracket Wood Screw



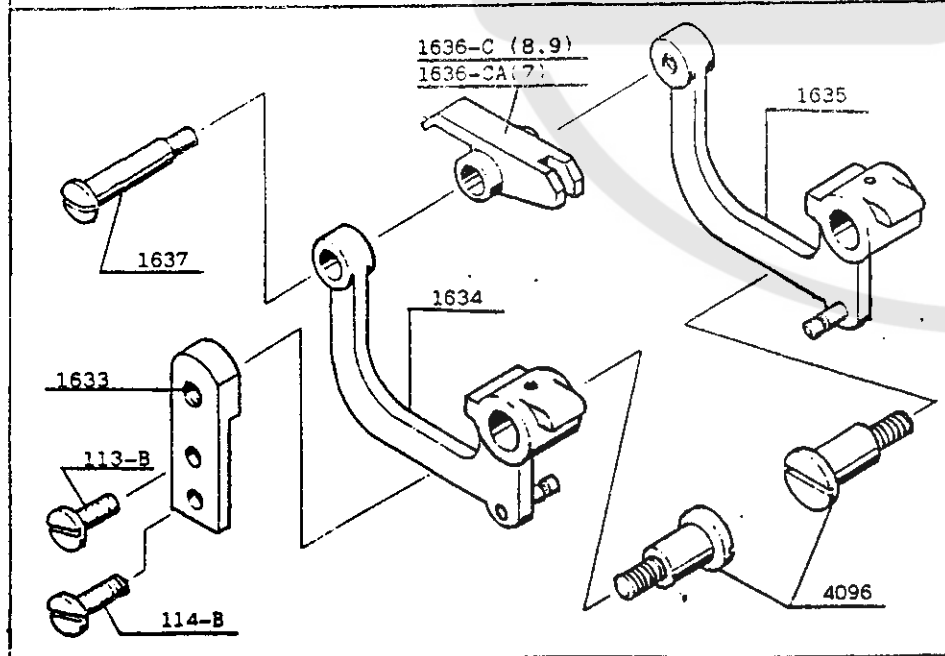
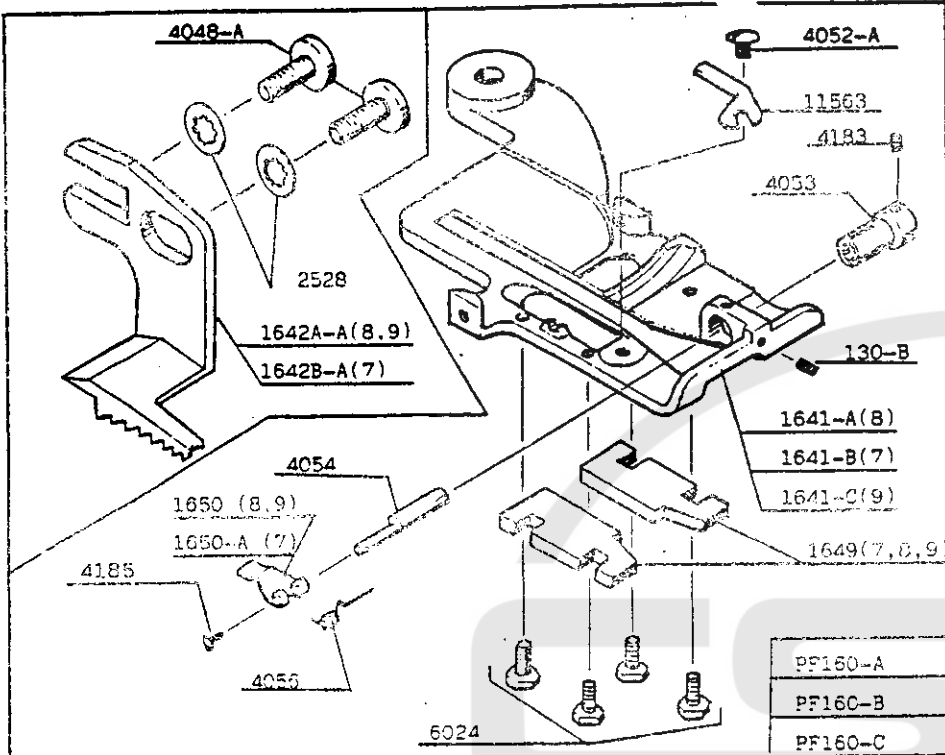
Standard Accessories

Ref. No.	Parts No.	Description
1	4152	Thread Guide
2	129-A	Thread Guide Set Screw
3	AC-101	Plastic Cap
4	4151	Spool Pin
5	4150	Cotton Stand Base
6	AC-10	Cotton Stand Base Wood Screw
7	AC-01	Screw Driver (Large)
8	AC-02	Screw Driver (Medium)
9	AC-03	Screw Driver (Small)
10	4181	Needle (System LW x 6T)
11	AC-04A	Oiler
12	AC-05	Oil
13	AC-08	Accessory Box





BELT SIZE | 7, 8, 9mm



BELT SIZE | 7, 8, 9mm

