

GLOBAL

INDUSTRIAL SEWING MACHINES

MODEL BM-9260-1
BLINDSTITCH MACHINES

PARTS BOOK
INSTRUCTION MANUAL

INDEX

1. Setting up Machine for Work	2
A. Location	2
B. Installing Thread Stand	2
C. Connecting Motor Controller	3
D. Assembly of knee Lifter	4
2. Lubrication	4
3. Needles and Thread	5
4. Replacing the Needle	6
5. Threading Machine	6
6. Inserting the Work Piece and Starting to Sew	8
7. Adjustment of Thread Tension	9
8. Regulating Stitch Length	10
9. Adjustment of Needle Penetration	10
10. Removal of the Work from the Machine	11
11. Skip Stitch Device	12

I N D E X

<INSTRUCTION MANUEL>

一、Unpacking machine	1
二、Setting-up Machine	1
三、Install lining rack	1
四、Handwheel Rotation and Speed	2
五、Replacing Needle	2
六、Oilling and Maintenance	3
七、Threading Machine	3
八、Sewing material feeding and sewing	4
九、Continuous sewing	5
十、Adjustment of Needle Penetration	6
十一、Stitch Length Regulation	6
十二、Needle Recommendation	7
十三、Taking out the sewed material	7
十四、Machine regulation	7

<PARTS LIST>

CONTENTS

Machine Frame&Covers Components	2
Main Shaft Mechanism Components	4
Needle Carrier&Feed Dog Mechanism Components	6
Looper Dive Mechanism&Presser Foot Parts Components	8
Ridge Forming Disc&Feed Plate Mechanism Components	10
Disc Oscillating Mechanism&Knee Press Shaft Parts Components	12
Cutting Material Componets	14
Knee Press & Standard Accessories	17

<INSTRUCTION MANUEL>

I N D E X

一、Unpacking Machine.....	1
二、Setting-up Machine.....	1
三、Install lining rack.....	1
四、Handwheel Rotation and Speed.....	2
五、Replacing Needle.....	2
六、Oilling and Maintenance.....	3
七、Threading Machine.....	3
八、Sewing material feeding and sewing.....	4
九、Continuous sewing.....	5
十、Adjustment of Needle Penetration.....	6
十一、Stitch Length Regulation.....	6
十二、Needle Recommendation.....	7
十三、Taking out the sewed material.....	7
十四、Machine regulation.....	7

一、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.

二、Setting-up Machine

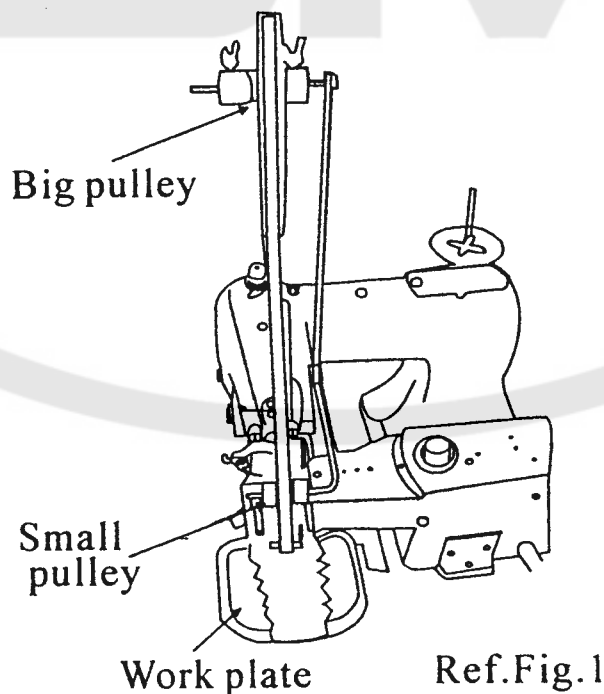
Assemble knee lifter lever to machine and place on sewing table so that lever is 13m/m distant from front edge of the table. Line up belt groove in belt pulley of handwheel with belt groove of drive mechanism (motor or clutch).

Mark three screw holes for fastening machine to sewing table and place felt pad under machine bed before machine is tightened down.

三、Install lining rack

Take out the lining rack. Fix it on the front part of the machine. Then install big and small pulleys device.

Notice: The distance between small pulley and workplate should be about 60mm. (Fig. 1).



四、 Handwheel Rotation and Speed

Turn handwheel only in 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 1,300-1,500 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 upto 1,800 stitches per minute. (The electrical machinery with the rotational speed for 1400 Round/minute should be adopted)

五、 Replacing Needle(Fig.2)

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 to wards 1).

Remove old or defective needle by loosening needle clamp screw. insert new needle into seat in needle clamp as far as it will to. Tighten needle clamp screw.

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.

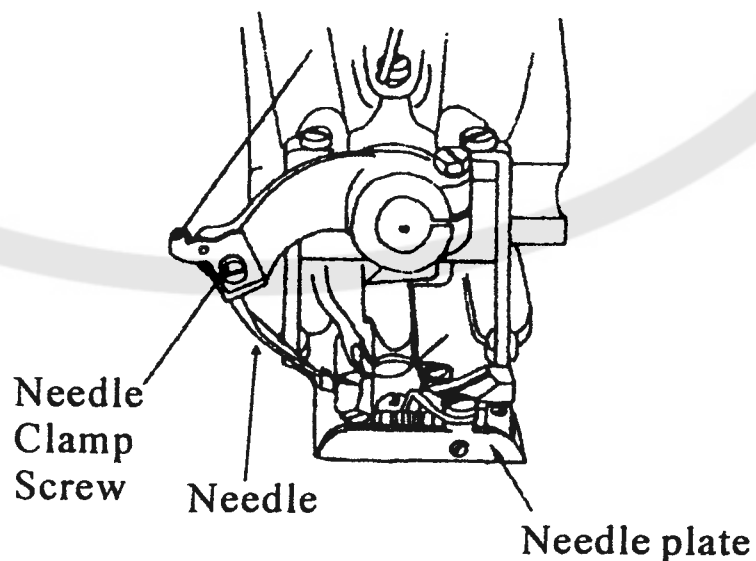


Fig.2

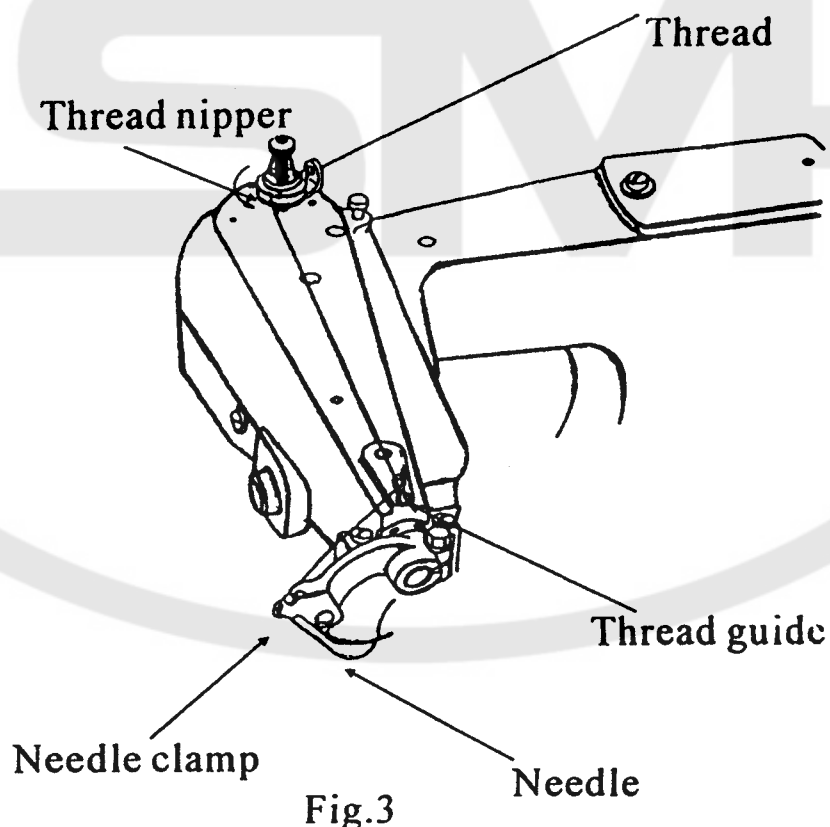
六、Oilling and Maintenance

It is important to operate the machine before oil of good quality has been filled in each and every oil hole along the top of the machine. When breaking-in a new machine oiling should be done sparingly several times a day. Thereafter, one oiling daily will be sufficient. After oiling, wipe machine carefully to avoid soiling of the material.

Do not operate without material under the presser foot unless the knee lever is depressed. This will prevent damage to the needle and the feed dog as well as the feed plattens.

七、Threading Machine

Turn handwheel to machine in clockwise direction away from operator until needle carrier reaches its furthest lefthand position. Draw thread from spool on thread wiper, thread guide and needle clamp and then through the eye of needle from below upward. Pull about 5 cm of thread through the eye of needle. (Fig.3)



八、Sewing material feeding and sewing

1. Scissor the material, which makes the front material form triangle cloth with the length of 100mm(Fig.4)

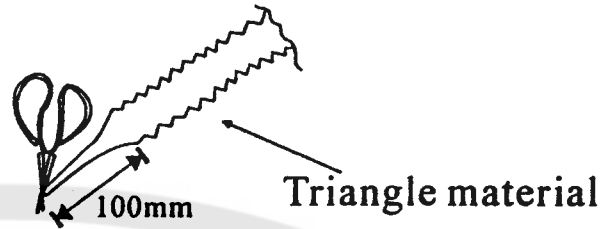


Fig.4

2. Press the rod. Leave the space between presser foot and feeding material retainer. Rotate the belt wheel, which makes front and rear feeding teeth rise. Feed the material into the front part of the feeding teeth with feeding cutter. Then the material is carried to the rear part of the feeding teeth:(Fig.5)

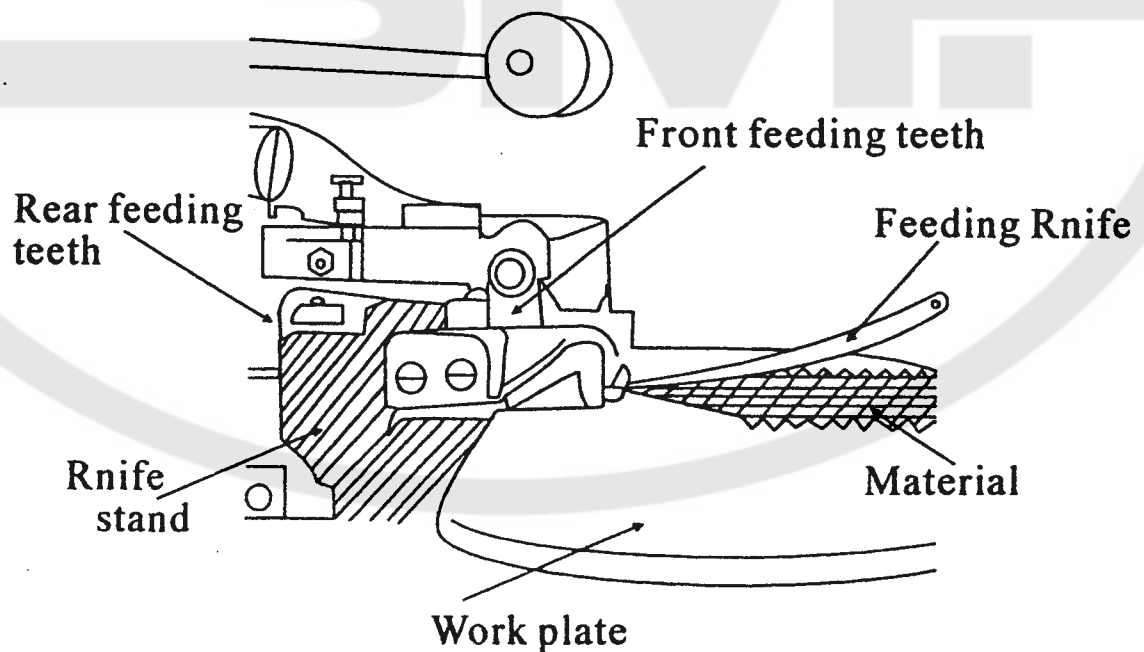


Fig.5

3. Lining cloth is installed on the big bulley. (Fig.1) Clamp the front part of the lining cloth with the clamp. Then above the main material. (Fig.6)

Notice: The lining cloth needn't be used when mid-thick material trousers ears are made.

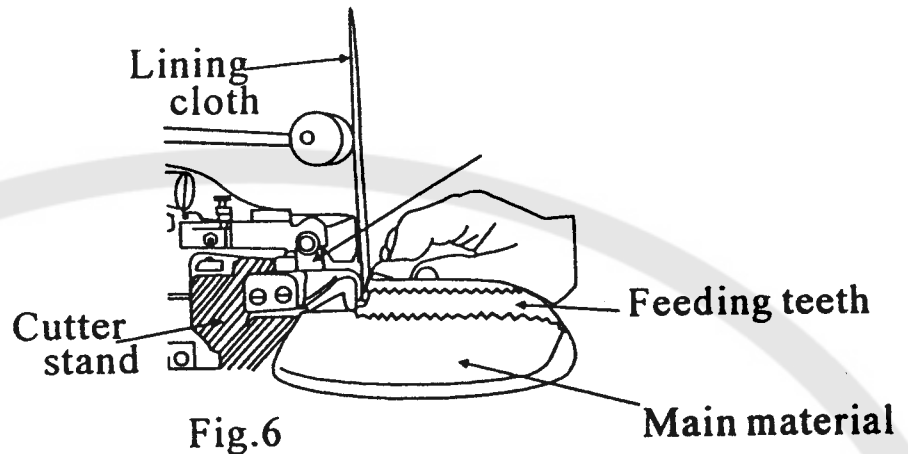


Fig.6

4. Check whether the position of the material and lining cloth are right. Start the machine slowly. Hold the material stably. Then begin to sew.

九、Continuous sewing

After sewing the material with the left length 20-30mm, you should stop operating the machine. Then put the awaiting material under the sewing material. Level the material. Start the machine slowly and sew it continuously. (Fig.7)

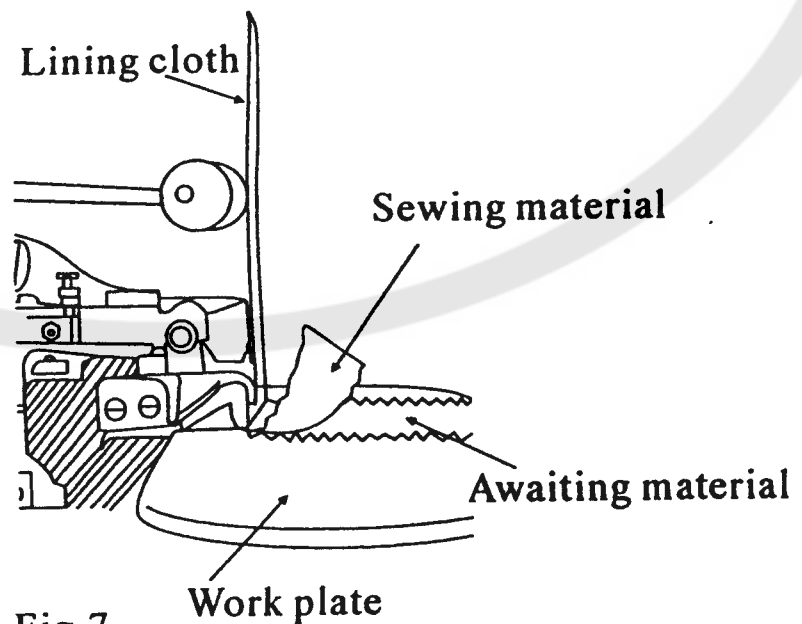


Fig.7

十、 Adjustment of Needle Penetration

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

Turn regulator clockwise for less penetration and counter-clockwise for more penetration(Fig.8)

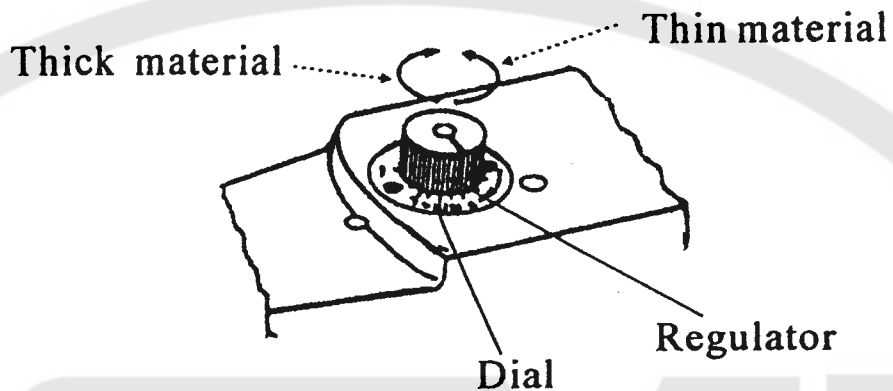


Fig.8

十一、 Stitch Length Regulation

Stitch length adjustment can be easily effected by adjusting needle driving eccentric in arm.

Go about it as follows:(When the machine has no power)

Turn handwheel by hand pushing plunger until same is felt to drop into a recess within the mechanism inside the arm of the machine.

With the plunger remaining depressed into this recess continue turning the handwheel either forward or in reverse until the desired number of stitches per inch is visible on indicator.(Fig.9)

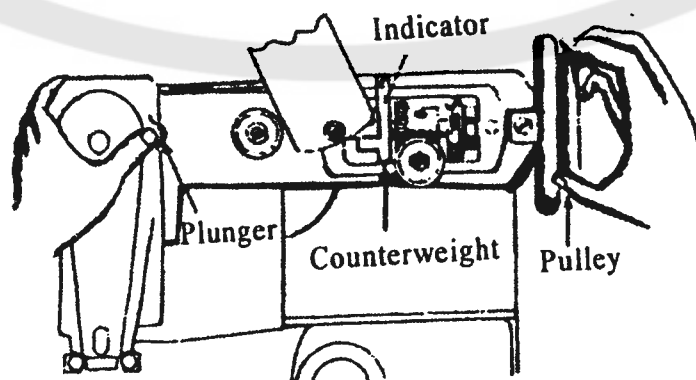


Fig.9

十二、Needle Recommendation

The recommended needle is system LW X 6T.

Size	Material
3(11)	Cottons,Silks,Acetates,Orion,Dacron and similar type of light weight fabrics.
3 $\frac{1}{2}$ (14)	Medium weight materials, Wollens and Others.
4(16)	Thick materials for coats,house furnishings.

十三、Taking out the sewed material

After sewing finished,stop the operation.Rotate the upper wheel clockwise,which makes the needle away from the material. Then press knee rod right,which makes the presser foot not press the sewed material.Pull the sewed material backward Quickly and lock the last stitch.Cut off the thread and take out the sewed material. Notice:After finished sewing the thinner material,you had better cut off thread with a scissor.so that not broke the thin material.

十四、Machine regulation

1.Above blade regulation

Loose four fixed screws of the above blade.Regulate the top edge of the above blade to level the top edge of the support.Then twist the screw tightly(Fig.10)

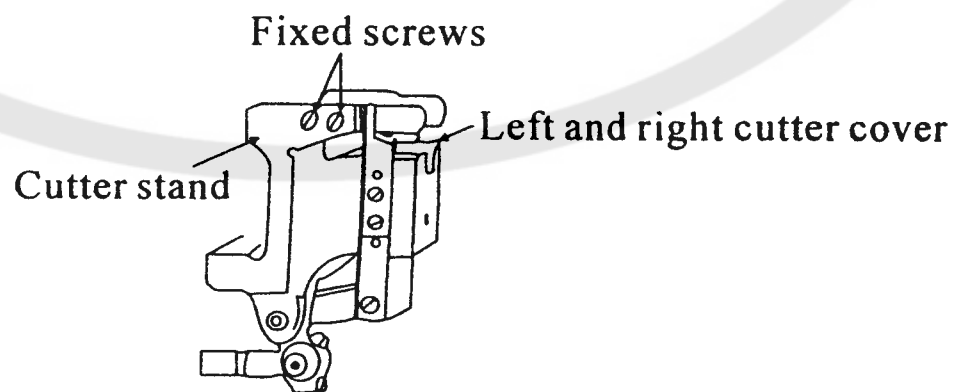
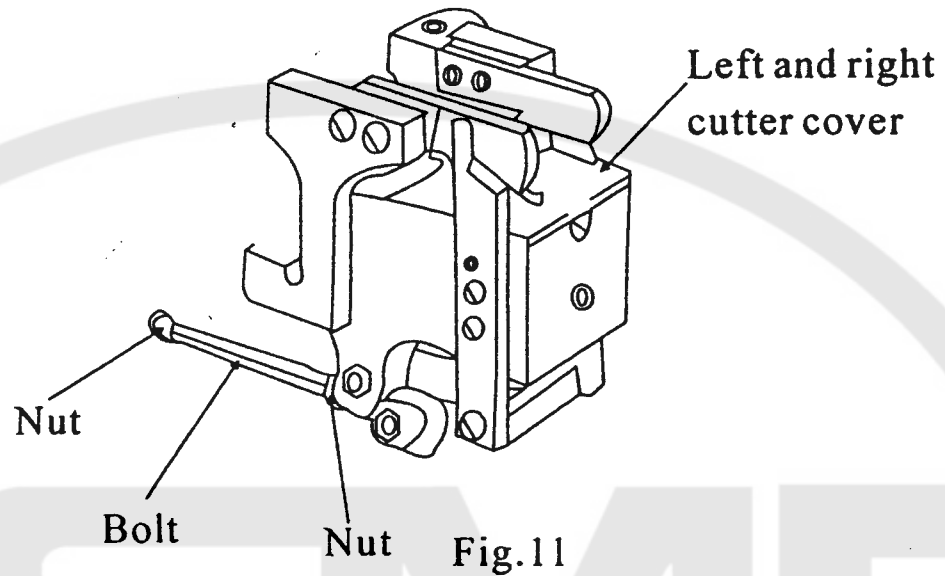


Fig.10

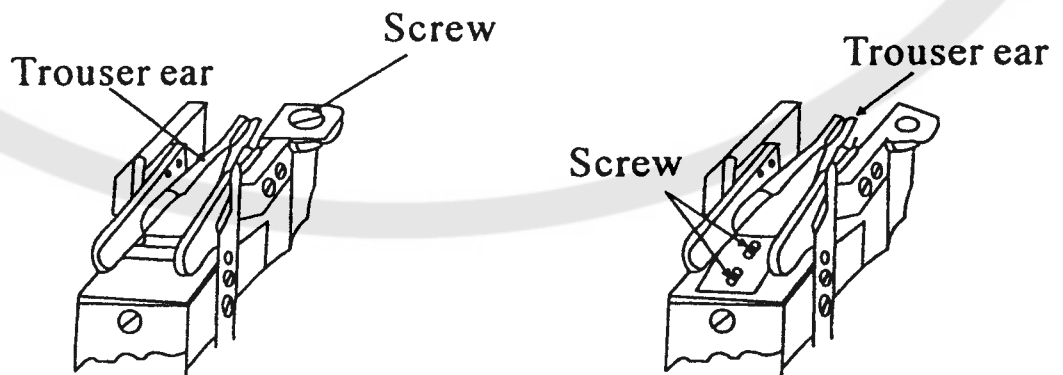
2. Left, right cutters regulation

Rotate the hand wheel clockwise until cutters get to the bolt until the edge of the left and right cutters is 1 mm above the lower edge of the above blade. Then twist the screws tightly. (Fig. 11)



3. Trouser

Loose the screws and regulate the trousers ears sideways or horizontally to the edge of the roof surface or the middle. (Fig. 12)



<PARTS LIST>

CONTENTS

Machine Frame&Covers Components.....	2
Main Shaft Mechanism Components.....	4
Needle Carrier&Feed Dog Mechanism Components.....	6
Looper Dive Mechanism&Presser Foot Parts Components.....	8
Ridge Forming Disc&Feed Plate Mechanism Components.....	10
Disc Oscillating Mechanism&Knee Press Shaft Parts Components.....	12
Cutting Material Componets.....	14
Knee Press & Standard Accessories.....	17

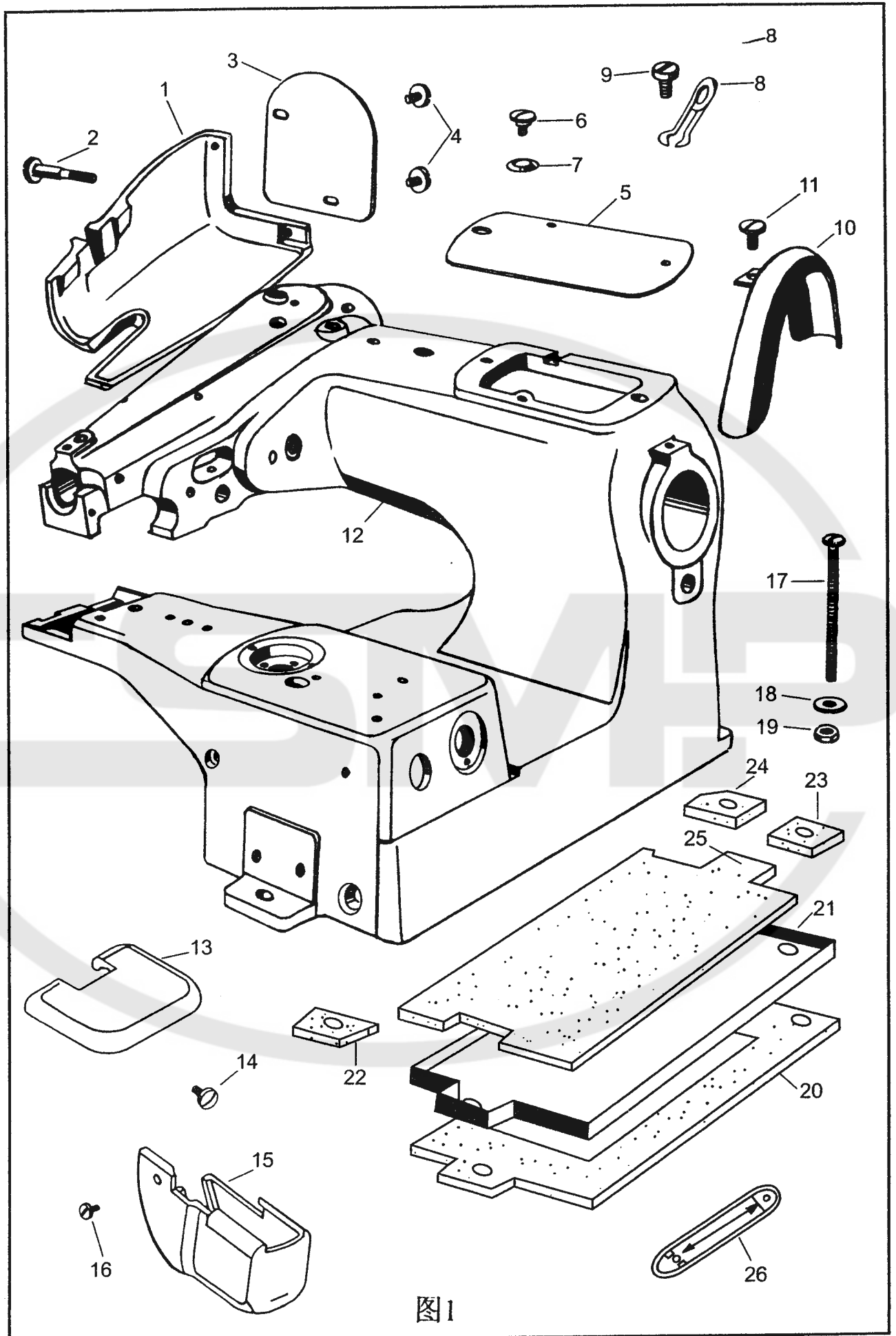


图1

Machine Frame&Covers Components

Ref.NO.	Parts NO .	Description
1-1	4139	Arm Side Cover
1-2	4144-A	Arm Side Cover Set Screw
1-3	4137	Arm Side Cover Plate
1-4	5227	Arm Side Cover Plate Screw
1-5		Arm Top Cover Plate
1-6	4141	Arm Top Cover Plate Screw
1-7	4140	Arm Top Cover Plate Washer
1-8	4203-A	Thread Guide
1-9	4193	Thread Guide Set Screw
1-10	4143	Belt Guard
1-11	4048-A	Belt Guard Set Screw
1-12	AM-101EX	Machine Frame
1-13	1643	Work Plate
1-14	6068	Screw
1-15	1640	Cutter Stand Guard
1-16	113-A	Cutter Stand Guard Set Screw
1-17	AC-15	Screw
1-18	AC-17	Machine Base Washer
1-19	AC-16	Machine Base Nut
1-20	4214	Machine Base Felt
1-21		Machine Base Padbad Oil Pan
1-22		Machine Base Rubber A
1-23		Machine Base Rubber B
1-24		Machine Base Rubber C
1-25		Machine Base Oil Felt
1-26	4226	Indicatorplate

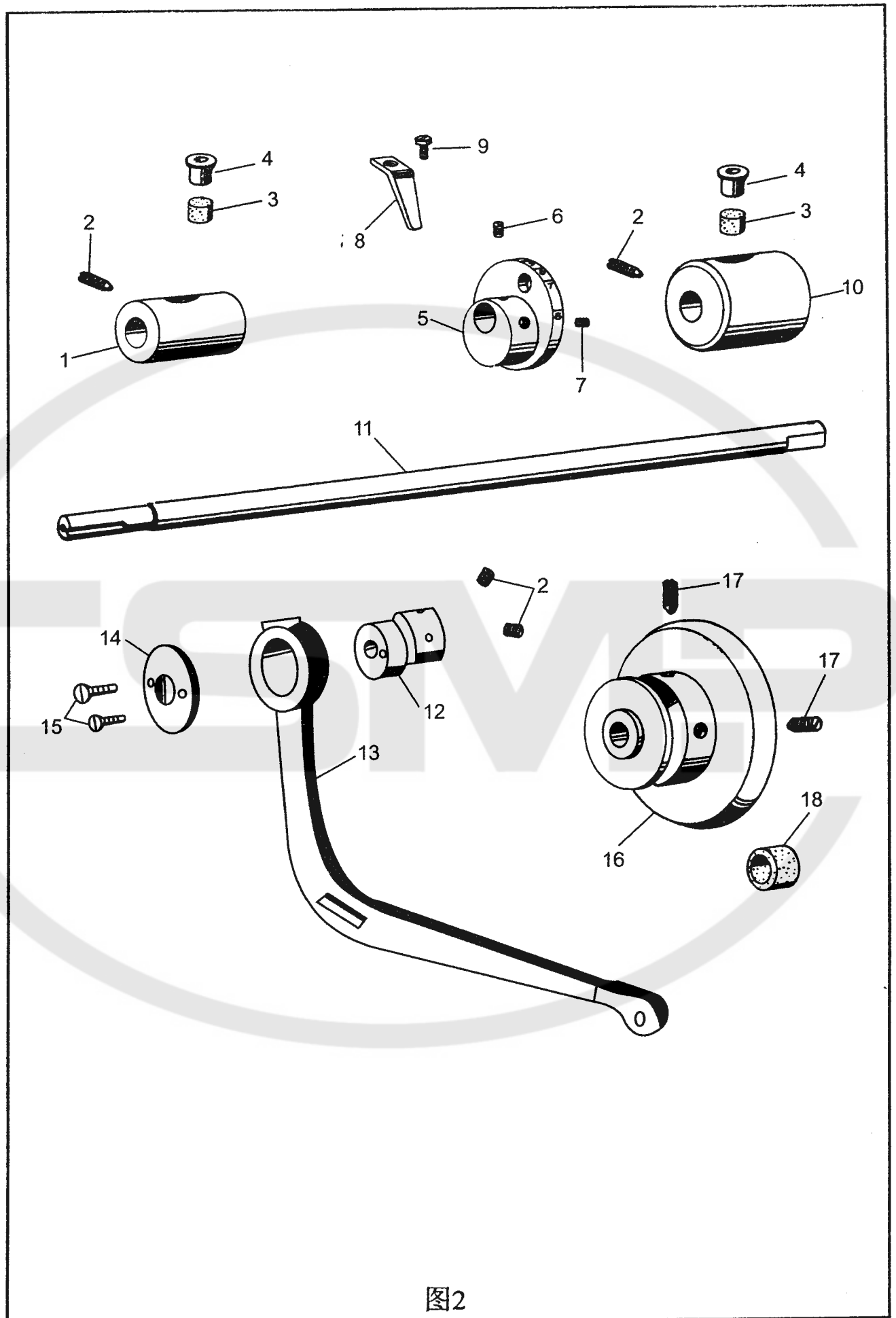


图2

Main Shaft Mechanism Components

Ref.NO.	Parts NO .	Description
2-1	11005	MainShaft Bushing(Front)
2-2	096010	Main Shaft Bushing Set Screw
2-3	4127-A	Oiling Felt
2-4	4128-A	Oil Cap
2-5	4133	Counterweight(w/Stitch Length Numbers)
2-6	132	Counterweight Set Screw(Short)
2-7	98	Counterweight Set Screw(Long)
2-8	4134	Stitch Length Indicator
2-9	124	Stitch Length Indicator Set Screw
2-10	11006	Main Shaft Bushing(Rear)
2-11	4003-A	Main Shaft
2-12		Bushing
2-13		Connecting Rod
2-14		Bushing Cap
2-15		Loopedamp Screw
2-16	4142-B	Hand Wheel(Pulley)
2-17	131	Hand Wheel Set Screw
2-18	4207-A	Hand Wheel Rubber Cap

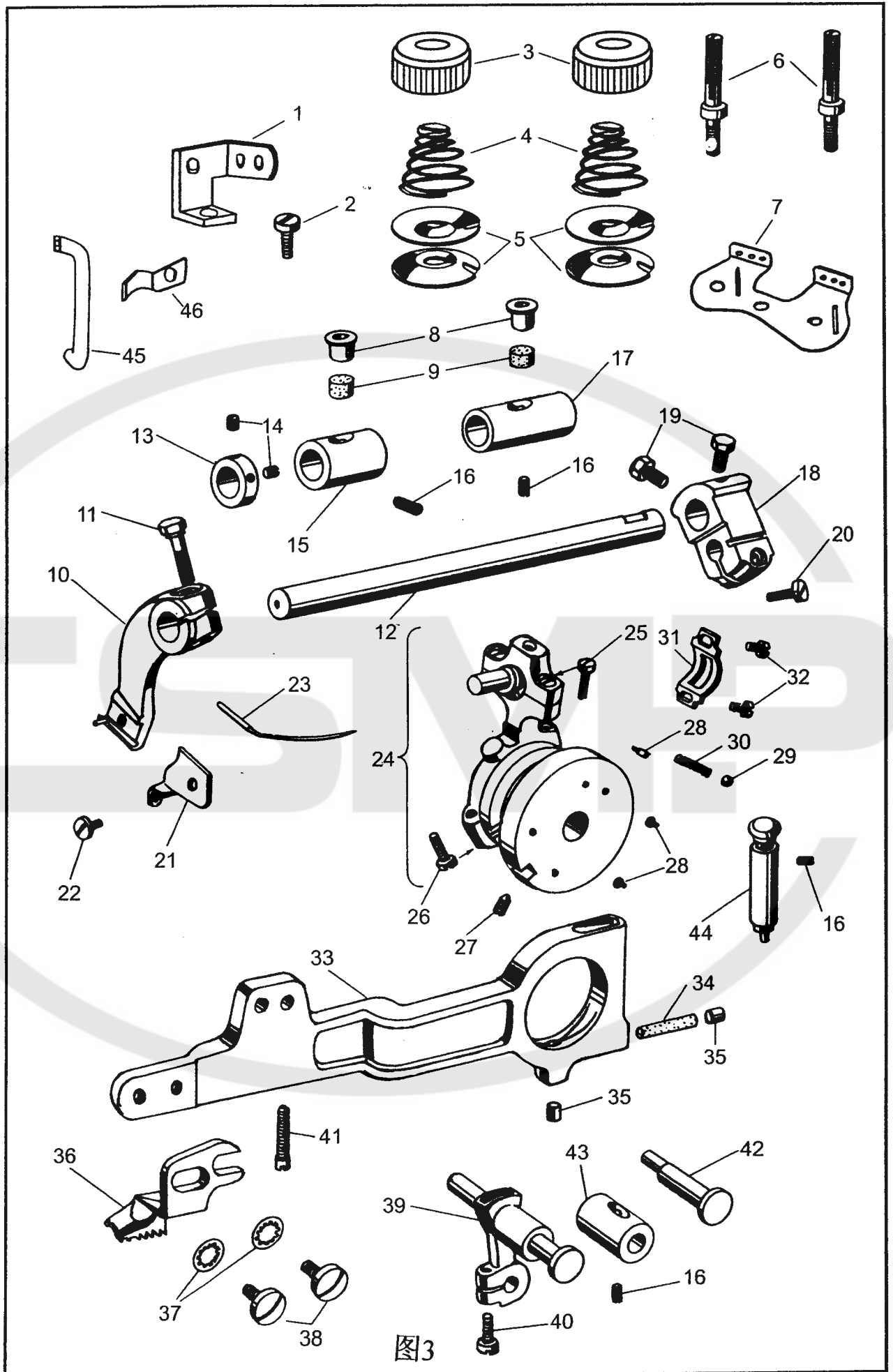
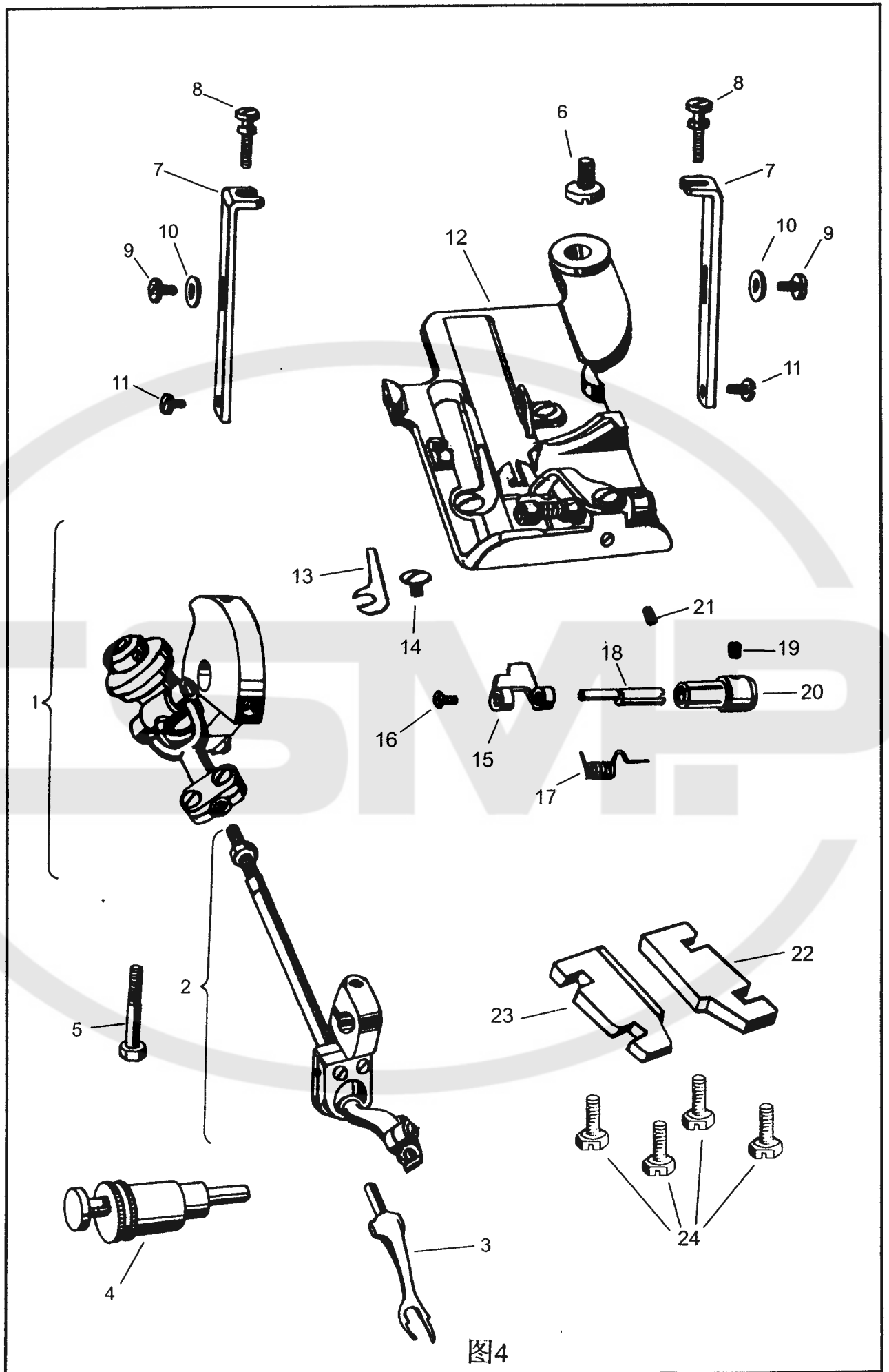


图3

Needle Carrier & Feed Dog Mechanism Components

Ref.NO.	Parts NO.	Description	Ref.NO.	Parts NO.	Description
3-1		Thread Guide Assembly	3-24	1151-B	Needle Driving Eccentric Sssembly
3-2	113-A	Thread Guide Set Screw			w/Rod,Regulator&Screw(Ref.22)
3-3	81	Nut	3-25	214012	Ball Connecting Rod Set Screw(Short)
3-4	79-B	Thread Tension Spring	3-26	214016	Ball Connecting Rod Set Screw(Long)
3-5	5190	Thread Tension Washer	3-27	4009-B	Needle Driving Eccentric Set Screw
3-6	21096	Thread Tension Staff	3-28	4012-A	Stitch Regulator Screw
3-7	4709-A	Thread Tension Limit Assembly	3-29	4010	Stitch Regulator Ball
3-8	4128-A	Oil Cap	3-30	1011-A	Stitch Regulator Spring
3-9	4127-A	Oiling Felt	3-31	4014	Ball Connecting Rod Cap
3-10	4023-A	Needle Carrier	3-32	4015	Ball Connecting Rod Cap Set Screw
3-11	4024	Needle Carrier Set Screw	3-33	11902-T	Feed Lever
3-12	4019	Needle Carrier Shaft	3-34	11124-J	Oiling Felt
3-13	4022	Needle Carrier Shaft Collar	3-35	11121	Oil Cap
3-14	129-B	Needle Carrier Shaft Set Screw	3-36	1642B-A	Feed Dog
3-15	11032	Needle Carrier Shaft Bushing(Front)	3-37	2528-A	Feed Dog Washer
3-16	129-A	Needle Carrier Shaft Bushing Set Screw	3-38	4048-A	Feed Dog Set Screw
3-17	11033	Needle Carrier Shaft Bushing(Rear)	3-39	1152-AA	Feed Link&Stud
3-18	4017-A	Needle Carrier Shaft Crank	3-40	4173	Feed Link Clamp Screw
3-19	4018-C	Needle Carrier Shaft Crank Clamp Screw	3-41	95016	Feed Link Stud Set Screw
3-20	114-A	Needle Carrier Shaft Crank Set Screw	3-42	4044	Feed Link Eccentric Stud
3-21	4025-A	Needle Clamp	3-43	4043	Feed Link Eccentric Stud Bushing
3-22	121	Needle Clamp Set Screw	3-44	520-A	Stitch Length Regulating Plunger Assembly
3-23	4181	Needle(System LWx6T)	3-45		Thread Guide Tube
			3-46		Thread Guide Button



Looper Drive Mechanism&Presser Foot Parts Components

Ref.NO.	Parts NO .	Description
4-1	538-A	Looper Drive Crank Assembly
4-2	539-A	Looper Carrier Assembly w/Ball Joint&Screws
4-3	4039	Looper
4-4	505	Eccentric Sleeve&Pin
4-5	4038	Eccentric Sleeve Clamp Screw
4-6	4050	Presser Foot Set Screw
4-7	4061-A	Presser Foot Bracket
4-8	4062	Presser Foot Bracket Adjusting Screw
4-9	121-B	Presser Foot Bracket Holding Screw
4-10	11158	Presser Foot Bracket Washer
4-11	4186-A	Presser Foot Holding Screw
4-12	1641-B	Plain Presser Foot
4-13	11563-A	Needle Guide
4-14	4052-B	Needle Guide Set Screw
4-15	1650-A	Cloth Retainer
4-16	4185-B	Retaining Block Screw
4-17	4056	Needle Guide
4-18	4054	Presser Foot Holding Screw
4-19	4183	Cloth Retainer Eccentric Stud Set Screw
4-20	4053	Cloth Retainer Eccentric Stud Bushing
4-21	130-B	Cloth Retainer Eccentric Stud Bushing Set Screw
4-22	1649	Right Limitplate
4-23	1649-A	Left Limitplate
4-24	6024	Hexagon Screw

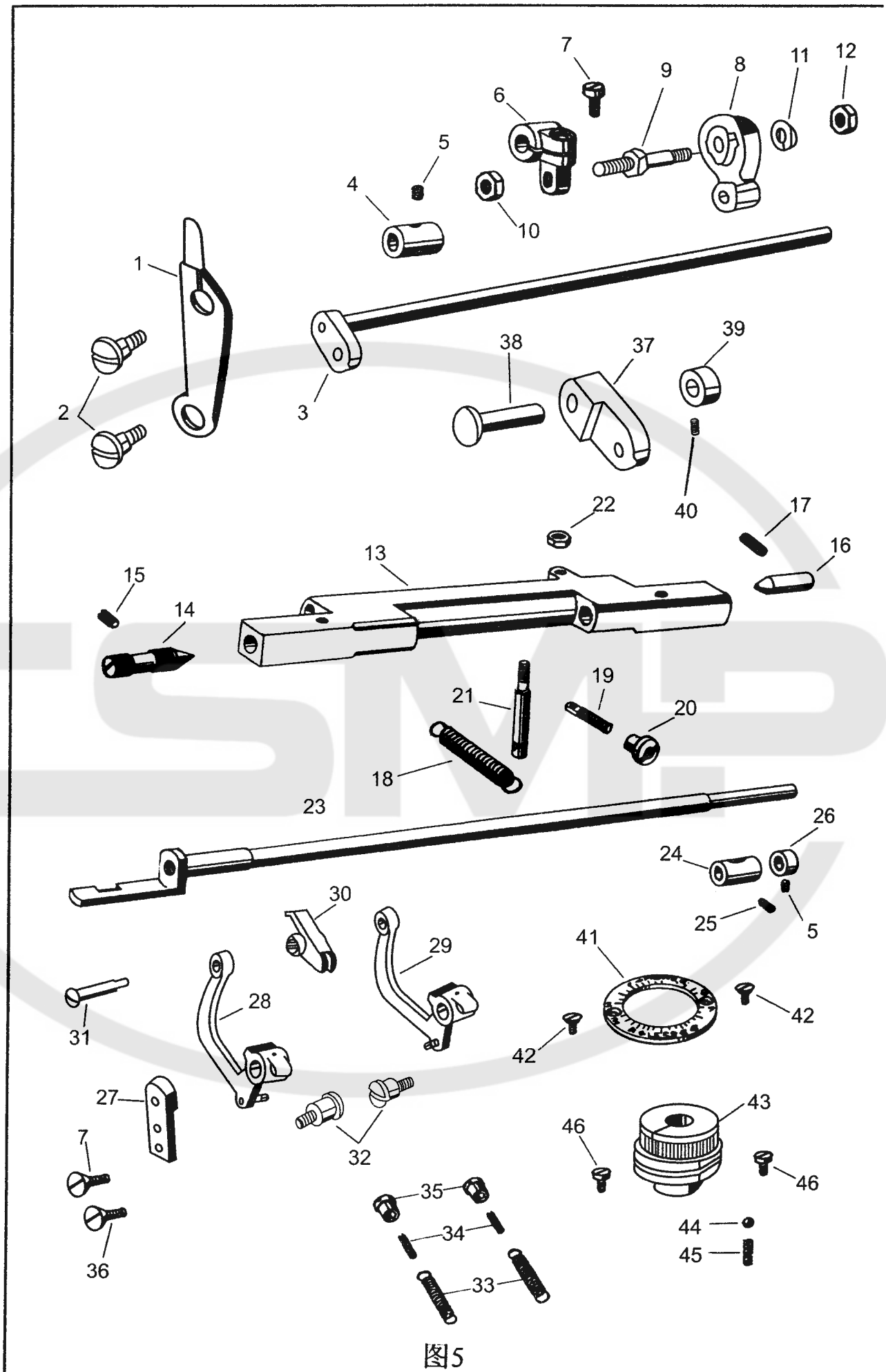


图5

Ridge Forming Disc&Feed Plate Mechanism Components

Ref.NO.	Parts NO.	Description
5-1		Ridge Forming Disc
5-2		Ridge Forming Discshaft Set Screw
5-3		Ridge Forming Disc Shaft
5-4	4111	Ridge Forming Disc Shaft Collar
5-5	129-B	Ridge Forming Disc Shaft Collar Set Screw
5-6	4112	Ridge Forming Disc Shaft Crank
5-7	113-B	Ridge Forming Disc Shaft Crank Set Screw
5-8	11519	Ball Connecting Lever
5-9	4230	Double-heads Set Screw
5-10	4176	Ball Stud Nut
5-11	8179	Spring Washer
5-12	17203	Hexagon Nut
5-13	4102	Disc Adjusting Holder
5-14	11048	Disc Adjusting Holder Pivcot Bearing Screw
5-15	98	Disc Adjusting Holder Piveot Bearing Screw Set Screw
5-16	11049	Disc Adjusting Holder Piveot Bearing Pin
5-17	11050	Disc Adjusting Holder Piveot Bearing Pin Set Screw
5-18	4104	Disc Adjusting Holder Spring
5-19	4105	Disc Adjusting Holder Spring Screw
5-20	4106	Disc Adjusting Holder Spring Nut
5-21	4103-B	Disc Adjusting Holder Spring Stud
5-22	5208	Disc Adjusting Holder Spring Stud Nut
5-23	11075-A	Feed Plate Shaft
5-24	4043	Feed Plate Shaft Bushing
5-25	96010	Feed Plate Shaft Bushing Set Screw
5-26	4090	Feed Plate Shaft Collar
5-27	1633	Left Feed Plate Bracket
5-28	1634	Left Feed Plate Assembly w/Screws&Nuts
5-29	1635	Right Feed Plate Assembly w/Screws&Nuts
5-30	1636-CA	Feed Plate
5-31	1637	Hinge Screw
5-32	4096	Feed Plate Shoulder Bearing Screw
5-33	4093-BA	Feed Plate Spring Set Screw
5-34	4094	Spring Set Screw
5-35	4095	Feed Plate Spring Adjusting Nut
5-36	114-B	Screw
5-37	1628-A	Ride Forming Disc Pitmanconnecting Link
5-38	11812	Driver Pin
5-39	1630	Retainer Ring
5-40	130-B	Screw
5-41	11255-N	Disc Adjusting Dial
5-42	129	Disc Adjusting Dial Set Screw
5-43	519-GT	Disc Adjusting Regulator Assembly
5-44	4010	Disc Adjusting Reguator Ball
5-45	10052	Disc Adjusting Regulator Spring
5-46	115	Disc Adjusting Regulator Base Set Screw

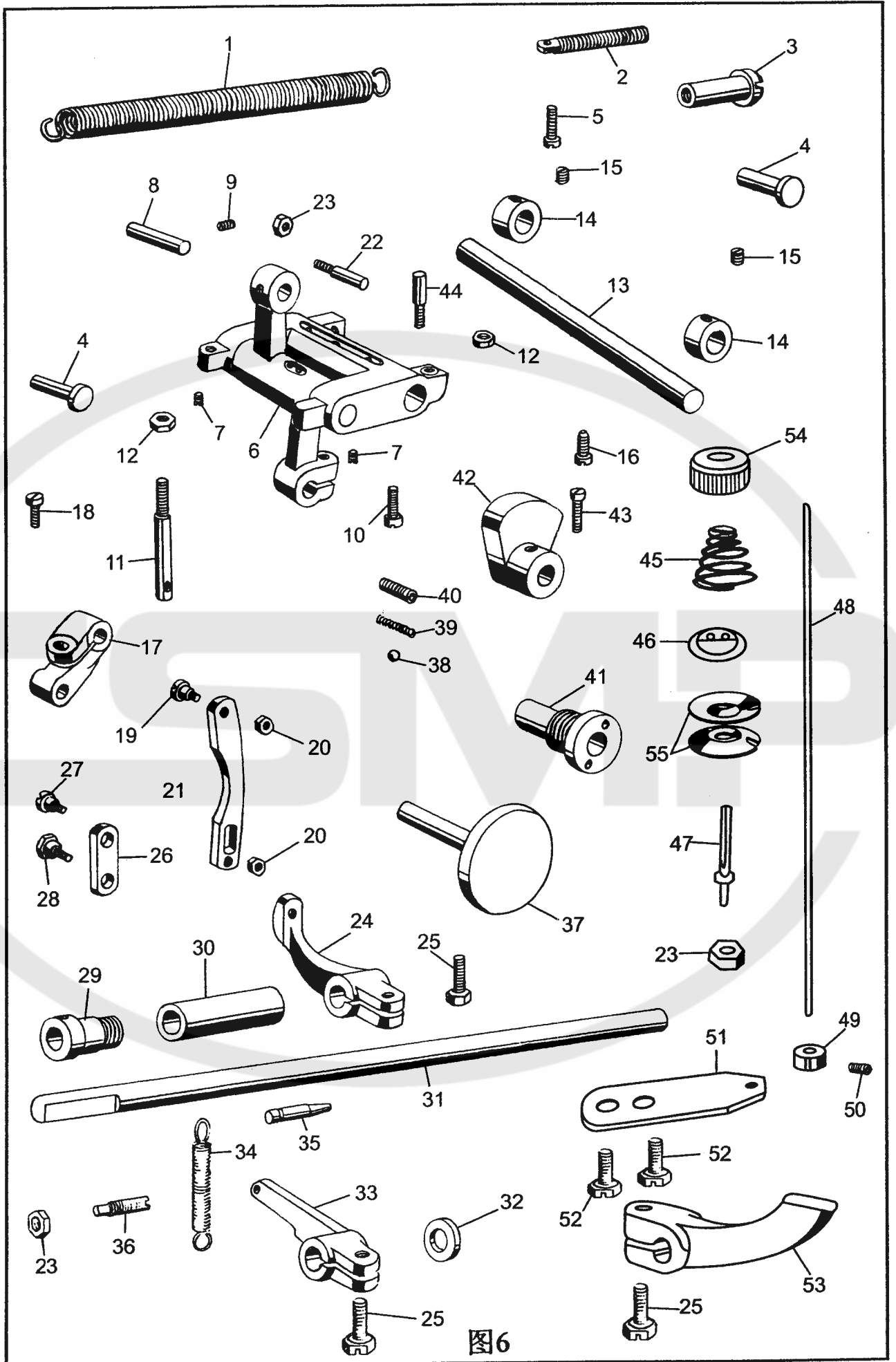


图6

Disc Oscillating Mechanism & Knee Press Shaft Parts Components

Ref.NO.	Parts NO.	Description	Ref.NO.	Parts NO.	Description
6-1	4073-A	Disc Oscillating Rod Bracket Spring	6-29	4081	Knee Press Shaft Bushing
6-2	4074	Disc Oscillating Rod Bracket Spring Screw	6-30	4177	Knee Press Shaft Sleeve
6-3	4075	Disc Oscillating Rod Bracket Spring Nut	6-31	11603-A	Knee Press Shaft
6-4	4065	Connecting Rod Stud	6-32	11539	Knee Press Shaft Washer
6-5	114-B	Connecting Rod Stud Set Screw	6-33	4221	Knee Press Stop Lever
6-6	S-4066-BB	Disc Oscillating Rod Assembly(w/Ref.No.8)	6-34	4222-B	Knee Press Stop Lever Spring
6-7	129-B	Disc Oscillating Rod Shaft Set Screw	6-35	4116	Knee Press Stop Lever Spring Pin
6-8	4115-A	Disc Oscillating Rod Pin	6-36	11050	Knee Press Stop Lever Limit Screw
6-9	129-A	Disc Oscillating Rod Pin Set Screw	6-37		Skip-Stitch Selecting Grip
6-10	4031-A	Disc Oscillating Rod Stud Set Screw	6-38	4010	Skip-Stitch Selecting Ball
6-11	4069-A	Disc Oscillating Rod Bracket Spring Stud	6-39	4011	Skip-Stitch Selecting Spring
6-12	4070	Skip-Stitch Selecting Cam Stud Nut	6-40	4174	Skip-Stitch Selecting Spring Holder
6-13	4076	Disc Oscillating Rod Bracket Shaft	6-41	4170	Skip-Stitch Selecting Grip Bushing
6-14	4077-A	Disc Oscillating Rod Bracket Shaft Collar	6-42	4172	Skip-Stitch Selecting Cam
6-15	132	Disc Oscillating Rod Bracket Shaft Collar Set Screw	6-43	4173	Skip-Stitch Selecting Cam Set Screw
6-16	96010	Disc Oscillating Rod Bracket Shaft Set Screw	6-44	4175-A	Skip-Stitch Selecting Cam Stud
6-17	4098-A	Feed Plate Depressing Crank	6-45	79-B	Thread Tension Spring
6-18	105	Feed Plate Depressing Crank Set Screw	6-46		Thread Tension Washer
6-19	4178-A	Crank&Link Shoulder Screw	6-47		Thread Tension Staff
6-20	5207	Crank&Link Shoulder Screw Nut	6-48	11162	Thread Nipper Releasing Pin
6-21	4086	Connecting Link(Large)	6-49	6053	Thread Nipper Releasing Pin Collar
6-22	4067-A	Connecting Link Guide Screw	6-50	130-B	Thread Nipper Releasing Pin Collar Set Screw
6-23	4068-A	Connecting Link Guide Screw Nut	6-51		Thread Nipper Releasing Pin Support
6-24	4083	Knee Press Shaft Crank	6-52	1156	Thread Nipper Releasing Pin Support Set Screw
6-25	4084	Knee Press Shaft Crank Set Screw	6-53		Thread Nipper Releasing Pin Lever
6-26	4087	Connecting Link (Small)	6-54	81	Thread Tension Nut
6-27	4088-A	Connecting Link Set Screw	6-55	5190	Thread Nipper Disc
6-28	4085	Connecting&Link Shoulder Screw			

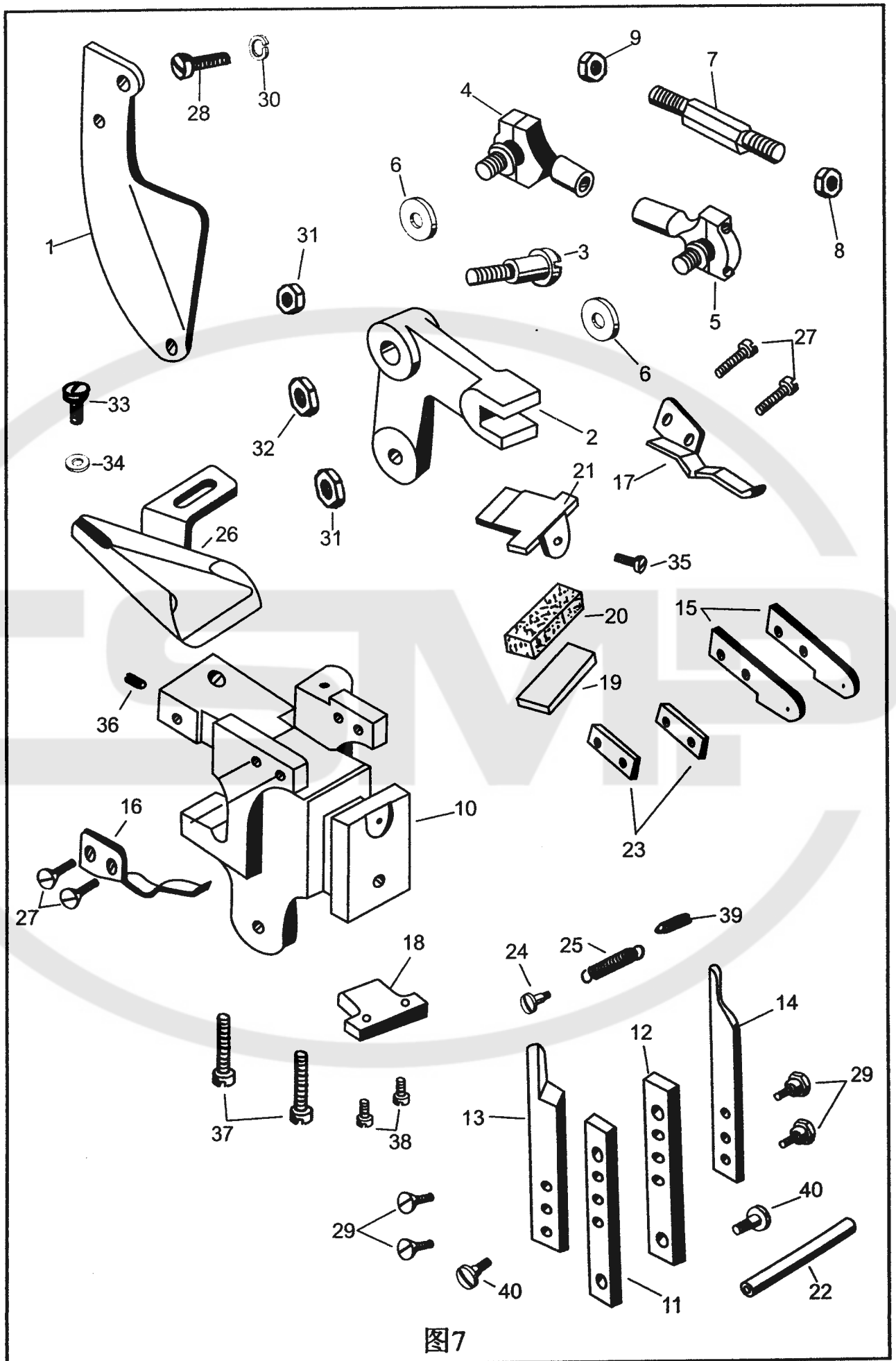


图7

Cutting material Components

Ref.NO.	Parts NO .	Description
7-1	1638	Connecting Rod
7-2	1602	Fork
7-3	1603	Forkconnecting Screw
7-4	S-1611-A	Cooper Drive Crank(Left)
7-5	S-1612-A	Cooper Drive Crank(Right)
7-6	5196-AT	Washer
7-7	1614	Bolt
7-8	1615	Nut(right)
7-9	1616	Nut(Left)
7-10	1610	Cutter Stand
7-11	1604	Left Guide Plate
7-12	1605	Right Guide Plate
7-13	1606	Left Cutter
7-14	1607	Right Cutter
7-15	1608	Upper Blade
7-16	1609	Leaf Spring(left)
7-17	1610	Leaf Spring(right)
7-18	1618	Limit Plate
7-19	1619	Baffle
7-20	1620	Oiling Felt
7-21	1621	Cutter Cover
7-22	1622	Pin Rod
7-23	1627	Washer
7-24	1624	Spring Shaft
7-25	1625-B	Spring
7-26	1646	Trouser car
7-27	1645	Screw
7-28	8128	Screw
7-29	4308	Screw
7-30	8179	Spring Washer
7-31	4176	Nut
7-32	4068-A	Cutter Stand Nut
7-33	4048-A	Belt Guard Set Screw
7-34	5178	Washer
7-35	4129	Counter Sunk Head Scren
7-36	129-A	Set Screw
7-37	1644	Screw
7-38	4040	Screw
7-39	4094-A	Feed Plate Screw
7-40	4186	Cutter Stand Connecting Screw

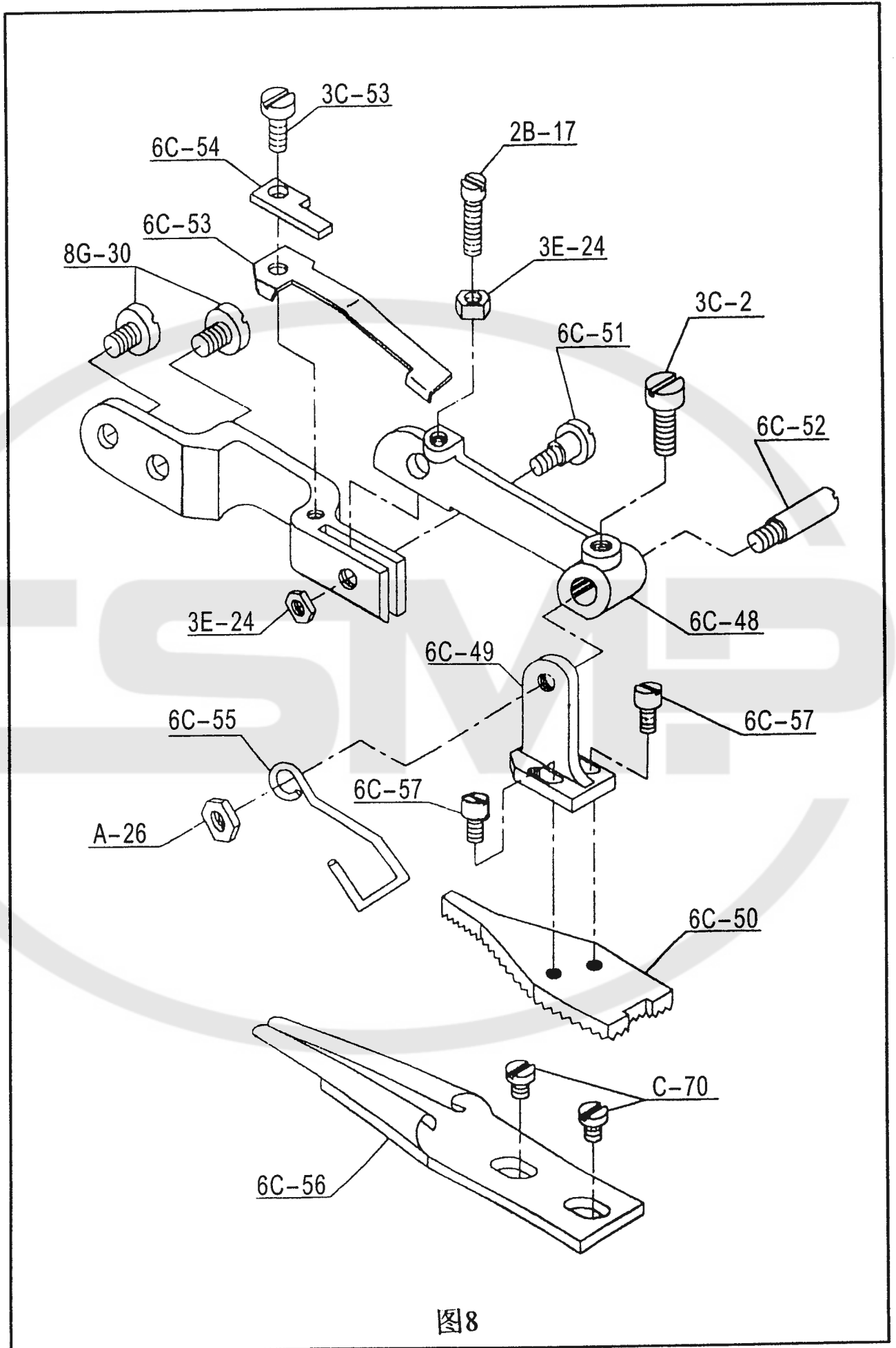


图8

Front Feeding Teeth Components

Ref.NO.	Chart NO.	Description
8-1	3C-53	Leaf Spring Set Screw
8-2	6C-54	Leaf Spring (short)
8-3	6C-53	Leaf Spring(long)
8-4	8G-30	Feed Dog Washer
8-5	2B-17	Ball Connecting Rod Set Screw(A)
8-6	3E-24	Nut
8-7	6C-51	Connecting Rod Holding Screw(A)
8-8	3C-2	Ball Connecting Rod Set Screw(B)
8-9	6C-52	Connecting Rod Holding Screw(B)
8-10	3E-24	Machine Base Nut
8-11	6C-48	Connecting Rod
8-12	6C-49	Feed Dog Bracket
8-13	6C-55	Disc Oscillating Rod
8-14	6C-57	Feed Dog Washer(B)
8-15	A-26	Machine Base Nut
8-16	6C-57	Feed Dog Washer
8-17	6C-50	Feed Dog
8-18	6C-56	Trouser Ear
8-19	C-70	Trouser Ear Set Screw

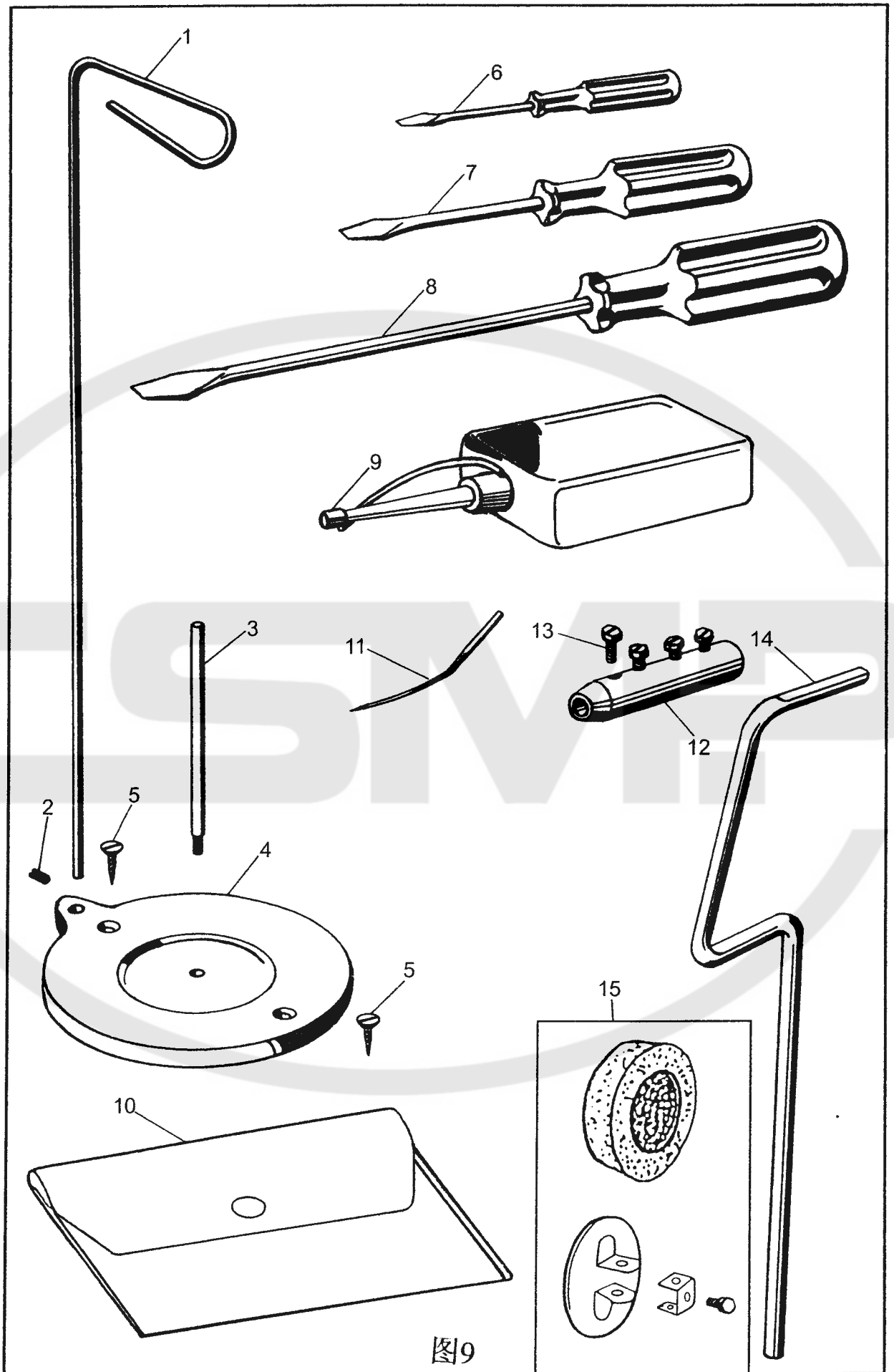


图9

Knee Press & Standard Accessories

Ref.NO.	Parts NO .	Description
9-1	4152	Thread Guide
9-2	129-A	Thread Guide Set Screw
9-3	4151	Spool Pin
9-4	4150	Cotton Stand Base
9-5	AC-10A	Cotton Stand Base Wood Screw
9-6	AC-03	Screw Driver(small)
9-7	AC-02	Screw Driver(Medium)
9-8	AC-01	Screw Driver(Large)
9-9	AC-04A/05	Oiler
9-10	AC-08A	Accessory Bag
9-11	4181	Needle (SystemLW×6T)
9-12	4146-B	Knee Press Rod Sleeve
9-13	4147-C	Knee Press Rod Sleeve Set Screw
9-14	4148-B	Knee Press Rod
9-15	S-21088	Kneepress Assemhhy