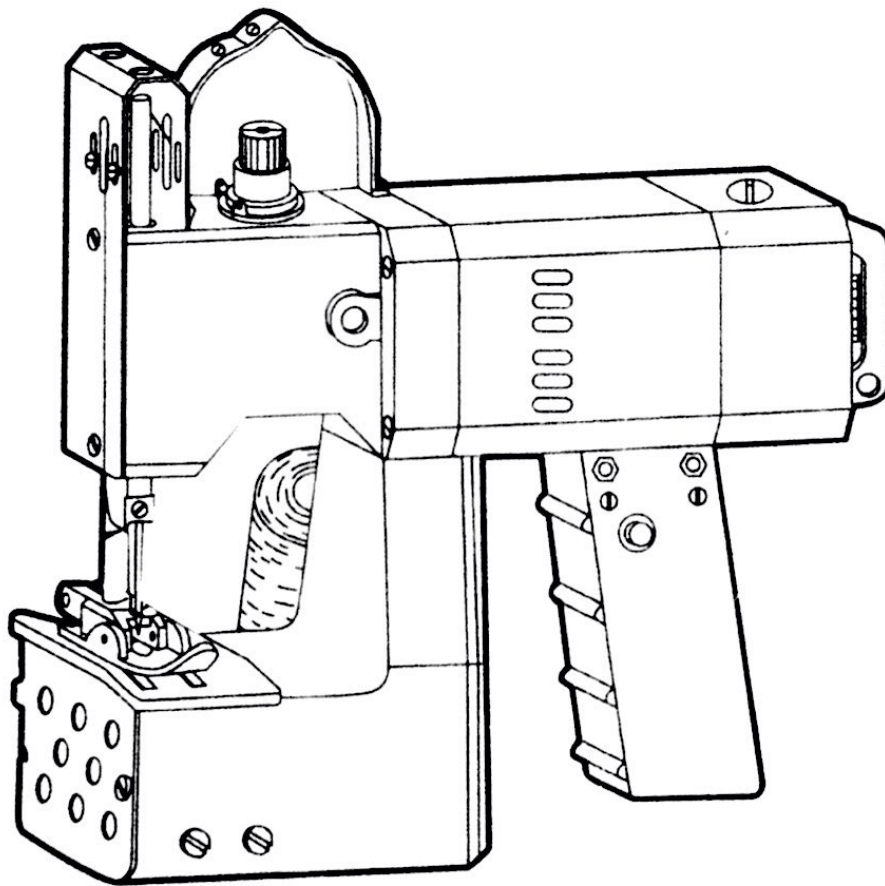


# INSTRUCTIONS, ENGINEER'S AND PARTS MANUAL



**PORTABLE BAG CLOSER**

# INSTRUCTIONS FOR Portable Bag Closer

## PREFACE

1. This manual has been prepared to guide you while operating and arranged to simplify ordering wear and spare parts.
2. This manual explains in detail the proper settings for operation of the machines. Illustrations are used to show the adjustments and reference letters are used to point out specific items discussed.
3. Careful attention to the instructions and cautions for operating and adjusting these machines will enable you to maintain the superior performance and reliability designed and built into every portable bag closer.
4. Adjustments and cautions are presented in sequence so that a logical progression is accomplished. Some adjustments performed out of sequence may have an adverse effect on the function of the other related parts.
5. This manual has been comprised on the basis of available information. Changes in design and / or improvements may incorporate a slight modification of configuration in illustrations or cautions.
6. On the following pages will be found illustrations and terminology used in describing the instructions and the parts for your machine.
7. In addition to the instructions and to the mandatory rules and regulations for accident prevention and environmental protection in the country and place of use of the machine / unit, the generally recognized technical rules for safe and proper working must also be observed.
8. The instructions are to be supplemented by the respective national rules and regulations for accident prevention and environmental protection.

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## APPLICATION AND STRUCTURE

The model GK9-500 Portable bag closer is a latest and completely new design product by CHUANGONG, which has been designed to stitch paper, plastic, net, jute, raffia, textile bags etc. with different thickness from thin to thick. Wholly metallic built, the well processed components ensures a great performance also with heavy materials and hard duty work. The machine is very light and handy, allowing easy and fast operations.

- The large overarm allows to stitch thin, medium, and thick bags.
- The one thread simple chain stitch gives a very strong, simple and quick bag stitching.
- The alternated looper avoids the thread's entanglement and stitch failure.

## SPECIFICATION

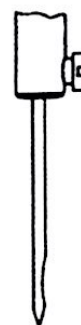
Stitch Length	6- 9mm
Max. Sewing Capacity	up to 3mm
Stitch Type	101
Needle	GK9, # 26 / # 230
Thread Size	21 Counts, 2x3 100% Polyester
Speed	1,500 - 1,700 rpm
	220V, Single Phase Output 150W
Motor	No Load 6,500 rpm Load 6,000 rpm
Dimension	250 x 80 x 240 mm
Net Weight	3.0 kg

## SAFETY RULES

1. Before maintenance, the machine has to be disconnected from the power supply by pulling out the main plug after using.
2. Check if the voltage of the sewing motor corresponds with the voltage of the wall socket.
3. Wall sockets for machines with ground wire must be properly grounded.
4. Do not block up the thermal hole of the motor.
5. Do not damage the button under hammer stroke.
6. Routine and maintenance must be done by an electrician or under direction and supervision of special skilled personnel.
7. Never store the machine under the wet or water condition.

## CHANGING THE NEEDLE

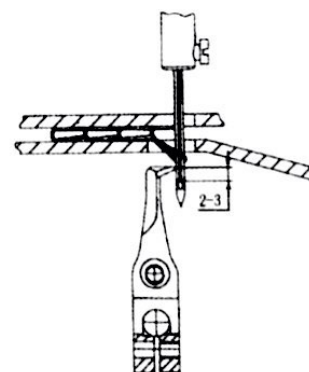
Loosen the screw for the needle and draw out the needle. Insert the shank of the new needle as far as it will go into the needle seat and with the flat on the shank facing to the front. Re-tighten screw for the needle on the flat of the needle shank and thread the needle eye. (Fig.1)



**Fig. 1**

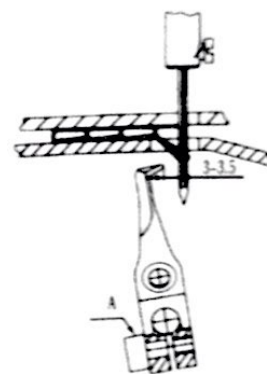
## TIMING BETWEEN NEEDLE AND LOOPER

When maintenance, check if the space between looper point and needle hole upper edge is within 2-3 mm. If not, adjust the needle to lower position. (Fig. 2)



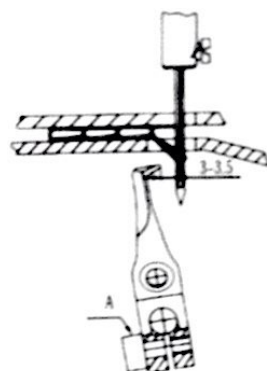
**Fig.2**

When the needle goes to the lowest position, the space between looper point and needle center is about 3-3.5 mm. If not, loosen screw A to adjust. (Fig. 3)



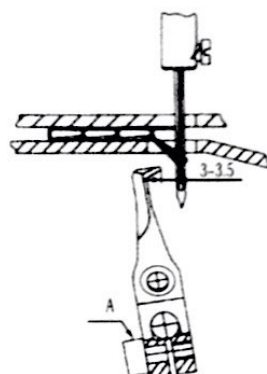
**Fig.3**

When lower edge of looper and upper edge of needle eye is flush, the space should be within 0.05-0.15 mm. (Fig. 4)



**Fig.4**

To change the looper, move the feed dog to the highest position, loosen the screw B then make the looper point to lean outward and pull it up. (Fig. 5)



**Fig.5**

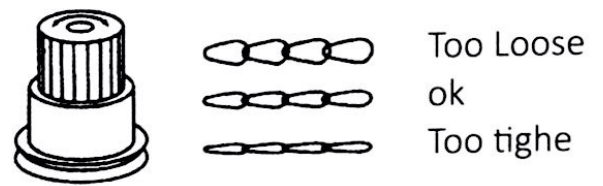
## THREAD TENSION

If the chain stitch is tight or loose, please turn the tension knob to regulate till the machine sews and chains off perfectly.

Clockwise: Tight

Counterclockwise: Loose

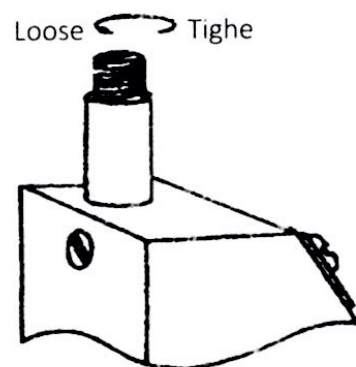
**Note:** Turn the tension knob a quarter per time till the machine sews and chains off perfectly. (Fig. 6)



**Fig.6**

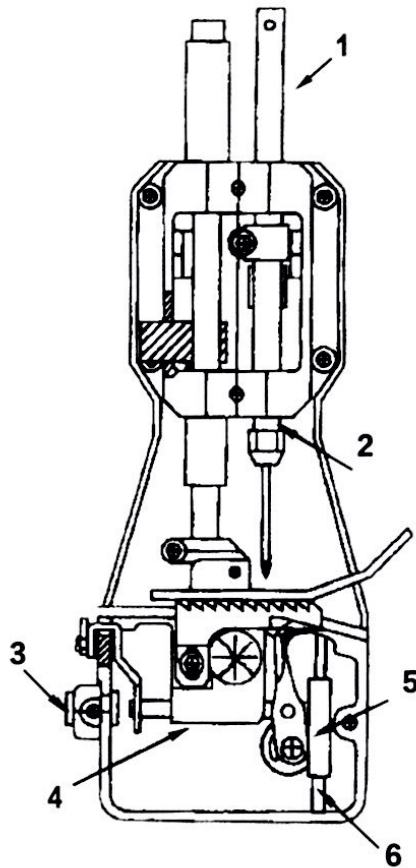
## PRESSER FOOT PRESSURE ADJUSTING

Presser foot pressure adjusting please according to Fig. 7.



**Fig.7**

## THREADING



## OILING

For lubrication we recommend "10# sewing machine white oil" or equivalent. Before operating a new machine for the first time, please oil the machine thoroughly. Repeat the oiling of a new machine after 10 minutes of operation! Lubricate the machine from the oil point. (Fig. 8)

## **CLEANING THE MACHINE**

Clean the machine at least once a week.

## TROUBLE SHOOTING

Problem	Cause	Solution
Needle (Looper) Thread breaks	Damaged looper Too much thread tension Too little thread tension Thread snarled or hung up along path between thread stand and needle/looper Incorrect threading, thread not between tension discs Incorrect needle setting Bent or damaged needle Double sewing Decreased stitch length because of worn feed dog teeth	Replace Decrease Increase Correct  Thread correctly Set correctly Replace Move up thread controller Replace feed dog
No chain formed	Incorrect threading Too much looper thread tension Too little needle thread tension Thread controller too low Needle and looper not timed each other Not enough presser foot pressure Thread is cut by feed dog teeth Feed dog is set too high, feedback chain	Thread correctly Decrease Increase Move it up Adjust timing Increase Filing the teeth Adjust height of feed dog
Skipping stitches	Wrong setting of needle Bent or damaged needle Thread controller too low Worn looper point Needle too high Thread sticking to needle due to heat Needle guard pushing needle Looper thread too loose to form a good triangle(reverse skip) Needle and looper wide apart(scoop skip)	Set correctly Replace Move it up Replace looper Lower needle bar Dampen needle thread with oil Adjust needle guard Increase looper thread tension Adjust distance needle to lower
Needle or looper breaks	Bent needle Looper point hitting needle Needle guard pushing needle or they are wide apart	Replace Adjust timing of needle looper Adjust needle guard
Stitch length not uniform, curved seam	Not enough presser foot pressure Worn feed dog teeth Bent needle	Increase Replace feed dog Replace

# **PARTS MANUAL FOR PORTABLE BAG CLOSER**

## **ORDERING WEAR AND SPARE PARTS ILLUSTRATIONS**

This manual has been arranged to simplify ordering wear and spare parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the sewing machine. On the page opposite the illustration will be found a listing of the parts with their part numbers, descriptions and the number of pieces required in the particular view being shown.

Numbers in the first column are reference numbers only and merely indicate the position of that part in the illustration.

Reference numbers should never be used in ordering parts.

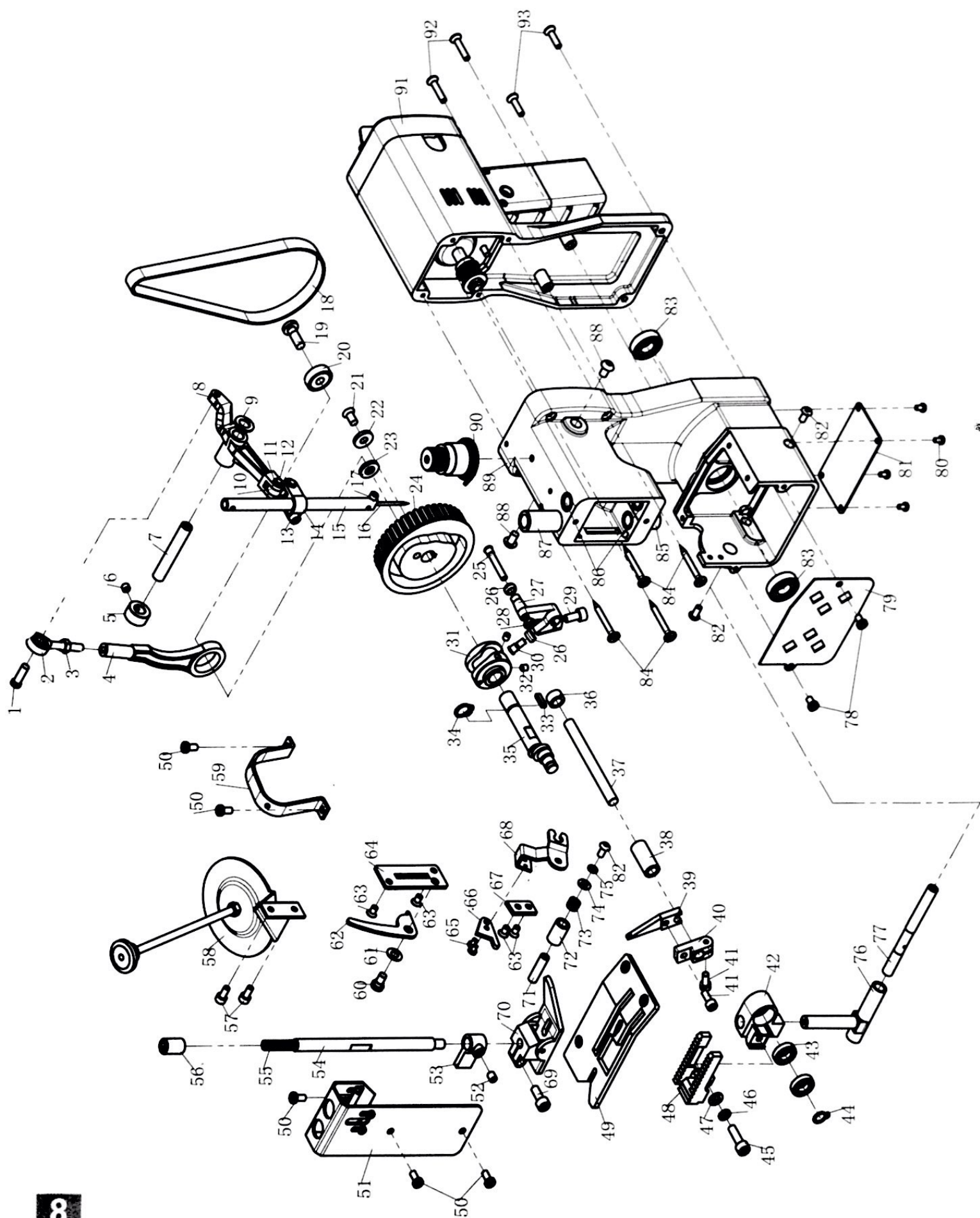
Always use the part number listed in the second column.

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their description under the description of the main subassembly.

At the back of the catalog will be found a numerical index of all parts shown in this catalog. This will facilitate locating the illustration and description when only the part number is known.

### **IMPORTANT!**

On all orders, please include part number, part name and type of machine for which part is ordered.

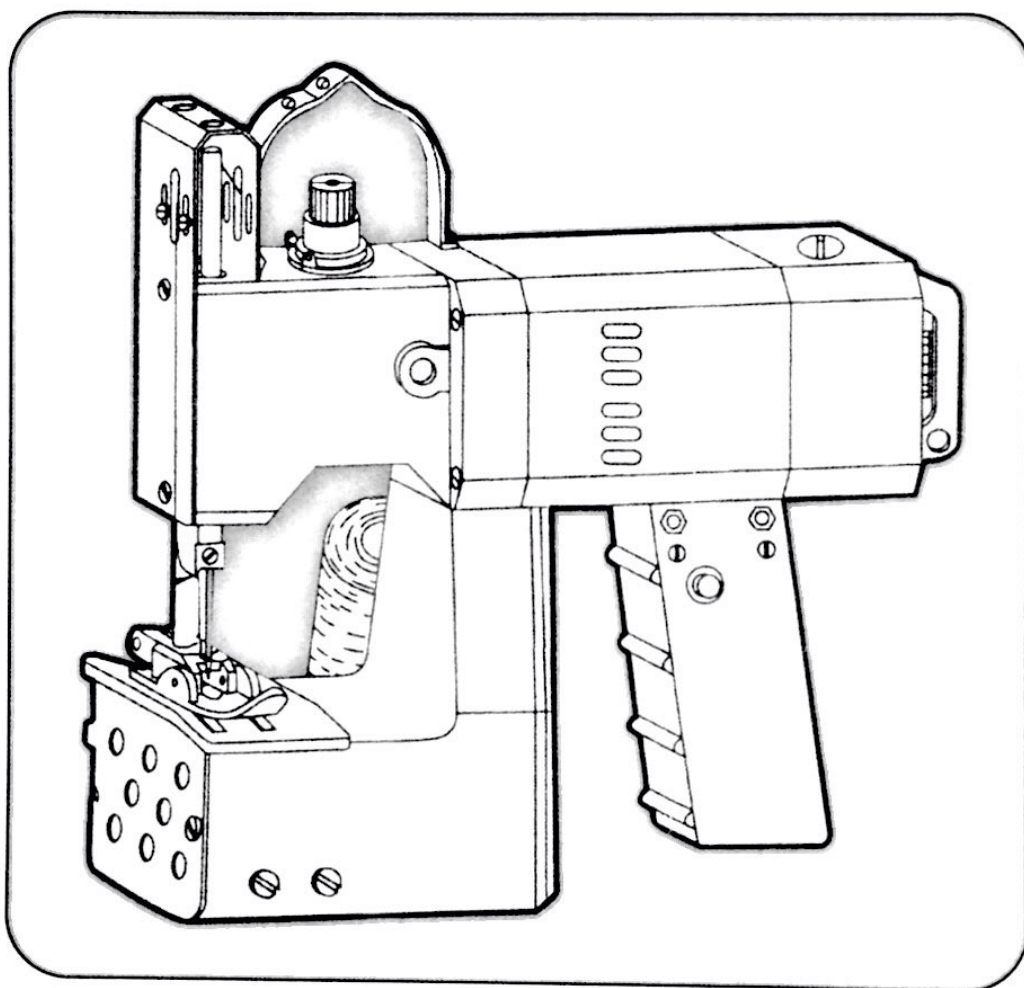


## SPARE PARTS LIST

1	Screw	32	Screw M4× 4	63	Screw M4× 6
2	Ball Connection Rod Ass'y	33	Key 3× 12	64	Side Plate
3	Screw M5	34	Washer	65	Screw M3× 4
4	Needle Bar Lever	35	Crank	66	Knife Moving
5	Spring	36	Looper Shaft Sleeve(Short)	67	Knife Stationary
6	Screw M5× 5	37	Looper Shaft	68	Knife Moving Bracket
7	Rob	38	Looper Shaft Sleeve	69	Screw M5× 12
8	Lever	39	Looper	70	Presser Foot Ass'y
9	Washer	40	Looper Bracket	71	Pin
10	Ball Joint	41	Screw M4× 8	72	Bushing
11	E-Spring	42	Feed Dog Base	73	Spring
12	Pin	43	DeepGrooveBall aring618/8	74	Washer
13	Screw M4× 8	44	Retainer 8	75	Washer
14	Needle Bar Connection rod	45	Screw M5× 16	76	Guide Rod
15	Needle Bar	46	Washer 5	77	Pin Rod
16	Needle	47	Washer	78	Screw M4× 6
17	Screw M3× 5	48	Feed Dog	79	Bottom Cover
18	Timing Belt	49	Needle Plate	80	
19	Screw	50	Screw M4× 8	81	Cover Plate
20	Bearing 126	51	Face Cover Ass'y	82	Screw M4× 8
21	Screw M5× 10	52	Screw M5× 6	83	Bearing
22	Washer	53	Presser Bar Guide	84	Screw M3.5× 35
23	Washer	54	Presser Bar	85	Presser Bar Bushing, lower
24	Synchronous Pully	55	Spring	86	Needle Bar Bushing
25	Ball Bearing	56	Screw	87	Presser Bar Bushing, upper
26	Ball	57	Screw M4× 8	88	Screw M5× 8
27	Looper Swinging Rod	58	Tension Disc Ass'y	89	Casting Housing
28	Screw M4	59	Thread Guide	90	Thread Tension
29	Screw M5× 12	60	Screw M5× 6	91	Motor Handle
30	Ball Bearing	61	Screw M3× 4	92	Screw M4× 20
31	In/out Cam	62	Wrench	93	Screw M4× 16

# 手提电动封包机

## 说明书



## 使用范围及结构特点

GK9-500型手提式电动工业封包机，系我厂已获得专利具有升级换代缝合袋口的最新产品。

本机采用先进合理的刺料、送料、钩线机构，其主要转动部位，装有微型精密的滚针、向心与杆端关节轴承，具有耐磨性强、噪音小、维修拆装方便、寿命长等优点。

机器配装有机械式自动剪线刀、缝合完毕后能自动剪线，是广泛适用于缝合厚薄不同的各种布袋、纸袋、塑料编织袋、纸塑复合袋，麻袋等包装袋。所缝的线迹具有弹性，线迹美观、封包牢固、拆包方便之特点。是当今最佳的封包设备。

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| (2) 钩针调换   | 八、零件名称及编号对照示意图 |
| (3) 穿线步骤   |                |
| (4) 压线盘的调整 |                |

针距长度：6-9毫米

最大缝料厚度：3毫米

缝线规格：21支 2x3涤纶线

机器净重：2.5 公斤

电动机：电压220V输出功率190W

空载6500/分负载6000/分

## 一、技术规格：

- (1) 线迹：单线链式
- (2) 机针型号：DPx5、135x5、25/200专用机针
- (3) 使用缝线规格：21支2x3涤纶线
- (4) 缝纫速度：1500~1700针/分
- (5) 电动机规格：电压220V输出功率190W空载6500/分负载6000/分
- (6) 外型尺寸：25x8x24（长宽高）
- (7) 机器净重：2.5公斤

## 二、安全注意事项：

- (1) 使用后维护前拔下电源插头。
- (2) 将本机与电源连接之前确认电压与本机电源是否符合。
- (3) 必须用三芯电源检查导线绝缘情况确认总电源已接地。
- (4) 电机散热孔不要堵塞应保持畅通。
- (5) 不要用硬物和重力撞击本机及按钮。
- (6) 应请合格的维护人员对本机进行定期维护。
- (7) 不得将本机受潮、及失水以免引起电器短路。

## 三、使用方法：

(1) 机针调换：将机针升高到最高位置，松开紧固螺丝即可，拔出机针，换上新机针，并使机针往上顶不动为止并注意机针缺口平面朝里紧固螺丝即可。（按图说明）

(2) 钩针调换：将送料牙升至最高点，打开六角螺丝B，然后针头向外倾斜，并往上抽即可。（按图说明）

(3) 穿线步骤。（按图说明）

(4) 压线盘的调整：转动压线螺母，顺时针为紧，逆时针为松。

(5) 压紧力的调整：顺时针转动调整螺丝压紧力增大，逆时针减小，建议在不影响送料效果的前提下适当减小压紧力，有利于为减轻电机负担和机件磨损。（按图说明）。

## 四、产品特点 and 用途：

### （一）产品特点：

（1）本机具有速度快、运动可靠性好、彻底改变旧机型运动稳定性差、机件易磨损、噪声大等设计缺点。采用低传动副，耐磨损、可靠性强，重量轻，绝缘性能好，结构紧凑合理等特点，能减轻工人长时间使用的劳动强度。

（2）压紧力可调：在缝制不同缝物时，调整压紧力大小，以达到提高工作效率、延长零部件使用寿命。

（2）自动剪线：在缝毕时无需人工剪线，只需要将尾线引入线槽即可。

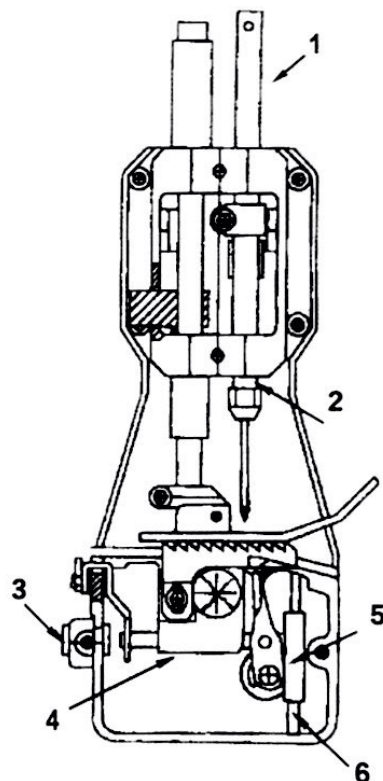
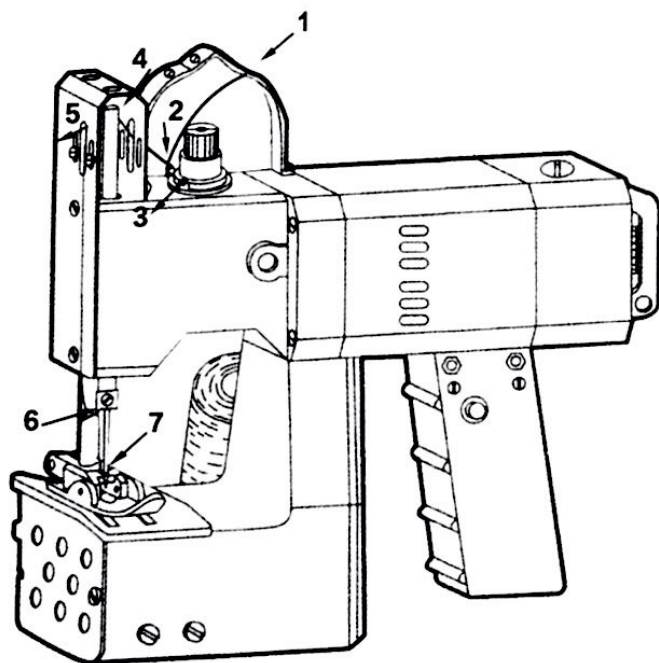
### （二）用途

本机供生产批量较大，场地比较拥挤的工厂、仓库和码头进行缝合盛满粮、糖、盐、茶叶、棉纱、药材、化工产品、金属粉剂、矿石粉末等物品的编织丙烯袋、布袋、麻袋、帆布袋、尼龙袋、牛皮纸袋等各种包装袋。

本机所缝的单线链式线迹，富有弹性、线迹美观，封包牢固，拆包方便。

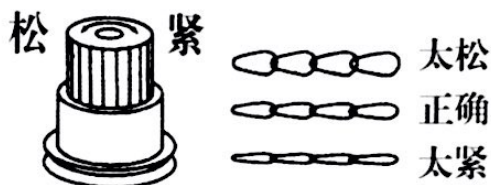
润滑油每天加油二次  
（按图部位）

穿线步骤按图所指示的顺序穿线

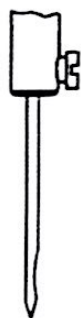


## 五、压紧力的调整

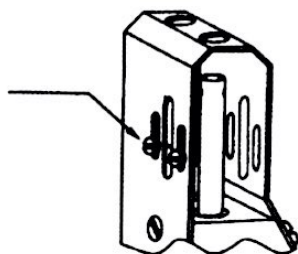
压线盘的调整：转动压线螺母，顺时针为紧，逆时针为松。



机针的调换：将机针升高到最高位置，拔出机针换上新针，使机针尾部顶丝面对准紧顶螺丝端面，同时针槽缺口平面与钩针平面相平行，然后拧紧螺丝即可。



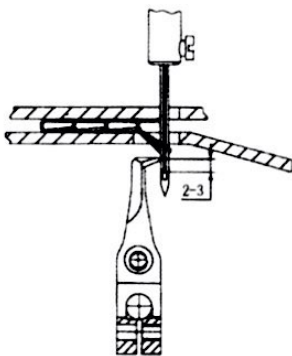
缝厚物时挑线板往上升可收紧线迹。



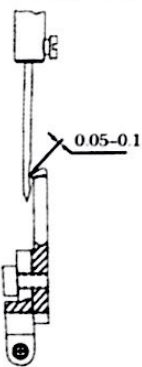
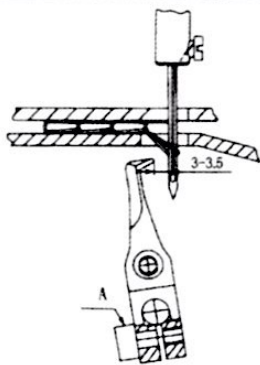
压紧力的调整：顺时针转动调整螺丝压紧力增大，逆时针减轻，建议在不影响松料效果的前提下适当减转压紧力有利于电机负担和机件磨损。

## 六、机针和钩针正确位置调整

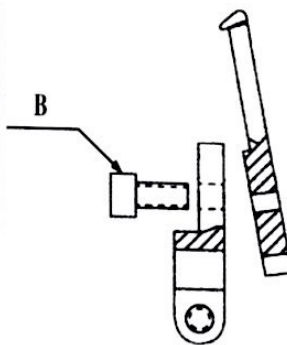
修理时请检查钩针尖与针孔上边缘是否在2-3毫米范围。如果不对应调整机针下降深度。



机针下降到最低点时，钩针尖与机针边缘距离应在3-3.5范围，不然就要松开螺丝A进行调整。



当钩针与机针凹槽相交时，其间隙应在0.05-0.15毫米范围。



钩针调换：将送料牙升至最高点，松开内六角螺丝B然后针头向外倾斜，（图）并往上抽即可。

## 七、一般故障的处理方法

故障类型	故障情况	发生故障原因	处理方法
断针	缝物过厚时断针	针尖刺偏或弯曲造成与弯针相撞	停止使用并更换新针
	机针与压脚或弯针相碰	压紧导架或压脚及弯针锁紧螺丝松动	检查后拧紧
跳针	机针没有穿入弯针线圈	机针偏高, 下行时机针动作相对滞后	对照说明书调整
	弯针不勾线	弯针与机针缺口平面间隙过大	对照说明书调整
		或机针偏高, 弯针动作相对滞后	
	快速缝厚物时偶尔跳针	机针缺口平面倾斜	调整机针缺口平面与弯针平行
		缝线张力不均, 时紧时松造成	更换优质缝线
断线	线头呈剥丝状	机针的针孔或线槽不光滑	更换机针
	尾线很毛	针板孔及弯针表面粗糙	用砂布打磨
	线头呈割断状	机针孔粗糙, 压线器太紧	检查后更新调整
		面板的挑线器太高等造成	
其他	送料不流畅	压脚表面不光滑, 送料牙齿尖不锋利, 送料牙抬升高度不够	更换压脚, 更换牙齿, 太高牙齿高度
	出尾时不流畅	送料牙与压脚底面按处不平	修整压脚底面
电机	电机不转动	检查碳刷磨损情况	更换新碳刷
	电机不转或转过高	开关接触不良以及整流管烧坏	更换新开关以及新整流转子

## 八、零件各名称及编号对照示意图

序号	图号	名称	数量	序号	图号	名称	数量
1		球脸杆螺钉	1	28		六角螺母M4	1
2		球连杆组件	1	29		内六角圆柱头螺钉M5x12	1
3		六角螺母M5	1	30		滚珠轴	1
4		针杆连杆	1	31		进出凸轮	1
5		挡圈	1	32		内六角凹端紧定螺钉M4x4	2
6		内六角凹端紧定螺母M5x5	1	33		键3x12	1
7		杠杆销	1	34		轴用弹性挡圈10	1
8		杠杆	1	35		抬牙曲拐	1
9		垫圈	1	36		钩针轴套(短)	1
10		小连杆	1	37		钩针轴	1
11		E型挡圈3	4	38		钩针轴套	1
12		销	2	39		勾针	1
13		内六角圆柱头螺钉M4x8	1	40		勾针架	1
14		针杆连接柱	1	41		内六角圆柱头螺钉M4x8	2
15		针杆	1	42		送料牙座	1
16		机针	1	43		深沟球轴承618/8	2
17		内六角圆柱头螺钉M3x5	1	44		轴用弹性挡圈8	1
18		同步带	1	45		内六角圆柱头螺钉M5x16	1
19		针杆连杆螺钉	1	46		弹性垫圈5	1
20		调心轴承 126	1	47		平垫圈5	1
21		沉头螺钉M5x10	1	48		送料牙	1
22		同步带轮垫圈	1	49		针板	1
23		垫片	1	50		盘头螺钉M4x8	5
24		同步带轮	1	51		面板组件	1
25		滚珠轴	1	52		紧定螺钉M5x6	1
26		滚珠	2	53		压杆导向	1
27		钩针摆杆	1	54		压杆	1

序号	图号	名称	数量	序号	图号	名称	数量
55		压杆弹簧	1	82		内六角半圆头螺钉M4x8	3
56		压杆螺钉	1	83		轴承6900Z	2
57		内六角螺母M4x8	2	84		自攻螺钉M3.5x35	4
58		线盘组件	1	85		压杆下套	1
59		过线	1	86		针杆套	2
60		轴位螺钉 $\Phi 6 \times M5$	1	87		压杆上套	1
61		十字槽盘头螺钉M3x4	1	88		内六角半圆头螺钉M5x8	2
62		扳手	1	89		机壳	1
63		十字槽盘头螺钉M4x6	4	90		夹线器	1
64		侧板	1	91		电机_手柄	1
65		十字槽盘头螺钉M3x4	4	92		沉头螺钉M4x20	2
66		动刀	1	93		沉头螺钉M4x16	2
67		定刀	1				
68		动刀架	1				
69		内六角螺钉M5x12	1				
70		压脚组件	1				
71		刀杆销	1				
72		刀杆销套	1				
73		动刀弹簧	1				
74		平垫圈4	1				
75		轻型弹簧垫圈4	1				
76		送料牙座导杆	1				
77		导轨	1				
78		盘头螺钉M4x6	2				
79		下盖	1				
80		开槽盘头螺钉M3x5	4				
81		盖板	1				

