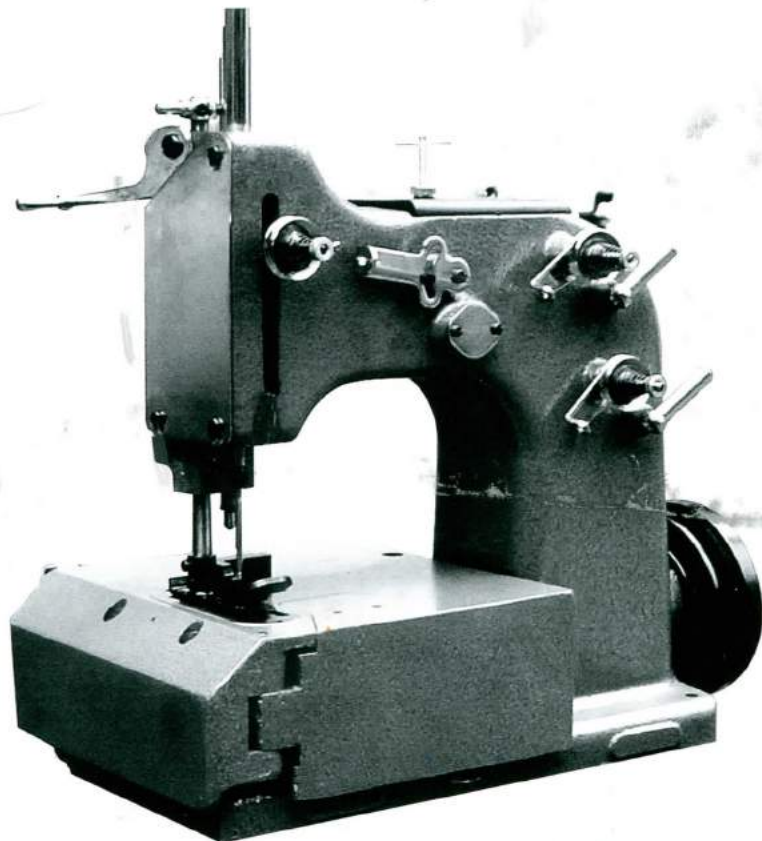


VISTA SM
VB8-4/VB8-24
INDUSTRIAL SEWING
MACHINE

OPERATING INSTRUCTION
&
PARTS LIST



A. Introduction

GK8 series industrial sewing machines are special equipment for sewing or closing bage. They are suited to make all kinds of bags made from burlap, jute, plastic knitting and single ply or multi-wall paper. Also suited to close filled bags in ports, storehouses, chemical plants, building material plants, or food processing factories.

GK8-1 jute bag folded top sewing machine may be used to make jute bags.

GK8-2 sewing machine is used to make single ply or multi-wall paper bags or plastic knitting bags.

GK8-3 jute bag closer is used for closing jute bags.

GK8-4 bag closer is used for closing filled paper bags, plastic paper bags or plastic knitting bags.

GK8-5 jute bas closer may be used for closing more packed jute bags because the distance from the center of needle to the left edge of working floor is 25mm only.

GK8-24 double-needle four-thread bag closing machine is used to closing filled paper bags, plastic paper bags or plastic knitting base.

All the machines effect dust-proof by virtus of semi-closed installations. The key parts are made of fine alloy steel. All easy worn part in the machines are made of metal by heat-treatment.

Whenever you may have any need, the manufacturer will offer you spare parts and other services.

B. Main Technical Specification

	Item	GK8-1	GK8-2/4	GK8-3	GK8-5	GK8-24
1	Highest sewing speed	1400spm	1400spm	1400spm	100spm	1300spm
2	Stitch type	Single-thread chain stitch	Lock stitch	Loch chain	Single-thread chain stitch	Loch chain stitch
3	Stitch length	10-18mm	8-16mm	8-16mm	10-18mm	6-10mm
4	Sewing thickness	10mm	10mm	10mm	10mm	10mm
5	The distance from center of the needle to the left edge of working floor	≤ 60mm	≤ 60mm	≤ 60mm	≤ 25mm	≤ 60mm
6	Type of neele	No.33	No.26	No.26 or 33	No.36	No.26
7	Sewing thread	3.2×2	20×2×3	20×2×3	3.2×3	20×2×3
8	Dimension	40×21.5×43	40×21.5×43	40×21.5×43	37×22×43	40×21.5×43
9	Net head weight	32kg	32kg	32kg	32kg	32kg
10	Motor	0.4kw	0.4kw	0.4kw	0.4kw	0.4kw

C. Maintenance

1. Preparation for use

Before operation a new machine or a long-restored one, the dust and grease on the surface of the body and the parts must be cleaned off, fill the lubricating holes drops of sewing machine oil or light engine oil. Turn pulley by hand to check the synchronization of machine, try to adjust as terms(3),(4),(5),(6) described in chapter D until everything is satisfied, and then turn on power.

In operating the empty sewing machine time should be shortened as much as possible in order to reduce the wear of feed dog teeth and presser foot.

2. Needle

The qualities that a needle requires are straight in body, sharp at needle point, smooth on the groove and the eye, bright and stainless on the surface, take away the unqualified needle as you notice it.

3. Thread

The qualities that a thread requires are not only soft and tight, but also strong and being equal in diameter.

4. Lubrication

Before beginning the work of each day or shift, fill oil into the position as drawing 1. Later on, fill again every two hours. When the day's work is over the accumulation of dust and thread-chip must be cleaned off.

5. Adjustment

This machine had been accurately adjusted and strictly examined before selling and need not be fixed any more. Adjusting can be done according to the direction in chapter D if necessary.

6. Speed

The working speed of these machines is at 800 to 1000 spm generally. Never run the machine at a speed faster than its limit.

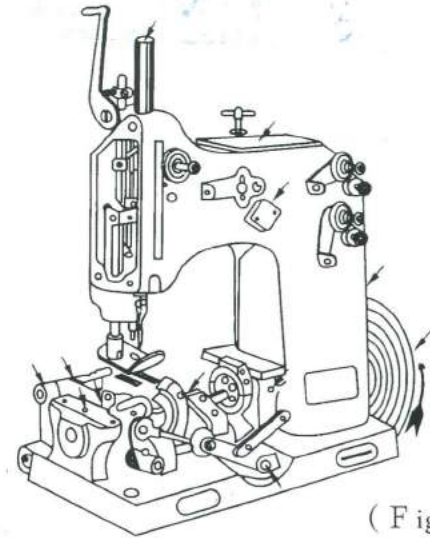
7. Grounding

Make sure the machine should be grounded for safety.

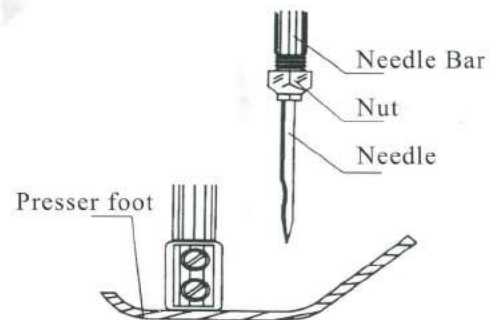
D. Operation and Adjustment

1. Needle setting(see drawing 2)

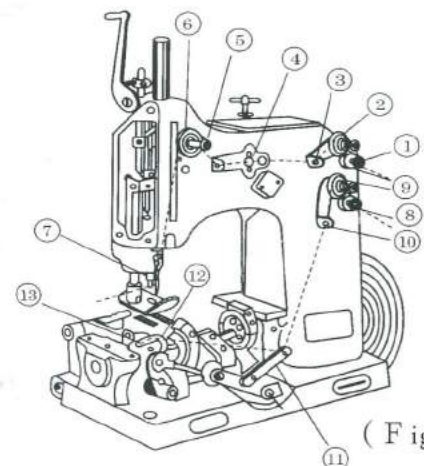
Turn the pulley with hand until the needle bar reaches its highest position. Loosen nut 2, insert the needle into the needle chuck as far as it will go. Be sure that the long groove of needle should face the operator. Then lock nut.



(Fig.1)



(Fig.2)



(Fig.3)

2. Threading (see drawing 3)

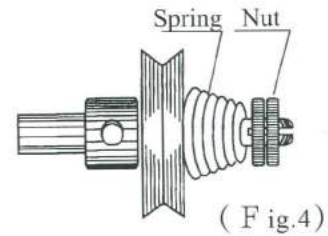
Follow the threading drawing for proper threading. Be sure to thread from the side which has a long groove passes through the needle eye.

3. Tension (see drawing 4)

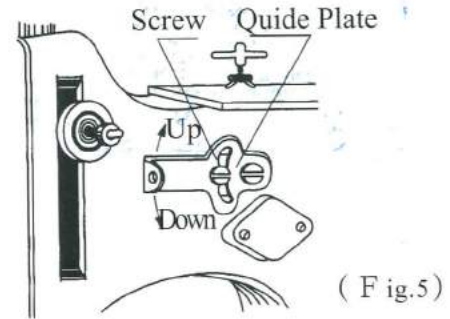
The tension of thread should effect the tightness of stitch, too light tension causes the stitch to loosen and too firm tension causes the stitch without elasticity or even to be snapped.

4. Tension fine-adjustment block (see drawing 5)

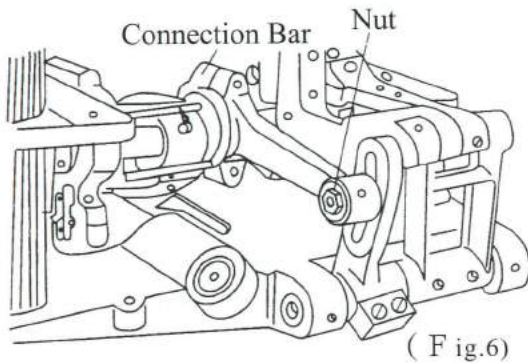
After the thread tension had been adjusted, adjust the tension fine-adjustment block to regulate the tension better, Loosen screw rock the tail of the block to perfection. Then lock screw.



(Fig.4)

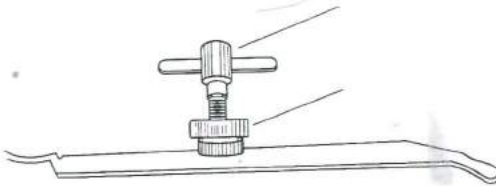


(Fig.5)



(Fig.6)

6. Presser foot (see drawing 7)



(Fig.7)

5. Stitch length (see drawing 6)

The stitch length may be regulated as you like in give range. To regulate the stitch length, turn the pulley to lift the needle bar to its highest position, loosen nut and lift the end of link will decrease the stitch length, lower it will increase the length. Then lock the nut.

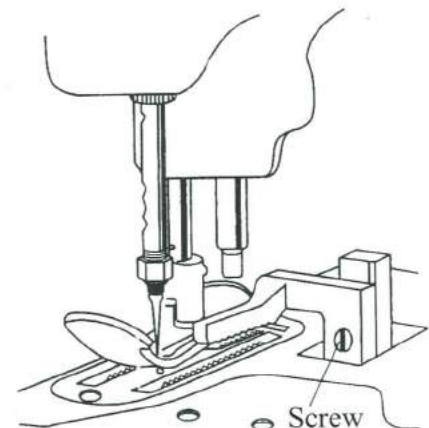
The pressure of presser foot is dependent on the sewing thickness. To adjust it, loosen nut, turn screw clockwise will increase the pressure and counter-clockwise will decrease it.

7. Feed dog teeth

Excessive wear of the feed dog teeth will cause poor feeding. In this case, replacing it is necessary. The teeth of bottom dog should protrude 2 mm above

the throat late when they are at their highest point.

Model GK8-2 and GK8-4 has bottom feed dog and a top feed dog. The top feed dog assembly is as shown in drawing 8. The height of top dog teeth is dependent on the sewing thickness. If the height of top feed dog teeth is too higt, it will be unable to feed the bag to be sewn. If too low, it will bite the bag and damage it. To adjust the height of top feed teeth, loosen the screw1, lift up or push down the dog to the righth height, then lock screw 1. The adjusting of bottom feed dog is the same as that of other models.

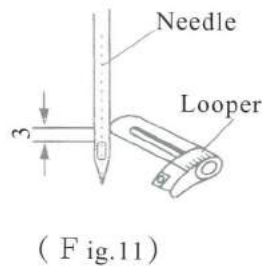
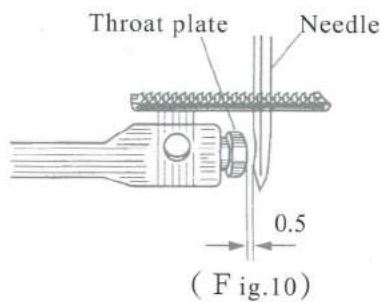


(Fig.8)

8. Needle guards (see drawing 10)

To adjust the seat of needle guard, turn the pulley with hand to lower the needle to its lowest position and adjust the evtended of guard 2 to a gap of some 0.5mm between the needle and the guard. It is unsuitable for the gap to be too large or too small.

9. Needle bar (see drawing 11)



Proper height of the needle bar is that the looper point should be 3mm higher than the upper edge of the needle eye when the looper moves to the center of needle.

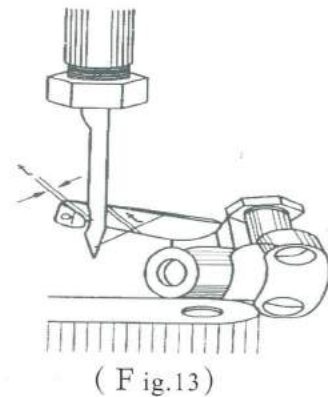
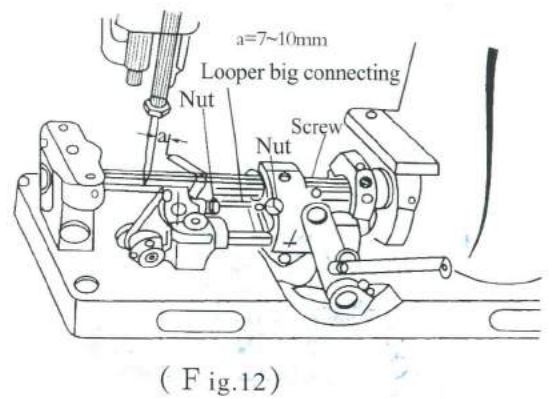
10. Looper (see drawing 12 and 13)

The adjustment of the looper should be done in the direction both horizontally and vertically.

Verticall loosen nut 2 on the both ends of looper rod 1. Move the looper to the position where its point is about 7-10 mm away from the center of the needle, then lock the nut.

Horizontally, loosen the screw of looper rocker, move the looper to the position where the two gaps(t). The front gap and the back gap between the looper and the needle shown in drawing 14, are equal.

The size of the gaps(t) is about the same as the diameter of thread. Remember to set the nut.



E. Skipping stitch

1. Skipping stitch

- Check whether the tension is suitable.
- Check the needle. If it is worn or crooked, replace it.
- Check the throat plate eyelet, if it is worn, replace it.

2. Thread breakage

- Adjust the needle and looper as mentioned above.
- Check whether the tension is proper.
- Check the needle, if it is worn, replace it.

3. Poor feeding

- Check the feed dog teeth, if it is worn, replace it.
- Check whether the pressure of presser foot is proper.

E. Accessories

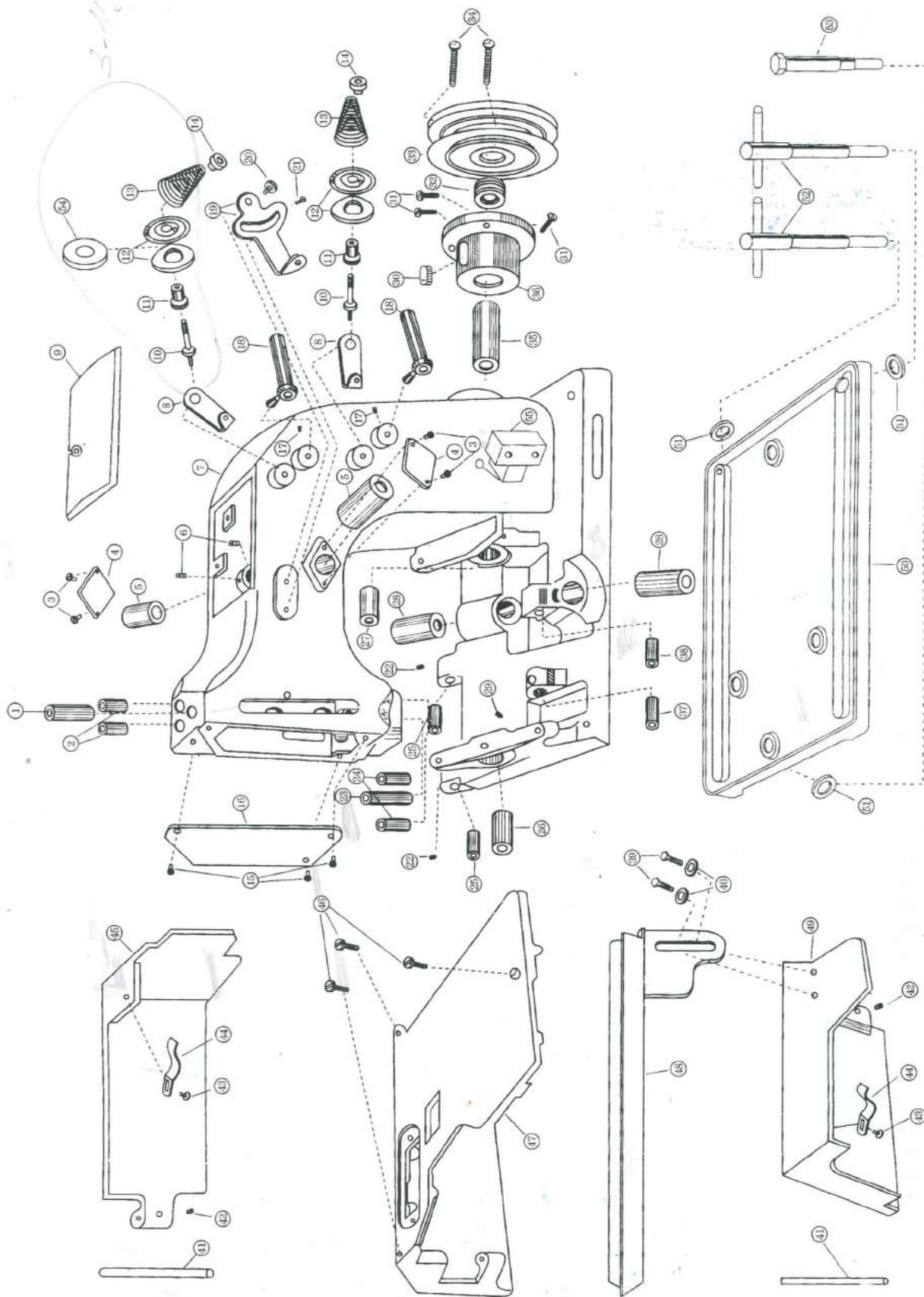
1. Accessories

Item No	Description		Qty	Remarks
1	Double Jawed Wrench 8	10mm	1	
2	Screw Driver 5	65mm	1	
3	Screw Driver 10	150mm	1	
4	Tweezers		1	
5	Oil can		1	

1.Main Frams parts

No.	Part.No.	Description	Qty	Remarks
1	10-20-2-1	Upper bushing of needle bar	1	
2	10-20-4-1	Upper bushing of presser bar	2	
3	10-1-3	Screw	4	
4	3-10	Cover for needle bar rocker	2	
5	10-20-7-1	Bushing fore needle bar rocker	2	
6	10-6-2	Screw	2	
7	2-1	Casting	1	
8	9-8S	Tension disc base	2	Only for GK8-24
	9-8	Frame thread plate	2	
9	9-4	Top cover	1	
10	9-5	Tension Screw	2	
11	3-12S	Tension disc	4	Only for GK8-24
	3-12	Tension roller	2	
12	3-13	Tension disc	4	
13	9-10-1	Tension spring	2	
14	10-16	Tension post	2	
15	10-1-4-1	Frame thread screw	3	
16	9-3	Face plate	1	
17	10-6-10	Screw	2	
18	9-7	Thread guide	2	Only for GK8-24
	9-7S	Thread guide tube	2	
19	9-6	Thread adjusting plate	1	Only for GK8-24
	9-6S	Thread adjusting plate	1	
20	10-8-6	Screw	1	
21	10-1-5	Screw	1	
22	10-6-3	Screw	2	
23	10-20-2-2	Needle bar bushing, lower	1	
24	10-20-5	Presser bar bushing, lower	2	
25	10-20-3	Feed dog support shaft bushing	2	
26	10-20-6	Main shaft front bushing	1	
27	10-20-7-2	Main shaft middle bushing	1	
28	10-20-8	Looper crank shaft bushing	2	
29	10-23-5	Oil felt	1	
30	10-25	Oil felt	1	
31	10-1-5	Screw	3	
32	10-22	Oil ring	1	Only for GK8-24
	10-21	Bearing	1	
33	9-1	Pulley	1	
34	10-6-9	Screw	2	
35	10-20-9	Bushing, rear	1	
36	9-2	Bushing base, rear	1	
37	10-20-4-2	Looper racket bushing, front	1	
38	10-20-4-3	Looper racket bushing, rear	1	
39	10-5-3	Screw	2	Only for GK8-24
40	10-17-10	Washer 8mm	2	Only for GK8-24
41	10-18-2	Hinged cover pin	2	
42	10-6-6	Screw	2	
43	10-1-4	Cover plate spring screw	2	
44	8-5	Hinged cover spring	2	
45	8-3	Hinged cover, rear	1	
46	10-1-8	Screw for cover plate	3	
47	8-1	Cover plate	1	
48	9-11	Wrapped edge device	1	Only for GK8-24
49	8-2	Hinged cover front	1	Only for GK8-24
50	9-9	Oil pan	1	Only for GK8-24
51	10-17-9	Washer	3	Only for GK8-24
52	10-12	Machine head base stud	2	Only for GK8-24
53	11-15-5	Machine head base stud	1	Only for GK8-24
54	3-13-1S	Tension disc washer	2	Only for GK8-24
55	9-7-1S	Frame thread eyelet supprt	1	Only for GK8-24

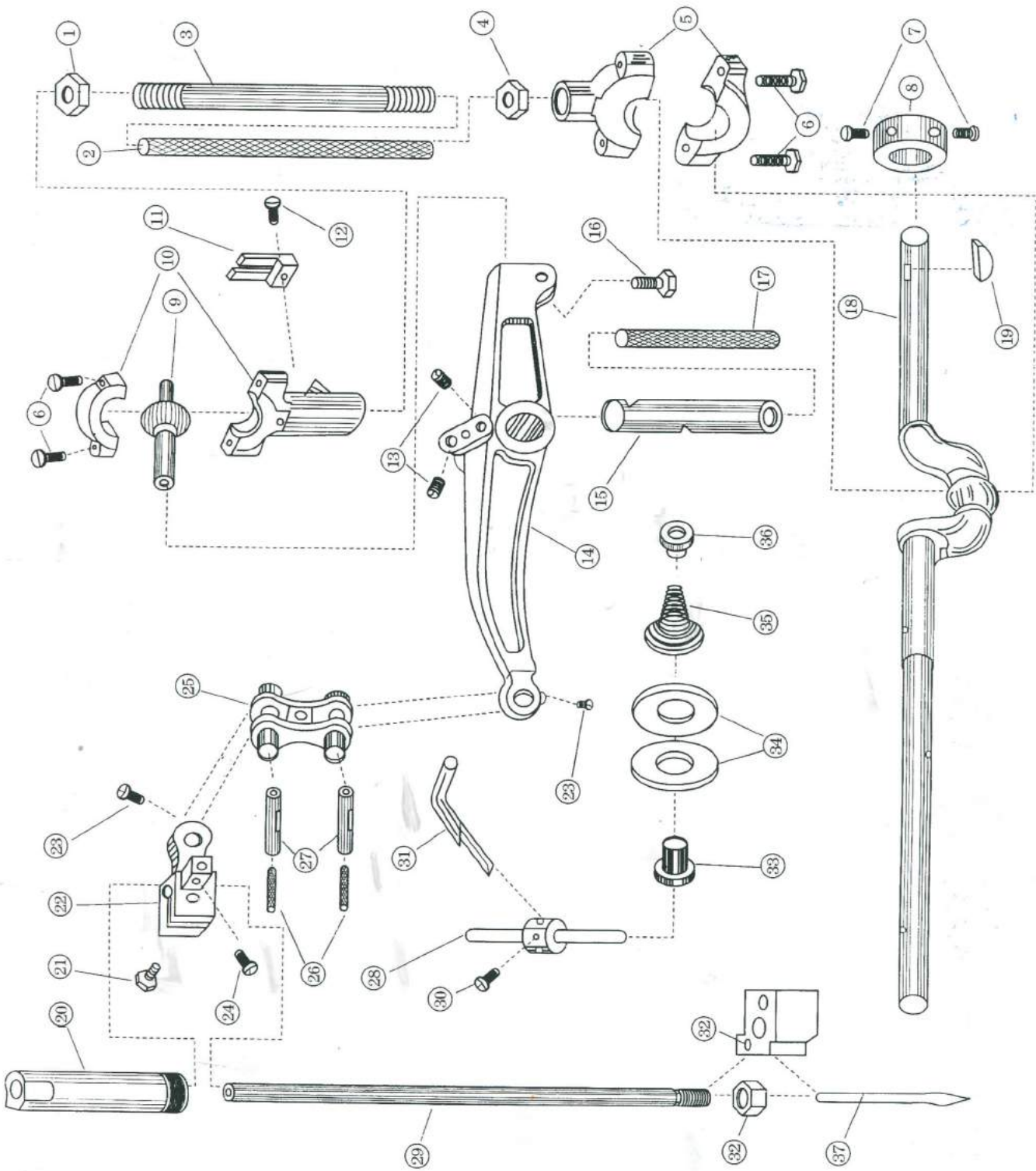
1.Main frame parts



2. Needle bar parts

No.	Part.No.	Description	Qty	Remarks
1	10-13-6-2	Nut	1	
2	10-23-1	Oil felt	1	
3	3-18	Needle bar connecting rod	1	
4	10-13-6-1	Nut	1	
5	3-17	Needle bar connecting rod lower joint	1	
6	10-2-5	Screw	4	
7	10-1-9	Screw	2	
8	10-15-1	Main shaftcollar	1	
9	3-15	Needle bar connecting rod ball stud	1	
10	3-16	Needle bar connecting rod upper joint	1	
11	4-23	Connecting rod guide plate	1	
12	10-1-3	Screw	1	
13	10-6-8	Screw	2	
14	3-8	Needle bar lever	1	
15	3-9	Needle bar lever shaft	1	
16	10-5-2	Screw	1	
17	10-26-1	Oil felt	1	
18	3-19	Main shaft	1	
19	10-19	Woodruff key	1	
20	3-4	Needle bar protection sleeve	1	
21	10-5-1	Screw	1	
22	3-5	Needle bar connecting socket	1	
23	10-1-2	Screw	2	
24	10-1-3	Screw	1	
25	3-6	Needle bar connecting link	1	
26	10-23-6	Oil felt	2	
27	3-7	Needle bar connecting link pin	2	
28	3-11	Needle bar thread retainer shaft	1	
29	3-2	Needle bar	1	
	3-2S	Needle bar		Only for GK8-24
30	10-1-1	Screw	1	
31	3-14	Thread hold bar	1	
32	3-3	Needle clamping nut	1	
	3-2-1S	Needle base	1	Only for GK8-24
33	3-12	Thread retainer plate roller	1	
34	3-13	Needle bar thread retainer plate	2	
35	9-10-2	Needle bar thread retainer spring	1	
36	10-16	Nut	1	
37	3-1-3	Needle 29#	1	
	Or 3-1-2	Needle 26#	1	Only for GK8-24

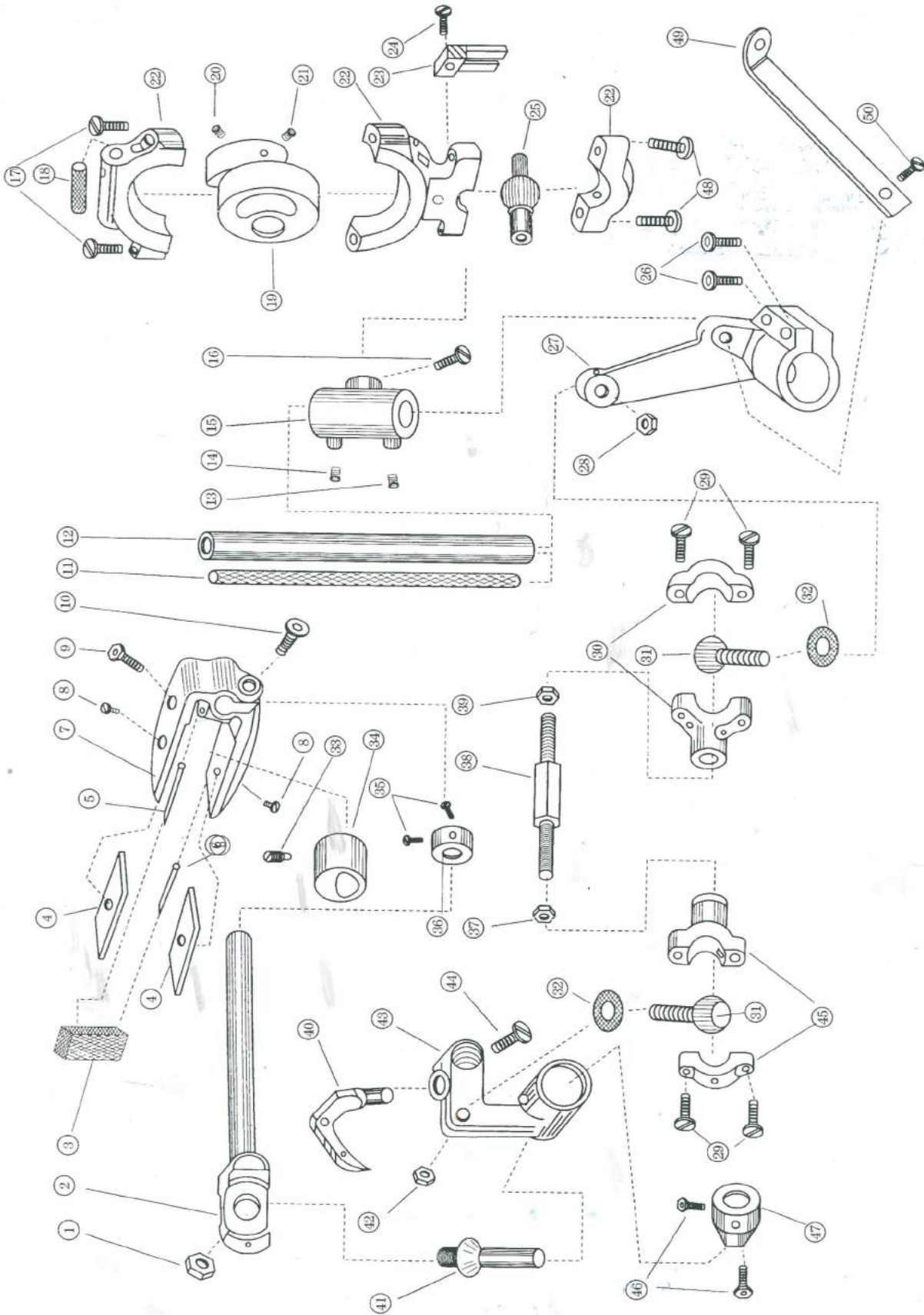
2. Needle bar parts



3. Looper driving parts

No.	Part.No.	Description	Qty	Remarks
1	10-13-5	Nut	1	
2	4-4	Looper bracket shaft	1	Only for GK8-24
	4-4S	Looper bracket shaft	1	
3	4-13	Oil felt	1	
4	4-12	Looper small eccentric sliding plant	2	
5	4-15-1-2	Oil felt nail	1	
6	4-15-1-1	Oil felt nail	1	
7	4-14	Looper rocker fork	1	
8	10-1-1	Screw	2	
9	10-1-6-2	Screw	1	
10	10-1-6-3	Screw	1	
11	10-26-3	Oil felt	1	
12	4-21	Looper crank fork	1	
13	10-7-5	Positioning screw	1	
14	10-6-7	Screw	1	
15	4-19	Looper inner crank	1	
16	4-1-5	Screw	1	
17	10-2-3	Screw	2	
18	10-23-4	Oil felt	1	
19	4-17	Looper big eccentric	1	
20	10-7-3	Positioning screw	1	
21	10-6-5	Screw	1	
22	4-16	Looper connecting rod	1	
23	4-23	Looper connecting rod guide plate	1	
24	10-1-3	Screw	1	
25	4-18	Looper ball stud	1	
26	10-1-6-1	Screw	2	
27	4-20	Looper outer crank	1	
28	10-13-3	Nut	1	
29	10-2-1	Screw	4	
30	4-7A	Looper connecting link, right	1	
31	4-9	Screw	2	
32	4-10	Oil felt	2	
33	10-7-4	Positioning screw	1	
34	4-11-2	Looper small eccentric	1	
35	10-1-1	Screw	2	
36	10-15-1	Looper bracket shaft collar	1	
37	10-13-4-1	Nut	1	
38	4-8	Looper screw-bar	1	
39	10-13-4	Nut	1	
40	4-2	Double-thread looper	1	Only for GK8-24
	4-2S	Looper	1	
41	4-5	Looper bracket conical shaft	1	Only for GK8-24
	4-5S	Looper bracket pin	1	
42	10-13-3	Nut	1	
43	4-3	Looper bracket	1	Only for GK8-24
	4-3S	Looper bracket	1	
44	10-1-9	Screw	1	
45	4-7B	Looper connecting link, left	1	
46	10-5-5	Screw	2	
47	4-6	Looper bracket conical shaft collar	1	Only for GK8-24
	4-6S	Looper bracket ring	1	
48	10-2-2	Screw	2	
49	4-22S	Thread take-up lever	1	Only for GK8-24
	4-22	Thread take-up lever	1	
50	10-1-4	Screw	1	

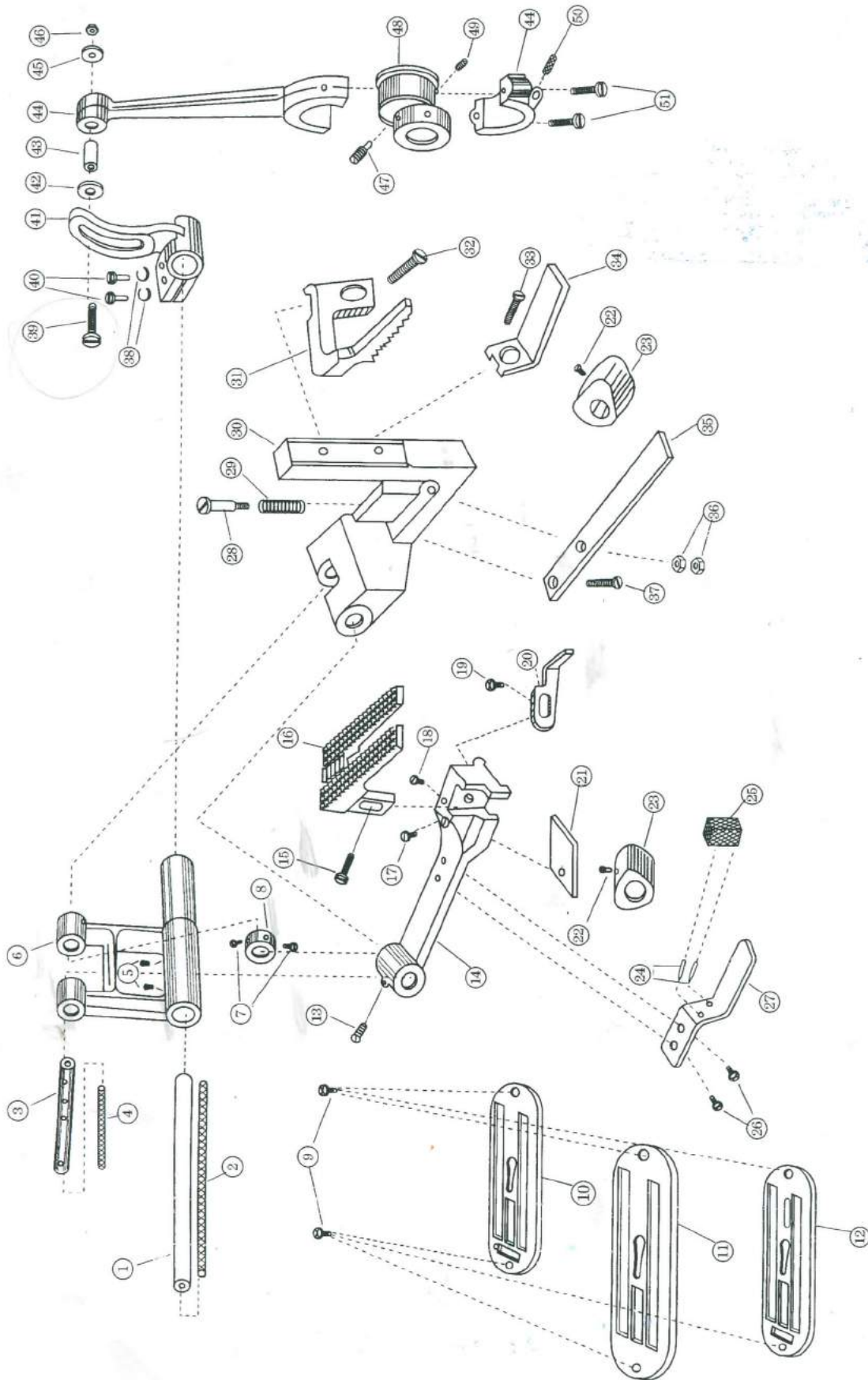
3. Looper driving parts



4.Feed driving parts

No.	Part.No.	Description	Qty	Remarks
1	5-10	Bottom feed dog carrier shaft	1	
2	10-26-5	Oil felt	1	
3	5-9	Top feed dog carrier shaft	1	
4	10-26-4	Oil felt	1	
5	10-6-1	Screw	2	
6	5-11	Feed dog carrier base	1	
7	10-1-1	Screw	2	
8	10-15-1	Feed dog carrier collar	1	
9	10-3	Screw	2	
10	5-2-1	Throat plate	1	
11	5-2	Throat plate	1	
12	5-2S	Throat plate	1	
13	10-6-3	Screw	1	
14	5-5	Feed dog carrier	1	
15	10-1-7	Screw	1	
16	5-4	Feed dog	1	
17	10-1-3	Screw	1	
18	10-1-3	Screw	1	
19	10-1-4	Screw	1	
20	5-20	Needle guard	1	
21	5-7	Feed dog carrier slide plate	1	
22	10-7-1	Setscrew	2	
23	5-15	Feed bar lifting cam	2	
24	4-15-1	Oil felt nail	2	
25	5-8	Oil felt	1	
26	10-1-3	Screw	2	
27	5-6	Feed dog carrier plate	1	
28	10-4	Screw	1	
29	10-27-3	Spring	1	
30	5-17	Top feed bar	1	
31	5-16	Top feed dog	1	
32	10-1-7	Feed dog screw	1	
33	10-1-5	Screw	1	
34	5-19	Top feed bar sliding block	1	
35	5-18	Top feed bar carrier plate	1	
36	10-13-2	Screw and nut	2	
37	10-1-5	Screw	1	
38	10-33-1	Spring washer 6min	2	
39	10-10	Stitch adjusting screw	1	
40	10-5-4	Screw	2	
41	5-12	Stitch adjusting block	1	
42	10-17-1-2	Washer	1	
43	10-20-1-2	Feed connecting link bushing	1	
44	5-13	Feed connecting link	1	
45	10-17-1-1	Washer	1	
46	10-13-4	Stitch adjusting nut	1	
47	10-7-2	Feed eccentric positioning screw	1	
48	5-14-9	Feed eccentric	1	
49	10-6-4	Screw	1	
50	10-23-3	Oil felt	1	
51	10-2-4	Screw	2	

4.Feed driving parts



5.Presser foot parts

No.	Part.No.	Description	Qty	Remarks
1	6-10	Presser foot lifter	1	
2	10-8-4	Screw	1	
3	6-7	Presser bar	2	
4	6-12-2	Presser bar lifting bracket(short)	1	
5	10-15-1	Presser bar collar	2	
6	10-1-1	Set screw	4	
7	10-1-7	Screw	1	
8	10-1-4	Screw	2	
9	10-1-4	Screw	2	
10	10-1-4	Screw	2	
11	6-8	Presser bar guide	1	
12	6-9	Presser bar guide block	1	
13	6-12-1	Presser bar lifting bracket(long)	1	
14	10-1-4	Screw	2	
15	10-1-1	Screw	4	
16	6-3	Presser foot shank	1	
17	10-8-3	Screw	1	
18	6-2-1	Presser foot, right	1	
19	6-2	Presser foot, left	1	
20	6-1	Presser foot	1	
21	6-2S	Presser foot	1	
22	10-8-5	Screw	1	
23	6-15	Presser foot lifter lever	1	
24	6-16	Presser foot lifter lever tortion spring	1	
25	10-11	Presser adjusting screw	1	
26	10-14	Presser adjusting nut	1	
27	10-18-1	Presser foot spring positioning pin	1	
28	6-13	Presser bar upper plate spring	2	
29	6-14	Presser bar lower plate spring	2	

5.Presser foot parts

