



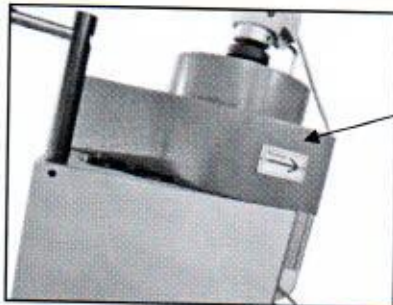
SM 7900 ES STITCHING MACHINE FOR SHOES



OPERATING INSTRUCTION MANUAL

Rev 201501

Thank you very much for your choice of this double thread side seam sewing machine. Please read the manual carefully before use!



Ensure that the rotation of the pulley conformable to the red allow on the belt cover !

Notice: Replace or installation motor belt should pay attention and v-belts cannot be adjusted too tight, synchronous belt cannot be adjusted too loose!



The machine has passed CE !

Main Warnings:

- ♥It is extremely important that the electrical device must be soundly earthed!
- ♥It is absolutely forbidden to remove any protection system provided by manufacturer while machine is on!
- ♥All setting and replacement operation must be carried out only by the qualified expert personnell!
- ♥For repairs, all tools and replacement parts must be qualified by manufacturer!
- ♥Whenever, and whatever reason, the machine is to be demolished, certain basic rules must be observed to safeguard public health and the environment in which we live!

CONTENTS

1. MACHINE DESCRIPTION	1
2. TECHNICAL FEATURES OF THE MACHINE	1
3. USE OF THE MACHINE	1
3.1 Compressed air supply connection	1
3.2 Start pedal	2
3.3 Needle thread preparation	2
3.4 Tension adjustment setting of needle thread	2
3.5 Stitch length adjustment setting	3
4. REPLACEMENT AND ADJUSTMENT OPERATION	3
4.1 Needle replacement	3
Attachment: Parts Drawings	4

Thank you very much for choosing our machine. Please read the instruction book carefully before use!

1. MACHINE DESCRIPTION

Mod.350 stitching machine for shoes, this machine is specially designed for “espadrillas” type of shoes. This machines can be fitted with “Arm-A” and “Arm-B”, “Arm-A” is suitable for sewing flat-bottomed shoes, and “Arm-B” is suitable for wedge shoes.

The machine is driven by the servo motor; the sewing speed can be changed stepless. The stop position of the machine is controlled by computer of the motor

2. TECHNICAL FEATURES OF THE MACHINE

Max sewing speed:	<400 RPM
Stitch length:	4-10mm
Needle system:	GB200 curved needle
Motor:	750W / 220V single-phase
Net weight:	128kg (N.W.)
Machine dimensions:	96cm×65cm×150cm (L.×W.×H.)

3. USE OF THE MACHINE

3.1 Compressed air supply connection (Fig.1)

The compress air system is connected to compressed air supply by air tube 1. Put the air tube 1 into the adapter 2 on the FRL unit. The value of the air pressure supply to the machine can be set by the knob 3 on the FRL unit. The value of the set pressure is visible on the pressure gauge dial.

Warning: Pressure to be set for this machine – 3bar.

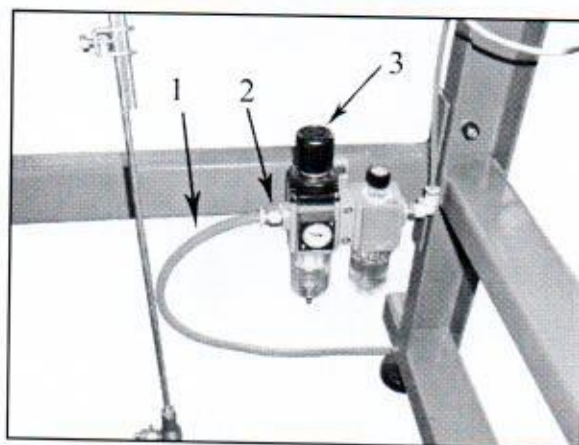


Fig.1

3.2 Start pedal (Fig.2)

First of all, switch on the main switch of the machine to check if the rotation of the motor conformable to the red arrow on the belt cover. Then operate the start pedal in three different movements. (Fig.2)

- Pressing forward (direction A) means advance. Pressing lightly is slow and pressing strongly is fast. Avoid pressing very strongly at the beginning.
- Stop in the neutral position.
- Pressing backward (direction B) means move the transport roller down.

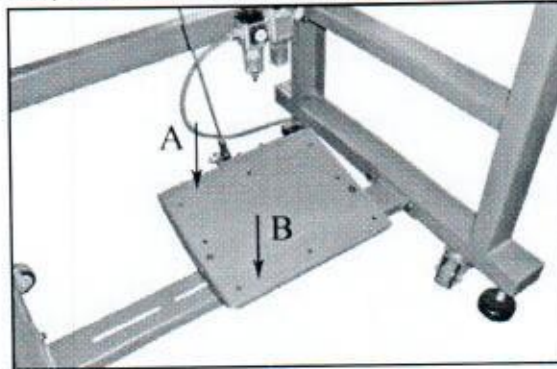


Fig.2

3.3 Needle thread preparation (Fig.3)

To prepare the needle thread, proceed as follows:

- Turn the pulley in the correct direction so that the needle comes to its highest position.
 - Threading the needle thread by the path indicated in Fig.3
- (1) Threading ring (2) Threading rod (3) Tightener 1 (4) Threading rod (5) Tightener 2 (6) Threading carrier (7) Threading wheel (8) Thread take-up spring (9) Thread take-up lever (10) Threading block (11) Threading hole of needle holder (12) Needle

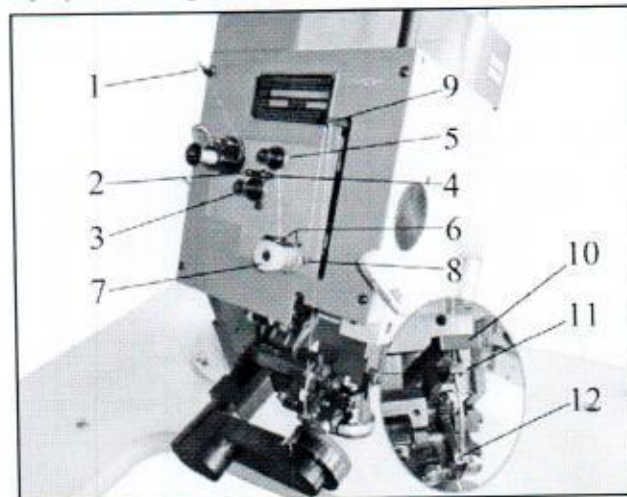


Fig.3

3.4 Tension adjustment setting of the needle thread (Fig.3)

Needle thread tension can be adjusted by turning Tightener 1 and Tightener 2. (Fig.3)

3.5 Stitch length adjustment setting (Fig.4)

The machine is designed to permit stitch lengths between a minimum of 4mm and a maximum of 10mm. To adjust the stitch length, proceed as follows: (Fig.4)

- Loosen the nut 1 on the back of the machine.
- Move the head of connecting rod to the left direction means decrease the stitch length, and move it to the right direction means increase the stitch length. (as shown in Fig.4)
- Tighten the nut 1 after adjusting.

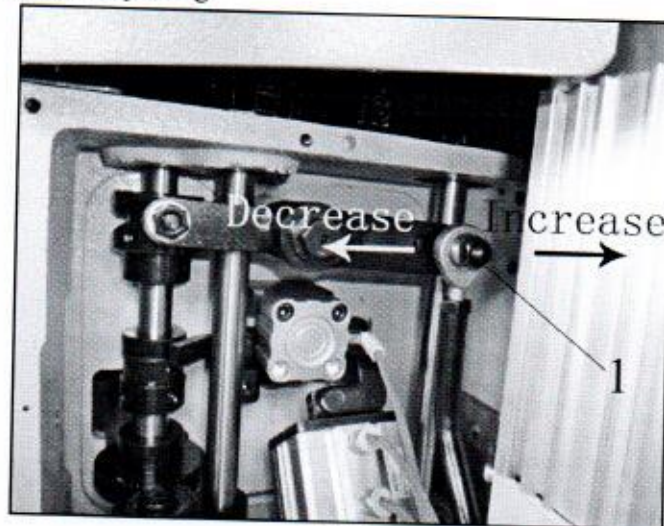


Fig.4

4. REPLACEMENT AND ADJUSTMENT OPERATION

4.1 Needle replacement (Fig.5)

To replace the needle, proceed as follows:

- Unscrew the two fixing screws 1, and then remove the needle clamp 2.
- Put the needle 3 into the arc groove on needle holder 4, it needs to special attention that the gap of needle 3 must level with the gap of the needle holder 4.
- Tighten the needle clamp 2 at last.

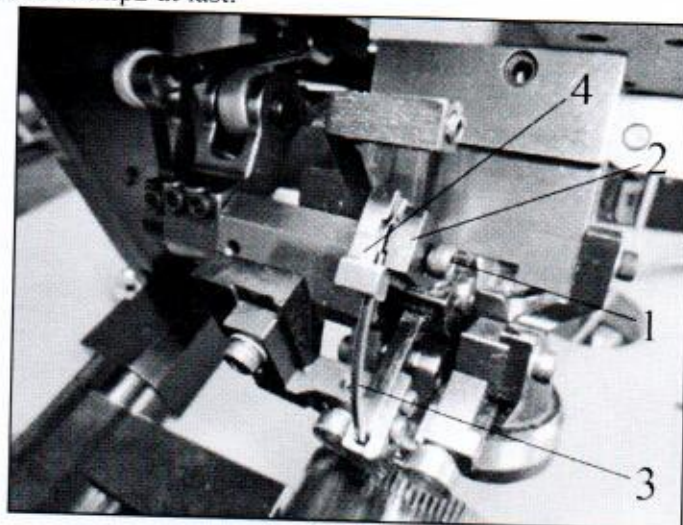


Fig.5

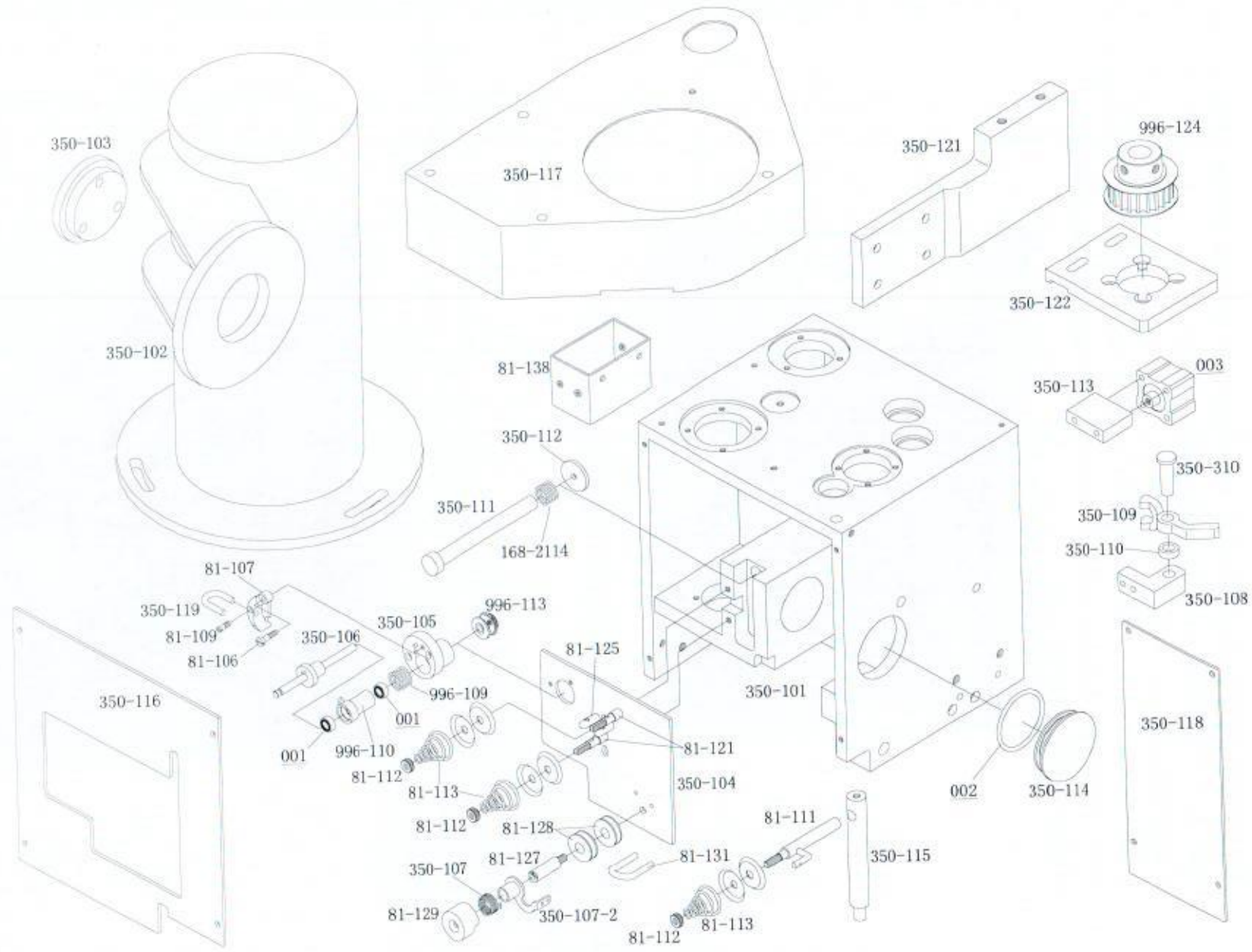


Fig. No.	Part's name	Quantity
350-101	Frame	1
350-102	Machine body stand	1
350-103	Fixed cover	1
350-104	Threading plate	1
350-105	Bracket of bobbin winding	1
350-106	Wind bobbin spindle	1
350-107	Torsion spring	1
350-107-2	Thread take-up piece	1
350-108	Bracket	1
350-109	Rocker for loosen thread	1
350-110	Washer	1
350-111	Thread loosen stem	1
350-112	Washer	1
350-113	Cylinder base	1
350-114	Capping plug	1
350-115	Pole	1
350-116	Front frame cover	1
350-117	Belt cover	1
350-118	Back frame cover	1
350-119	Cutting lever	1
350-121	Bracket	1
350-122	Base plate for motor	1
81-106	Screwing pin	1
81-107	Stopper	1
81-109	Screw	1
81-111	Winding amount adjusting rod	1
81-112	Winding amount adjusting nut	3
81-113	Cone spring	3
81-121	Rod of thread tighter(long)	2
81-125	Thread guider rod(long)	2
81-127	Thread take-up spring shaft	1
81-128	Threading wheel	2
81-129	Cover	1
81-131	Threading carrier	1
81-138	Oil box	1
996-109	Spring	1
996-110	Casing	1
996-113	Bevel gear	1
996-124	Belt wheel for motor	1
168-2114	Spring	1
001	Bearing (628/6)	2
002	Obturator ring $\Phi 50 \times 3.55$	1
003	Cylinder ACQ25 \times 5	1

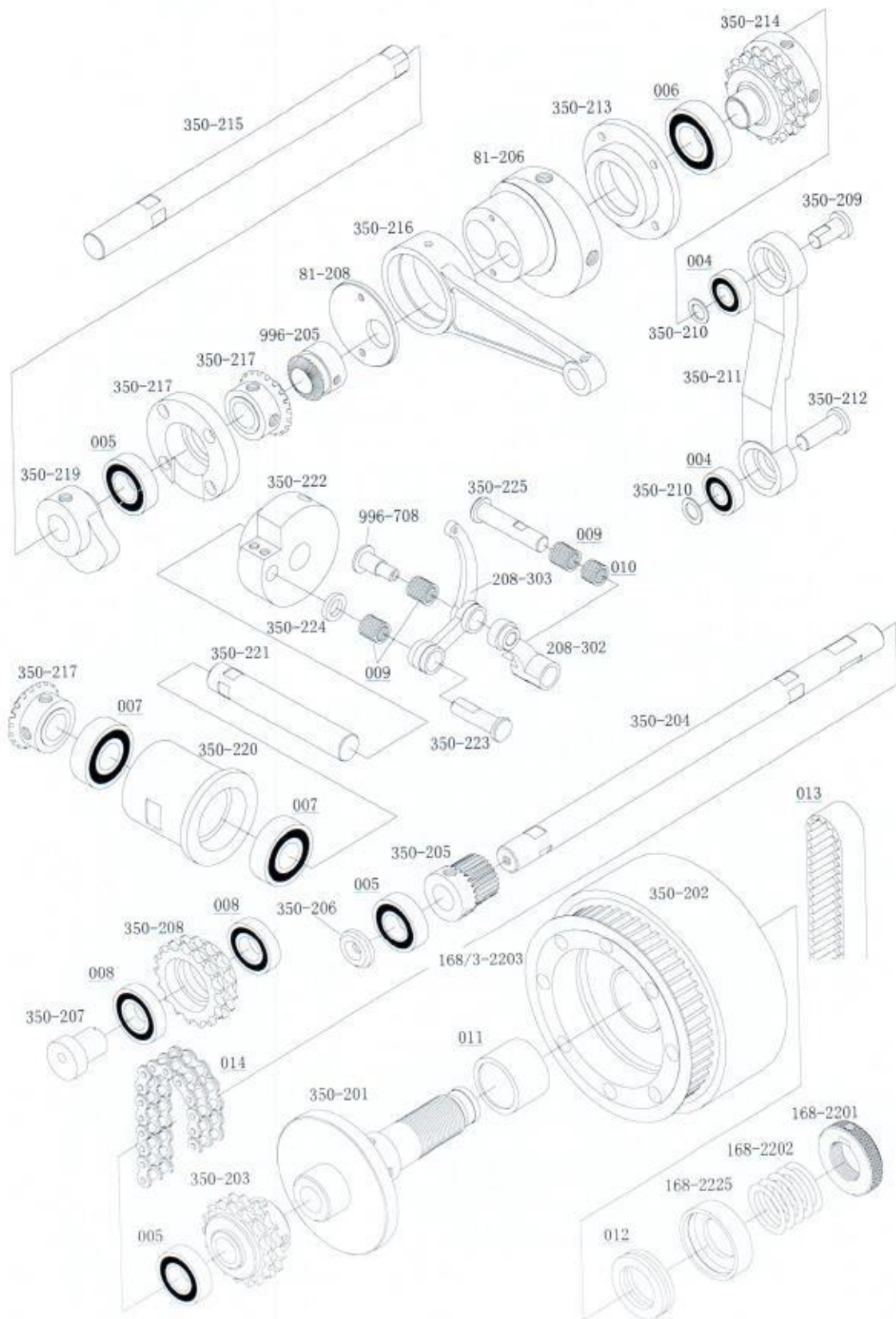


Fig. No.	Part's name	Quantity
350-201	Clutch sleeve	1
350-202	Hand wheel	1
350-203	Sprocket wheel	1
350-204	Main shaft	1
350-205	Gear	1
350-206	Washer	1
350-207	Eccentric rod	1
350-208	Sprocket wheel	1
350-209	Pin	1
350-210	Washer	2
350-211	Connecting lever	1
350-212	Pin	1
350-213	Bearing casing	1
350-214	Sprocket wheel	1
350-215	Shaft	1
350-216	Connecting lever	1
350-217	Spiral bevel gear	2
350-218	Bearing casing	1
350-219	Cam	1
350-220	Bearing casing	1
350-221	Shaft	1
350-222	Crank	1
350-223	Pin	1
350-224	Washer	2
350-225	Pin	1
81-206	Eccentric cam	1
81-208	Cover plate	1
168-2201	Round nut	1
168-2202	Spring	1
168-2225	Bearing protect circle	1
168/3-2203-2	Synchronous belt wheel	1
208-302	Connecting lever	1
208-303	Thread take-up lever	1
996-205	Bevel gear	1
996-708	Pin	1
004	Bearing (6000)	2
005	Bearing (6003)	3
006	Bearing (6004)	1
007	Bearing (6203)	2
008	Bearing (16003)	2
009	Needle roller bearing (K10×13×13)	3
010	Needle roller bearing (K10×13×10)	1
011	Needle roller bearing (HK3026)	1
012	Thrust bearing (51105)	1
013	Synchronous belt (8M×656×20)	1
014	Double chain (06B-2×50)	1

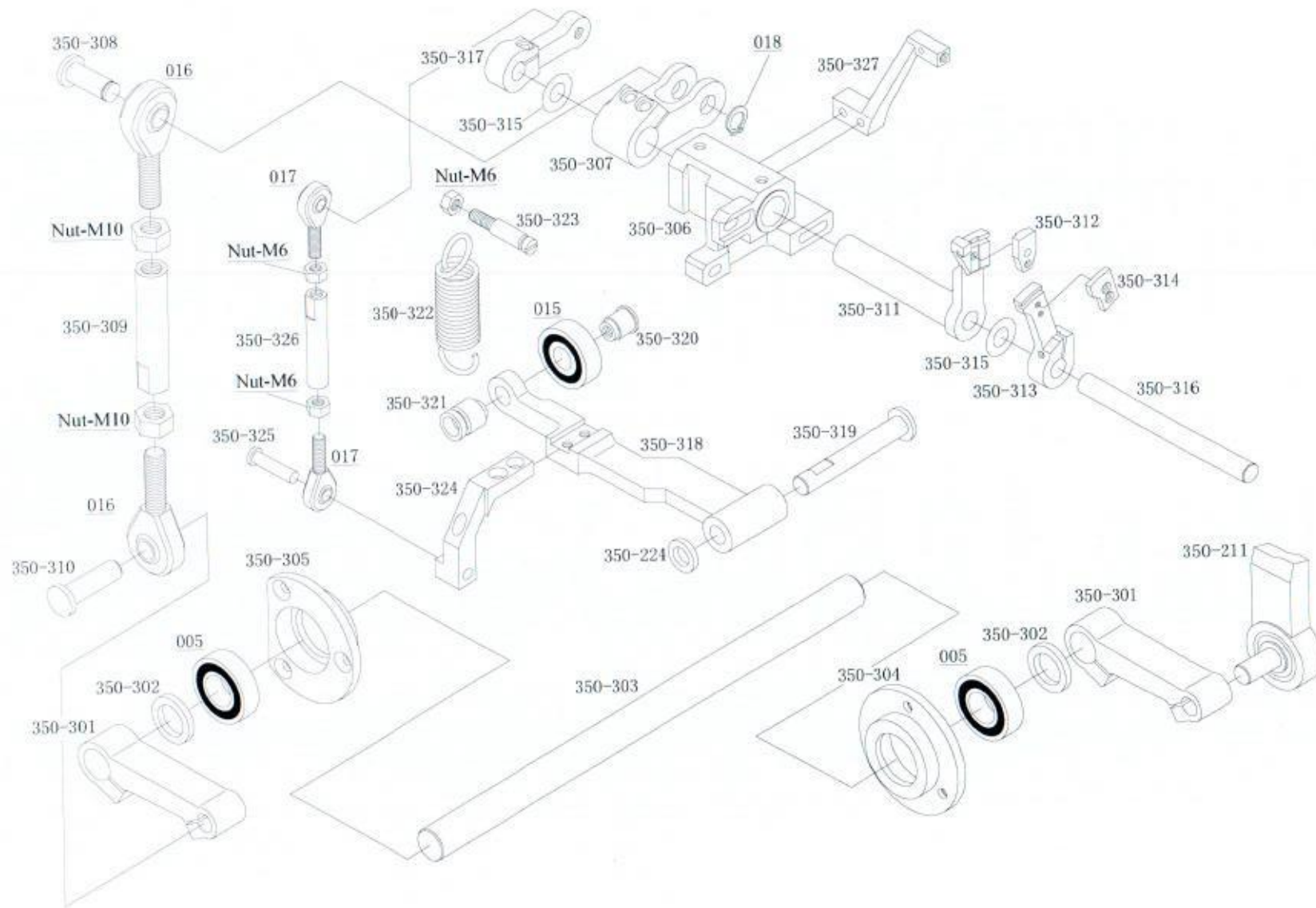


Fig. No.	Part's name	Quantity
350-301	Rocker	2
350-302	Washer	2
350-303	Shaft	1
350-304	Bearing casing	1
350-305	Bearing casing	1
350-306	Bracket	1
350-307	Rocker	1
350-308	Pin	1
350-309	Connecting rod	1
350-310	Pin	2
350-311	Needle holder	1
350-312	Needle clamp	1
350-313	Needle guider	1
350-314	Cover plate	1
350-315	Washer	2
350-316	Shaft	1
350-317	Rocker	1
350-318	Rocker	1
350-319	Pin	1
350-320	Bearing rod	1
350-321	Pin	1
350-322	Spring	1
350-323	Screw for spring	1
350-324	Connecting block	1
350-325	Pin	1
350-326	Connecting rod	1
350-327	Threading block	1
<u>005</u>	Bearing (6003)	2
<u>015</u>	Bearing (6201)	1
<u>016</u>	Rod end joint bearing (SA10)	2
<u>017</u>	Rod end joint bearing (SA6)	2
<u>018</u>	Lock ring for shaft (Φ10)	1

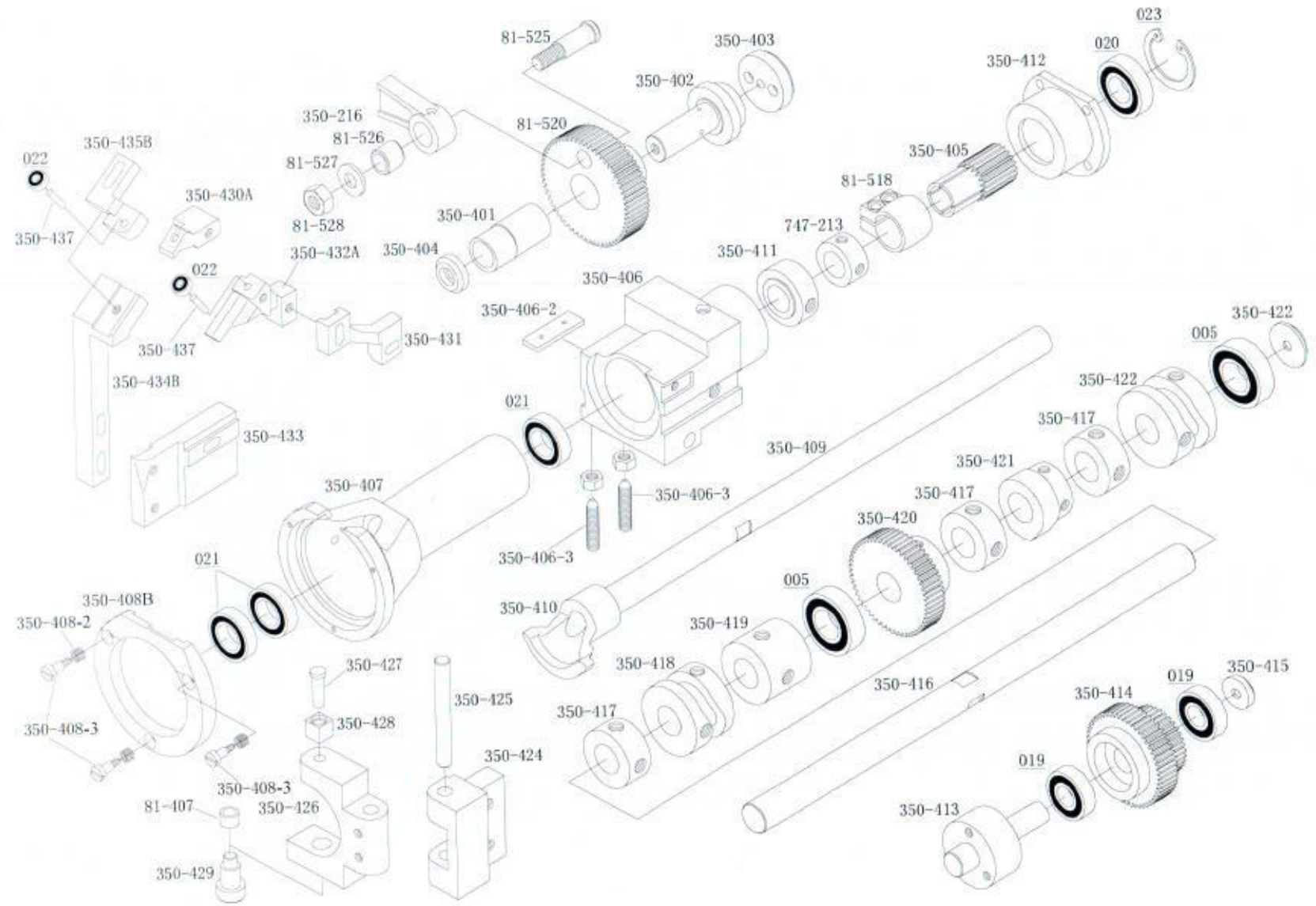


Fig. No.	Part's name	Quantity
350-401	Sleeve for crank gear	1
350-402	Eccentric rod for crank gear	1
350-403	Fixing board	1
350-404	Washer	1
350-405	Gear	1
350-406	Bracket	1
350-406-2	Padding	1
350-406-3	Screw	1
350-407	Shuttle holder	1
350-408B	Cover ring	1
350-408-2	Spring	3
350-408-3	Screw	3
350-409	Shaft for shuttle driver	1
350-410	Shuttle driver	1
350-411	Washer	1
350-412	Bearing casing	1
350-413	Rod for gear	1
350-414	Gear	1
350-415	Washer	1
350-416	Shaft	1
350-417	Thrust ring	3
350-418	Cam	1
350-419	Thrust ring	1
350-420	Gear	1
350-421	Cam	1
350-422	Cam	1
350-423	Washer	1
350-424	Bracket	1
350-425	Pin	1
350-426	Rocker	1
350-427	Pin	1
350-428	Slider	1
350-429	Pin	1
350-430A	Needle plate	1
350-431	Holder for right guider	1
350-432A	Right guider	1
350-433	Bracket	1
350-434B	Holder for left guider	1
350-435B	Left guider	1
350-437	Pin	2
81-407	Roller	1
81-518	Gripper sleeve	1
81-520	Gear	1
81-525	Screw	1
81-526	Sleeve	1
81-527	Washer	1
81-528	Nut	1
747-213	Thrust ring	1
005	Bearing (6003)	2
019	Bearing (6001)	2
020	Bearing (6002)	1
021	Bearing (61902)	3
022	Bearing (624)	2
023	Lock ring for hole (Φ32)	1

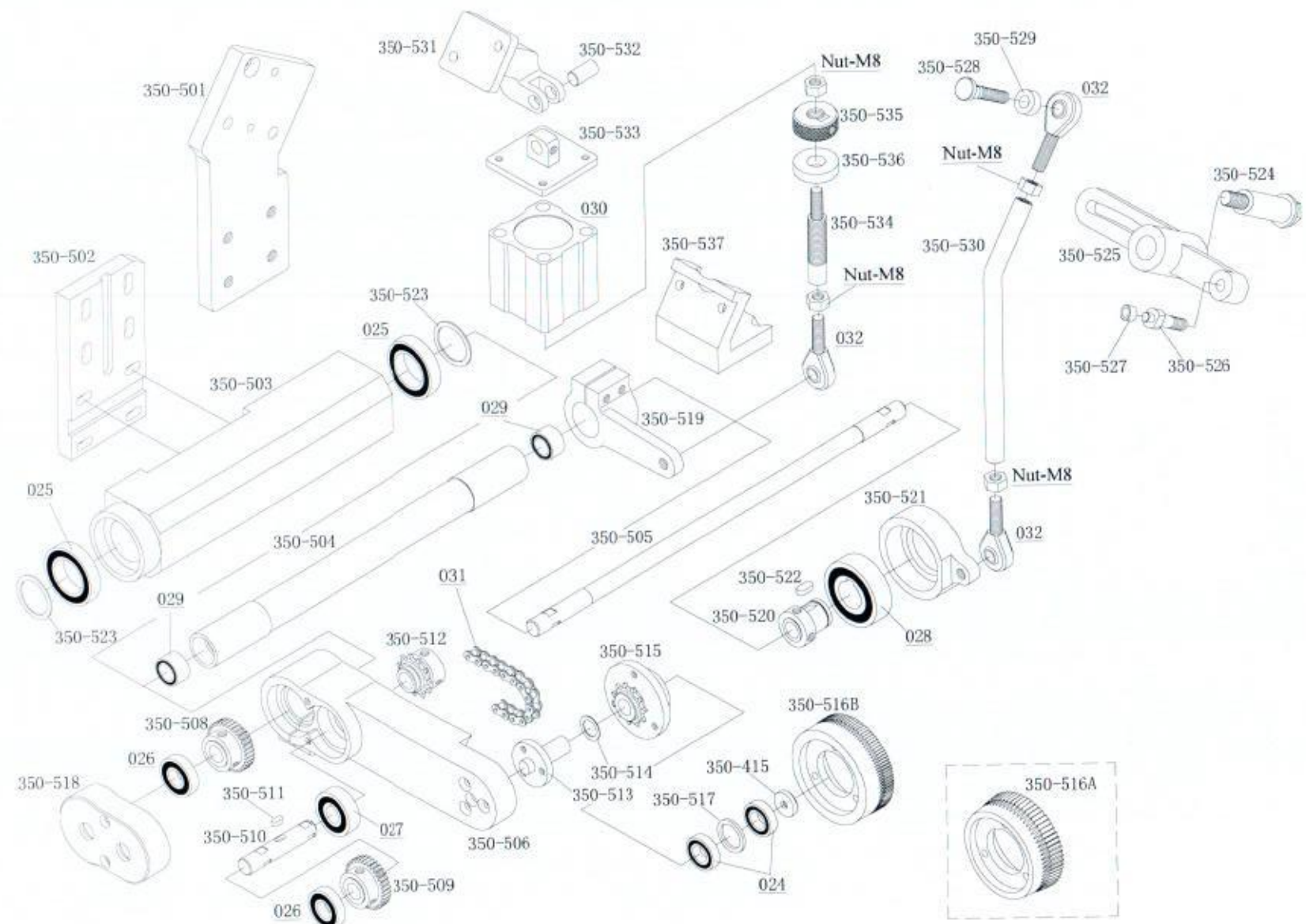


Fig. No.	Part's name	Quantity
350-501	Bracket	1
350-502	Fixing plate	1
350-503	Holder for arm	1
350-504	Hollow shaft	1
350-505	Shaft	1
350-506	Arm	1
350-508	Gear	1
350-509	Gear	1
350-510	Short shaft	1
350-511	Flat key	1
350-512	Sprocket wheel	1
350-513	Rod for sprocket wheel	1
350-514	Washer	1
350-515	Sprocket wheel	1
350-516A/B	Transport wheel	1/1
350-517	Washer	1
350-518	Cover	1
350-519	Rocker	1
350-520	Sleeve	1
350-521	Transport crank	1
350-522	Flat key	1
350-523	Washer	2
350-524	Screw	1
350-525	Rocker	1
350-526	Pin	1
350-527	Roller	1
350-528	Pin	1
350-529	Washer	1
350-530	Connecting rod	1
350-531	Bracket	1
350-532	Pin	1
350-533	Holder for cylinder	1
350-534	Connecting rod	1
350-535	Round nut	1
350-536	Washer	1
350-537	Dead block	1
350-415	Washer	1
024	Bearing (61901)	2
025	Bearing (61905)	2
026	Bearing (16001)	2
027	Single direction bearing (CSK12P)	1
028	Single direction bearing (CSK20P)	1
029	Roller bearing (RNA49/9)	2
030	Cylinder (ACQ40×15)	1
031	Chain (05B-1×42)	1
032	Rod end joint bearing (SA8)	3