



GLOBAL

WF 9221-76

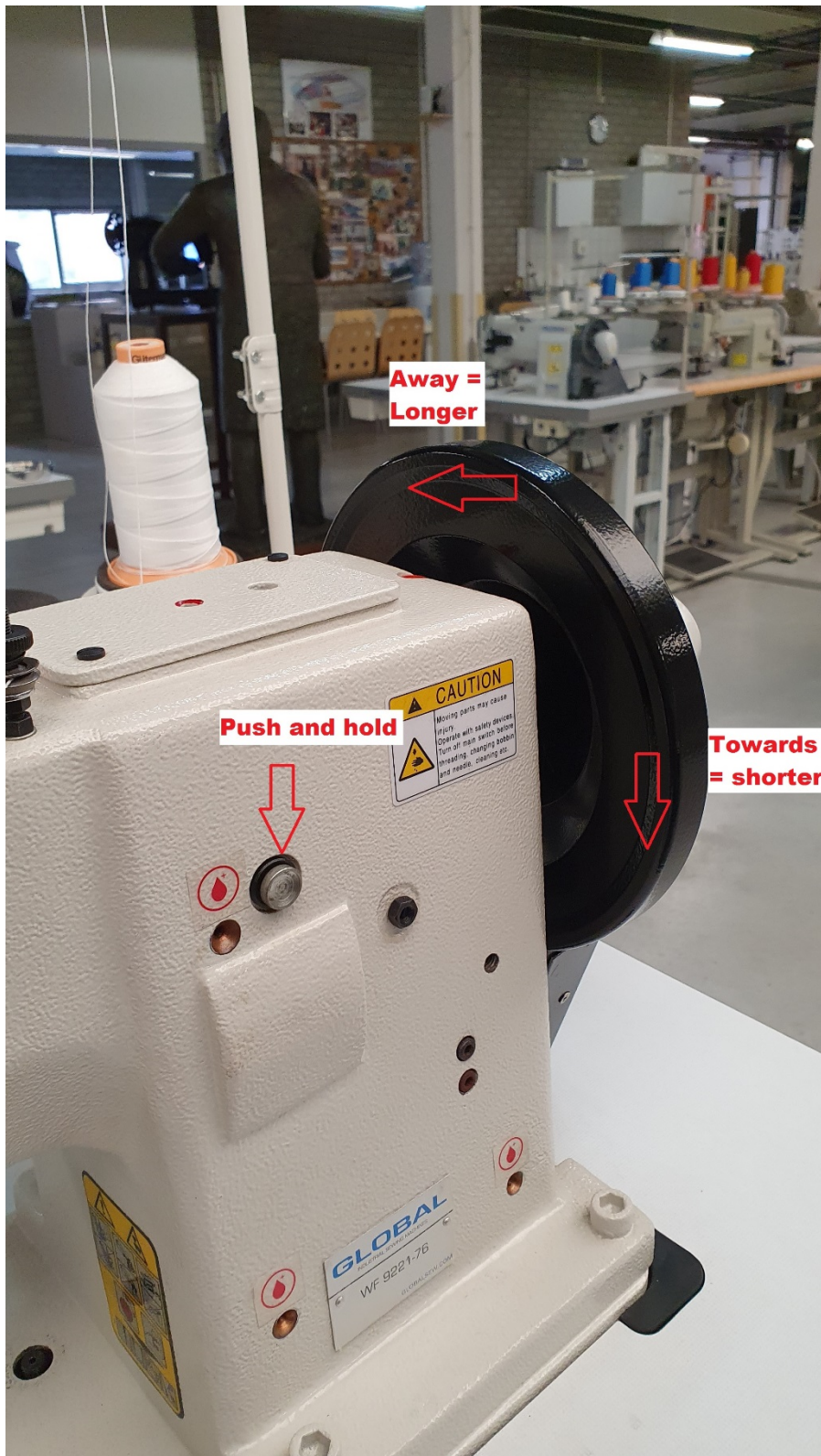
Instruction manual

Technical Data

Machine subclass:		Global WF 9221-76	Global WF 9221-2-76
Needle system	:	DY x 23	DY x 23
Needle size (standard)	:	230	230
Max. PFL lift	:	20mm	20mm
Max. stitch length	:	10mm	10mm
Standard needle gauge	:	X	18mm
Needle gauge available	:	X	8 / 9,5 / 12,7 / 15,9 / 25,4 / 44,5mm
Working space	:	760mm	760mm
Back Tack (standard)	:	Pneumatic	Pneumatic
Presserfootlifter (standard)	:	Pneumatic	Pneumatic

Adjusting the stitch length

- Push and hold button shown on picture, turn handwheel until you feel button lock-in.
- Hold in the button, turning the hand wheel away from you will make the stitch length longer and turning the hand wheel towards you will make the stitch length shorter (see below).



Adjusting the rocker

- With the stitch length being set for 0 with the needle at the lowest position, the feeding foot bar should be distanced 14,5mm from the presser foot bar (see picture below).

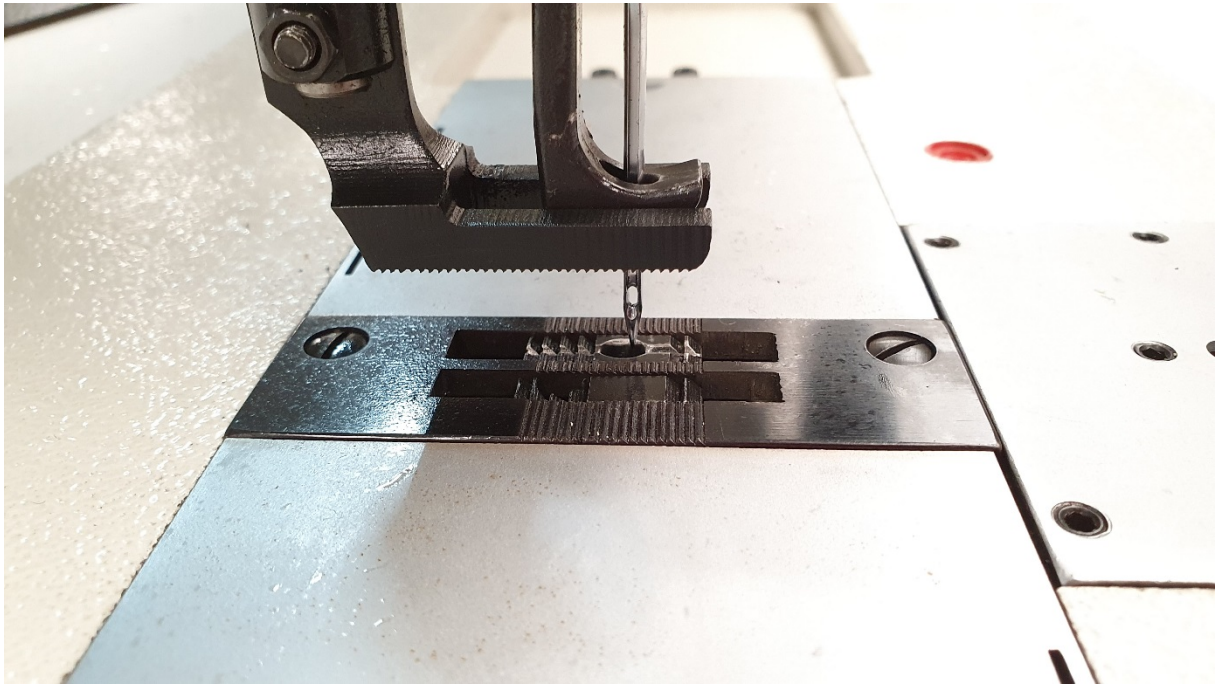


Feed dog height

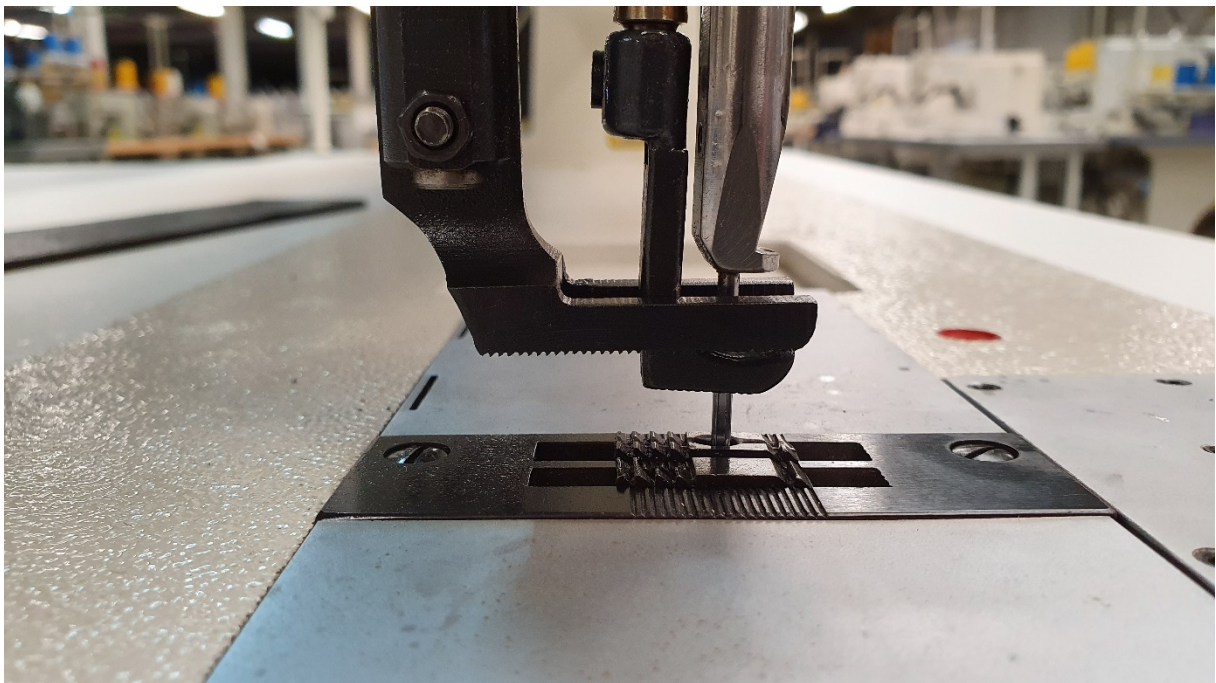
- Being in its topmost position, the feed dog should exceed the throat plate by 1 tooth height.
- For checking, set the stitch regulator for 0 stitch length and turn the handwheel.

Lifting movement of the feed dog

- The ascending feed dog and the descending needle should reach the throat plate level simultaneously (see picture below).



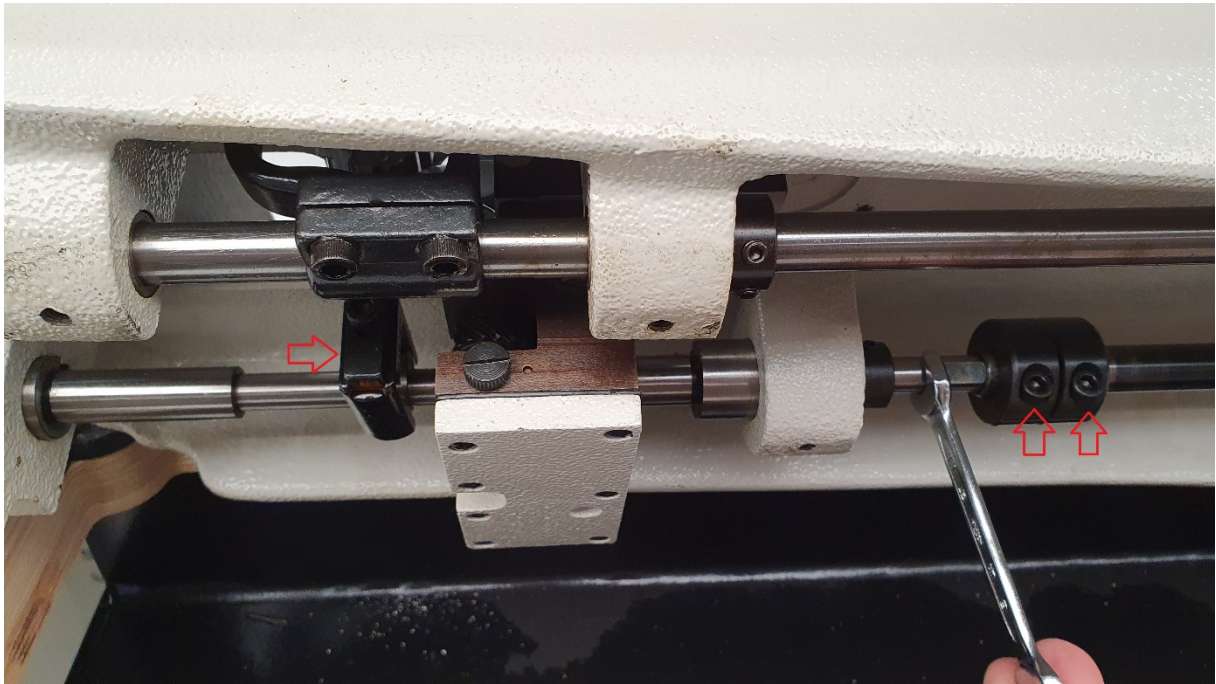
- The feed dog is at its topmost point when the needle is at its lower dead point (see picture below).



- For checking, set the stitch regulator for 0 stitch length and turn the handwheel.

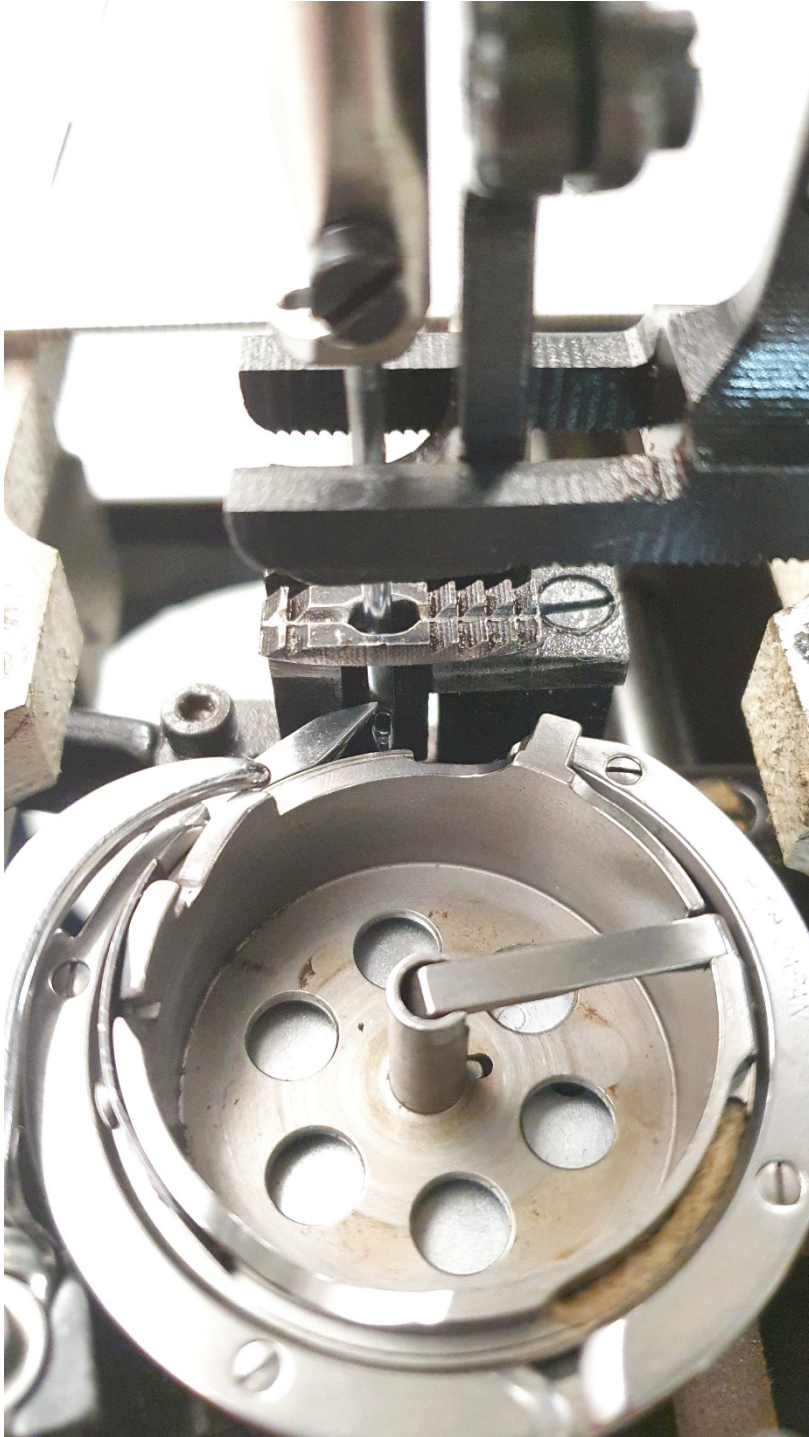
Feed lift motion

- Loosen the two Allen keys, turn the shaft to adjust the height of the feed lift motion (see picture below).



Hook timing

- Set the stitch length on 0. Turn the needle to the lowest position and continue to turn until the needle bar rises 3,5 – 4mm at this position the hook point must be half way across the width of the needle (see picture below).

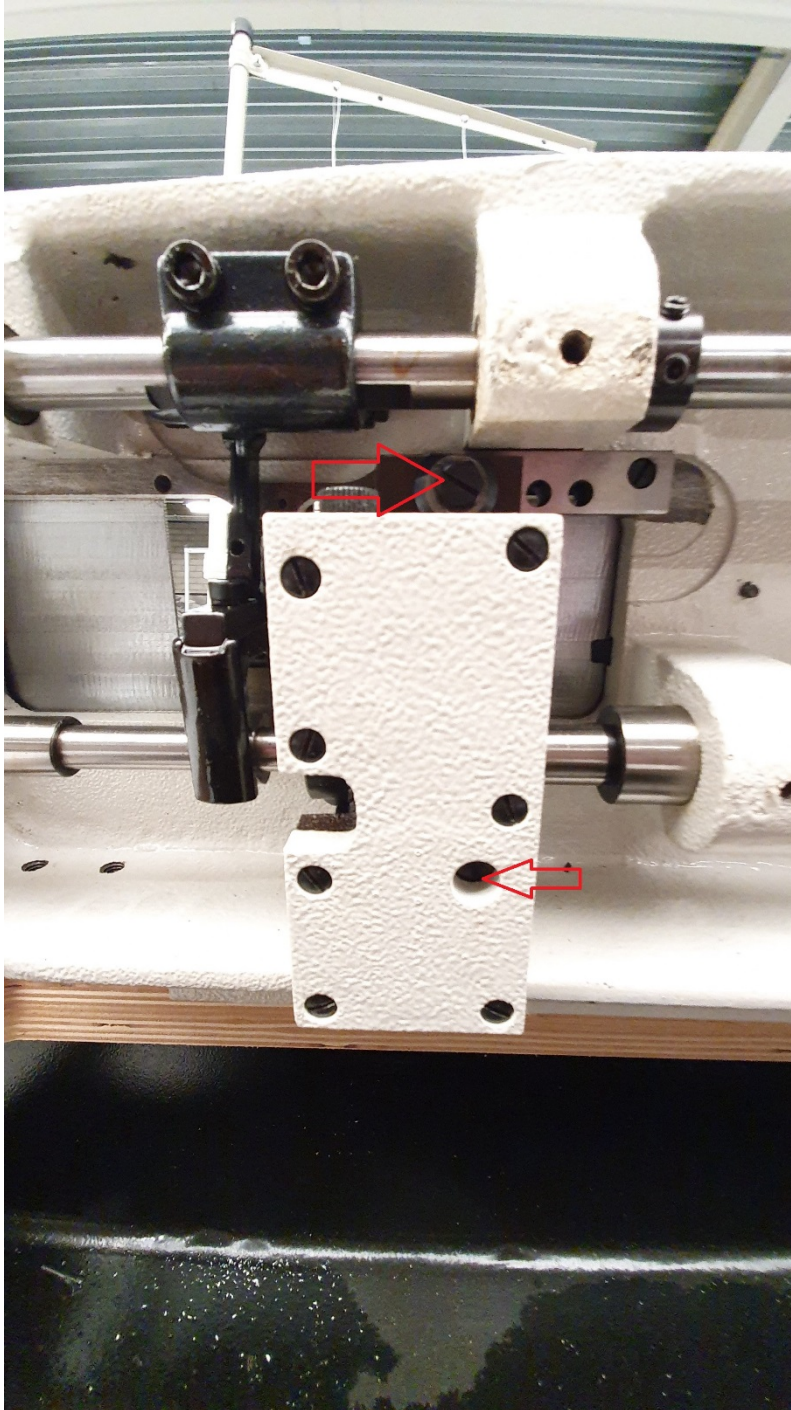


Needle bar height

- Set the machine on the longest stitch. The hook must be 2mm above the eye of the needle (see picture above).

Distance between the hook and the needle

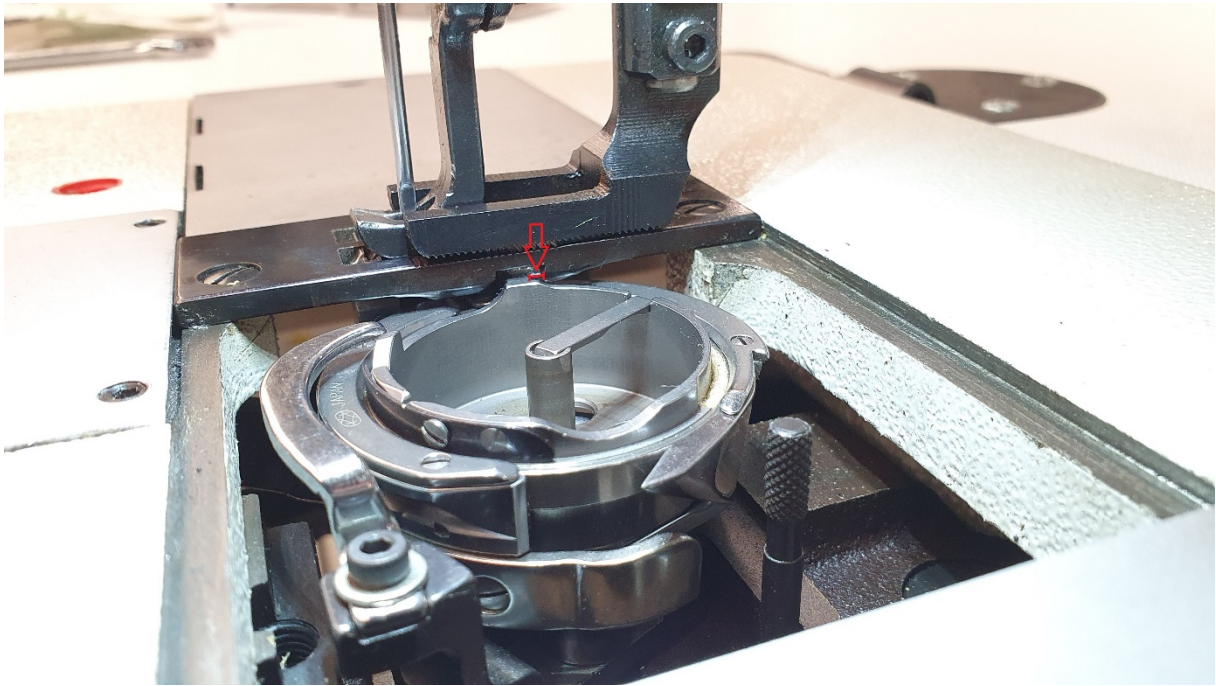
- The distance between the hook point and the needle should amount to 0,1mm. This is adjusted by unscrewing the two screws highlighted below in red and by moving the hook saddle left of right (see picture below).



- In case of a needle size change, check the distance and adjust accordingly.
- After re-setting, re-check hook timing.

Bobbin case opener

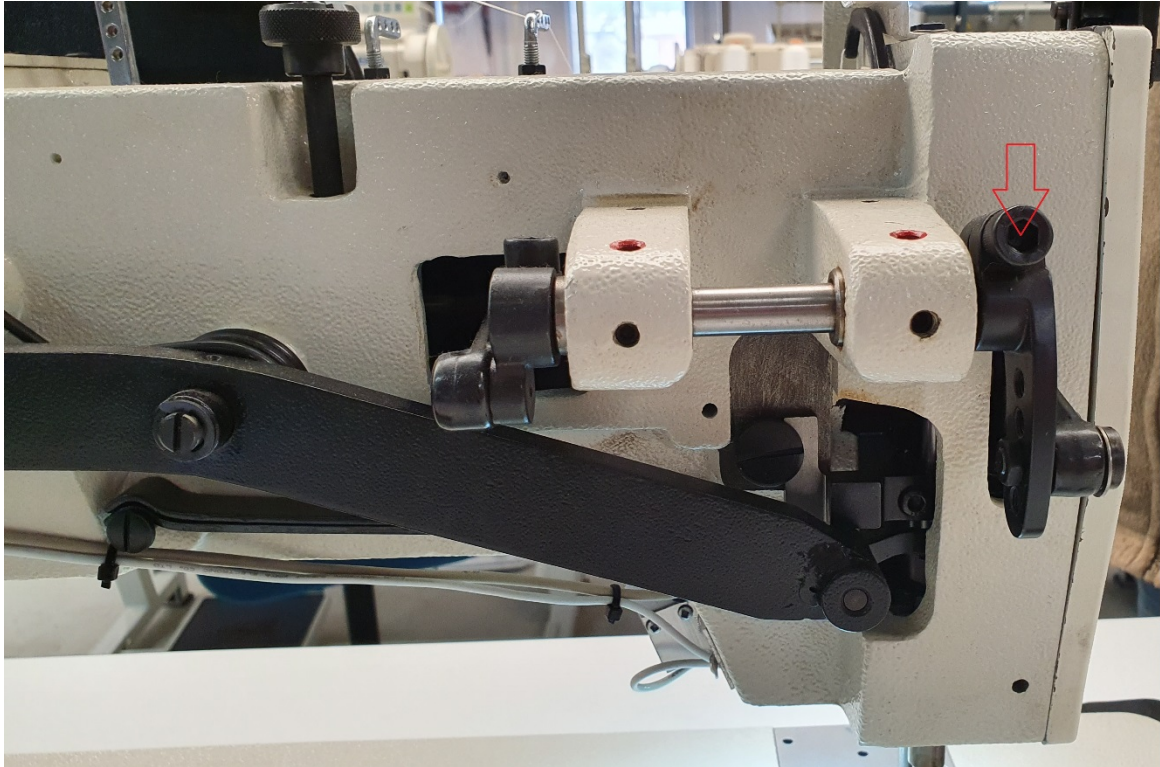
- The bobbin case is opened by the finger at the moment of thread passage.
- The finger travel and the lifting moment are not adjustable.
- Bobbin case opening finger – max opening 2 – 2,5mm (see picture below).



Feeding foot and presser foot

Equal stroke of feeding foot and presser foot

- Both feet should have the same stroke.
- Adjust 0 stitch length, turn the machine and compare the strokes.
- For correcting:
 1. lift slightly the foot with the higher stroke off the throat plate.
 2. Loosen the block with the screw of the shaft (see picture below).



The lifted foot will be lowered by the presser foot spring down to the throat plate.

3. Repeat the adjustment until the strokes are equal.

Feeding foot to needle timing

- Condition for the control and adjustment:
 1. Equal stroke of the feeding foot and of the presser foot (as previously said).
 2. Correct feed dog lifting movement (as previously said).
- The feeding foot should reach the throat plate level at the same time as the ascending feed dog and the descending needle.
- For checking, turn the machine with the stitch length on 0.
- For correcting, turn the eccentric on the arm shaft accordingly after loosening the screw (see picture below).



Stroke height of the feeding foot and of the presser foot

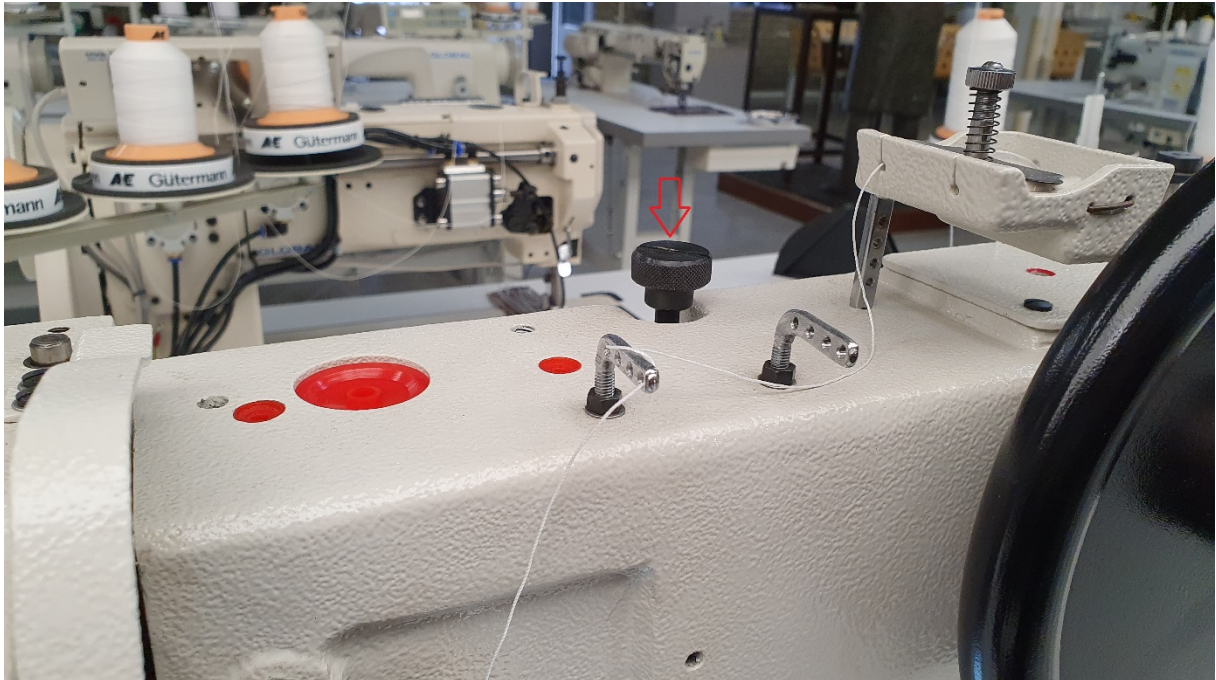
- It is possible to select 4 different stroke heights according to the material to be sewn.
- Connect the lever with one of the 4 holes of the driving lever (see picture below).



- Topmost hole: minimum stroke
- Lowest hole: maximum stroke

Pressure of the sewing feet

- Adjust by setting the lever according to the material to be sewn (see picture below).



Safety clutch

- this should act when the hook is jammed.
- For engaging the clutch, press the arresting button and turn the handwheel opposite to the direction of rotation.
- Move the handwheel until the hook is free again (if the clutch is again disengaged, remove the bobbin case). See picture below.



Maintenance

- All areas marked in red are **daily** oiling points.
- See pictures below for the hook oil reservoir. The reservoir must be filled until the pin gives half way (see pictures below).



Threading

- See pictures below for threading and bobbin thread.



