

GabbarTM

BAG SEWING MACHINE

MODEL

ST 502 - HD

ST 502 - JHD

INSTRUCTION MANUAL/PARTS LIST



Manufactured By :

Gabbar
Engineering Co.

Gujarat, India.

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SAFETY PRECUATIONS AND CHECK

A. Safety Precuations

1. Always turn power off before threading, oiling and adjusting the machine or replacing parts.
2. Wear safety glasses.
3. Make sure, before starting the machine, that all cover and shields are in place and closed.
4. Do not touch on the machine when it is running.

B. Check

1. Remove dust from throat plate, feed dog grooves and around looper eyelet everyday after work.
2. Check the machine for loose screws and tighten them, if any once a month.

INTRODUCTION

We express our heartfelt thanks for your purchase of the sewing machine belonged to ST - 502 HD, ST 502J HD and ST - 502 P HD.

For all user of the machine, this Instruction Book has been ready with explanations all about its operation, adjustments and maintenance.

Please read this book carefully, before use of the machine, to operate it under the best condition. Thus the machine will make a splendid contribution to your stitching business with its durability for a long time.

CLASSIFICATION OF MACHINE

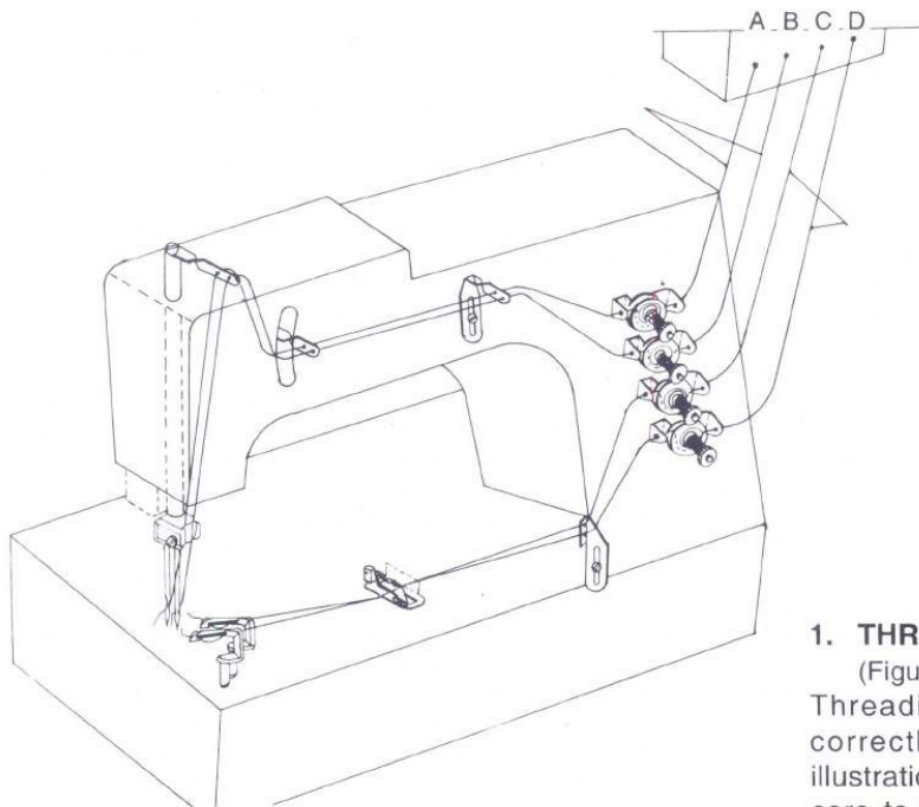
Model No.

- | | |
|----------------------|--|
| ST - 502 HD | (Double Needle chain stitch machine for Seaming and Hemming of PP/HDPE Woven Sacks.) |
| ST - 502 J HD | (Double Needle chain stitch machine for Seaming and Hemming of Tar Laminated Hessian Jute Bags.) |
| ST - 502 P HD | (Double Needle chain stitch machine for Seaming & Hemming of Paper Bag) |

SPECIFICATION

MODEL	ST 502 HD	ST 502 J HD	ST 502 P HD
Max speed	2800	2400	2400
Stitch range	11-16 / 100 MM	8-14/100 MM	8-14/100 MM
Seam	Double thread	chain stitch	
No. of Needle	2 Needle	2 Needle	2 Needle/1 Needle
No of Thread	4 Thread	4 Thread	2 Thread/4 Thread
Needle Size	DN X 1#25	DR X 2 # 26	DN X 1 # 26
Lubrication	(Automatic oil bath system)		
Fabric	For HDPE/PP	For Hessian / Tar limated / Paper Bag Jute Bag	

Current models are in production is ST - 502 HD, ST - 502J HD and ST - 502 P HD, Old Models ST - 302 HD and ST - 402 HD have been discontinued in production. Most of the spares of Model 302 HD, 402 HD, 502 HD and 502 J HD are same. Eventhough while placing the order always mentioned Model No., Part Nos. and Name of the Part.



1. THREADING :

(Figure No : 1)

Threading must be made correctly according to the illustration hereunder and take care to the fact that in-correct threading may cause some time skip-stitching, thread breakage and lack of uniformity in the sewing performance.

A. B. Needle Thread

C. D. Looper Thread.

1.1 THREAD TESION :

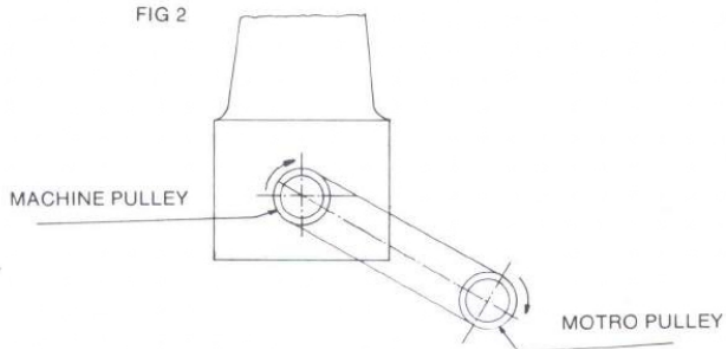
The thread tension must be adjusted according to sewing Fabric thickness, sewing thread seam width, stitch length etc. Therefore the pressuer of tension nuts of thread guides must be adjusted in each individual case.

2. ROTATIONAL DIRECTION :

Rotational Direction of the Pulley of motor & machine must be in clockwise direction.

Note : Belt 'V' Type No. F. H.P. 2360 OR 36. Do not run it before making sure the correct turning direction of motor

FIG 2



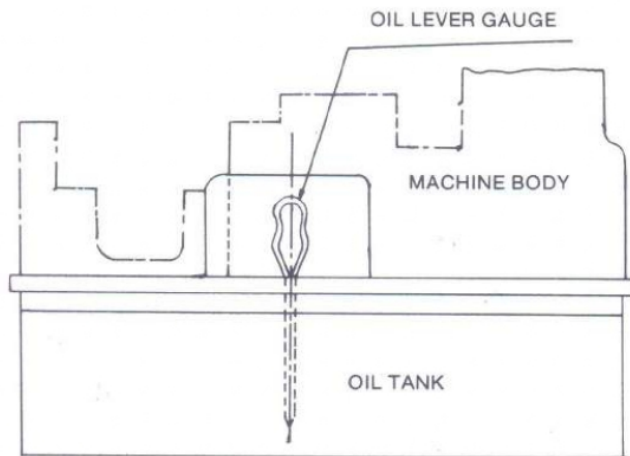


FIG 3

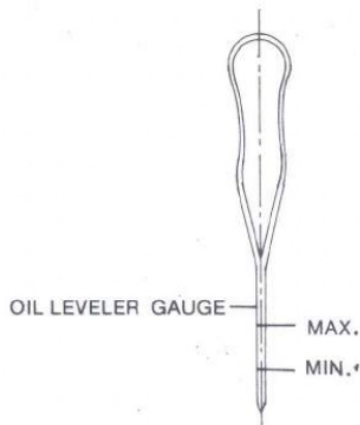
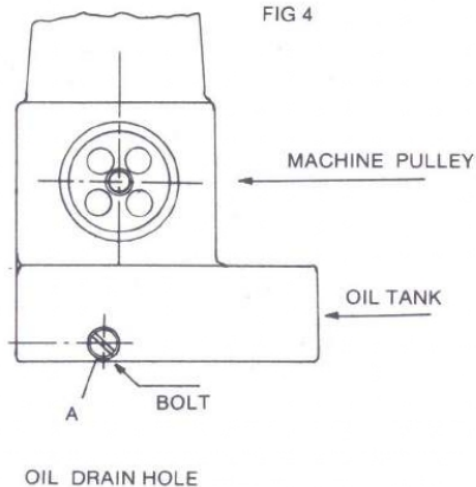


FIG 4



3. LUBRICATION

3.1 LUBRICANT :

Hindustan Petroleum 20 W - 40
or 40 NO. Indian Oil - SERVO OIL
NO : 40

3.2 FEEDING OF OIL :

At the time of shipment oil will have drained completely from the machine so it must be filled with new oil by opening the top cover. (502114A).

3.3 OIL LEVEL :

Pour the oil and maintain the level of oil in tank by checking oil guage (by dropping guage in tank and lifting immediately to see) maintain level as per fig 3 between maximum and minimum line every day.

Please note that excess oil result in overflow from the machine and less can damage the machine by overheating. While stitching tocool the thread pour sufficient quantity of diseal in the oil box (Part No.: 5021111) every day.

4. EXCHANGE OF OIL :

To keep iife of machine longer change oil completely with new one once a month.

4.1 ORDER OF EXCHANGE OF OIL :

1. Remove the oil by opening drain hole - A & then tight afterward.
2. For feeding the new oil refer 3.2

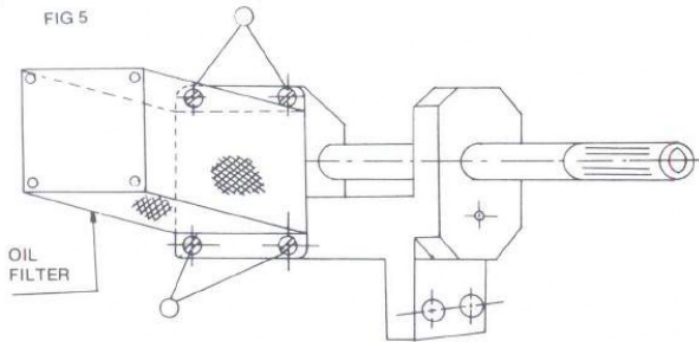
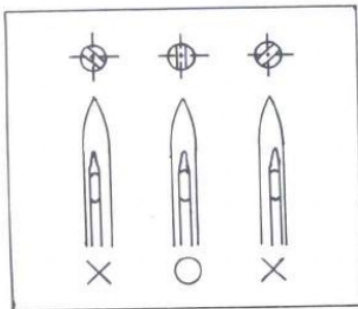


FIG 6



6. SETTING OF NEEDLE :

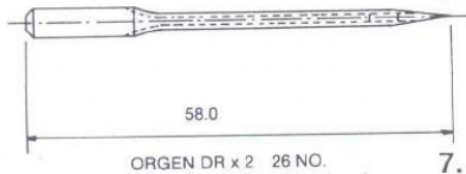
Needle should be set correctly in same way as the middle on (O) of illustration which shows facing of needle seen from the operator side. Marks of (X) are the incorrect facing.

6.2A NEEDLE TO BE USED :

(for "**Gabbar**" MODEL ST - 502HD DN x 1 Size : 25 OR 26 UY 143 GS (SNF 225 OR 230)

6.2B NEEDLE FOR JUTE MACHINE :

(for "**Gabbar**" MODEL ST-502J) Needle for Jute Machine is DR x 2 Size :26 as per Dr. No. 15 (length reduced to 58 mm)

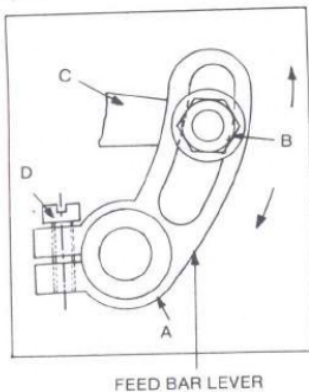


7. ADJUSTMENT FOR STITCH LENGTH (FIGURE NO : 7) (Stitches per 100 mm)

To get less or more stitch length : Maximum stitch length is obtained by loosening nut "B" of feed bar Lever (A) and setting it at upper most edge of the oval hole.

Minimum 'Stitch Length' is obtained by loosening Nut 'B' of feed bar (A) and setting it at lower most edge of oval hole and thus with similar way required stitch length is obtained by loosening screw 'B' of feed bar (A) and setting it as required in oval hole.

FIG 7



5. CLEAN OIL TANK AND OIL FILTER :

5.1 FOR CLEANING OF OIL TANK

1. Remove the machine head from the table top.
2. Removing the oil tank by loosening 6 bolts of the bottom of the table.
3. Clean oil tank by kerosin.

This cleaning will prolong life of machine remarkably.

5.2 CLEAN OF FILTER :

For cleaning the filter (Loosen the screw A(fig.5) and clean the filter by kerosin.

6.3 ORDER OF FITTING OF NEEDLE :

- A. Turn pulley until needle bar reaches to its highest position
- B. Pull off the useless needle downward by loosening screw.
- C. Insert the new needle as far as it will go facing if scarf towards backside of the Needle Holder.

Now clearance between needle & needle support would be disturbed. Adjust it as per instruction No. 13. Also position of feed dog in throat plate would be disturbed. By opening two bolts 'D' adjust position of feed dog in throat plate.

FIG 8

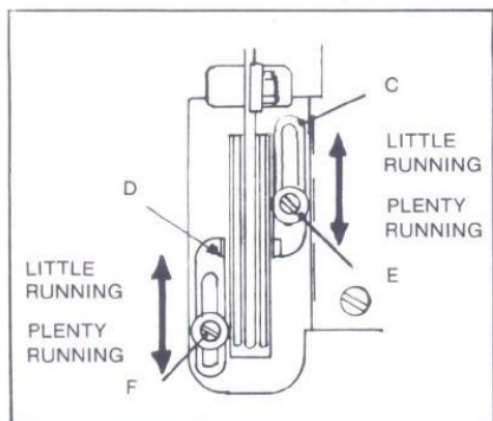


FIG 9

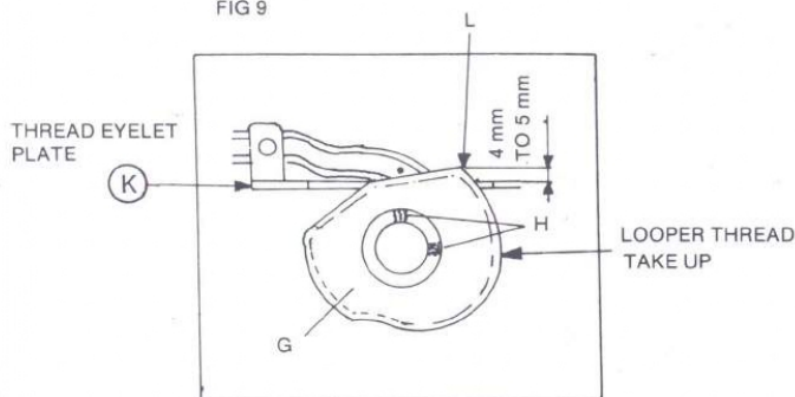
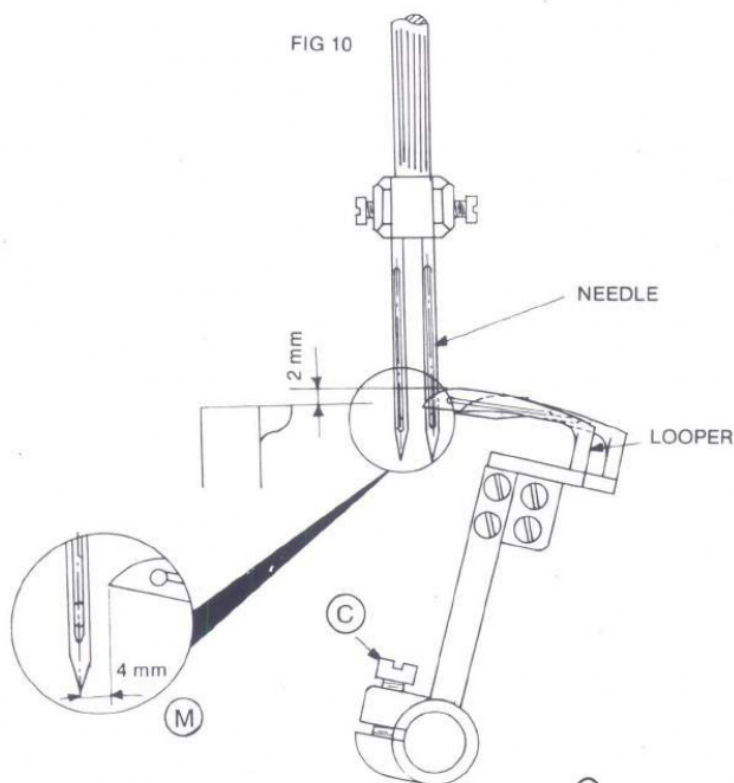


FIG 10



8. TENSION OF LOOPER THREAD. (FIGURE NO :8)

To get right quantity of thread move eyelet 'C' & 'D' towards operators side by loosening 'E' & 'F' and move them to the rear side of smaller quantity of thread.

9. POSITIONING OF LOOPER THREAD TAKE UP (FIGURE NO :9)

1. The sketch shows looper thread Take up 'G' viewed from the side of Needle Bar.

2. The looper reaches the Extreme left end of its movement then starts to return to right direction just when Looper Thread Takeup will also start to take thread up.

3. At this time, the highest point (L) of the Looper Thread Takes up (G) must positioned with the distance of 4 mm to 5 mm above top Face of Thread Eyelet Plate (K)

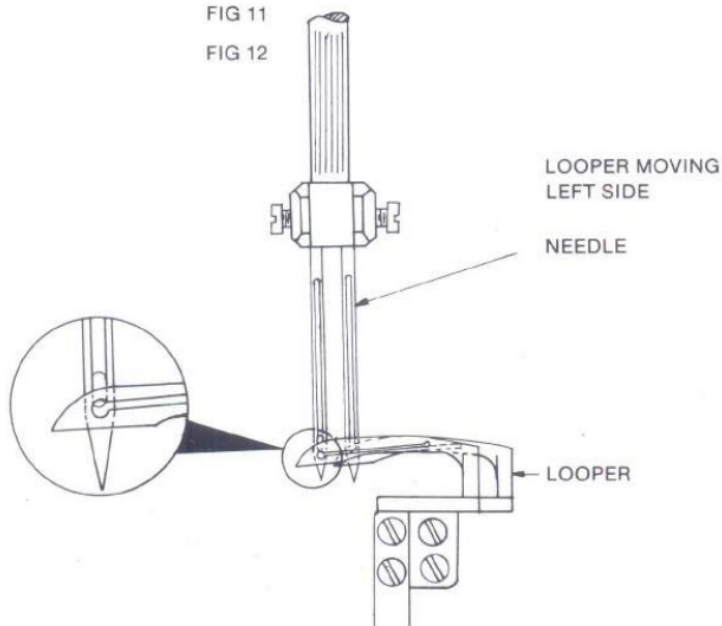
4. To obtain richer quantity of thread in the taking, positioning of the take-up G must be made earlier than the timing mentioned above. In this adjusting, the take-up must not be moved in right or left, to which take care please.

10. ADJUSTMENT OF LOOPER

As shown in the sketch here Under Movement Scope (m) of looper means the distance between point of looper and Centre of rightmost needle. When the looper reaches Extreme end of its movement of the right. When Needles are at their lowest position & looper is at Extreme right of the movement distance of looper point from Centre of Needles Shall be 4 mm & this Adjustment is made by loosening screw (c).

FIG 11

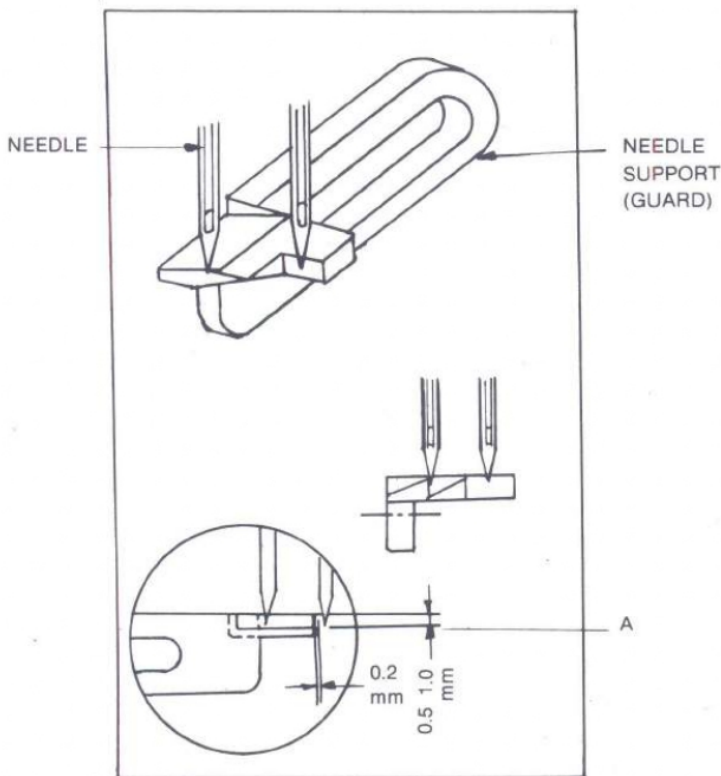
FIG 12



11/12 TIMING OF NEEDLE WITH LOOPER MOVING RIGHT/LEFT : (FIG. NO : 11/12)

On its both ways to right and left half position of holes of looper must coincide with the holes of needle. To obtain above situation, height of the needle bar shall be adjusted loosening screw of needle bar connecting bracket.

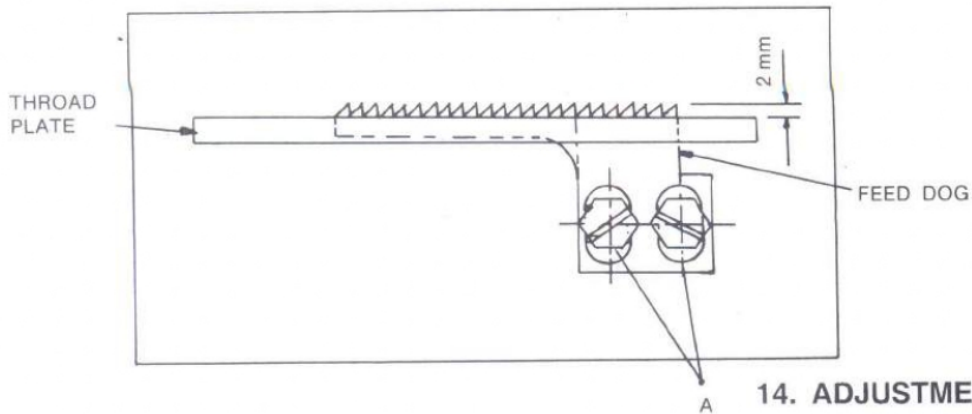
FIG 13



13. RELATION BETWEEN NEEDLE AND NEEDLE SUPPORT (GUARD) (Fig. No.13)

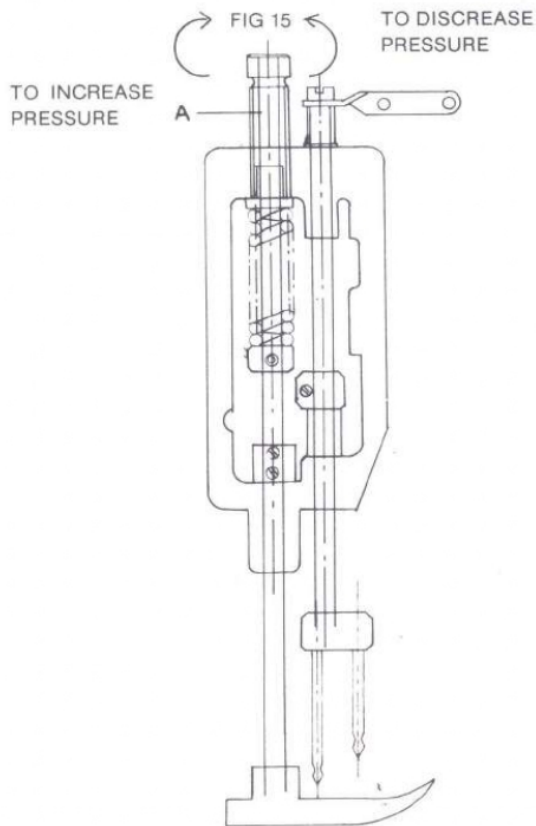
Install the needle support (guard) so that the point 'A' may come to the position of about 0.5 mm to 1.00 mm upward. In this case the clearance between the needle and the needle support (guard) should be 0.2 mm but see to it that the needle support (guard) will not touch the needle. This needle support (guard) being fixed on feed dog holder, you must re-adjust it when you have changed the stitch length. If the needle guard is not adjusted properly, it can cause of breakage of needle or skipping of stitches.

FIG 14



14. ADJUSTMENT OF HEIGHT OF FEED DOG :
FIGURE NO : 14)

Top faces of feed dog and throat plate shall be parallel when the feed dog is at its highest position. At this moment levelling top face the feed dog must be 2mm upper then throat plate. Height of the feed dog must be adjust by screw 'A'.

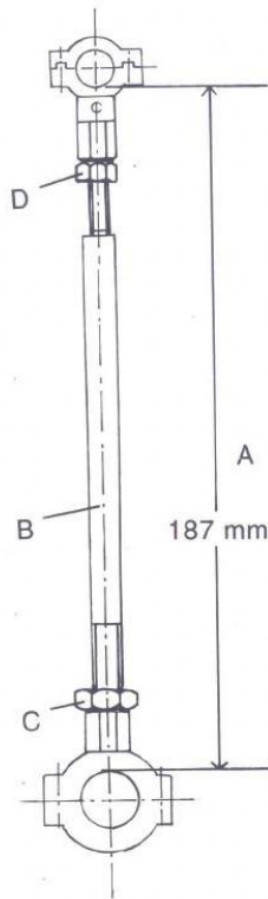


15. ADJUSTING OF PRESSURE OF PRESSURE FOOT :

Pressure of presure foot assembly is so adjusted that your material are feed at a constant and uniform speed.

Pressure knob (A) turn clock wise to increase pressuer and turn counter clockwise to decrease it.

Too large pressure will thread break etc and too small pressuer failure of thread chain, at end of material and also slips of bags.



**16. SETTING OF NEEDLE
LEVER CONN. ROD
ASSEMBLY :**

Distance A must be kept 187 mm when adjusting Needle lever connecting long (B) with two nuts (C & D).

TROUBLE SHOOTING :

When trouble occurs operation the machine, refer to the following table for selecting suitable measures :

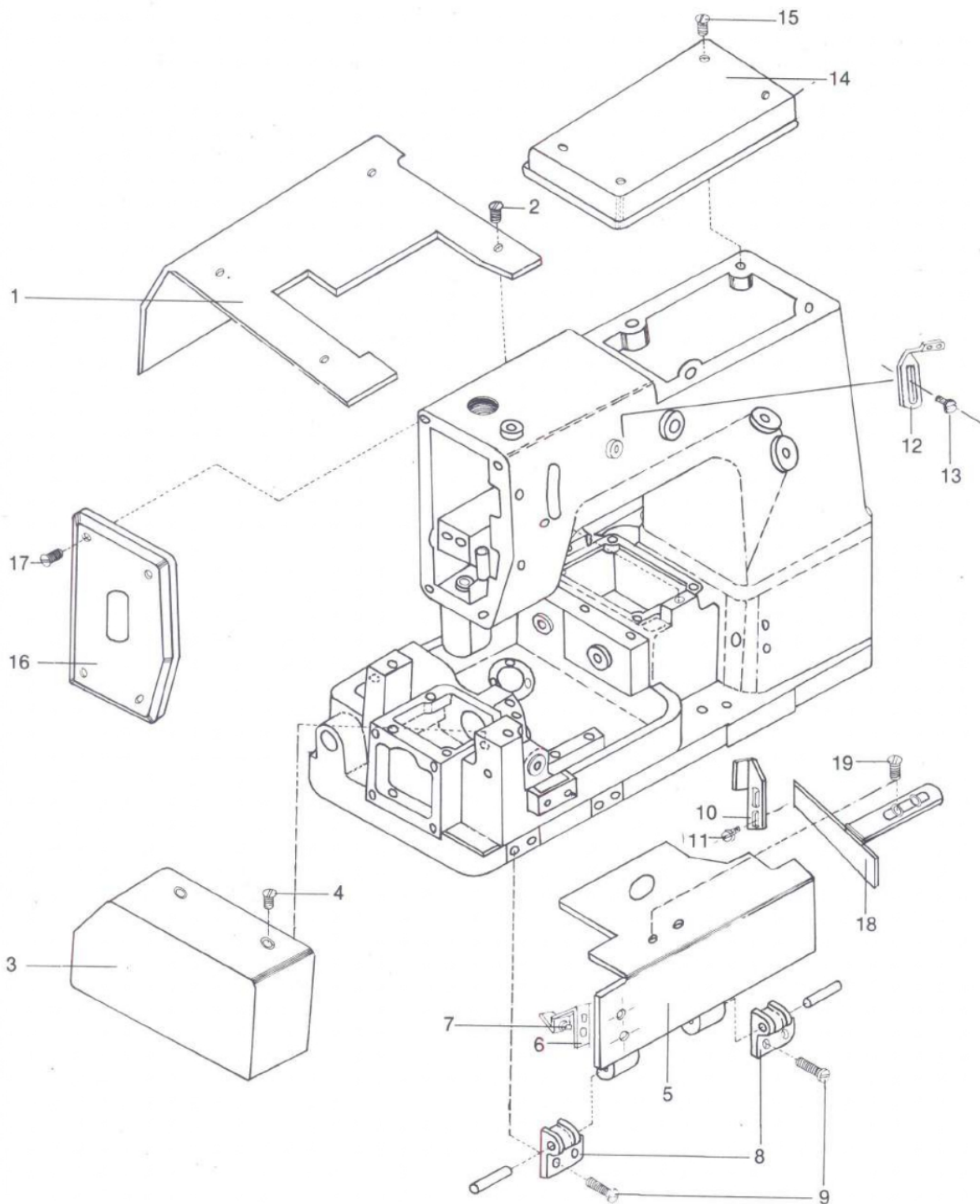
Problem	Cause	Solution
Needle thread breaks	<ol style="list-style-type: none"> 1. Damaged looper 2. Needle thread too tight 3. Worn out feed dog causing fine stitches. 4. Thread Twisting or entangling between thread stand & needle 5. Improper needle setting, Bant or damaged needle 6. Needle Thread Too loose 	Replace Looper Reduce tension Replace feed dog Secure correct thread Set needle properly Replace needle Increase Tension
Looper thread breaks	<ol style="list-style-type: none"> 1. Looper thread too tight or too loose 2. Damaged looper 3. Thread twisting or entangling between thread stand and looper 	Adjust tension Replace looper Check for correct threading
No chaining on work edges	<ol style="list-style-type: none"> 1. Incorrect threading 2. Looper thread too tight 3. Improper timing of needle looper 	Threading machine correctly Reduce tension Adjust timing of needle and looper
Thread skips	<ol style="list-style-type: none"> 1. Needle setting not correct 2. Bent or damaged needle 3. Needle thread sticking on needle due to heat 4. Needle bar set to high 	Set needle correctly Replace needle Use lubricant on thread Lower needle bar
Needle or Looper breaks	<ol style="list-style-type: none"> 1. Improper timing of needle and looper 2. Bent needle 	Adjust timing of needle and looper Replace needle
Non-uniform stitch length seam not straight	<ol style="list-style-type: none"> 1. Weak pressure of pressure foot 2. Bent needle 3. Worn out feed dog 	Increase pressure Replace needle Replace feed dog

ORDERING PARTS

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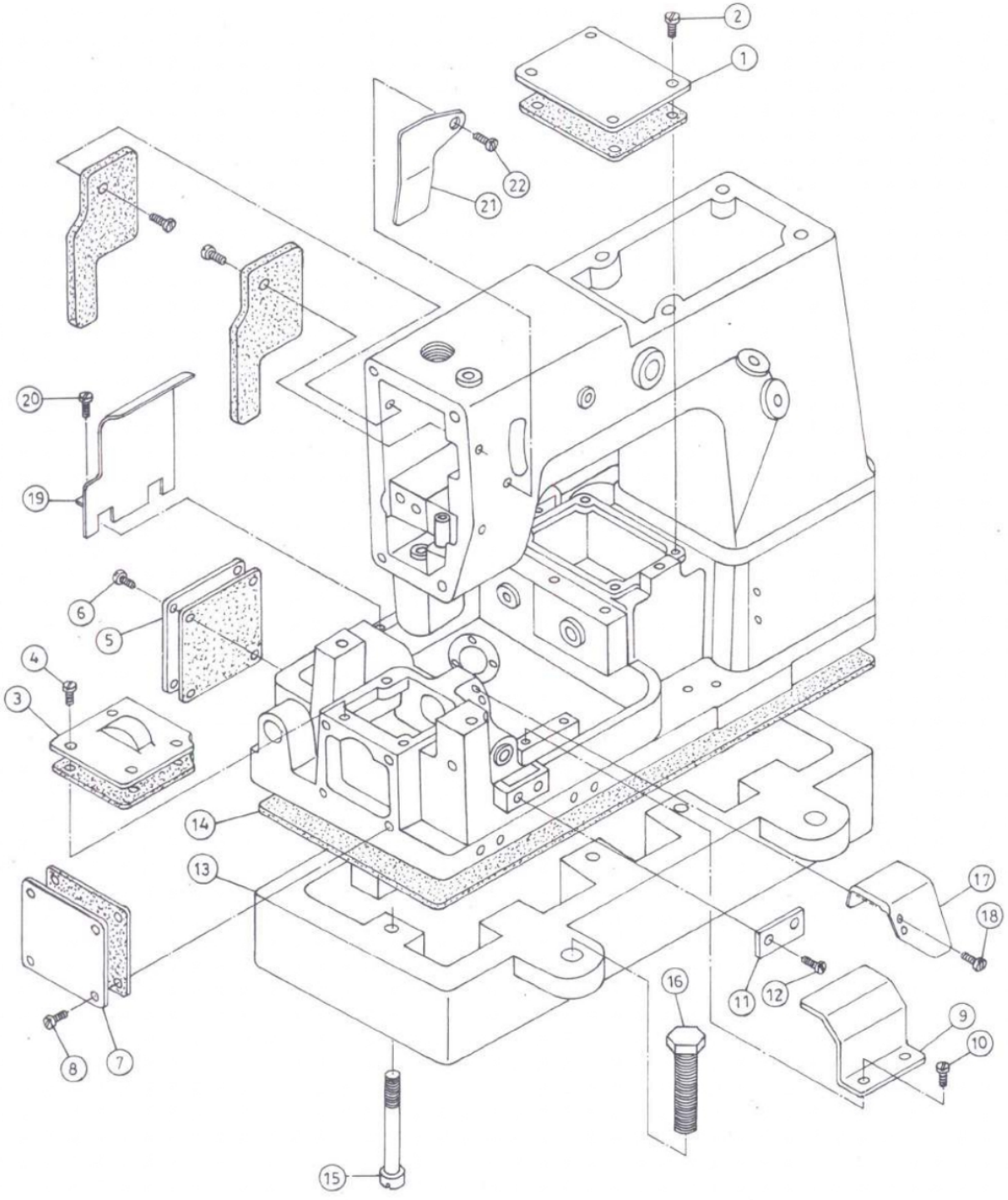
1. MISCELLANEOUS COVER



1. MISCELLANEOUS COVER

Sr. No.	Parts No.	Description	Amt. Req.
1	50211	Cloth Plate	1. Pc.
2	50212	Screw for Cloth Plate	4. Pc.
3	50213	Side Cover	1. Pc.
4	50214	Screw for Side Cover	2. Pc.
5	50215	Front Cover	1. Pc.
6	50216	Front Cover Latch Spring	1. Pc.
7	50217	Screw for Front Cover Latch Spring	2. Pc.
8	50218	Front Cover Hings	4. Pc.
9	50219	Screw for Front Cover Hinge	1. Pc.
10	502110A	Looper Thread Guide take up	1. Pc.
11	502111A	Screw for Looper Thread Guide Take-up	1. Pc.
12	502112A	Needle Thread Eyelet	1. Pc.
13	502113A	Screw for Needle Thread Eyelet	1. Pc.
14	502114A	Top Cover	1. Pc.
15	502115A	Screw for Top Cover	4. Pc.
16	502116A	Head Cover	1. Pc.
17	502117A	Screw for Head Cover	4. Pc.
18	502118A	Cloth Guide	1. Pc.
19	502119A	Screw for Cloth Guide	2. Pc.

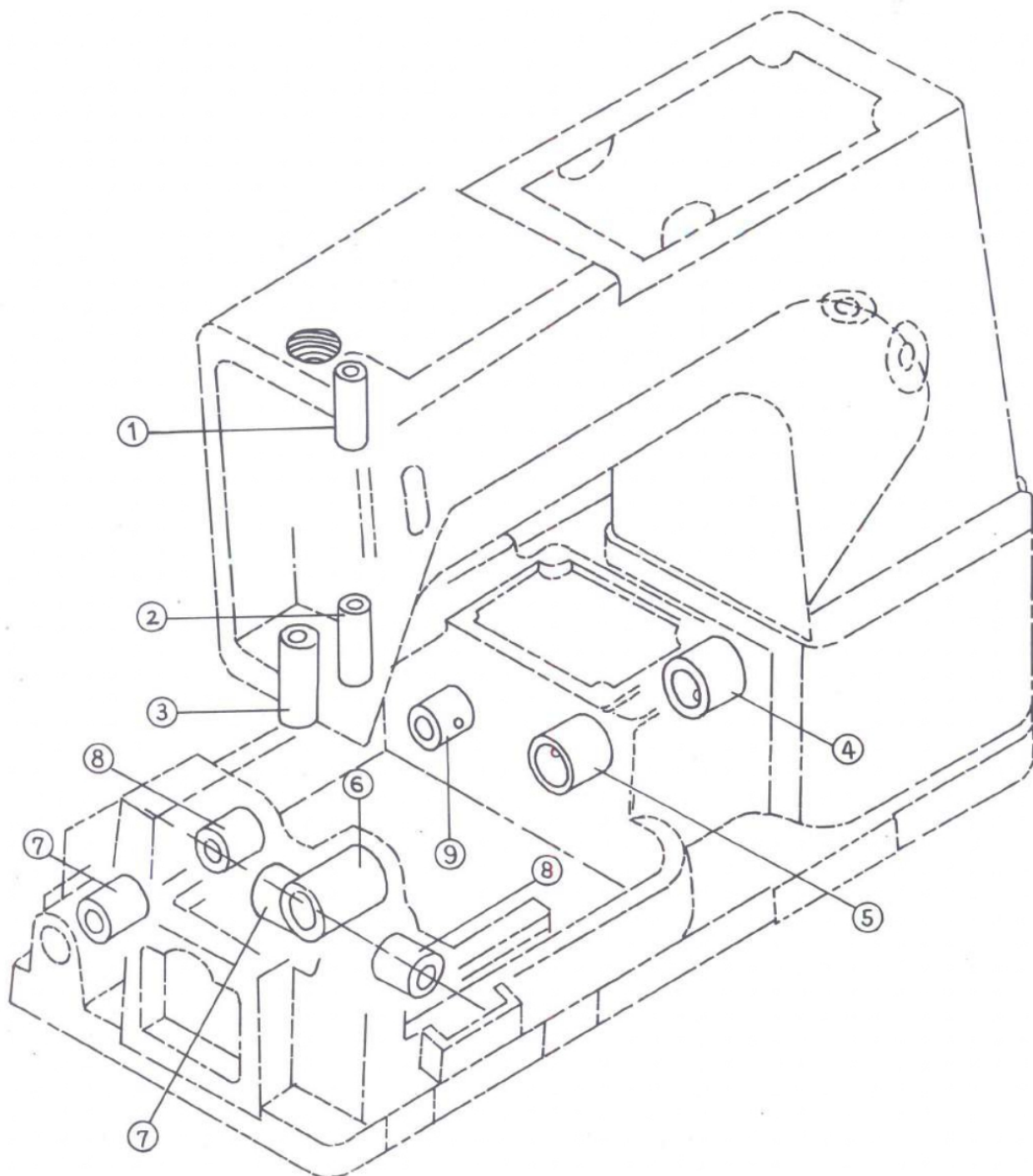
2. MISCELLANEOUS COVER & BASE



2. MISCELLANEOUS COVER & BASE

Sr. No.	Parts No.	Description	Amt. Req.
1	50221	Worm Chamber Cover	1. Pc.
2	50222	Screw for Worm Chamber Cover	4. Pc.
3	50223	Crank Chamber Cover	1. Pc.
4	50224	Screw for Crank Chamber Cover	4. Pc.
5	50225	Tail Cover	1. Pc.
6	50226	Screw for Tail Cover	4. Pc.
7	50227	Side Cover	1. Pc.
8	50228	Screw for the Side Cover	4. Pc.
9	50229	Feed dog Driving Rod Front Cover	1. Pc.
10	502210	Screw for Feed Dog Driving Rod Front Cover	2. Pc.
11	502211	Looper Holder Front Cover	1. Pc.
12	502212	Screw for Looper Holder Front Cover	2. Pc.
13	502213	Oil Tank	1. Pc.
14	502214	Oil Tank Gasket	1. Pc.
15	502215	Screw of Oil Tank	6. Pc.
16	502216	Screw for Machine Foundation	4. Pc.
17	502217	Feed Dog Driving Rod Top Cover	1. Pc.
18	502218	Screw for Feed Dog Driving Rod Top Cover	2. Pc.
19	502219	Feed Bar Cover	1. Pc.
20	502220	Screw for Feed Bar Cover	2. Pc.
21	502221	Needle Thread Guide Cover	1. Pc.
22	502222	Screw for Needle Thread Guide Cover	1. Pc.

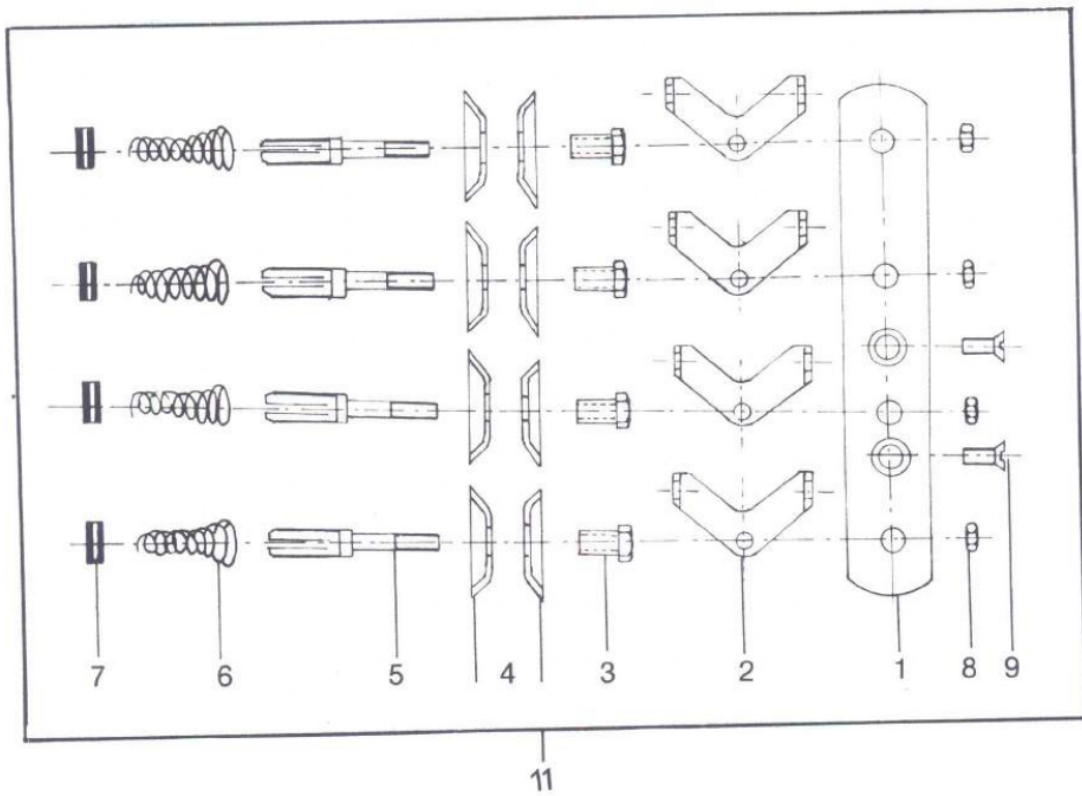
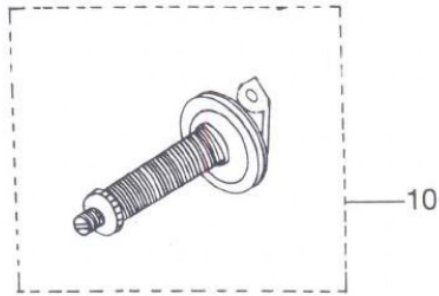
2A. MISCELLANEOUS BUSHING



2A. MISCELLANEOUS BUSHING

Sr. No.	Parts No.	Description	Amt. Req.
1	5022A-1	Needle Bar Bushing (Upper)	1. Pc.
2	5022A-2	Needle Bar Bushing (Lower)	1. Pc.
3	5022A-3	Pressure Bar Bushing	1. Pc.
4	5022A-4	Oil Lubricating Bush	1. Pc.
5	5022A-5	Crank Shaft Bushing (Short)	1. Pc.
6	5022A-6	Crank Shaft Bushing (Long)	1. Pc.
7	5022A-7	Feeding Driving & Looper Oscillating Shart Bushing (Left)	2. Pc.
8	5022A-8	Feeding Driving & Looper Oscillating Shart Bushing (Cent.)	2. Pc.
9	5022A-9	Feed Driving Shaft Bushing (Right)	1. Pc.

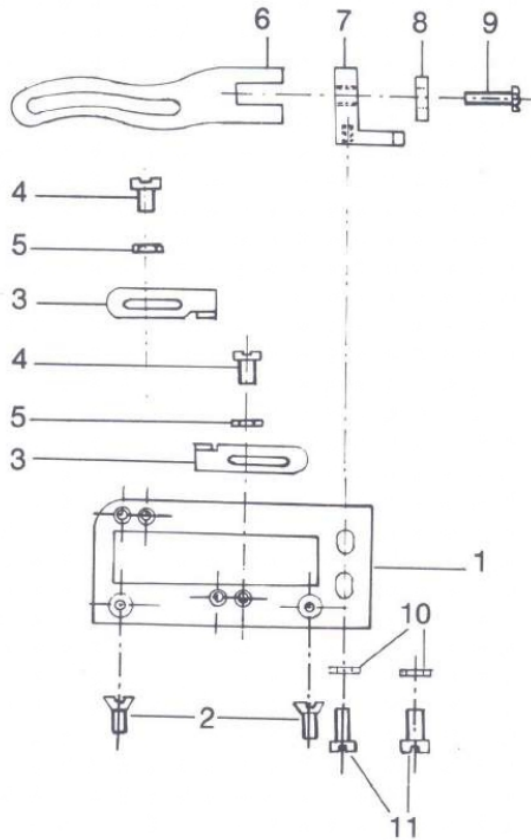
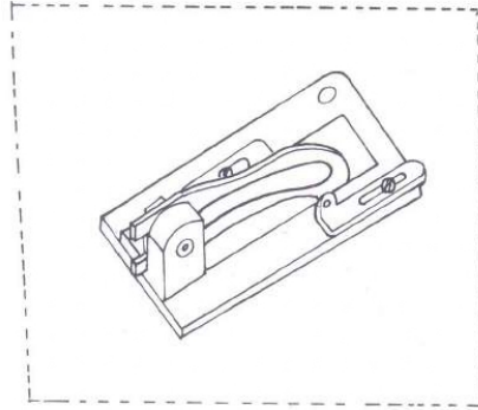
3. THREAD EYELET



3. THREAD EYELET

Sr. No.	Parts No.	Description	Amt. Req.
1	50231	Tension Disc Seperator	1. Pc.
2	50232	Tension Disc Eyelet	4. Pcs.
3	50233	Tension Disc Bush	4. Pcs.
4	50234	Tension Disc	8. Pcs.
5	50235	Tension Stud	4. Pcs.
6	50236	Tension Spring	4. Pcs.
7	50237	Lock Nut	4. Pcs.
8	50238	Nut for Tension Stud	4. Pcs.
9	50239	Screw for Tension Disc Seperator	2. Pcs.
10	502310	Tension Assy. [(2 to 8) item]	4 Set
11	502310AY	Tension Unit Comp. Assy. (1 to 9)	1. Set

4. LOOPER THREAD EYELET



4. LOOPER THREAD EYELET

Sr. No.	Parts No.	Description	Amt. Req.
1	50241	Thread Eyelet Plate	1. Pc.
2	50242	Screw for Thread Eyelet Plate	2. Pcs.
3	50243	Looper Thread Take-up Eyelet	2. Pcs.
4	50244	Screw for Looper Thread Take-up	2. Pcs.
5	50245	Washer	2. Pcs.
6	50246	Retaining Finger	1. Pc.
7	50247	Retaining Finger Support Bkt.	1. Pc.
8	50248	Pressure Washer	1. Pc.
9	50249	Screw for Pressure Washer	1. Pc.
10	502410	Washer for Retaining Finger Support Bkt.	2. Pcs.
11	502411	Screw for Retaining Finger Support Bkt.	2. Pcs.
12	50241AY	Thread Eyelet Plate Assy.	1 Set

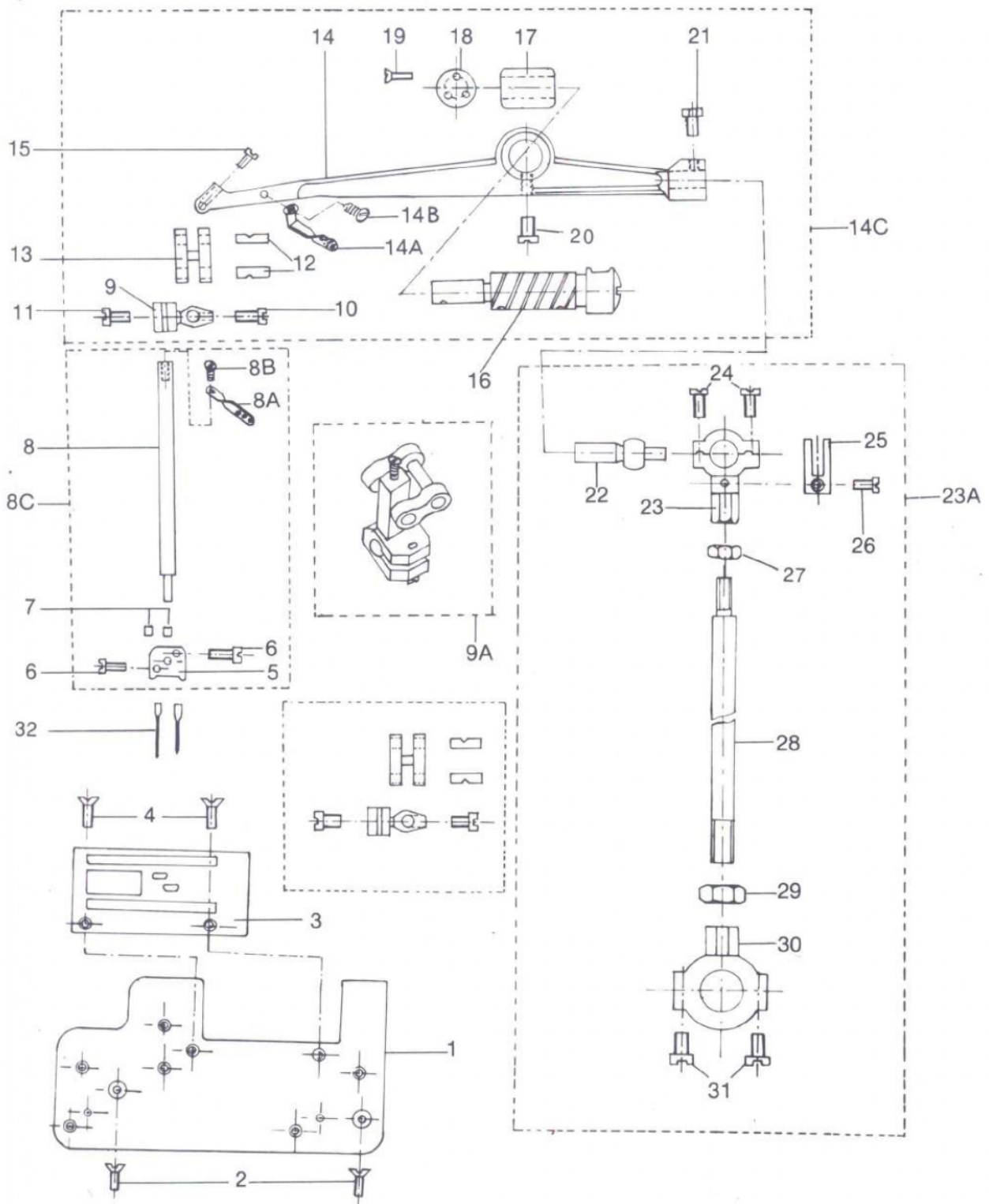
5. MAIN DRIVING SHAFT MECHANISM

Sr. No.	Parts No.	Description	Amt. Req.
1	50251	Pulley	1. Pc.
1A	50251A	Screw for Pulley	4. Pc.
2	50252	Pulley Washer	1. Pc.
2A	50252A	Screw for Pulley Washer	2. Pc.
3	50253	Pulley Holder	1. Pc.
3A	50253A	Screw for Pulley Holder	2. Pc.
4	50254	Bearing Cover	1. Pc.
4A	50254A	Screw for Bearing Cover	4. Pc.
5	50255	Ball Bearing - 6302ZZ	1. Pc.
5A	50255A	Ball Bearing - 6202ZZ	1. Pc.
6	50256	Bearing Holder Coller	1. Pc.
7	50257	Crank Shaft Bearing Housing	1. Pc.
7A	50257A	Screw for Bearing Housing	4. Pc.
7B	50257B	Oil Sleeve	1. Pc.
8	50258	Key for Crank Shaft	1. Pc.
9	50259	Screw for Counter Weight of Crankshaft	4. Pc.
10/11	502560/61	Counter Weight of Crank Shaft	2. Pc.
12A	502562A	Crank Shaft (Right)	1. Pc.
12B	502562B	Crank Shaft (Left)	1. Pc.
13	502563	Worm Eccentric	1. Pc.
14/15	502564/65	Screw for Worm Eccentric	2. Pc.
16	502566	Worm Eccentric Cover	1. Pc.
17	502567	Screw for Worm Eccentric Cover	2. Pc.
18	502568	Looper thread Take Up	2. Pc.
19	502569	Screw for Looper Thread Take - Up	3. Pc.
20	502570	Feed Dog Regulating Control Eccentric	1. Pc.
21/22	502571/72	Screw for Feed Dog Regulating Control	2. Pc.
23	502573	Feed Dog Regulating Control Eccentric Cover	1. Pc.
24	502574	Feed Dog Driving Eccentric	1. Pc.
25	502575	Screw for Feed Dog Driving Eccentric	2. Pc.
14	502584	Looper Driving Eccentric Crank	1. Pc.
14A	502585	Screw for Looper Driving Eccentric	2. Pc.

NOTE :

502566, Worm Eccentric Cover. Can be used in our old model so that which can be seen in this drawing

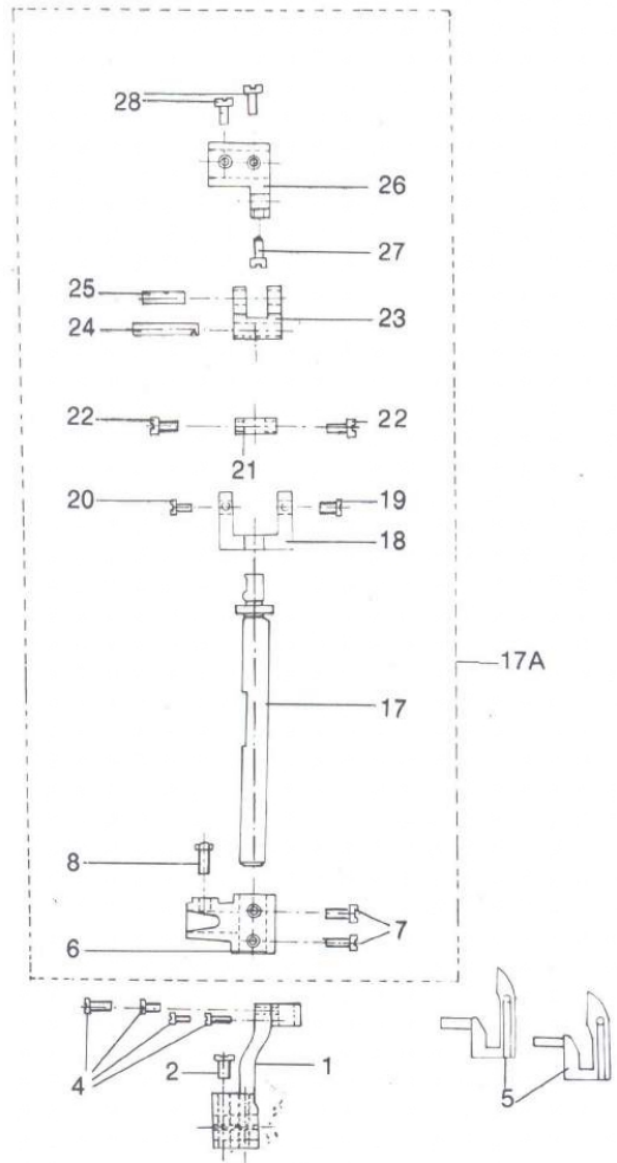
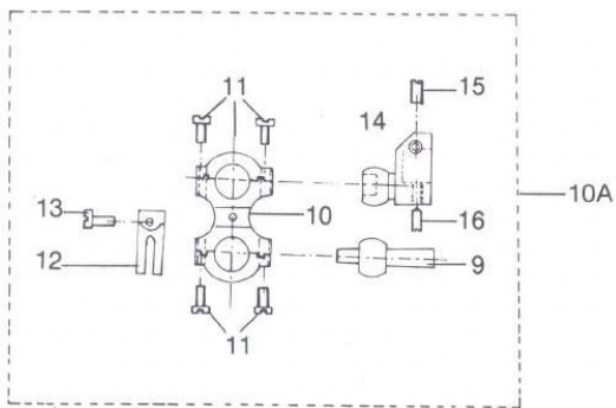
6. NEEDLE BAR MECHANISM



6. NEEDLE BAR MECHANISM

Sr. No.	Parts No.	Description	Amt. Req.
1	50261	Throat Plate Supporter	1 Pc.
2	50262	Screw for Throat Plate Supporter	2 Pc.
3	50263	Throat Plate	1 Pc.
4	50264	Screw for Throat Palte	2 Pc.
5	50265	Needle Holder	1 Pc.
6	50266	Screw for Needle	2 Pc.
7	50267	Screw for Needle Holder	2 Pc.
8	50268	Needle Bar	1 Pc.
8A	50268A	Needle Bar Thread Eyelet	1 Pc.
8B	50268B	Screw for Needle Bar Thread Eyelet	1 Pc.
8C	50268C-AY	Needle Bar with Needle Holder & Thread Eyelet (5-8)	1 Set
9	50269	Needle bar Connecting Bracket	1 Pc.
9A	50269A-AY	Needle Bar Con. Bkt with Link Set (9-13)	1 Set
10	502670	Screw for Needle Bar Connecting Link	1 Pc.
11	502671	Screw for Needle Bar Connecting Bkt.	1 Pc.
12	502672	Needle Bar Connecting Link Pin	2 Pc.
13	502673	Needle Bar Connecting Link	1 Pc.
14	502674	Needle Bar Driving Crank Bkt.	1 Pc.
14A	502674A	Needle Thread Take Up	1 Pc.
14B	502674B	Screw for Needle Thread Take up	1 Pc.
14C	502674C-AY	Needle Bardriving Crank Bkt Comp. Assy.	1 Set
15	502675	Screw for Needle Bar Conn. Link Pin	1 Pc.
16	502676	Needle Bar Driving Bracket Shaft	1 Pc.
17	502677	Needle Bar Driving Bkt. Shaft Collar	1 Pc.
18	502678	Needle Bar Driving Bkt. Shaft Collar Washer	1 Pc.
19	502679	Screw for Needle Bar Driving Bkt. Shaft Collar	3 Pc.
20	502680	Screw for Needle Bar Driving Crank Bkt.	1 Pc.
21	502681	Screw for Ball Stud	1 Pc.
22	502682	Ball Stud (for N.B.B)	1 Pc.
23	502683	Needle Lever Conn. Rod Bkt. small	1 Pc.
23A	502683-AY	Needle Lever conn. Rod Bkt. Assy.comp(22-31)	1 Set
24	502684	Screw for Needle Lever conn. Rod Bkt. (Small)	2 Pc.
25	502685	Ball Stud Guid (for N.B.B)	1 Pc.
26	502686	Screw for Ball Stud Guid	1 Pc.
27	502687	Nut for Needle Lever Con. Rod (Small)	1 Pc.
28	502688	Needle Lever Connecting (Long)	1 Pc.
29	502689	Nut for Needle Lever Conn. Rod (Big)	1 Pc.
30	502690	Needle Lever Conn. Rod Bkt. (Big)	1 Pc.
31	502691	Screw for Needle Lever Conn. Rod Bkt. (Big)	2 Pc.
32	502692	Needle DNX 1-25/26	2 Pc.

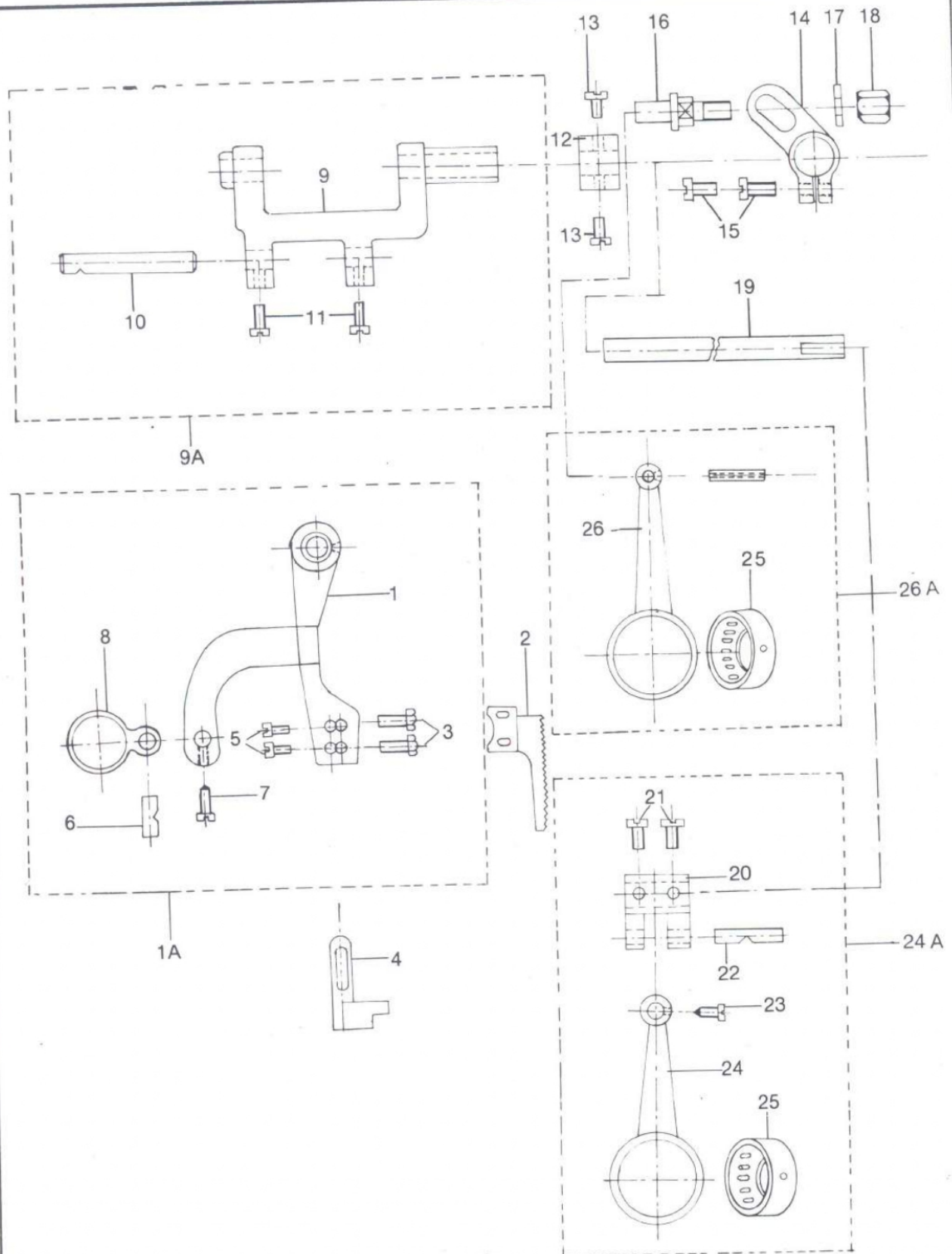
7. LOOPER DRIVING MECHANISM



7. LOOPER DRIVING MECHANISM

Sr. No.	Parts No.	Description	Amt. Req.
1	50271	Looper Hoder Bracket.	1 Pc.
2	50272	Screw for Looper Holder Bkt.	2 Pc.
3	50273	Screw for Looper Bracket (Old Model)	1 Pc.
4	50274	Screw for Looper	4 Pc.
5	50275	Looper	2 Pc.
6	50276	Looper Driving Lever	1 Pc.
7	50277	Screw for Looper Driving Lever	2 Pc.
8	50278	Screw for Ball Stud	1 Pc.
9	50279	Ball Stud for L.D.M.	1 Pc.
10	502780	Looper Connecting Rod Compelte	1 Pc.
10A	502780A-AY	Looper Connecting Rod Comp. Set (9-16)	1 Pc.
11	502781	Screw for Looper Conn. Rod Complete Set	4 Pc.
12	502782	Ball Stud Guide L.D.M.	1 Pc.
13	502783	Screw for Ball Stud Guide	1 Pc.
14	502784	Looper Driving Ecentric Crank	1 Pc.
15/16	502785/86	Screw for Looper Driving Ece	2 Pc.
17	502787	Looper Driving Shaft	1 Pc.
17A	502787A-AY	Looper Driving Shaft Comp Assy (17-28)	1 set
18	502788	Looper Link Holder	1 Pc.
19/20	502789/90	Screw for Looper Link Holder	2 Pc.
21	502791	Looper Driving Shaft Collar	1 Pc.
22	502792	Screw for Looper Driving Shaft Collar	2 Pc.
23	502793	Looper Link	1 Pc.
24	502794	Looper Link Pin (Long)	1 Pc.
25	502795	Looper Link Pin (Short)	1 Pc.
26	502796	Looper Oscillating Lever	1 Pc.
27	502797	Screw for Looper Oscillating	1 Pc.
28	502798	Screw for Looper Oscillating Lever	2 Pc.

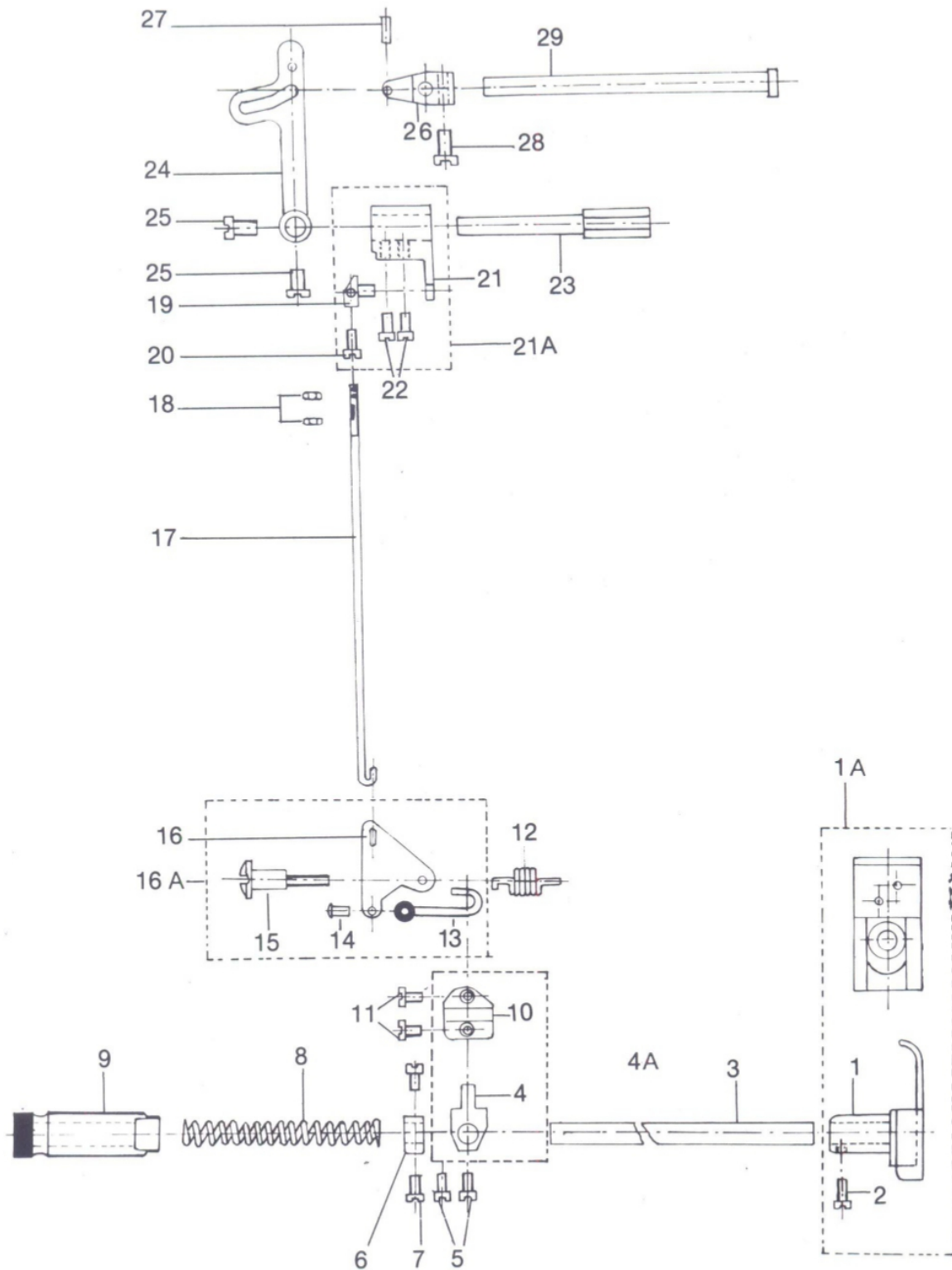
8. FEED DRIVING MECHANISM



8. FEED DRIVING MECHANISM

Sr. No.	Parts No.	Description	Amt. Req.
1	50281	Feed Bar Bracket	1 Pc.
1A	50281A-AY	Feed Bar Bracket Comp Assy (1,6,7,8,10)	1 set
2	50282	Feed Dog	1 Pc.
3	50283	Screw for Feed Dog	2 Pc.
4	50284	Needle Support (guard)	1 Pc.
5	50285	Screw for Needle Support (Guard)	2 Pc.
6	50286	Feed Dog Driving Lever Link Pin	1 Pc.
7	50287	Screw for Feed Dog Driving lever Link Pin	1 Pc.
8	50288	Feed Dog Driving Lever	1 Pc.
9	50289	Feed Bar	1 Pc.
9A	50289A-AY	Feed Bar Comp Assy. (9 to 11)	1 set
10	502890	Feed Bar pin	1 Pc.
11	502891	Screw for Feed Bar Pin	2 Pc.
12	502892	Feed Bar Shaft Coller	2 Pc.
13	502893	Screw for Feed Bar Shaft Coller	2 Pc.
14	502894	Feed Bar Lever	1 Pc.
15	502895	Screw for Feed Bar Lever	2 Pc.
16	502896	Feed dog Driving Conn. Rod Pin	1 Pc.
17	502897	Washer for Feed Dog Conn. Rod Pin	1 Pc.
18	502898	Nut for Feed Dog conn. Rod Pin	1 Pc.
19	502899	Feed Bar Shaft	1 Pc.
20	502810	Looper Driving Lever	1 Pc.
21	502811	Screw for Looper Driving Lever	2 Pc.
22	502812	Looper Driving Lever link pin	1 Pc.
23	502813	Screw for Looper Driving Lever Link Pin	1 Pc.
24	502814	Looper Oscillating Rod	1 Pc.
25	502815	Ball Bearing	2 Pc.
26	502816	Feed Dog Driving Conn. Rod	1 Pc.
24A	502814AY	Looper Oscillating Rod Assy. (20-25)	1 Pc.
26A	502816AY	Feed dog Driving Conn. Rod Assy.	1 Pc.

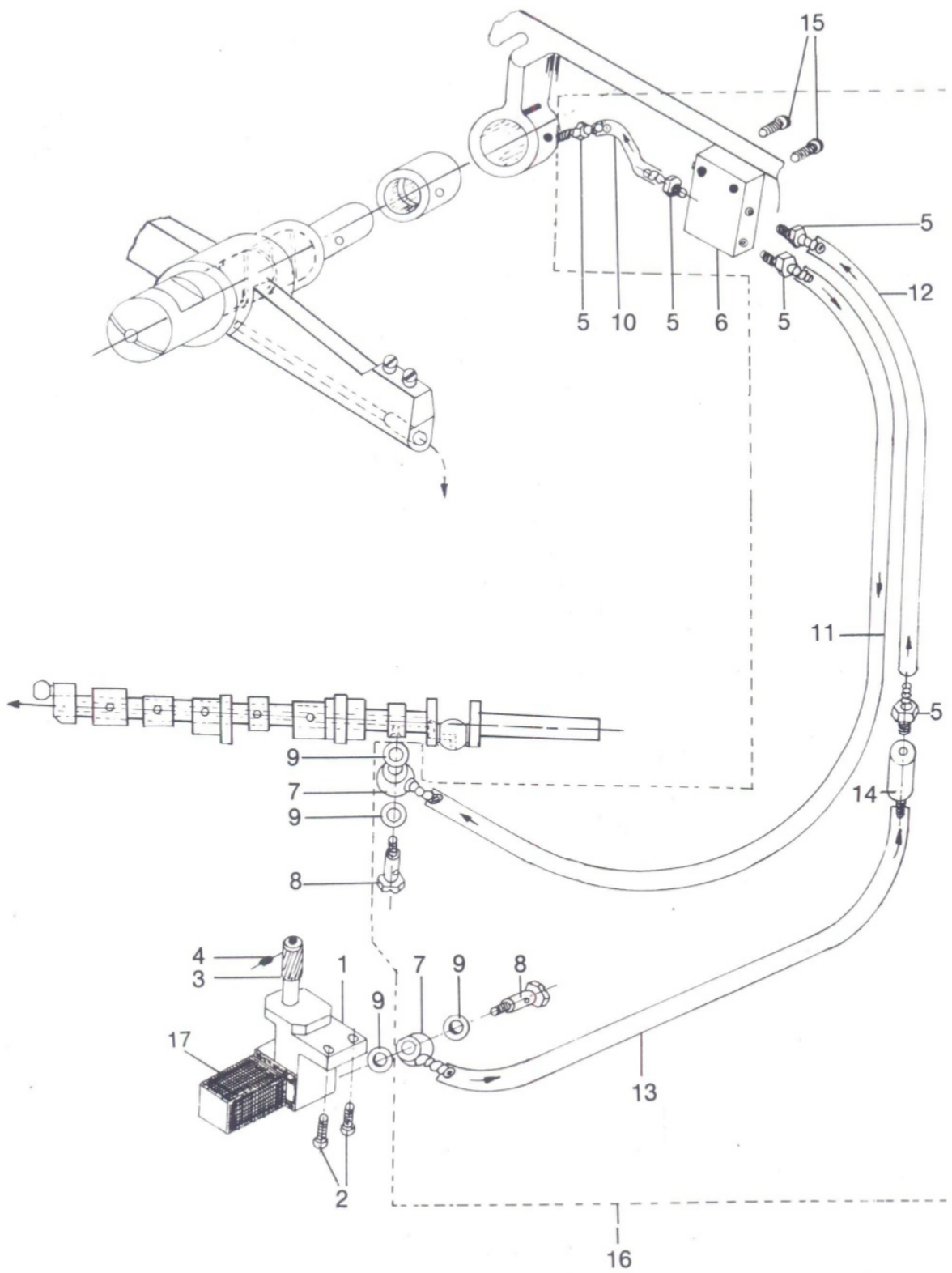
9. PRESSURE FOOT LIFTER MECHANISM



9. PRESSURE FOOT LIFTER MECHANISM

Sr. No.	Parts No.	Description	Amt. Req.
1	50291	Pressure Foot Complete Set	1 Pc.
1A	50291A-AY	Pressure Foot Complete Set	1 Set
2	50292	Screw for Pressure Foot	1 Pc.
3	50293	Pressure Bar	1 Pc.
4	50294	Pressure Bar Connecting Bkt.	1 Pc.
4A	50294A-AY	Pressure Bar Connecting Bkt. with Collar Comp. Set	1 Set
5	50295	Screw for Pressure Bar Connecting Bkt.	2 Pc.
6	50296	Pressure Shaft Collar	1 Pc.
7	50297	Screw for Pressure Shaft collar	2 Pc.
8	50298	Pressure Shaft Spring	1 Pc.
9	50299	Pressure Spring Regulator	1 Pc.
10	502910	Pressure Bar Guide	1 Pc.
11	502911	Screw for Pressure Bar Guide	2 Pc.
12	502912	Foot Lifter Spring	1 Pc.
13	502913	Foot Lifter Link	1 Pc.
14	502914	Stud for foot Lifter Link	1 Pc.
15	502915	Screw for Foot Lifter Driving Lever	1 Pc.
16	502916	Foot Lifter Driving Lever	1 Pc.
16A	502916A-AY	Foot Lifting Driving Lever	(13-16 set)
17	502917	Foot Lifting Connecting Rod	1 Pc.
18	502918	Nut for Foot Lifting Connecting Rod	2 Pc.
19	502919	Foot Lifter Connecting Adjusting Rod	1 Pc.
20	502920	Screw for Foot Lifter Connecting Adjusting Rod	1 Pc.
21	502921	Foot Lifter Link Lever	1 Pc.
21A	502921A-AY	Foot Lifter Link Lever Com. Assy.	1 Set
22	502922	Screw for Foot Lifter Link Lever	2 Pc.
23	502923	Foot Lifter shaft	1 Pc.
24	502924	Foot Lifter Lever (Handle)	1 Pc.
25	502925	Screw for Foot Lifter Handle	2 Pc.
26	502926	Tension Release Lever	1 Pc.
27	502927	Pin for Tension Release Lever	1 Pc.
28	502928	Screw for Tension Release Lever	1 Pc.
29	502929	Tension Release Shaft	1 Pc.

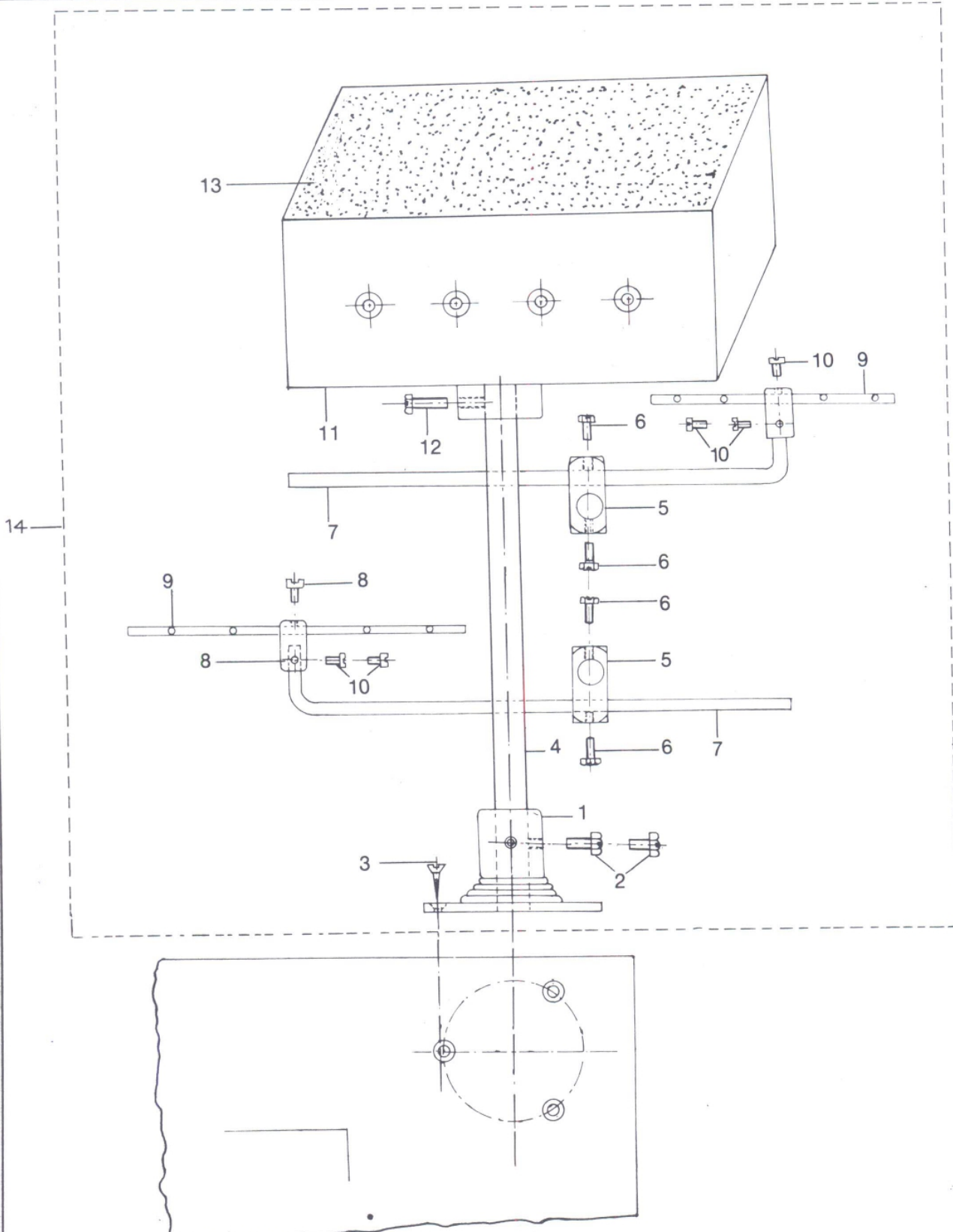
10. OIL LUBRICATING SYSTEM



10. OIL LUBRICATING SYSTEM

Sr. No.	Parts No.	Description	Amt. Req.
1	502101	Oil Pump Complete Set	1 pc.
2	502102	Screw for Oil pump Fittings	2 pc.
3	502103	Oil Pump Driving Worm Gear	1 pc.
4	502104	Screw for Worm Gear	2 pc.
5	502105	Oil Tube Fitting Knob	5 pc.
6	502106	Oil Tube Connection	1 pc.
7	502107	Oil Tube Fitting One Way End	2 pc.
8	502108	Oil Tibe Fitting Stud	1 pc.
9	502109	Fibar Washer	4 pc.
10	5021010	Oil Tube	1 pc.
11	5021011	Oil Tube	1 pc.
12	5021012	Oil Tube	1 pc.
13	5021013	Oil Tube	1 pc.
14	5021014	Oil Relief Valve	1 pc.
15	5021015	Screw for Upper Shaft Oil Nozzle	1 pc.
16	5021016	Oil System Comp Set	2 pc.
17	5021017	Oil filter	1 Set

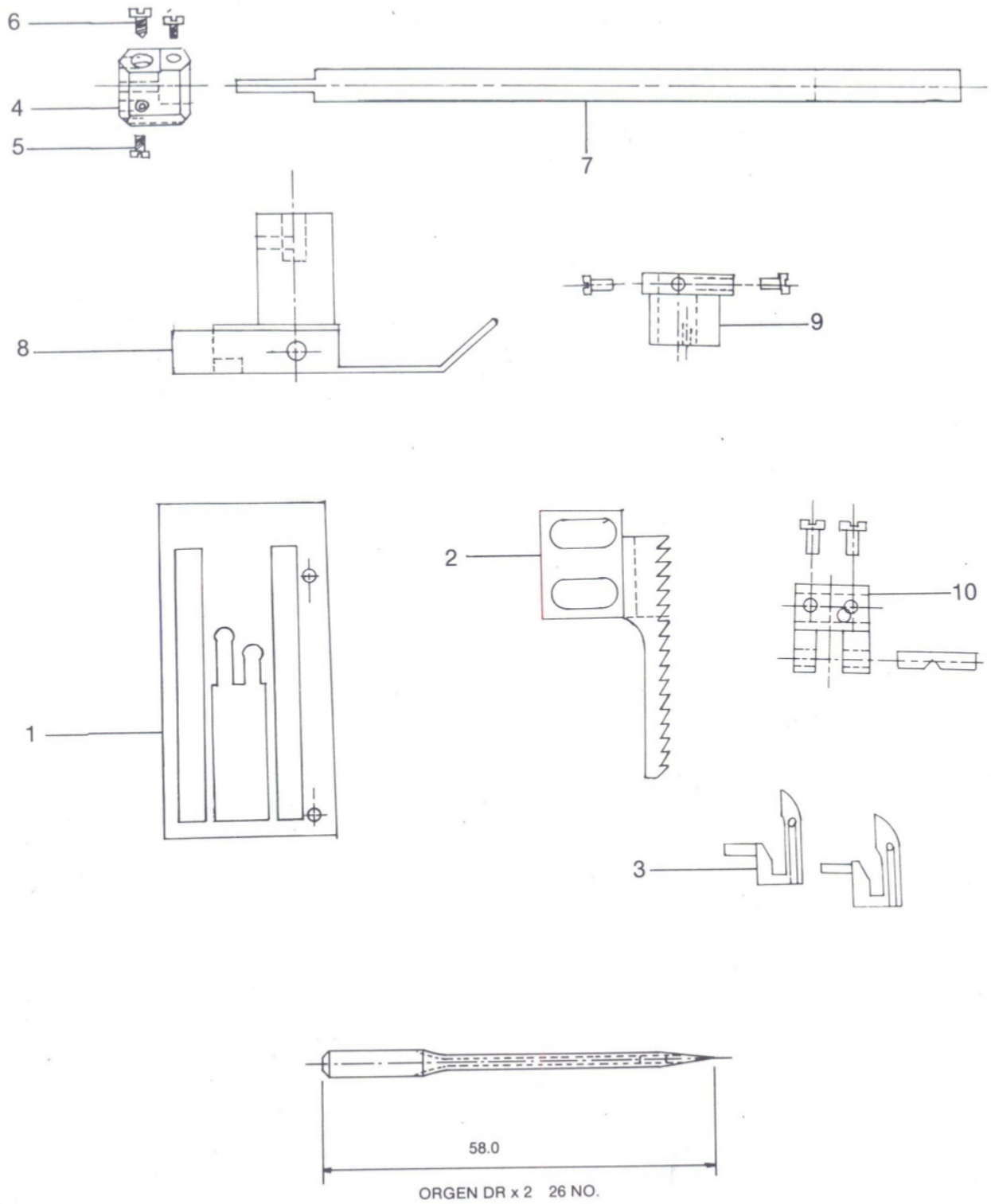
11. THREAD STAND



11. THREAD STAND

Sr. No.	Parts No.	Description	Amt. Req.
1	502111	Thread Stand Base	1 pc.
2	502112	Screw for Thread Stand Base	3 pc.
3	502113	Wooden Screw	3 pc.
4	502114	Main Rod	1 pc.
5	502115	Thread guide Holder	2 pc.
6	502116	Screw for Thread guide Holder	4 pc.
7	502117	Thread guide Bar (L types)	2 pc.
8	502118	Thread Guide Bar Bracket	2 pc.
9	502119	Thread Guide (Big)	2 pc.
10	5021110	Screw for Thread Guide Bkt.	2 pc.
11	5021111	Thread Lubrication Box	1 pc.
12	5021112	Screw for Lubrication Box	2 pc.
13	5021113	U Foam	1 set
14	5021114	Thread guide stand compassy (1-13) set	

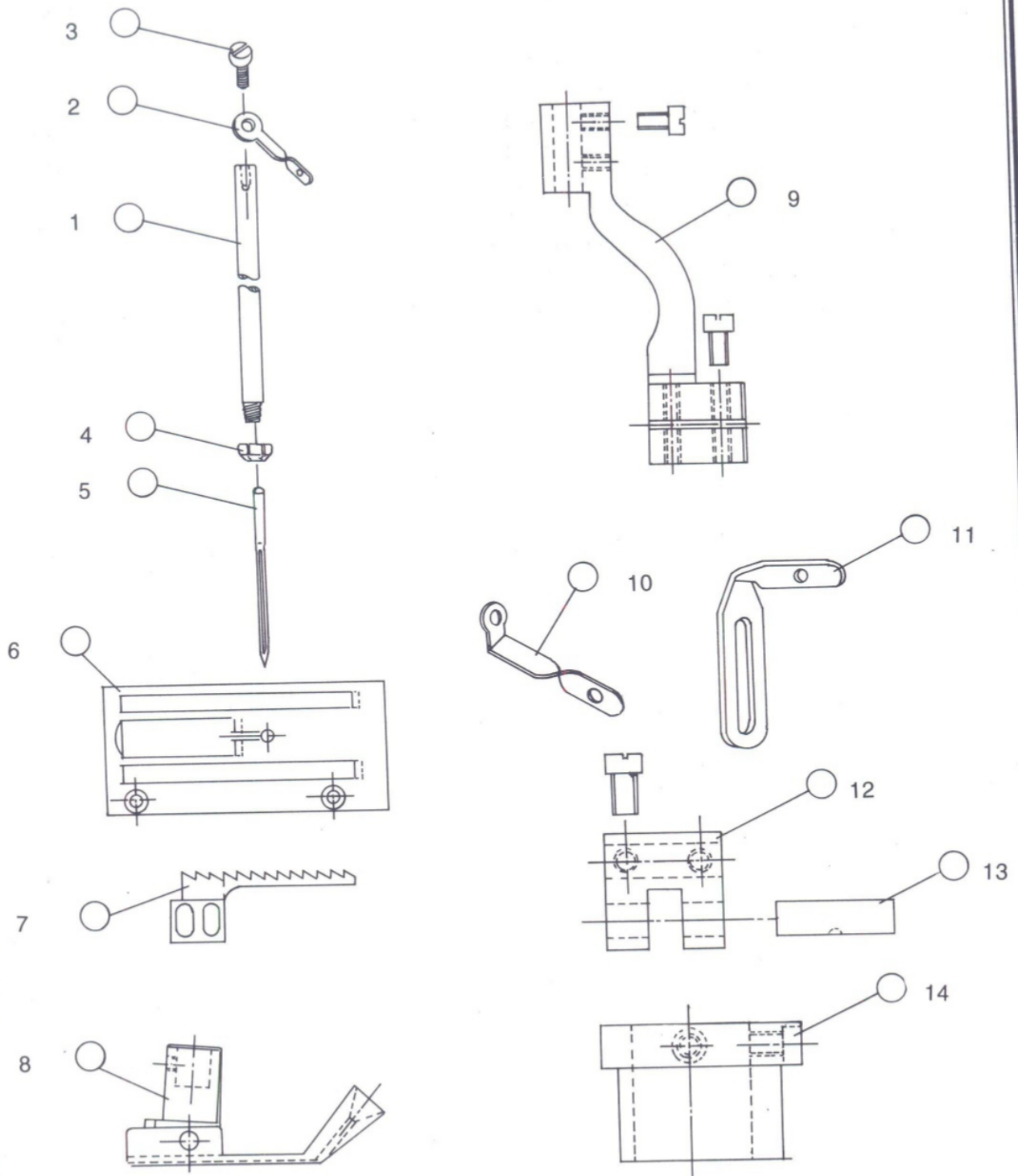
12. DIFFERENT PARTS FOR JUTE MACHINE



12. DIFFERENT PARTS FOR JUTE MACHINE

Sr. No.	Parts No.	Description	Amt. Req.
1	502J121	Throat Plate	1 No.
2	502J122	Feed Dog	1 No.
3	502J123	Looper	2 pc.
4	502J124	Needle Holder	1 No.
5	502J125	Screw for Needle Holder	1 No.
6	502J126	Screw for Needle Holder	2 pc.
7	502J127	Needle Bar	2 pc.
8	502J128	Pressure Foot	1 No.
9	502J129	Feed Dog Regulating Control Ecc.	1 No.
10	502J1210	Looper Driving Lever	1 No.
11	502J1211	Needle DR x 2	2 pc.

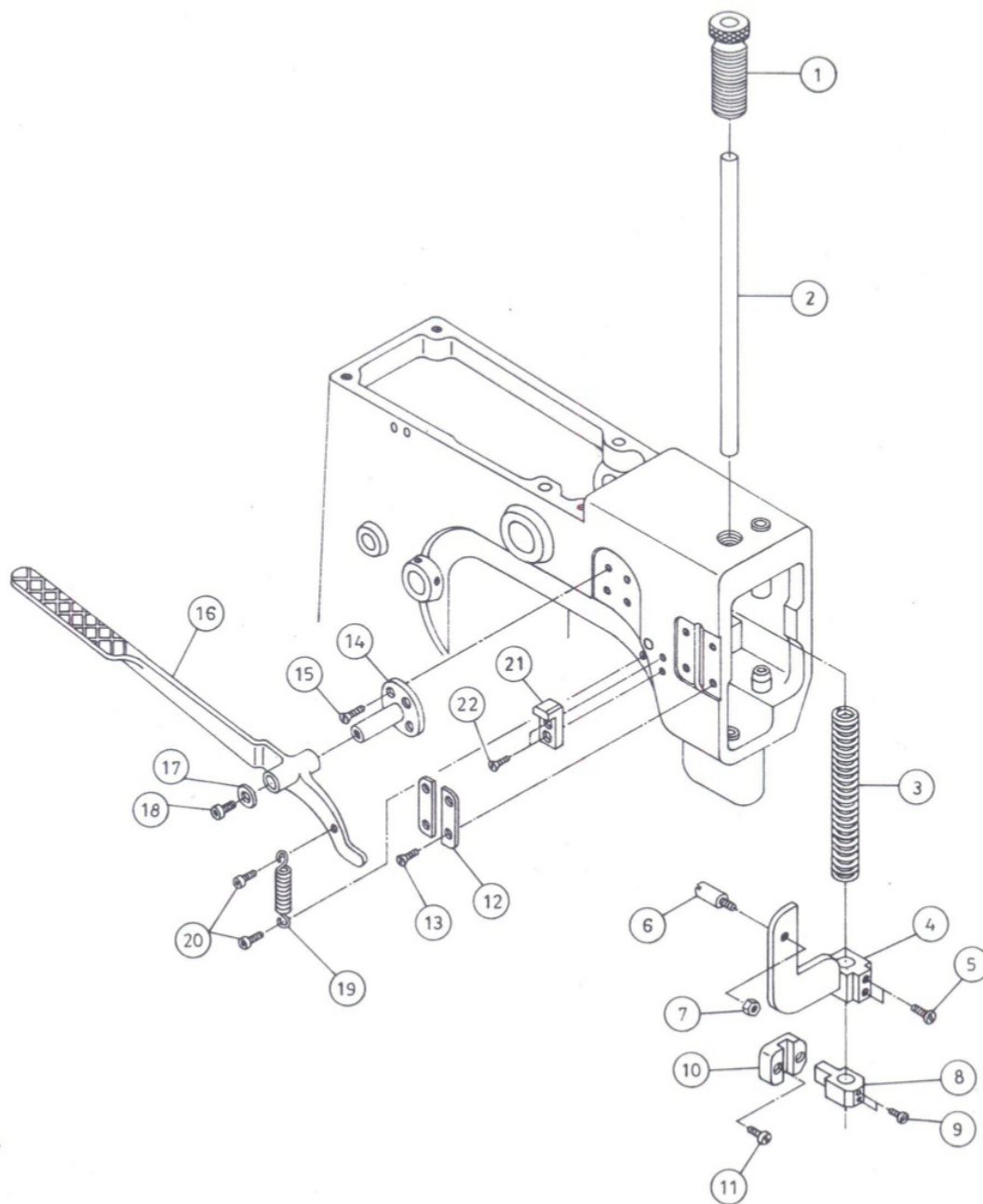
13. SPECIAL PARTS FOR PAPER BAG MACHINE



13. SPECIAL PARTS FOR PAPER BAG MACHINE

Sr. No.	Parts No.	Description	Amt. Req.
1	502P131	Needle Bar	1 No.
2	502P132	Needle Bar Thread Eyelet	1 No.
3	502P133	Screw Needle Bar Thread Eyelet	2 pc.
4	502P134	Needle Clamp Nut	1 No.
5	502P135	Needle	1 No.
6	502P136	Throat Plate	2 pc.
7	502P137	Feed Dog	2 pc.
8	502P138	Pressure Foot	1 No.
9	502P139	Looper Hoder Bkt.	1 No.
10	502P1310	Needle Thread Take-up	1 No.
11	502P1311	Needle Thread Eyelet	2 pc.
12	502P1312	Looper Driving Lever	1 No.
13	502P1313	Looper Driving Liver Link Pin	1 No.
14	502P1314	Feed Dog Driving Control Ecc.	1 No.

14. NEW TYPE PRESSURE FOOT LIFTER PARTS



14. NEW TYPE PRESSURE FOOT LIFTER PARTS

Sr. No.	Parts No.	Description	Amt. Req.
1	502141	Pressure Bar Regulating Knob	1. Pc.
2	502142	Pressure Bar	1. Pc.
3	502143	Pressure Bar Spring	1. Pc.
4	502144	Pressure Bar Lifter Bracket	1. Pc.
5	502145	Screw for Pressure Bar Lifter Bracket	2. Pc.
6	502146	Stud For Pressure Bar Lifter Bracket	1. Pc.
7	502147	Nut For Stud	1. Pc.
8	502148	Pressure Bar Connecting Bracket	1. Pc.
9	502149	Screw for Pressure Bar Connecting Bracket	2. Pc.
10	5021410	Pressure Bar Guide	1. Pc.
11	5021411	Screw For Pressure Bar Guide	2. Pc.
12	5021412	Guide Plate	2. Pc.
13	5021413	Screw For Guide Plate	4. Pc.
14	5021414	Pressure Foot Lifter Lever Bracket	1. Pc.
15	5021415	Screw For Pressure Foot Lifter Lever Bracket	4. Pc.
16	5021416	Pressure Foot Lifter Lever Handle	1. Pc.
17	5021417	Washer For Pressure Foot Lifter Lever Handle	1. Pc.
18	5021418	Screw For Pressure Foot Lifter Lever Handle	1. Pc.
19	5021419	Spring For Pressure Foot Lifter Lever Handle	1. Pc.
20	5021420	Screw For Spring	2. Pc.
21	5021421	Pressure Foot Lifter Lever Handle Stopper	1. Pc.
22	5021422	Screw For Stopper	2. Pc.

Packing List of the
***"Gabbar"* Machine Accessories**

1. Thread Guide stand with oil tank complete set 1
2. Wooden angle 1 pc.
3. Feed dog 1 pc.
4. Looper 1 set
5. Needle 4 Pcs.
6. Scissor 1 pc.
7. Screw Driver 2 Pc.
8. Spanner 8 x 10 Number 1 Pc.
9. Rod for Foot Leg 1 set.
10. V-belt 1 Pc.
11. Booklet 1 Pc.
12. Oil Cane 1 Pc.
13. Brush 1 Pc.
14. Clamper 1 Pc.

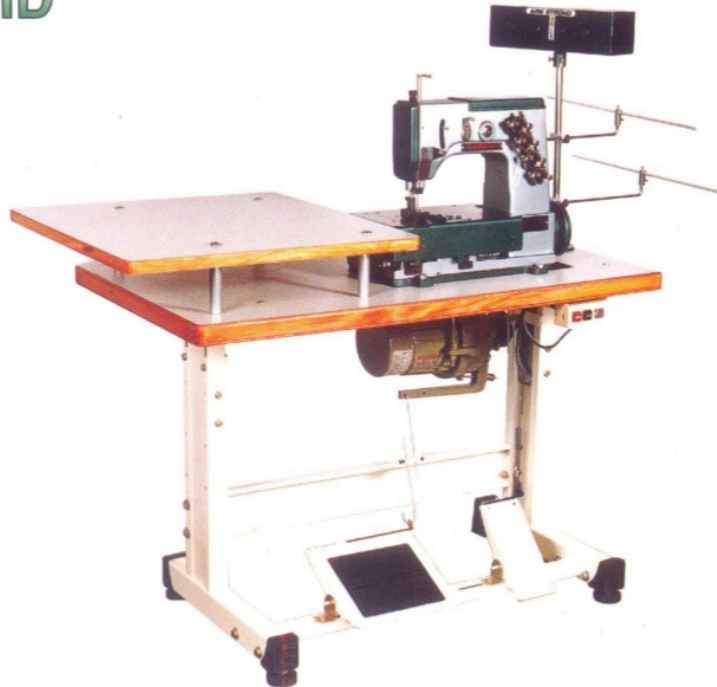
GabbarTM

BAG SEWING MACHINE

MODEL

ST 502 - HD

ST 502 - JHD



Manufactured By :

Gabbar
Engineering Co.

Plot No. 1903, Phase III, G.I.D.C., Vatwa, Ahmedabad - 382 445. GUJARAT-INDIA

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