

Gabbar™

BIG BAGS SEWING MACHINE

INSTRUCTION MANUAL / PARTS LIST



Model No. ST 603 DR

Manufactured By :

**Gabbar
Engineering Co.**

Gujarat, India.



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INTRODUCTION

1) INTRODUCTION :

We express our heartfelt thanks for your purchase of the sewing machine.

For all user of the machine, this Instruction Book has been ready with explanations all about its operation, adjustment 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

2) Classification of Machine :

MODEL NO.

ST 603 DR

DESCRIPTION

Single Needle Plain Feed Flat bed,
Double Thread Chain Stitch Hemming Machine.

SEFETY PRECAUTION & CHECK

3)

A) Safety Precaution :

- a) Always turn power off before threading, oiling and adjusting the machine or replacing parts.
- b) Make sure, all covers and guards must be in position before operating machine.
- c) Do not touch on the machine when it is running.
- d) Wear safety glasses.

B) Check :

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

SPECIFICATION

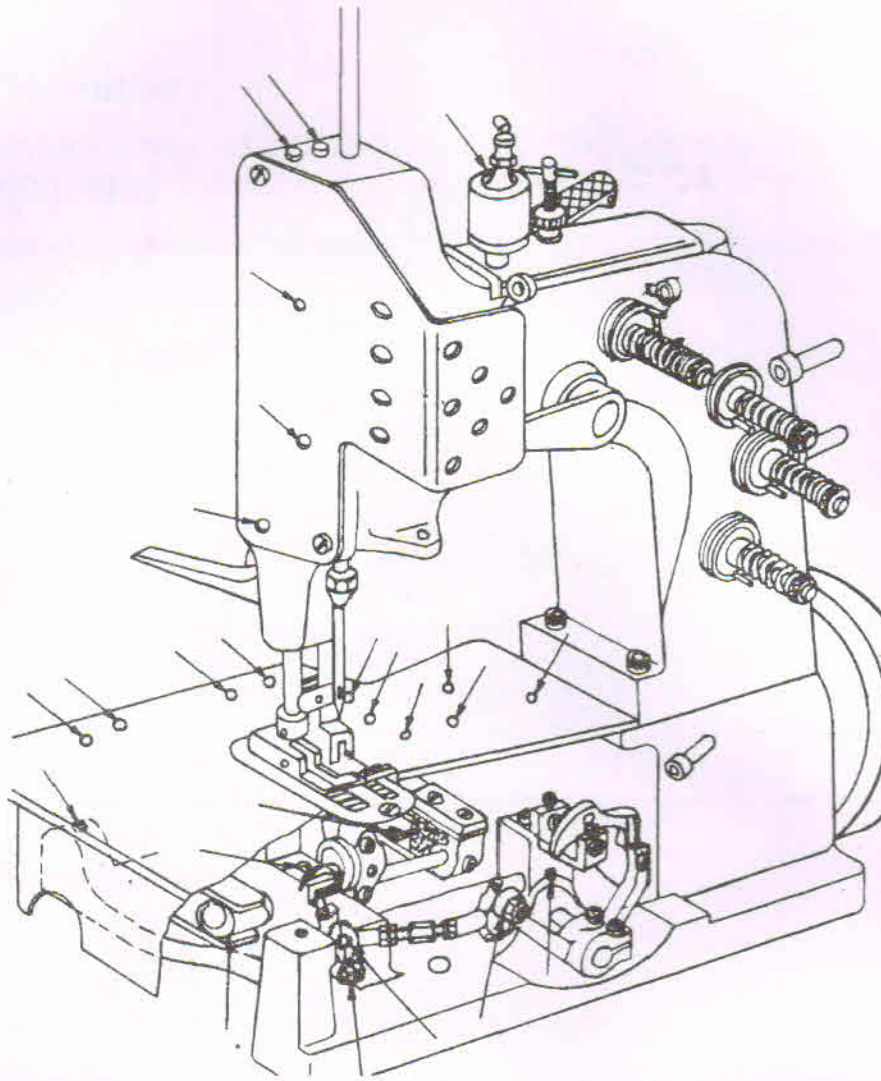
MODEL NO.	ST 603 DR
Max. Speed	2000 r. p. m.
Working Speed	1800 r. p. m.
No. of Needle	1 Needle
No. of Thread	2 Thread
Stitch Range	6.5 to 13 mm
Maximum thickness of material	11 mm
Needle type and size	DR x 2-28 (ORGEN)
Thread	Jute or pp/pe, multiple filament or Fabricted Yarns.
Motor Speed	1/2 H. P. 2850 r. p. m. 1 Phase or 3 Phase

APPLICATION

4) Application :

For Hemming of light weight to heavy weight jute or pp/pe woven cloth bags, Jumbo bags.

OILING DIAGRAM



6. OILING OF THE MACHINE

Fill Oiling System and oil all bearing, particularly the eccentrics and feed cam oil felt on the main shaft. Oiling the machine everyday as per the indication in the Oiling Diagram.

7. ADJUSTING INSTRUCTION :

7-1 SETTING NEEDLE

Before adjusting the machine, insert new needle into the needle bar as deep as it will go. The long groove of the needle should face the operator. Tighten the needle bar nut (603348) firmly :

NOTE :

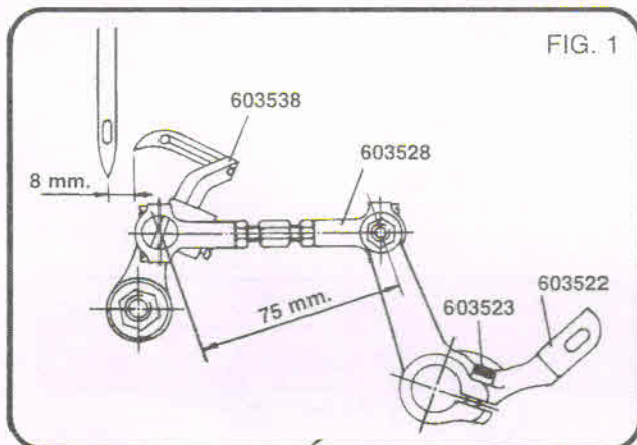
Improper needle setting, a crooked needle, and worn out needle point and hole are possible causes of thread breaking and skipping.

7-2 ADJUSTING LOOPER (See Fig. 1)

Place the Looper in the Looper Holder and When Needle are at their Lowest Position and Looper is at Extreme right of the movement distance of Looper Point from centre of Needle shall be 8 mm This adjustment is made by loosening screw. (603523)

NOTE :

- (1) If the distance between the needle center and the looper point is shorter than 8 mm, "double stitching" will be caused while the thread may skip if it is larger.
- (2) If there is no clearance between the needle and the looper, with the needle contacting the looper, the former will be damager and thread break will be caused. Thread may skip if the clearance is too large.



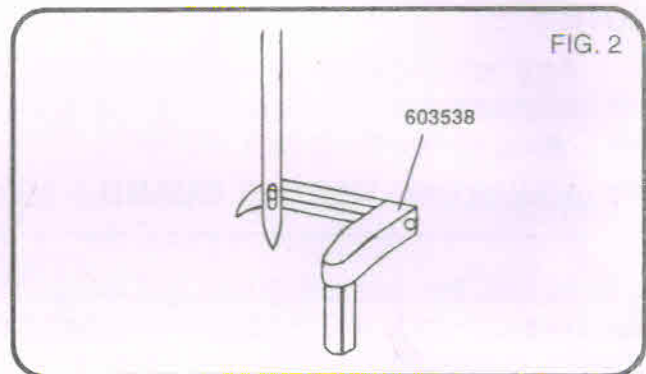
7-3 SETTING OF BALL JOINT ASSY. (603528A) (See Fig. 1)

While Setting the Ball Joint (Right) or (Left) the Distance between the Centre of Ball Joint (Right) and Center of Ball Joint (Left) must be 75 mm.

7-4 SETTING HEIGHT OF NEEDLE BAR (See Fig. 2)

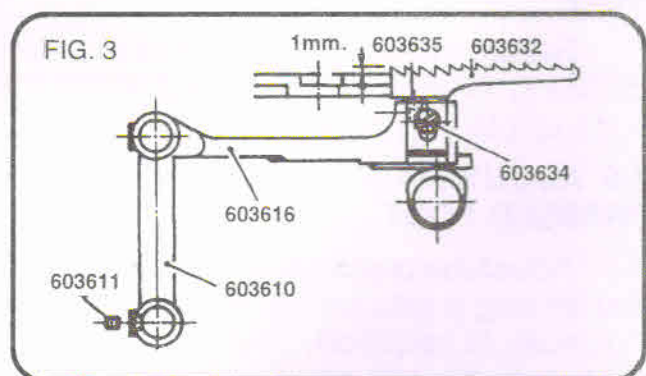
(See Fig. 2)

Adjust the height of the needle bar (603347) so that the Needle hole and the looper hole coincide as shown in (Fig. 2) during the looper point's movement towards the left. The clearance between the needle and the point of looper should be 0.2 mm when looper moves to the left and reach needle. this adjustment is done by loosening screw (603517) of looper avoid eccentric fork. (603516)



7-5 ADJUSTING FEED DOG (See Fig. 3)

The height of the feed dog is correct when, at its highest point of travel, the rear-most teeth project above the throat plate by 1 mm as shown in Fig 3.



7-6 ADJUSTING STITCH LENGTH

(See Fig. 4)

The stitch length adjustable in the range of 6.5 to 13 mm. Your machine is set at the standard stitch length of 10 mm in our plant before shipment. To adjust, loosen the nut (60369) of the feed regulating stud (60367) which connects the feed Bar (603610) and the feed Drive Conn. Bkt. (60362) and move the feed regulating stud vertically. Bringing down the feed regulating stud makes the stitch longer and moving it up shorter. after the adjustment never forget to tighten the nut.

NOTE :

Any change in the stitch length will necessitate a corresponding change in the setting of needle guard (603623)

7-7 ADJUSTING NEEDLE GUARD :

(See Fig. 5)

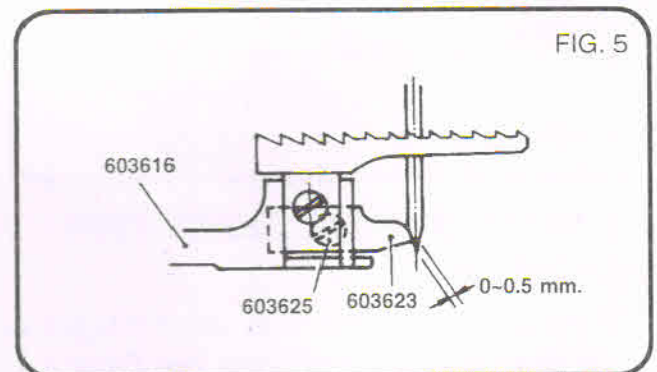
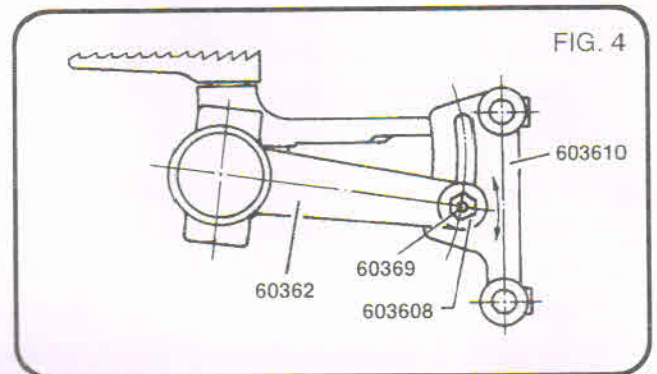
Mount the needle guard (603623) on the feed bar bkt. (603616). and adjust its position in the groove of the feed bar, so that it will just contact the needle as the needle goes up. Hold the guard in position securely by tightening the screw (603625). To confirm the proper adjustment, turn the pulley counterclockwise to check if the needle clicks on the guard. If it does, the guard is pushing the needle and Readjustment is necessary.

NOTE :

Readjustment of the needle guard (603623) is always necessary when the stitch length is changed.

7-8 ADJUSTING PRESSURE OF PRESSER FOOT

Adjust the pressure of pressure foot so that feeding is satisfactory. Relatively Strong Pressure is required. This adjustment is made by tightening or loosening of pressure foot spring screw (60344).



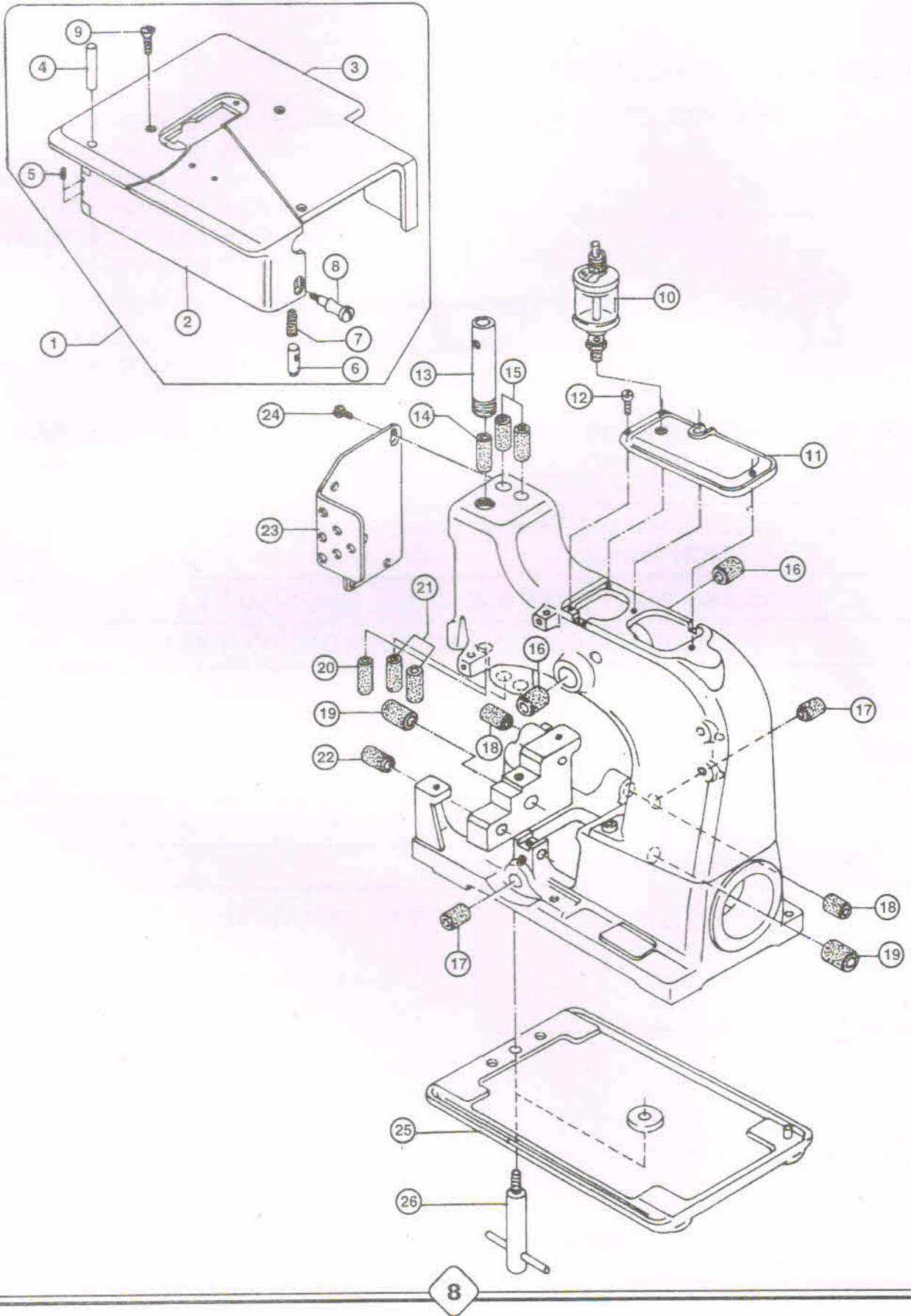
IDENTIFICATION AND ORDERING PARTS :

While all orders, please include part number, part name and model name of machine.

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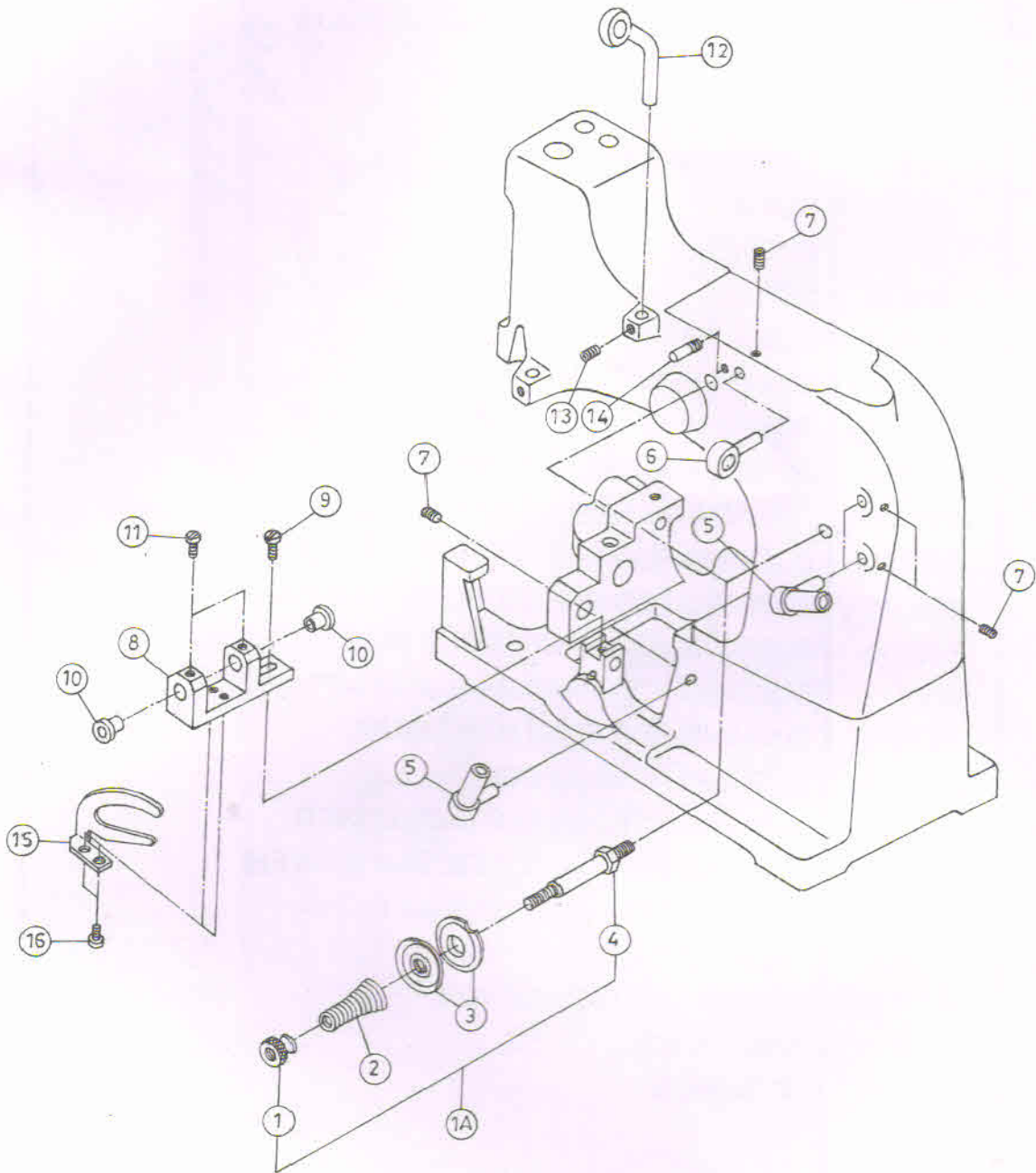
[1] BUSHING, OILER AND COVER PARTS



[1] BUSHING, OILER AND COVER PARTS

SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60311	CLOTH PLATE ASSY.	1
2	60312	CLOTH PLATE SWINGING EXTENSION	1
3	60313	CLOTH PLATE	1
4	60314	PIN	1
5	60315	SCREW FOR PIN	2
6	60316	GUIDE	1
7	60317	SPRING	1
8	60318	SCREW	1
9	60319	SCRW FOR CLOTH PLATE	3
10	603110	SIGHT FEED OILER	1
11	603111	TOP COVER	1
12	603112	SCREW FOR TOP COVER	3
13	603113	GUARD FOR NEEDLE BAR	1
14	603114	BUSHING FOR NEEDLE BAR (UPPER)	1
15	603115	BUSHING FOR PRESSURE BAR (UPPER)	2
16	603116	BUSHING FOR NEEDLE BKT. SHAFT	2
17	603117	BUSHING FOR TRANSVERSE SHAFT	2
18	603118	BUSHING FOR FEED BAR SHAFT	2
19	603119	BUSHING FOR MAIN SHAFT	2
20	603120	BUSHING FOR NEEDLE BAR (LOWER)	1
21	603121	BUSHING FOR PRESSURE BAR (LOWER)	2
22	603122	BUSHING FOR LOOPER SHAFT	2
23	603123	FACE COVER	1
24	603124	SCREW FOR FACE COVER	2
25	603125	BASE PLATE	1
26	603126	"T" SCREW	2

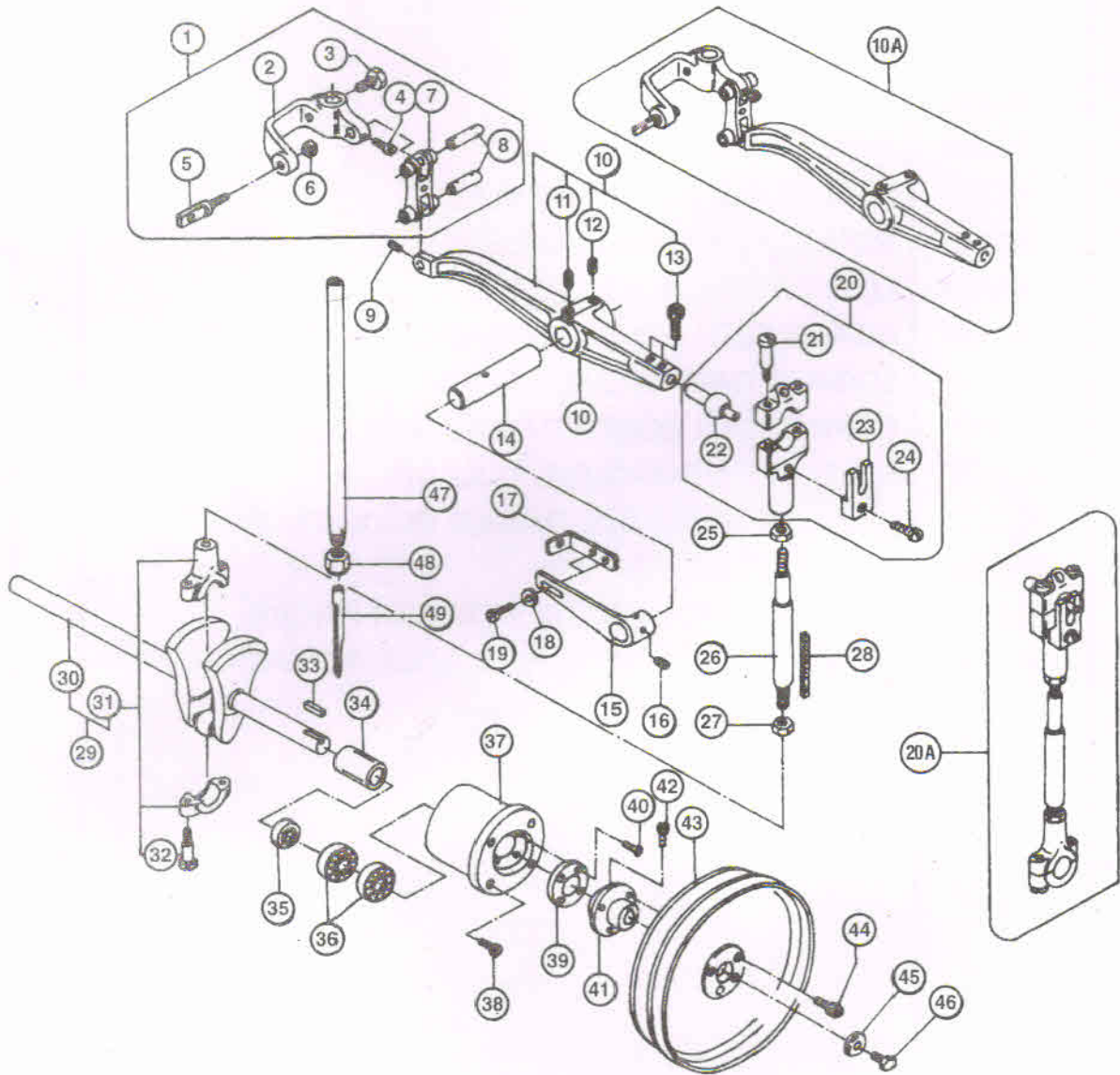
[2] MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS



(2) MISCELLANEOUS THREAD GUIDE AND THREAD TENSION PARTS

SR. NO.	PART NO.	DESCRIPTION	QTY.
1A	60321A	TENSION UNIT ASSLY.	2 SET
1	60321	TENSION REGULATING NUT	2
2	60322	TENSION SPRING	2
3	60323	TENSION DISC	4
4	60324	TENSION STUD	2
5	60325	THREAD SLEEVE	3
6	60326	NEEDLE THREAD GUIDE SLEEVE	1
7	60327	SCREW FOR THREAD SLEEVE	4
8	60328	LOOPER THREAD GUIDE BKT.	1
9	60329	SCREW FOR LOOPER THREAD GUIDE BKT.	1
10	603210	LOOPER THREAD GUIDE BUSH	2
11	603211	SCREW FOR LOOPER THREAD GUIDE BUSH	2
12	603212	NEEDLE THREAD GUIDE TAKE-UP	1
13	603213	SCREW FOR NEEDLE THREAD GUIDE TAKE-UP	1
14	603214	TENSION DISC STOP PIN	1
15	603215	LOOPER THREAD GUIDE RETAINER FINGER	1
16	603216	SCREW FOR LOOPER THREAD GUIDE RETAINER FINGER	2

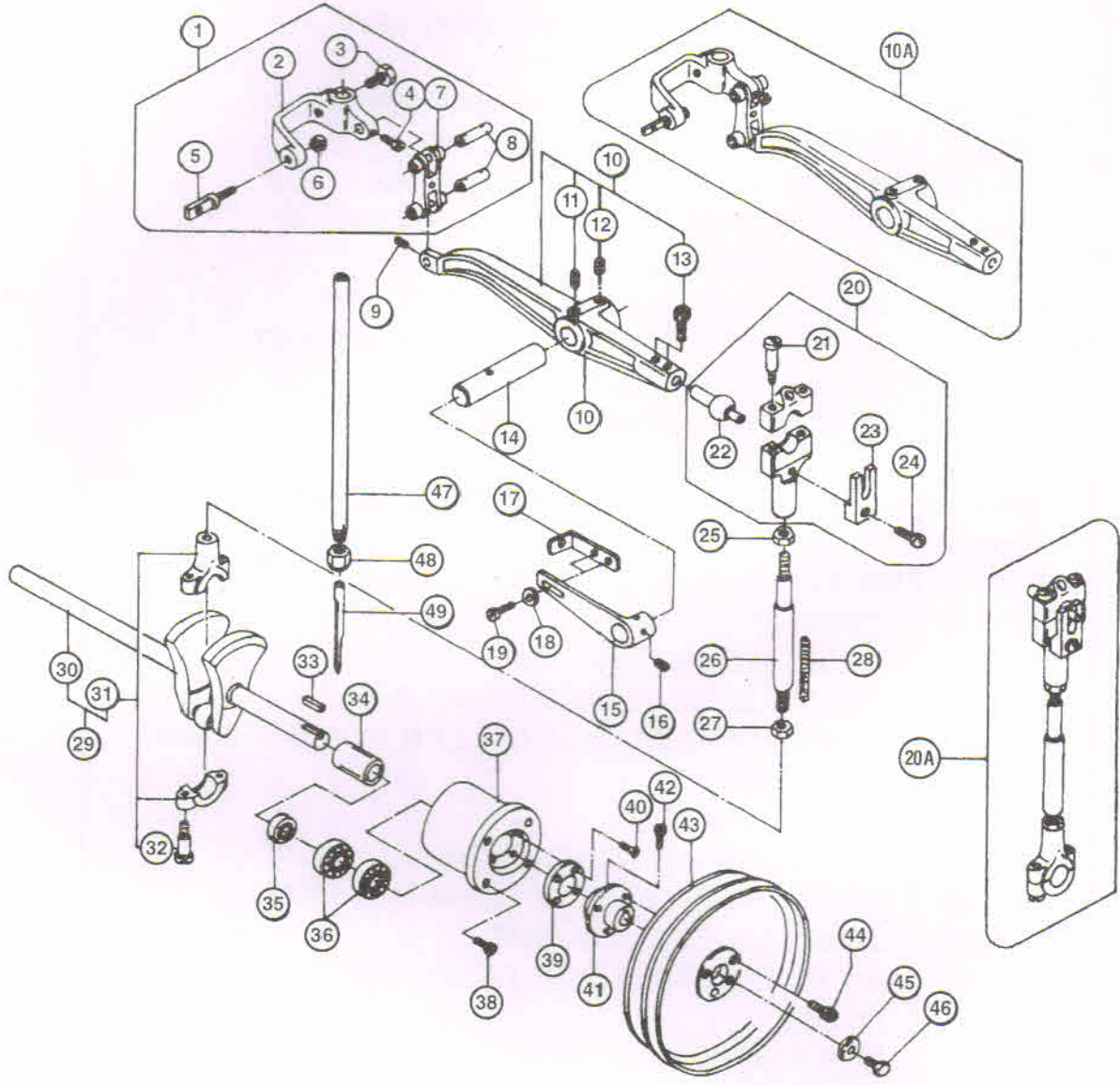
[3] NEEDLE BAR, PULLEY AND CRANK SHAFT PARTS



[3] NEEDLE BAR, PULLEY AND CRANK SHAFT PARTS

SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60331	NEEDLE BAR CONNECTING BKT. ASSY.	1
2	60332	NEEDLE BAR CONNECTING BKT.	1
3	60333	SCREW FOR NEEDLE BAR CONN. BKT.	1
4	60334	SCREW FOR NEEDLE BAR CONN. LINK	1
5	60335	NEEDLE THREAD TAKEUP	1
6	60336	NUT FOR NEEDLE THREAD TAKE UP	1
7	60337	NEEDLE BAR CONNECTING LINK	1
8	60338	NEEDLE BAR CONNECTING LINK PIN	2
9	60339	SCREW FOR NEEDLE BAR CONN. LINK PIN	1
10	603310	NEEDLE BAR DRIVING CRANK BKT.	1
10A	603310A	NEEDLE BAR DRIVING CRANK BKT. ASSY.	1
11/12	603311/12	SCREW FOR NEEDLE BAR DRIV. CRANK BKT.	2
13	603313	SCREW FOR BALL STUD	2
14	603314	NEEDLE BAR DRIVING CRANK BKT. SHAFT	1
15	603315	NEEDLE THREAD GUIDE BKT.	1
16	603316	SCREW FOR NEEDLE THREAD GUIDE BKT.	2
17	603317	NEEDLE THREAD GUIDE	1
18	603318	WASHER FOR NEEDLE THREAD GUIDE	2
19	603319	SCREW FOR NEEDLE THREAD GUIDE	2
20	603320	NEEDLE LEVER CONN. ROD BKT. (SMALL) ASSY.	1
20A	603320A	NEEDLE LEVER CONN. ROD BKT. ASSY.	1
21	603321	SCREW FOR NEEDLE LEVER CON. ROD BKT. (SMALL)	2
22	603322	BALL STUD	1
23	603323	BALL STUD GUIDE	1
24	603324	SCREW FOR BALL STUD GUIDE	1
25	603325	NUT FOR NEEDLE LEVER CONN. ROD (SMALL)	1
26	603326	NEEDLE LEVER CONN. ROD	1
27	603327	NUT FOR NEEDLE LEVER CONN. ROD (BIG)	1
28	603328	OIL FELT	1
29	603329	MAIN SHAFT ASSY.	1
30	603330	MAIN SHAFT	1
31	603331	NEEDLE LEVER CONN. ROD BKT. (BIG)	1
32	603332	SCREW FOR NEEDLE LEVER CONN. ROD BKT. (BIG)	2
33	603333	KEY FOR CRANK SHAFT	1
34	603334	COLLAR	1
35	603335	OIL SEAL	1

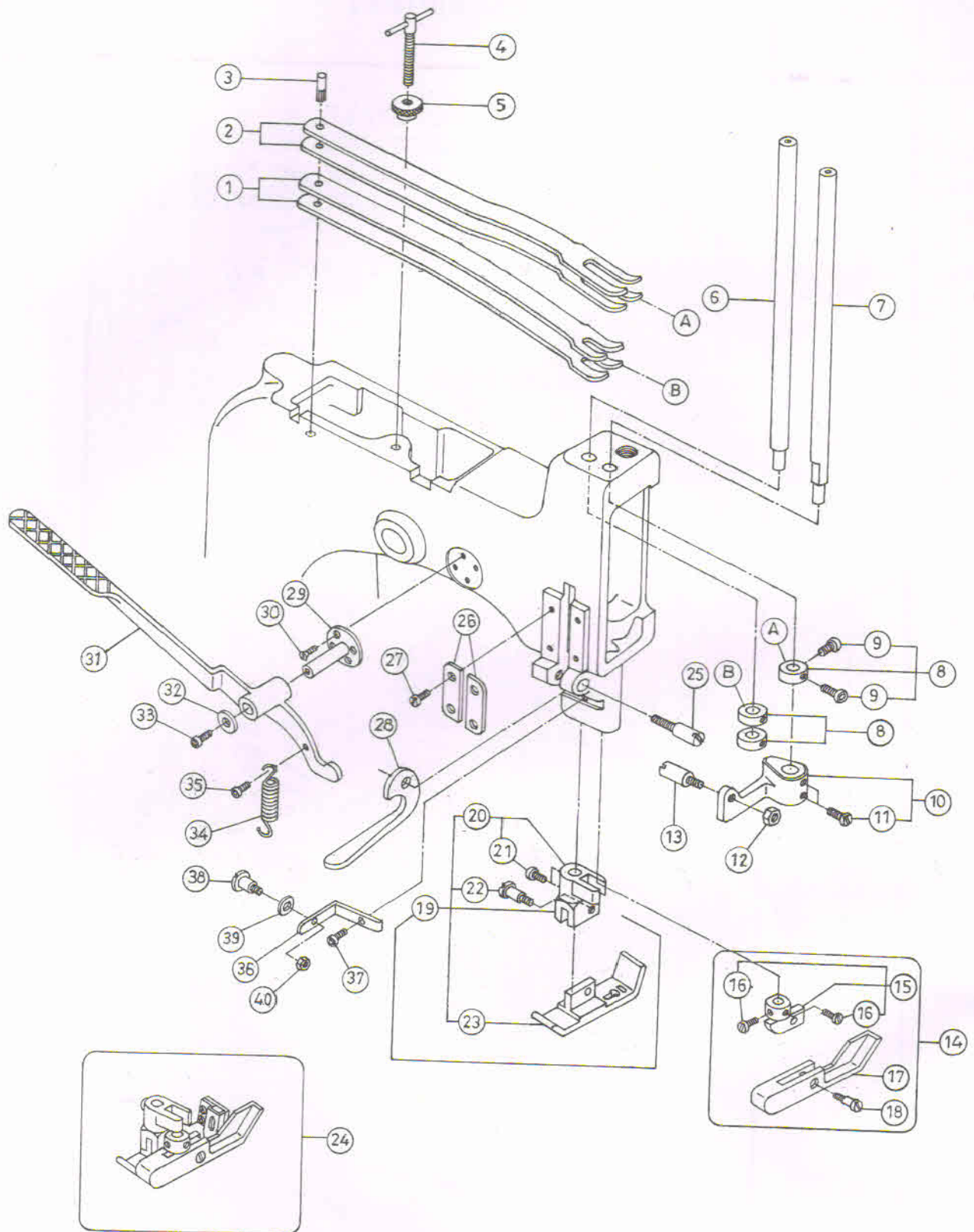
[3] NEEDLE BAR, PULLEY AND CRANK SHAFT PARTS



[3] NEEDLE BAR, PULLEY AND CRANK SHAFT PARTS

SR. NO.	PART NO.	DESCRIPTION	QTY.
36	603336	BEARING (6302 ZZ)	2
37	603337	CRANK SHAFT BEARING HOUSING	1
38	603338	SCREW FOR CRANK SHAFT BEARING HOUSING	4
39	603339	COVER FOR CRANK SHAFT BEARING HOUSING	1
40	603340	SCREW FOR CRANK SHAFT BEARING HOUSING COVER	4
41	603341	PULLEY HOLDER	1
42	603342	SCREW FOR PULLEY HOLDER	2
43	603343	PULLEY	1
44	603344	SCREW FOR PULLEY	4
45	603345	PULLEY WASHER	1
46	603346	SCREW FOR PULLEY WASHER	1
47	603347	NEEDLE BAR	1
48	603348	NEEDLE CLAMP NUT	1
49	603349	NEEDLE (DR 2-28)	1

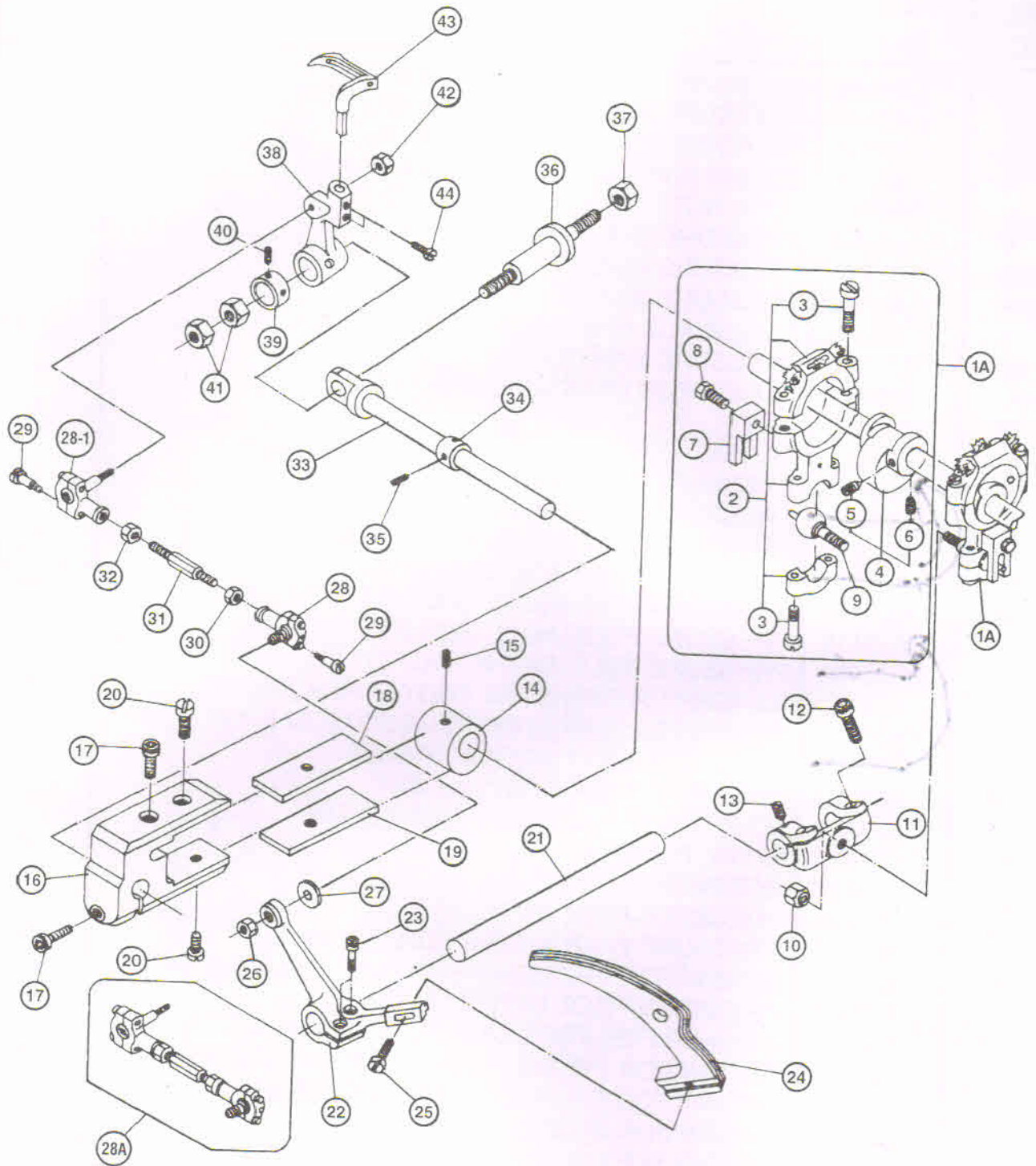
(4) PRESSURE FOOT LIFTER AND PRESSURE FOOT PARTS



(4) PRESSURE FOOT LIFTER AND PRESSURE FOOT PARTS

SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60341	PRESSURE FOOT SPRING (LOWER)	2
2	60342	PRESSURE FOOT SPRING (UPPER)	2
3	60343	PIN FOR PRESSURE FOOT SPRING	1
4	60344	SCREW FOR PRESSURE FOOT SPRING	1
5	60345	LOCK NUT	1
6	60346	PRESSURE BAR (RIGHT)	1
7	60347	PRESSURE BAR (LEFT)	1
8	60348	PRESSURE BAR COLLAR	3
9	60349	SCREW FOR PRESSURE BAR COLLAR	6
10	603410	PRESSURE BAR GUIDE	1
11	603411	SCREW FOR PRESSURE BAR GUIDE	2
12	603412	NUT	1
13	603413	SCREW	1
14	603414	PRESSURE FOOT ASSY. (LEFT)	1
15	603415	PRESSURE FOOT SHANK (LEFT)	1
16	603416	SCREW FOR PRESSURE FOOT SHANK (LEFT)	2
17	603417	PRESSURE FOOT BOTTOM (LEFT)	1
18	603418	SCREW FOR PRESSURE FOOT BOTTOM (LEFT)	1
19	603419	PRESSURE FOOT ASSY. (RIGHT)	1
20	603420	PRESSURE FOOT SHANK (RIGHT)	1
21	603421	SCREW FOR PRESSURE FOOT SHANK (RIGHT)	2
22	603422	SCREW FOR PRESSURE FOOT BOTTOM (RIGHT)	1
23	603423	PRESSURE FOOT BOTTOM (RIGHT)	1
24	603424	PRESSURE FOOT ASSY. (14-25)	1
25	603425	SCREW FOR PRESSURE FOOT LIFTER	1
26	603426	GUIDE PLATE	2
27	603427	SCREW FOR GUIDE PLATE	4
28	603428	PRESSURE FOOT LIFTER	1
29	603429	PRESSURE FOOT LIFTER LEVER BRACKET	1
30	603430	SCREW FOR PRESSURE FOOT LIFTER LEVER BKT.	4
31	603431	PRESSURE FOOT LIFTER LEVER	1
32	603432	WASHER FOR PRESSURE FOOT LIFTER LEVER	1
33	603433	SCREW FOR PRESSURE FOOT LIFTER LEVER	1
34	603434	SPRING FOR PRESSURE FOOT LIFTER LEVER	1
35	603435	SCREW FOR SPRING	1
36	603436	SPRING SUPPORTER	1
37	603437	SCREW FOR SPRING SUPPORTER	2
38	603438	SCREW FOR SPRING	1
39	603439	WASHER FOR SCREW	1
40	603440	NUT FOR SCREW	1

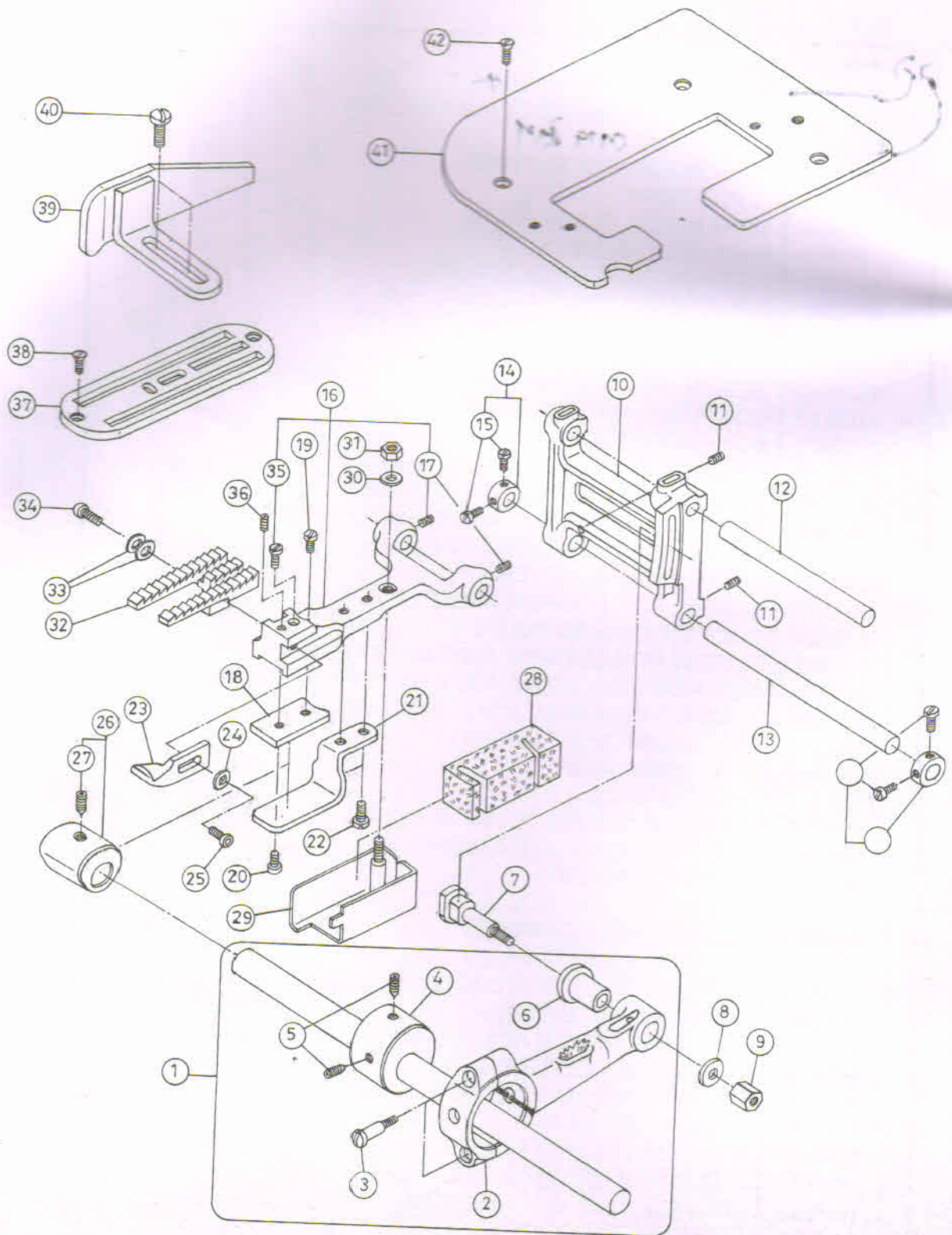
[5] LOOPER DRIVE PARTS



[5] LOOPER DRIVE PARTS

SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60351A	ECCENTRIC ASSY.	1
2	60352	CONNECTING BEARING ⁺	1
3	60353	SCREW FOR CONNECTING BEARING	4
4	+60354	ECCENTRIC <i>019 21</i>	1
5/6	60355/6	SCREW FOR ECCENTRIC	2
7	60357	GUIDE FORK	1
8	60358	SCREW FOR GUIDE FORK	1
9	60359	BALL STUD SCREW	1
10	603510	NUT FOR BALL STUD SCREW	1
11	603511	DRIVE LEVER	1
12/13	603512/13	SCREW FOR DRIVE LEVER	3
14	603514	LOOPERDRIVE ECCENTRIC	1
15	603515	SCREW FOR LOOPER DRIVE ECCENTRIC	1
16	603516	LOOPER AVOID ECCENTRIC FORK	1
17	603517	SCREW FOR LOOPER AVOID ECC. FORK	2
18	603518	LOOPER AVOID ECCENTRIC SHOE	1
19	603519	LOOPER AVOID ECCENTRIC SHOE	1
20	603520	SCREW FOR LOOPER AVOID ECCENTRIC SHOE	2
21	603521	LOOPER DRIVE LEVER SHAFT	1
22	603522	LOOPER DRIVE LEVER	1
23	603523	SCREW FOR LOOPER DRIVE LEVER	2
24	603524	LOOPER THREAD TAKE-UP	1
25	603525	SCREW FOR LOOPER THREAD TAKE-UP	1
26	603526	NUT FOR BALL JOINT ASSY. (RIGHT)	1
27	603527	WASHER FOR BALL JOINT ASSY. (RIGHT)	1
28	603528	BALL JOINT ASSY. (RIGHT)	1
28A	603528A	BALL JOINT ASSY. SET	1
28-1	603528-1	BALL JOINT ASSY. (LEFT)	1
29	603529	SCREW FOR BALL JOINT ASSY. RIGHT & LEFT	4
30	603530	NUT FOR CONN. ROD (RIGHT)	1
31	603531	CONNECTING ROD	1
32	603532	NUT FOR CONN. ROD (LEFT)	1
33	603533	LOOPER HOLDER SHAFT	1
34	603534	LOOPER HOLDER SHAFT COLLAR	1
35	603535	SCREW FOR LOOPER HOLDER SHAFT COLLAR	2
36	603536	LOOPER HOLDER PIN	1
37	603537	NUT FOR LOOPER HOLDER PIN	1
38	603538	LOOPER HOLDER BRACKET	1
39	603539	COLLAR FOR LOOPER HOLDER BRACKET	1
40	603540	SCREW FOR LOPER HOLDER COLLAR	2
41	603541	NUT FOR LOOPER HOLDER PIN	2
42	603542	NUT FOR BALL JOINT ASSY. (LEFT)	1
43	603543	LOOPER	1
44	603544	SCREW FOR LOOPER	2

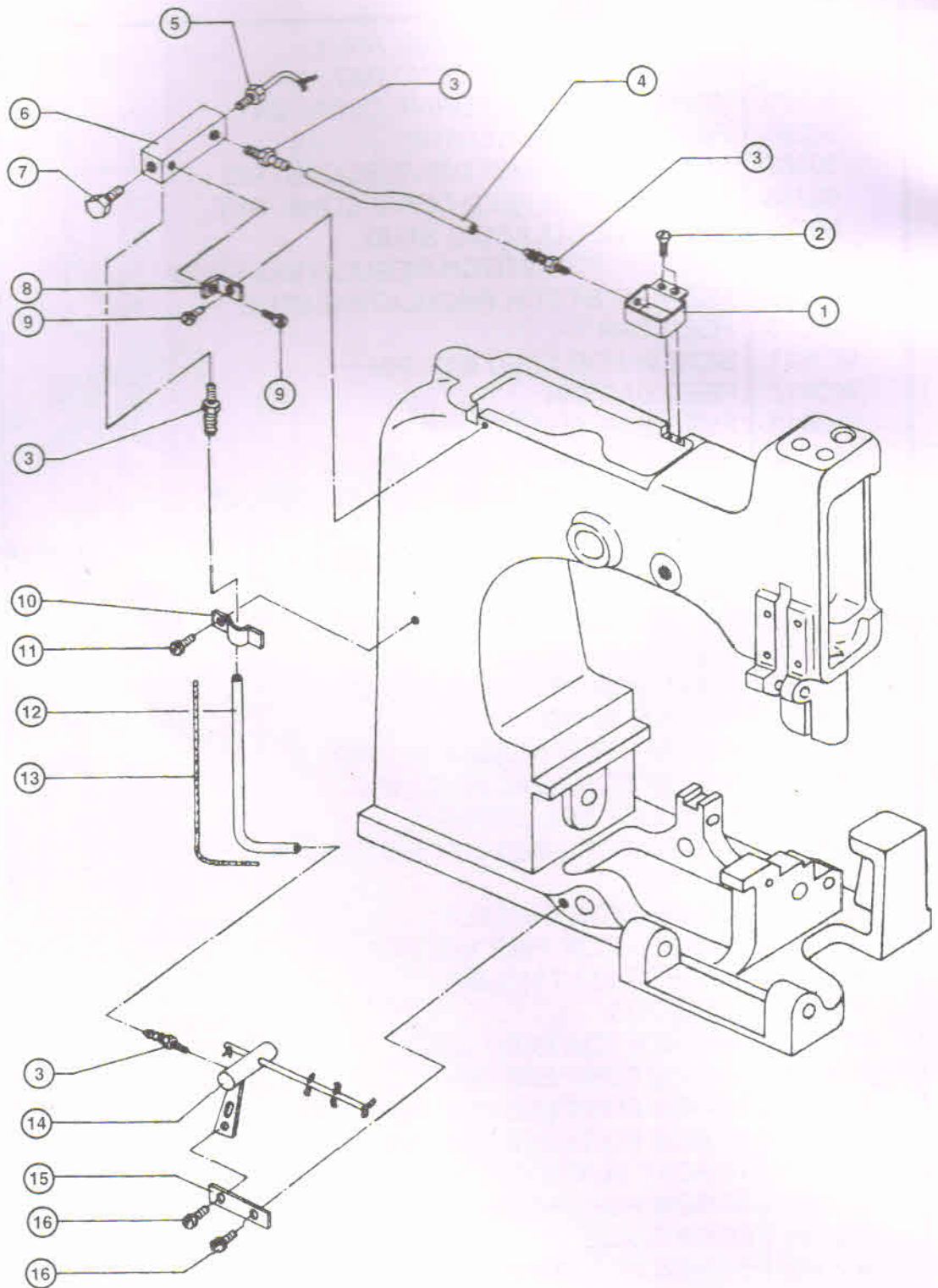
(6) FEED LIFT AND FEED DRIVING PARTS



(6) FEED LIFT AND FEED DRIVING PARTS

SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60361	FEED DRIVE ECCENTRIC ASSY.	1
2	60362	FEED DRIVE CONNECTIC BKT.	1
3	60363	SCREW FOR FEED DRIVE CONN. BKT.	2
4	60364	FEED DRIVE ECCENTRIC	1
5	60365	SCREW FOR FEED DRIVE ECCENTRIC	2
6	60366	BUSHING FOR FEED DRIVE CONN. BKT.	1
7	60367	STITCH REGULATING STUD	1
8	60368	WASHER FOR STITCH REGULATING STUD	1
9	60369	NUT FOR STITCH REGULATING STUD	1
10	603610	FEED BAR	1
11	603611	SCREW FOR FEED BAR PIN	2
12	603612	FEED BAR PIN	1
13	603613	FEED BAR SHAFT	1
14	603614	FEED BAR SHAFT COLLAR	2
15	603615	SCREW FOR FEED BAR SHAFT COLLAR	4
16	603616	FEED BAR BRACKET	1
17	603617	SCREW FOR FEED BAR BRACKET	2
18	603618	FEED BAR SHOE	1
19/20	603619/20	SCREW FOR FEED BAR SHOE	2
21	603621	FEED BAR PRONG	1
22	603622	SCRW FOR FEED BAR PRONG	2
23	603623	NEEDLE GUARD	1
24	603624	WASHER FOR NEEDLE GUARD	1
25	603625	SCREW FOR NEEDLE GUARD	1
26	603626	FEED LIFT ECCENTRIC	1
27	603627	SCREW FOR FEED LIFT ECCENTRIC	1
28	603628	OIL FELT	1
29	603629	HOLDER FOR OIL FELT	1
30	603630	WASHER FOR FELT HOLDER	1
31	603631	NUT FOR FELT HOLDER	1
32	603632	FEED DOG	1
33	603633	WASHER FOR FEED DOG	2
34	603634	SCREW FOR FEED DOG	1
35	603635	SCREW FOR FEED DOG SUPPORT	1
36	603636	SCREW FOR FEED DOG ADJUSTMENT	2
37	603637	THROAT PLATE	1
38	603638	SCREW FOR THROAT PLATE	2
39	603639	EDGE GUIDE	1
40	603640	SCREW FOR EDGE GUIDE	2
41	603641	THROAT PLATE SUPPORTER	1
42	603642	SCREW FOR THROAT PLATE SUPPORTER	3

[7] OIL LUBRICATION MECHANISM

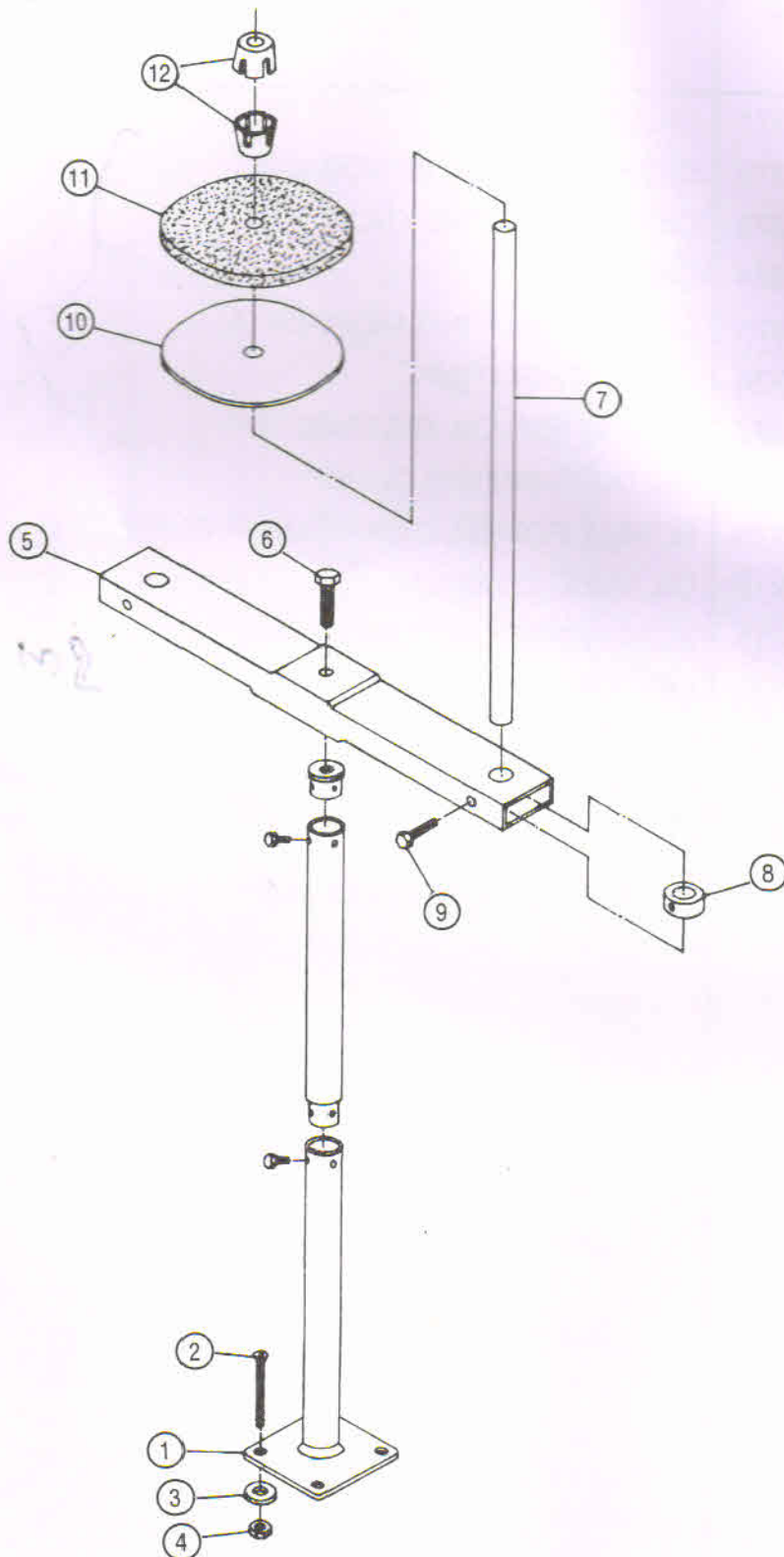


[7] OIL LUBRICATION MECHANISM

SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60371	OIL RESERVOIR	1
2	60372	SCREW FOR OIL RESERVOIR	2
3	60373	OIL TUBE FITTING KNOB	4
4	60374	OIL TUBE	1
5	60375	OIL DISTRIBUTING MEMBER (A)	1
6	60376	OIL DISTRIBUTOR	1
7	60377	SCREW FOR OIL DISTRIBUTOR	1
8	60378	OIL DISTRIBUTOR CLAMP	1
9	60379	SCREW FOR OIL DISTRIBUTOR CLAMP	2
10	603710	OIL TUBE CLAMP	1
11	603711	SCREW FOR OIL TUBE CLAMP	1
12	603712	OIL TUBE	1
13	603713	OIL FELT	1
14	603714	OIL DISTRIBUTING MEMBER (B)	1
15	603715	FITTING CLAMP	1
16	603716	SCREW FOR FITTING CLAMP	2

for 21/4/19

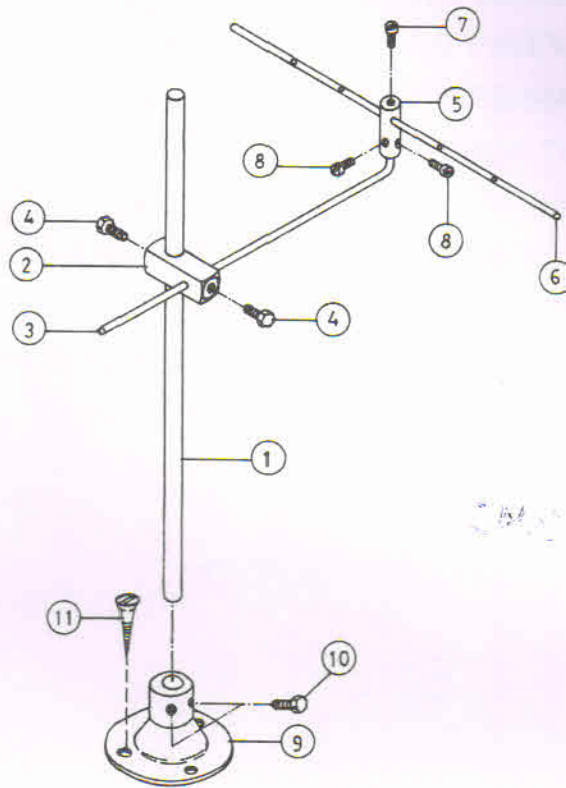
(8) THREAD STAND PARTS (NEW)



(8) THREAD STAND PARTS (NEW)

SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60381	THREAD STAND PARTS	1
2	60382	SCREW FOR THREAD STAND PARTS	4
3	60383	WASHER FOR SCREW	4
4	60384	NUT FOR SCREW	4
5	60385	THREAD CONE BASE	1
6	60386	SCREW FOR THREAD CONE BASE	1
7	60387	THREAD CONE GUIDE PIPE	2
8	60388	COLLAR FOR THREAD CONE GUIDE PIPE	2
9	60389	SCREW FOR COLLAR	2
10	603810	THREAD CONE DISC	2
11	603811	"U" FOAM	2
12	603812	THREAD CONE SUPPORT	4

(9) THREAD STAND PARTS (OLD)



SR. NO.	PART NO.	DESCRIPTION	QTY.
1	60391	MAIN ROD	1
2	60392	THREAD GUIDE HOLDER	1
3	60393	THREAD GUIDE BAR L TYPE	1
4	60394	SCREW FOR THREAD GUIDE HOLDER	2
5	60395	THREAD GUIDE BAR BRACKET	1
6	60396	THREAD GUIDE (BIG)	1
7	60397	SCREW FOR THREAD GUIDE BIG	1
8	60398	SCREW FOR THREAD GUIDE BAR BRACKET	2
9	60399	THREAD STAND BASE	1
10	603910	SCREW FOR MAIN ROD	2
11	603911	SCREW FOR THREAD STAND BASE	3

PACKING LIST OF "**Gabbar**" MACHINE ACCESSORIES

1.	MACHINE BASE PLATE	1
2.	THREAD STAND COMPLETE SET	1
3.	MACHINE PULLEY	1
4.	'V' BELT 241 ^o	1
5.	SIGHT FEED OILER	1
6.	ALLEN KEY WRENCH 'T' TYPE	5
7.	ALLEN KEY WRENCH 'L' TYPE	5
8.	FIX SPANNER (8X10)	1
9.	SCISSOR	1
10.	OIL CAN	1
11.	PLUCKER	1
12.	SCREW DRIVER	1
13.	BRUSH	1
14.	INSTRUCTION MANNUAL & PARTS LIST BOOKLET	1