



TYPICAL

TW3-P335/P335B

Cylinder Bed Compound Feed Sewing Machine

TW3-P335V/P335VB

Cylinder Bed Compound Feed Binding Machine

OPERATION INSTRUCTION / PARTS MANUAL

- Please don't adjust and repair the machine by non-professionals,except adjusting stitch.
- Specifications subject to change without notice

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Operation Instruction

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1. Bref introduction

This series machines adopt compound feed mechanism with large amount of alternating presser foot lifter which assures the sewing capability of hard materials. The worktable of the small type of cylinder enlarges the working space.

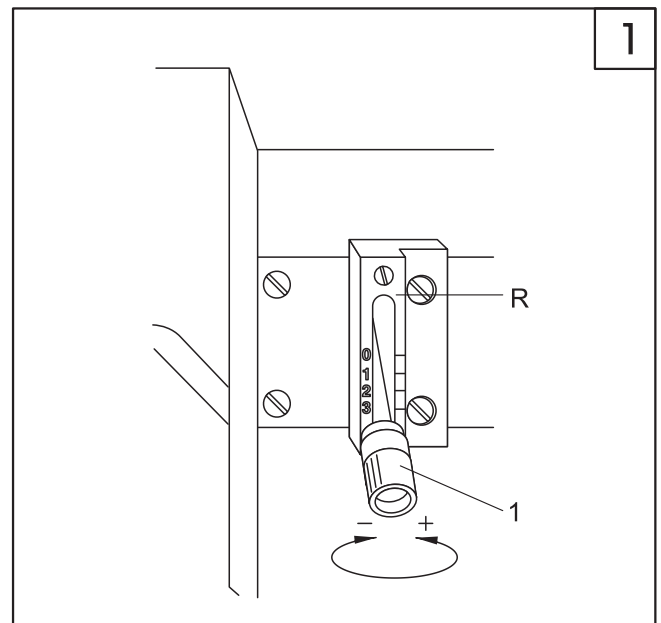
These machine are widely used in manufacturing clothes, bags, leather products and trimming of the shoe, cushion and suitcase.

2. Main specifications

Model	TW3-P335	TW3-P335V	TW3-P335B	TW3-P335VB
Max.sewing speed	2400s.p.m			
Max.stitch length	6mm			
Needle bar stroke	33.4mm			
Presser foot lift height	10mm by hand, 14mm by knee			
Max. lifting amount of presser foot	7mm			
Needle	DP×17 14#~18#			
Cylinder diameter	φ 46.5mm			
Lubrication	By hand			
Hook	Standard	Standard	1.4 times	1.4 times
Motor power	370w			

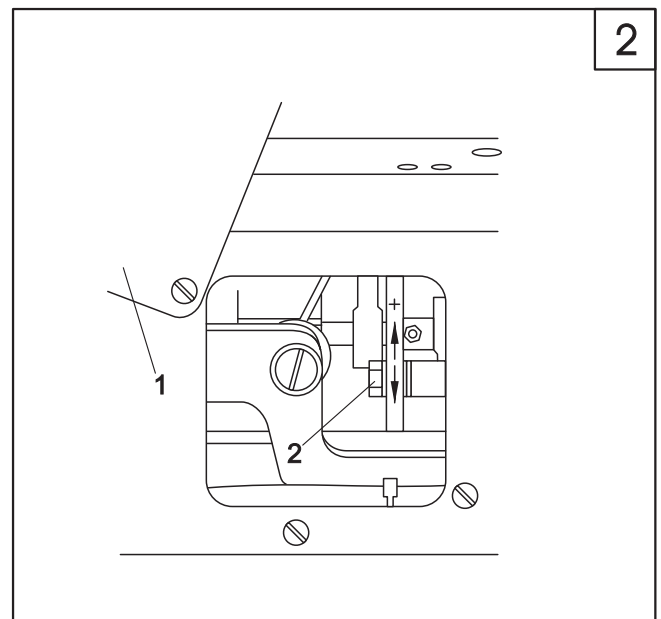
3. Stitch length adjustment/reverse stitching (Fig.1)

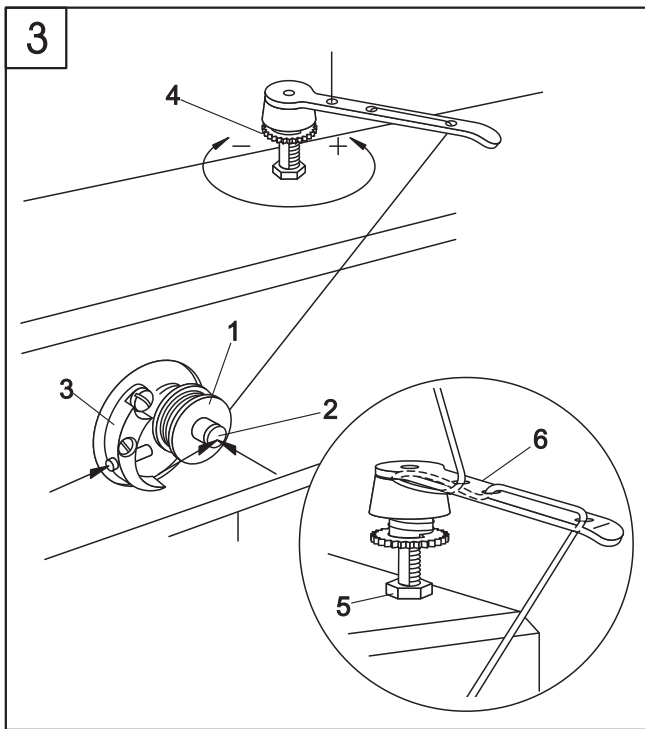
- 1.Adjust the stitch length by turning nut 1;
- 2.When reverse sewing, push nut 1 to mark R as much as possible.



4. Adjusting the lifting amount of the presser foot (Fig.2)

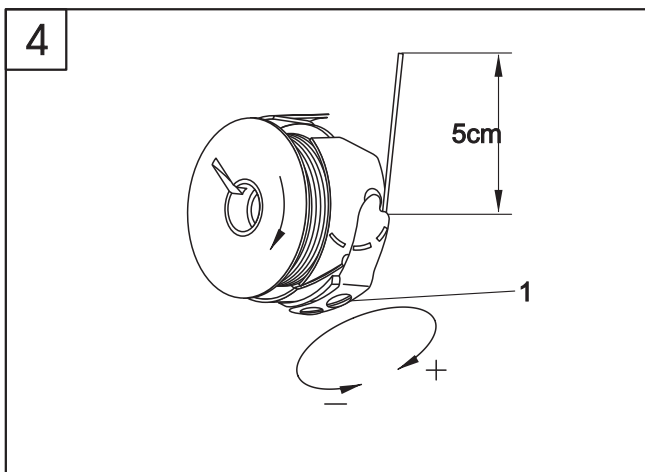
Open the rear cover 1, loosen screw 2, and move it up and down as required.





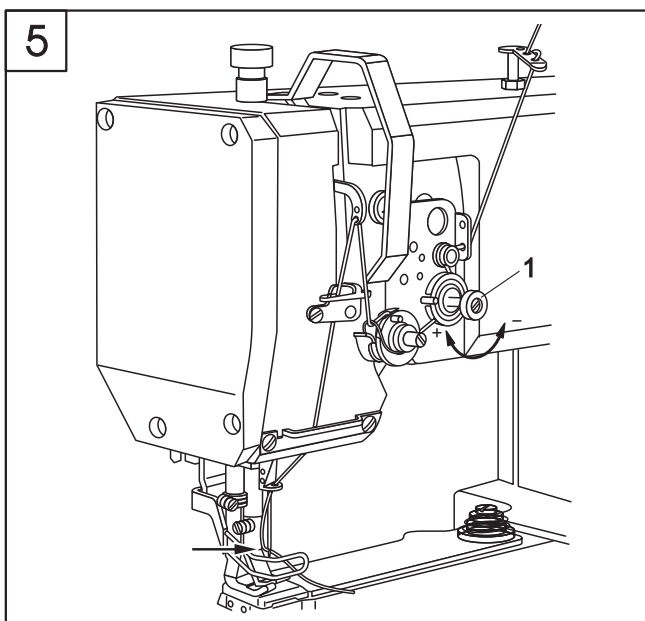
5. Winding the bobbin thread(Fig.3)

1. Put the bobbin into the bobbin shaft 2;
 2. As Fig.3 shows, draw out the thread and winding clockwise to the bobbin several times;
 3. Before winding, press down the winding shaft 2 and the hook gib 3;
 4. Adjusting the bobbin 1 thread tension by the screw 4;
 5. When the bobbin is full, the bobbin winder will automatically stop.
- If the winding is abnormal, loosen the screw 5, and as required, move the thread guide 6, then tighten the screw 5.



6. Adjusting the bobbin thread tension(Fig.4)

1. Draw out the bobbin thread;
- ※ When the bobbin thread is drawn out, the bobbin should run as the arrow goes.
2. Adjusting the bobbin thread tension by screw 1.



7. Threading the needle thread /adjusting the tension of the needle thread(Fig.5)

1. Threading as the Fig shows;
- ※ Pass the thread to the eye of the needle from the left (Fig. Arrow)
2. Adjusting the needle thread tension by the screw 1.

8. Maintenance

Clean the rotating hook clearance	Once a day
Normal oiling	Twice a week
Front parts oiling	Twice a week
Check the oil box	Once a week
Clean the rotating hook	Once a week
Upper feed driving eccentric oiling	Once a year

※ The above data is due to the normal situation.

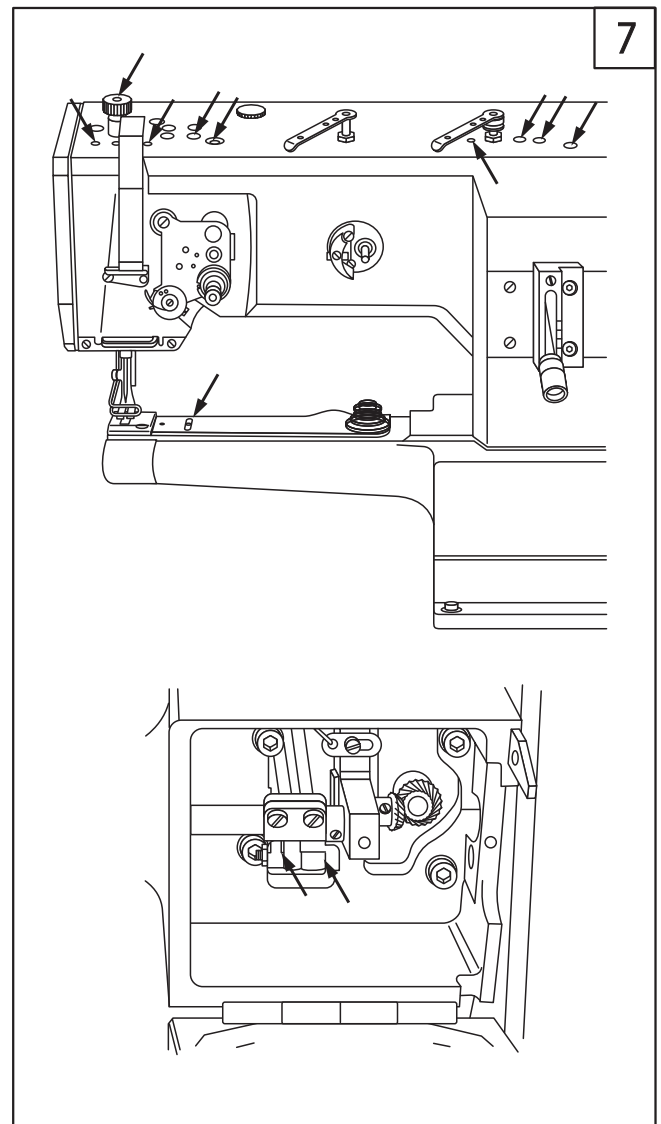
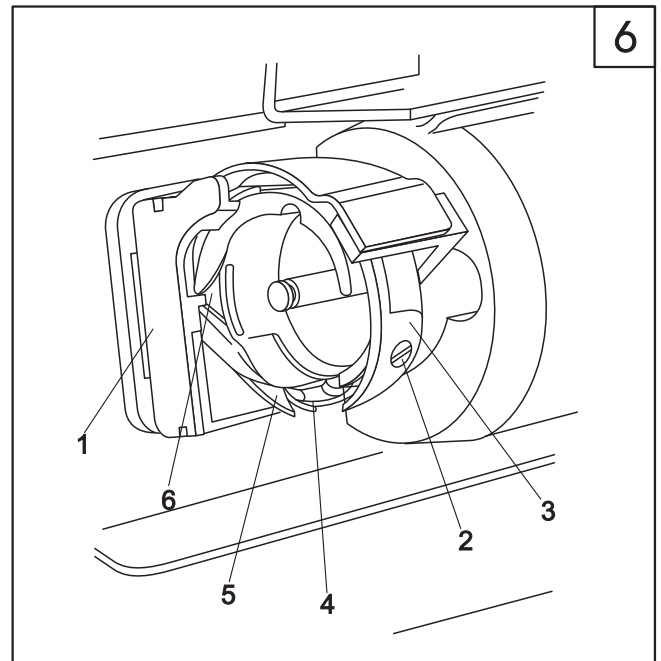
If the machine is used frequently, the interval of the maintenance should be shortened.

Maintenance for rotating hook(Fig.6)

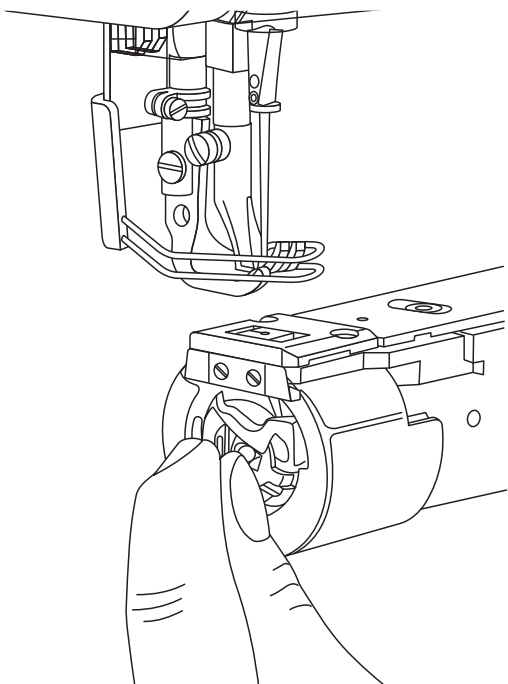
1. Clean the rotating hook with brush every day, and constant use needs more frequent cleansing.
2. Clean the rotating hook thoroughly every week. As follows;
 - a. Open the cover plate and lift the needle bar to its highest point;
 - b. Take out the bobbin case and the bobbin;
 - c. Release the position block 1;
 - d. Loosen the screw 2 and take out the hook point;
 - e. Turn the balance wheel until the point 4 and 5 reach at the same height;
 - f. Take out the rotating hook and clean it with oil.
 - g. Installation is a reverse process. Make sure that the position block 1 is in the groove 6;
 - h. Close the cover plate.

9.Oiling(Fig.7)

The machine must be oiled at the mark (arrow) twice a week.

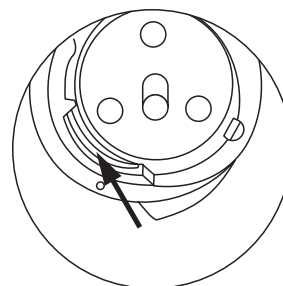


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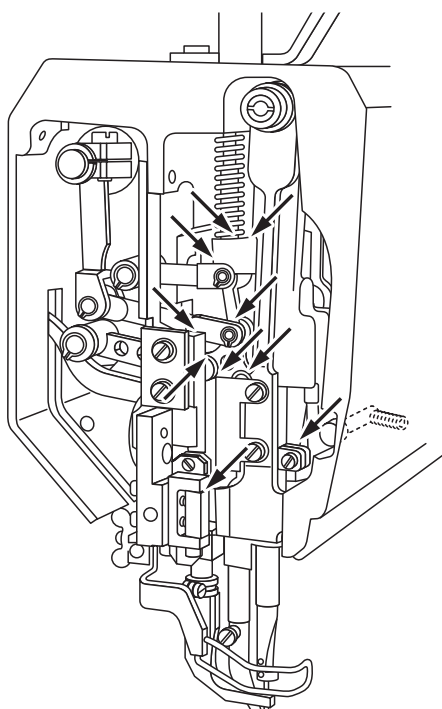


10. Lubricating the rotating hook(Fig.8)

1. Take out the bobbin case;
2. Oil the mark(arrow) with one or two drops every day;
3. Insert the bobbin case.



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11. Lubricating the machine head (Fig.9)

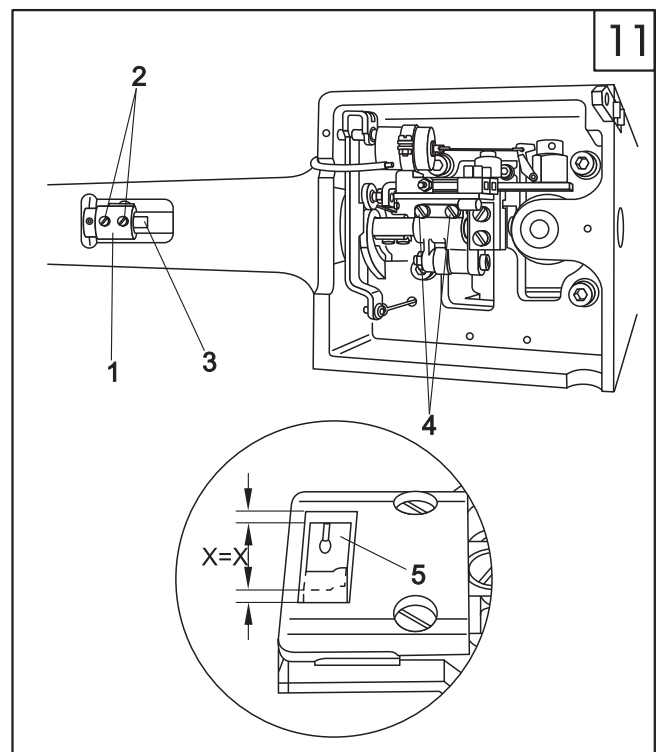
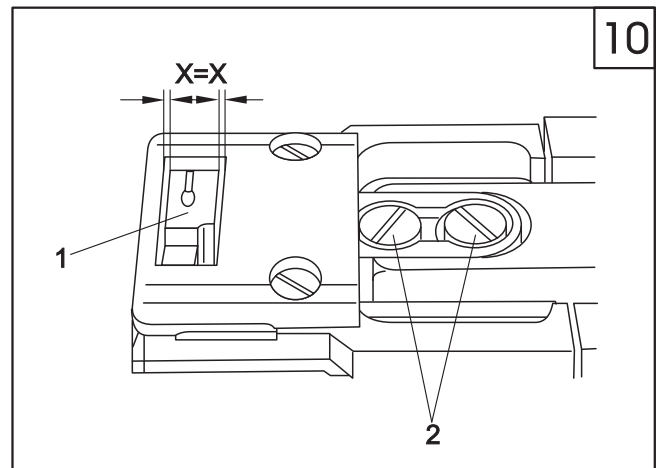
1. Loosen the face plate;
2. Oil the moving parts as the fig shows twice a week;
3. Install the face plate.

12. Adjusting the feed dog

1. Positioning the feed dog in the direction of sewing(Fig.10)
 - a. Loosen the screw 2;
 - b. Adjusting the feed dog as required;
 - c. Tighten the screw 1;※ The feed dog must be of the same distance from the left and the right of the needle cutout.

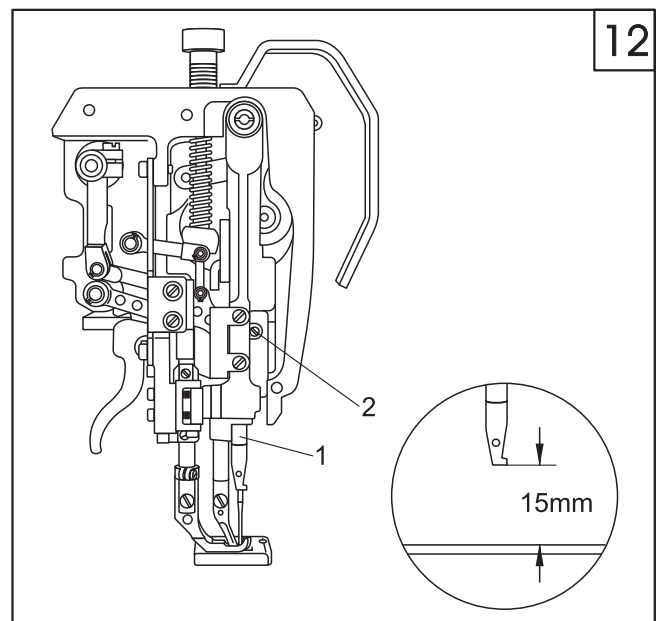
2.Positioning the feed dog in the direction of sewing(Fig.12)

- a. Set it to the max stitch length;
 - b. Loosen the screw 2 to turn the crank 1 to the left; tighten the screw 2 until it prop up the surface 3 of the shaft;
 - c. Loosen the screw 4;
 - d. Move the feed dog as required;
 - e. Tighten the screw 4.
- ※ When the stitch length is at the max, the front and the rear clearance between the feed dog and the needle plate groove should be the same.

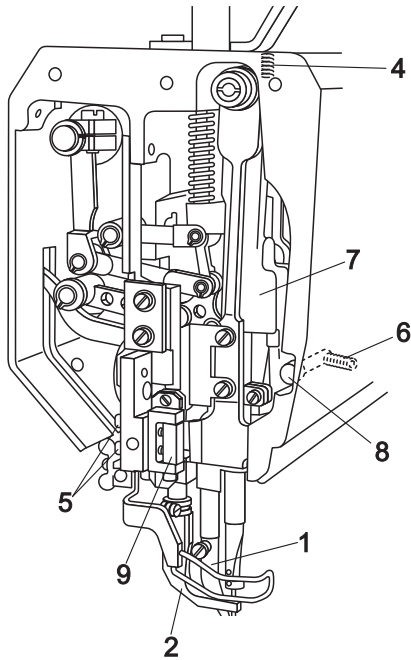


13.Pre-adjusting the needle height(Fig.12)

- Move the needle bar 1 (by screw 2) up and down, and as required, adjust it to the right position.
- ※ When the needle bar is at its lowest position, the clearance between the needle plate and the needle bar should be 15 mm.



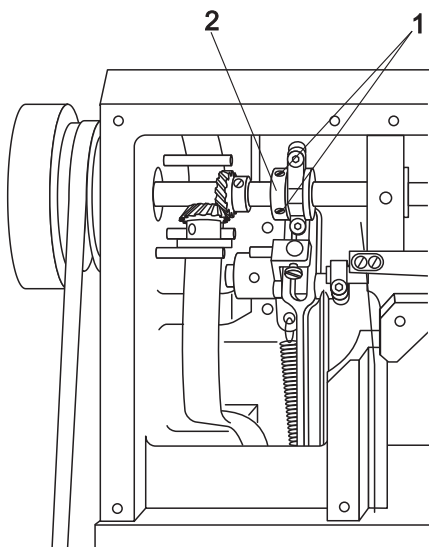
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14. Adjusting the position of the needle and the needle hole(Fig.13)

1. Loosen the rock shaft 1 and the presser foot 2;
 2. Adjust the stitch length to "0" , and lift the needle bar to its highest position;
 3. Insert a new needle, and loosen the screw 3, 4, 5, 6;
 4. Turn the balance wheel and pass the needle directly through the feed dog;
 5. Move the needle bar frame 7 as required;
 6. Tighten the screw 3, 4, 5;
 7. Move the position pin 8 to make it touch the needle bar frame 7, and tighten the screw 6.
- ※ When the stitch length is at the "0" , the needle must enter the hole exactly in the middle.

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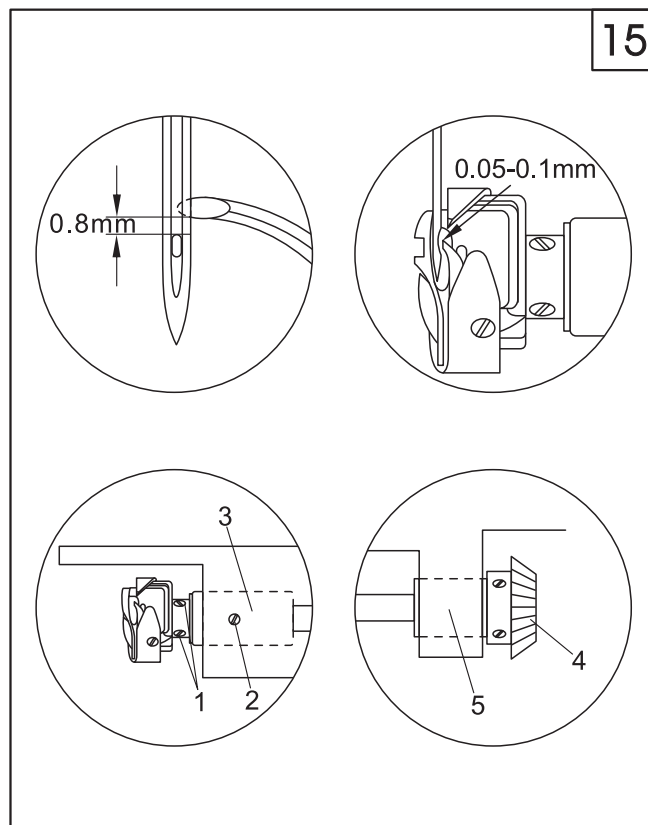


15. Adjusting the position of the bottom feed dog(Fig.14)

1. Adjust the stitch length to its max;
 2. Loosen the screw 1 so the driving eccentric wheel 2 can turn on the shaft;
 3. Adjust the needle bar to its lowest position;
 4. Turn the eccentric wheel 2 to make the throw of eccentric upward, and turn it a bit as required;
 5. Tighten the screw 1;
 6. Test it as required.
- ※ Set the stitch length to its max, adjust the needle bar to its lowest position, and when the reverse feed lever is working, it will not feed.

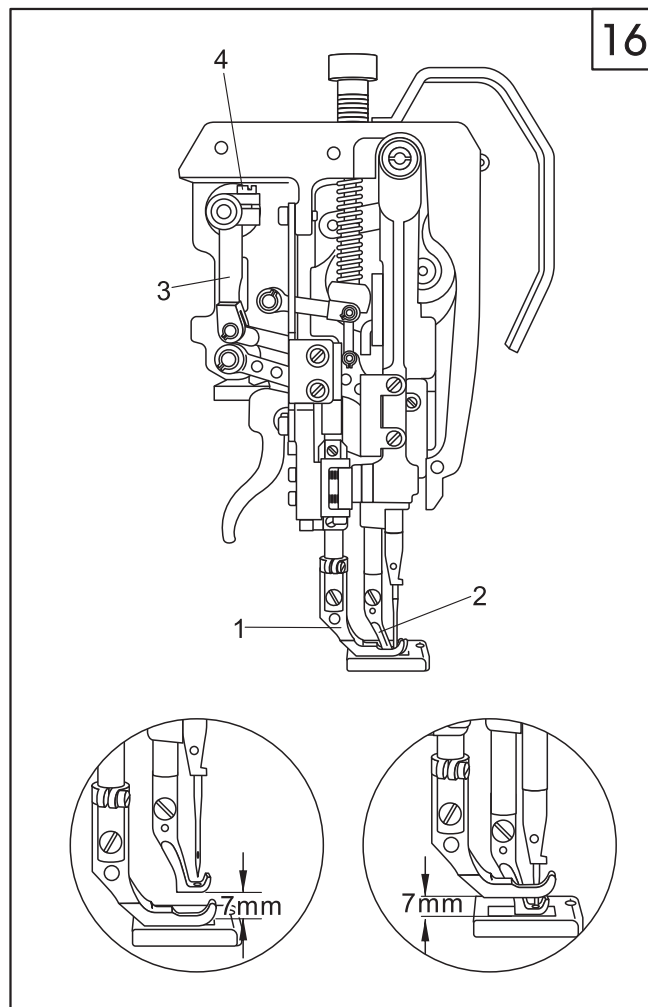
16. Position of the needle and the rotating hook (Fig.15)

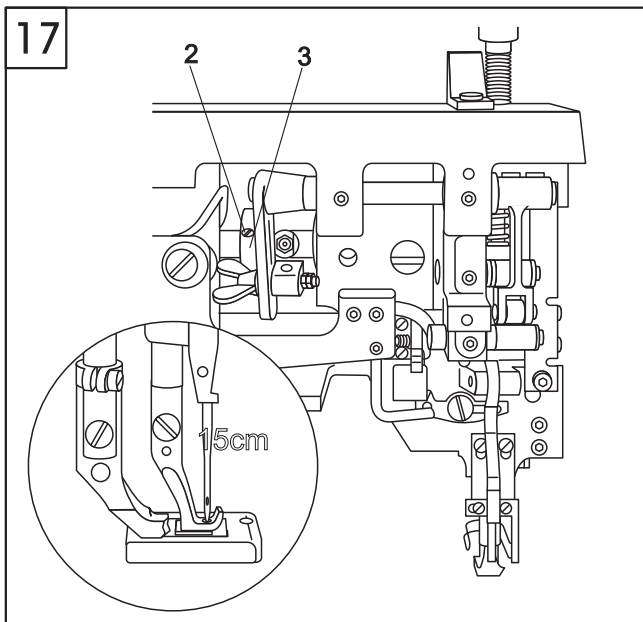
1. Adjust the stitch length to “0”, and then loosen the screw 1 and 2;
 2. Turn the balance wheel until the needle is at its lowest position, and then lift it by 1.8mm;
 3. Move the rotating hook as required;
 4. Make the cover 3 touch the rotating hook, then tighten the screw 2;
 5. Make sure that the gear 4 touches the bushing 5, then tighten the screw 1.
- ※ Adjust the stitch length to “0”, and lift the needle by 1.8mm.
- a. The hook point must reach the center of the needle and the clearance between them should be 0.05-0.1mm;
 - b. The vertical distance between the top of the needle hole and the hook point should be 0.8mm.



17. Adjusting the lifting amount of alternating presser foot (Fig.16)

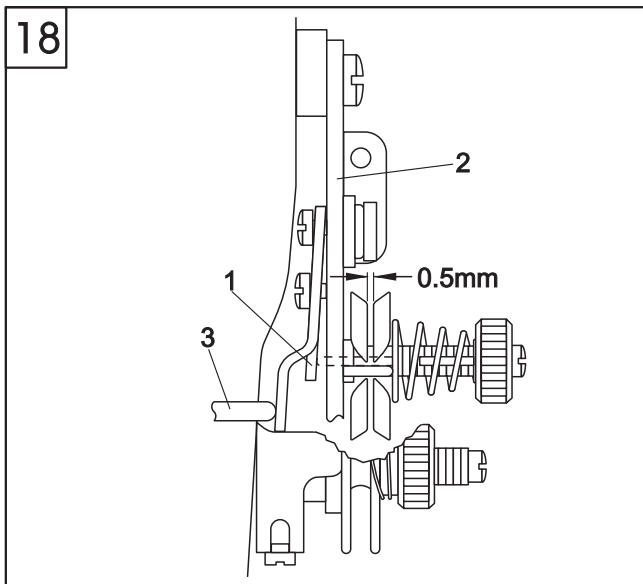
1. Adjust the stitch length to “0” and adjust the lifting amount of alternating presser foot to its max;
 2. Lower the presser foot 1 on the needle plate;
 3. Turn the balance wheel until the walking foot 2 reaches its highest position;
 4. As required, move the crank 3 (by screw 4);
 5. Test as required.
- ※ When the stitch length is at the “0” and the lifting amount of alternating presser foot is at the max, turn the balance wheel to make sure that the clearance between the presser foot 1 and the walking foot 2 is 7.0mm.





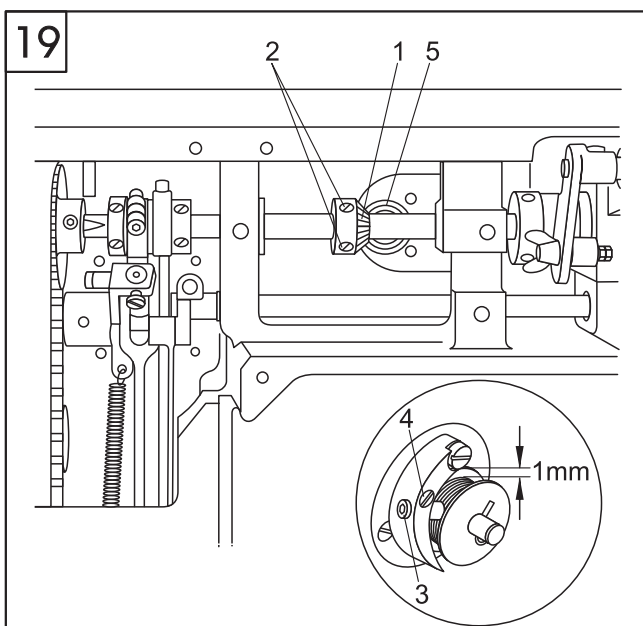
18. Adjusting the upper feed(Fig.17)

- 1.Lower the presser foot on the needle plate;
 - 2.Loosen the screw 2 until the feed eccentric wheel can merely turn;
 - 3.Adjust the feed eccentric wheel 3 as required;
 - 4.Tighten the screw 2;
 - 5.Test as required.
- ※ When the stitch length is at the max and the presser foot touches the needle plate, the walking foot and the needle should reach the needle plate simultaneously.



19. Needle thread tension releasing(Fig.18)

When the presser foot is lifted up, there must be a clearance of 0.5mm between the two tension plates (the minimum clearance is 0.5mm, when sewing with thick thread, it should be adjusted to 1mm,or more.). Adjust the adjusting plate as required.



20. Bobbin winder (Fig.19)

1. When the winder switches on, its spindle must engage reliable;when the winder switches off, the friction wheel 5 and the driving wheel 1 should get apart;
2. When the thread is approx. 1mm from the edge of the bobbin, the winder will switch off automatically;
3. When operating, insert the bobbin to the winder, thread the bobbin thread and switch the winder on.Adjust the pin 3 and the screw 4 as required.

Thank you very much for buying our company's sewing machine. Before using your new machine, please read the safety instructions below and the explanations given in the instruction manual.

With industrial sewing machines, it is normal to carry out work while positioned directly in front of moving parts such as the needle and thread take-up lever, and consequently there is always a danger of injury that can be caused by these parts. Follow the instructions from training personnel and instructors regarding safe and correct operation before operation before operating the machine so that you will know how to use it correctly.

SAFETY INSTRUCTIONS

1. Safety indications and their meanings

This instruction manual and the indications and symbols that are used on the machine itself are provided in order to ensure safe operation of this machine and to prevent accidents and injury to yourself or other people. The meanings of these indications and symbols are given below.

Indications




CAUTION


The instructions which follow this term indicate situations where failure to follow the instructions could cause injury when using the machine or physical damage to equipment and surroundings.

Symbols




This symbol () indicates something that you should be careful of. The picture inside the triangle indicates the nature of the caution that must be taken. (For example, the symbol at left means "beware of injury".)



.....This symbol() indicates something that you must not do.



.....This symbol () indicates something that you must do. The picture inside the circle indicates the nature of the thing that must be done. (For example, the symbol at left means "you must make the ground connection.")

NOTE ON SAFETY

WARNING



Do not put your hand into any openings near the belt. As your hands could get caught in the belt, and serious injury could result.



CAUTION

Environmental requirements



Use the sewing machine in an area which is free from sources of strong electrical noise such as high - frequency welders. Sources of strong electrical noise may cause problems with correct operation.



The ambient temperature should be within the range of 5°C to 35°C during use. Temperatures which are lower or higher than this may cause problems with correct operation.



Any fluctuations in the power supply voltage should be within +10% of the rated voltage for the machine. Voltage fluctuations which are greater than this may cause problems with correct operation.



The relative humidity should be within the range of 45% to 85% during use, and no dew formation should occur in any devices. Excessively dry or humid environments and dew formation may cause problems with correct operation.



The power supply capacity should be greater than the requirements for the sewing machine's electrical consumption. Insufficient power supply capacity may cause problems with correct operation.



Avoid exposure to direct sunlight during use. Exposure to direct sunlight may cause problems with correct operation.



The pneumatic delivery capability should be greater than the requirements for the sewing machine's total air consumption. Insufficient pneumatic delivery capability may cause problems with correct operation.



In the event of an electrical storm, turn off the power and disconnect the power cord from the wall outlet. Lightning may cause problems with correct operation.

Installation



Machine installation should only be carried out by a qualified technician.



Contact your Brother dealer or a qualified electrician for any electrical work that may need to be done.



The sewing machine weighs is so heavy, that the installation should be carried out by two or more people.



Do not connect the power cord until installation is complete, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.



Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.



All cords should be secured at least 25 mm away from any moving parts. Furthermore, do not excessively bend the cords or secure them too firmly with staples, otherwise there is the danger that fire or electric shocks could occur.



Install the belt covers to the machine head and motor.



If using a work table which has casters, the casters should be secured in such a way so that they cannot move.



Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea. Keep the oil out of the reach of children.

⚠ CAUTION

Sewing



This sewing machine should only be used by operators who have received the necessary training in safe use beforehand.



The sewing machine should not be used for any applications other than sewing.



Be sure to wear protective goggles when using the machine.

If goggles are not worn, there is the danger that if a needle breaks, parts of the broken needle may enter your eyes and injury may result.



Turn off the power switch at the following times. Otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.

- When threading the needle
- When replacing the bobbin and needle
- When not using the machine and when leaving the machine unattended

* The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.



If using a work table which has casters, the casters should be secured in such a way so that they cannot move.



Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.



Do not touch any of the moving parts or press any objects against the machine while sewing, as this may result in personal injury or damage to the machine.



If an error occurs in machine, or if abnormal noises or smells are noticed, immediately turn off the power switch. Then contact your nearest dealer or a qualified technician.



If the machine develops a problem, contact your nearest dealer or a qualified technician.

Cleaning



Turn off the power switch before carrying out cleaning, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.

*The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.



Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result.

Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea. Keep the oil out of the reach of children.

Maintenance and inspection



Maintenance and inspection of the sewing machine should only be carried out by a qualified technician.



Ask your dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.



Turn off the power switch and disconnect the power cord from the wall outlet at the following times, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.

- When carrying out inspection, adjustment and maintenance
- When replacing consumable parts such as the looper and knife

*The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.

Disconnect the air hoses from the air supply and wait for



If the power switch and air need to be left on when carrying out some adjustment, be extremely careful to observe all safety precautions.



the needle on the pressure gauge to drop to "0" before carrying out inspection, adjustment and repair of any parts which use pneumatic equipment.



Use only the proper replacement parts as specified by our company.



If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the machine.



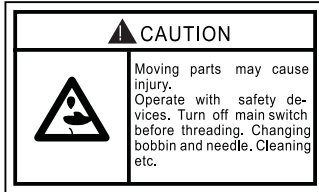
Any problems in machine operation which result from unauthorized modifications to the machine will not be covered by the warranty.

WARNING LABELS

The following warning labels appear on the sewing machine.

Please follow the instructions on the labels at all times when using the machine. If the labels have been removed or are difficult to read. Please contact your nearest dealer.

1



Safety devices

- ① Finger guard
- ② Thread take - up cover
- ③ Belt cover, etc.

2



Be sure to connect the ground. If the ground connection is not secure. you run the risk of receiving a serious electric shock.

3



Direction of operation