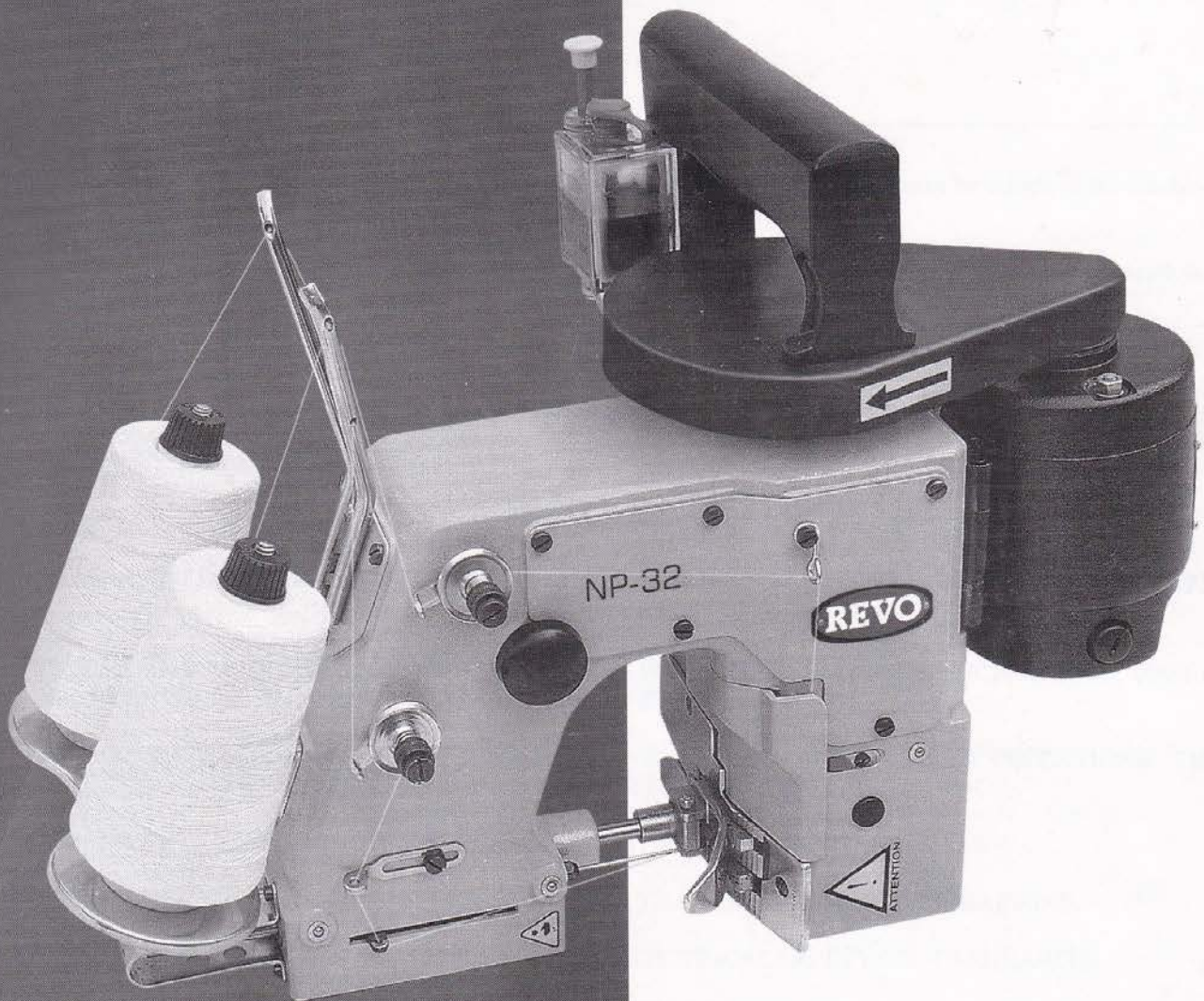


REVO[®]

SINCE 1942

**India's Largest
Manufacturers of
Industrial Sewing Machines**



NP-32
**INSTRUCTION BOOK
AND PARTS MANUAL**

For Operator Safety

Thanks you for purchasing the REVO Model NP-32 Portable Bag Closer.

- ◆ This manual contains the instructions and precautions for using the Model NP-32 Portable Bag Closer. Be sure to read and understand this manual before use and use the machine correctly.
- ◆ Keep this manual near the sewing machine for easy reference. Be sure to attach this manual to the machine when lending or transferring it to another person or company.
- ◆ Please order this manual from the nearest REVO office if it is lost.
- ◆ The contents of this manual are subject to change without prior notice for improvement and safety purpose.



Instructions with this mark are especially important for operator safety. Be sure to observe these marked instructions.

Hazard of Being Caught in the Machine

Be careful, when you insert a bag to be closed into the sewing machine, or your fingers may be caught in the machine between the presser foot and feed dog.

A "Hazardous" mark is attached to the machine. When sewing, be sure to support the bag with the hand from beneath the sewing head and not to touch on the machine.

When adjusting the machine or replacing parts, always disconnecting the Electric Cord from the power source.

This is important in view of safety to the operator and adjuster.

WARNING

PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED.

- ◆ BE SURE THE AREA SURROUNDING MACHINE IS FREE OF ALL HAZARDS SUCH AS FIRE, WATER, OIL, RUBBISH OR ANYTHING THAT CAN CAUSE INJURY.
- ◆ DO NOT OPERATE MACHINE IN AN EXPLOSIVE AREA OR UNDER WET CONDITIONS. THE MACHINE IS NOT AN EXPLOSION-PROOF TYPE NOR WATER PROOF TYPE.
- ◆ DO NOT OPERATE MACHINE BEFORE READING INSTRUCTION MANUAL.
- ◆ DO NOT OPERATE MACHINE ON VOLTAGES OTHER THAN SPECIFIED FOR THE MACHINE.
- ◆ BE SURE MACHINE IS CONNECTED TO BUILDING ELECTRICAL SAFETY GROUND (EARTH).
- ◆ BE SURE POWER SUPPLY IS OFF BEFORE PERFORMING MACHINE MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS OR CLEANING.
- ◆ DO NOT OPERATE MACHINE WITH GUARDS AND COVERS REMOVED.
- ◆ DO NOT TOUCH KNIFE, NEEDLE, PULLEY, BELT AND MOVING PARTS WHEN MACHINE IS IN OPERATION.
- ◆ BE SURE MACHINE IS PLACED ON A SMOOTH (LEVEL) SURFACE WHEN PERFORMING MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS, CLEANING OR STORAGE.

- ◆ BE SURE THE MATERIAL TO BE SEWN OR CLOSED COMPLIES WITH THE MACHINE SPECIFICATION.
- ◆ DO NOT USE SPARE PARTS OTHER THAN “REVO” GENUINE PARTS.

Identifying and Ordering Parts

Where the construction permits, each part is stamped with its part number. On all orders, please include part number, part name and model name of machine.

Safety Rules

To prevent personal injury :

- ◆ All power sources to the machine must be turned off before threading, oiling, adjusting or replacing parts.
- ◆ All cover and guards must be in position before operating machine.
- ◆ Do not temper with safety covers, guards etc, while machine is in operation.

Cautions When Using the Machine

Safety Precautions

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 covers and shields are in place and closed.
4. Do not touch on the machine when it is running.
5. Turn power off and make sure the cutter does not operate before you put your fingers under the cutter blades and the needles to adjust.

Maintenance

- ◆ Please keep in mind to handle the machine carefully and to maintain the machine in good condition.
- ◆ Thread fuzz or dust must be cleaned with air or brush on throat plate, in the groove of feed dog or around looper after the day's work.
- ◆ Wipe the area easy to rust with oil cloth.
- ◆ Check the machine for loose screws and tighten them, if any, once a month.
- ◆ Good maintenance will prolong the machine life.

CONTENTS

1.	SPECIFICATIONS
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	PARTS LIST
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	DIAGRAM OF SCREW, NUT & WASHER

1. SPECIFICATIONS

Seam.....	Double-Thread Single-Chain stitch
Stitch Range(m.m.).....	8.5 mm (fixed)
Speed (rpm.).....	1.650 rpm # 100
Needle.....	DNx1 #25/080 for medium 26/090 for heavy fabric (Schmetz)
Thread.....	20/6 (synthetic or cotton)
Bag Material To Be Closed.....	Hessian, Jute, PP/PE Woven Cloths, Cotton Kraft Paper etc.
Drive Motor.....	110~120 / 220~240V (AC.) Available in sealed / air colled motor single phase

2. THE POINTS BEFORE OPERATION

- ◆ Oil the area through which thread passes, the tension disc, the thread guide, looper, etc.(Note: An anti corrosive agent is applied to the machines at the factory, in order to prevent rusting. It is necessary to use oil to remove this agent, or it may prevent the thread from passing smoothly.)
- ◆ Confirm that the machine has been threaded as per the instructions 3. in the manual.
- ◆ Confirm that the machine has been lubricated as per the instructions 4. in the manual

3.THREADING

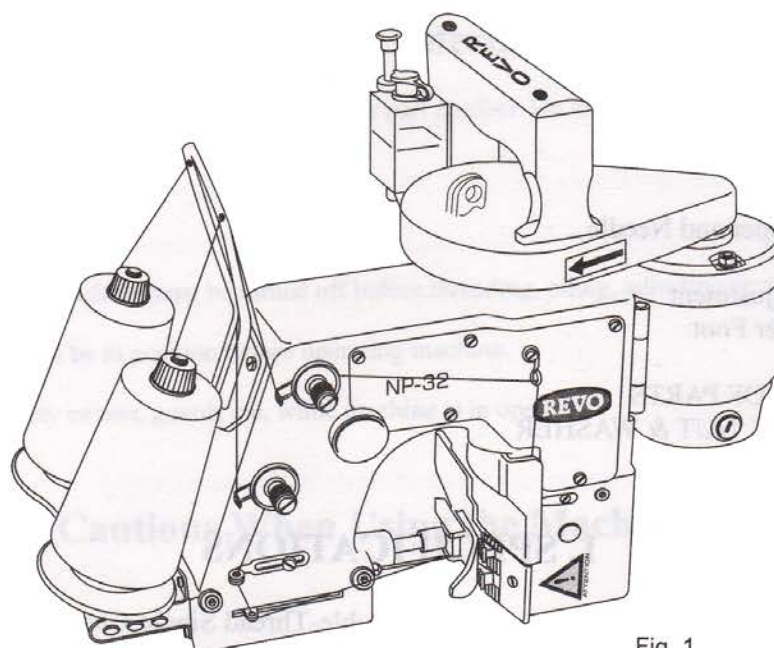


Fig. 1

4. OILING

With adoption of hand lubricating system, the drip oiling before operation is imperative to keep the machine in good condition.

The oiling points are shown in red circle or are where the ball cups and the oil cups are provided.

The lubricant oil should be in conformity with the machine oil attached with the machine, the white spindle oil #60 (viscosity of 10cSt) or the equivalent.

5. OPERATION

1. Hold the machine at the handle in your right hand.
2. Support the bag slightly by your left hand and inset the edge of a bag between presser foot and feed dog.
3. Push the switch button or the handle by your index finger to stitch the bag. Apart your index finger from the push button stop to the machine.
4. After stitching, the plain chain stitch with 1-2 inches in length shall be pressed down in the groove of throat plate to be cut down by knives mounted on the machine.

< Caution >

Stitch the bag synchronously with the speed of feed dog. If the bag is pulled out faster than that of feed dog. It causes mis-stitch or needle break holding of bag.

6. ADJUSTMENT

The machine has been properly adjusted before shipment from the factory. But if it needs re-adjustment for repair or replacement of parts, proceed as follows; When adjusting, make sure that the electric wiring plug is removed from the consent.

6-1 Needle and Looper

Check the distance between needle center and looper edge. Turn the pulley by hand until the looper reaches its right furthest position, while keeping the clearance of 5mm between needle center and looper edge.

1. Confirm whether or not the distance between centers of ball joint (A) is being kept 87mm. Also pay special attention to the strict distance of 87mm, and if not, it is unable to adjust every parts at all.
2. Turn the pulley again by hand until looper reaches its left furthest position, while keeping the clearance of 5mm between needle center and looper edge to loose nuts (a) and (b) of joint rod (B).

In case the distance between centers is more than 5mm, turn joint rod (B) to "S" direction to decrease it.

In case the distance between centers is less than 5mm, turn joint rod (B) to "L" direction to increase it.

Make sure that the nut (b) has left-handed thread.

6-2 Needle Height

When the looper moves left and right to turn pulley by hand, the looper and the needle shall be adjusted in such a way that the bottom of both holes will be entirely corresponded as shown in Fig. 3.

- 1) Check if or not the needle is set in the needle bar as deep as it will go by loosening the needle bar clamping nut.
- 2) Make sure of setting a needle with its concave part facing correctly toward the looper when the needle is just going up from the lowest position.
- 3) Should it be necessary to change needle height, first remove the upper face plate.

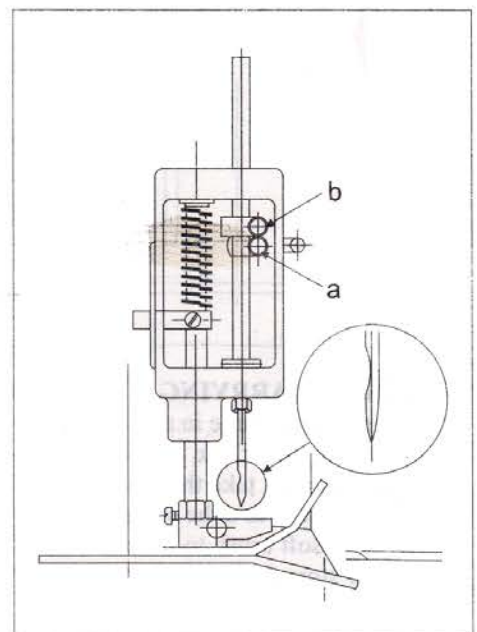
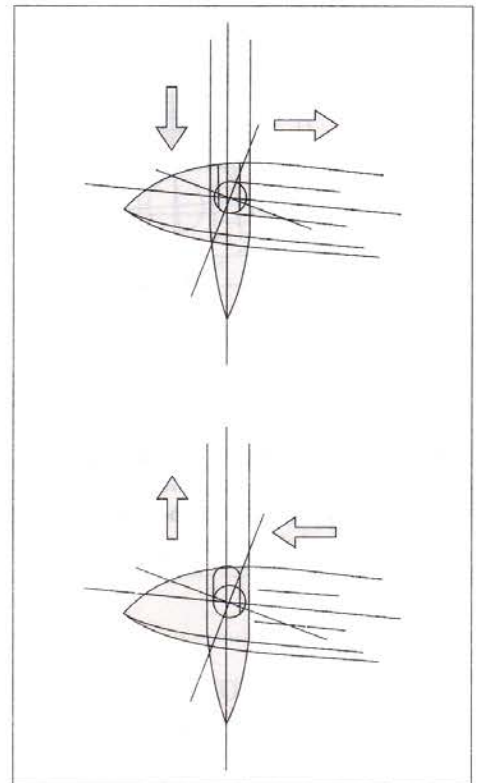
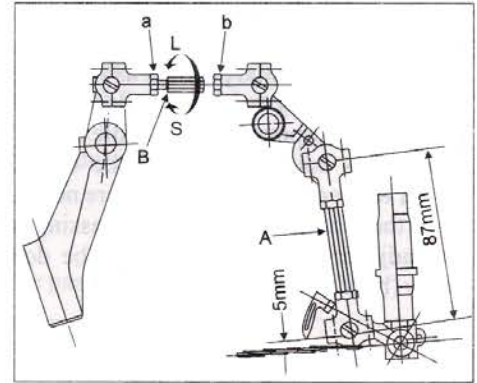
To go up the needle....

Loosen the screw (a), lower the needle bar connection to obtain proper distance required and tighten it. Then, loosen the screw (b), risen the needle bar until the needle bar connection touches the needle bar connecting stud and tighten it.

To go down the needle....

Loosen the screw (b), lower the needle bar to obtain proper distance required and tighten it. Then, loosen the screw (a), fix the needle bar connection at the place where it touches the needle bar connecting stud and tighten it,

4. Check once again if the direction of concave part of needle is correct or not

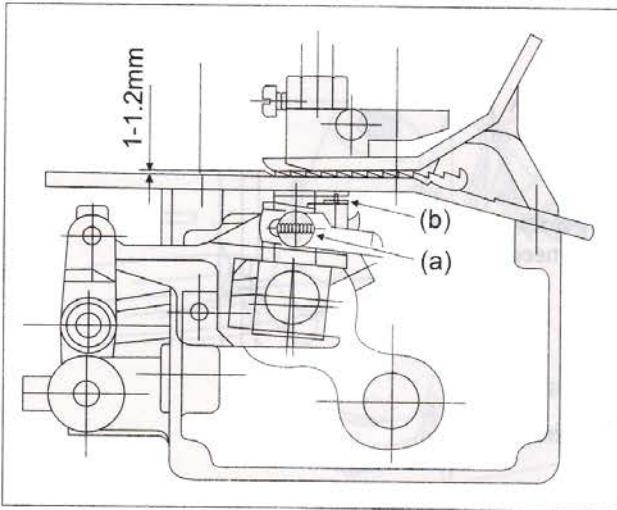


6-3 Gap between looper and Needle.

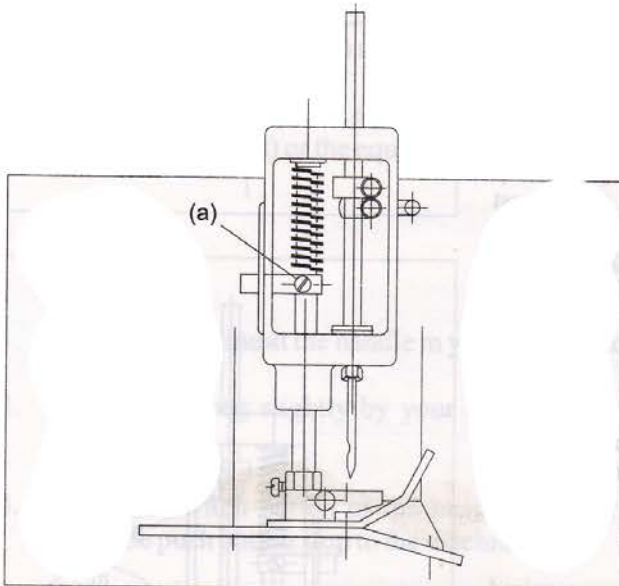
Turn pulley by hand and fix eccentric cam so that the screw (a) may be horizontal position as shown in fig. 5, while the looper is passing behind needle and the sharp point of looper is corresponded with needle center.

Afterwards adjust the gap to be 0.05-0.1mm between looper & needle to confirm they are not clashed each other when the sharp point of looper is passing behind needle.

The adjustment of the gap shall be done by loosening screw (b) of looper oscillating arm.

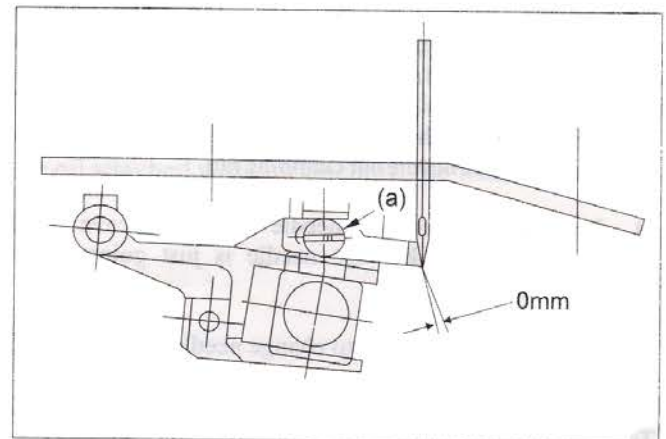
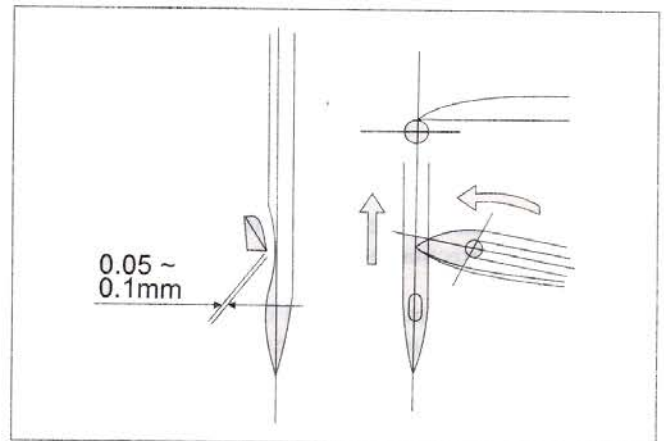
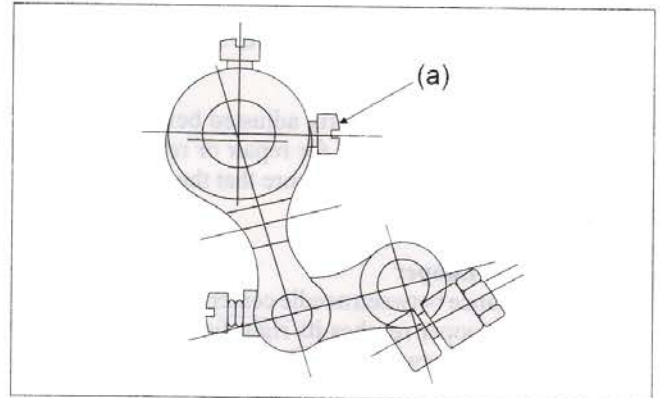


6-4 Feed Dog Height. To adjust the height of feed dog loosen screw (a) in order to obtain the most appropriate protrusion of 1.0-1.2mm above the upper surface of throat plate after regulating the screw (b).



[NOTES ON CARRYING AND STORAGE]

1. Carry the machine in a storage box.
2. After the use of the machine, remove the plug, clean the dirt, take the thread from the machine and then put it in to a the storage box. We suggest you to use a soft brush to clean the rear of the machine.
3. Never store the machine under the sunlight dried or wet condition.



6-5 Needle Guard Adjustment

Adjust the clearance between needle guard and needle to zero when the needle is just coming up from its lowest position as shown in Fig. 8 and tighten the screw (a).

6-6 Pressure of presser Foot .The pressure of presser foot shall be adjusted in such a manner that the upper face plate will be taken out first and then the presser bar connecting stud will be moved up-and-down by loosening its screw (a).

When stitching thinner material (ex. P.P. woven cloth bag) increase pressure.

On the other hand when stitching thicker material (ex. Jute bag), decrease pressure.

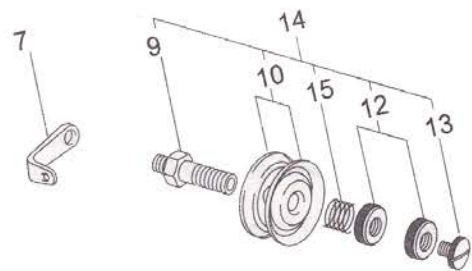
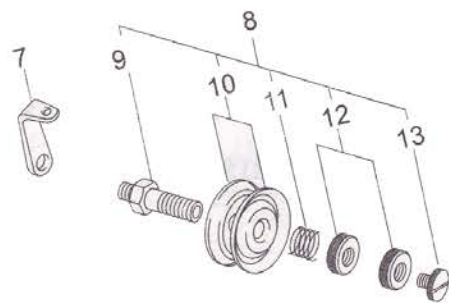
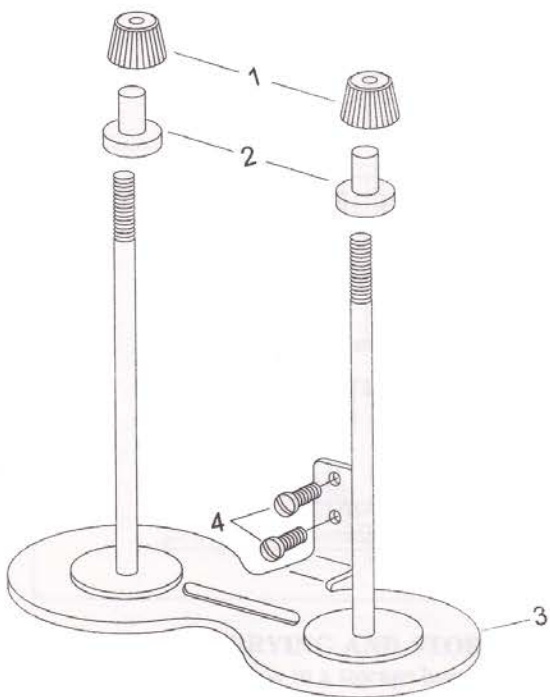
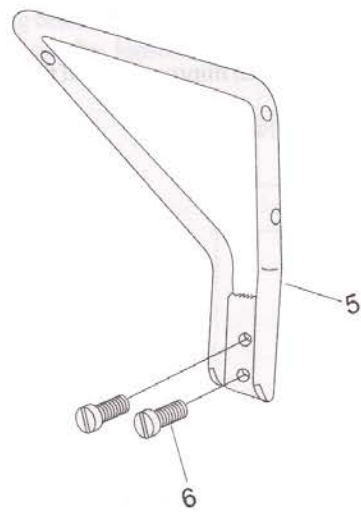
ORDERING PARTS

1. Description of each part and its stamp number is described in this parts list. Screws and nuts for parts are shown adjacent to the relevant parts when ordering parts, describe clearly stamp number with its name of part.
2. The parts which have no Ref. No. can not be, delivered independently; always order it as an assembly.
3. A set of assembled parts is represented by the stamp number of its main parts
4. The last figure on the parts stamp number advances on each improvement of the parts
5. Parts No. described in [] of Remarks means old parts No.

The parts list is subject to change without prior notice.

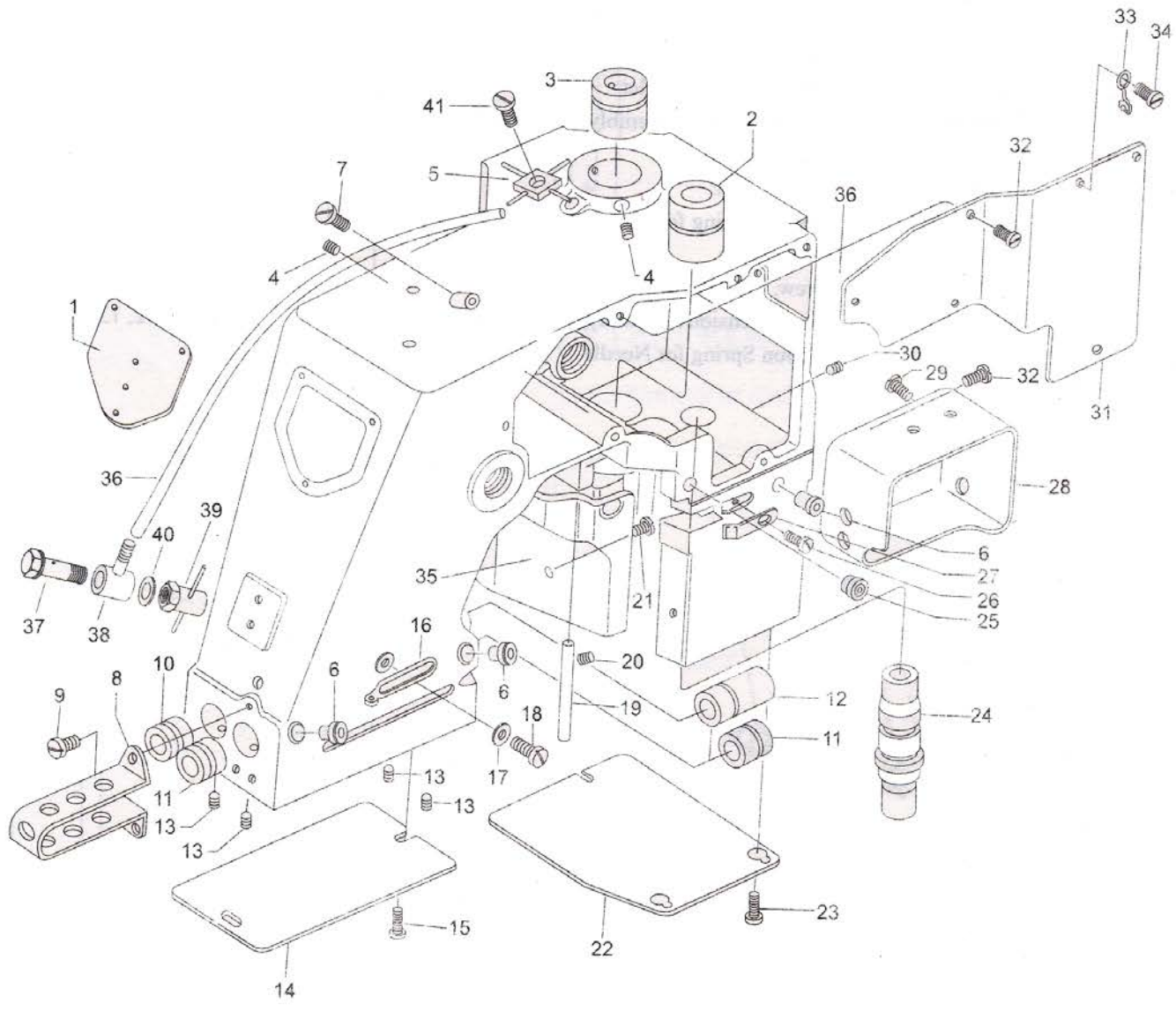
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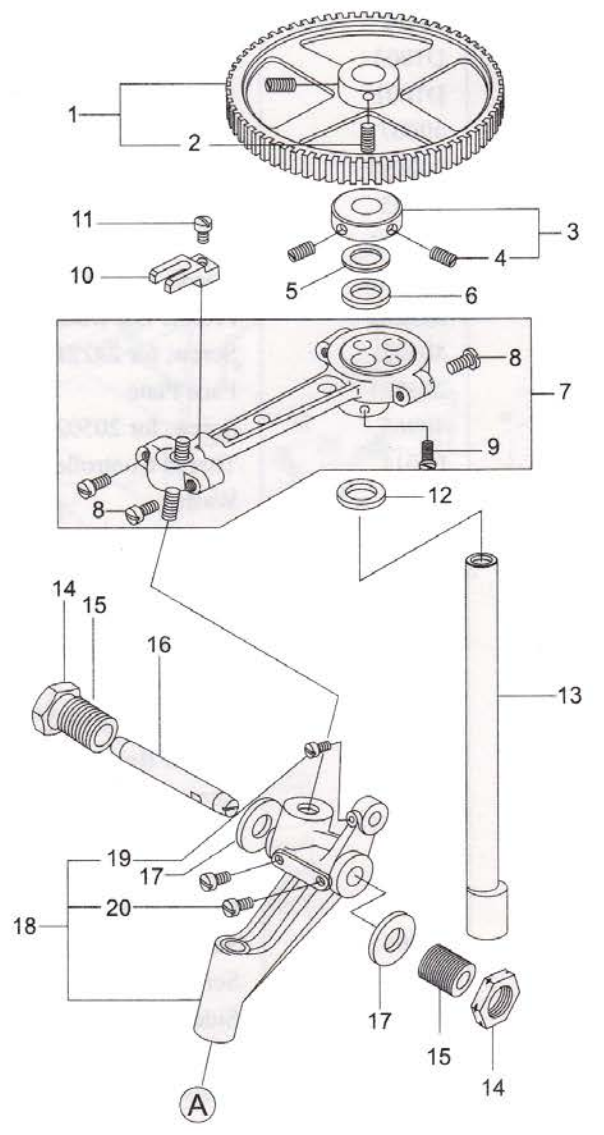
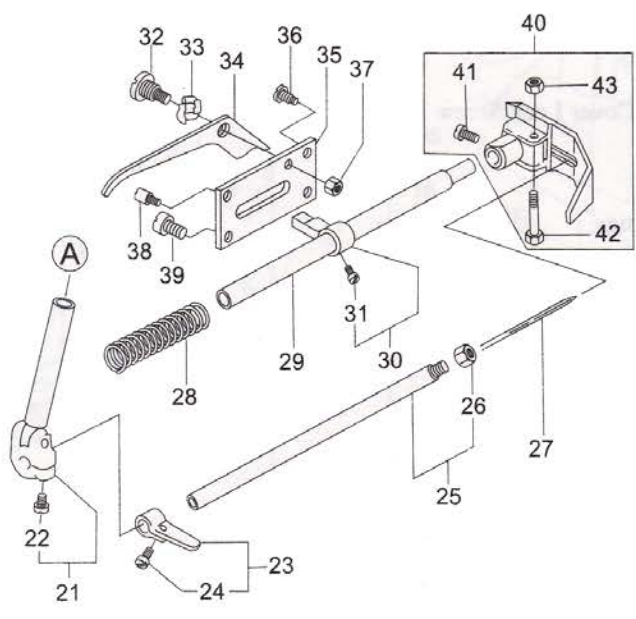
1. THREAD STAND AND THREAD TENSION PARTS

Ref. No.	Part no.	Description	Qty	Remarks
1 - 1	D805	Thread Cone Clamping Nut	2	
2	D807-1	Rubber Clamp	2	
3	205101	Thread Cone Stand	1	
4	28017	Screw, for 205101	2	
5	P5181	Thread Guide	1	
6	40006	Screw, for P5181	2	
7	245071	Thread Tension Eyelet	2	
8	245081B	Thread Tension Assembly, for Looper	1	(9, 10, 11, 12, 13)
9	245081	Tension Post	2	
10	065261	Tension Disc	4	
11	205091	Tension Spring for Looper	1	
12	245091	Tension Nut	4	
13	40011	Screw, for 245081	2	
14	245081A	Thread Tension Assembly, for Needle	1	(9, 10, 12, 13, 15)
15	245101	Tension Spring for Needle	1	



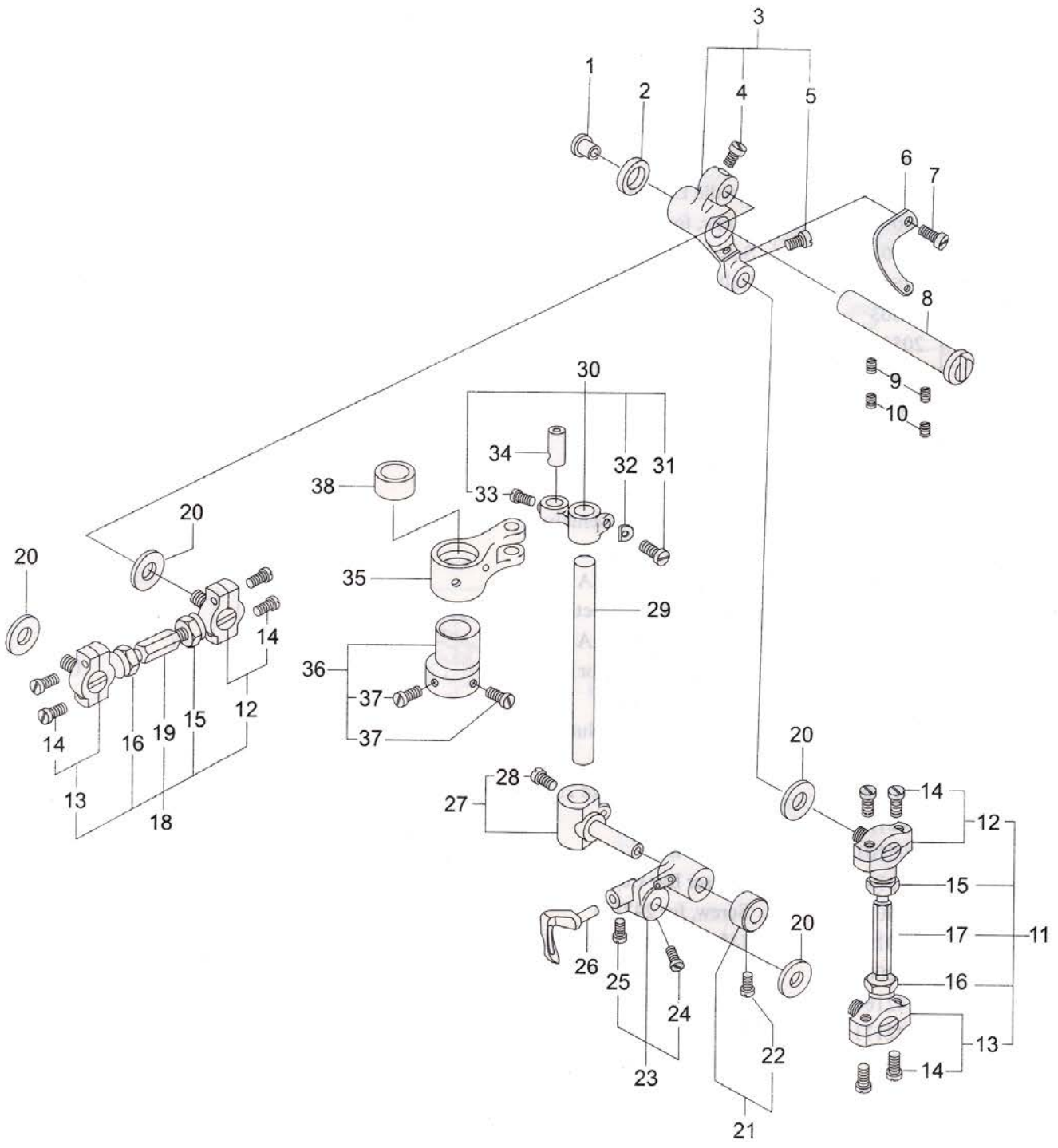
2. MAIN FRAME, BUSHINGS AND OILING PARTS

Ref. No.	Part no.	Description	Qty	Remarks
2- 1	T100	Top Cover	1	
2	241111	Main Shaft Bushing front	1	
3	241122	Main Shaft Bushing , rear	1	
4	40502	Screw, for 241122,241111	2	
5	D1003	Oil Distributor	1	
6	D1001	Push Oil Cup	5	
7	40007	Screw, for 205191	2	
8	202091	Needle Bar Guard	1	
9	40005	Screw, for 202091	3	
10	242211	Presser Bar Bushing, upper	1	
11	202051	Needle Bar Bushing	2	
12	242221	Presser Bar Bushing, lower	1	
13	40502	Screw, for 242211, 202051,242221	4	
14	205021	Face Plate	1	
15	40065	Screw, for 205021	2	
16	P5011	Thread Controller, for Needle	1	
17	15103	Washer	1	
18	28002	Screw	1	
19	205011	Looper Cover Hinge Pin	1	
20	40501	Screw, for 205011	1	
21	40058	Looper Cover Extension Cover Lock Screw	1	
22	205032	End Cover	1	
23	40065	Screw, for 205032	3	
24	203031	Looper Rock Shaft Bushing	1	
25	P5161	Thread Guide Bushing ,for Looper	1	
26	40G01	Looper Cover Extension Lock Screw	1	
27	P1091	Looper Cover Extension Lock Spring	1	
28	205071	Feed Rocker Cover	1	
29	40005	Screw, for 205071	2	
30	40502	Screw, for 203031	1	
31	205042	Side Cover	1	
32	40005	Screw, for 205041,205042,205043	9	
33	P5031	Thread Guide Wire, for looper	1	
34	40005	Screw, for P5031	1	
35	205002	Cover	1	
36	L201	Main Pipe	1	
37	L202	Oil Supply Screw	1	
38	L203	Benzo T	1	
39	L204	Oil Supplier	1	
40	L205	Fiber Washer	1	
41	D1002	Oil Distributor Screw	1	



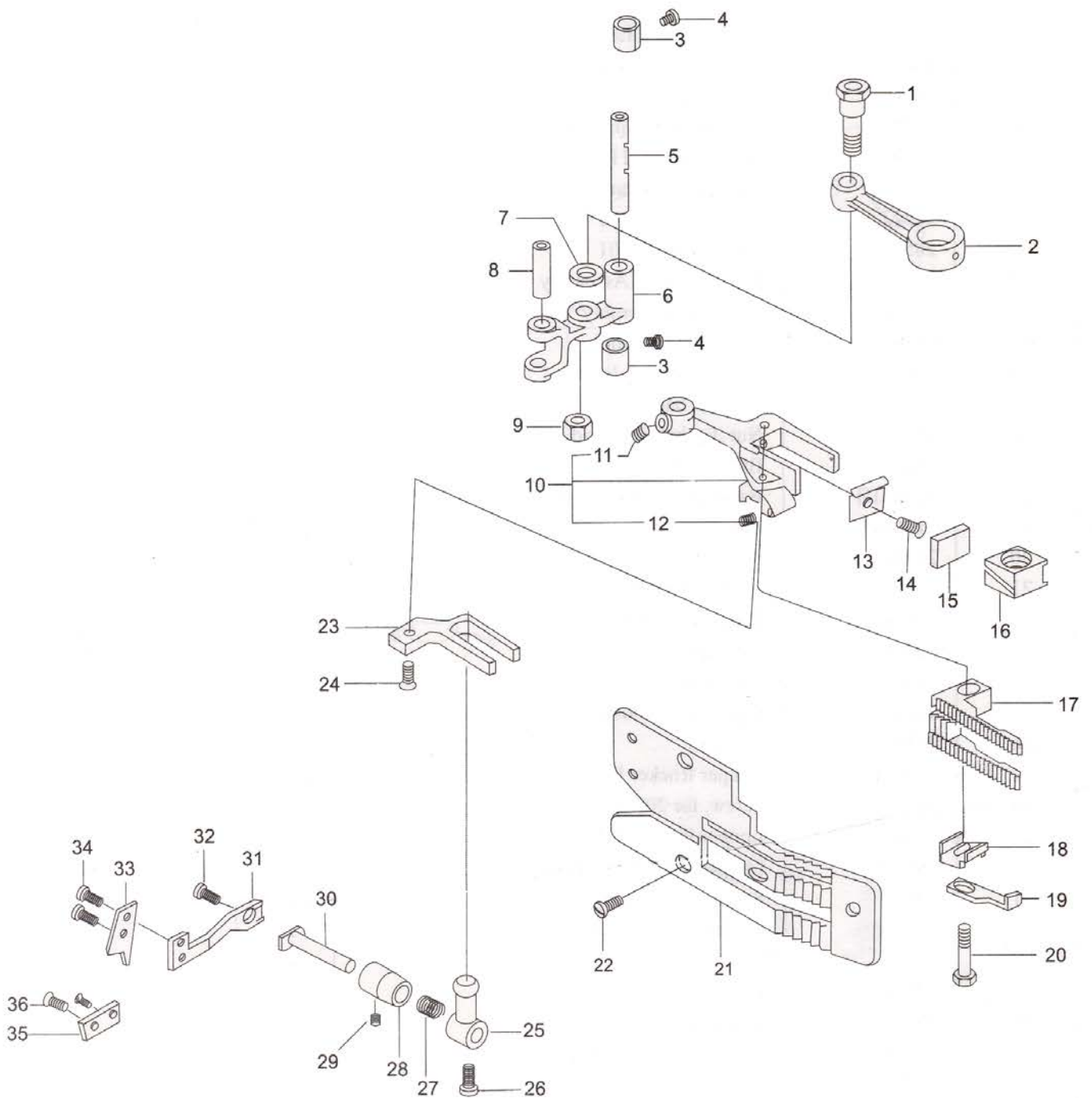
3. NEEDLE BAR, PRESSER BAR AND DRIVING PARTS

Ref. No.	Part no.	Description	Qty	Remarks
3 - 1	241091	Machine Pulley	1	(2)
2	28001	Screw for 241091	2	
3	241131	Retaining Collar	1	(4)
4	40501	Screw, for 241131	2	
5	241161	Spacer	1	
6	205131	Oil Felt	1	
7	202001A	Needle Lever Connecting Rod Assembly	1	(8,9)
8	40090	Screw, for needle lever connecting rod cap	4	
9	40001	Screw, for eccentric cam	2	
10	076062	Ball stud Guide Fork	1	
11	40003	Screw, for 076062	1	
12	205131	Oil Felt	1	
13	201011	Main Shaft	1	
14	18101	Nut, for 242081	2	
15	242081	Adjusting Stud	2	
16	202041	Needle Lever Stud	1	
17	245231	Oil Felt	2	
18	202033A	Needle Lever Assembly	1	(21,22)
19	40006	Screw, for 013081B	1	
20	28005	Screw, for 202033A	2	
21	202071A	Needle Bar Connection Assembly	1	(24)
22	40003	Screw, for 202071A	1	
23	202081	Thread Take-Up, for needle	1	(28)
24	40002	Screw, for 202081	1	
25	202061A	Needle Bar with Nut	1	(30)
26	P2412	Needle Lock Nut	1	
27	B01002	Needle (DN#1 Size 25/080 - SCHMETZ)	1	
28	242191	Presser Spring	1	
29	202101	Presser Bar	1	
30	242181	Presser Bar Connection	1	(35)
31	40003	Screw, for 242181	1	
32	40015	Lifter Hinge screw	1	
33	08206	Spring Washer, for 242161	1	
34	242161	Presser Foot Lifter	1	
35	242171	Presser Foot Lifter Base	1	
36	40007	Screw, for 242171	2	
37	40201	Nut, for Lifter Hinge Screw	1	
38	40001	Presser Foot lifter Stopper Screw	1	
39	40002	Screw, for 242171	1	
40	202121A	Presser Foot Assembly	1	(45~47)
41	40005	Screw, for presser foot shank	1	
42	40055	Presser Foot Hinge Screw	1	
43	40101	Nut, for presser foot hinge screw	1	



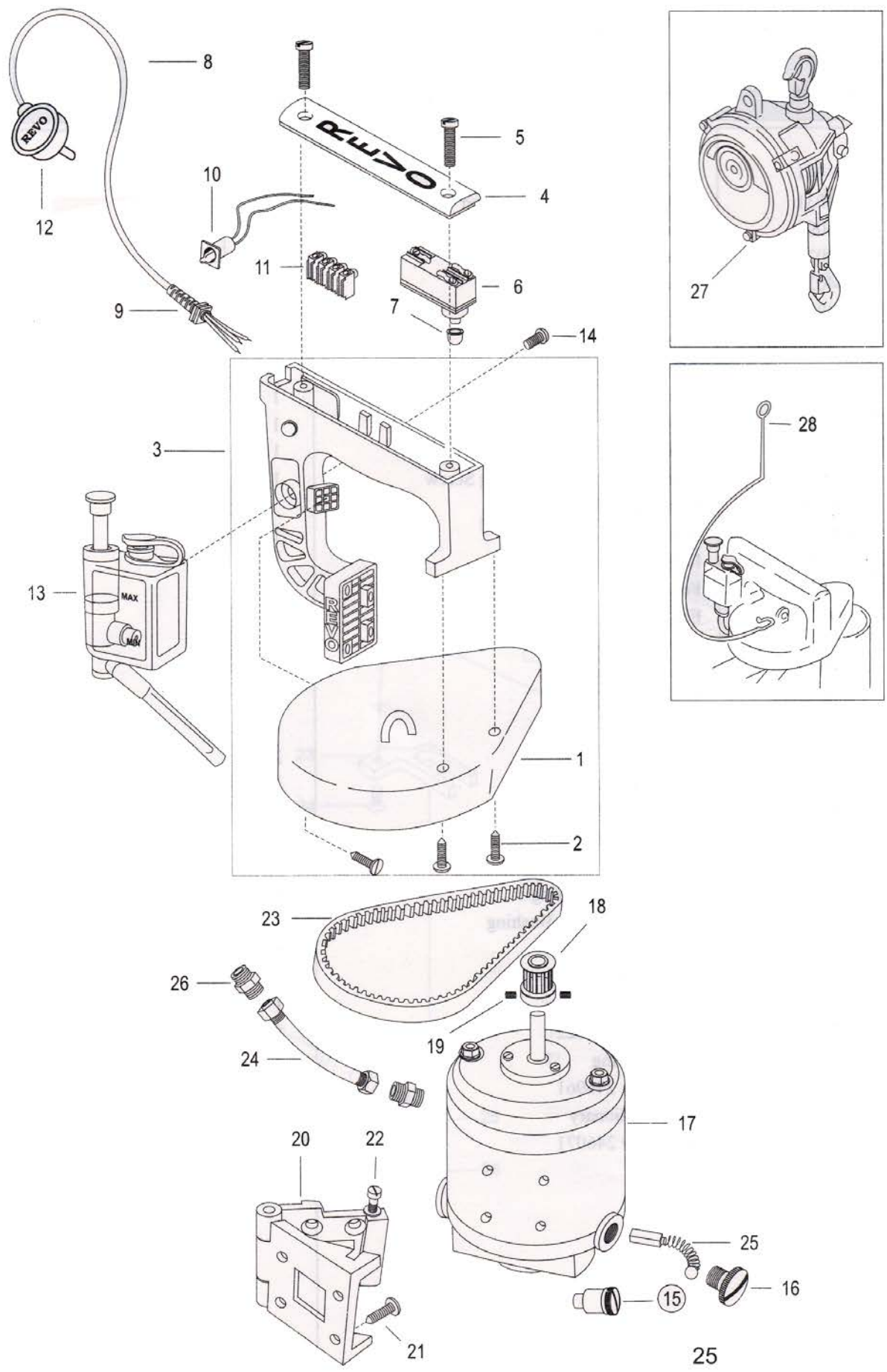
4. LOOPER DRIVING PARTS

Ref. No.	Part no.	Description	Qty	Remarks
4 - 1	D01001	Push Oil Cup	1	
2	P3051	Spacer	1	
3	203091	Looper Bell Crank	1	(4,5)
4	40049	Screw, for 013081B	1	
5	40049	Screw, for 203121A	1	
6	203111	Thread Take-Up, for Looper	1	
7	40004	Screw, for 203111	1	
8	203101	Looper Bell Crank Hinge Stud	1	
9	28522	Screw, for 203101	2	
10	28511	Screw, for 203101	2	
11	203121A	Ball Joint Rod Assembly	1	(13~18)
12	013042B	Ball Joint Assembly	2	(15)
13	013062A	Ball Joint Assembly	2	(15)
14	40061	Screw, for ball Joint	8	
15	40203L	Nut, for ball joint rod	2	
16	40203	Nut ,for ball joint rod	2	
17	203121	Ball Joint Rod	1	
18	013081B	Ball Joint Rod Assembly	1	(13~17,20)
19	013081	Ball Joint Rod	1	
20	20108	Fiber	4	
21	203071	Looper Rocker Collar	1	(23)
22	40076	Screw, for 203071	1	
23	203061	Looper Rocker	1	(25,26)
24	40002	Screw, for 203121A	1	
25	40002	Screw, for 203081	1	
26	203081	Looper	1	
27	203051	Looper Rocker Frame	1	(29)
28	40089	Screw, for 203051	1	
29	203041	Looper Rocker Shaft	1	
30	203021	Looper Rocker Shaft Arm	1	(32~34)
31	40089	Screw, for 203021	1	
32	10104	Washer, for 203021	1	
33	40001	Screw, for P2071	1	
34	P2071	Link Pin	1	
35	203011	Looper Avoid Link	1	
36	203001	Looper Avoid Eccentric	1	(39)
37	40001	Screw, for 203001	2	
38	205181	Oil Felt	1	



5. FEED DRIVING AND THREAD CUTTER PARTS

Ref. No.	Part no.	Description	Qty	Remarks
5 - 1	204041	Feed Rocker Connecting Rod Pin	1	
2	204031	Feed Rocker Connecting Rod	1	
3	204001	Feed Rocker Shaft Bushing	2	
4	40002	Screw, for 204001	2	
5	204021	Feed Rocker Shaft	1	
6	204011	Feed Rocker	1	
7	P4031	Washer, for 204041	1	
8	P4101	Feed Bar Shaft	1	
9	28208	Nut, for 204041	1	
10	204062	Feed Bar	1	(14,15)
11	40502	Screw, for P4101	1	
12	40001	Feed Dog Height Adjusting Screw	1	
13	205111	Lubricating Felt Holder	1	1
14	44009	Screw, for 205111	1	
15	205121	Lubricating Felt	1	
16	204051	Feed Lifting Block	1	
17	204071	Feed Dog	1	
18	P4161	Needle Guard Holder	1	
19	204081	Needle Guard	1	
20	40012	Screw, for 204071	1	
21	204091	Throat Plate	1	
22	40043	Screw, for 204091	3	
23	206043	Knife Bracket Extension	1	
24	40006	Screw, for 206042	1	
25	206061	Knife Bracket Extension Ball	1	
26	40005	Screw, for 206051	1	
27	246051	Knife Tension Spring	1	
28	206002	Knife Bracket Pin Bushing	1	
29	40503	Screw, for 206002	1	
30	206012	Knife Bracket Pin	1	
31	206022	Knife Bracket	1	
32	40005	Screw, for 206022	1	
33	246061	Knife moving	1	
34	40003	Screw, for 246061	2	
35	246071	Knife, stationary	1	
36	40003	Screw, for 246071	2	



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P5181	9	40005	11	40007	13
40006	9	205002	11	40201	13
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