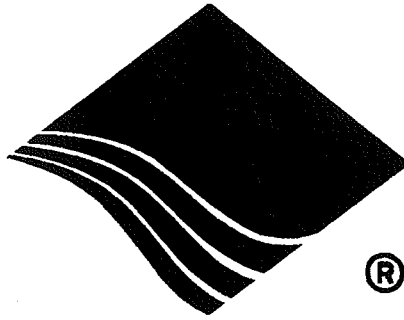


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HIGHLEAD

**GC0318-2A/GC0318-2H/GC0318-2B/
GC0318-2AD
TOP AND BOTTOM FEED LOCKSTITCH
SEWING MACHINE**

**Instruction Manual
Parts Catalog**

SHANGHAI HUIGONG NO.3 SEWING MACHINE FACTORY

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1. MAIN SPECIFICATIONS

| Item | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD |
|-------------------------|--|----------------------|-----------------------|--|
| Max. sewing speed (spm) | 2000 | 2000 | 2000 | 2000 |
| Needle | DP×17 18 [#] -22 [#] | DP×5 14 [#] | DP×17 25 [#] | DP×17 18 [#] -22 [#] |
| Needle bar stroke (mm) | 35 | 35 | 35 | 35 |
| Lubrication | Automatic | Automatic | Automatic | Automatic |
| Stitch length (mm) | 0-10 | 0-4 | 0-10 | 0-8 |
| Presser foot lift | by hand (mm) | 6 | 6 | 6 |
| | by knee (mm) | 13 | 13 | 13 |

2. INSTALL THE MOTOR (Fig.1)

Align Motor Pulley Groove (B) and Balance Wheel Groove (A) by moving the motor leftward or rightward.

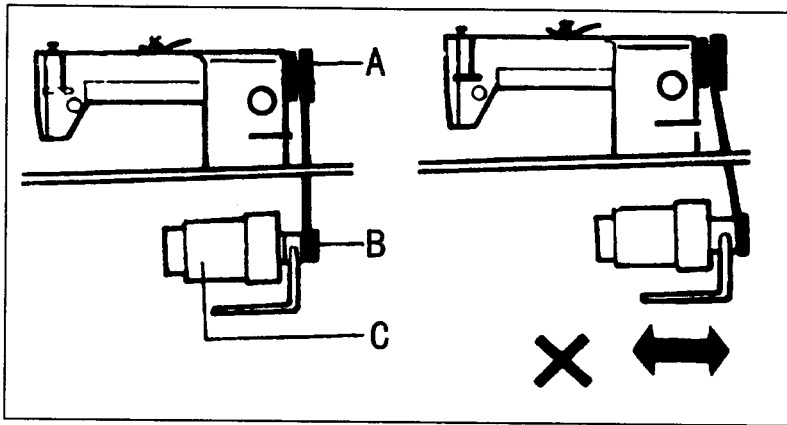


Fig. 1

3. CONNECT THE CLUTCH LEVER WITH THE PEDAL (Fig.2)

- 1) The optimum tilt angle of pedal (A) is approximately 15 deg.
- 2) Adjust Clutch Cover (D) so that Clutch-Lever (C) and Draw Bar (B) run in line.
- 3) The balance wheel should rotate counter-clockwise when viewed from the outside of Balance Wheel (G). The direction of the motor pulley rotation can be reversed (turning over 180 deg .) the power plug of the motor.
- 4) Adjust the tension of V-belt (F) by turning Motor Vertical Position Screw (E). The proper tension of the V-belt is a slack of 10-20mm when the belt is depressed at the center of the belt by finger.

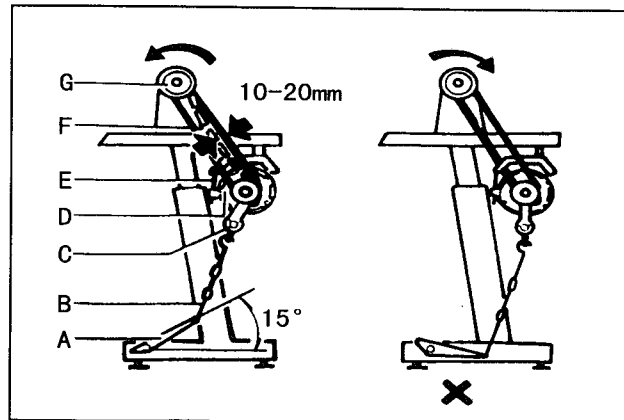


Fig. 2

4. Adjustment of needle bar stop position(Fig3):

1) Adjustment of “UP” position

When the pedal is kicked down by heel to cut the thread, the machine stops in the “UP” position. If the marks deviate more than 3mm, adjust as follows:

- (1) Disconnect the plug (12 pins) from the control panel;
- (2) Run the machine and stop in the “UP” position;
- (3) While holding the pulley, insert the adjusting tool into the two holes marked “A”, then rotate the pulley.

2) Adjustment of “DOWN” position

When the pedal is returned to the neutral position, the machine stops in the “DOWN” position. If the marks deviate more than 3mm, adjust as follows:

- (1) Disconnect the plug (12 pins) from the control panel;
 - (2) Run the machine and stop in the “DOWN” position;
 - (3) While holding the pulley, insert the adjusting tool into the two holes marked “B”, then rotate the pulley.
- 3) Confirm the stop operation then the plug (12 pins) coming from the machine head into the receptacle.

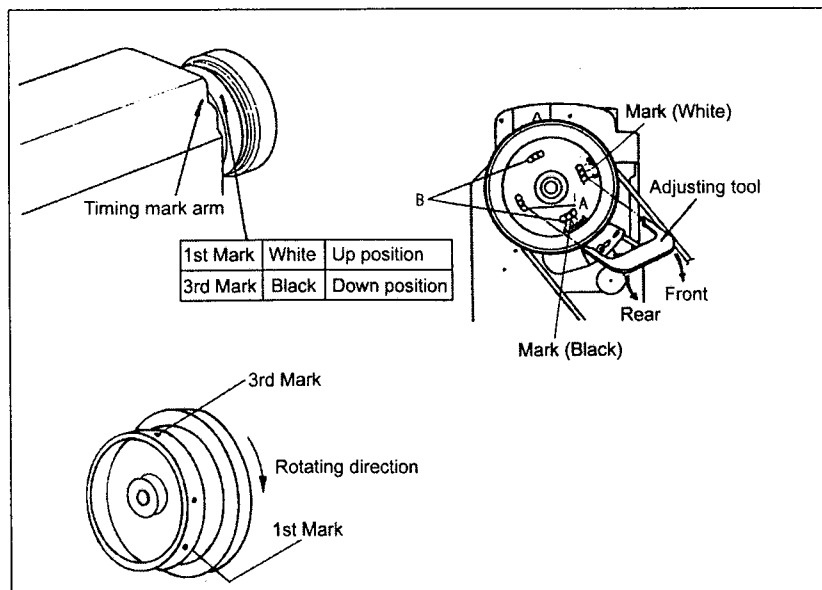


Fig. 3

5. PREPARATION AND LUBRICATION (Fig.4)

1) Cleaning the machine

Before leaving the factory, the machine parts are coated with rust-preventive grease, which may be hardened and contaminated by dust during storage and shipment. This grease must be removed with gasoline.

2) Examination

Though every machine is confirmed by strict inspection and test before leaving the factory, the machine parts may be loose or deformed after long distance transportation with jolt. A thorough examination must be performed after cleaning the machine. Turn the balance wheel to see if there is running obstruction, parts collision, uneven resistance or abnormal noise. If these exist, adjustment must be made accordingly before run-in operation.

3) Oiling

(1) Required amount of oil.

Line (A) on the oil reservoir: Max. oil level.

Line (B) on the oil reservoir: Min. oil level.

If oil level goes down under line (B), oil cannot be distributed to each part of the machine, thus causing the parts a seizure.

(2) Replenishing

Always use only No.18 special machine oil for high speed sewing. Be sure to replenish oil to Line (A) before starting operation.

(3) Replacing oil

To replace oil, remove Screw (C) to drain oil. After completely draining off oil, clean the oil reservoir and securely tighten Screw (C), then fill the reservoir with fresh oil.

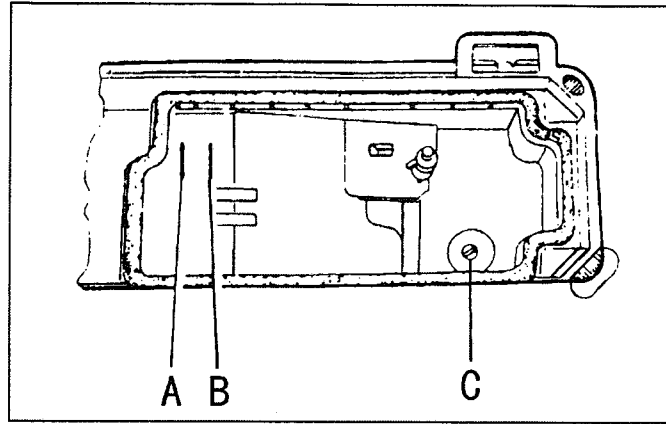


Fig. 4

6. REPLACE NEEDLES (Fig.5)

Turn the balance wheel to lift needle bar to the upper end of its stroke. Loosen Needle Clamp Screw 1. While keeping the long groove of the needle leftward fully insert the needle shank up to the bottom of the needle socket. Then tighten Needle Clamp Screw A.

Note: Fig. (b): insufficient insertion.

Fig. (c): wrong direction of long groove.

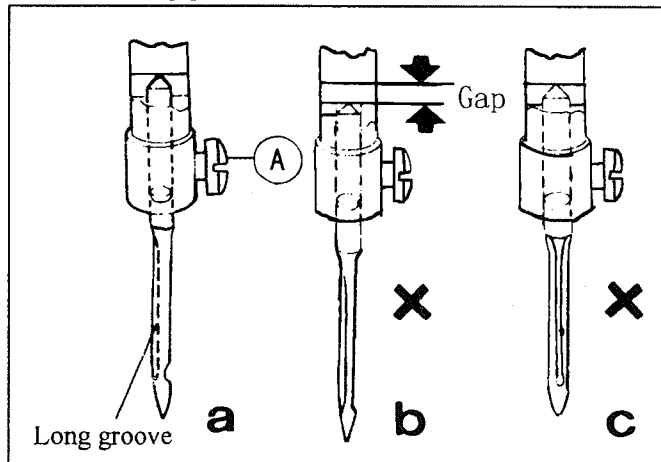


Fig. 5

7. RUN-IN OPERATION (Fig. 6)

Run-in operation is required for a new sewing machine, or a sewing machine left out operation for a considerable length of time.

1) Remove Red Rubber Plugs (A) on the top of the arm and replenish sufficient amount of oil.

2) Lift Presser Foot (B).

3) Run the machine at a low speed (2000-2500spm) to check oil distributing condition through Oil Check Window (C).

4) Perform run-in operation at 2000-2500spm for 30minutes. After a lapse of one month of service during which the working speed is increased gradually and the machine runs sufficiently well, the high speed 5000spm can be adopted according to the nature of the work.

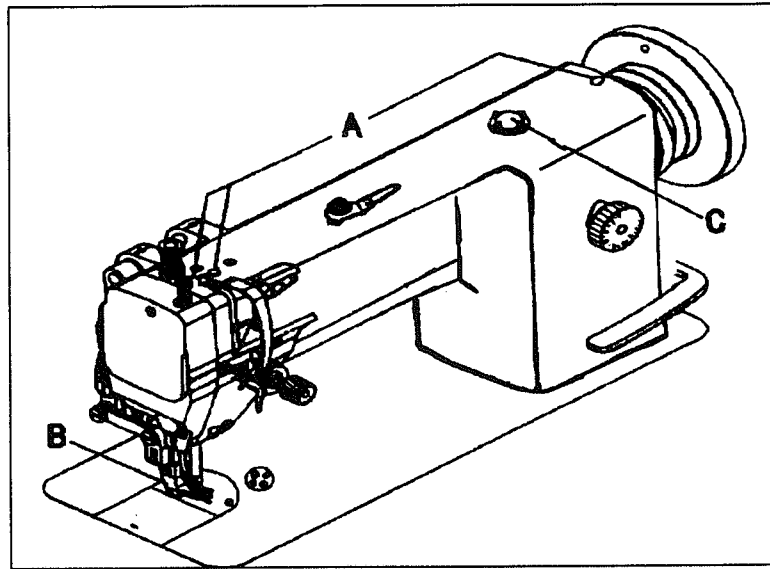


Fig. 6

8. THREADING (Fig.7)

To thread the needle thread, raise needle bar to the upper end of its stroke, lead the thread from spool and perform threading as shown in Fig.7 . To draw the bobbin thread, hold the end of the needle thread and turn the balance wheel to lower the needle bar and then to lift it to its highest position. Pull the needle thread and the bobbin thread is drawn up. Put the ends of needle thread and bobbin thread frontward under presser foot.

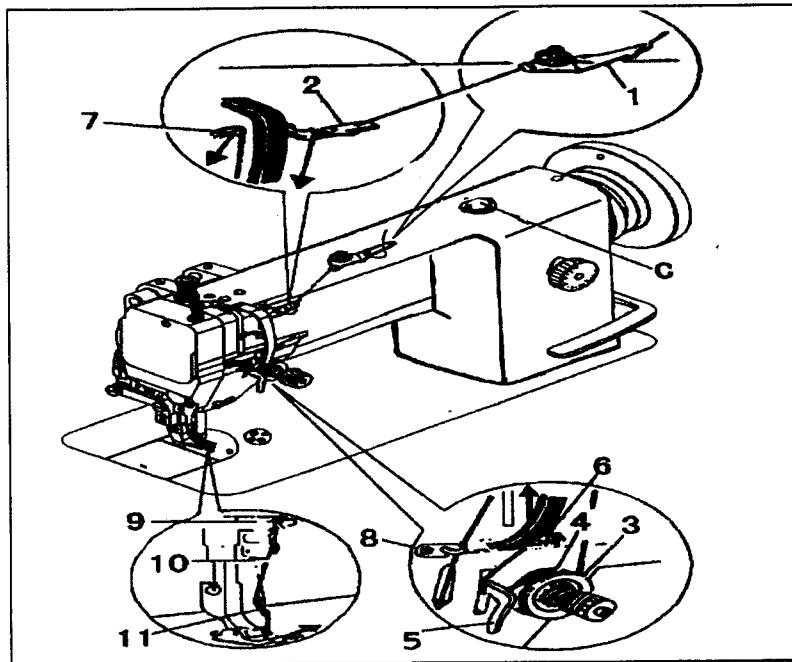


Fig. 7

9. WINDING ADJUSTMENT (Fig.8)

1) The wound bobbin thread should be neat and tight, if not, adjust the winding tension by turning Tension Stud Nut (A) of bobbin winder tension bracket.

Note: nylon or polyester thread should be wound with little tension, otherwise, Bobbin (D) might break or deform.

2) When the wound thread layer does not present a cylindrical shape as shown in Fig.7 (a), loosen Set Screw (B) of bobbin winder tension bracket and slide Bracket (C) leftward or rightward. If thread is wound as shown in Fig.7 (b), move the bracket rightward, but if thread is wound as shown in Fig.7 (c), move the bracket leftward.

After adequately positioning the bracket, tighten Set Screw (B).

3) Do not overfill the bobbin. The optimum length of thread will fill about 80% of bobbin capacity. This can be adjusted by Adjusting Screw (E) of bobbin winder stop latch.

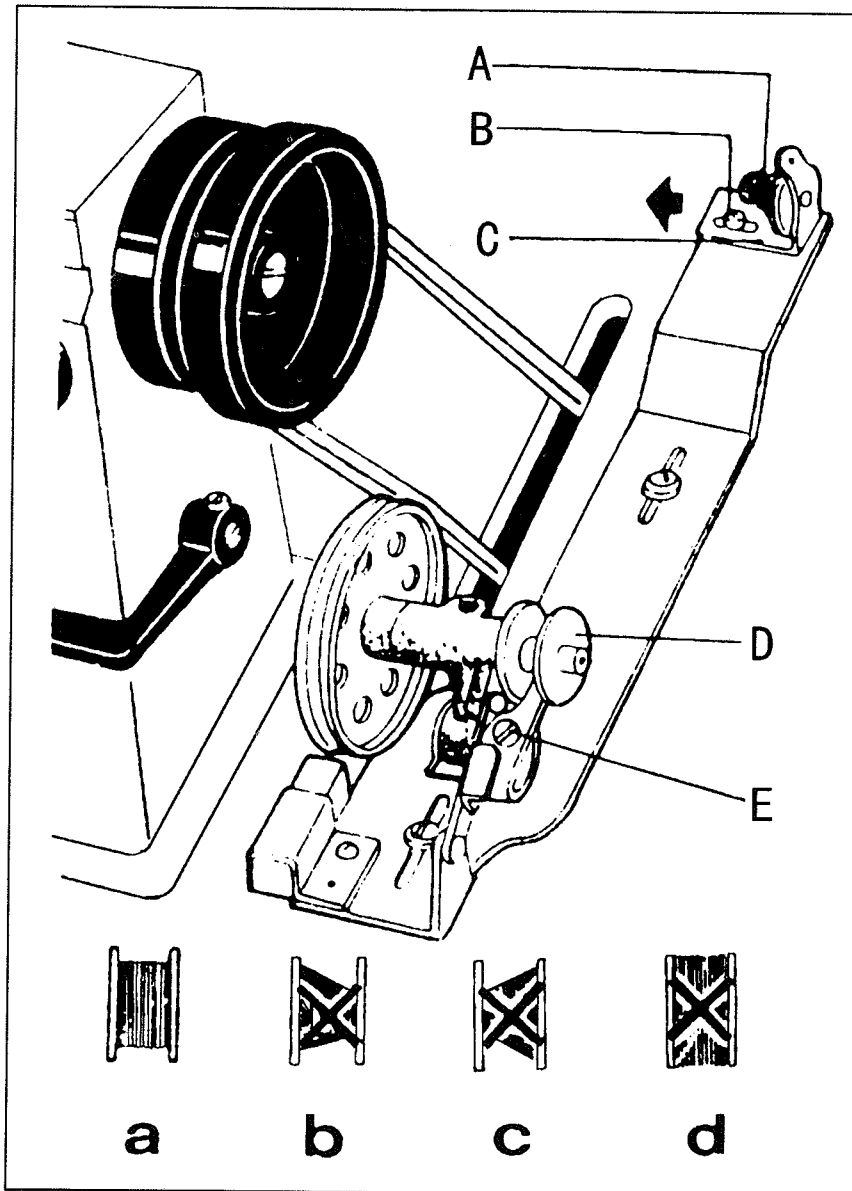


Fig. 8

10. SET STITCH LENGTH AND REVERSE FEEDING (Fig.9)

- 1) Stitch length can be set by turning Dial (A).
- 2) The figures on Face (B) of dial show stitch length in mm.
- 3) Reverse feeding starts when Reverse Feed Lever (C) is depressed, and the machine will feed forward again if Reverse Feed lever (C) is released.

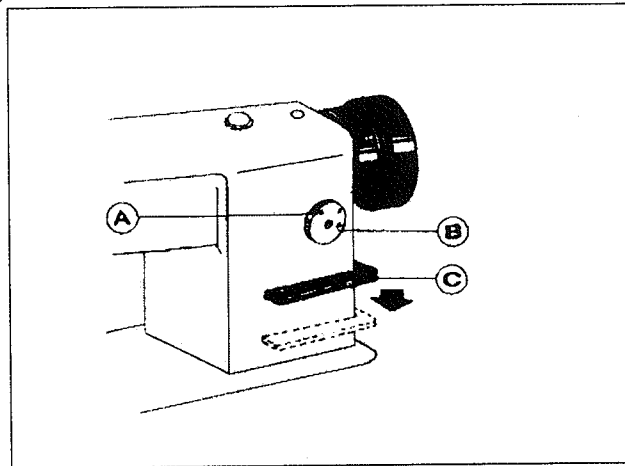


Fig. 9

11. POSITION PRESSER BAR (Fig.10)

- 1) Loosen lock Nut (E) and Pressure Regulating Thumb Screw (A).
- 2) Remove rubber plug from Face Plate (B).
- 3) Loosen Screw (C) and adjust the position of Presser Bar (D) till the presser foot is 6 mm above the throat plate will the presser foot lifted to its highest.
- 4) Tighten Screw (C) and put in the rubber plug.
- 5) Tighten pressure Regulating Thumb Screw (A) and Lock Nut (E).

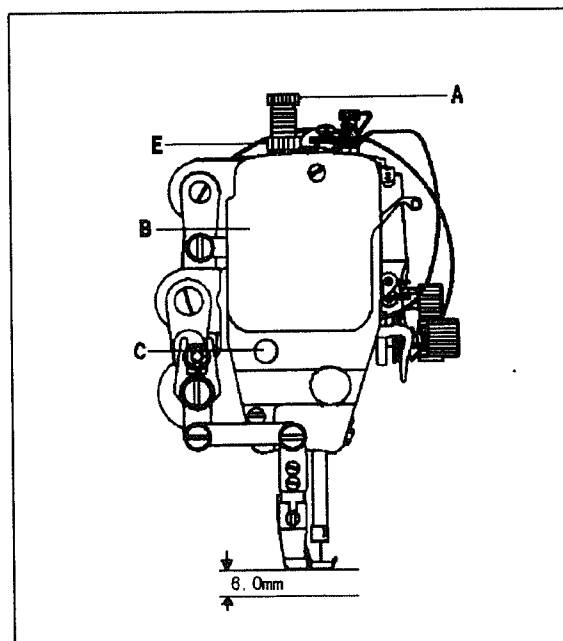


Fig. 10

12. ADJUST THE PRESSURE OF PRESSER FOOT (Fig.11)

Pressure of presser foot is to be adjust in accordance with thickness of materials to be sewn.

First loosen Lock Nut (A). For heavy materials, turn the pressure regulating thumb screw as shown in Fig.10 (a) to increase the pressure, while for light materials, turn the pressure regulating thumb screw as shown in Fig.10 (b) to decrease the pressure. Then tighten Lock Nut (A).

The pressure of presser foot is recommended to be less as long as normal feeding is ensured.

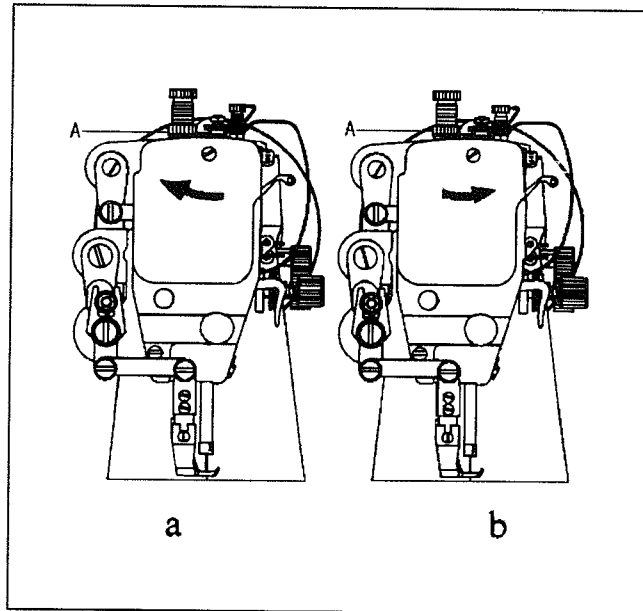


Fig. 11

13. ADJUST THREAD TENSION (Fig.12,13)

In principle, thread tension is to be adjusted in accordance with materials, thread and other factors.

In practice, thread tension is adjusted according to the stitches obtained. The needle thread tension should be adjusted with reference to the bobbin thread tension. Turn Tension Spring Regulating Screw (A) of bobbin case clockwise for more tension, or turn the screw counter-clockwise for less tension.

It is common practice to test the bobbin test the bobbin thread tension as shown in Fig.13 . Hold the end of the thread from delivery eye. If the bobbin case is falling slowly, the proper tension is obtained. The needle thread tension can be adjusted by setting (1) the take-up spring tension. (2) the thread take-up spring stroke and (3) tension spring. All these adjustments will be described in the following.

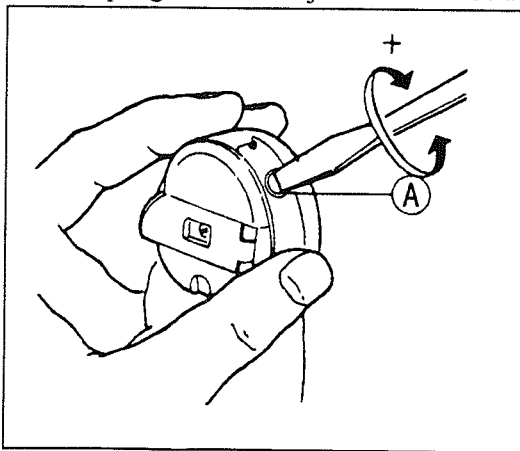


Fig. 12

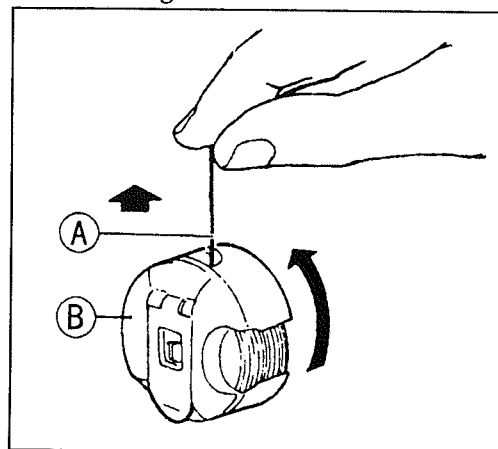


Fig. 13

14. ADJUST THREAD TAKE-UP SPRING (Fig.14,15)

1) Adjusting the thread take-up spring tension

Loosen Set Screw (A), turn Tension Stud (B) clockwise to increase the spring tension, or turn the stud counter-clockwise to decrease the spring tension. After the adjustment, be sure to tighten Set Screw (A). The thread take-up spring tension should be about 30g. To Attain this. First loosen Set Screw (A), turn Tension Stud (B) counter-clockwise to decrease the tension of Thread Take-up Spring (C) to zero, then turn Tension Stud (B) clockwise until Spring (C) comes to the notch of thread tension regulating bushing, and again turn Tension Stud (B) halfway back (counterclockwise) After the adjustment. Tighten Set Screw (A).

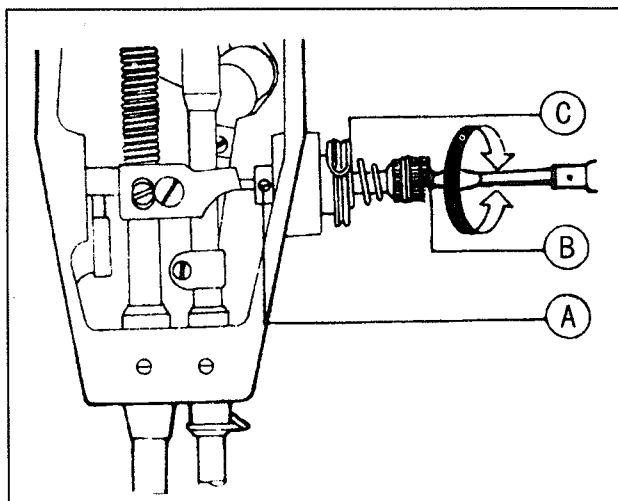


Fig. 14

2) Adjusting the thread take-up spring stroke

Loosen Set Screw (B), turn Stud (C) clockwise to increase the stroke or turn Stud (C) counter-clockwise to decrease the stroke. After the adjustment, tighten Set Screw (B).

Before leaving the factory, the thread take-up spring has properly been adjusted. Readjustment is needed only in the case of special material or special thread.

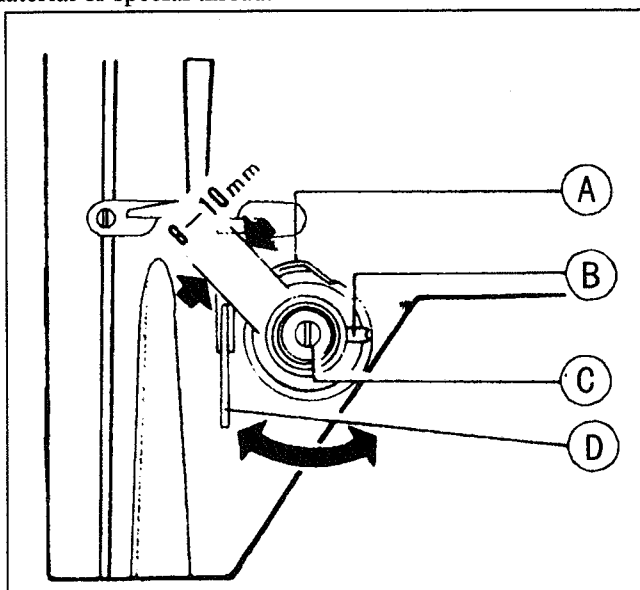


Fig. 15

15. ADJUST THREAD GUIDE AND THREAD TENSION (Fig.16,17)

The position of the thread guide affects stitch tightness and therefore must be adjusted according to sewing materials and sewing conditions.

| | 1 | 2 | 3 |
|-----------------------|----------|--------|-----------|
| Thread guide position | Leftward | Center | Rightward |
| Material weight | Heavy | Medium | Light |

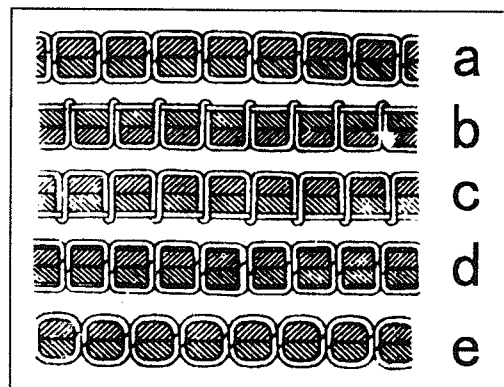


Fig. 16

1) In case needle thread tension is too strong or bobbin thread tension is too weak, as shown in Fig.15 (b), turn the thumb nut counterclockwise to decrease the needle thread tension, or tighten the tension spring regulating screw of bobbin case to increase the bobbin thread tension (See Fig.16)

2) In case needle thread tension is too weak or bobbin thread tension is too strong, as shown in Fig.15 (c), turn the thumb nut clockwise to increase the needle thread tension, or loosen the tension spring regulating screw of bobbin case to decrease the bobbin thread tension.

3) In case of the stitch forms as shown in Fig.15 (d) and (e), adjustments can be made with reference to the above means.

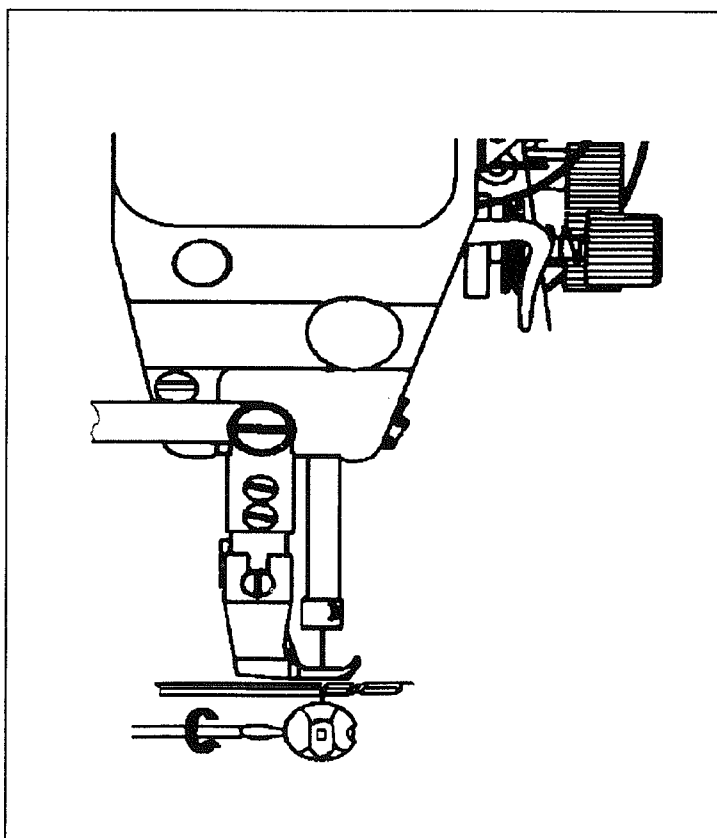


Fig. 17

16. TIME NEEDLE TO ROTATING HOOK (Fig.18,19,20,21)

A. Adjusting the needle position (See Fig.18)

- 1) Turn balance wheel by hand to bring Needle Bar (C) to the lowest position of its stroke.
- 2) Remove rubber plug from Face Plate (A).
- 3) Loosen Set Screw (B) of needle bar adaptor.
- 4) Move Needle Bar (C) vertically to adjust needle timing.
- 5) After the adjustment, tighten Set Screw (B) and put in the rubber plug. The standard needle timing (See Fig.18) is to align Timing Mark (B) on the needle bar and the bottom of Needle Bar Bushing (A) and meanwhile align the Inner Surface (E) of the hook and the center of Needle Eye (D) when the needle bar gets down to its lowest position.

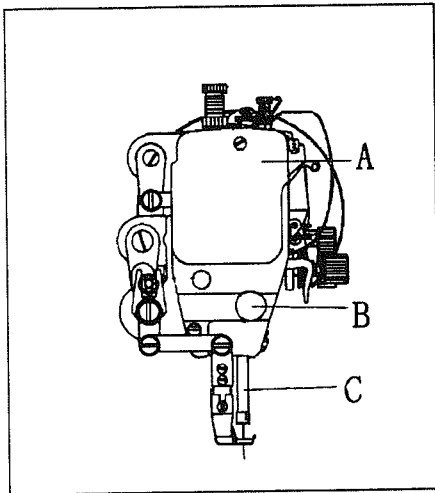


Fig. 18

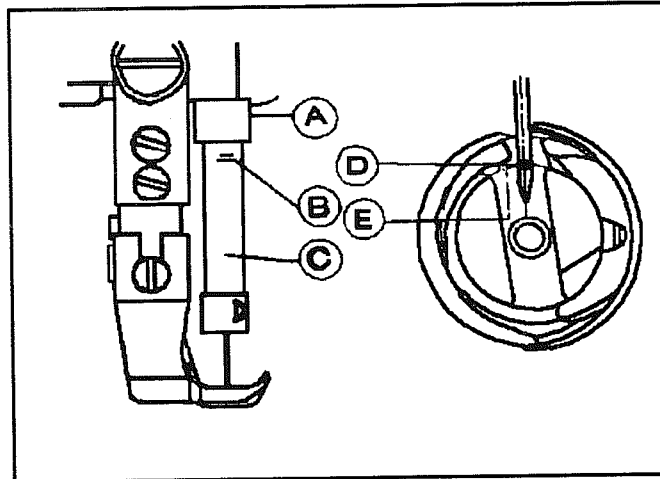


Fig. 19

B. Adjusting the hook point timing

Timing of needle motion to rotating hook motion has a great effect on sewing performance. The standard hook point timing (See Fig.20) is to align Hook Point (D) and Needle Centerline (C) when Needle Bar (B) is lifted by 2.2mm from the lower end of its stroke. Besides, Hook Point (D) should be 1.0-1.5mm above the upper end of needle eye (E).

When adjusting the hook point timing, also notice that the clearance between the bottom of needle notch and Hook Point (C) should be approx. 0.05mm (See Fig.21)

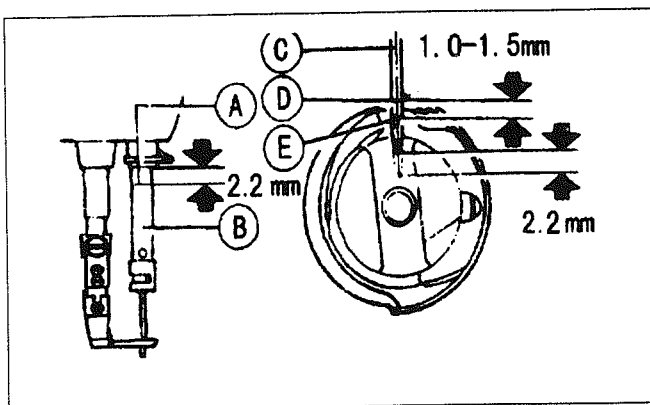


Fig. 20

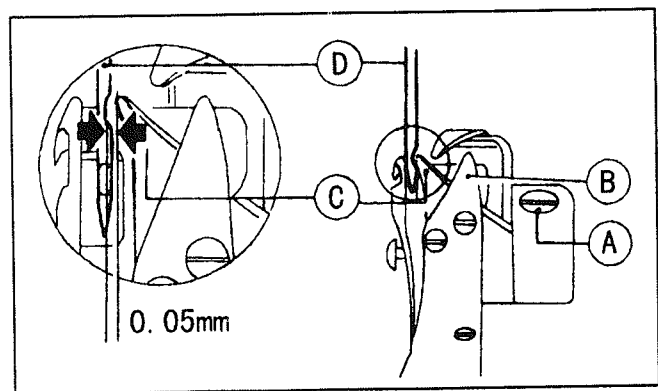


图 21

17. REPLACE ROTATING HOOK (Fig.22)

- 1) Lift needle bar to the highest position of its stroke.
- 2) Remove throat plate, take down needle and bobbin case.
- 3) Loosen Screw (C) of hook positioner and take down Hook Positioner (A).
- 4) Loosen two Screws (D) of rotating hook.
- 5) Turn balance wheel to raise feed bar to its highest position, then take down the rotating hook by turning it away from feed bar.
- 6) Installing the hook can be done in reverse sequence. Note that Needle (B) and the convex surface of Hook Positioner (A) should align with a clearance of 0.5-0.7mm between them.

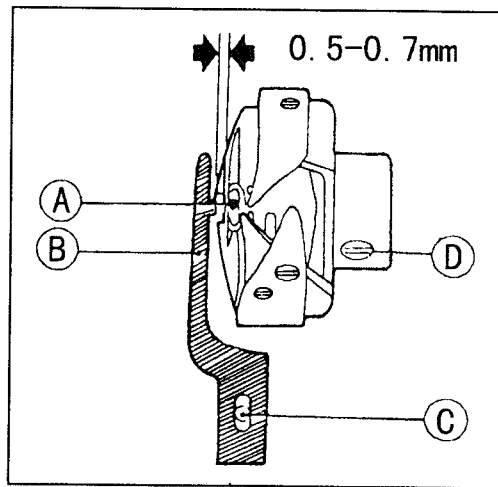


Fig. 22

18. ADJUST THE HEIGHT OF FEED DOG (Fig.23,24)

- 1) Turn balance wheel until feed dog is lifted to its highest position from throat plate surface.
- 2) Loosen Screw (A) of feed lifting rock shaft crank right (See Fig.23,b)
- 3) Move Feed Bar (B) in the direction shown by the arrow in Fig. 23 (a) to adjust the height of the feed dog. The standard height of feed dog is that the top of feed dog is 1mm above Throat Plate Surface (B).
- 4) After the adjustment, be sure to tighten Screw (A).

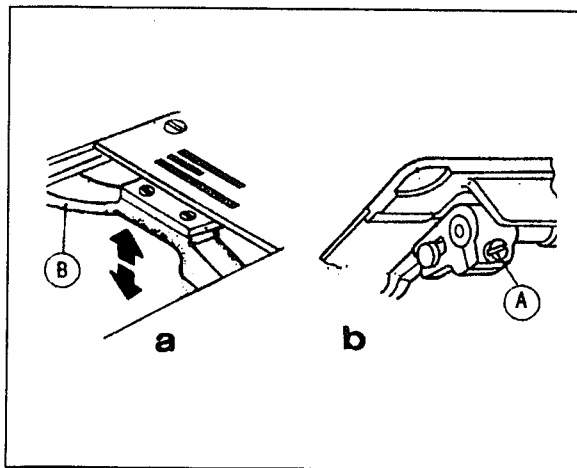


Fig. 23

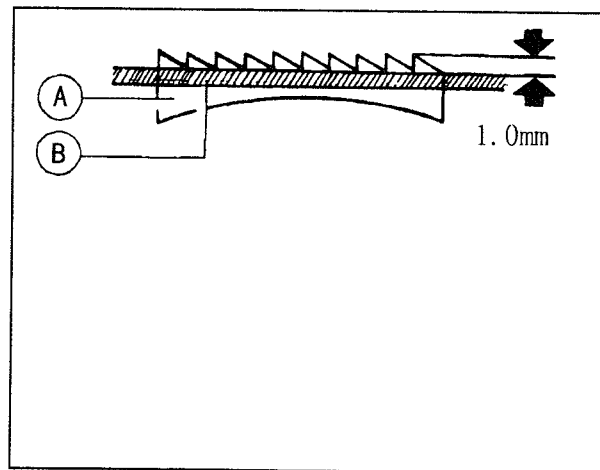


Fig. 24

19. Adjustment of feed dog inclination (Fig.25,26):

If necessary, adjust the inclination according to the material to be sewn as follows:

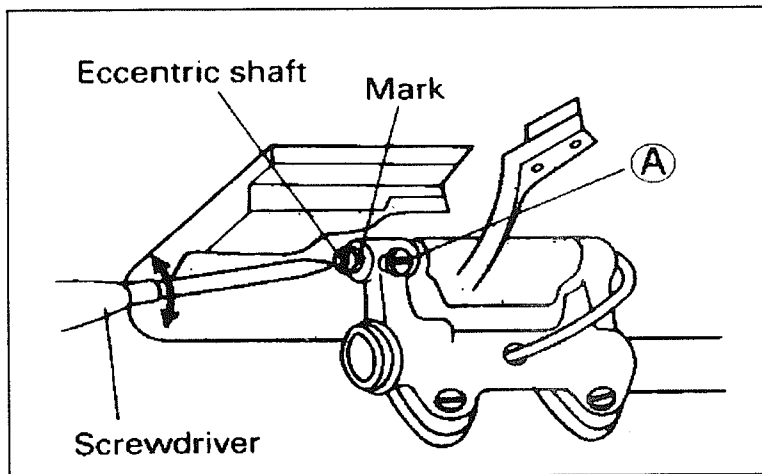


Fig. 25

- 1) Loosen the screw "A".
- 2) Rotate the eccentric shaft clockwise or counterclockwise with screw driver.
- 3) Tighten the screw "A".


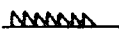

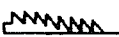


| Position of mark on the eccentric shaft | Feed dog |
|--|---|
|  Horizontal |  Standard |
|  Up |  Front up (MAX.) |
|  Down |  Front down (MAX.) |

Fig. 26

20. TIME FEED MOTION TO NEEDLE MOTION (Fig.27,28,29)

The standard timing of feed motion to needle motion is that the top of feed Dog (C) is flush with Throat Plate Surface (B) when the point of Needle (A) reaches Throat Plate Surface (B). See Fig.27 .

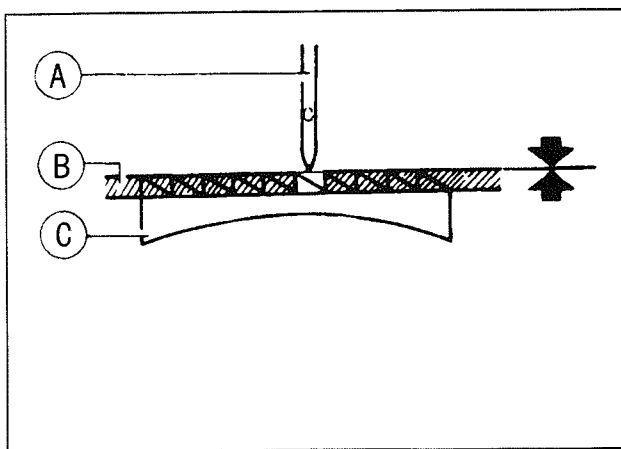


Fig. 27

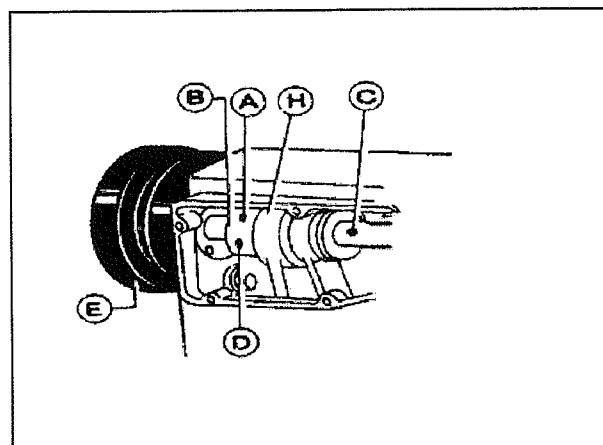


Fig. 28

If feed motion is not timed to needle motion, adjust as follows (See Figs.28 and 29).

- 1) Remove Arm Side Cover .
- 2) Loosen Set Screws (A) and (D) of feed and feed lifting eccentric.
- 3) Hold Feed and Feed Lifting Eccentric (B) and turn Balance Wheel (E) slowly until the upper edge of Arm Shaft Oil Hole (C) aligns with the lower edge of Reference Hole (G) of feed and feed lifting eccentric.

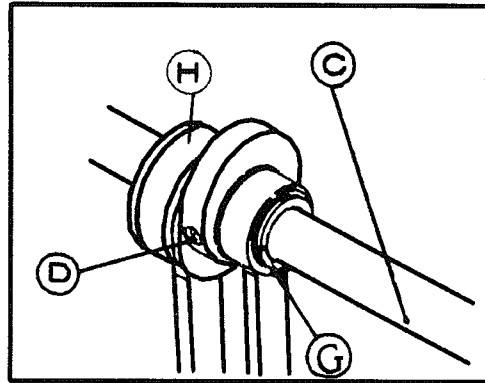


Fig. 29

21. ADJUST OPENING TIME OF THE TENSION DISCS (Fig.30)

within the presser foot lift range of 2-7mm opening time of the tension discs can be adjusted as follows:

- 1) Remove the rubber plug from the back of arm and loosen Screw (A) of knee lifter lever (left).
- 2) Move the tension releasing cam leftward for earlier opening or rightward for later opening. It will facilitate the adjustment to put under the presser foot a block as thick as the presser foot lift.
- 3) After the adjustment, fully tighten Screw (A).

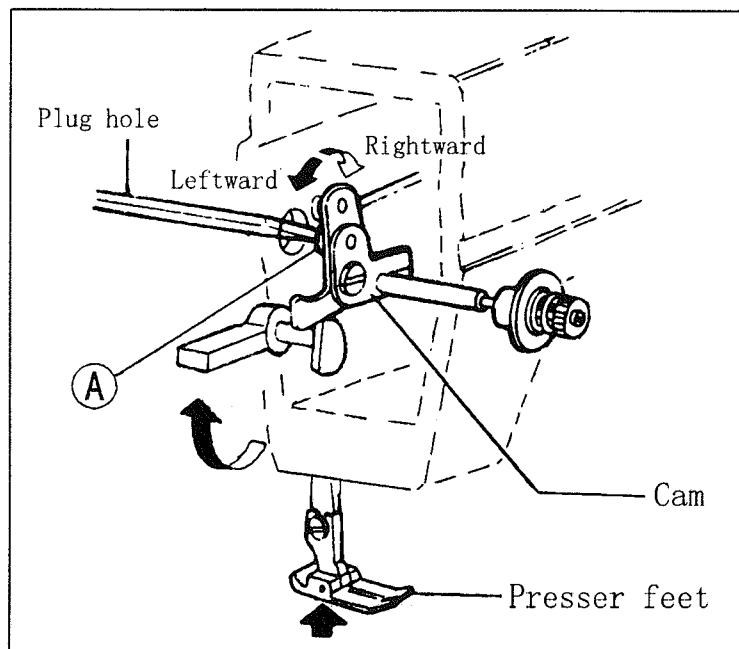


Fig. 30

22. LUBRICATION ADJUSTMENT (Fig.31)

A. Adjusting oil pump.

In ordinary operation, adjustment is not required for the oil pump. If oil splashing does not occur in the oil check window when the machine runs at a low, speed (approx.2000spm), reduce the clearance of the by-pass hole.

B. Adjusting the lubrication of rotating hook.

The lubrication of the rotating hook can be adjusted by Oil Adjusting Screw (A) as follows:

1) Turn Oil Adjusting Screw (A) clockwise to increase oil and turn Oil Adjusting Screw (A) counterclockwise to decrease oil.

2) Oil Adjusting Screw (A) adjusts oil amount within 5 turns. When Oil Adjusting Screw (A) is fully tightened, oil amount is maximum.

3) Readjustment depends on temperature, sewing speed and the like. In practice, oil amount can be judged as follows: remove the throat plate and place a piece of paper on instead, run the machine for about 20 seconds, then check the oil splashed on the paper.

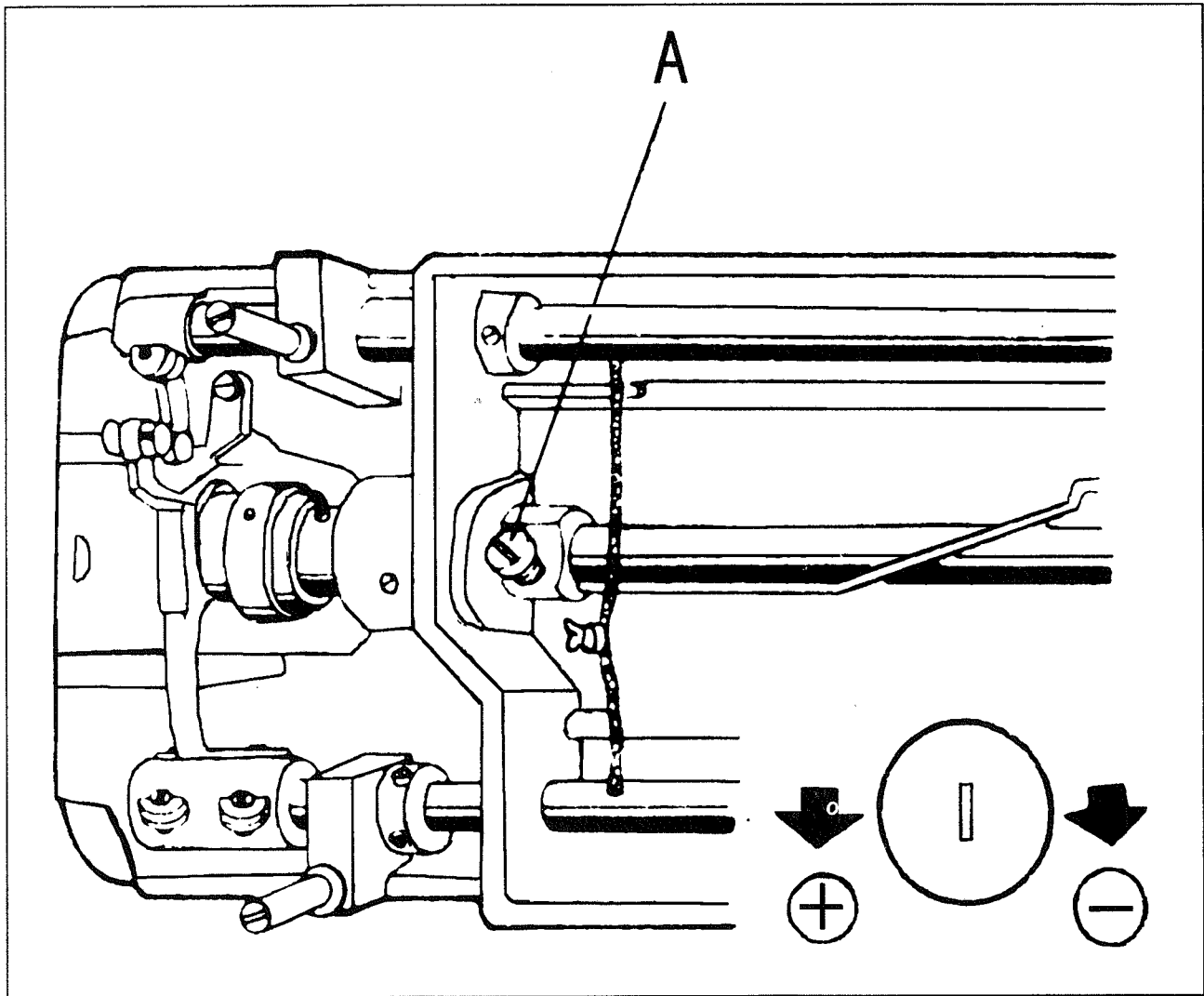


Fig. 31

23. REGULAR CLEANING (Fig.32,33,34)

1) Cleaning feed dog (See Fig.32)

Remove the throat plate and clear off the dust and lint between feed dog tooth slots.

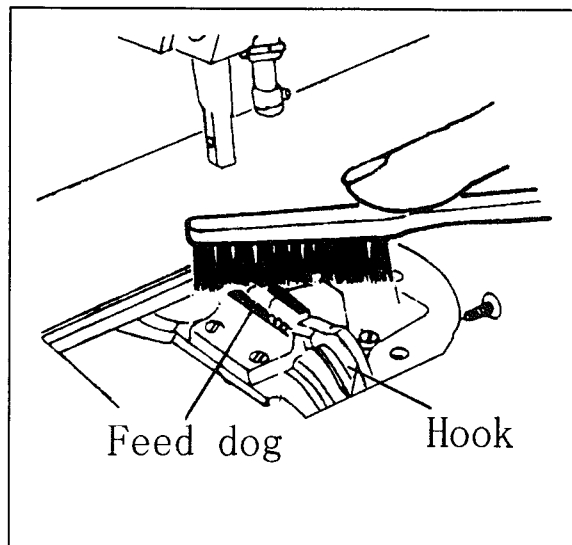


Fig. 32

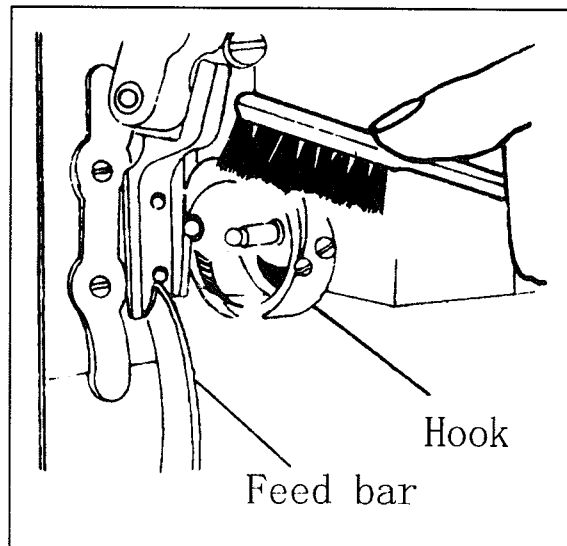


Fig. 33

2) Cleaning rotating hook (See Fig 33)

Swing out the machine head and clean the hook. Wipe the bobbin case with soft cloth.

3) Cleaning oil pump, screen (See Fig.34)

Swing out the machine head and clear off the dust and dirt on oil pump screen.

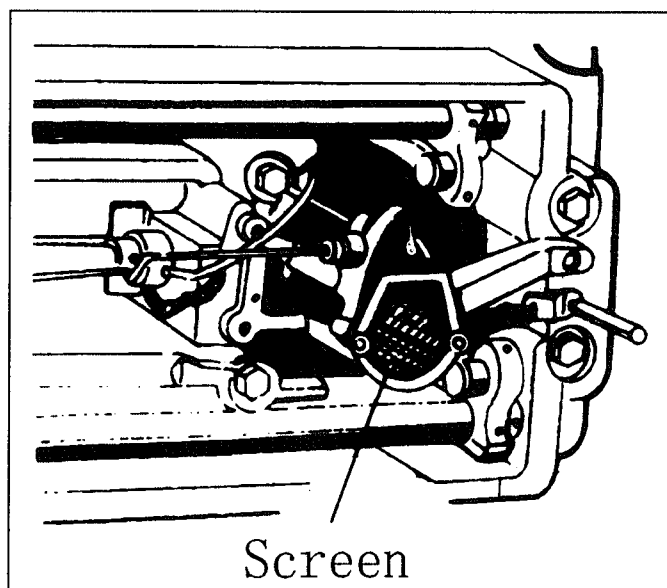
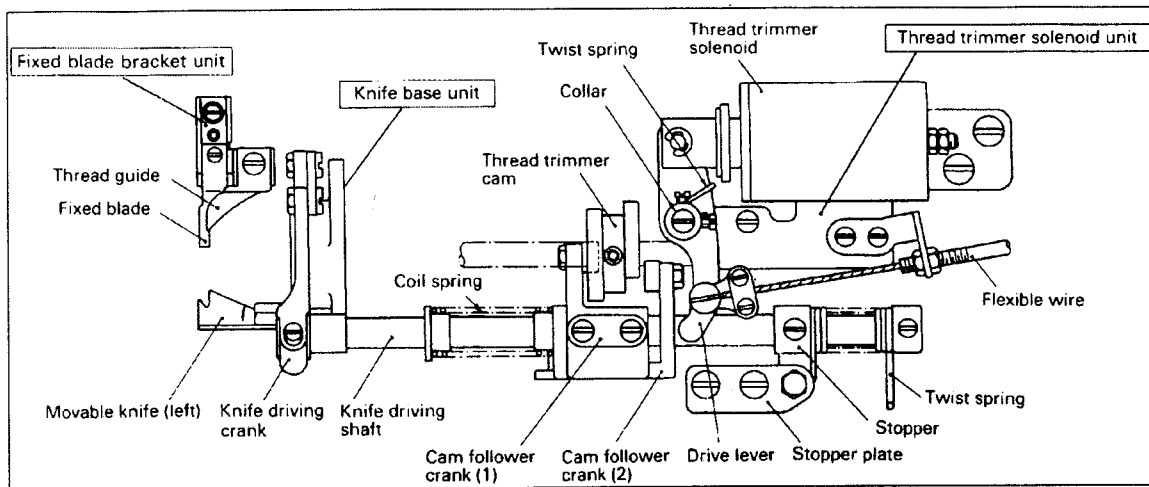


Fig. 33

24、 Adjustment of thread trimmer mechanism:

1) The thread trimmer mechanism illustrated as Fig.35.



(1) Operation stroke of the thread trimmer solenoid:

- a. Standard operation stroke is 6.0mm.
- b. This stroke can be adjusted by using nut "A".

2) Adjustment of knife engagement (Fig.36):

(1) Position of movable knife (left) and fixed blade:

See the Fig.36, the standard distances from the needle center are 7.5mm and 5mm from the movable knife (left) and fixed blade respectively.

(2) Adjustment of knife engagement:

With the solenoid activated, turn on the machine. This rotates the threadtrimming cam which rotates the movable knife (left). When the movable knife (left) has moved to its farthest distance, the standard engagement of the blade is 1.5mm-2.0mm. The engagement can be adjusted by properly mounting the drive arm.

(3) Adjustment of knife engagement pressure:

a. If a thread is poorly cut, particularly when it is thick, slightly increase the engaging pressure. This should solve the problem.

b. The engaging pressure can be adjusted in this way:

Loosen lock nut "B" and adjust it by using adjusting screw "A"

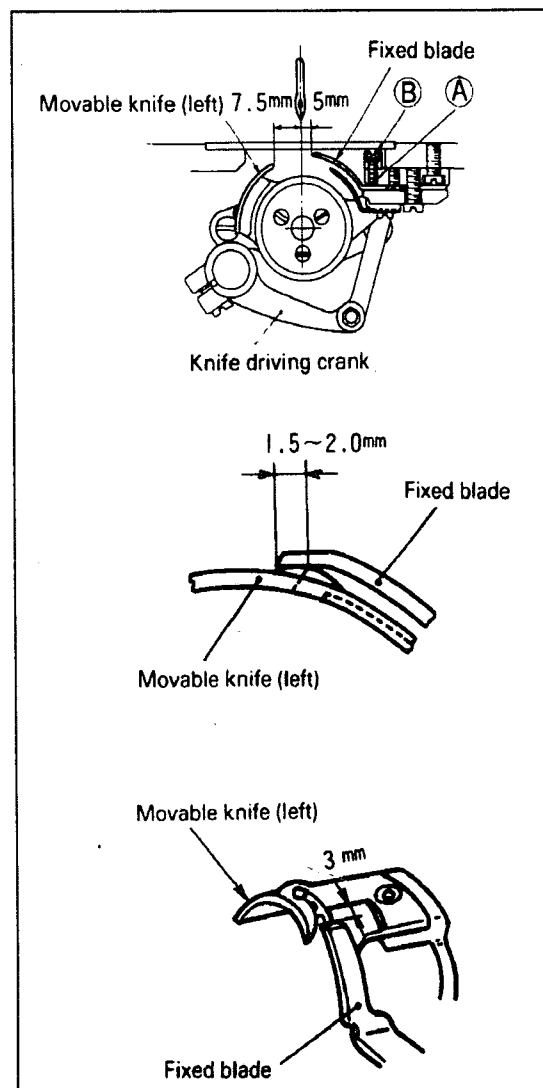
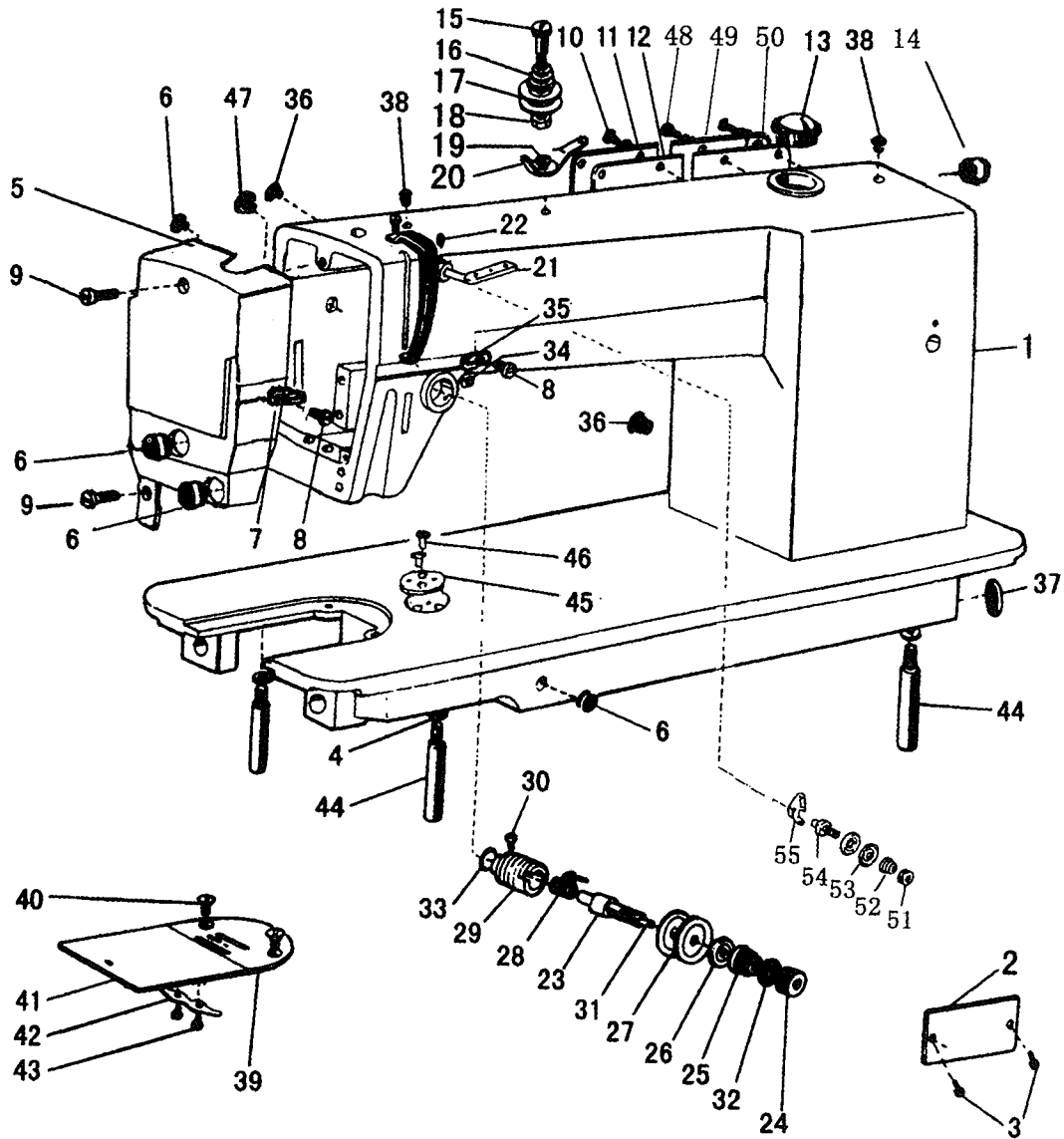


Fig. 36

A. ARM BED AND ITS ACCESSORIES



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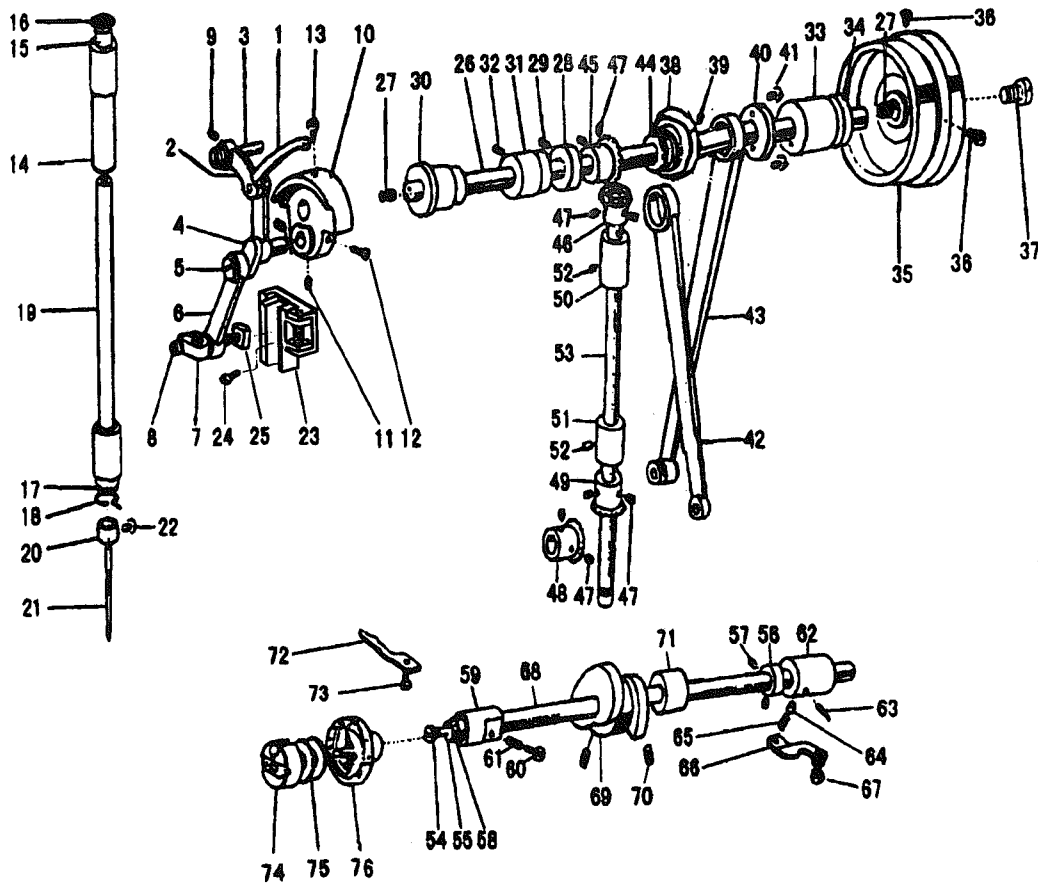
A.ARM BED AND ITS ACCESSORIES

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|-----------------------------------|-----------|-----------|-----------|------------|-----------------------------|
| A01 | HM307B8001 | Arm | 1 | | 1 | | |
| A01 | HN208B8001 | Arm | | 1 | | | |
| A01 | HN606B8001 | Arm | | | | 1 | |
| A02 | HM309B8001 | Trade mark plate | 1 | | | | |
| A02 | HN408B8001 | Trade mark plate | | 1 | | | |
| A02 | HN305B8001 | Trade mark plate | | | 1 | | |
| A02 | HN608B8001 | Trade mark plate | | | | 1 | |
| A03 | H924025050 | rivet | 6 | 6 | 6 | 6 | GB/T827 $\phi 2.5 \times 5$ |
| A04 | H005008060 | Spring washer | 2 | 2 | 2 | 2 | GB/T93 6 |
| A05 | H2005B0065 | Face plate | 1 | 1 | 1 | 1 | |
| A06 | HA306B0674 | Rubber plug ($\phi 11.8$) | 3 | 3 | 3 | 3 | |
| A07 | HA607B0671 | Thread guide on face plate | 1 | 1 | 1 | 1 | |
| A08 | HA106B0676 | Thread guide screw | 1 | 1 | 1 | 1 | SM9/64 (40) $\times 6$ |
| A09 | HA700B2030 | Face plate screw | 2 | 2 | 2 | 2 | SM11/64 (40) $\times 20$ |
| A10 | HA300B2170 | Screw group | 4 | 4 | 4 | 4 | |
| A11 | H6028B8001 | Arm side cover | 1 | 1 | 1 | 1 | |
| A12 | H6029B8001 | Gasket for arm side cover | 1 | 1 | 1 | 1 | |
| A13 | H1210B0671 | Check window | 1 | 1 | 1 | 1 | |
| A14 | H6030B8001 | Rubber plug ($\phi 22$) | 1 | 1 | 1 | 1 | |
| A15 | HA112B0691 | Screw type tension stud | 1 | 1 | 1 | 1 | SM11/64 (40) $\times 16$ |
| A16 | HA112B0692 | Spring for pre-tension | 1 | 1 | 1 | 1 | |
| A17 | HA112B0693 | Disc for pre-tension | 2 | 2 | 2 | 2 | |
| A18 | HA112B0694 | Spacer for pre-tension | 1 | 1 | 1 | 1 | |
| A19 | H007013030 | Stop ring | 1 | 1 | 1 | 1 | GB/T896 3 |
| A20 | HA112B0695 | Pre-tension thread guide | 1 | 1 | 1 | 1 | |
| A21 | HA100B2100 | Three-hple thread guide | 1 | 1 | 1 | 1 | |
| A22 | HA100B2110 | Set screw | 1 | 1 | 1 | 1 | SM11/64 (40) $\times 5.5$ |
| A23 | HA115B0701 | Thread tension stud | 1 | 1 | 1 | 1 | SM1/4 (40) $\times 17$ |
| A24 | HA310B0701 | Oil thumb nut | 1 | 1 | 1 | 1 | |
| A25 | HA505B0671 | Thread tension spring | 1 | 1 | 1 | 1 | |
| A26 | HA310B0702 | Thread tension releasing disc | 1 | 1 | 1 | 1 | |
| A27 | HA310B0705 | Thread tension disc | 2 | 2 | 2 | 2 | |
| A28 | HA505B0672 | Thread take-up spring | 1 | 1 | 1 | 1 | |
| A29 | HA310B0703 | Thread tension regulating bushing | 1 | 1 | 1 | 1 | |
| A30 | HA115B0708 | Set screw | 1 | 1 | 1 | 1 | SM9/64 (40) $\times 4$ |
| A31 | HA115B0709 | Thread tension releasing pin | 1 | 1 | 1 | 1 | |
| A32 | HA115B7010 | Stop disc | 1 | 1 | 1 | 1 | |
| A33 | HA115B7011 | Rubber ring | 1 | 1 | 1 | 1 | |
| A34 | HA300B2080 | Set screw | 1 | 1 | 1 | 1 | SM15/64 (28) $\times 6.8$ |
| A35 | HA600B2050 | Thread guide at arm center | 1 | 1 | 1 | 1 | |
| A36 | HA300B2090 | Rubber plug ($\phi 8.8$) | 2 | 2 | 2 | 2 | |
| A37 | HA300B2100 | Rubber plug ($\phi 27$) | 1 | 1 | 1 | 1 | |
| A38 | HA300B2110 | Red rubber plug ($\phi 5.7$) | 2 | 2 | 2 | 2 | |

A.ARM BED AND ITS ACCESSORIES

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|--------------------------|-----------|-----------|-----------|------------|-------------------|
| A39 | H2100B2120 | Needle plate | 1 | | | 1 | |
| A39 | HN208B8001 | Needle plate | | 1 | | | |
| A39 | H6520B8001 | Needle plate | | | 1 | | |
| A40 | HA300B2190 | Needle plate screw | 2 | 2 | 2 | 2 | SM11/64(40) × 4.5 |
| A41 | HA124B0711 | Slide plate | 1 | 1 | 1 | 1 | |
| A42 | HA124B0712 | Slide plate spring | 1 | 1 | 1 | 1 | |
| A43 | HA124B0713 | Screw | 2 | 2 | 2 | 2 | SM3/32(56) × 2.2 |
| A44 | HA100B2220 | Leg | 3 | 3 | 3 | 3 | |
| A45 | HA300B2140 | Plate for guide | 1 | 1 | 1 | 1 | |
| A46 | HA300B2130 | Screw | 2 | 2 | 2 | 2 | SM11/64(40) × 5 |
| A47 | HA307B0673 | Rubber plug | 1 | 1 | 1 | 1 | |
| A48 | HA300B2160 | Screw | 5 | 5 | 5 | | |
| A49 | H6409B8001 | Arm bed cover | 1 | 1 | 1 | | |
| A50 | H6410B8001 | Gasket for arm bed cover | 1 | 1 | 1 | | |
| A51 | HA710B0671 | Nut | | | | 1 | |
| A52 | HA710B0672 | Spring for pre-tension | | | | 1 | |
| A53 | HA112B0692 | Disc for pre-tension | | | | 2 | |
| A54 | HA710B0673 | Screw | | | | 1 | |
| A55 | HA710B0674 | Pre-tension thread guide | | | | 1 | |

B. NEEDLE BAR AND TAKE-UP LEVER, ARM SHAFT MECHANISM



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B.NEEDLE BAR AND TAKE-UP LEVER, ARM SHAFT MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|-------------------------------------|-----------|-----------|-----------|------------|-------------------|
| B01 | H11111C204 | Therad take-up lever | 1 | | 1 | 1 | |
| B01 | HA3111C104 | Therad take-up lever | | 1 | | | |
| B02 | H11112C104 | Thread take-up lever link | 1 | | 1 | 1 | |
| B02 | HA304C0012 | Thread take-up lever link | | 1 | | | |
| B03 | HA104C0653 | Hinge pin | 1 | 1 | 1 | 1 | |
| B04 | HA504C0651 | Thread take-up crank | 1 | 1 | 1 | 1 | |
| B04 | HA104C0655 | Needle bearing | 2 | 2 | 2 | 2 | |
| B05 | HA104C0656 | Set screw (left-handed) | 1 | 1 | 1 | 1 | SM9/64 (40) × 7 |
| B06 | HA304C0653 | Needle bar link | 1 | 1 | 1 | 1 | |
| B07 | HA104C0658 | Needle bar adaptor | 1 | 1 | 1 | 1 | |
| B08 | HA104C0659 | Screw | 1 | 1 | 1 | 1 | SM9/64 (40) × 6 |
| B09 | HA100C2020 | Set screw | 1 | 1 | 1 | 1 | SM15/64 (28) × 10 |
| B10 | HA307C0661 | Needle bar crank | 1 | 1 | 1 | 1 | |
| B11 | HA307C0662 | Set screw | 2 | 2 | 2 | 2 | SM1/4 (40) × 6 |
| B12 | HA100C2060 | Set screw | 1 | 1 | 1 | 1 | SM9/32 (28) × 13 |
| B13 | HA100C2070 | Set screw | 1 | 1 | 1 | 1 | SM9/32/ (28) × 14 |
| B14 | HA100C2080 | Needle bar bushing (upper) | 1 | 1 | 1 | 1 | |
| B15 | HA100C2100 | Felt plug | 1 | 1 | 1 | 1 | |
| B16 | HA300C2050 | Red rubber plug (φ 8.8) | 1 | 1 | 1 | 1 | |
| B17 | HA804B0652 | Needle bar bushing (lower) | 1 | 1 | 1 | 1 | |
| B18 | HA500C2060 | Thread guide for needle bar bushing | 1 | 1 | 1 | 1 | |
| B19 | H2100C2010 | Needle bar | 1 | | 1 | 1 | |
| B19 | HA700G2030 | Needle bar | | 1 | | | |
| B20 | HA500C2030 | Thread guide for needle bar | 1 | 1 | 1 | 1 | |
| B21 | H2000G2030 | Needle | 1 | | | 1 | DP × 17 22# |
| B21 | HA700G2040 | Needle | | 1 | | | DP × 5 14# |
| B21 | H6524B8001 | Needle | | | 1 | | DP × 17 25# |
| B22 | HA100C2170 | Needle clamp screw | 1 | 1 | 1 | 1 | SM1/8 (44) × 4.5 |
| B23 | HA100C2180 | Guide for slide block | 1 | 1 | 1 | | |
| B23 | HA704G0065 | Guide for slide block complete | | | | 1 | |
| B24 | HA100C2190 | Set screw | 2 | 2 | 2 | 2 | SM11/64 (40) × 8 |
| B25 | HA100C2200 | Slide block | 1 | 1 | 1 | 1 | |
| B26 | H2604C0651 | Arm shaft | 1 | 1 | 1 | 1 | |
| B27 | HA104D0652 | Rubber plug (φ 7.4 × 10) | 2 | 2 | 2 | 2 | |
| B28 | HA108G0661 | Collar for | 1 | 1 | 1 | 1 | |
| B29 | HA105D0662 | Set screw | 2 | 2 | 2 | 2 | SM1/4 (40) × 4 |
| B30 | HA100D2030 | Arm shaft bushing(left) | 1 | 1 | 1 | 1 | |
| B31 | HA100D2040 | Arm shaft bushing(middle) | 1 | 1 | 1 | 1 | |
| B32 | HA100C2020 | Set screw | 1 | 1 | 1 | 1 | SM15/64 (28) × 10 |
| B33 | HA300D2020 | Arm shaft bushing(right) | 1 | 1 | 1 | 1 | |
| B34 | HA306D0066 | Oil seal | 1 | 1 | 1 | 1 | |
| B35 | H2000C2040 | Balance wheel | 1 | 1 | 1 | 1 | |
| B36 | HA110D0672 | Set screw | 2 | 2 | 2 | 2 | SM15/64 (28) × 12 |

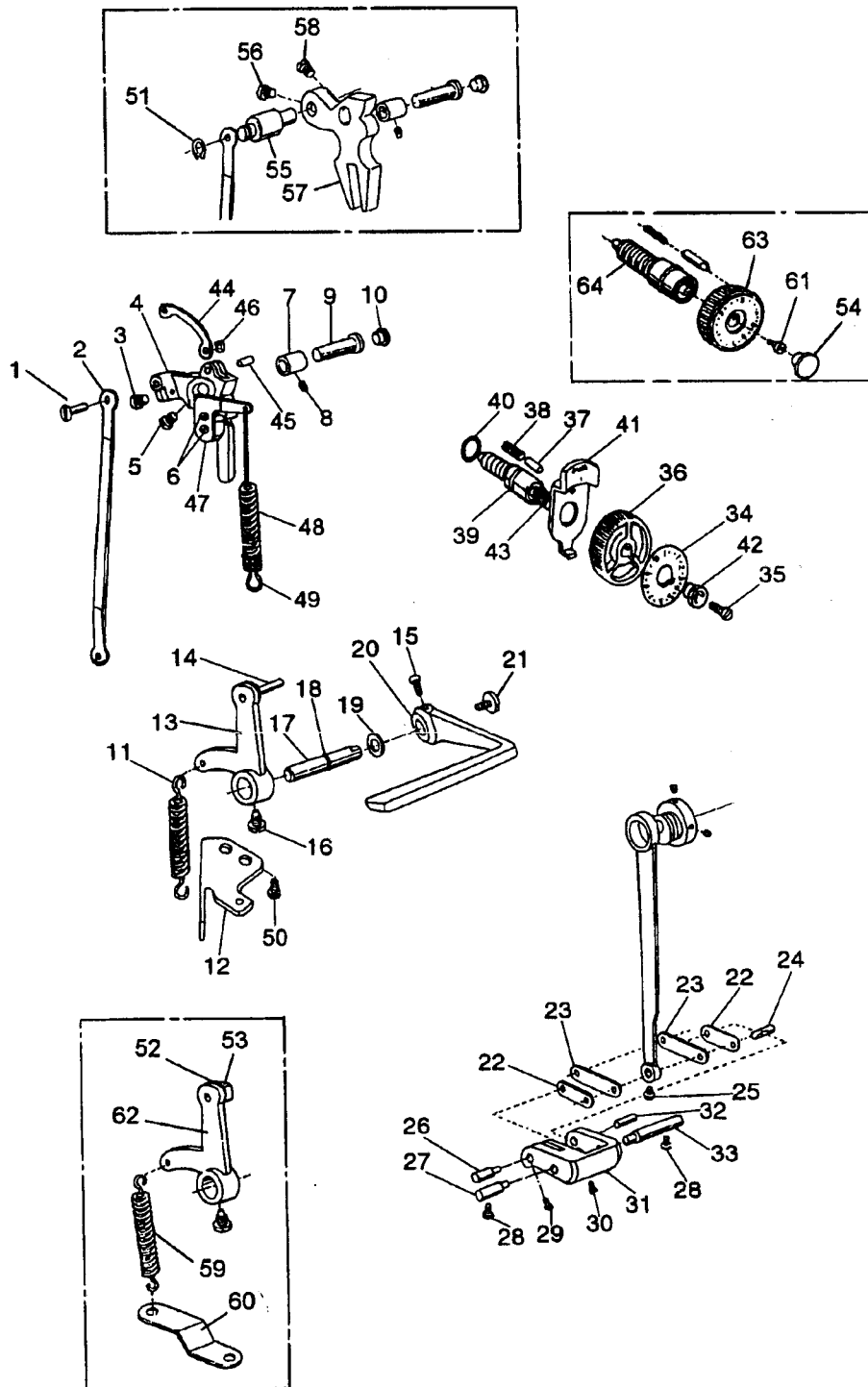
B.NEEDLE BAR AND TAKE-UP LEVER, ARM SHAFT MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|---------------------------------------|-----------|-----------|-----------|------------|---------------------|
| B37 | HA100D2080 | Screw | 1 | 1 | 1 | 1 | SM11/32 (28) × 10 |
| B38 | H6510D8001 | Feed and feed lifting eccentric | 1 | | 1 | 1 | |
| B38 | HA7311C106 | Feed and feed lifting eccentric | | 1 | | | |
| B39 | HA100C2020 | Set screw | 2 | 2 | 2 | 2 | SM15/54 (28) × 7 |
| B40 | H6511D8001 | Feed cam cover | 1 | | 1 | 1 | |
| B40 | HA7311C206 | Feed cam cover | | 1 | | | |
| B41 | HA7311C306 | Set screw | 3 | 3 | 3 | 3 | 82T2-003C1a1 |
| B42 | HA112D3013 | Crank rod for feed lifting rock shaft | 1 | 1 | 1 | 1 | |
| B43 | HA7311C506 | Feed rock | 1 | 1 | 1 | 1 | |
| B44 | HA112D3012 | stop ring | 1 | 1 | 1 | 1 | |
| B45 | HA113D2112 | Bevel gear for arm shaft | 1 | 1 | 1 | 1 | |
| B46 | HA113D2122 | Bevel gear for vertical shaft(upper) | 1 | 1 | 1 | 1 | |
| B47 | HA108C0663 | Set screw | 8 | 8 | 8 | 8 | SM1/4 (40) × 7 |
| B48 | HA113D2212 | Bevel gear for hook shaft | 1 | 1 | 1 | 1 | |
| B49 | HA113D2222 | Bevel gear for vertical shaft(lower) | 1 | 1 | 1 | 1 | |
| B50 | HA100D2110 | Vertical shaft bushing(upper) | 1 | 1 | 1 | 1 | |
| B51 | HA600D2010 | Vertical shaft bushing(lower) | 1 | 1 | 1 | 1 | |
| B52 | HA100C2020 | Set screw | 2 | 2 | 2 | 2 | SM15/64 (28) × 10 |
| B53 | H2100D2010 | Vertical shaft | 1 | 1 | 1 | 1 | |
| B54 | HA1111E104 | Filter screw | 1 | 1 | 1 | 1 | SM3/16 (32) × 9 |
| B55 | HA1111E204 | Filter | 1 | 1 | 1 | 1 | |
| B56 | HA305E0661 | Collar for hook shaft | 1 | 1 | 1 | 1 | |
| B57 | HA305E0662 | Set screw | 2 | 2 | 2 | 2 | SM15/64 (28) × 4.5 |
| B58 | HA106E0071 | Oil seal for rotating hook shaft | 1 | 1 | 1 | 1 | |
| B59 | HA100E2040 | Hook shaft bushing (left) | 1 | 1 | 1 | 1 | |
| B60 | HA100E2050 | Oil adjusting screw | 1 | 1 | 1 | 1 | SM11/64 (40) × 28.5 |
| B61 | HA100E2060 | Spring for oil adjuster | 1 | 1 | 1 | 1 | |
| B62 | HA311E0671 | Hook shaft bushing (right) | 1 | 1 | 1 | 1 | |
| B63 | HA110E0672 | Oil pipe for hook shaft bushing | 1 | 1 | 1 | 1 | |
| B64 | HA300E2100 | Plunger | 1 | 1 | 1 | 1 | |
| B65 | HA300E2110 | Plunger spring | 1 | 1 | 1 | 1 | |
| B66 | HA600E2020 | Guide plate | 1 | 1 | 1 | 1 | |
| B67 | HA104F0654 | Screw | 1 | 1 | 1 | 1 | SM15/64 (28) × 10 |
| B68 | HA604E0651 | Hook shaft | 1 | 1 | 1 | 1 | |
| B69 | HA710E0691 | cam | | | | 1 | |
| B70 | HA710E0692 | Screw | | | | 2 | |
| B71 | HA704B0653 | Hook shaft bushing | 1 | 1 | 1 | 1 | |
| B72 | H2100E2010 | Rotating hook positioner | 1 | | 1 | 1 | |
| B72 | HA300E2050 | Rotating hook positioner | | 1 | | | |
| B73 | HA100E2150 | Screw | 1 | 1 | 1 | 1 | SM11/64 (40) × 13 |
| B74 | HA608E0067 | Bobbin case | 1 | | 1 | | |
| B74 | HA300E2070 | Bobbin case | | 1 | | | |
| B74 | HA900E2030 | Bobbin case | | | | 1 | |

B.NEEDLE BAR AND TAKE-UP LEVER, ARM SHAFT MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|------------------------|-----------|-----------|-----------|------------|---------|
| B75 | H1100E2010 | Bobbin | 1 | | 1 | | |
| B75 | HA100E2170 | Bobbin | | 1 | | | |
| B75 | HA900E2030 | Bobbin | | | | 1 | |
| B76 | H1105E0066 | Rotating hook complete | 1 | | | | |
| B76 | HA500E2030 | Rotating hook complete | | 1 | | | |
| B76 | H6519B8001 | Rotating hook complete | | | 1 | | |
| B76 | HA906E0066 | Rotating hook complete | | | | 1 | |

C. STITCH REGULATOR MECHANISM



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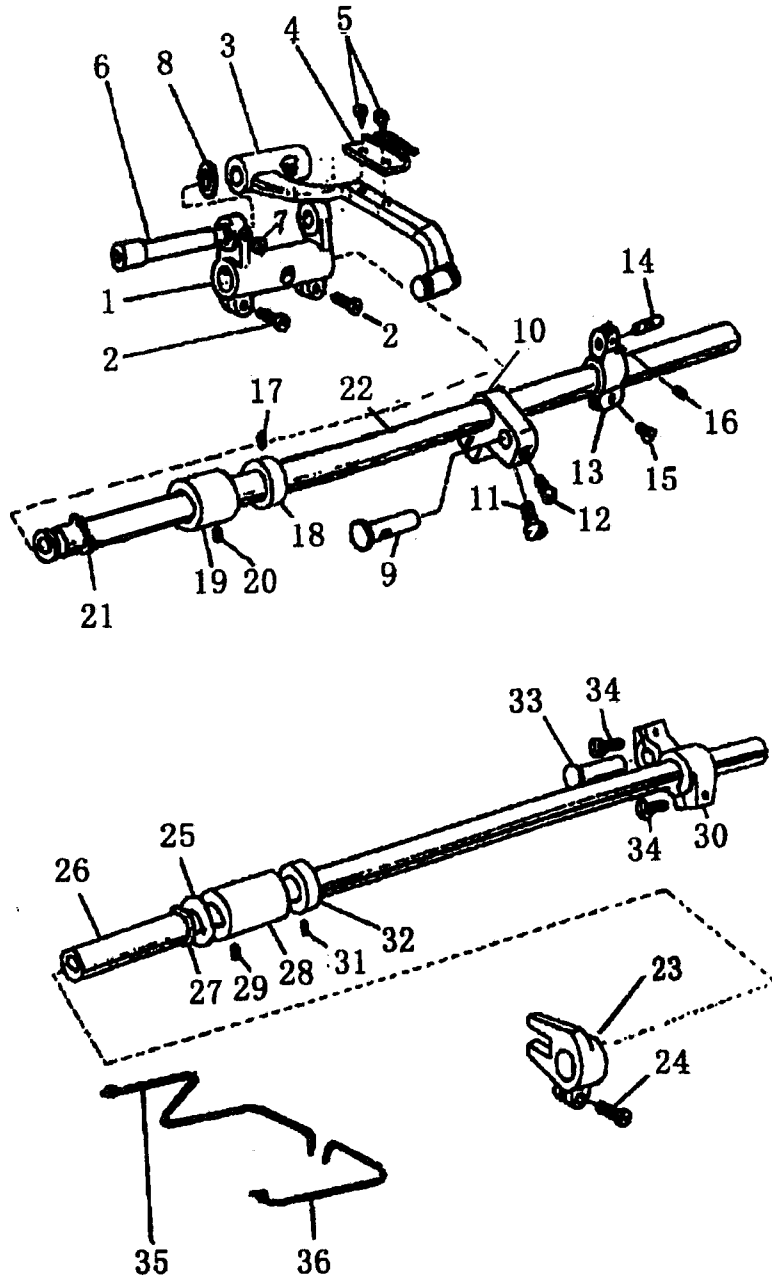
C.STITCH REGULATOR MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|-------------------------------|-----------|-----------|-----------|------------|---------|
| C01 | HA700C2060 | Pin | | | | 1 | |
| C02 | HA7311C406 | Connecting rod stud | | | | 1 | |
| C03 | HA111G0683 | Screw | 1 | 1 | 1 | 1 | |
| C04 | HB5251F081 | Feed regulator | | | | 1 | |
| C05 | HA113F0684 | Screw | | | | 1 | |
| C06 | HA100C2190 | Screw | | | | 2 | |
| C07 | HA704B0655 | Bushing for feed regulator | 1 | 1 | 1 | 1 | |
| C08 | HA100C2020 | Screw | 1 | 1 | 1 | 1 | |
| C09 | HA100F2040 | Pin | 1 | 1 | 1 | 1 | |
| C10 | HA700B2120 | Rnbbber plug | 1 | 1 | 1 | 1 | |
| C11 | H2600E2050 | Spring | | | | 1 | |
| C12 | HA800F2010 | Bracket spring | | | | 1 | |
| C13 | H2605E0661 | Reverse feed crank | | | | 1 | |
| C14 | H2207D0671 | Slide block pin | | | | 1 | |
| C15 | HA104F0654 | Screw | 2 | 2 | 2 | 2 | |
| C16 | HA100F2130 | Screw | 1 | 1 | 1 | 1 | |
| C17 | HA113F3021 | Reverse feed lever shaft | 1 | 1 | 1 | 1 | |
| C18 | HA113F3022 | O-ring | 1 | 1 | 1 | 1 | |
| C19 | HA100F2110 | Washer | 1 | 1 | 1 | 1 | |
| C20 | HA309F0671 | Reverse feed lever | 1 | 1 | 1 | 1 | |
| C21 | HA113F0683 | Screw | 1 | 1 | 1 | 1 | |
| C22 | HA706C1191 | link (short) | 2 | 2 | 2 | 2 | |
| C23 | HA8211C305 | Link (long) | 2 | 2 | 2 | 2 | |
| C24 | HA706C11B1 | Link stud | 1 | 1 | 1 | 1 | |
| C25 | HA7311C806 | Screw | 1 | 1 | 1 | 1 | |
| C26 | HA7311CF06 | Link stud | 1 | 1 | 1 | 1 | |
| C27 | HA700C2050 | Feed regulator shaft (left) | 1 | 1 | 1 | 1 | |
| C28 | HA111G0683 | Screw | 2 | 2 | 2 | 2 | |
| C29 | HA7311CC06 | Screw | 1 | 1 | 1 | 1 | |
| C30 | HA7311CD06 | Screw | 1 | 1 | 1 | 1 | |
| C31 | HA7311CG06 | Stitch length adjusting crank | 1 | 1 | 1 | 1 | |
| C32 | HA7311CE06 | Link stud | 1 | 1 | 1 | 1 | |
| C33 | HA700C2040 | Feed regulator shaft (right) | 1 | 1 | 1 | 1 | |
| C34 | HM308F8001 | Plate for stitch length | 1 | | 1 | | |
| C34 | HB5253F081 | Plate for stitch length | | | | 1 | |
| C35 | HA720F0686 | Screw | 1 | | 1 | 1 | |
| C36 | HA7421F120 | Dial | 1 | | 1 | 1 | |
| C37 | HA100F2080 | Stopper pin | 1 | 1 | 1 | 1 | |
| C38 | HA100F2090 | Spring for stopper pin | 1 | 1 | 1 | 1 | |
| C39 | HA720F0681 | Screw bar | 1 | | 1 | 1 | |
| C40 | HA109F0674 | O-ring | 1 | 1 | 1 | 1 | |
| C41 | HA720F0683 | Stopper pin releasing lever | 1 | | 1 | 1 | |
| C42 | HA720F0685 | Bushing | 1 | | 1 | 1 | |

C.STITCH REGULATOR MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|-------------------------------------|-----------|-----------|-----------|------------|---------|
| C43 | HA720F0687 | Coil spring | 1 | | 1 | 1 | |
| C44 | HB5255F081 | Reverse link | | | | 1 | |
| C45 | H2204D0652 | Pin | | | | 1 | |
| C46 | H007013040 | Stop ring | | | | 1 | |
| C47 | H2204D0653 | Spring retainer | | | | 1 | |
| C48 | HA806C0674 | Spring | | | | 1 | |
| C49 | HA806C0675 | Spring retainer | | | | 1 | |
| C50 | HA800F2020 | Screw | | | | 1 | |
| C51 | 50 | Stop ring | 1 | 1 | 1 | | |
| C52 | HA1511F115 | shaft | 1 | 1 | 1 | | |
| C53 | HA1511F215 | Slide block | 1 | 1 | 1 | | |
| C54 | HA300F2050 | Rubber piug | | 1 | | | |
| C55 | H1204E0652 | Stitch length adjusting swing shaft | 1 | 1 | 1 | | |
| C56 | HA100C2190 | Screw | 1 | 1 | 1 | | |
| C57 | H1404E0651 | Feed regulator | 1 | | 1 | | |
| C57 | H1204E0651 | Feed regulator | | 1 | | | |
| C58 | HA104F0654 | Screw | 1 | 1 | 1 | | |
| C59 | HA115F0692 | Spring | 1 | 1 | 1 | | |
| C60 | HA100F2140 | Spring holder | 1 | 1 | 1 | | |
| C61 | HA109F0673 | Screw | | 1 | | | |
| C62 | HA115F0691 | Crank | 1 | 1 | 1 | | |
| C63 | H1205E0661 | Dial | | 1 | | | |
| C64 | HA109F0671 | Screw bar | | 1 | | | |

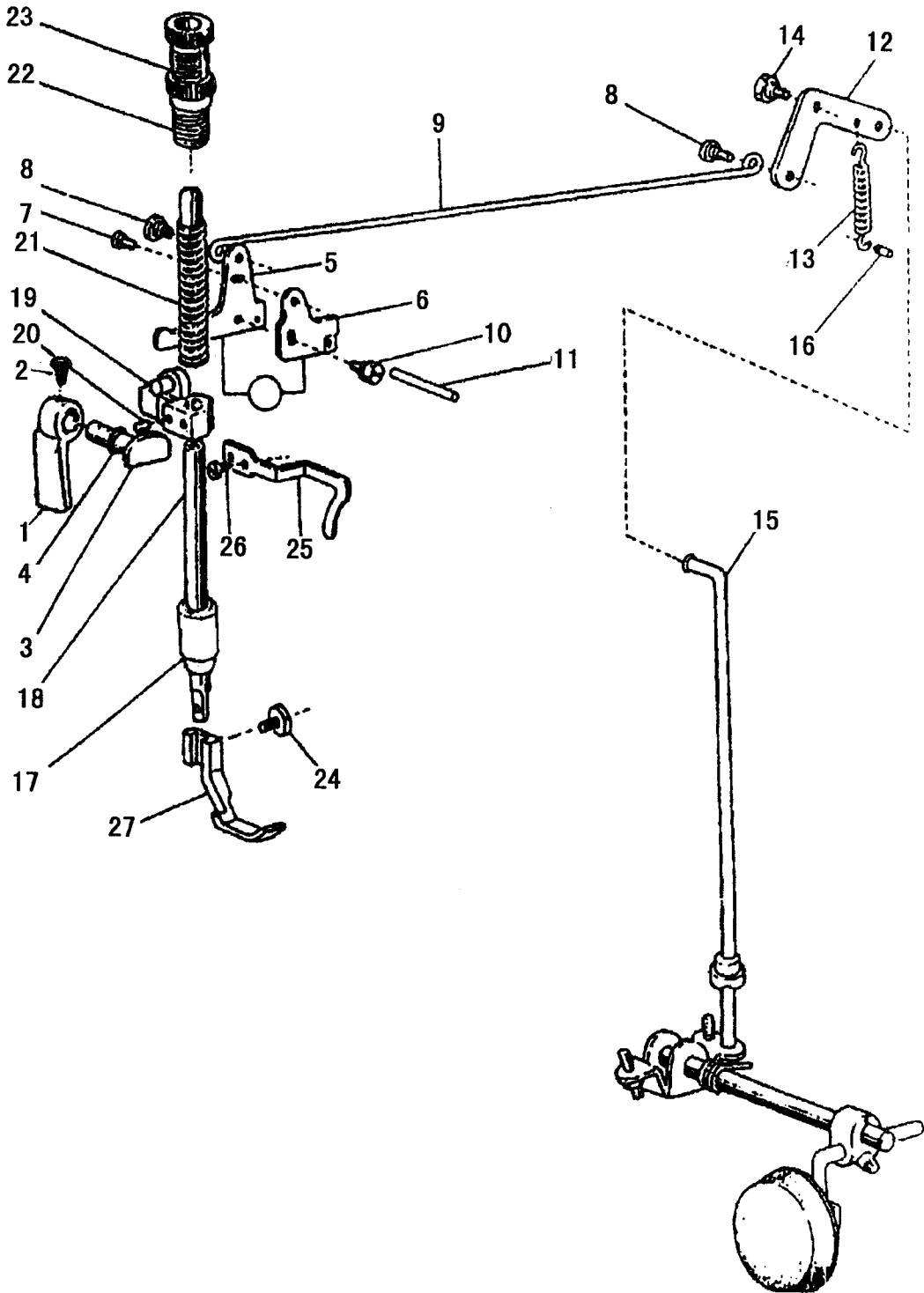
D. FEEDING AND FEED LIFTING MECHANISM



D. FEEDING AND FEED LIFTING MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|---------------------------------------|-----------|-----------|-----------|------------|-------------------|
| D01 | HA104G0011 | Feed rock shaft crank (left) | 1 | 1 | 1 | 1 | |
| D02 | HA304G0656 | Screw | 2 | 2 | 2 | 2 | SM3/16 (28) × 15 |
| D03 | H6507G7101 | Feed bar assay | 1 | 1 | 1 | 1 | |
| D04 | HA104G0653 | Feed dog | 1 | | | 1 | |
| D04 | H2900G2010 | Feed dog | | 1 | | | |
| D04 | H6521B8001 | Feed dog | | | 1 | | |
| D05 | HA104G0654 | Screw | 2 | 2 | 2 | 2 | SM1/8 (44) × 6 |
| D06 | HA705J0654 | Hinge pin for feed regulator | 1 | 1 | 1 | 1 | |
| D07 | HA300C2030 | Screw | 1 | 1 | 1 | 1 | SM11/64 (40) × 8 |
| D08 | HA104G0656 | Washer | 1 | 1 | 1 | 1 | |
| D09 | H6505G8001 | Hinge pin | 1 | 1 | 1 | 1 | |
| D10 | H6504G8001 | Feed rock shaft crank (right) | 1 | 1 | 1 | 1 | |
| D11 | HA104G0012 | Screw | 2 | 2 | 2 | 2 | SM3/16 (28) × 12 |
| D12 | H6505G8001 | Screw. | 1 | 1 | 1 | 1 | |
| D13 | HA8211C205 | Feed rock shaft crank (right) | 1 | 1 | 1 | 1 | |
| D14 | HA8311CB03 | Link stud | | | | | |
| D15 | HA8211C205 | Screw | 1 | 1 | 1 | 1 | |
| D16 | HA8311C803 | Screw | | | | | |
| D17 | HA105D0662 | Set screw | 2 | 2 | 2 | 2 | SM1/4 (40) × 4 |
| D18 | HA108G0661 | Collar | 1 | 1 | 1 | 1 | |
| D19 | H2100G2020 | Bushing for feed rock shaft | 1 | 1 | 1 | 1 | |
| D20 | HA305E0662 | Set screw | 1 | 1 | 1 | 1 | SM15/64 (28) × 4 |
| D21 | H007009150 | C-type stop ring | 1 | 1 | 1 | 1 | |
| D22 | H2100G2010 | Feed rock shaft | 1 | 1 | 1 | 1 | |
| D23 | HA304G0655 | Oil braid | 1 | 1 | 1 | 1 | |
| D24 | HA305G0664 | Oil braid | 1 | 1 | 1 | 1 | |
| D25 | HA100G2130 | Washer | 1 | 1 | 1 | 1 | |
| D26 | HA108G0661 | Collar for feed lifting rock shaft | 1 | 1 | 1 | 1 | |
| D27 | HA704K0652 | Feed lifting rock shaft | 1 | 1 | 1 | 1 | |
| D28 | HA100G2120 | Bushing for feed lifting rock shaft | 1 | 1 | 1 | 1 | |
| D29 | HA100C2020 | Set screw | 1 | 1 | 1 | 1 | SM15/64 (28) × 10 |
| D30 | H007009150 | C-type stop ring | 1 | 1 | 1 | 1 | |
| D31 | HA105D0662 | Screw | 2 | 2 | 2 | 2 | SM1/4 (40) × 4 |
| D32 | HA111G0683 | Screw | 1 | 1 | 1 | 1 | SM11/64 (40) × 12 |
| D33 | HA306G0671 | Feed lifting rock shaft crank (right) | 1 | 1 | 1 | 1 | |
| D34 | HA100G2070 | Hinge pin | 1 | 1 | 1 | 1 | |
| D35 | HA104G0012 | Screw | 2 | 2 | 2 | 2 | SM3/16 (28) × 12 |
| D36 | H1204D0651 | Feed lifting rock shaft crank (left) | 1 | 1 | 1 | 1 | |

E. PRESSER FOOT MECHANISM

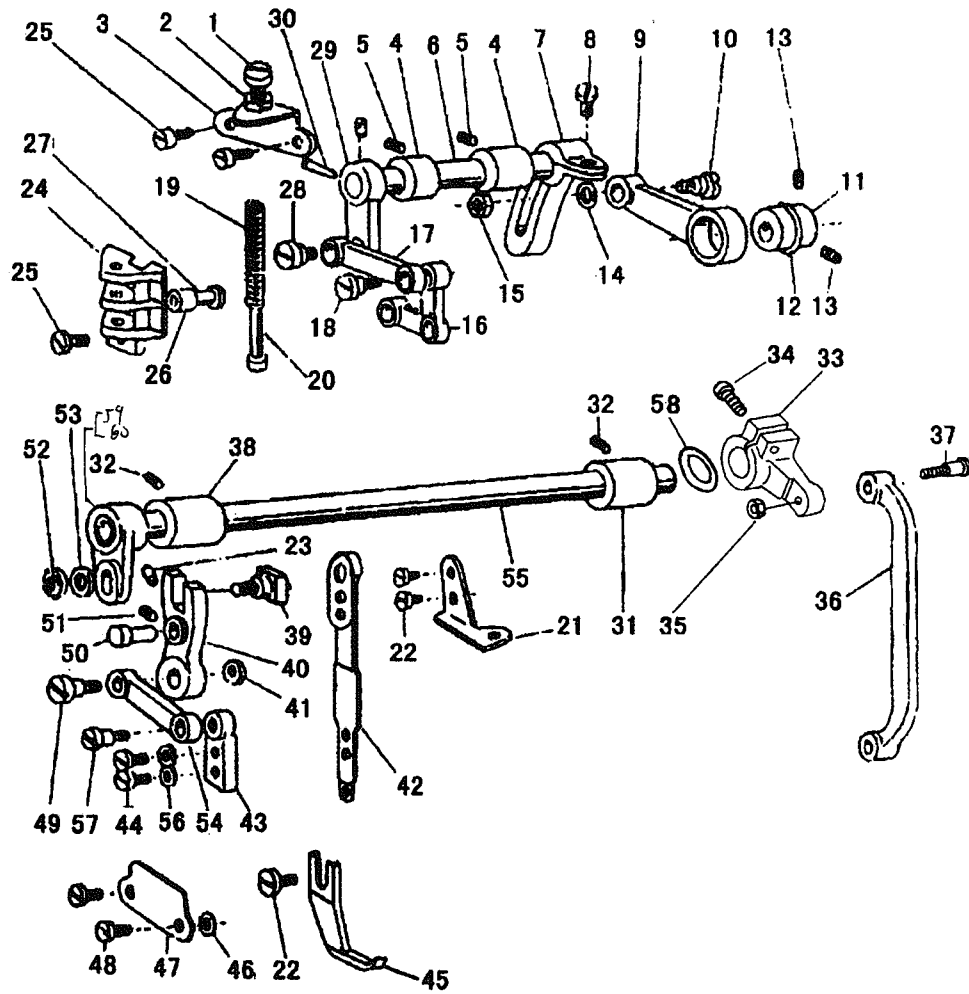


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E.PRESSER FOOT MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|--------------------------------------|-----------|-----------|-----------|------------|----------------|
| E01 | H2104H0651 | Presser bar lifter | 1 | 1 | 1 | 1 | |
| E02 | HA100B2110 | Set screw | 1 | 1 | 1 | 1 | SM11/64(40)×5 |
| E03 | H2104H0661 | Presser bar lifting cam | 1 | | 1 | 1 | |
| E04 | HA300H2080 | Oil seal fot presser bar litting cam | 1 | 1 | 1 | 1 | 8×1.9 |
| E05 | HA107H1011 | Knee lifter lever (left) | 1 | 1 | 1 | 1 | |
| E06 | HA305H6611 | Tension releasing cam | 1 | 1 | 1 | 1 | |
| E07 | HA107H1013 | Screw | 1 | 1 | 1 | 1 | SM11/64(40)×6 |
| E08 | HA107H0662 | Hinged screw | 2 | 2 | 2 | 2 | SM3/16(28)×3.5 |
| E09 | HA107H0663 | Knee lifter rod | 1 | 1 | 1 | 1 | |
| E10 | HA100H2050 | Bolt | 1 | 1 | 1 | 1 | SM15/64(28)×13 |
| E11 | HA100H2060 | Tension releasing pin | 1 | 1 | 1 | 1 | |
| E12 | HA110H0671 | Knee lifter lever (right) | 1 | 1 | 1 | 1 | |
| E13 | H3211E0692 | Spring | 1 | 1 | 1 | 1 | |
| E14 | HA100H2050 | Bolt for knee lifter lever | 1 | 1 | 1 | 1 | SM15/64(28)×10 |
| E15 | HA306H0671 | Knee lifter connecting rod | 1 | 1 | 1 | 1 | |
| E16 | HA720B0651 | Pin for spring | 1 | 1 | 1 | 1 | |
| E17 | HA300H2090 | Presser bar bushing | 1 | 1 | 1 | 1 | |
| E18 | H2000I2010 | Presser bar | 1 | 1 | 1 | 1 | |
| E19 | HM305H8001 | Presser bar lifting bracket | 1 | 1 | 1 | 1 | |
| E20 | HA3411D308 | Set screw | 1 | 1 | 1 | 1 | SM15/64(28)×7 |
| E21 | H1100H2020 | Presser spring | 1 | 1 | 1 | 1 | |
| E22 | H2005I0065 | Pressure regulating thumb screw | 1 | 1 | 1 | 1 | SM1/2(28)×43 |
| E23 | HA117H0692 | Lock nut | 1 | 1 | 1 | 1 | |
| E24 | HA100H2150 | Set screw | 1 | 1 | 1 | 1 | SM9/64(40)×11 |
| E25 | HA300H2120 | Upper thread guide | 1 | 1 | 1 | 1 | |
| E26 | HA100C2040 | Screw | 1 | 1 | 1 | 1 | SM11/64(40)×5 |
| E27 | H2000I2040 | Presser loot complete | 1 | | | 1 | |
| E27 | H2900H2020 | Presser loot complete | | 1 | | | |
| E27 | H6522B8001 | Presser loot complete | | | 1 | | |

F. PRESSER LIFTING, FEEDING MECHANISM



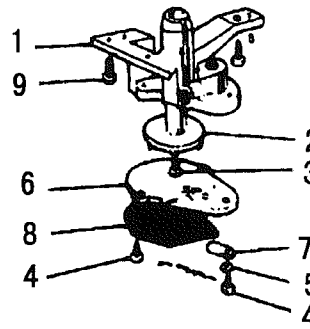
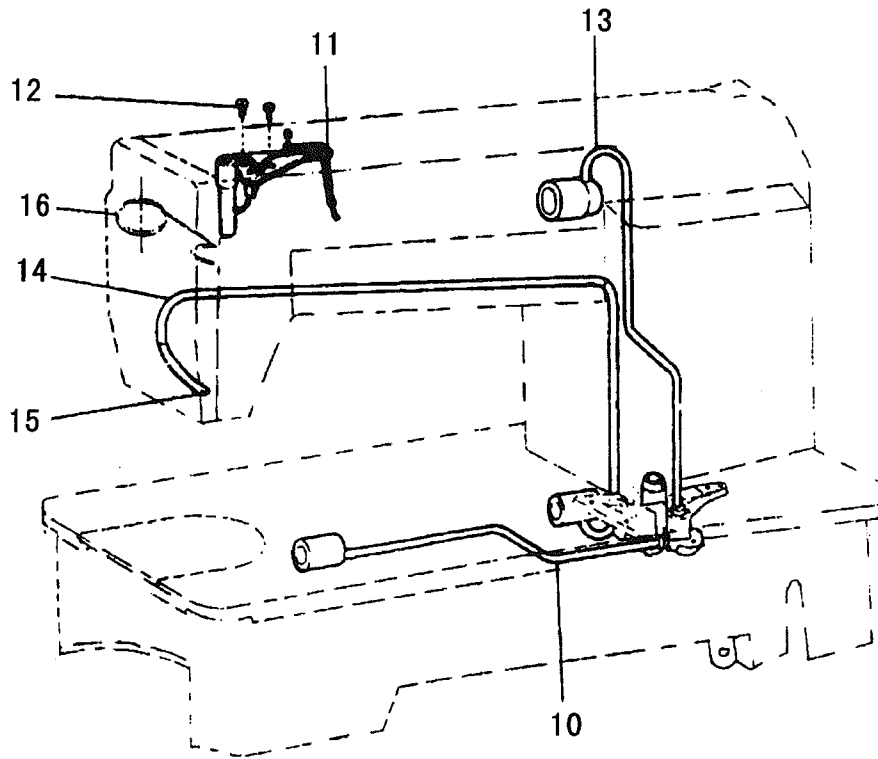
F. PRESSER LIFTING、 FEEDING MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|-------------|--|-----------|-----------|-----------|------------|--------------------|
| F01 | H2010J0065 | Lifting presser adjusting screw | 1 | 1 | 1 | 1 | SM9/32 (28) × 35 |
| F02 | H2010J0066 | Lifting presser adjusting nut | 1 | 1 | 1 | 1 | |
| F03 | H2000J2060 | Lifting presser bracket for spring | 1 | 1 | 1 | 1 | |
| F04 | H2009B0068 | Presser lifting shaft bushing | 2 | 2 | 2 | 2 | |
| F05 | HA100B2110 | Screw | 2 | 2 | 2 | 2 | |
| F06 | H2011J0066 | Shaft | 2 | 2 | 2 | 2 | |
| F07 | H2100I2010 | Presser lifting shaft | 1 | 1 | 1 | 1 | |
| F08 | H2012N0652 | Set screw | 1 | 1 | 1 | 1 | |
| F09 | H2104I0065 | Eccentric wheel rod | 1 | 1 | 1 | 1 | |
| F10 | H2000J2100 | Set screw | 1 | 1 | 1 | 1 | |
| F11 | H2014J0652 | Eccentric wheel | 1 | 1 | 1 | 1 | GB/T894.1 25 |
| F12 | H007009250 | C-type stop ring | 1 | 1 | 1 | 1 | |
| F13 | HA307C0662 | Screw | 2 | 2 | 2 | 2 | |
| F14 | H2013J0065 | Washer | 1 | 1 | 1 | 1 | |
| F15 | H0030020608 | Nut | 1 | 1 | 1 | 1 | |
| F16 | H2100I2020 | Presser feed crank | 1 | 1 | 1 | 1 | |
| F17 | H2004J0652 | Presser feed crank link | 1 | 1 | 1 | 1 | |
| F18 | H2004J0653 | Screw | 1 | 1 | 1 | 1 | |
| F19 | H2100I2190 | Lifting presser spring | 1 | 1 | 1 | 1 | |
| F20 | H2007J0066 | Presser spring guide | 1 | 1 | 1 | 1 | |
| F21 | H2004J0658 | Lifting presser guide plate | 1 | 1 | 1 | 1 | SM3/16 (28) × 12.6 |
| F22 | HA100H2150 | Screw | 1 | 1 | 1 | 1 | |
| F23 | H609025180 | Pin | 1 | 1 | 1 | 1 | |
| F24 | H2000J2020 | Lifting presser plate | 2 | 2 | 2 | 2 | |
| F25 | H2000I2050 | Screw | 1 | 1 | 1 | 1 | |
| F26 | H2000J2030 | Lifting presser spring guide pin | 1 | 1 | 1 | 1 | |
| F27 | H2004J0655 | Feed crank guide shaft | 1 | 1 | 1 | 1 | |
| F28 | H2004J0662 | Screw | 1 | 1 | 1 | 1 | |
| F29 | H2011J0065 | Presser lifting crank | 1 | 1 | 1 | 1 | |
| F30 | H602040200 | Pin | 1 | 1 | 1 | 1 | |
| F31 | H3209B0065 | Presser swing shaft bushing (right) | 1 | 1 | 1 | 1 | GB/T117 4×20 |
| F32 | HA100B2110 | Screw | 2 | 2 | 2 | 2 | |
| F33 | H6013F8001 | Presser swing crank(right) | 1 | 1 | 1 | 1 | |
| F34 | H6017F8001 | Screw | 1 | 1 | 1 | 1 | |
| F35 | H2010J0066 | Lifting presser adjusting nut | 1 | 1 | 1 | 1 | |
| F36 | H6505I8001 | Presser swing crank (right) rod | 1 | 1 | 1 | 1 | |
| F37 | H2012N0066 | Screw | 1 | 1 | 1 | 1 | |
| F38 | H2100I2060 | Presser swing shaft bushing (left) | 1 | 1 | 1 | 1 | |
| F39 | H2121I0065 | Lifting presser sway crank shaft compl | 1 | 1 | 1 | 1 | |
| F40 | H2013N0069 | Lifting presser sway crank | 1 | 1 | 1 | 1 | |
| F41 | H2008N0066 | Lock nut | 1 | 1 | 1 | 1 | SM1/4 (40) |
| F42 | H2004J0654 | Presser rod | 1 | 1 | 1 | 1 | |
| F43 | H2004J0661 | Presser rod guide | 1 | 1 | 1 | 1 | |

F. PRESSER LIFTING, FEEDING MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|--------------------------------------|-----------|-----------|-----------|------------|--------------------|
| F44 | H2004J0067 | Screw | 2 | 2 | 2 | 2 | SM9/64(40) × 9 |
| F45 | H2100I2040 | Out presser | 1 | | | 1 | |
| F45 | H2900I2020 | Out presser | | 1 | | | |
| F45 | H6525B8001 | Out presser | | | 1 | | |
| F46 | H2000N0040 | Space for presser rod plate | 2 | 2 | 2 | 2 | |
| F47 | H2000N0030 | Lifting presser rod plate | 1 | 1 | 1 | 1 | |
| F48 | HA111G0683 | Screw | 2 | 2 | 2 | 2 | SM11/64(40) × 14.5 |
| F49 | H2008N0065 | Screw | 1 | 1 | 1 | 1 | SM1/4(40) × 26 |
| F50 | H2013N0066 | Lifting presser sway crank guide pin | 1 | 1 | 1 | 1 | SM1/4(40) |
| F51 | H2100I2070 | Screw | 1 | 1 | 1 | 1 | SM3/16(32) × 7 |
| F52 | H2013N0067 | Presser crank connecting nut | 1 | 1 | 1 | 1 | SM1/4(24) |
| F53 | H2013J0065 | Washer | 1 | 1 | 1 | 1 | |
| F54 | H2013N0070 | Presser swing crank(left) | 1 | 1 | 1 | 1 | |
| F55 | HM304I8001 | Presser swing shaft | 1 | 1 | 1 | 1 | |
| F56 | HA100I2050 | Washer | 1 | 1 | 1 | 1 | |
| F57 | H2004J0662 | Screw | 1 | 1 | 1 | 1 | SM1/4(40) × 15 |
| F58 | H6018F8001 | O-ring | 1 | 1 | 1 | 1 | |
| F59 | H6005F500 | Upper feed rock shaft crank(left) | 1 | 1 | 1 | 1 | |
| F60 | H6017F500 | Screw | 1 | 1 | 1 | 1 | SM15/64(28) × 18 |

G. OIL LUBRICATION MECHANISM

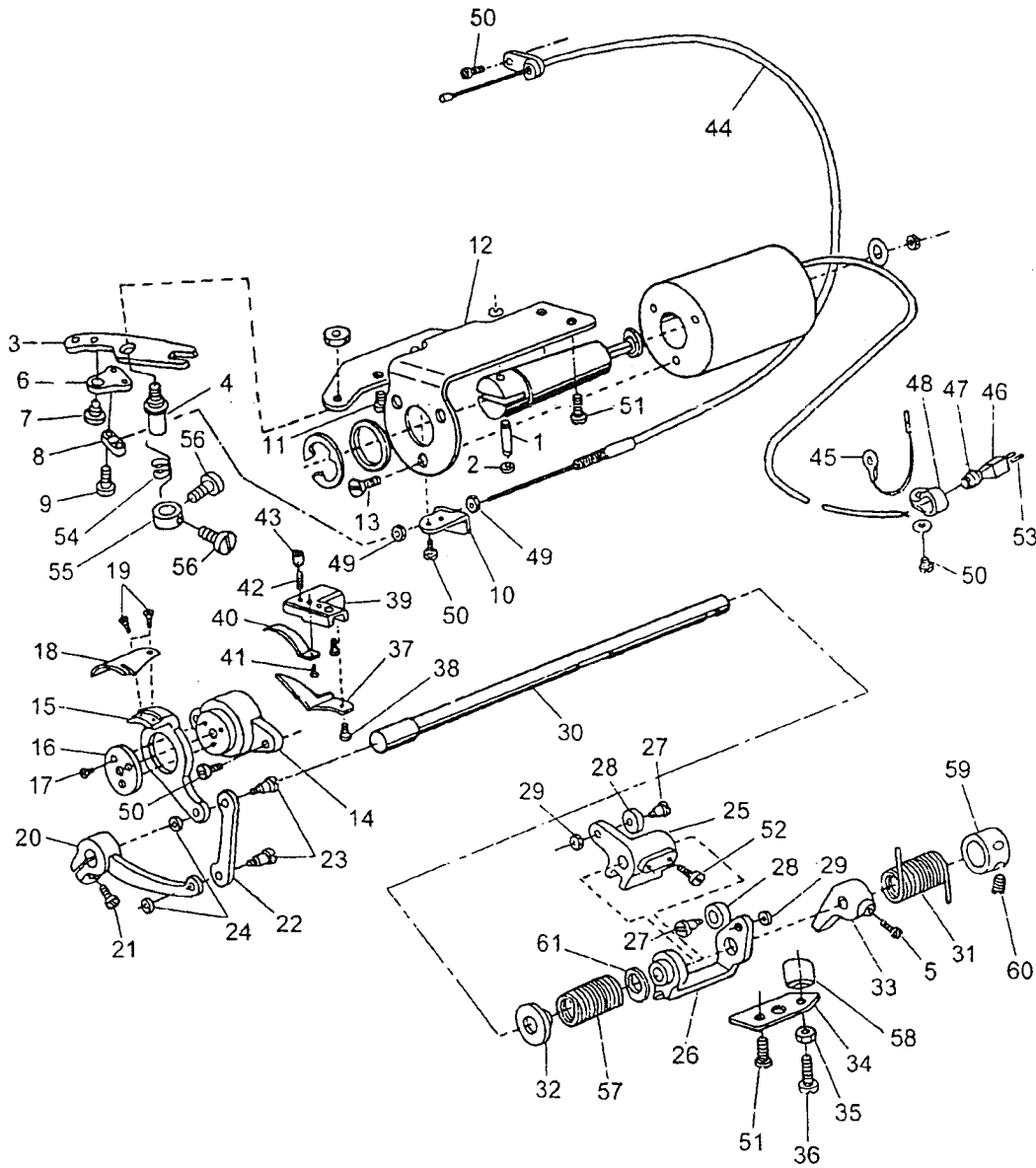


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G.OIL LUBRICATION MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|--------------------------|-----------|-----------|-----------|------------|------------------|
| G01 | HA100I2010 | Oil pump body | 1 | 1 | 1 | 1 | |
| G02 | H6010I8001 | Oil pump impeller | 1 | 1 | 1 | 1 | |
| G03 | HA100I2090 | Screw | 1 | 1 | 1 | 1 | SM11/64(40) × 13 |
| G04 | HA300I2050 | Screw | 3 | 3 | 3 | 3 | |
| G05 | HA100I2050 | Spring washer | 1 | 1 | 1 | 1 | |
| G06 | H6012I8001 | Oil pump fitting plate | 1 | 1 | 1 | 1 | |
| G07 | HA100I2070 | Oil adjusting plate | 1 | 1 | 1 | 1 | |
| G08 | HA111I0065 | Oil pump screen complete | 1 | 1 | 1 | 1 | |
| G09 | HA100I2090 | Screw | 3 | 3 | 3 | 3 | SM11/64(40) × 13 |
| G10 | HA113I0066 | Oil pipe for hook shaft | 1 | 1 | 1 | 1 | |
| G11 | HA304I0065 | Oil braid fitting plate | 1 | 1 | 1 | 1 | |
| G12 | HA100I2020 | Screw | 2 | 2 | 2 | 2 | SM9/64(40) × 11 |
| G13 | H5604G0065 | Oil pipe for arm shaft | 1 | 1 | 1 | 1 | |
| G14 | HA305I0661 | Oil return pipe | 1 | 1 | 1 | 1 | |
| G15 | HA100I2150 | Felt pouch | 1 | 1 | 1 | 1 | |
| G16 | HA300I2060 | pipe holder | 1 | 1 | 1 | 1 | |

H. THREAD TRIMMER MECHANISM



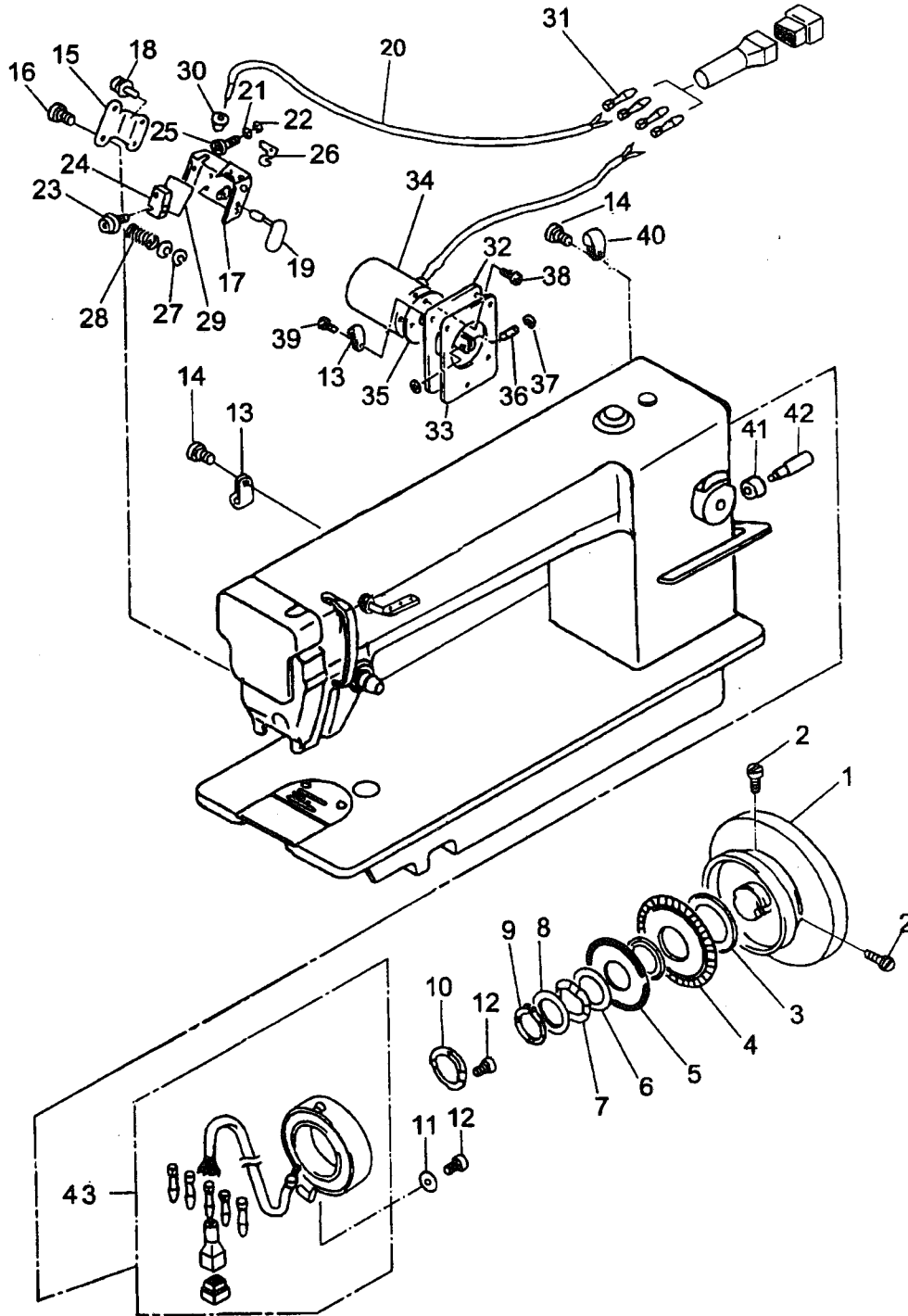
H. THREAD TRIMMER MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|-------------------------------------|-----------|-----------|-----------|------------|---------|
| H01 | HA712N0692 | Link stud | | | | 1 | |
| H02 | H007013040 | E-type ring 4 | | | | 2 | |
| H03 | HA712N0698 | Thread trimmer driving lever | | | | 1 | |
| H04 | HA712N0695 | Stud screw | | | | 1 | |
| H05 | HA113F0684 | Set screw | | | | 1 | |
| H06 | HA712N6910 | Flexible wire bracket | | | | 1 | |
| H07 | HA712N0699 | Set screw | | | | 1 | |
| H08 | HA712N6911 | Link bracket | | | | 1 | |
| H09 | HA712N6912 | Set screw | | | | 2 | |
| H10 | HA712N6913 | Holder | | | | 1 | |
| H11 | HA100E2150 | Set screw | | | | 1 | |
| H12 | HA7511N212 | Solenoid bracket | | | | 1 | |
| H13 | | P-type screw | | | | 3 | |
| H14 | HA704N1111 | Knife holding bracket saddle | | | | 1 | |
| H15 | HA904N1111 | Knife holding bracket saddle (left) | | | | 1 | |
| H16 | HA704N1113 | Washer | | | | 1 | |
| H17 | HA704N1114 | Set screw | | | | 3 | |
| H18 | H2806H8001 | Movable knife (left) | | | | 1 | |
| H19 | HA7111N704 | Set screw | | | | 2 | |
| H20 | HA7111N604 | Knife driving crank | | | | 1 | |
| H21 | HA719B7011 | Set screw | | | | 1 | |
| H22 | HA7111N404 | Link | | | | 1 | |
| H23 | HA7111N204 | Set screw | | | | 2 | |
| H24 | HA7111N304 | Nut | | | | 2 | |
| H25 | HA7211N106 | Cam follower crank 1 | | | | 1 | |
| H26 | HA7211N206 | Cam follower crank 2 | | | | 1 | |
| H27 | HA7221N206 | Roller stud | | | | 2 | |
| H28 | HA7221N106 | Roller | | | | 2 | |
| H29 | HA706N0663 | Nut | | | | 2 | |
| H30 | HA900N0020 | Knife driving shaft | | | | 1 | |
| H31 | HA700N0110 | Coil spring | | | | 1 | |
| H32 | HA700N0050 | Brshing | | | | 1 | |
| H33 | HA906N0661 | Stopper lever | | | | 1 | |
| H34 | HA710N0682 | Lever stopper plate | | | | 1 | |
| H35 | HA710N0683 | Nut | | | | 1 | |
| H36 | HA7411N110 | Set screw | | | | 1 | |
| H37 | H22121H204 | Thread finger | | | | 1 | |
| H38 | HA7311CH06 | Set screw | | | | 3 | |
| H39 | HA7121N104 | Bracket for fixed blade | | | | 1 | |
| H40 | H22121H104 | Fixed blade | | | | 1 | |
| H41 | HA7121N304 | Set screw | | | | 1 | |
| H42 | HA7121N604 | screw | | | | 1 | |
| H43 | HA7121N704 | Nut | | | | 1 | |

H.THREAD TRIMMER MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|---|-----------|-----------|-----------|------------|---------|
| H44 | HA713N0702 | Flexible wire | | | | 1 | |
| H45 | HA705Q0065 | Grounded wire | | | | 1 | |
| H46 | HA700Q0010 | Connector plug | | | | 1 | |
| H47 | HA70400657 | Gasket | | | | 1 | |
| H48 | HA708P0668 | Cord holder HP-3N | | | | 1 | |
| H49 | H003002050 | Nut M5 | | | | 2 | |
| H50 | HA300B2170 | Set screw | | | | 5 | |
| H51 | HA700N0080 | Set screw | | | | 4 | |
| H52 | HA113F0684 | Set screw | | | | 2 | |
| H53 | HA7641B319 | Adaptor | | | | 1 | |
| H54 | HA712N0697 | Spring for thread trimmer driving lever | | | | 1 | |
| H55 | HA712N0696 | Collar for thread trimmer driving lever | | | | 1 | |
| H56 | HA7311CC06 | Set screw | | | | 2 | |
| H57 | HA700N0040 | Coil spring | | | | 1 | |
| H58 | HA7411N210 | Dead block | | | | 1 | |
| H59 | HA715N0711 | Collar with screw | | | | 1 | |
| H60 | HA105D0662 | Set screw | | | | 1 | |
| H61 | HA706N0664 | Washer | | | | 1 | |

I. TOUCH BACK MECHANISM & DETECTOR MECHANISM

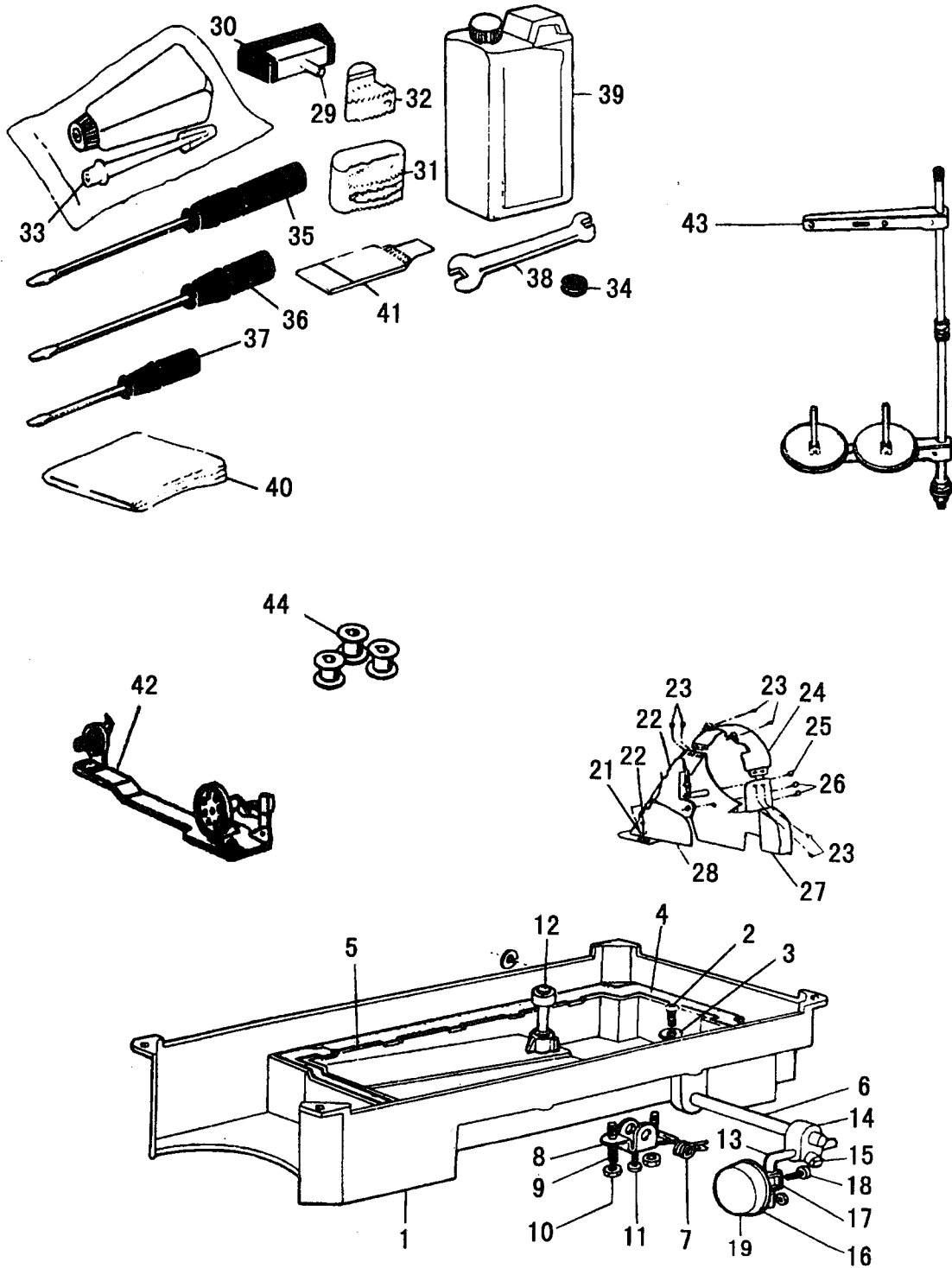


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I.TOUCH BACK MECHANISM & DETECTOR MECHANISM

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|--|-----------|-----------|-----------|------------|---------|
| I01 | H2204I0651 | Pulley | | | | 1 | |
| I02 | HA110D0672 | Screw | | | | 2 | |
| I03 | HA700R0030 | Spacer 1 | | | | 2 | |
| I04 | HA700R0010 | Speed command disc 1 | | | | 1 | |
| I05 | HA700R0020 | Speed command disc 2 | | | | 1 | |
| I06 | HA700R0040 | Spacer 2 | | | | 1 | |
| I07 | HA700R0050 | Supporter spring | | | | 1 | |
| I08 | HA700R0060 | Washer | | | | 1 | |
| I09 | H007009300 | C-type ring | | | | 1 | |
| I10 | HA703R0066 | Detector bracket assay | | | | 1 | |
| I11 | HA703R0067 | Washer | | | | 1 | |
| I12 | HA300C2030 | Screw | | | | 3 | |
| I13 | HA708P0668 | Cord holder | | | | 2 | |
| I14 | HA300B2170 | Screw | | | | 2 | |
| I15 | HN605K8001 | Bracket | | | | 1 | |
| I16 | HA300B2160 | Screw | | | | 2 | |
| I17 | H2205I0661 | Bracket for touch switch | | | | 1 | |
| I18 | HA7221P508 | Screw | | | | 2 | |
| I19 | HA70400021 | Push button | | | | 1 | |
| I20 | HA71610104 | Vinyl cap-trire cable for touch switch | | | | 1 | |
| I21 | HA70406512 | Washer | | | | 2 | |
| I22 | HA70406511 | Washer | | | | 2 | |
| I23 | HA70406510 | Screw | | | | 2 | |
| I24 | HA70400655 | Micro switch | | | | 1 | |
| I25 | HA70400659 | Screw | | | | 2 | |
| I26 | HA70400654 | Spring plate | | | | 1 | |
| I27 | H007013030 | E-type ring | | | | 2 | |
| I28 | HA70400653 | Spring | | | | 1 | |
| I29 | HA70400658 | Insulator set | | | | 1 | |
| I30 | HA70400657 | Rubber plug | | | | 1 | |
| I31 | HA7641B319 | Terminal pin | | | | 2 | |
| I32 | H6010K8001 | Arm bed cover | | | | 1 | |
| I33 | H6011K8001 | Gasket for arm bed cover | | | | 1 | |
| I34 | H2206I0673 | Solenoid assay for touch black | | | | 1 | |
| I35 | H2206I0672 | Washer | | | | 1 | |
| I36 | HA712N0692 | Pin | | | | 1 | |
| I37 | H007013040 | E-type ring | | | | 1 | |
| I38 | HA300C2030 | Screw | | | | 4 | |
| I39 | HA300B2160 | Screw | | | | 5 | |
| I40 | HA700Q0050 | Cord holder | | | | 1 | |
| I41 | H2204G0652 | Rubber plug | | | | 1 | |
| I42 | H2204G0651 | Screw | | | | 1 | |
| I43 | HA700R0000 | Detector bracket assay | | | | 1 | |

J. ACCESSORIES



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J.ACCESSORIES

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|------------------------------------|-----------|-----------|-----------|------------|---------------------|
| J01 | HA304J0651 | Oil seservoir | 1 | 1 | 1 | 1 | |
| J02 | HA104J0652 | Oil drain screw | 1 | 1 | 1 | 1 | SM5/16(28) × 10 |
| J03 | HA104J0653 | Washer | 1 | 1 | 1 | 1 | |
| J04 | HA104J0654 | Gasket for oil reservoir (small) | 1 | 1 | 1 | 1 | |
| J05 | HA104J0655 | Gasket for oil reservoir (big) | 1 | 1 | 1 | 1 | |
| J06 | HA300J2160 | Hinge pin for knee lifter | 1 | 1 | 1 | 1 | |
| J07 | HA104J0657 | Backspring for knee lifter | 1 | 1 | 1 | 1 | |
| J08 | HA104J0658 | Knee lifter stop bracket | 1 | 1 | 1 | 1 | |
| J09 | HA104J0659 | Adjusting screw | 2 | 2 | 2 | 2 | SM15/64(28) × 28 |
| J10 | HA104J6510 | Lock nut | 2 | 2 | 2 | 2 | |
| J11 | HA110D0672 | Screw | 1 | 1 | 1 | 1 | SM15/64(28) × 14. 8 |
| J12 | HA106J0661 | Knee lifter lifting rod | 1 | 1 | 1 | 1 | |
| J13 | HA106J0662 | Knee lifter bell crank | 1 | 1 | 1 | 1 | |
| J14 | HA106J0663 | Joint for knee lifter bell crank | 2 | 2 | 2 | 2 | |
| J15 | HA300J2180 | Set screw | 1 | 1 | 1 | 1 | SM5/16(28) × 16 |
| J16 | HA106J0665 | Knee lifter plate | 1 | 1 | 1 | 1 | |
| J17 | HA106J0666 | Bracket for knee lifter plate | 1 | 1 | 1 | 1 | |
| J18 | HA106J0667 | Set screw | 1 | 1 | 1 | 1 | SM15/64(28) × 8 |
| J19 | HA106J0668 | Pad for knee lifter plate | 4 | 4 | 4 | 4 | |
| J20 | H801045200 | Screw | 4 | 4 | 4 | 4 | GB/T99 4. 5×20 |
| J21 | HA300J2230 | Washer | 1 | 1 | 1 | 1 | |
| J22 | H200800068 | Belt (upper) | 6 | 6 | 6 | 6 | |
| J23 | HA300B2170 | Screw | 1 | 1 | 1 | 1 | SM11/64(40) × 8 |
| J24 | H200800671 | Belt mark complrte | 1 | 1 | 1 | 1 | |
| J25 | HA300J2250 | Screw | 2 | 2 | 2 | 2 | M4 × 12. 5 |
| J26 | HA300J2280 | Screw | 1 | 1 | 1 | 1 | SM15/64(28) × 8 |
| J27 | H200800067 | Belt (lower) | 1 | 1 | 1 | 1 | |
| J28 | HA305J0665 | Belt complete | 1 | 1 | 1 | 1 | |
| J29 | HA110J0701 | Hinge of machine head | 2 | 2 | 2 | 2 | |
| J30 | HA307J0671 | Rubber socket for hinge | 2 | 2 | 2 | 2 | |
| J31 | HA300J2050 | Rubber cushion (big) | 2 | 2 | 2 | 2 | |
| J32 | HA300J2060 | Rubber cushion (small) | 2 | 2 | 2 | 2 | |
| J33 | HA100J2110 | Oiler | 1 | 1 | 1 | 1 | |
| J34 | HA100J2120 | Magnet | 1 | 1 | 1 | 1 | |
| J35 | HA300J2070 | Screw driver (long) | 1 | 1 | 1 | 1 | |
| J36 | HA300J2200 | Screw driver (medium) | 1 | 1 | 1 | 1 | |
| J37 | HA300J2210 | Screw driver (short) | 1 | 1 | 1 | 1 | |
| J38 | HA300J2220 | Double-end wrench | 1 | 1 | 1 | 1 | |
| J39 | HA100J2170 | Oil container | 1 | 1 | 1 | 1 | |
| J40 | HA100J2180 | Vinyl cover | 1 | 1 | 1 | 1 | |
| J41 | H2000G2030 | Needle | 4 | | | 4 | |
| J41 | HA700G2040 | Needle | | 4 | | | |
| J41 | H6524B8001 | Needle | | | 4 | | |

J.ACCESSORIES

| Fig. No. | Part No. | Description | GC0318-2A | GC0318-2H | GC0318-2B | GC0318-2AD | Remarks |
|----------|------------|--------------------|-----------|-----------|-----------|------------|---------|
| J42 | HA905S0066 | Bobbin winder assy | 1 | | 1 | 1 | |
| J42 | HA706S0067 | Bobbin winder assy | | 1 | | | |
| J43 | HA200J2030 | Washer | 1 | 1 | 1 | 1 | |
| J44 | H1100E2010 | Bobbin | 3 | | 3 | 3 | |
| J44 | HA100E2170 | Bobbin | | 3 | | | |

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The description covered in this manual is subject to change for improvement of the commodity without notice

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