

HIGHLEAD

GC2268-2B/2BL

**Two Needle Cylindrical Bed Compound Feed
Lockstitch Sewing Machine**

**Instruction Manual
Parts Catalog**

SHANGHAI HUIGONG NO.3 SEWING MACHINE FACTORY

From the library of: Superior Sewing Machine & Supply LLC

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一、 PRECAUTIONS BEFORE STARTING OPERATION

1. Safety precautions

- 1) When turning the power on, keep your hands and fingers away from the area around/under the needle and the area around the pulley.
- 2) Power must be turned off when the machine is not in use, or when the operator leaves the seat.
- 3) Power must be turned off when tilting the machine head, installing or removing the “V” belt, adjusting the machine, or when replacing.
- 4) Avoid placing fingers, hairs, bars etc., near the pulley, “V” belt, bobbin winder pulley, or motor when the machine is in operation.
- 5) Do not insert fingers into the thread take-up cover, under/around the needle, or pulley when the machine is in operation.

2. Precautions before starting operation

- 1) Do not operate the machine before lubricating it.
- 2) When a new sewing machine is first turned on, verify the rotational direction of the pulley with the power on (the pulley should rotate counterclockwise when viewed from pulley) .
- 3) Verify the voltage and (single or three) phase with those given on the machine nameplate.

3. Precautions for operating conditions

- 1) Avoid using the machine at abnormally high temperatures (35°C or higher) or low temperatures (5°C or lower) .
- 2) Avoid using the machine in dusty conditions.

二、 SPECIFICATIONS

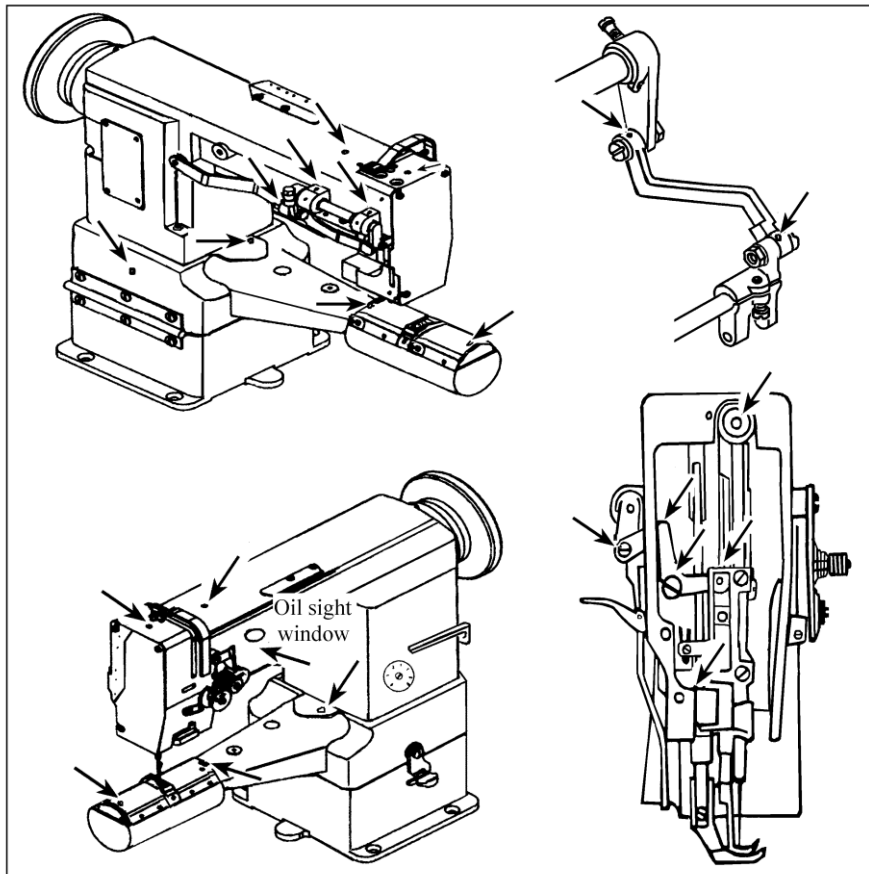
		GC2268-2B	GC2268-2BL
Max. sewing speed		2000 rpm	1600 rpm
Needle		DP×17 23#	
Needle bar stroke		36 mm	
Thread take-up lever stroke		74.5 mm	
Stitch length		6 mm	
Presser foot stroke		By Hand 8 mm / By Knee 13 mm	
Alternating movement		2-5 mm	
Bed size In dia / Length		83 mm / 222 mm	83 mm / 566 mm
Lubrication		Manual	
Needle gauge	Standard	6.4 mm	
	Special	3.2 mm / 9.5 mm	

三、CAUTIONS ON USE

1. Lubrication

- When a new sewing machine is first operated, or when a sewing machine is operated which is out of use for long period of time, it will be necessary to oil through the oil holes after removing the rubber plugs shown below.
- See dripping of oil through the oil sight hole to check oiling condition during operation.

For oil, Use white spindle oil



2. Winding of bobbin thread

Note: When bobbin thread is wound, keep the presser foot lifted.

Adjustment:

- **Tension of wound thread**

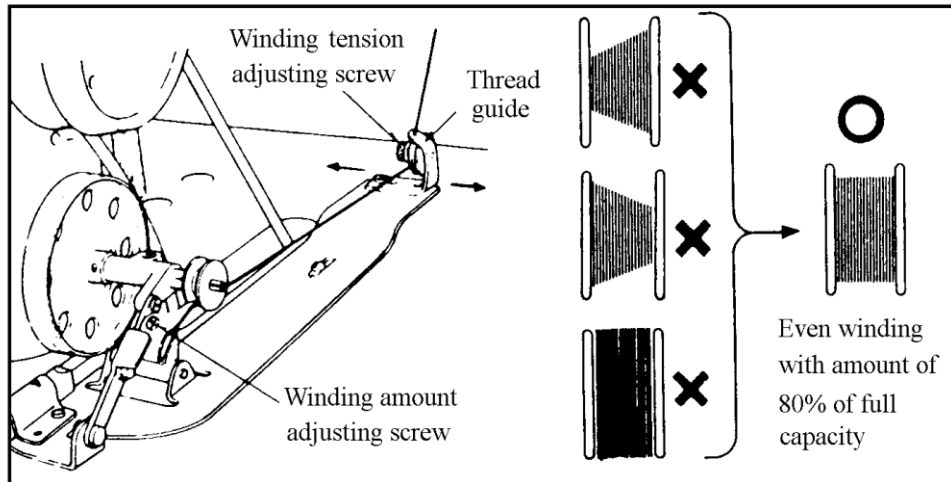
Slack winding is recommended for polyester thread and nylon thread.

- **Conically wound thread**

Move the thread guide toward smaller diameter of wound thread layer.

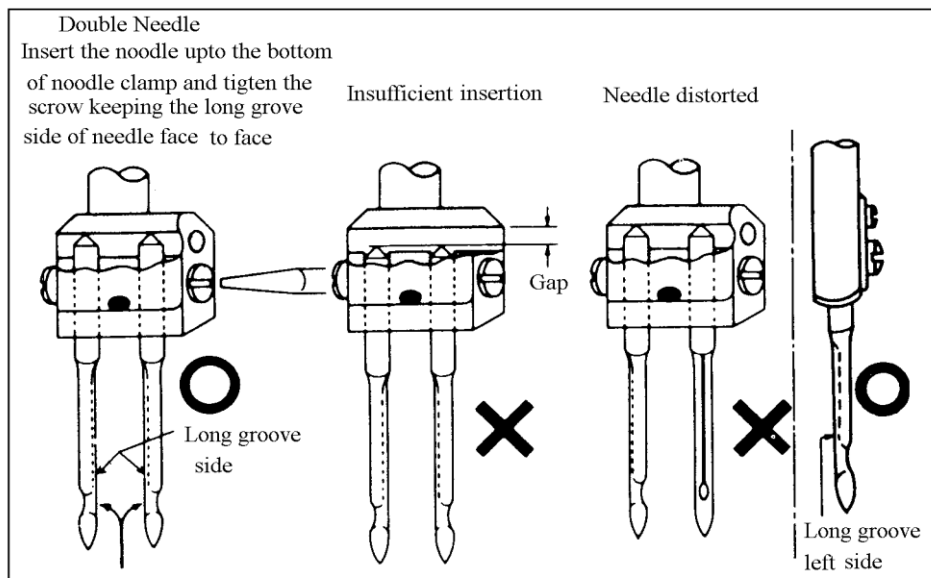
- **Length of wound thread**

Loosen the thread length adjusting screw to increase length of thread and tighten the screw to decrease length of thread.



3. Attaching the needle

Note: Before installing the needles, be sure to turn off the power.

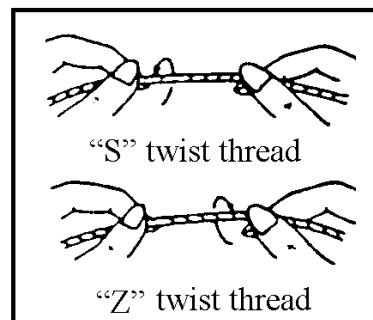


4. Selection of thread

It is recommended to use "S" twist thread in the left needle (viewed from front), and "Z" twist thread in the right needle.

When use of needle threads discriminates is impossible, use "Z" twist thread in both the needles.

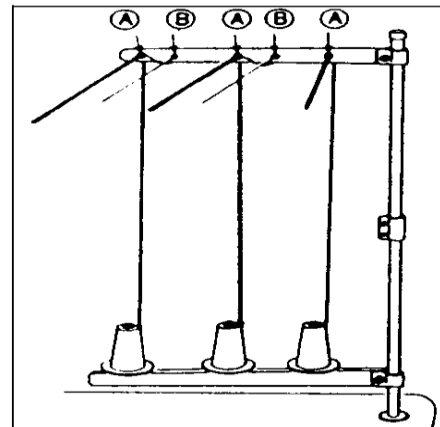
For bobbin thread, "S" twist thread as well as "Z" twist thread can be used.



5. Threading of needle threads

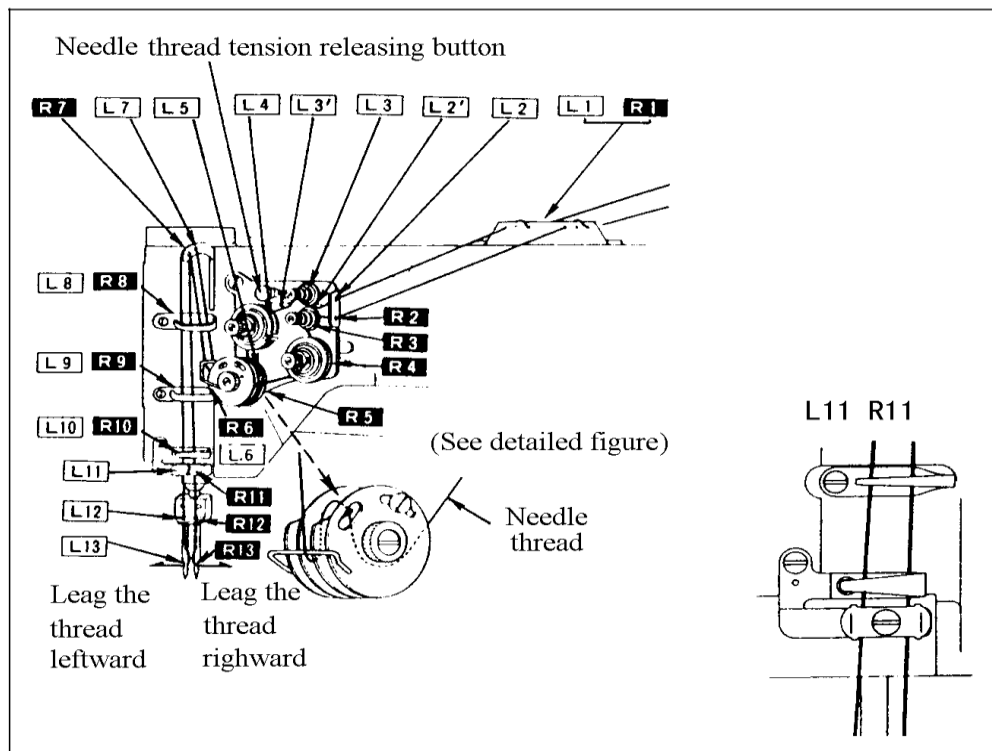
- 1) Pass each needle thread through thread guide "A" .

Note: When thin slippery thread (polyester thread or filament thread, for example) is used pass the thread through thread guides "B" as well.



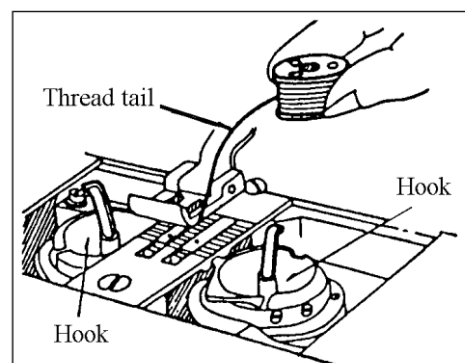
- 2) With the take-up lever located at the upper most position, pass each needle thread in the order shown in the following figure.

Note: Pressing the upper thread loosening button shown in the figure below opens the saucer of the upper thread tension adjuster, and the upper thread can easily pulled out



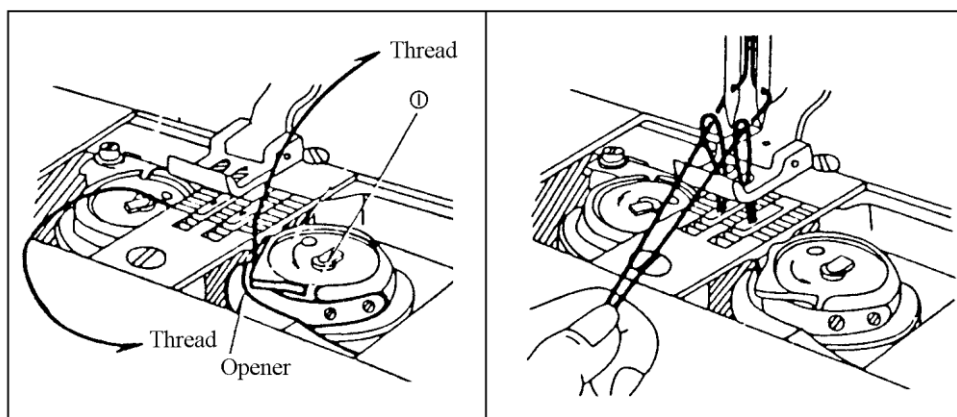
6. Setting of bobbin

- 1) Pulling out 5. cm thread tail from the bobbin.
- 2) Hold the bobbin so that the bobbin thread is would in right direction and put it into the hook.



7. Threading of bobbin threads

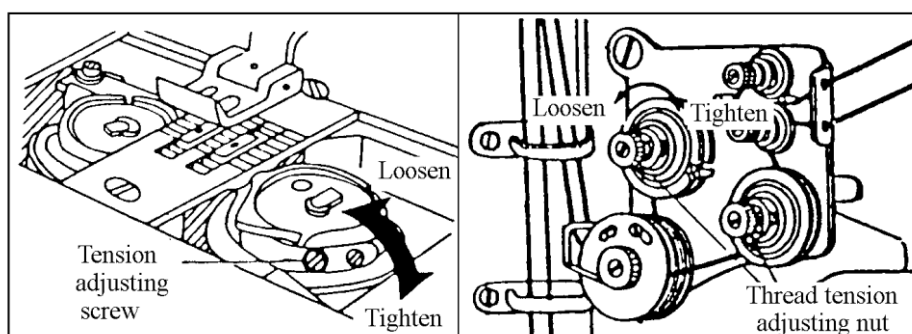
- 1) Put the hook into the bobbin case and press down the latch ①.
- 2) While holding the two needle threads by left hand, rotate the hand-wheel one turn by right hand.
By pulling up the needle threads, as shown in the figure, the bobbin threads will be lifted.
Each combination of bobbin thread and needle thread should be aligned and led backward.



8. Thread tension

1) Adjusting the bobbin thread tension

Turn tension screw, clockwise to increase the bobbin thread tension, or counter clockwise to decrease it.



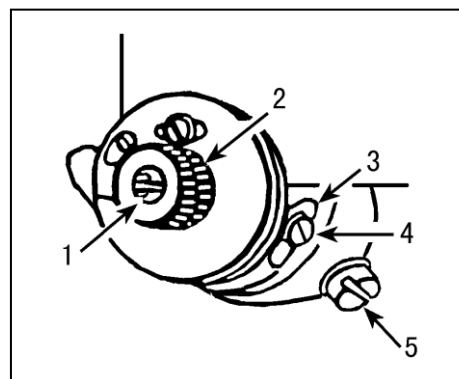
2) Adjusting the needle thread tension

- Needle thread tension should be adjusted in reference to bobbin thread tension.
- Turn tension nut clockwise to increase the needle thread tension, or counter clocking to decrease it.
- Needle thread tension can be also adjusted for special fabric and thread by changing intensity and movable range of slack thread adjusting spring.

9. Thread take-up spring

1) To change the stroke of thread take-up spring

- Loosen screw "4" in the stopper, and move stopper "3" to the right or left.
- Move the stopper to the right to increase the stroke of the thread take-up spring, or to the left to decrease it.



2) To change the tension of the thread take-up spring

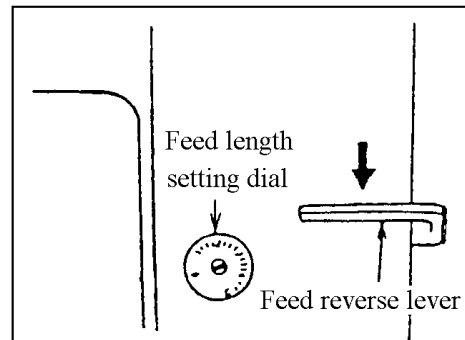
Loosen nut “2” and screw “5”. Turn spring shaft “1” counter clockwise to increase the tension of the spring, or clockwise to decrease it. Fit a screwdriver in the spring shaft and turn it until the desired tension is provided.

10. Adjusting the stitch length

Turn stitch length dial counter-clockwise to bring the desired value to the top of the dial so that the value is aligned with the pin.

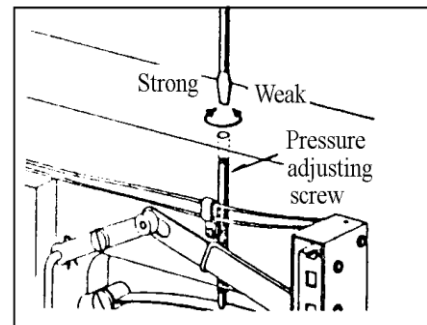
Reverse feed stitching

- 1) The machine performs reverse feed stitching as long as the lever is held depressed.
- 2) The moment you release the lever, the machine resumed the normal stitching mode.



11. Adjusting the pressure of the presser foot

Pressure to fabric can be adjusted by turning the pressure adjusting screw.



12. Adjusting the presser foot and the walking foot

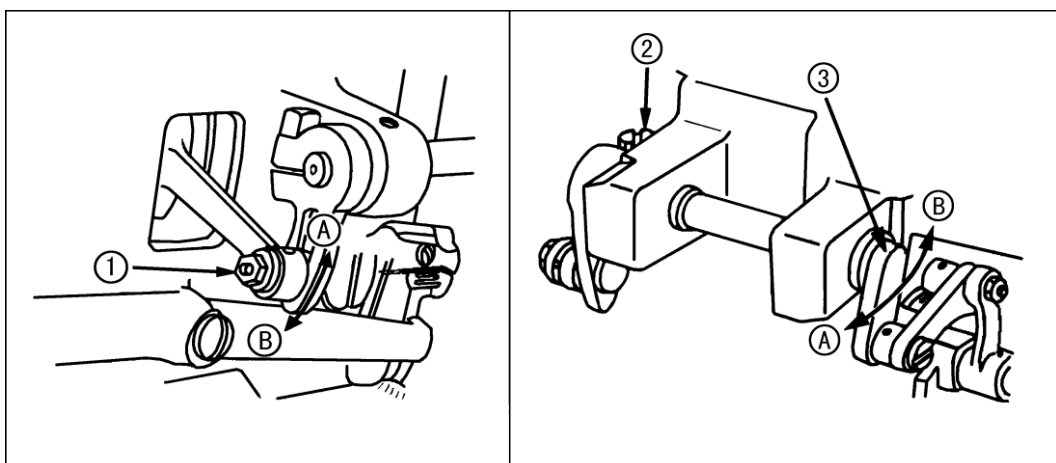
- 1) Loosen nut 1, and change the position of the cam rod boss accordingly.

Highest position---The stroke is maximized. “A”
Lowest position--- The stroke is minimized. “B”.

- 2) Alternate vertical motions of the walking foot and presser foot

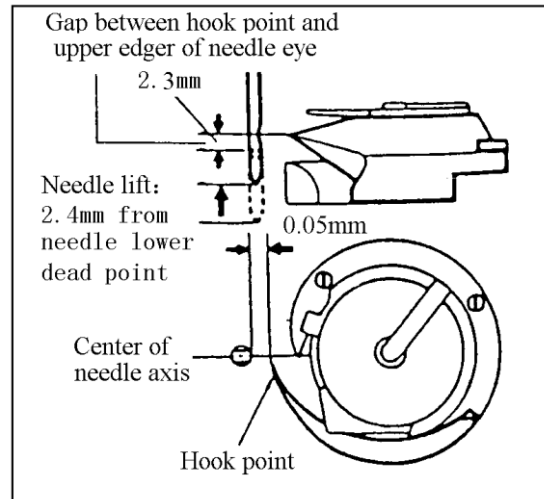
The alternate vertical strokes of the walking foot and presser foot

- Loosen screw ② of the top feed crank..
- Bring the thread take-up lever to its highest position, and lower the presser bar lifting lever. Move top feed crank ③ to left “A” to increase the stroke of the presser foot, or to the right “B” to increase it.



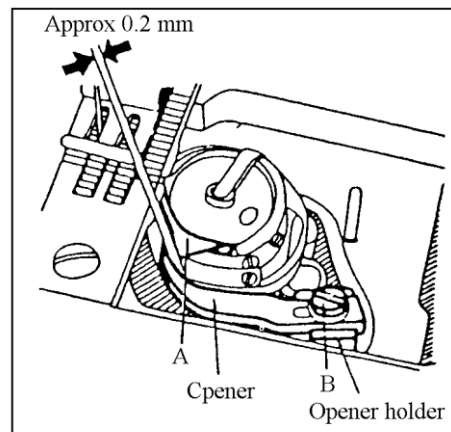
13. Timing between rotating hook motion and needle motion

- 1) Set feed length (stitch length) to “6” on the feed setting dial.
- 2) When needle is lifted 2.4mm from the lower dead point, as shown in Figure, the following positional relationship should be maintained.
 - The upper edge of needle eye should be 2.3 mm below the hook point.
 - The hook point should be located at the center of needle axis.
 - Gap between the hook point and the side face of needle should be 0.05mm.



14. Relationship between hook motion and opener motion

- 1) Turn the balance wheel by hand and stop when the opener holder is located most remotely from the throat plate.
- 2) Make sure gap between the bobbin case holder A and the opener is approximately 0.2 mm.
- 3) If the gap is too large or small, loosen the opener holder set screw B and adjust position of the opener.

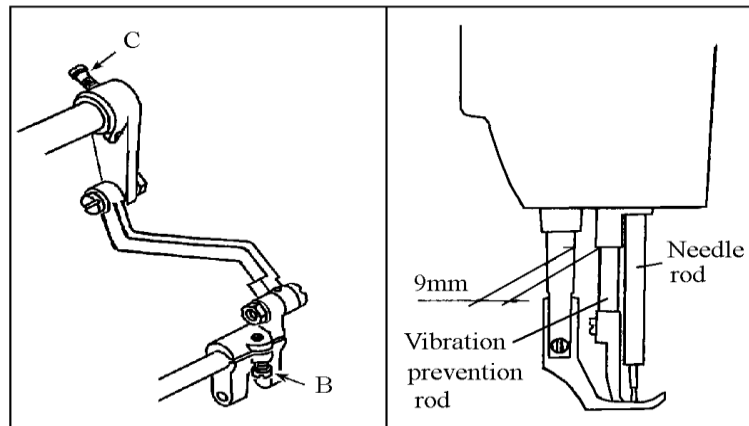


15. Relationship between needle motion and feed dog motion

- 1) Set feed length to “0” on the feed setting dial
- 2) Set the needle at the lowest position.
- 3) Lean the machine head backward, remove the back cover, loosen screw B and C.
- 4) Adjust the distance between presser rod and vibration prevention rod to 9 mm.
- 5) After the completion of adjustment, fully tighten the screws B and C.

Note:

At this time make certain that needle can enter the feed dog needle hole at the center of the hole.

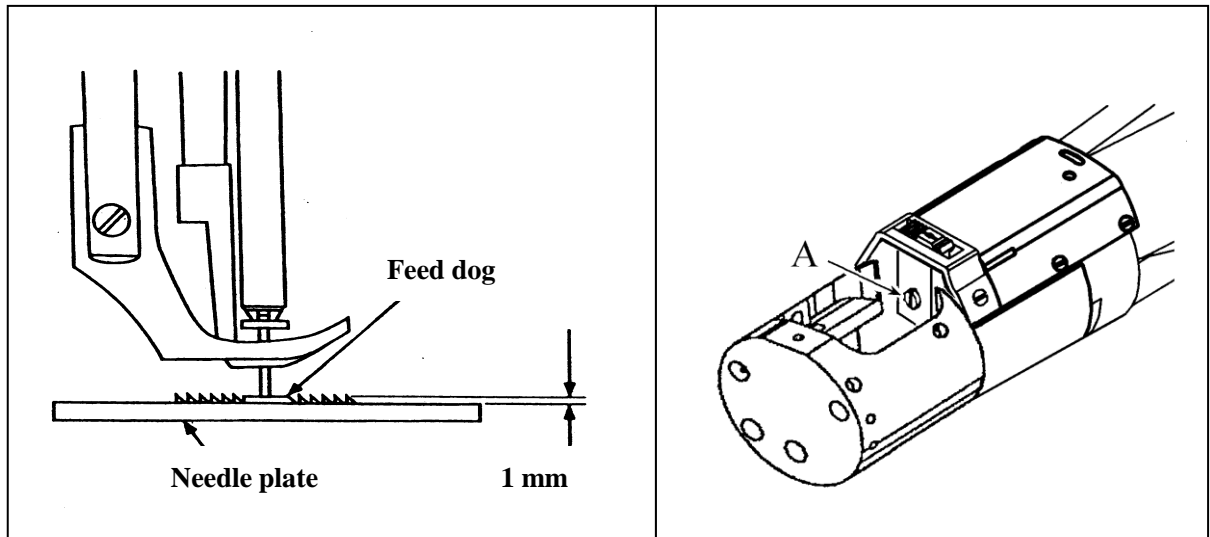


16. Adjusting the height of the feed dog

The max. Height of the feed dog from the surface to the needle plate is normally 1mm.

To adjust this height:

- 1) Set the stitch length at minimum.
- 2) Turn the pulley so as to raise the feed dog to it highest position.
- 3) Loosen the screw "A", adjust the height of the feed dog.
- 4) Tighten the screw "A" after adjustment.



17. Safety mechanism

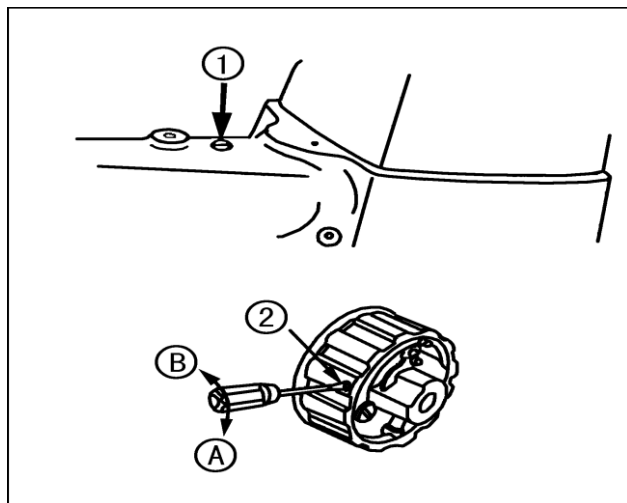
If the thread is caught in the hook while the sewing machine is in operation, the safety mechanism actuates to idle the lower sprocket only if the thread is caught in the hook while the sewing machine is in operation, the safety mechanism actuates to idle the lower sprocket only.

1) How to reset

- Remove the thread caught in the hook
- Pressing push button ①, strongly turn the pulley in the direction opposite to its normal rotational direction.

2) Safety load

Turn adjustment screw ② in direction "A" (clockwise) to increase the safety load, or in direction "B" (counter-clockwise) to decrease it.



18. Adjustment of needle bar stop position (GC2268-2BL)

1) Adjust of "UP" position

When the pedal is kicked down by heel, the machine stops at "UP" position. If the marks deviate larger than 3mm, adjust as follows.

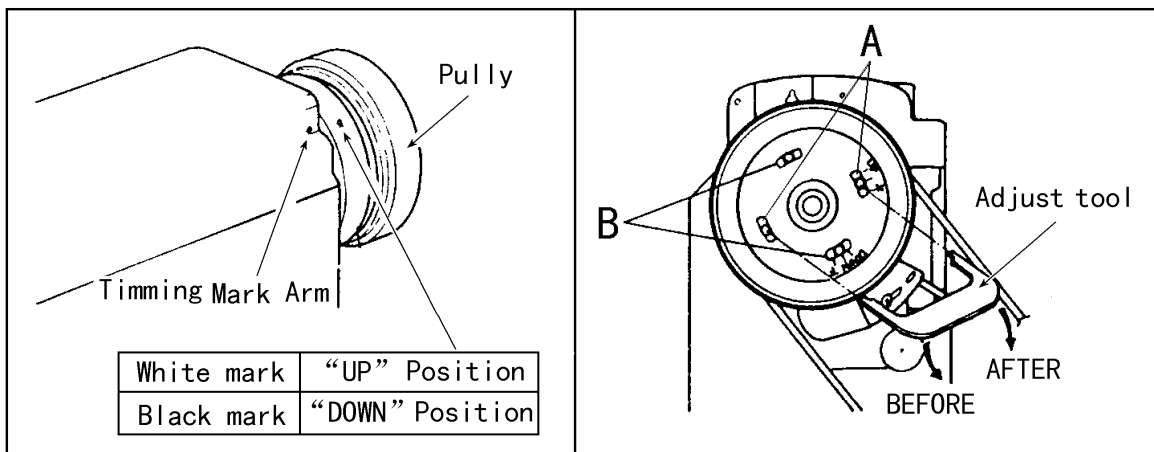
- Disconnect the plug of cable from the machine head.
- Run the machine and stop at "UP" position.
- While holding the pulley, insert the "adjusting tool" in hole "A", then remove the tool.

2) Adjust of "DOWN" position

When the pedal is "Neutral" the machine stops at "DOWN" position. If the marks deviate larger than 5mm, adjust as follows.

- Disconnect the plug of cable from the machine head.
- Run the machine and stop at "DOWN" position.
- While holding the pulley, insert the "adjusting tool" in hole "B", then remove the tool.

3) Confirm the stop operation, then set the plug coming from the machine head into the receptacle.

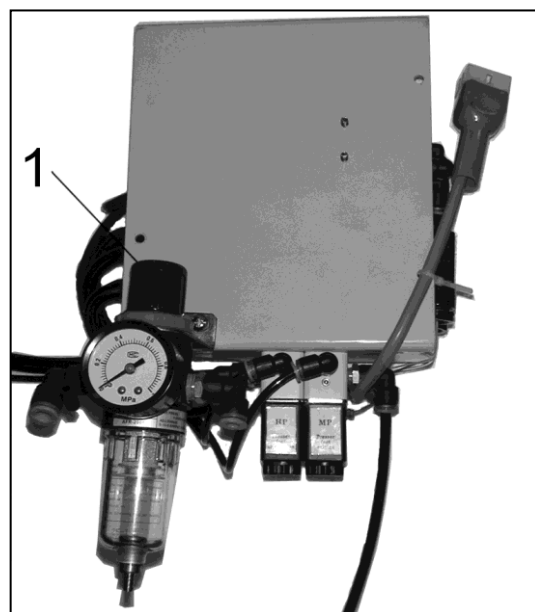


19. Regulate the atmospheric pressure

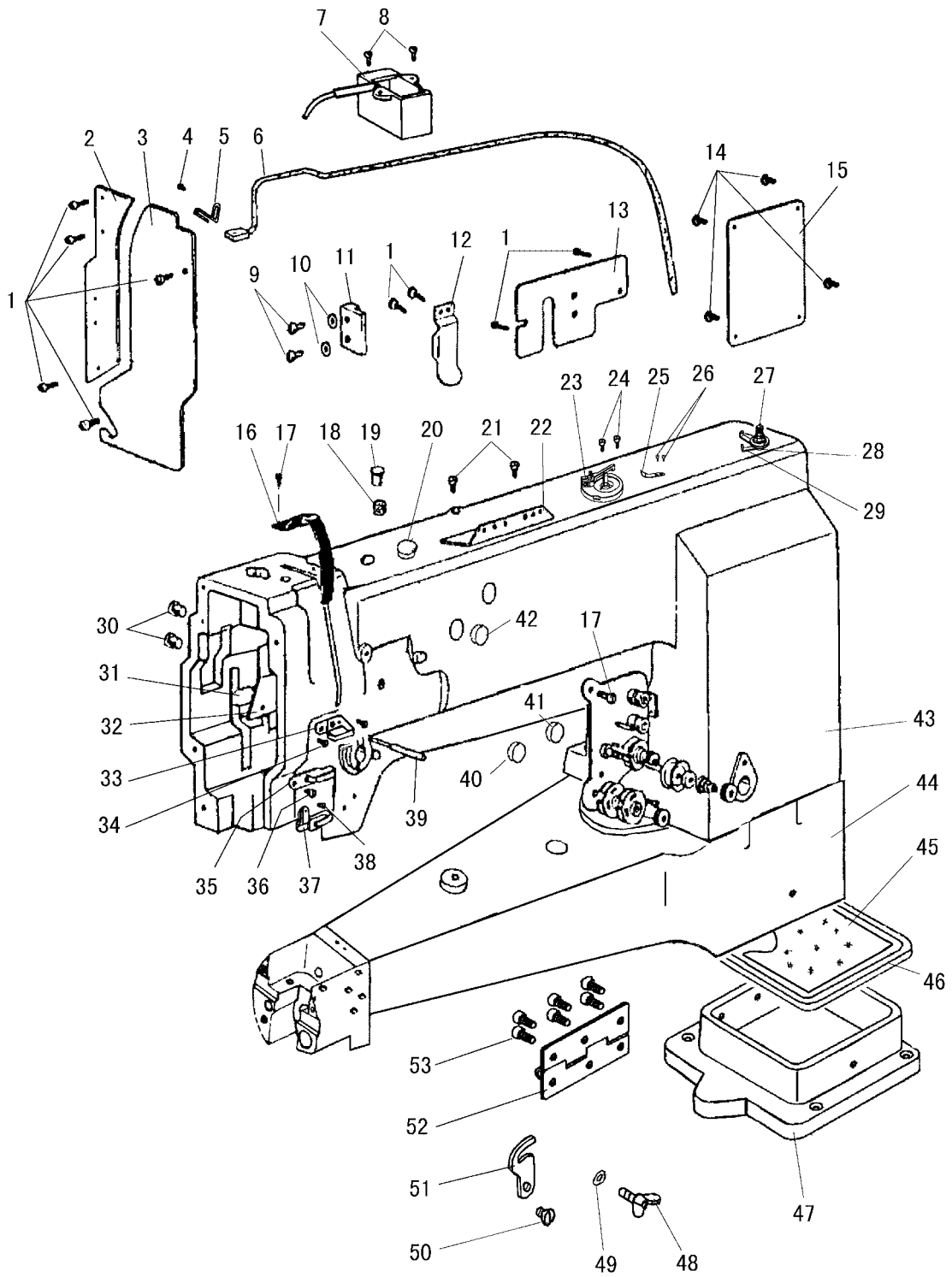
(GC2268-2BL)

When the air cylinder works normally, the necessary atmospheric pressure is 5~6bar. Can find out through the dial plate of the filtering.

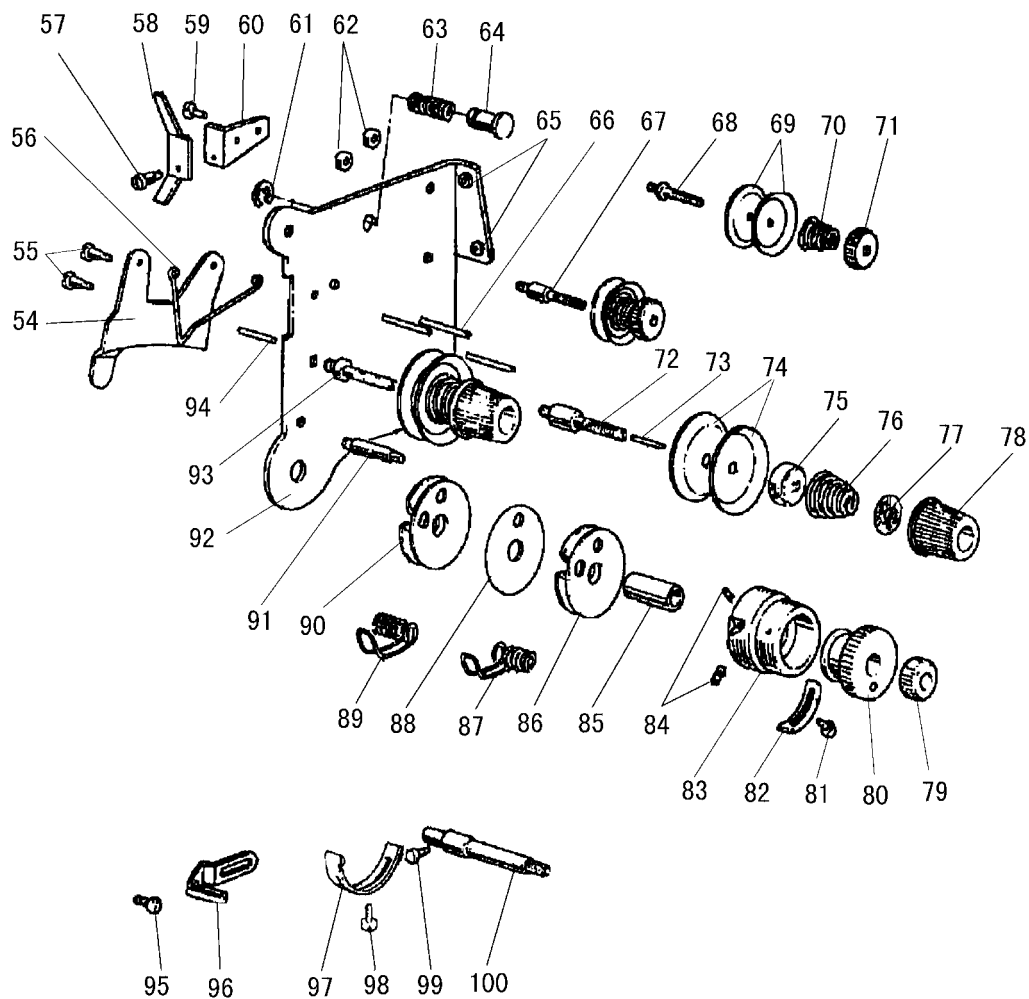
- 1) Lifting knob 1, clockwise rotation, the pressure increases.
- 2) Lifting knob 1, anticlockwise rotation, the pressure is reduced.



A. ARM BED AND ITS ACCESSORIES



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Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
A01	HA300B2170	Face plate screw	9	9	SM11/64(40) × 9
A02	H4730B8001	Guide mounting plate	1	1	
A03	H4727B8001	Face plate	1	1	
A04	HA300C2030	Screw	1		SM11/64(40) × 8
A05	H4731J8001	Holder	1		
A06	H4711J7101	Oil pipe	1		
A07	HH61B17101	Oil pipe	1	1	
A08	H411040160	Screw	2	2	
A09	HA100E2150	Screw	2	2	SM11/64(40) × 10
A10	H4722E8001	Washer	2	2	
A11	H4721E8001	Guide for slide block	1	1	
A12	H4716B8001	Oil guard plate	1	1	
A13	H4718B8001	Arm side cover	1	1	
A14	HA300B2170	Face plate screw	4		SM11/64(40) × 9
A15	H4719B8001	Arm side cover	1		
A16	H4717B8001	Thread take-up guard	1	1	
A17	HA300C2030	Screw	2	2	SM11/64(40) × 8
A18	H32175B304	Felt	1	1	
A19	H4715B8001	Oil cup	1	1	φ 13
A20	H4735B8001	Oil cup	1	2	φ 22
A21	HA700B2060	Screw	2	2	SM11/64(40) × 8
A22	H2400B2100	Thread guide	1	1	
A23	H7007D7101	Bobbin complete		1	
A24	H3107G0662	Screw		2	
A25	H6756B8001	Cut plate		1	
A26	HA500C2070	Screw		2	SM9/64(28) × 5
A27	H7014D7101	Down-lead complete		1	
A28	H7016D8001	Washer		1	
A29	H6662B8001	Thread guide		1	
A30	HA300B2090	Oil cup	2	2	φ 8.8
A31	H2400B2060	Oil guard plate block	1	1	
A32	H3200B2060	Oil guard	1	1	
A33	H2400B2070	Thread guide	1	1	
A34	H2400B2080	Screw	2	2	SM3/16(28) × 13
A35	H4726B8001	Thread guide	1	1	
A36	H3000D2160	Screw	1	1	SM9/64(40) × 6.5
A37	H3212B0066	Thread guide	1	1	
A38	H3200B2100	Screw	1	1	SM9/64(40) × 6.5
A39	H4769E8001	Tension releasing pin	1		
A39	H7010E8001	Tension releasing pin		1	
A40	H4736B8001	Oil cup	1	1	φ 15
A41	HA307B0673	Oil cup		1	φ 19
A42	HA307B0673	Oil cup	1	1	φ 19

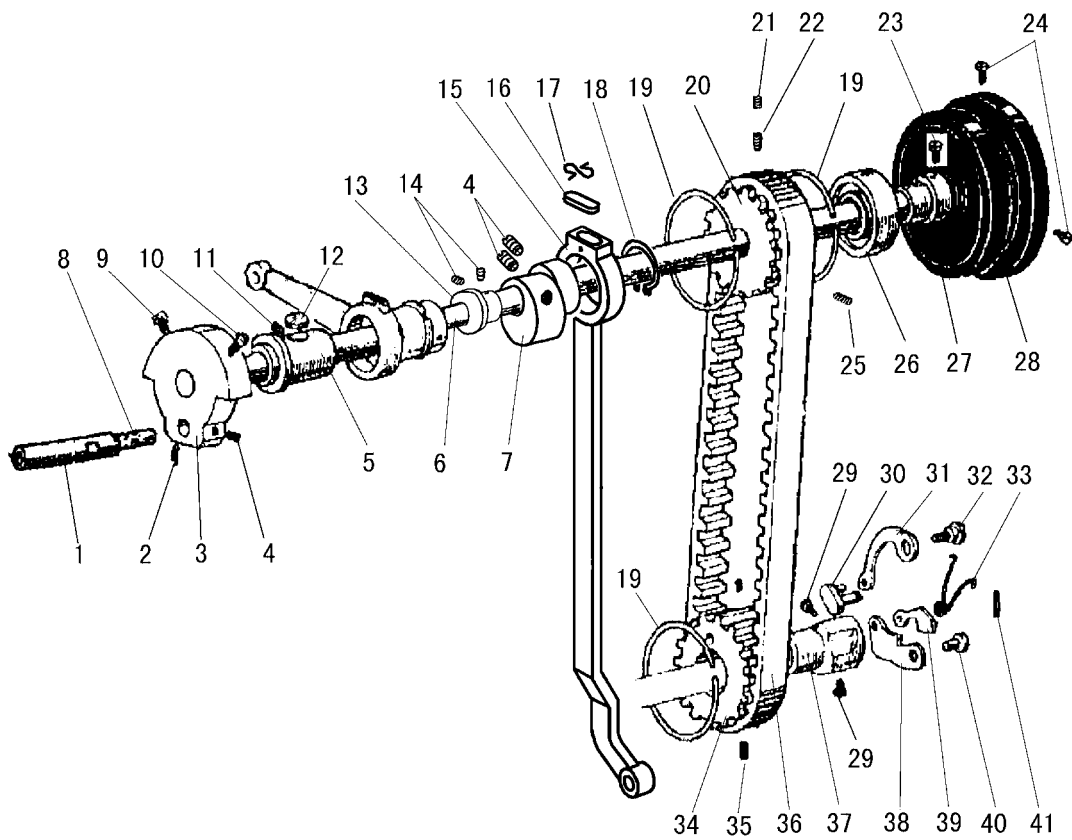
A. ARM BED AND ITS ACCESSORIES

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
A43	HH60B68001	Arm	1		
A43	HH70B68001	Arm		1	
A44	HH60B78001	Arm bed	1		
A44	HH70B78001	Arm bed		1	
A45	HH60B98001	Felt	1		
A46	HH60B88001	Oil reservoir	1		
A47	H4107B0672	Supporter	1		
A48	HE107I8001	Screw	1	M6	
A49	H4100B2090	Washer	1		
A50	H4100B2070	Screw	1		SM1/4(24) × 9.8
A51	H4100B2060	Link plate	1		
A52	H4100B2100	Hinge	1		
A53	H4100B2110	Hinge screw	6		SM1/4(24) × 9.8
A54	H3221B3142	Tension releasing plate	1	1	
A55	H3221B6811	Screw	2	2	SM9/64(40) × 3
A56	H3221B6812	Tension releasing spring	1	1	
A57	H4705C8001	Screw	1	1	
A58	H4706C8001	Lever	1	1	
A59	HA7311C306	Screw	1	1	SM9/64(40) × 7
A60	H4707C8001	Mounting plate	1	1	
A61	H007013050	Stop ring	1	1	
A62	H3221B6810	Nut	2	2	
A63	H4708C8001	Spring	1	1	
A64	H4709C8001	Push button	1	1	
A65	H3221B0681	Porcelain cluct	2	2	
A66	H3221B0682	Pin	3	3	
A67	H3221B0685	Thread tension stud	1	1	
A68	H3221B0683	Thread tension stud	1	1	
A69	HA112B0693	Thread tension disc	4	4	
A70	H3221B0684	Spring	2	2	
A71	HA710B0671	Thumb nut	2	2	SM11/64(40) × 6
A72	H3221B0689	Thread tension stud	1	1	
A73	H3221B6816	Pin	1	1	
A74	HA310B0705	Thread tension disc	4	4	
A75	HA310B0702	Thread tension releasing disc	2	2	
A76	H4710C8001	Spring	2	2	
A77	HA115B7010	Thumb nut complete	2	2	
A78	HA310B0701	Thumb nut revolution stopper	2	2	
A79	H32481B721	Thumb nut	1	1	SM1/4(40) × 4.5
A80	H32481B621	Take-up spring guard	1	1	
A81	H32481BC21	Screw	1	1	SM9/64(40) × 6
A82	H32481BB21	Stopper	1	1	
A83	H32481B921	Thread tension post	1	1	

A. ARM BED AND ITS ACCESSORIES

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
A84	H32481B521	Screw	2	2	SM11/64 (40) × 10
A85	H32481B821	Bush	1	1	
A86	H32481BF21	Plate complete	1	1	
A87	H4712C8001	Thread take-up spring	1	1	
A88	H32481BE21	Plate	1	1	
A89	H4713C8001	Thread take-up spring	1	1	
A90	H32481BD21	Plate complete	1	1	
A91	H32481B421	Screw	1	1	
A92	H3221B6820	Mounting plate	1	1	
A93	H3221B0686	Thread tension stud	1	1	
A94	H3221B6817	Pin	1	1	SM9/64 (40) × 6
A95	HA106B0676	Screw	1	1	
A96	H3306B0661	Oil check window	1	1	SM9/64 (40) × 6.5
A97	H3221B6819	Stopper	1	1	
A98	H3200B2100	Screw	1	1	
A99	H3230K0751	Screw	1	1	SM11/64 (40) × 10
A100	H32481B121	Thread tension stud	1	1	

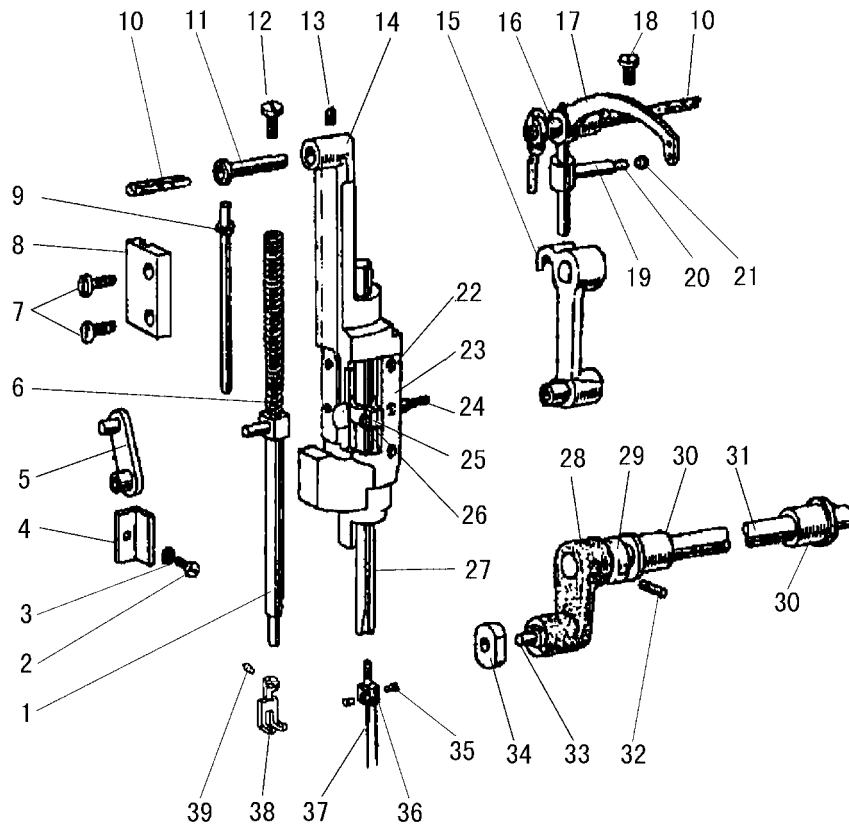
B. ARM SHAFT MECHANISM



B. ARM SHAFT MECHANISM

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
B01	H2405D0662	Hinge pin	1	1	
B02	HA105D0662	Screw	1	1	SM1/4 (40) × 4
B03	H4706D8001	Needle bar crank	1	1	
B04	HA307C0662	Screw	3	3	SM1/4 (40) × 6
B05	H32111B204	Arm shaft bushing (left)	1	1	
B06	HH61C08001	Arm shaft	1		
B06	HH70C58001	Arm shaft		1	
B07	H5332C8001	Feed cam (right)	1	1	
B08	H4716F8001	Oil wick	1	1	
B09	HA100C2060	Screw	1	1	SM9/32 (28) × 13
B10	HA100C2070	Screw	1	1	SM9/32 (28) × 14
B11	H2405D0664	Screw	1	1	SM15/64 (28) × 14
B12	H32111B104	Felt	1	1	
B13	H7005D8001	Driving wheel		1	
B14	H4723D8001	Screw		2	SM15/64 (28) × 4.5
B15	HH60C58001	Connecting rod for upper feed	1	1	
B16	H20111C106	Holder	1	1	
B17	H5330C8001	Felt	1	1	
B18	H007009260	Stop ring	1	1	
B19	H3205C0661	Spring stop ring	3	3	
B20	HH60C78001	Pulley	1	1	
B21	HE030C8001	Screw	1	1	SM17/64 (24) × 6.5
B22	HE029C8001	Screw	1	1	SM17/64 (24) × 14.5
B23	HA113F0684	Screw	2		SM15/64 (28) × 8.5
B24	HA110D0672	Screw	2		SM15/64 (28) × 12
B25	HE028C8001	Screw	1	1	SM17/64 (24) × 20
B26	H3205J0662	Needle bearing	1		
B27	H3205J0661	Arm shaft collar	1		
B28	H4100C2040	Balance wheel	1		
B29	HE022G8001	Screw	2	2	SM1/4 (32) × 10.5
B30	HE027G8001	Pin	1	1	
B31	HE023G8001	Long lever for pulley	1	1	
B32	HE024G8001	Pin	1	1	
B33	HE026G8001	Spring for pulley	1	1	
B34	HE019G8001	Pulley	1	1	
B35	HE028E8001	Screw	2	2	SM7/32 (32) × 7
B36	HE109C8001	Cog belt	1	1	
B37	HE021G8001	Shaft for pulley	1	1	
B38	H4719D8001	Short lever for pulley	1	1	
B39	HE031G8001	Lever for pulley	1	1	
B40	HE029G8001	Pin	1	1	
B41	H601012100	Pin	1	1	

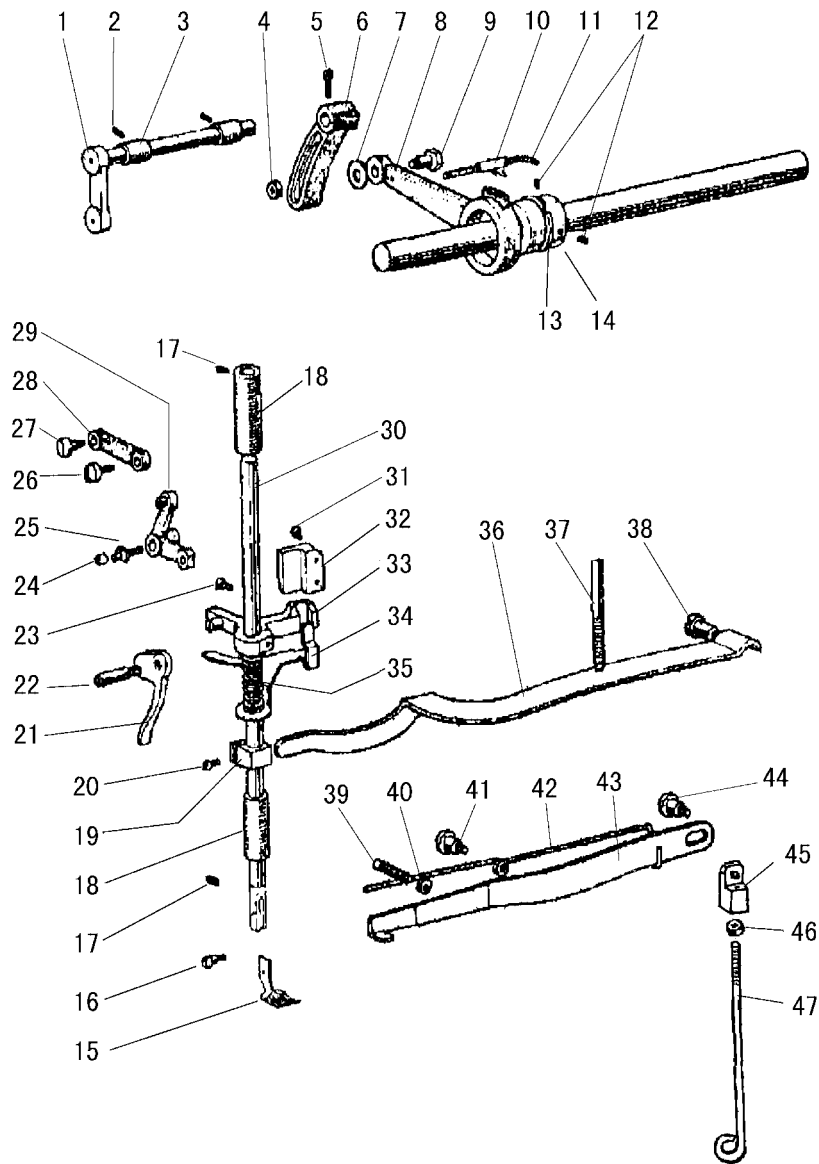
C. NEEDLE BAR & THREAD TAKE-UP LEVER MECHANISM



C. NEEDLE BAR & THREAD TAKE-UP LEVER MECHANISM

Fig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
C01	H4725F8001	Presser bar	1	1	
C02	H3400C2020	Screw	1	1	
C03	H3200I2030	Washer	1	1	
C04	H3400C2010	Needle bar guide	1	1	
C05	H4726F8001	Presser bar connecting link	1	1	
C06	H4729F8001	Spring	1	1	
C07	H4753E8001	Screw	2	2	SM11/64 (40) × 17.5
C08	H4728F8001	Guide for slide block	1	1	
C09	H4730F8001	Vibrating presser bar extension	1	1	
C10	H2405D1122	Oil wick	2	2	
C11	H4706F8001	Pin	1	1	
C12	H4707F8001	Screw	1	1	
C13	HA3411B308	Screw	1	1	SM15/64 (28) × 7
C14	H4719F8001	Needle bar rock frame	1	1	
C15	H4717F8001	Needle bar connecting link	1	1	
C16	H2405D1121	Pin	1	1	
C17	H4712F8001	Thread take-up lever	1	1	
C18	HA110D0672	Screw	1	1	SM15/64 (28) × 12
C19	H2405D1112	Thread take-up link	1	1	
C20	H24211D405	Oil wick	1	1	
C21	H24211D305	Oil wick	1	1	
C22	H32111D304	Screw	6	6	SM3/32 (56) × 4
C23	H4721F8001	Washer	2	2	
C24	H3204D6513	Felt	1	1	
C25	H4722F8001	Needle bar connecting stud	1	1	
C26	H32111D604	Screw	1	1	SM9/64 (40) × 8.5
C27	H4724F8001	Needle bar	1	1	
C28	H3406C0672	Crank	1	1	
C29	H4734F8001	Washer	1	1	
C30	H3204B0652	Needle bar rock shaft bushing	2	2	
C31	H4736F8001	Needle bar rock shaft	1		
C31	H7004F8001	Needle bar rock shaft		1	
C32	H602040240	Pin	1	1	
C33	H3406C0671	Screw	1	1	SM15/64 (28) × 10
C34	H4759F8001	Square block	1	1	
C35	H32132D104	Screw	2	2	SM9/64 (40) × 3
C36	H4739F8001	Needle bar connecting stud	1	1	
C37	JZDP1700G2302	Needle	2	2	DP × 17 23#
C38	H4737F8001	Vibrating Presser foot	1	1	
C39	HA700F2100	Screw	1	1	SM11/64 (40) × 7

D. PREAER FOOT MECHANISM



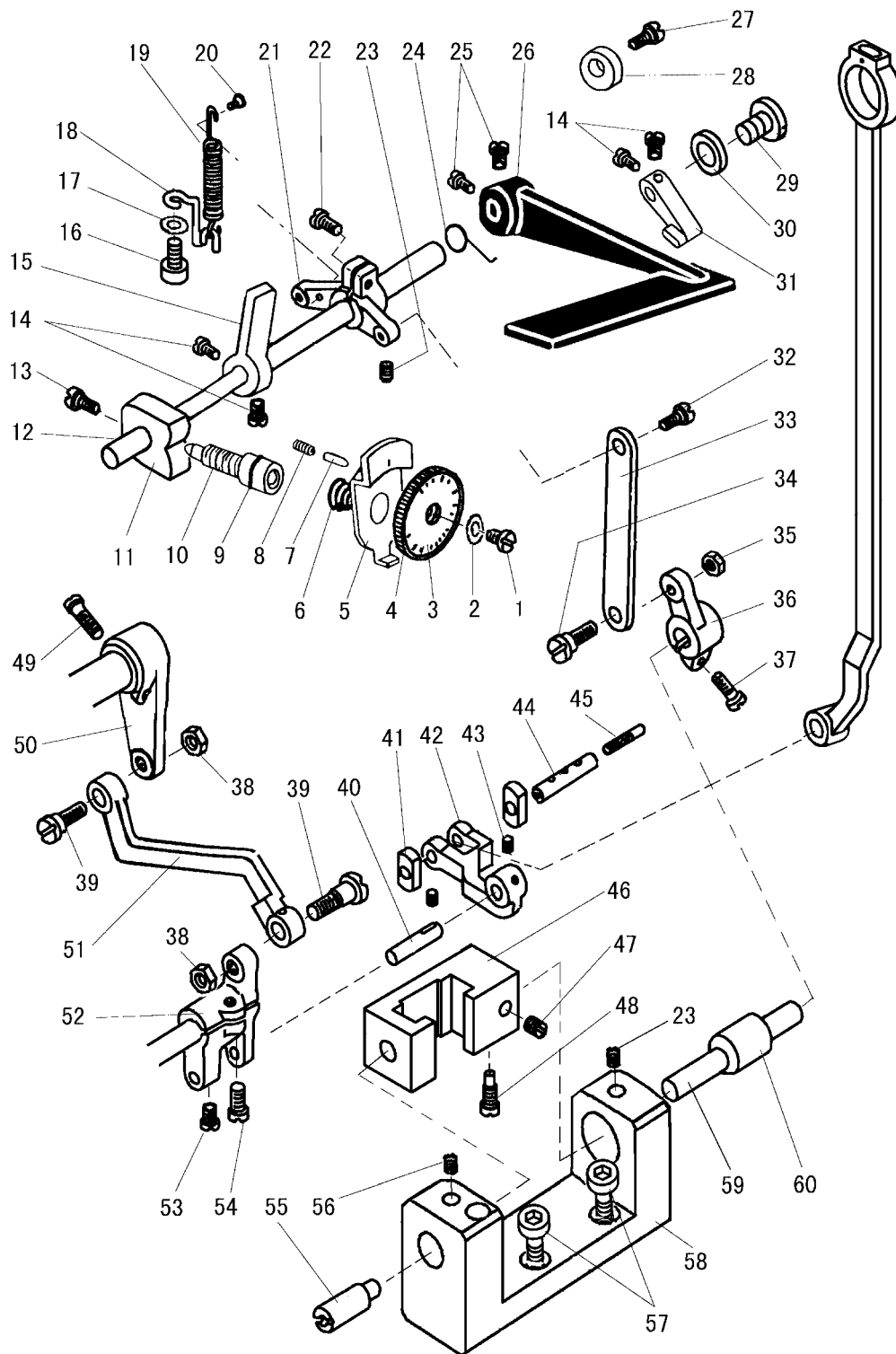
D. PREAER FOOT MECHANISM

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
D01	H4705E8001	Feed lifting rock shaft	1	1	
D02	H4706E8001	Screw	2	2	SM1/4 (24) × 7
D03	H4707E8001	Bushing	2	2	
D04	H0030550608	Thumb nut	1	1	M6 × 0. 75
D05	H3115F0671	Screw	1	1	SM1/4 (28) × 16
D06	H4709E8001	Regulating crank	1	1	
D07	H2013J0065	Washer	1	1	
D08	H2014J0066	Connecting rod	1	1	
D09	H2000J2100	Screw	1	1	M6 × 0. 75
D10	H20111C106	Felt clip	1	1	
D11	H4713E8001	Oil wick	1	1	
D12	HA307C0662	Screw	2	2	SM1/4 (40) × 6
D13	H007009250	Stop ring	1	1	
D14	H4714E8001	Eccentric	1	1	
D15	H4757E8001	Lifting Presser foot	1	1	
D16	H3200E2020	Screw	1	1	SM1/8 (44) × 4
D17	H4708D8001	Screw	2	2	SM1/4 (24) × 13
D18	H4744E8001	Bushing for presser bar	2	2	
D19	H4746E8001	Presser bar spring bracket	1	1	
D20	H2404I0034	Screw	1	1	SM9/64 (40) × 8. 5
D21	H4748E8001	Presser bar lifter	1	1	
D22	H4749E8001	Screw	1	1	SM11/64 (40) × 8. 5
D23	H4753E8001	Screw	1	1	SM11/64 (40) × 17. 5
D24	H4717E8001	Roller	1	1	
D25	H2004J0655	Support shaft	1	1	
D26	H4718E8001	Screw	1	1	SM11/64 (32) × 6
D27	H2004J0662	Screw	1	1	SM1/4 (40) × 5
D28	H4719E8001	Link	1	1	
D29	H4715E8001	Bell crank	1	1	
D30	H4754E8001	Presser bar	1	1	
D31	HA111G0683	Screw	2	2	SM11/64 (40) × 12
D32	H4723E8001	Guide	1	1	
D33	H4752E8001	Presser bar lifting bracket	1	1	
D34	H4768E8001	Thread releasing plate	1	1	
D35	H4767E8001	Spring	1	1	
D36	H4730E8001	Presser bar spring	1	1	
D37	H4729E8001	Screw	1	1	
D38	H3100G2170	Screw	1	1	SM1/4 (24) × 11
D39	H4725E8001	Screw	1	1	SM1/4 (24) × 19
D40	H4726E8001	Nut	1	1	
D41	H3100G2130	Screw	1	1	SM1/4 (24) × 7
D42	H4727E8001	Spring	1	1	
D43	HH60E48001	Knee lifter lever	1		

D. PREAER FOOT MECHANISM

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
D43	H4728E8001	Knee lifter lever		1	
D44	H2000I2140	Screw	1		
D45	H2000I2150	Knee lifter lever joint	1		
D46	H2000I2160	Nut	1		SM3/16 (32)
D47	HH60E58001	Knee lifter rod	1		

E. STITCH REGULATOR MECHANISM



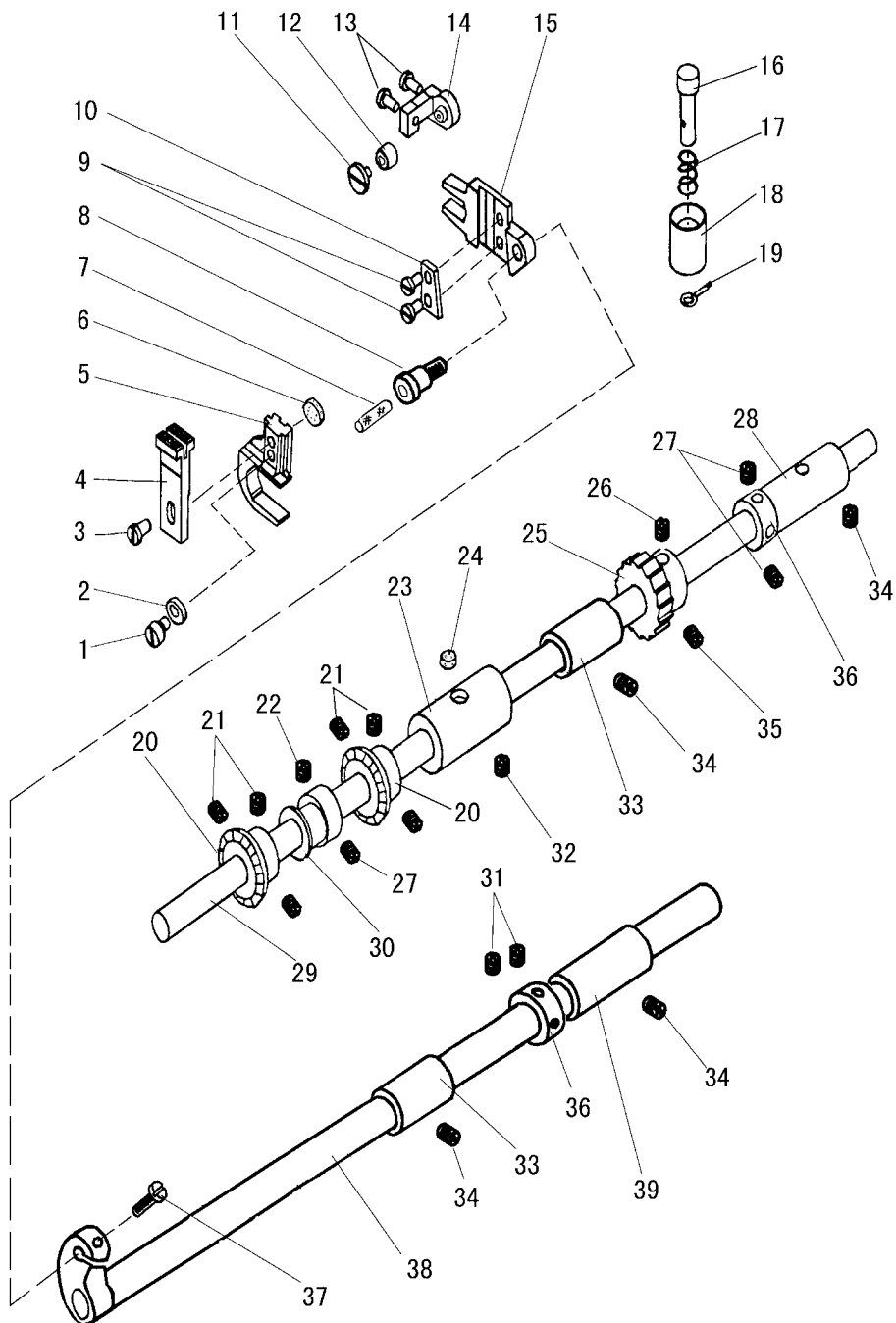
E. STITCH REGULATOR MECHANISM

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
E01	HA720F0686	Screw	1	1	SM3/16 (28) × 12
E02	HA720F0685	Bushing	1	1	
E03	H5341H8001	Plate for stitch length	1	1	
E04	HA7421F120	Dial	1	1	
E05	HA720F0683	Stopper pin releasing lever	1	1	
E06	HA720F0687	Coil spring	1	1	
E07	HA700F2030	Stopper pin	1	1	
E08	HA100F2090	Spring for stopper pin	1	1	
E09	HA109F0674	Seal	1	1	14 × 2.4
E10	HA720F0681	Screw bar	1	1	
E11	HH61F18001	Feed regulator crank	1	1	
E12	HH61F28001	Feed reversing lever shaft	1		
E12	HH70F88001	Feed reversing lever shaft		1	
E13	HA104F0654	Screw	1	1	SM15/64 (28) × 10
E14	HA113F0684	Screw		4	SM15/64 (28) × 8.5
E15	HH71F08001	Baffle		1	
E16	HA100H2150	Screw	1	1	SM9/64 (40) × 11
E17	H005004050	Washer	1	1	
E18	H5330H8001	Spring retainer	1	1	
E19	HG207G8001	Spring	1	1	
E20	H5329H8001	Screw	1	1	SM9/64 (40) × 4
E21	H5327H8001	Feed reversing lever shaft crank	1	1	
E22	H5343H8001	Screw	1	1	SM3/16 (32) × 16
E23	HA3411D308	Set screw	2	2	SM15/64 (28) × 7
E24	H4939L8001	Spring		1	
E25	HA113F0684	Set screw	2		SM15/64 (28) × 8.5
E26	HH61F38001	Feed reversing lever	1		
E26	HH70F98001	Feed reversing lever		1	
E27	H4937L8001	Screw		1	SM15/64 (28) × 6
E28	H4938L8001	Rubber ring		1	
E29	HA113F0683	Screw	1		SM3/16 (28) × 6.5
E30	HA100F2110	Washer	1		
E31	H4936L8001	Lever		1	
E32	H5333H8001	Screw	1	1	SM3/16 (32) × 8.5
E33	HH60F98001	Link lever	1	1	
E34	H5324H8001	Screw	1	1	SM3/16 (32) × 13.5
E35	H5325H8001	Nut	1	1	SM3/16 (32) × 3.6
E36	H5322H8001	Reverse block shaft crank	1		
E36	HH70F68001	Reverse block shaft crank		1	
E37	HA104G0012	Screw	1		SM3/16 (28) × 12
E37	HA111G0683	Screw		1	SM11/64 (28) × 12
E38	H2010J0066	Nut	2	2	SM9/32 (28) × 3.6
E39	H5317H8001	Screw	2	2	SM9/32 (28) × 13.3

E. STITCH REGULATOR MECHANISM

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
E40	H5315H8001	Crank shaft	1	1	
E41	H5309H8001	Slide block	2	2	
E42	H5313H8001	Link lever	1	1	
E43	HA711B0681	Screw	2	2	SM9/64 (40) × 4.5
E44	H5311H8001	Shaft for reversing block slide block	1	1	
E45	H5312H8001	Oil wick	1	1	
E46	H5305H8001	Reverse block	1	1	
E48	HA100F2130	Screw	1	1	SM15/64 (28) × 5
E47	HA300B2080	Set screw	1	1	SM15/64 (28) × 6.5
E49	H5320H8001	Screw	1	1	SM15/64 (28) × 23.5
E50	HH60F78001	Link lever	1	1	
E51	HH60F68001	Link lever	1	1	
E52	H5314H8001	Crank	1	1	
E53	HA700F2100	Screw	1	1	SM11/64 (40) × 7
E54	HA800F2020	Screw	1	1	SM15/64 (28) × 13.5
E55	H5308H8001	Reverse block shaft	1		
E55	HH70F48001	Reverse block shaft		1	
E56	HA100C2020	Set screw	1	1	SM15/64 (28) × 10
E57	H415060160	Screw	2		
E58	HH60F48001	Mounting frame	1		
E59	H5306H8001	Reverse block shaft	1	1	
E60	H5307H8001	Bushing for reverse block shaft	1	1	

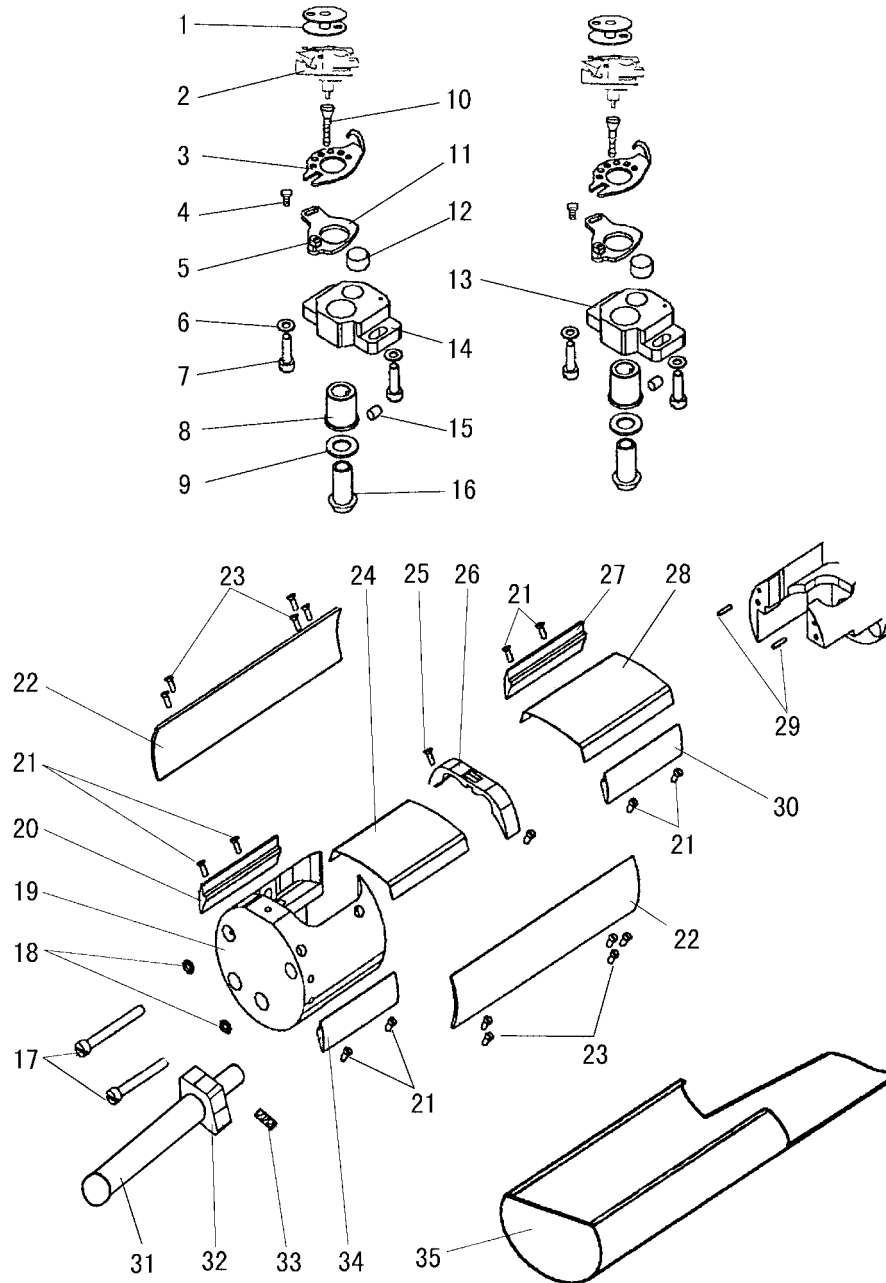
F. FEEDING AND FEED LIFTING & ROTATING HOOK SHAFT MECHANISM



F. FEEDING AND FEED LIFTING & ROTATING HOOK SHAFT MECHANISM

Fig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
F01	HE114E8001	Screw	1	1	SM11/64(40) × 6
F02	HE115E8001	Washer	1	1	
F03	HE012E8001	Connecting screw for feed dog	1	1	SM11/64(32) × 6.5
F04	HE112E8001	Feed dog	1	1	
F05	HE113E8001	Feed rock lifting shaft crank	1	1	
F06	H41111E204	Felt	1	1	
F07	HE117E8001	Oil wick	1	1	
F08	HE116E8001	Pin	1	1	
F09	HE046C8001	Screw	2	2	SM0.1339(36) × 6
F10	HE105E8001	Slide block for crank	1	1	
F11	HE109E8001	Screw	1	1	SM9/64(40) × 5
F12	HE110E8001	Roller	1	1	
F13	HE108E8001	Screw	2	2	SM9/64(40) × 7
F14	HE106E7101	Mounting frame	1	1	
F15	HE104E8001	Feed rock shaft crank	1	1	
F16	HE109D8001	Safe clutch shaft	1	1	
F17	H4107D0672	Safe clutch spring	1	1	
F18	HE108D8001	Safe clutch bushing	1	1	
F19	H601016100	Safe clutch shaft pin	1	1	
F20	HE110D8001	Bevel gear for hook shaft	2	2	
F21	HG214G8001	Set screw	6	6	SM1/4(40)
F22	HE105C8001	Set screw	1	1	SM13/64(32) × 4.7
F23	HE111D8001	Rotating hook shaft bushing (left)	1	1	
F24	HE112D8001	Felt	1	1	
F25	HE106D8001	Recessed wheel	1	1	
F26	HE043C8001	Set screw	1	1	SM1/4(28) × 6.5
F27	HE013H8001	Screw	3	3	SM13/64(32) × 4.3
F28	HE113D8001	Bushing	1		
F28	HH70G58001	Bushing		1	
F29	HE104D8001	Rotating hook shaft	1		
F29	HH70G48001	Rotating hook shaft		1	
F30	HE104C8001	Feed eccentric	1	1	
F31	HE121E8001	Set screw	2	2	SM13/64(32) × 5
F32	HE013C8001	Screw	1	1	SM17/64(24) × 6.5
F33	H4100D2100	Bushing		2	
F34	HE034G8001	Screw	2	4	SM1/4(32) × 7
F35	HE107D8001	Screw	1	1	SM1/4(28) × 6
F36	HE105D8001	Rotating hook shaft collar	2	2	
F37	HE119E8001	Screw	1	1	SM5/32(40) × 9
F38	HE118E7101	Feed rock shaft	1		
F38	HH70G67101	Feed rock shaft		1	
F39	HE113D8001	Bushing	1		
F39	H5321E8001	Bushing		1	

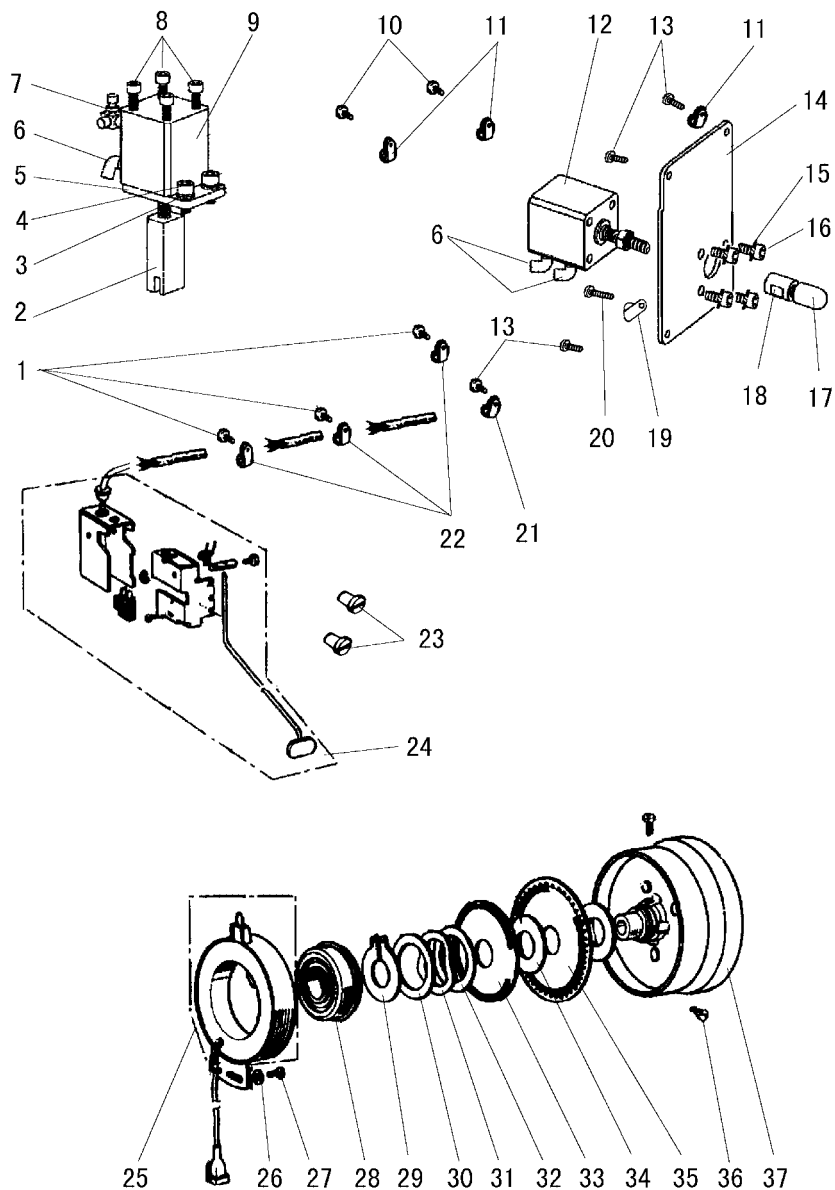
G. HOOK SADDLE MECHANISM



G. HOOK SADDLE MECHANISM

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
G01	HD806I8001	Bobbin	2	2	
G02	HH60H67101	Rotating hook	2	2	
G03	HE117B8001	Rotating position guide	2	2	
G04	HE046C8001	Screw	2	2	SM0. 1339 (36) × 6
G05	HE116B8001	Guide plate slide block	2	2	
G06	HE121B8001	Washer	4	4	
G07	HE120B8001	Washer	4	4	SM13/64 (32) × 16. 5
G08	HE125B8001	Bushing	2	2	
G09	HE124B8001	Washer	2	2	
G10	H2404I0652	Screw	2	2	SM9/64 (40)
G11	HE127B7101	Guide plate	2	2	
G12	HE126B8001	Felt	2	2	
G13	HE147B8001	Rotating hook bracket	1	1	
G14	HE119B8001	Rotating hook bracket	1	1	
G15	HE028E8001	Screw	2	2	SM7/32 (32) × 7
G16	HE123B8001	Bevel	2	2	
G17	HE143B8001	Screw	2	2	SM13/64 (32)
G18	H005009050	Washer	2	2	
G19	HE113B8001	Connecting frame	1	1	
G20	HE131B8001	Front guide plate (left)	1	1	
G21	HE130B8001	Screw	8	8	SM0. 1339 (36) × 8. 2
G22	HE144B8001	Connecting plate	2	2	
G23	HE145B8001	Screw	10	10	SM11/64 (40) × 9
G24	HE133B7101	Front slide plate	1	1	
G25	HE137B8001	Set screw	2	2	SM11/64 (32) × 10
G26	HE136B8001	Needle plate	1	1	
G27	HE140B8001	Back guide plate (left)	1	1	
G28	HE138B7101	Back slide plate	1	1	
G29	HE142B8001	Connecting plate	2	2	
G30	HE141B8001	Back guide plate (right)	1	1	
G31	HE115B8001	Slide plate	1	1	
G32	H4111E0682	Back guide plate (left)	1	1	
G33	HE114B8001	Needle plate	1	1	M4 × 4
G34	HE132B8001	Front guide plate(right)	1	1	
G35	HE146B8001	Slide plate	1	1	

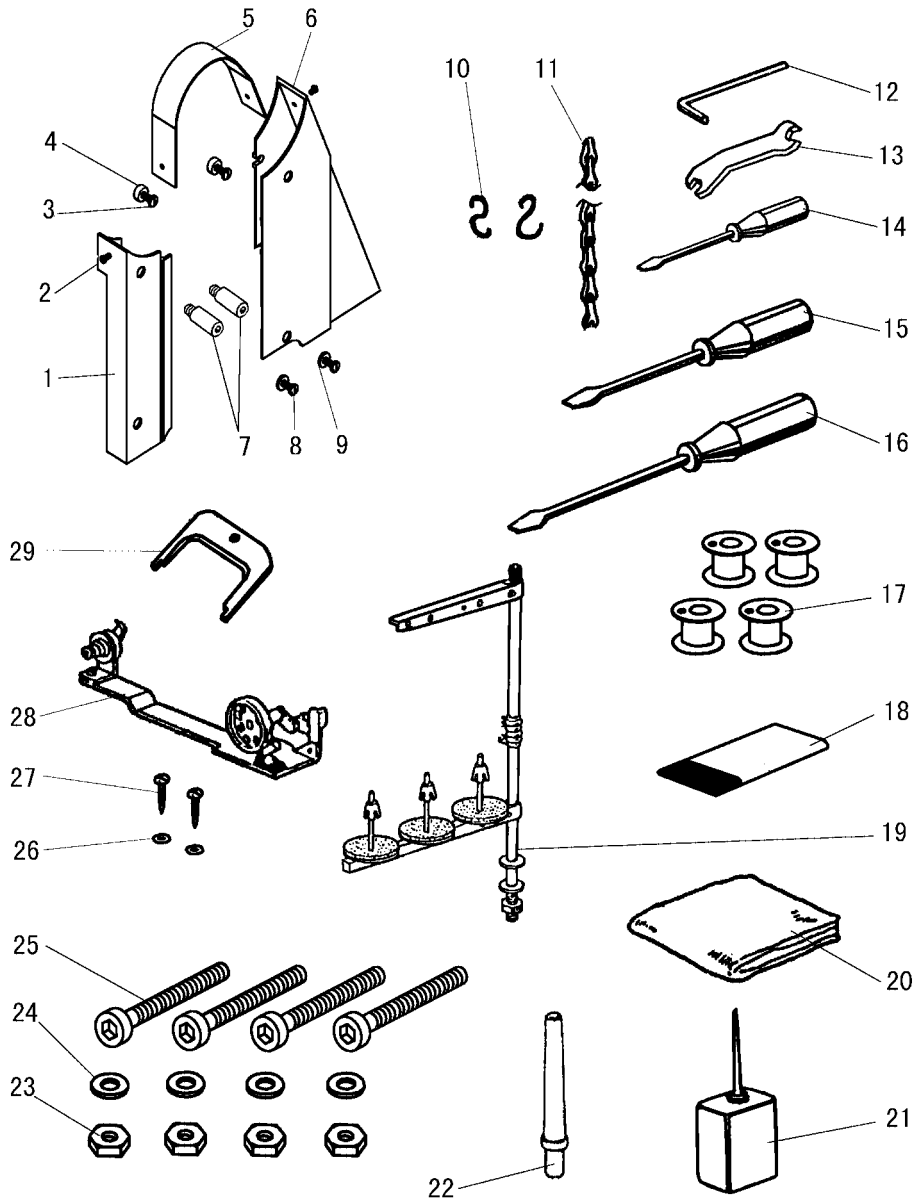
H. PNEUMATIC CONTROL UNIT



H. PNEUMATIC CONTROL UNIT

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
H01	HA300B2130	Screw		3	SM11/64(40) × 5.5
H02	H0606N8001	Support block		1	
H03	H005008060	Spring Washer		2	
H04	H415060200	Screw		2	
H05	H0605N8001	Fixing plate		1	
H06	H4916G8001	Windpipe joint		3	φ 6-M5
H07	H0608N8001	Wire joint		1	φ 6-M5
H08	H415050450	Screw		4	
H09	H0607N8001	Pump		1	SDA25 × 25-B
H10	HA300B2170	Screw		2	SM11/64(40) × 9
H11	HA700Q0050	Holder		3	
H12	H4915G8001	Pump		1	SDA25 × 25-B
H13	HA300B2170	Screw		4	SM11/64(40) × 9
H14	HH70I58001	Arm side cover		1	
H15	H005008060	Spring Washer		4	
H16	H415060200	Screw		4	
H17	H4913G8001	Coupling		1	
H18	H4914G8001	Link		1	
H19	HD44JM8001	Holder		1	
H20	HA100I2090	Screw		1	SM11/64(40) × 13
H21	HA708P0668	Holder		1	
H22	H4980K8001	Holder		3	
H23	H4918L8001	Screw		2	
H24	HH70I57101	Touth switch complete		1	
H25	HA703R0065	Detector bracket (complele)		1	
H26	HA703R0067	Washer		1	
H27	HA300C2030	Screw		1	SM11/64(40) × 8
H28	H3205J0662	Needle bearing		1	NTN 6204Z
H29	H007009300	Retaining ring C-type		1	
H30	HA700R0060	Washer		1	
H31	HA700R0050	Support spring		1	
H32	HA700R0040	Spacer B		1	
H33	H4928L8001	Speed command disk F20 (up)		1	
H34	HA700R0030	Spacer A		2	
H35	H4930L8001	Speed command disk F11 (down)		1	
H36	HA110D0672	Screw		2	SM15/64(28) × 12
H37	H4931L8001	Pulley (complele)		1	

I. ACCESSORIES



I. ACCESSORIES

Pig. No.	Part No.	Description	GC2268-2B	GC2268-2BL	Remarks
I01	HH60I68001	Belt cover (left)	1		
I01	HH70J68001	Belt cover (left)		1	
I02	H200000360	Screw	2	2	SM11/64 (40) × 6
I03	H0207L8001	Screw	2	2	SM15/64 (28) × 18
I04	H6760B8001	Washer	2	2	
I05	H6307L8001	Belt cover (upper)	1	1	
I06	HH60I78001	Belt cover (right)	1		
I06	HH70J78001	Belt cover (right)		1	
I07	HH60I88001	Screw	2		SM15/64 (28)
I08	HN720J8001	Screw	2		SM15/64 (28) × 10
I08	H0207L8001	Screw		2	SM15/64 (28) × 18
I09	H005006060	Washer	2		
I10	H8000H2070	Pothook	2		
I11	HPG100E203	Chain	1		
I12	HB00001060	Socket wrench	1	1	
I13	HE105I8001	Spanner	1	1	
I14	HA300J2210	Screw driver (small)	1	1	
I15	HA300J2200	Screw driver (middle)	1	1	
I16	HA300J2070	Screw driver (larger)	1	1	
I17	HD806I8001	Bobbin	4	4	
I18	JZDP1700G2302	Needle	6	6	DP × 17 23#
I19	H3200L0120	Thread stand assay	1	1	
I20	HA100J2180	Cover	1		
I20	H7009K8001	Cover		1	
I21	H200400069	Oil tank	1	1	
I22	H6620J8001	Head rest bar	1		
I23	H003002080	Nut	4		
I23	H003002120	Nut		4	
I24	H005001080	Washer	4		
I24	H005001120	Washer		4	
I25	H403080750	Screw	4		
I25	H103120120	Screw		4	
I26	HA300J2230	Washer	2		
I27	H801045200	Wood screw	2		
I28	H3300L0040	Bobbin winder assay	1		
I29	HA704S0654	Adjusting plate for speed command disk		1	

GAUGE PARTS LIST

Description	Part No.			
	1/4" (6.4mm)	1/8" (3.2mm)	3/8" (9.5mm)	1/2" (12.7mm)
Vibrating Presser foot	H4737F8001	H4741F8001	H4745F8001	H4746F8001
Needle Clamp	H4739F8001	H4750F8001	H4754F8001	H4755F8001
Lifting Presser foot	H4757E8001	H4758E8001	H4762E8001	H4763E8001
Feed Dog	HE112E8001	HE139E8001	HE138E8001	HH60G48001
Needle Plate	HE136B8001	HE169B8001	HE160B8001	HH61H18001
Front Slide Plate	HE133B7101	HE165B7101	HE156B7101	HH60H97101
Back Slide Plate	HE138B7101	HE167B7101	HE158B7101	HH61H07101
Front Guide Plate (left)	HE131B8001	HE161B8001	HE152B8001	HH61H28001
Front Guide Plate (right)	HE132B8001	HE162B8001	HE153B8001	HH61H38001
Back Guide Plate (left)	HE140B8001	HE163B8001	HE154B8001	HH61H48001
Back Guide Plate (right)	HE141B8001	HE164B8001	HE155B8001	HH61H58001

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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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