

ARTISAN

2618₂-1B

**Cylinder Bed Compound Needle Feed
Lockstitch Sewing Machine**

**Instruction Manual
and Parts Catalog**

Artisan Sewing Supplies, LLC, San Francisco, California

CONTENTS

INSTRUCTION MANUAL

I. PRECAUTIONS BEFORE STARTING OPERATION.....	1
II. SPECIFICATIONS.....	1
III. CAUTIONS ON USE.....	2
1. Lubrication.....	2
2. Winding of bobbin thread.....	2
3. Attaching the needle.....	3
4. Threading of needle threads.....	3
5. Setting of bobbin.....	4
6. Threading of bobbin threads.....	4
7. Thread tension.....	4
8. Thread take-upspring.....	5
9. Adjusting the stitch length	5
10. Adjusting the pressure of the presser foot.....	6
11. Adjusting the presser foot and the walking foot.....	6
12. Timing between rotating hook motion and needle motion.....	6
13. Relationship between hook motion and opener motion.....	7
14. Relationship between needle motion and feed dog motion.....	7
15. Adjusting the height of the feed dog.....	7
16. Safety mechanism.....	8

CATALOG

A. ARM BED AND ITS ACCESSORIES.....	9
B. THREAD TENSION REGULATOR MECHANISM.....	12
C. ARM SHAFT MECHANISM.....	15
D. NEEDLE BAR & THREAD TAKE-UP LEVER MECHANISM.....	17
E. PRESSER FOOT MECHANISM	19
F. STITCH REGULATOR MECHANISM.....	22
G. FEEDING AND FEED LIFTING & ROTATING HOOK SHAFT MECHANISM.....	25
H. HOOK SADDLE MECHANISM.....	27
I. ACCESSORIES	29

I 、 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.

II 、 SPECIFICATIONS

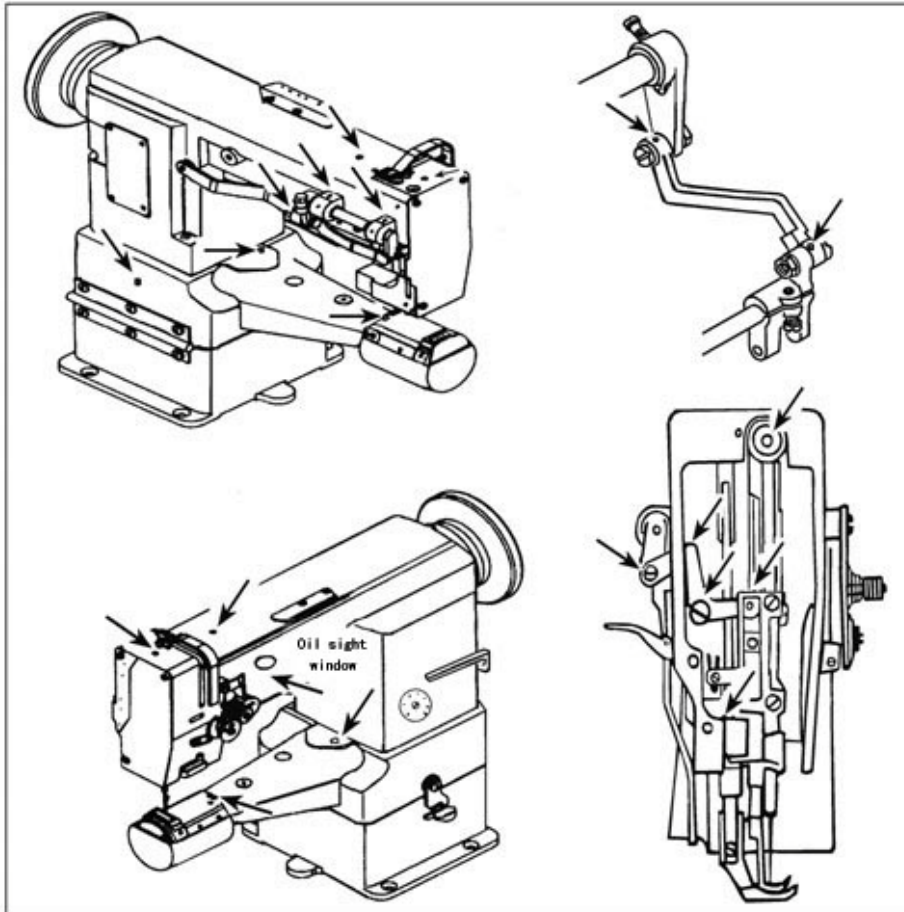
	GC2268-1B
Max. sewing speed	2200 rpm
Needle	DP×17 18-23#
Needle bar stroke	36 mm
Thread take-up lever stroke	74.5 mm
Stitch length	9 mm
Presser foot stroke	By Hand 8 mm / By Knee 14 mm
Alternating movement	2-5 mm
Bed size In dia / Length	71 mm / 222 mm
Lubrication	Manual

III、 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**

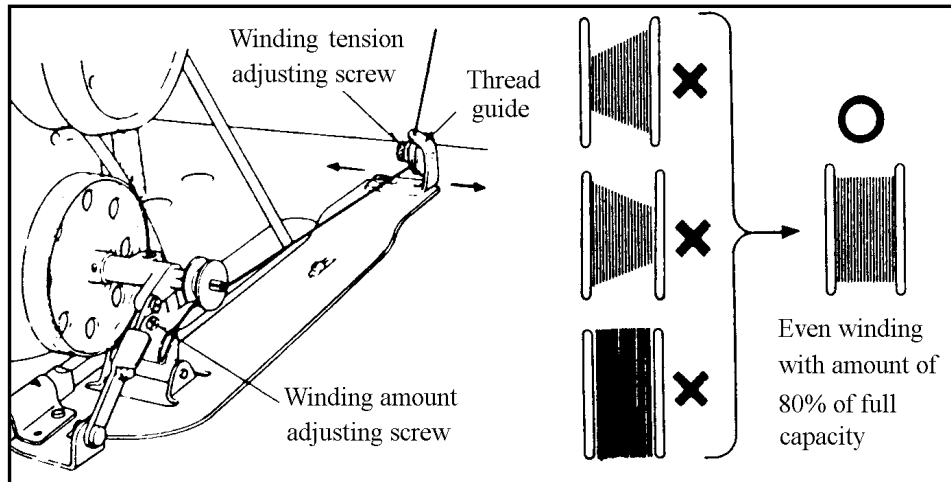
Slack winding is recommended for polyester thread and nylon thread.

- **Conically wound thread**

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

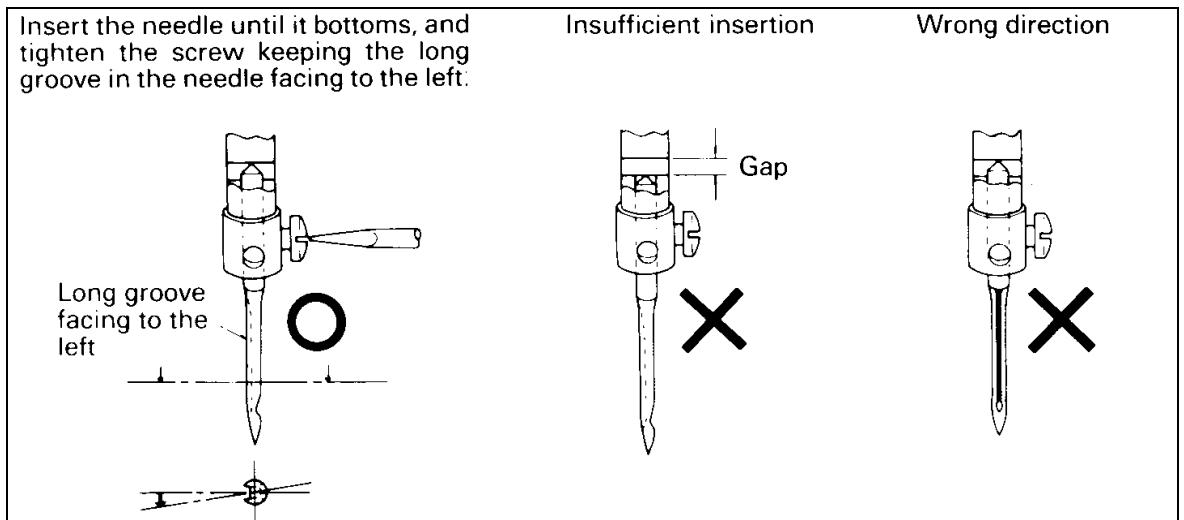
- **Length of wound thread**

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.

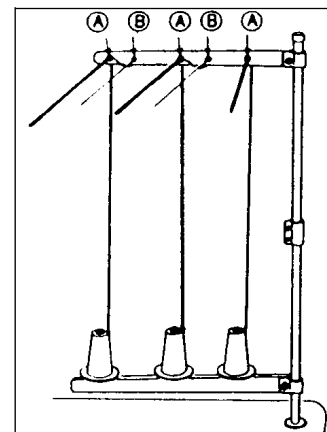


4. Threading of needle threads

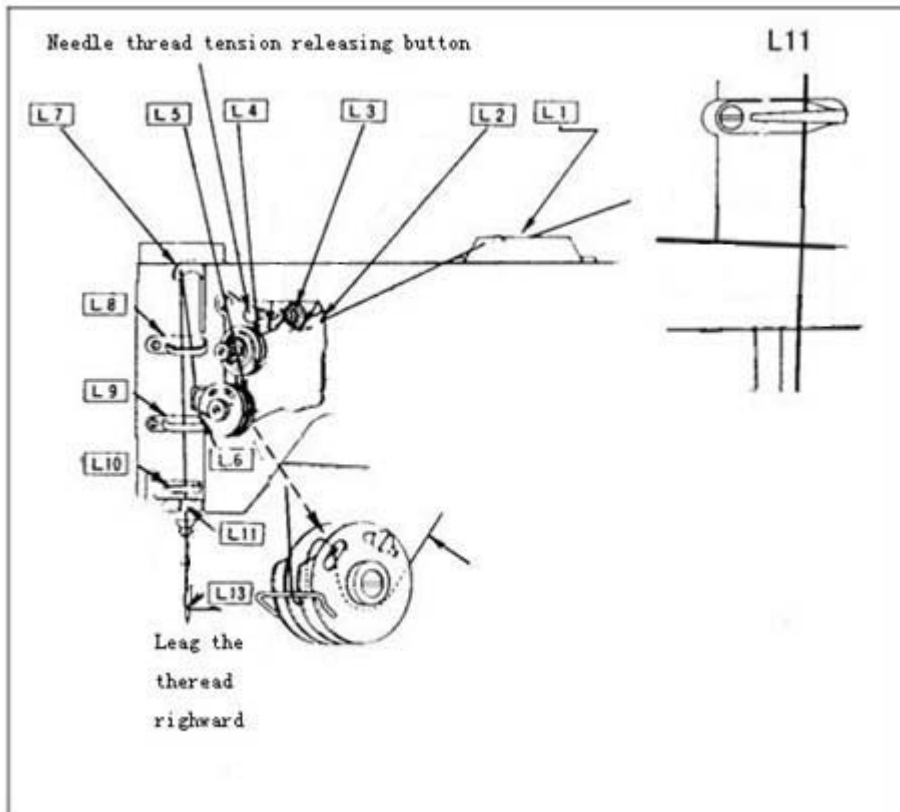
- 1) Pass each needle thread through thread guide "A" .

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.

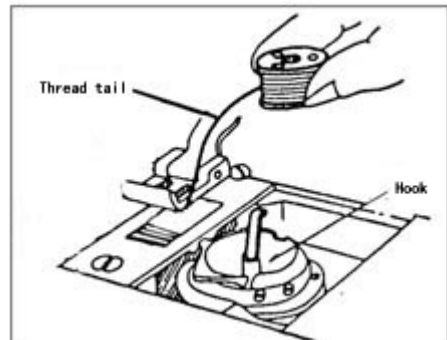


Note: Pressing the upper thread loosening button shown in the figure below opens the saucer of the upper thread tension adjuster, and the upper thread can easily be pulled out



5. Setting of bobbin

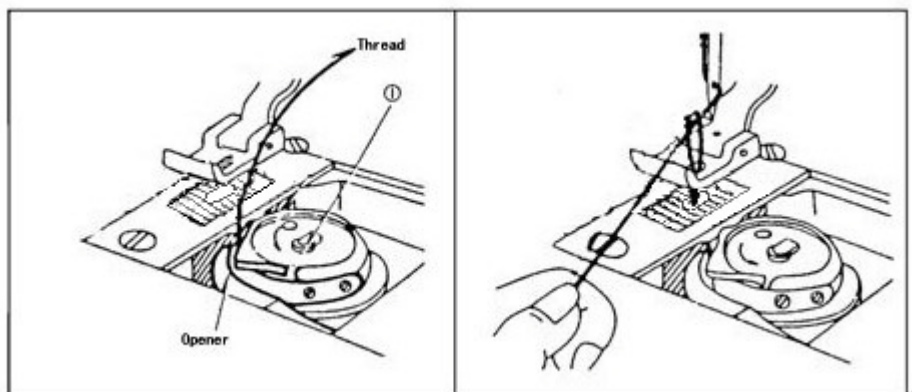
- 1) Pulling out 5cm thread tail from the bobbin.
- 2) Hold the bobbin so that the bobbin thread is would in right direction and put it into the hook.



6. Threading of bobbin threads

- 1) Put the hook into the bobbin case and press down the latch ①.
- 2) While holding the needle threads by left hand, rotate the hand-wheel one turn by right hand.

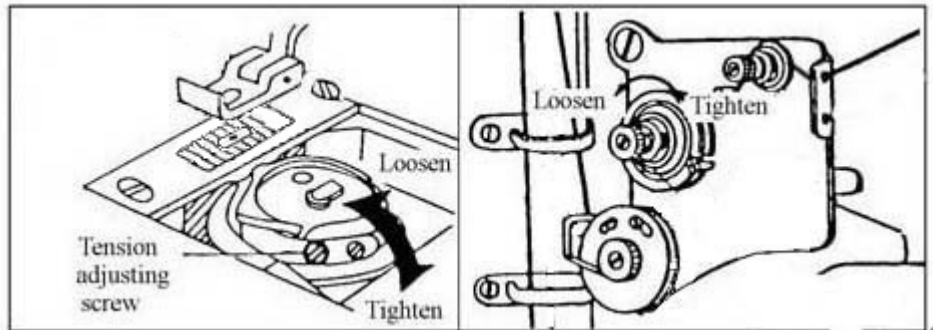
By pulling up the needle threads, as shown in the figure, the bobbin threads will be lifted. Each combination of bobbin thread and needle thread should be aligned and led backward.



7.Thread tension

1) Adjusting the bobbin thread tension

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



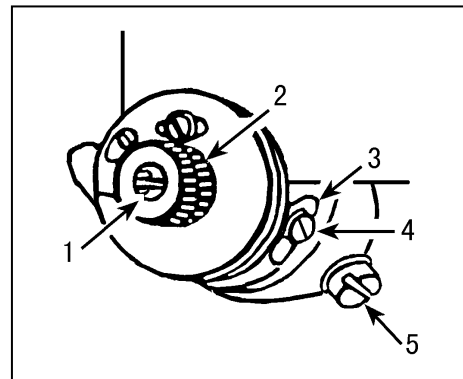
2) Adjusting the needle thread tension

- 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.

8.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

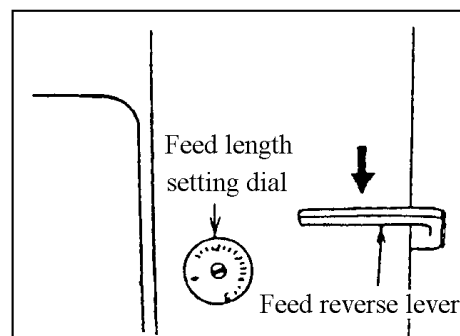
Loosen nut “2” and screw “5”. Turn spring shaft “1” counter clockwise to increase the tension of the spring, or clockwise to decrease it. Fit a screwdriver in the spring shaft and turn it until the desired tension is provided.

9.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.

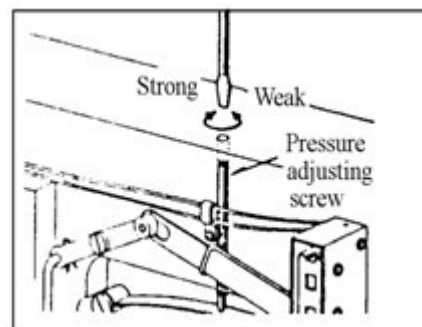
Reverse feed stitching

- 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.



10. Adjusting the pressure of the presser foot

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



11. Adjusting the presser foot and the walking foot

1) Loosen not 1, and change the position of the cam rod boss accordingly.

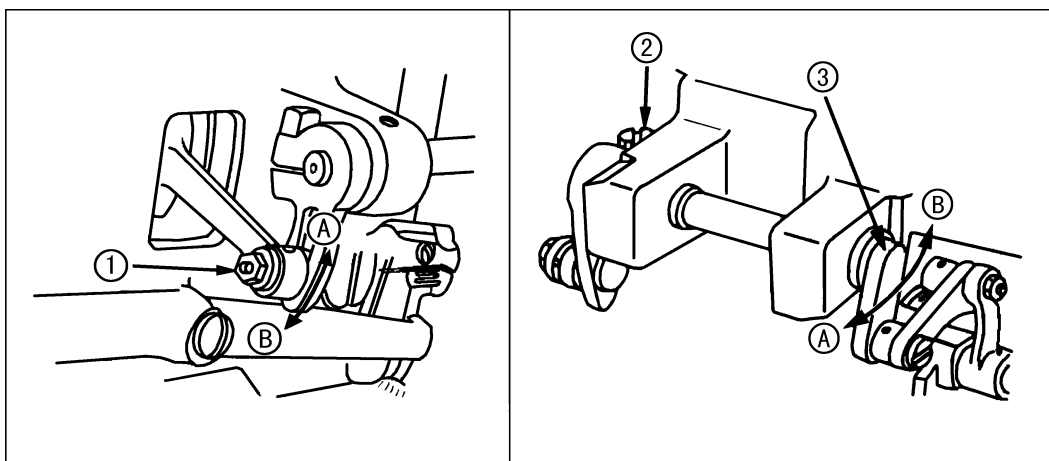
Highest position---The stroke is maximized. "A"

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.

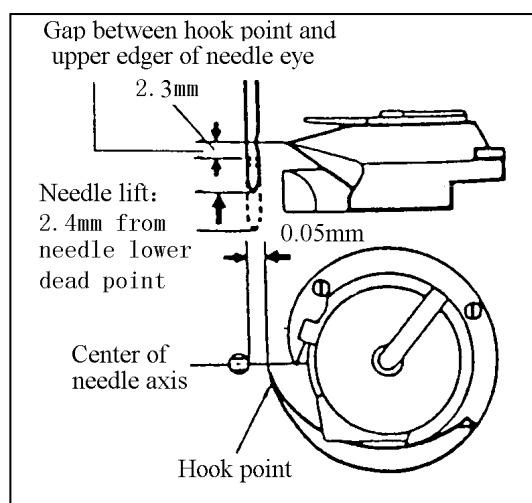


12. Timing between rotating hook motion and needle motion

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.

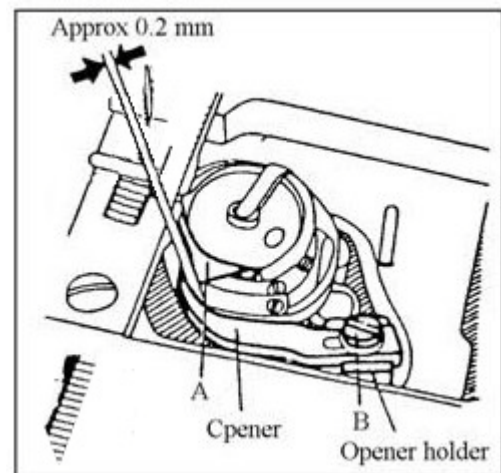
- The upper edge of needle eye should be 2.3 mm below the hook point.
- The hook point should be located at the center of needle axis.
- Gap between the hook point and the side face of needle should be 0.05mm.



13. Relationship between hook motion and opener motion

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.



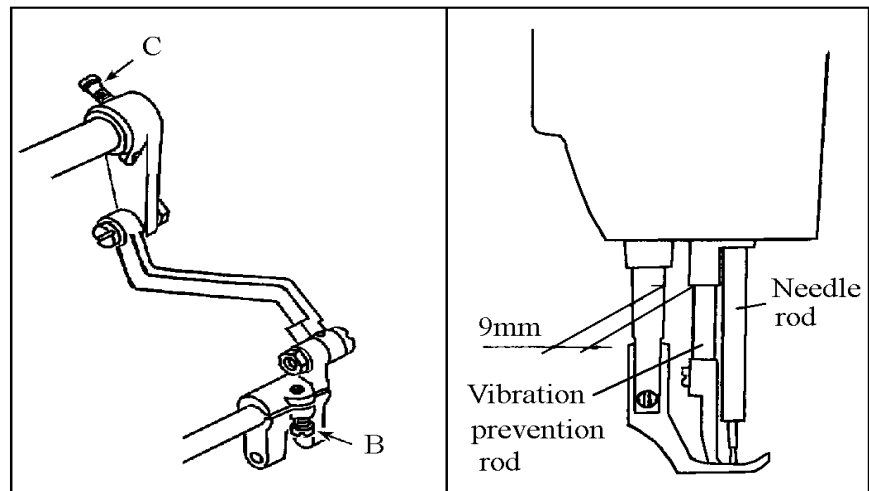
14. Relationship between needle motion and

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.

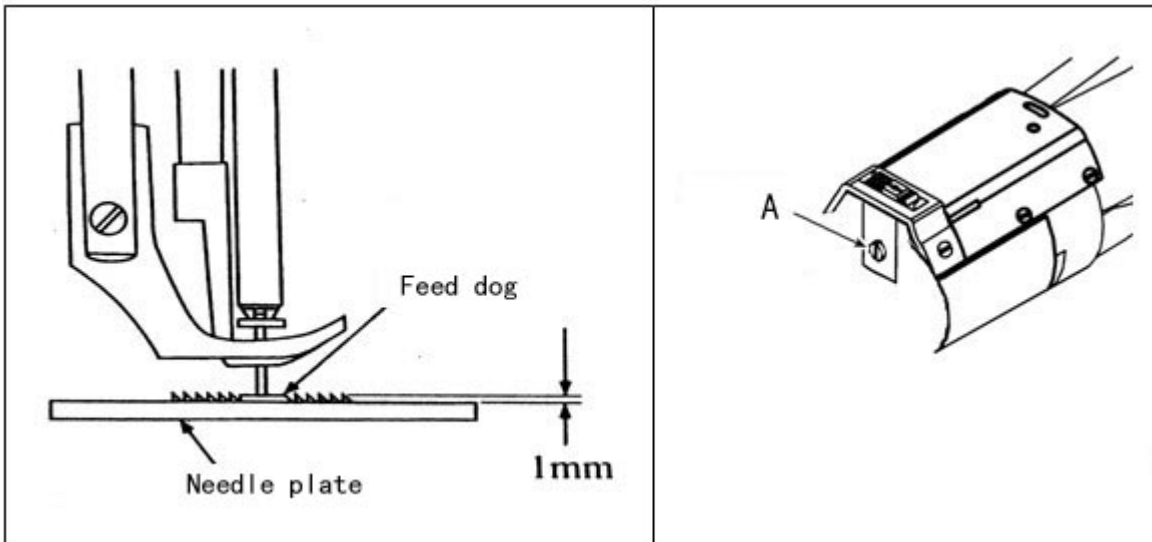


15. Adjusting the height of the feed dog

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 its highest position.
- 3) Loosen the screw "A", adjust the height of the feed dog.
- 4) Tighten the screw "A" after adjustment.



16.Safety mechanism

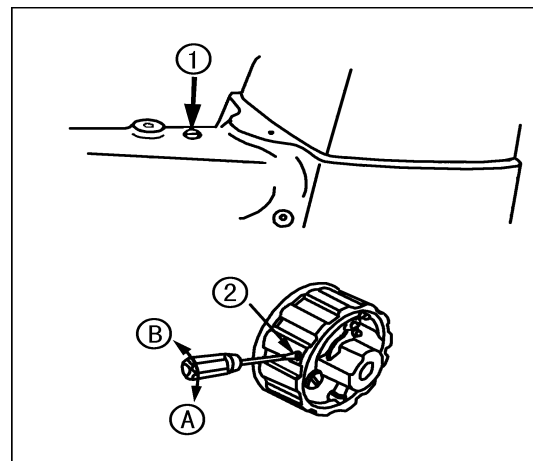
If the thread is caught in the hook while the sewing machine is in operation, the safety mechanism actuates to idle the lower sprocket only if the thread is caught in the hook while the sewing machine is in operation, the safety mechanism actuates to idle the lower sprocket only.

1) How to reset

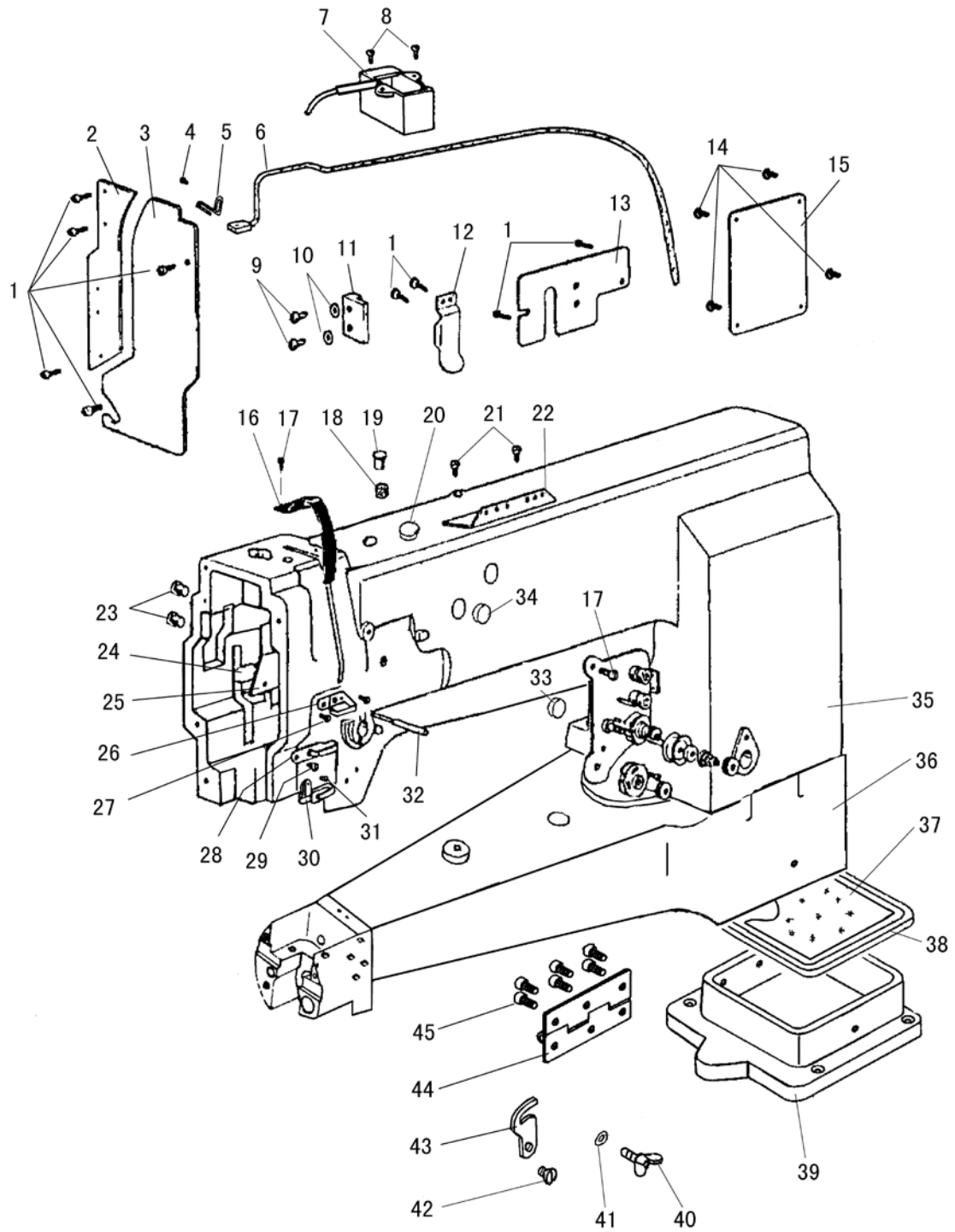
- Remove the thread caught in the hook
- Pressing push button ①, strongly turn the pulley in the direction opposite to its normal rotational direction.

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.



A. ARM BED AND ITS ACCESSORIES



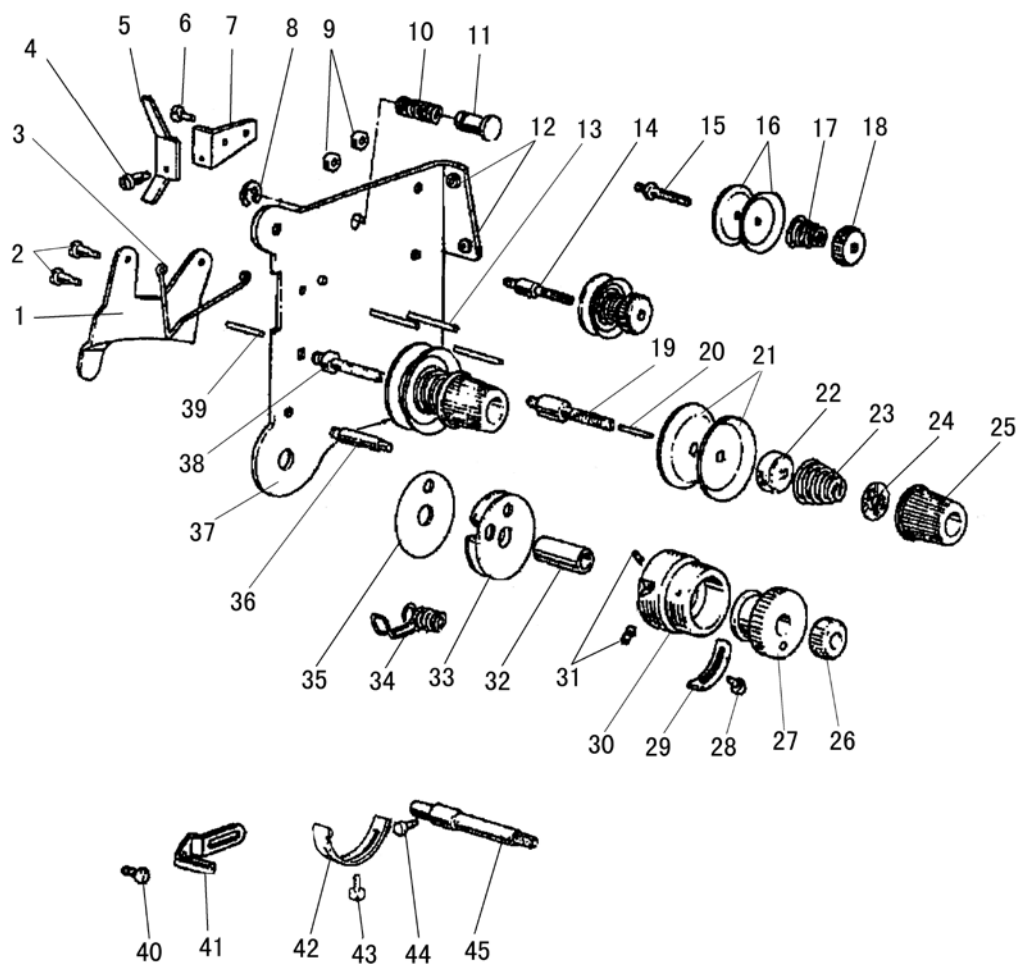
A. ARM BED AND ITS ACCESSORIES

Pig. No.	Part No.	Description	GC2268-1B	Remarks
A01	HA300B2170	Face plate screw	9	SM11/64(40) × 9
A02	H4730B8001	Guide mounting plate	1	
A03	H4727B8001	Face plate	1	
A04	HA300C2030	Screw	1	SM11/64(40) × 8
A05	H4731J8001	Holder	1	
A06	H4711J7101	Oil pipe	1	
A07	HH61B17101	Oil pipe	1	
A08	H411040160	Screw	2	
A09	HA100E2150	Screw	2	SM11/64(40) × 10
A10	H4722E8001	Washer	2	
A11	H4721E8001	Guide for slide block	1	
A12	H4716B8001	Oil guard plate	1	
A13	H4718B8001	Arm side cover	1	
A14	HA300B2170	Face plate screw	4	SM11/64(40) × 9
A15	H4719B8001	Arm side cover	1	
A16	H4717B8001	Thread take-up guard	1	
A17	HA300C2030	Screw	2	SM11/64(40) × 8
A18	H32175B304	Felt	1	
A19	H4715B8001	Oil cup	1	φ 13
A20	H4735B8001	Oil cup	1	φ 22
A21	HA700B2060	Screw	2	SM11/64(40) × 8
A22	H2400B2100	Thread guide	1	
A23	HA300B2090	Oil cup	2	φ 8.8
A24	H2400B2060	Oil guard plate block	1	
A25	H3200B2060	Oil guard	1	
A26	H2400B2070	Thread guide	1	
A27	H2400B2080	Screw	2	SM3/16(28) × 13
A28	H4726B8001	Thread guide	1	
A29	H3000D2160	Screw	1	SM9/64(40) × 6.5
A30	H3212B0066	Thread guide	1	
A31	H3200B2100	Screw	1	SM9/64(40) × 6.5
A32	H4769E8001	Tension releasing pin	1	
A33	H4736B8001	Oil cup	1	φ 15
A34	HA307B0673	Oil cup	1	φ 19
A35	HH60B68001	Arm	1	
A36	HH60B78001	Arm bed	1	
A37	HH60B98001	Felt	1	
A38	HH60B88001	Oil reservoir	1	
A39	H4107B0672	Supporter	1	

A. ARM BED AND ITS ACCESSORIES

Fig. No.	Part No.	Description	GC2268-1B	Remarks
A40	HE107I8001	Screw	1	M6
A41	H4100B2090	Washer	1	
A42	H4100B2070	Screw	1	SM1/4 (24) × 9.8
A43	H4100B2060	Link plate	1	
A44	H4100B2100	Hinge	1	
A45	H4100B2110	Hinge screw	6	SM1/4 (24) × 9.8

B. THREAD TENSION REGULATOR MECHINISM



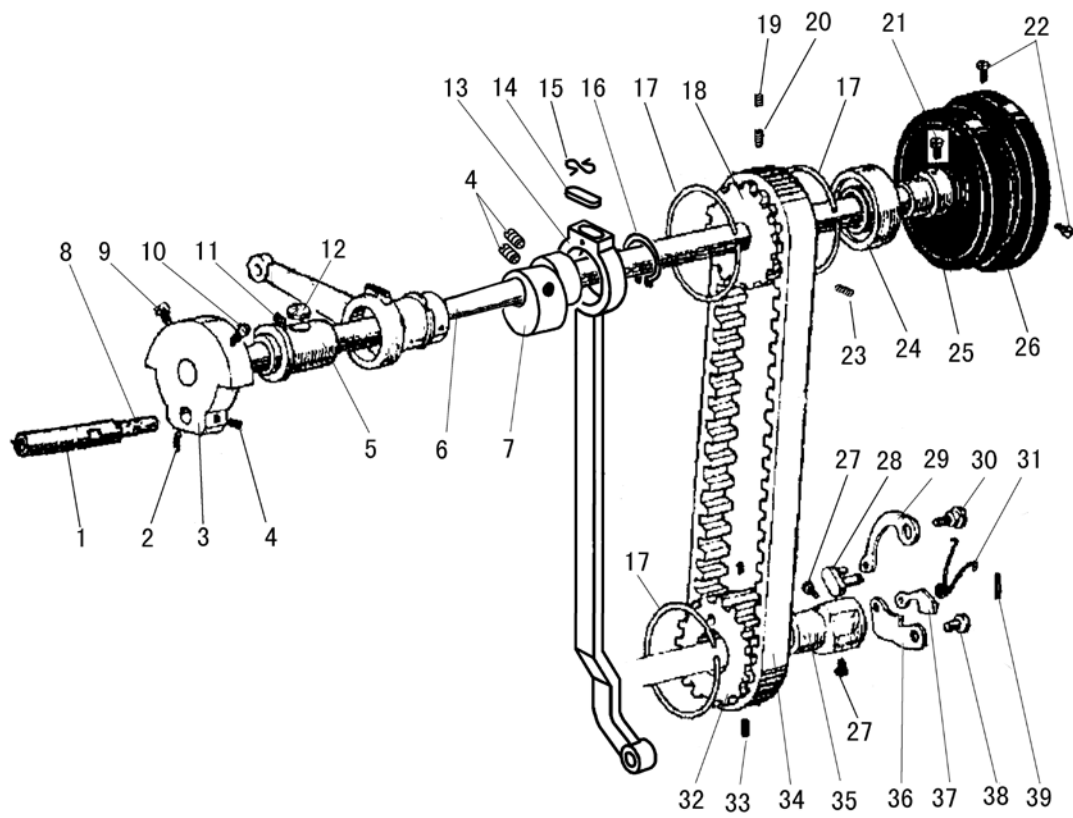
B. THREAD TENSION REGULATOR MECHINISM

Pig. No.	Part No.	Description	2618-1B	Remarks
B01	H3221B3142	Tension releasing plate	1	
B02	H3221B6811	Screw	2	SM9/64 (40) × 3
B03	H3221B6812	Tension releasing spring	1	
B04	H4705C8001	Screw	1	
B05	H4706C8001	Lever	1	
B06	HA7311C306	Screw	1	SM9/64 (40) × 7
B07	H4707C8001	Mounting plate	1	
B08	H007013050	Stop ring	1	
B09	H3221B6810	Nut	2	
B10	H4708C8001	Spring	1	
B11	H4709C8001	Push button	1	
B12	H3221B0681	Porcelain cluct	2	
B13	H3221B0682	Pin	3	
B14	H3221B0685	Thread tension stud	1	
B15	H3221B0683	Thread tension stud	1	
B16	HA112B0693	Thread tension disc	4	
B17	H3221B0684	Spring	2	
B18	HA710B0671	Thumb nut	2	SM11/64 (40) × 6
B19	H3221B0689	Thread tension stud	1	
B20	H3221B6816	Pin	1	
B21	HA310B0705	Thread tension disc	4	
B22	HA310B0702	Thread tension releasing disc	2	
B23	H4710C8001	Spring	2	
B24	HA115B7010	Thumb nut complete	2	
B25	HA310B0701	Thumb nut revolution stopper	2	
B26	H32481B721	Thumb nut	1	SM1/4 (40) × 4.5
B27	H32481B621	Take-up spring guard	1	
B28	H32481BC21	Screw	1	SM9/64 (40) × 6
B29	H32481BB21	Stopper	1	
B30	H32481B921	Thread tension post	1	
B31	H32481B521	Screw	2	SM11/64 (40) × 10
B32	H32481B821	Bush	1	
B33	H32481BF21	Plate complete	1	
B34	H4712C8001	Thread take-up spring	1	
B35	H32481BE21	Plate	1	
B36	H32481B421	Screw	1	
B37	H3221B6820	Mounting plate	1	
B38	H3221B0686	Thread tension stud	1	
B39	H3221B6817	Pin	1	
B40	HA106B0676	Screw	1	SM9/64 (40) × 6
B41	H3306B0661	Oil check window	1	

B. ARM BED AND ITS ACCESSORIES

Fig. No.	Part No.	Description	2618-1B	Remarks
B42	H3221B6819	Stopper	1	
B43	H3200B2100	Screw	1	SM9/64(40) × 6.5
B44	H3230K0751	Screw	1	SM11/64(40) × 10
B45	H32481B121	Thread tension stud	1	

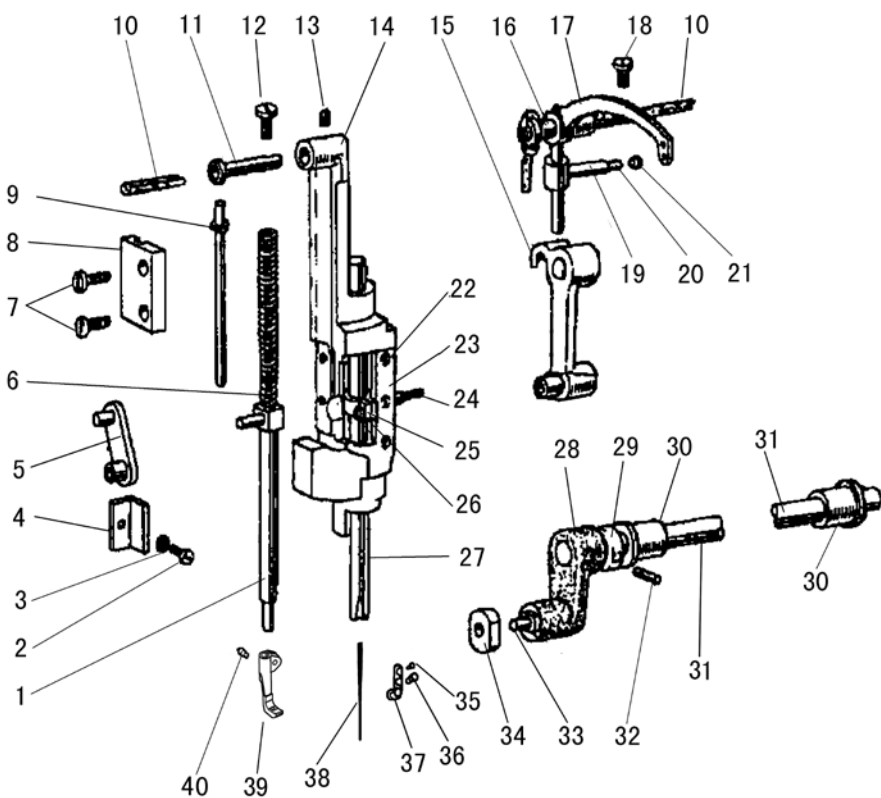
C. ARM SHAFT MECHANISM



C. ARM SHAFT MECHANISM

Pig. No.	Part No.	Description	2618-1B	Remarks
C01	H2405D0662	Hinge pin	1	
C02	HA105D0662	Screw	1	SM1/4(40) × 4
C03	H4706D8001	Needle bar crank	1	
C04	HA307C0662	Screw	3	SM1/4(40) × 6
C05	H32111B204	Arm shaft bushing (left)	1	
C06	HH61C08001	Arm shaft	1	
C07	H5332C8001	Feed cam (right)	1	
C08	H4716F8001	Oil wick	1	
C09	HA100C2060	Screw	1	SM9/32(28) × 13
C10	HA100C2070	Screw	1	SM9/32(28) × 14
C11	H2405D0664	Screw	1	SM15/64(28) × 14
C12	H32111B104	Felt	1	
C13	HH60C58001	Connecting rod for upper feed	1	
C14	H20111C106	Holder	1	
C15	H5330C8001	Felt	1	
C16	H007009260	Stop ring	1	
C17	H3205C0661	Spring stop ring	3	
C18	HH60C78001	Pulley	1	
C19	HE030C8001	Screw	1	SM17/64(24) × 6.5
C20	HE029C8001	Screw	1	SM17/64(24) × 14.5
C21	HA113F0684	Screw	2	SM15/64(28) × 8.5
C22	HA110D0672	Screw	2	SM15/64(28) × 12
C23	HE028C8001	Screw	1	SM17/64(24) × 20
C24	H3205J0662	Needle bearing	1	
C25	H3205J0661	Arm shaft collar	1	
C26	H4100C2040	Balance wheel	1	
C27	HE022G8001	Screw	2	SM1/4(32) × 10.5
C28	HE027G8001	Pin	1	
C29	HE023G8001	Long lever for pulley	1	
C30	HE024G8001	Pin	1	
C31	HE026G8001	Spring for pulley	1	
C32	HE019G8001	Pulley	1	
C33	HE028E8001	Screw	2	SM7/32(32) × 7
C34	HE109C8001	Cog belt	1	
C35	HE021G8001	Shaft for pulley	1	
C36	H4719D8001	Short lever for pulley	1	
C37	HE031G8001	Lever for pulley	1	
C38	HE029G8001	Pin	1	
C39	H601012100	Pin	1	

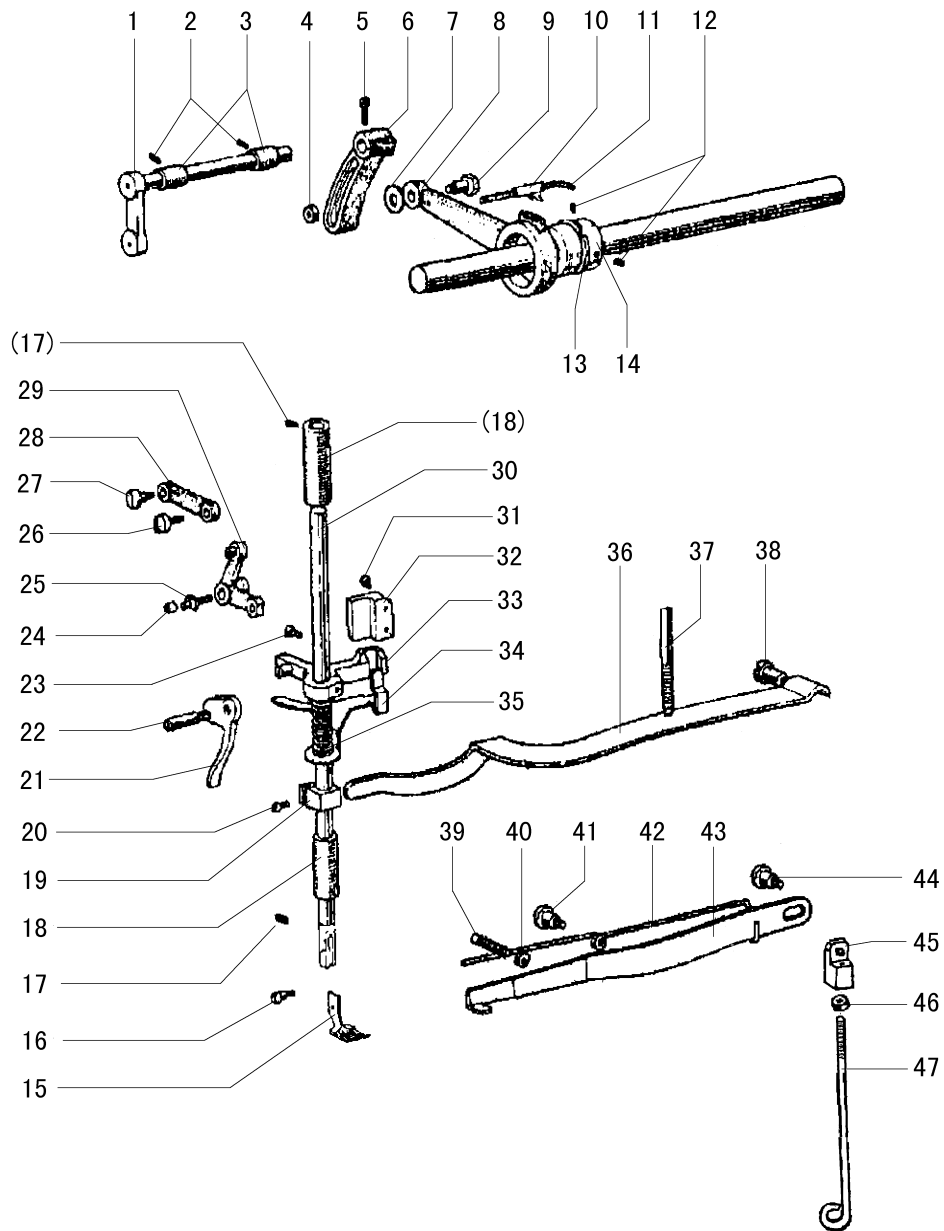
D. NEEDLE BAR & THREAD TAKE-UP LEVER MECHANISM



D. NEEDLE BAR & THREAD TAKE-UP LEVER MECHANISM

Fig. No.	Part No.	Description	2618-1B	Remarks
D01	H4725F8001	Presser bar	1	
D02	H3400C2020	Screw	1	
D03	H3200I2030	Washer	1	
D04	H3400C2010	Needle bar guide	1	
D05	H4726F8001	Presser bar connecting link	1	
D06	H4729F8001	Spring	1	
D07	H4753E8001	Screw	2	SM11/64 (40) × 17.5
D08	H4728F8001	Guide for slide block	1	
D09	H4730F8001	Vibrating presser bar extension	1	
D10	H2405D1122	Oil wick	2	
D11	H4706F8001	Pin	1	
D12	H4707F8001	Screw	1	
D13	HA3411B308	Screw	1	SM15/64 (28) × 7
D14	H4719F8001	Needle bar rock frame	1	
D15	H4717F8001	Needle bar connecting link	1	
D16	H2405D1121	Pin	1	
D17	H4712F8001	Thread take-up lever	1	
D18	HA110D0672	Screw	1	SM15/64 (28) × 12
D19	H2405D1112	Thread take-up link	1	
D20	H24211D405	Oil wick	1	
D21	H24211D305	Oil wick	1	
D22	H32111D304	Screw	6	SM3/32 (56) × 4
D23	H4721F8001	Washer	2	
D24	H3204D6513	Felt	1	
D25	H4722F8001	Needle bar connecting stud	1	
D26	H32111D604	Screw	1	SM9/64 (40) × 8.5
D27	H4724F8001	Needle bar	1	
D28	H3406C0672	Crank	1	
D29	H4734F8001	Washer	1	
D30	H3204B0652	Needle bar rock shaft bushing	2	
D31	H4736F8001	Needle bar rock shaft	1	
D32	H602040240	Pin	1	
D33	H3406C0671	Screw	1	SM15/64 (28) × 10
D34	H4759F8001	Square block	1	
D35	H32132D104	Screw	2	SM9/64 (40) × 3
D36	HA100C2170	Screw	1	SM9/64 (40) × 3
D37	H4739F8001	Needle bar connecting stud	1	
D38	JZDP1700G2302	Needle	1	DP × 17 23#
D39	H4737F8001	Vibrating Presser foot	1	
D40	HA700F2100	Screw	1	SM11/64 (40) × 7

E. PREAER FOOT MECHANISM



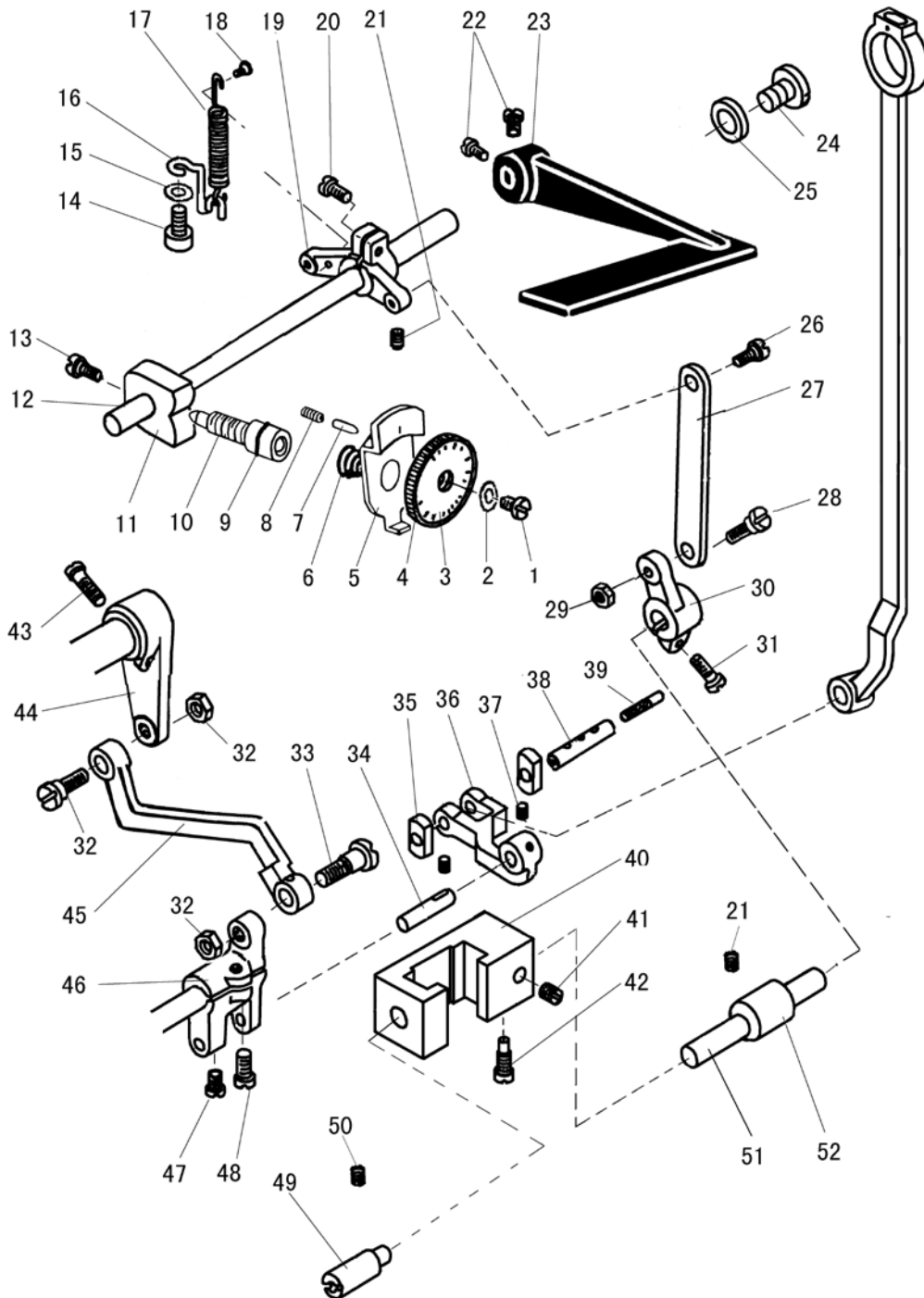
E. PREAER FOOT MECHANISM

Pig. No.	Part No.	Description	2618-1B	Remarks
E01	H4705E8001	Feed lifting rock shaft	1	
E02	H4706E8001	Screw	2	SM1/4(24) × 7
E03	H4707E8001	Bushing	2	
E04	H0030550608	Thumb nut	1	M6 × 0. 75
E05	H3115F0671	Screw	1	SM1/4(28) × 16
E06	H4709E8001	Regulating crank	1	
E07	H2013J0065	Washer	1	
E08	H2014J0066	Connecting rod	1	
E09	H2000J2100	Screw	1	M6 × 0. 75
E10	H20111C106	Felt clip	1	
E11	H4713E8001	Oil wick	1	
E12	HA307C0662	Screw	2	SM1/4(40) × 6
E13	H007009250	Stop ring	1	
E14	H4714E8001	Eccentric	1	
E15	H4757E8001	Lifting Presser foot	1	
E16	H3200E2020	Screw	1	SM1/8(44) × 4
E17	H4708D8001	Screw	2	SM1/4(24) × 13
E18	H4744E8001	Bushing for presser bar	2	
E19	H4746E8001	Presser bar spring bracket	1	
E20	H2404I0034	Screw	1	SM9/64(40) × 8. 5
E21	H4748E8001	Presser bar lifter	1	
E22	H4749E8001	Screw	1	SM11/64(40) × 8. 5
E23	H4753E8001	Screw	1	SM11/64(40) × 17. 5
E24	H4717E8001	Roller	1	
E25	H2004J0655	Support shaft	1	
E26	H4718E8001	Screw	1	SM11/64(32) × 6
E27	H2004J0662	Screw	1	SM1/4(40) × 5
E28	H4719E8001	Link	1	
E29	H4715E8001	Bell crank	1	
E30	H4754E8001	Presser bar	1	
E31	HA111G0683	Screw	2	SM11/64(40) × 12
E32	H4723E8001	Guide	1	
E33	H4752E8001	Presser bar lifting bracket	1	
E34	H4768E8001	Thread releasing plate	1	
E35	H4767E8001	Spring	1	
E36	H4730E8001	Presser bar spring	1	
E37	H4729E8001	Screw	1	
E38	H3100G2170	Screw	1	SM1/4(24) × 11
E39	H4725E8001	Screw	1	SM1/4(24) × 19
E40	H4726E8001	Nut	1	
E41	H3100G2130	Screw	1	SM1/4(24) × 7

E. PREAER FOOT MECHANISM

Fig. No.	Part No.	Description	2618-1B	Remarks
E42	H4727E8001	Spring	1	
E43	HH60E48001	Knee lifter lever	1	
E44	H2000I2140	Screw	1	
E45	H2000I2150	Knee lifter lever joint	1	
E46	H2000I2160	Nut	1	SM3/16 (32)
E47	HH60E58001	Knee lifter rod	1	

F. STITCH REGULATOR MECHANISM



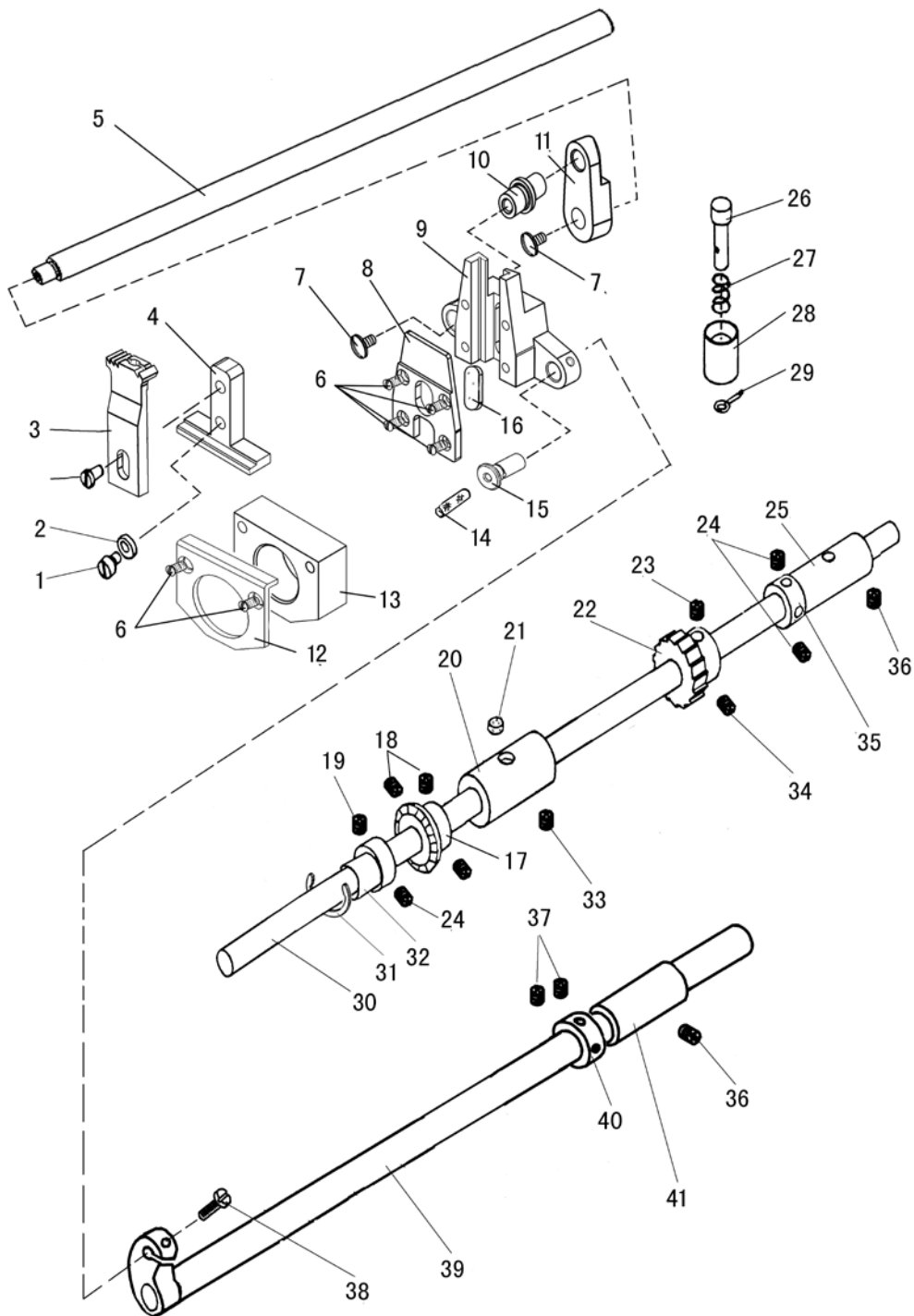
F. STITCH REGULATOR MECHANISM

Pig. No.	Part No.	Description	2618-1B	Remarks
F01	HA720F0686	Screw	1	SM3/16 (28) × 12
F02	HA720F0685	Bushing	1	
F03	H5341H8001	Plate for stitch length	1	
F04	HA7421F120	Dial	1	
F05	HA720F0683	Stopper pin releasing lever	1	
F06	HA720F0687	Coil spring	1	
F07	HA700F2030	Stopper pin	1	
F08	HA100F2090	Spring for stopper pin	1	
F09	HA109F0674	Seal	1	14 × 2. 4
F10	HA720F0681	Screw bar	1	
F11	HH61F18001	Feed regulator crank	1	
F12	HH61F28001	Feed reversing lever shaft	1	
F13	HA104F0654	Screw	1	SM15/64 (28) × 10
F14	HA100H2150	Screw	1	SM9/64 (40) × 11
F15	H005004050	Washer	1	
F16	H5330H8001	Spring retainer	1	
F17	HG207G8001	Spring	1	
F18	H5329H8001	Screw	1	SM9/64 (40) × 4
F19	H5327H8001	Feed reversing lever shaft crank	1	
F20	H5343H8001	Screw	2	SM3/16 (32) × 16
F21	HA3411D308	Set screw	2	SM15/64 (28) × 7
F22	HA113F0684	Set screw	2	SM15/64 (28) × 8. 5
F23	HH61F38001	Feed reversing lever	1	
F24	HA113F0683	Screw	1	SM3/16 (28) × 6. 5
F25	HA100F2110	Washer	1	
F26	H5333H8001	Screw	1	SM3/16 (32) × 8. 5
F27	HH60F98001	Link lever	1	
F28	H5324H8001	Screw	1	SM3/16 (32) × 13. 5
F29	H5325H8001	Nut	1	SM3/16 (32) × 3. 6
F30	H5322H8001	Reverse block shaft crank	1	
F31	HA104G0012	Screw	1	SM3/16 (28) × 12
F32	H2010J0066	Nut	2	SM9/32 (28) × 3. 6
F33	H5317H8001	Screw	2	SM9/32 (28) × 13. 3
F34	H5315H8001	Crank shaft	1	
F35	H5309H8001	Slide block	2	
F36	H5313H8001	Link lever	1	
F37	HA711B0681	Screw	2	SM9/64 (40) × 4. 5
F38	H5311H8001	Shaft for reversing block slide block	1	
F39	H5312H8001	Oil wick	1	
F40	H5305H8001	Reverse block	1	
F41	HA300B2080	Set screw	1	SM15/64 (28) × 6. 5

F. STITCH REGULATOR MECHANISM

Pig. No.	Part No.	Description	2618-1B	Remarks
F42	HA100F2130	Screw	1	SM15/64(28) × 5
F43	H5320H8001	Screw	1	SM15/64(28) × 23.5
F44	HH60F78001	Link lever	1	
F45	HH60F68001	Link lever	1	
F46	H5314H8001	Crank	1	
F47	HA700F2100	Screw	1	SM11/64(40) × 7
F48	HA800F2020	Screw	1	SM15/64(28) × 13.5
F49	H5308H8001	Reverse block shaft	1	
F50	HA100C2020	Set screw	1	SM15/64(28) × 10
F51	H5306H8001	Reverse block shaft	1	
F52	H5307H8001	Bushing for reverse block shaft	1	

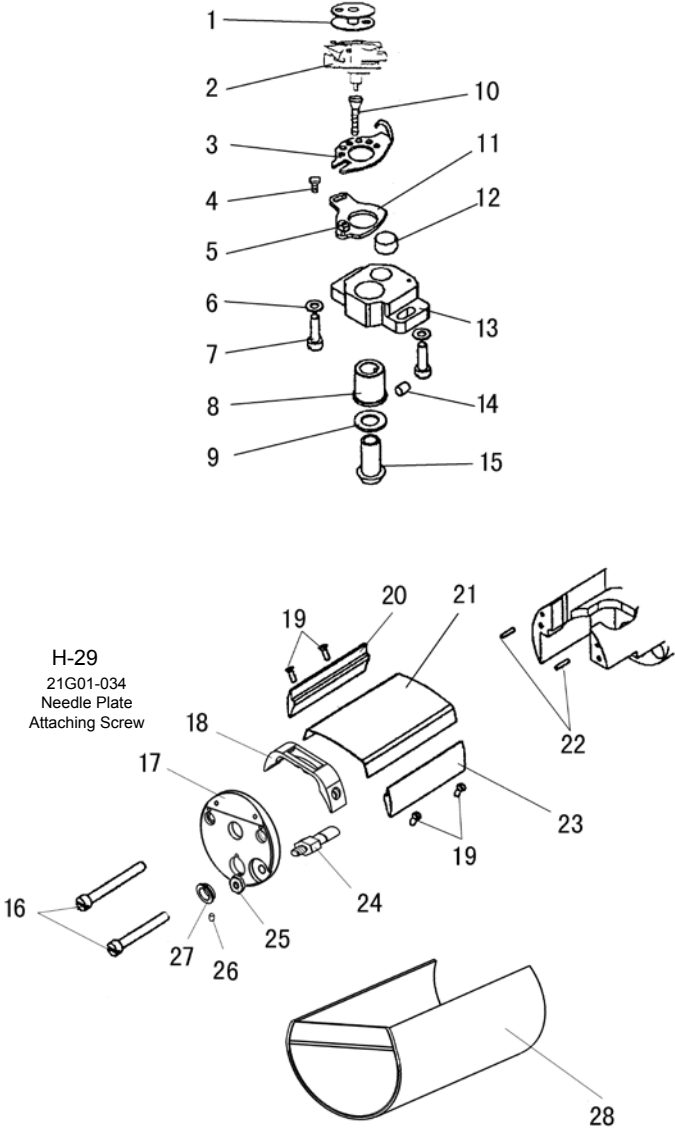
G. FEEDING AND FEED LIFTING & ROTATING HOOK SHAFT MECHANISM



G. FEEDING AND FEED LIFTING & ROTATING HOOK SHAFT MECHANISM

Fig. No.	Part No.	Description	2618-1B	Remarks
G01	H4967K8001	Screw	2	SM11/64 (40) × 7. 2
G02	HBG6260081	Washer	1	
G03	HBG6264081	Feed dog	1	
G04	HBG6255081	Slide	1	
G05	HBG6261081	Shaft	1	
G06	HBG7256081	Screw	4	SM9/64 (3. 57) × 40
G07	HA7311C306	Screw	2	SM9/64 (3. 57) × 40
G08	HBG6256081	Feed rocker shaft crank plate	1	
G09	HBG6253081	Feed rocker shaft crank	1	
G10	HBG6253081	Pin	1	
G11	HBG6263081	Link	1	
G12	HBG6258081	Plate	1	
G13	HBG6259081	Feed eccentric bracket	1	
G14	HE117E8001	Oil wick	1	
G15	HE117E8001	Pin	1	
G16	HBG6254081	Felt	1	
G17	HE110D8001	Bevel gear for hook shaft	1	
G18	HG214G8001	Set screw	3	SM1/4 (40)
G19	HE105C8001	Set screw	1	SM13/64 (32) × 4. 7
G20	HE111D8001	Rotating hook shaft bushing (left)	1	
G21	HE112D8001	Felt	1	
G22	HE106D8001	Recessed wheel	1	
G23	HE043C8001	Set screw	1	SM1/4 (28) × 6. 5
G24	HE013H8001	Screw	3	SM13/64 (32) × 4. 3
G25	HE113D8001	Bushing	1	
G26	HE109D8001	Safe clutch shaft	1	SM1/4 (28) × 6. 5
G27	H4107D0672	Safe clutch spring	1	SM13/64 (32) × 3. 5
G28	HE108D8001	Safe clutch bushing	1	
G29	H601016100	Safe clutch shaft pin	1	
G30	HBG6265081	Rotating hook shaft	1	
G31	HE108D8001	C type ring	1	
G32	HE104C8001	Feed eccentric	1	
G33	HE013C8001	Screw	1	SM17/64 (24) × 6. 5
G34	HE107D8001	Screw	1	SM1/4 (28) × 6
G35	HE105D8001	Rotating hook shaft collar	2	
G36	HE034G8001	Screw	2	SM1/4 (32) × 7
G37	HE121E8001	Set screw	2	SM13/64 (32) × 5
G38	HE119E8001	Screw	1	SM5/32 (40) × 9
G39	HE118E7101	Feed rocker shaft	1	
G40	HE105D8001	Rotating hook shaft collar	2	
G41	HE113D8001	Bushing	1	SM5/32 (40) × 9

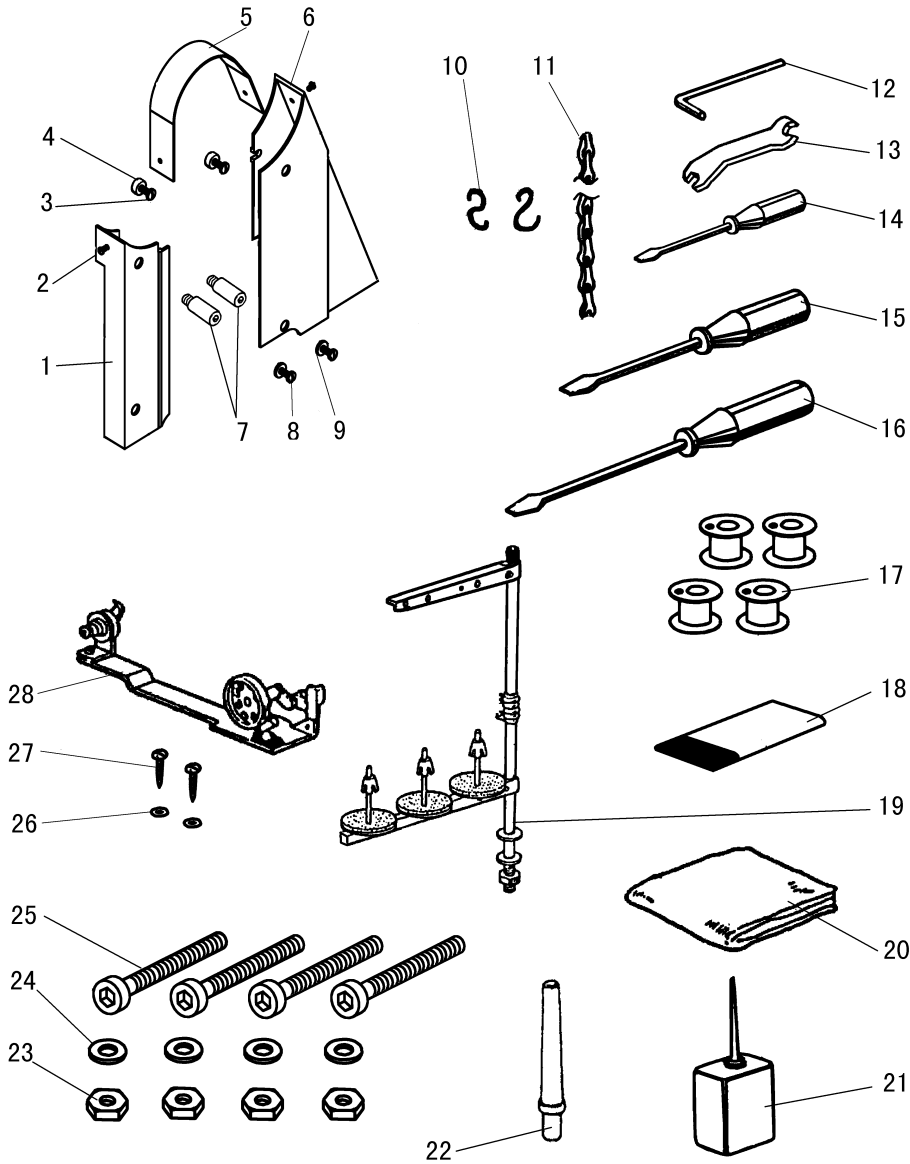
H. HOOK SADDLE MECHANISM



H. HOOK SADDLE MECHANISM

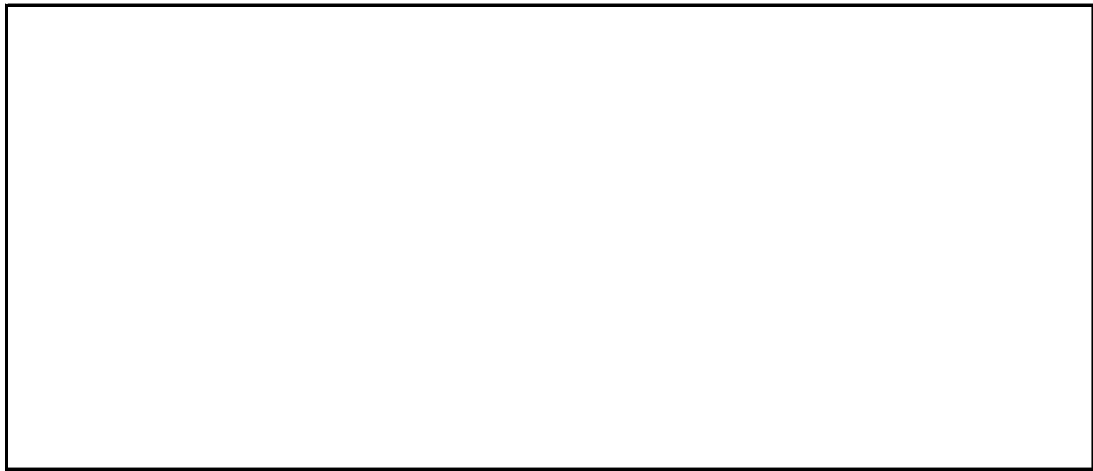
Pig. No.	Part No.	Description	2618-1B	Remarks
H01	HD806I8001	Bobbin	1	
H02	HH60H67101	Rotating hook	1	
H03	HE117B8001	Rotating position guide	1	
H04	HE046C8001	Screw	1	SM0. 1339 (36) × 6
H05	HE116B8001	Guide plate slide block	1	
H06	HE121B8001	Washer	1	
H07	HE120B8001	Screw	1	SM13/64 (32) × 16. 5
H08	HE125B8001	Bushing	1	
H09	HE124B8001	Washer	1	
H10	H2404I0652	Screw	1	SM9/64 (40)
H11	HE127B7101	Guide plate	1	
H12	HE126B8001	Felt	1	
H13	HE147B8001	Rotating hook bracket	1	
H14	HE028E8001	Screw	1	SM7/32 (32) × 7
H15	HE123B8001	Bevel	1	
H16	HE213B8001	Screw	2	SM13/64 (32) × 10. 5
H17	HBH6253081	Stop plate	1	
H18	HE136B8001	Needle plate	1	
H19	HE130B8001	Screw	4	SM0. 1339 (36) × 8. 2
H20	HE140B8001	Back guide plate (left)	1	
H21	HE138B7101	Back slide plate	1	
H22	HE142B8001	Connecting plate	2	
H23	HE141B8001	Back guide plate (right)	1	
H24	HBH6256081	Pin	1	
H25	H4100E2070	Nut	1	SM7/32 × 32
H26	HE219B8001	Felt	1	
H27	HBH6254081	Bushing	1	
H28	HE146B8001	Slide plate	1	
H29	21G01-034	Needle Plate Attaching Screw	2	

I. ACCESSORIES



I. ACCESSORIES

Pig. No.	Part No.	Description	2618-1B	Remarks
I01	HH60I68001	Belt cover (left)	1	
I02	H200000360	Screw	2	SM11/64 (40) × 6
I03	H0207L8001	Screw	2	SM15/64 (28) × 18
I04	H6760B8001	Washer	2	
I05	H6307L8001	Belt cover (upper)	1	
I06	HH60I78001	Belt cover (right)	1	
I07	HH60I88001	Screw	2	SM15/64 (28)
I08	HN720J8001	Screw	2	SM15/64 (28) × 10
I09	H005006060	Washer	2	
I10	H8000H2070	Pothook	2	
I11	HPG100E203	Chain	1	
I12	HB00001060	Socket wrench	1	
I13	HE105I8001	Spanner	1	
I14	HA300J2210	Screw driver (small)	1	
I15	HA300J2200	Screw driver (middle)	1	
I16	HA300J2070	Screw driver (larger)	1	
I17	HD806I8001	Bobbin	4	
I18	JZDP1700G2302	Needle	6	DP × 17 23#
I19	H3200L0120	Thread stand assay	1	
I20	HA100J2180	Cover	1	
I21	H200400069	Oil tank	1	
I22	H6620J8001	Head rest bar	1	
I23	H003002080	Nut	4	
I24	H005001080	Washer	4	
I25	H403080750	Screw	4	
I26	HA300J2230	Washer	2	
I27	H801045200	Wood screw	2	
I28	H3300L0040	Bobbin winder assay	1	



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

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