



# TYPICAL

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## **GC6220** **GC6240** MD/BD SERIES

TWO-NEEDLE BAR DIRECT DRIVE  
LOCKSTITCH SEWING MACHINE

INSTRUCTION BOOK  
PARTS CATALOGUE

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XI'AN TYPICAL INDUSTRIES CO.,LTD.

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

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


## SAFETY INSTRUCTIONS

### 1. Safety indications and their meanings

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

The meanings of these indications and symbols are given below.

#### Indications

 <b>CAUTION</b>	The instructions which follow this term indicate situations where failure to follow the instructions could cause injury when using the machine or physical damage to equipment and surroundings.
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#### Symbols



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



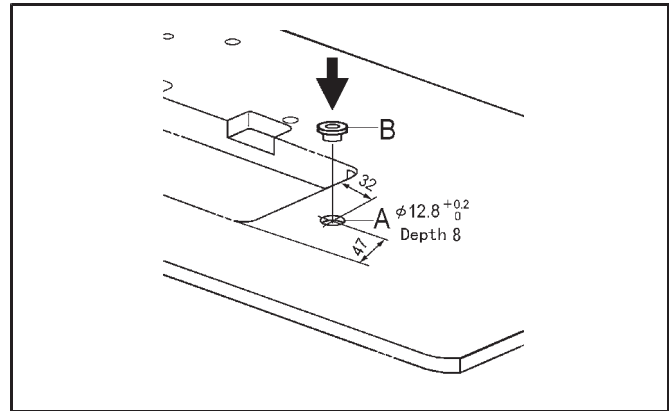
..... This symbol (⊘) indicates something that you must not do.



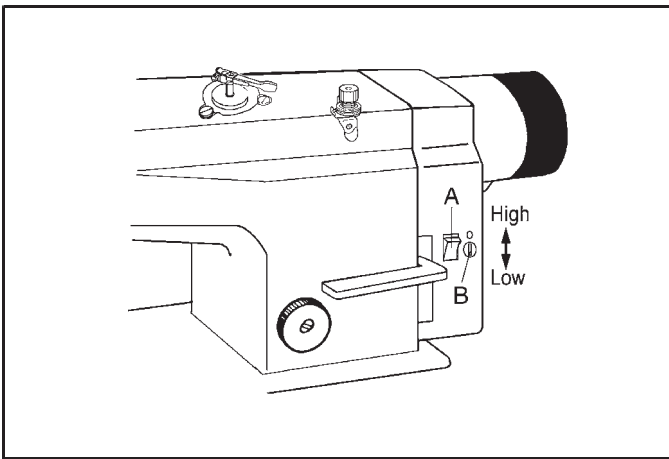
..... This symbol (●) indicates something that you must do. The picture inside the circle indicates the nature of the thing that must be done.  
(For example, the symbol at left means "you must make the ground connection".)

## 1. INSTALL THE MAGNET

For safety, pedal should be no response when machine overturned. To realize it, a magnet with rubber cover installed into hole A. Note that S-poles must be upward.

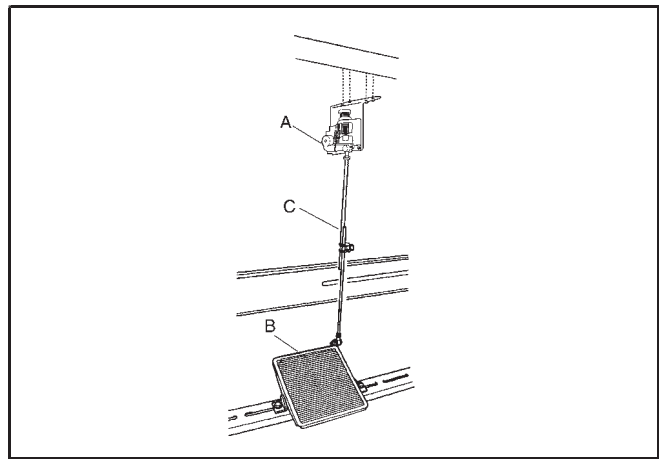


## 2. MAXIMUM SPEED ADJUSTMENT



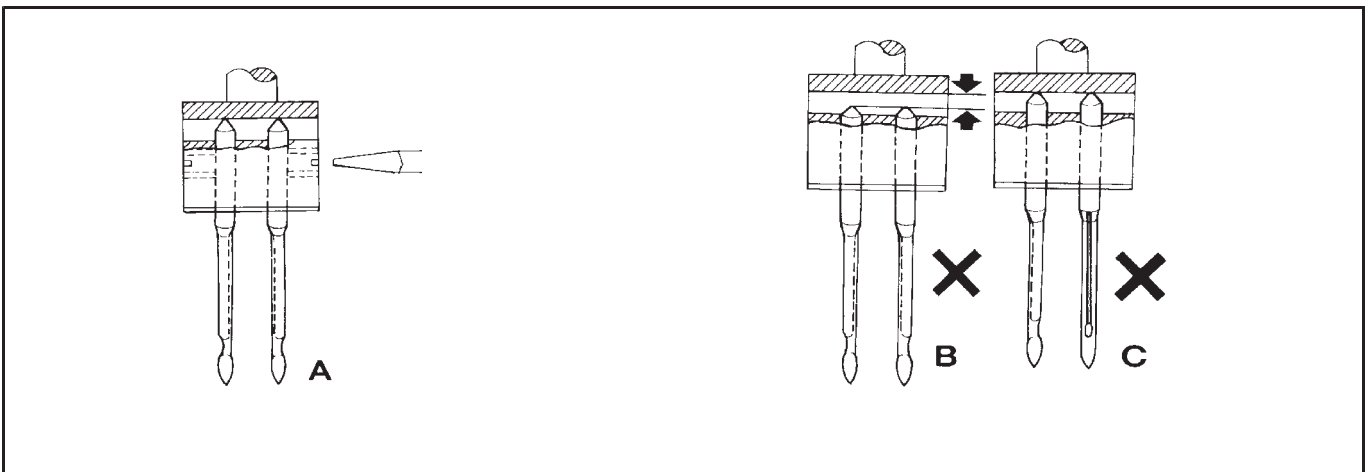
Push switch A, lighting lamp indicate power on. Turn the knob B to adjust the maximum speed, upwards to high and downwards to low.

## 3. CONNECTION OF THE CLUTCH LEVER WITH THE PEDAL



- (1) Install speed governor A, link speed governor A and pedal B with tie bar, keep tie bar C vertical.
- (2) The optimum tilt angle of pedal is approximately 15 deg.

## 4. NEEDLE INSTALLTION



Turn the balance wheel to lift needle bar to the highest position, loosen Needle Set Screw, fully insert the needle shank upto the bottom of needles opposite with each other, then tighten Screw.

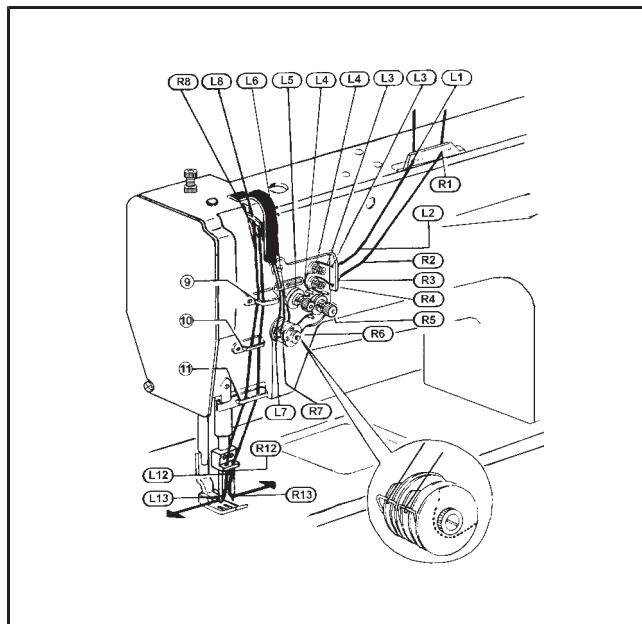
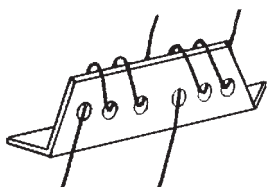
## 5.THREADING

As threading needle thread, needle bar should be raised to its highest position,. Then draw the thread end from thread spool and thread it in the order shown in the finger.

Note: L: Threading order of left needle

R: Threading order of right needle

When use more elastical thead,please threading as Fig.



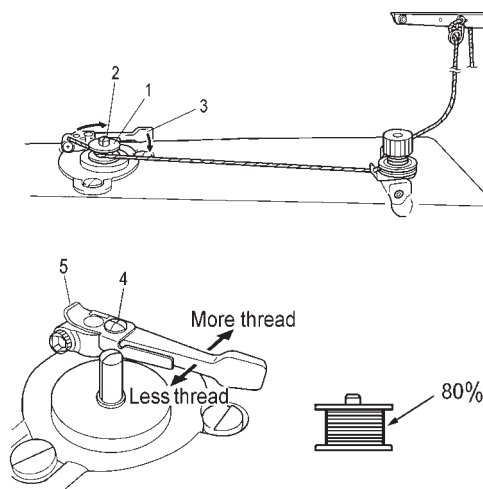
## 6. WINDING THE LOWER THREAD

1. Turn on the power switch.
2. Place the bobbin (1) onto the bobbin winder shaft(2).
3. Wind the thread several times around the bobbin(1) in the direction indicated by the arrow.
4. Push the bobbin presser arm(3) toward the bobbin (1).
5. Raise the presser foot with the lifting lever .
6. Depress the treadle. Lower thread winding will then start.
7. Once winding of the lower thread is completed, the bobbin presser arm (3) will return automatically.
8. After the thread has been wound on ,remove the bobbin and cut the thread with the knife(5).

\* Loosen the screw (4) and mover the knife (5) to adjust the amount of thread wound onto the bobbin.

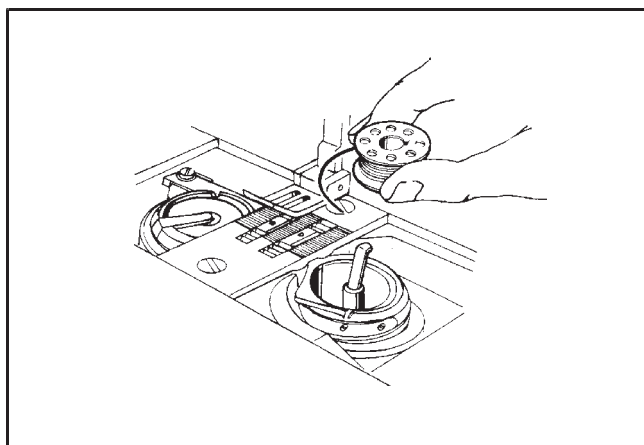
NOTE:

The amount of thread wound onto the bobbin should be a maximum of 80% of the bobbin capacity.



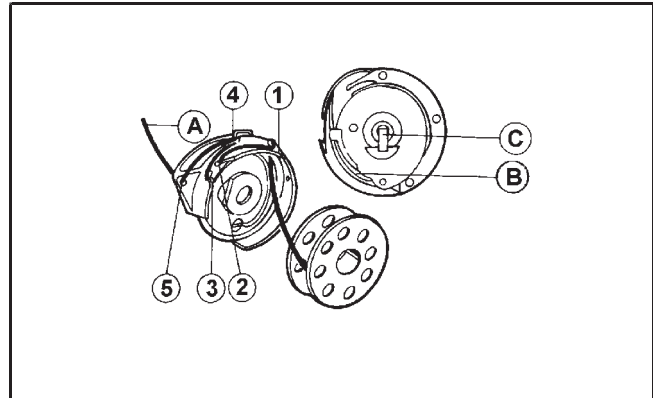
## 7.BOBGING INSTALLATION

Draw about 5mm thread from the bobbin, see the Fig. hold the bobbin in the correct way, and put it in the rotating hook.



## 8.THREADING BOBBIN THREAD AND INSTALLING BOBBIN CASE

1. Draw the bobbin thread from point (A) in the left side of bobbin set into bobbin case.
2. Pass the thread through the bobbin case in the order (1)–(5) shown in the Fig.
3. Keep Hollow (B) of bobbin case facing the convex of rotating hook and place bobbin case in the rotating hook.
4. Release latch (C)
5. Place the thread end on the throat plate.



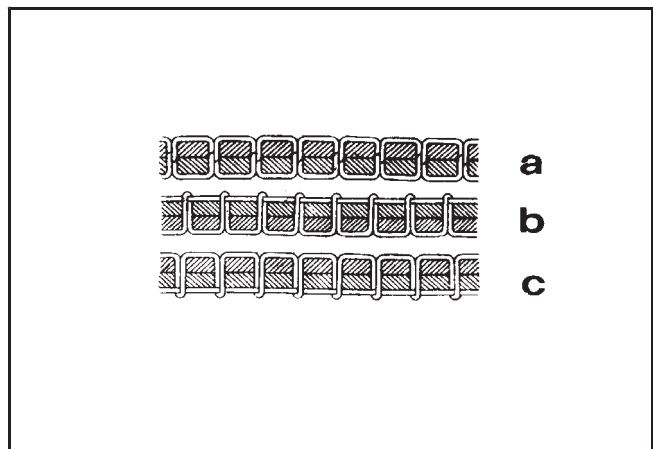
## 9.THREAD TENSION ADJUSTMENT

### Needle thread and bobbin thread adjustment

Thread tension is adjusted in accordance with materials, thread and other factors.

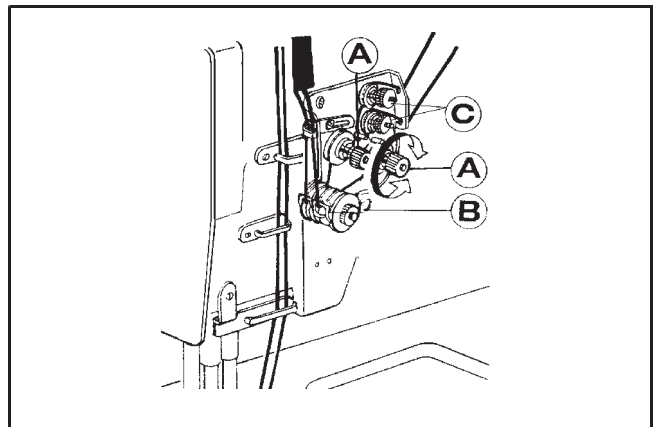
In practice, thread tension is adjusted according to the stitches obtained, and with it the normal stitch is formed.

All forms of stitches are shown in Fig. The normal stitch of sewing machine is shown as Fig. a. If stitch is abnormal as Fig b,c the puckering and thread breakage will occur, and the needle thread tension and bobbin thread tension should be adjusted so that the normal stitch can be obtained.

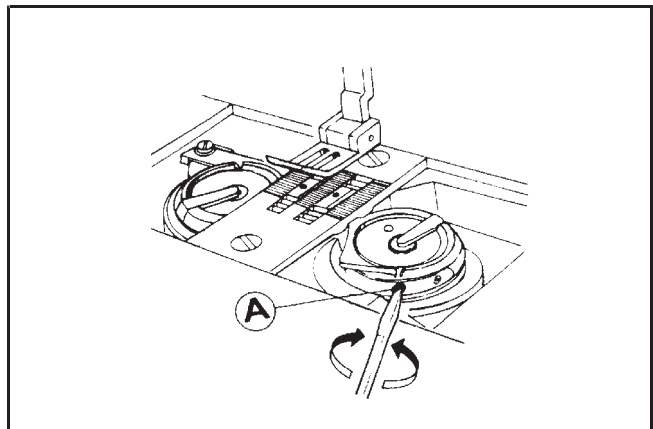


As adjusting needle thread, first adjust bobbin thread as Fig.

1. Turn Screw A,C
  2. Adjusting thread take-up spring swing range B
- For special sewing with special thread, the tension needed can be obtained by adjusting the power and stroke of the thread take-up spring.



As for bobbin thread tension, adjust Screw A with small screwdriver as Fig.






## Adjusting thread take-up spring swing range

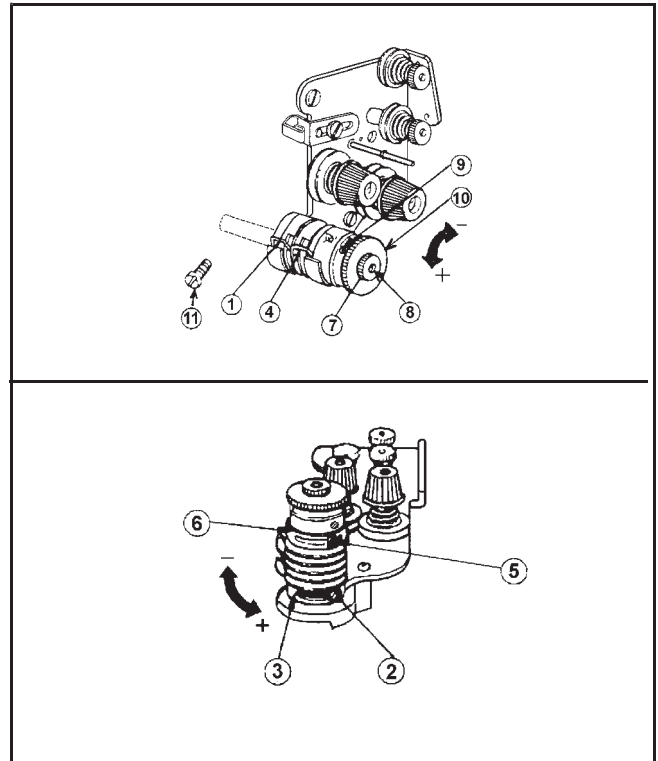
1. Left thread take-up spring (1)  
Loosen Screw (2), thus can adjust throat plate position.
2. Right thread take-up spring (4)  
loosen Screw (5), thus can adjust hold block position.

## Adjusting thread take-up spring strength

As adjust left needle thread, loosen Nut (7) and (11), then adjust Screw. After this tension screws and nut. As adjust right needle thread, loosen Screw and Nut (10), and then tension the screw.

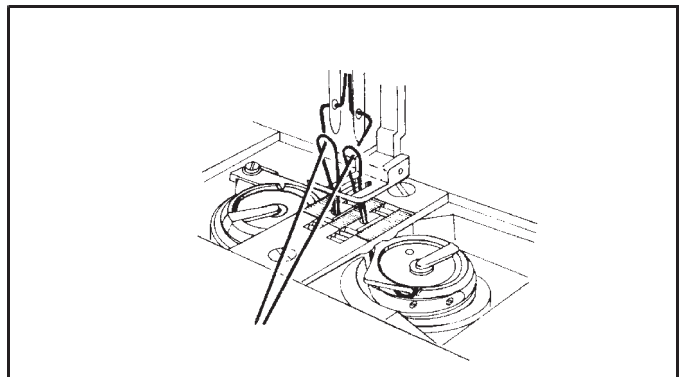
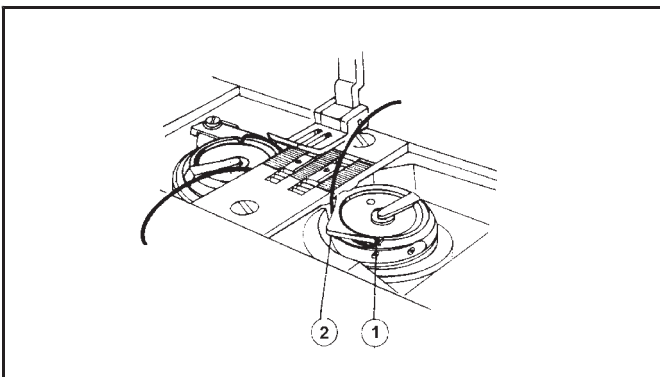
Adjusting thread position according to the sewing material..

	Left	Middle	Right
Thread guide position			
Sewing material	Heavy	Medium	Light



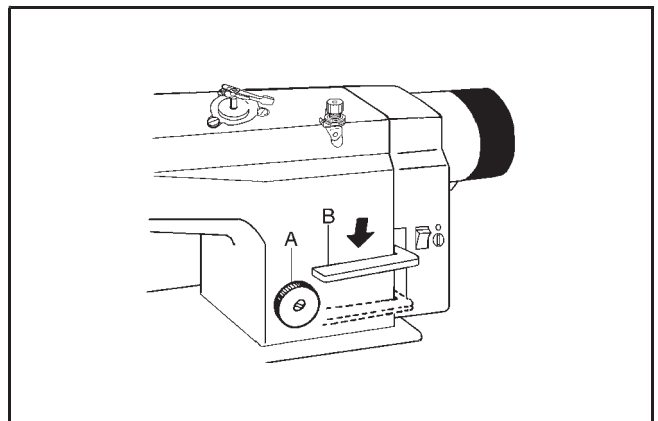
## 10. THE BOBBIN THREAD THROUGH AND OUT THE HOOK

1. Pass the thread end through thread slit (1), and draw it through under position loop (2), place the thread end on the surface of machine bed.
2. Hold the two needles thread with left hand. As the figure shows, raise the needle thread, and the bobbin thread will be drawn out of throat plate, then place the needle thread and bobbin thread under the presser foot neatly.

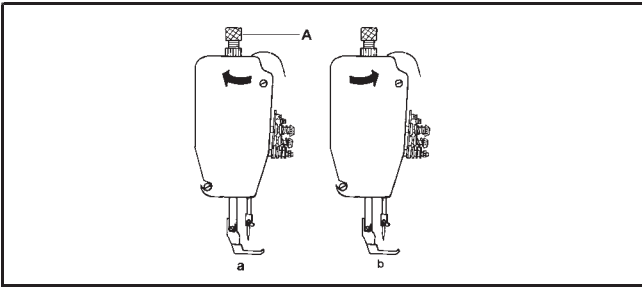


## 11. SET STITCH LENGTH AND REVERSE FEEDING

Turning dial (A) can set stitch length. The figure on face of the dial shows stitch length (mm) in arm. To get small stitch length, presses down the reverse feed lever and turn the dial. Reverse feeding starts when reverse feed lever (B) is depressed, and the machine with feed forward again if re-verse feed lever (B) is released.



## 12. ADJUSTING THE PRESSURE OF PRESSER FOOT

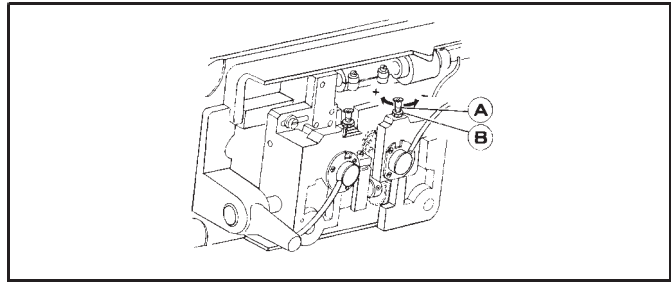


The pressure of the presser foot should be adjusted according to the thickness of the sewing materials.

If stitch on heavy-duty material, the pressure should be increased and turn the pressure adjusting screw as Fig. a, if reduce the pressure as Fig. b

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

## 13. HOOK OIL AMOUNT ADJUSTMENT



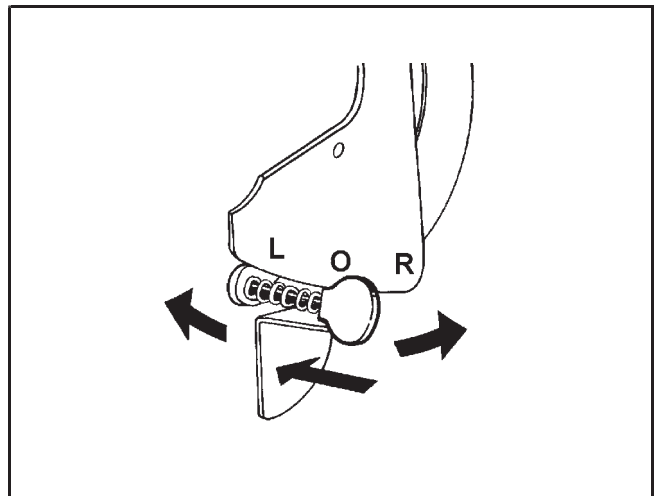
Adjusting screw A can adjusting hook oil amount, first loosen Screw B, turn Screw A clockwise can make more oil turn counterclockwise the screw, less oil. After this, tension Screw B.

## 14. LEFT RIGHT NEEDLE BAR STOPPING

1. Stop left needle bar Turn the button to L position
2. Stop right needle bar Turn the button to R position.
3. Replacement

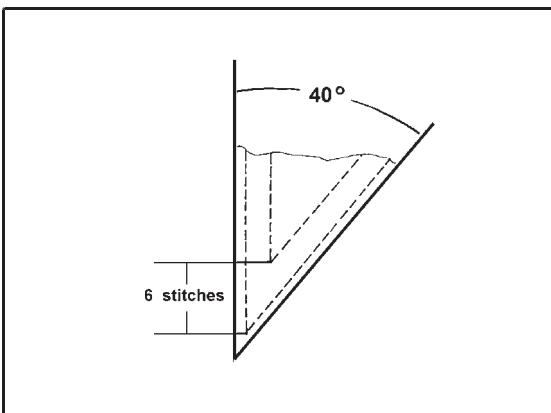
When change left or right needle bar to double two-needle running, only press down the nut. The nut can back to the O mark position, the double needles can work together.

Attention: When machine is running, the needle-bar nut can be operated, but for the smooth running please stop the machine first, make the needle bar the highest position, then make the operation.



## 15. THE RELATIONSHIP BETWEEN SEWING STITCH ANGLE AND NEEDLE STITCH LENGTH

1. For the neat sewing stitch angle, please choose the sewing angle and needle length as the Fig. (only for 6.4mm needle gauge)
2. After choose the angle and stitch length, then the outside stitches can be got.
3. For example: the stitch angle is 40 degree, needle gauge is 2.9mm, and the stitch is 6.

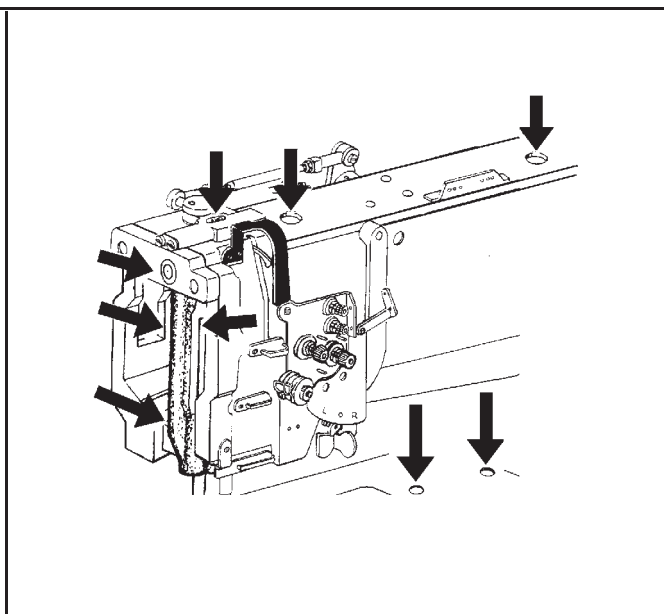
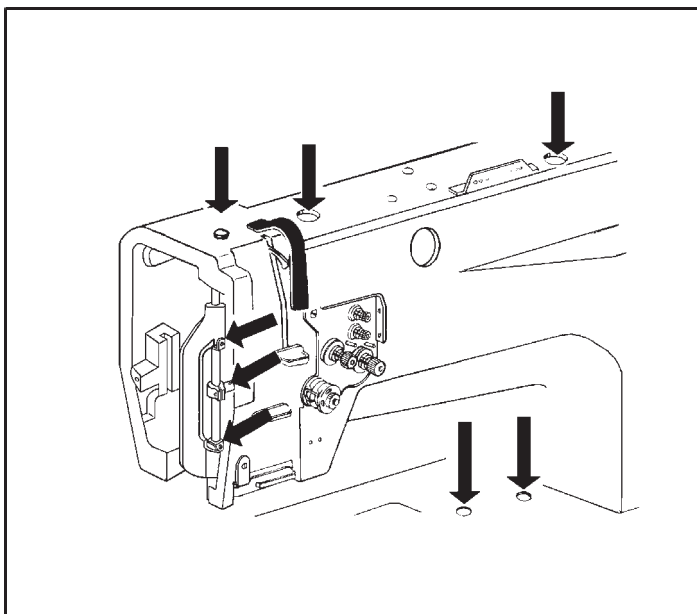
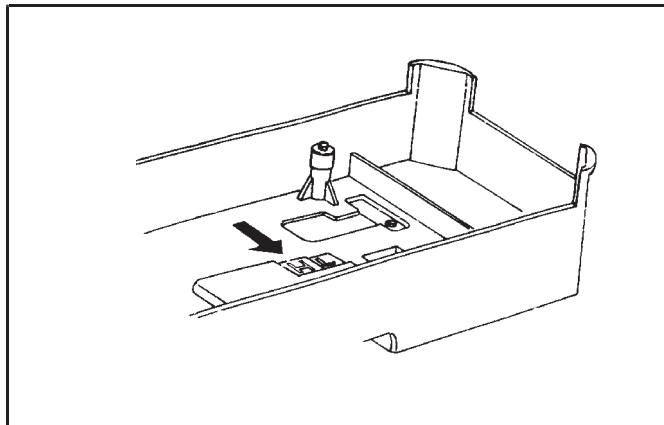


angle \ stitch	stitch							
	2	3	4	5	6	7	8	
30				4.8	4.0	3.7	3.0	
40			4.4	3.5	2.9	2.5	2.2	
50		4.6	3.4	2.7	2.3	2.0	1.7	
60	5.5	3.7	2.8	2.2	1.9	1.6		
70	4.6	3.0	2.3	1.8	1.5			
80	3.8	2.5	1.9	1.5	1.3			
90	3.2	2.1	1.6	1.3				
100	2.7	1.8	1.3					
110	2.2	1.5						
120	1.8	1.2						
130	1.5							
140	1.1							

## 16.LUBRACATING

Fill oil (1) Oil amount should be filled according to the marks in the oil reservoir. Mark (H) refers to the highest of oil amount. Please check the oil amount after some time running, if oil amount low mark L, please fill additional oil to mark H. (please use machine oil No. 18)

Fill oil (2) When the machine starts for the initial time or refuses after a long period of time, the proper oil amount should be filled in sections of machine shown by arrows in Fig.

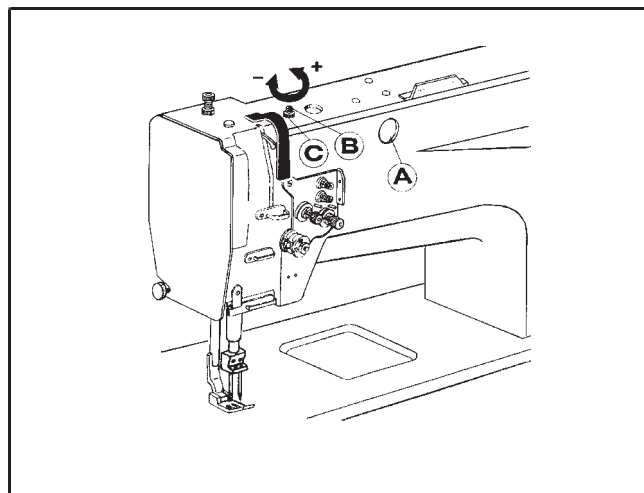


## 17.OILING EXAMINATION AND TAKE-UP LEVER OILING

After running, please observe if Oil Window A fill with oil, if not stop and make examination.

### Adjustment oiling of take-up lever:

Loosen Screw C, turn Screw B as Fig, then tension Screw C.

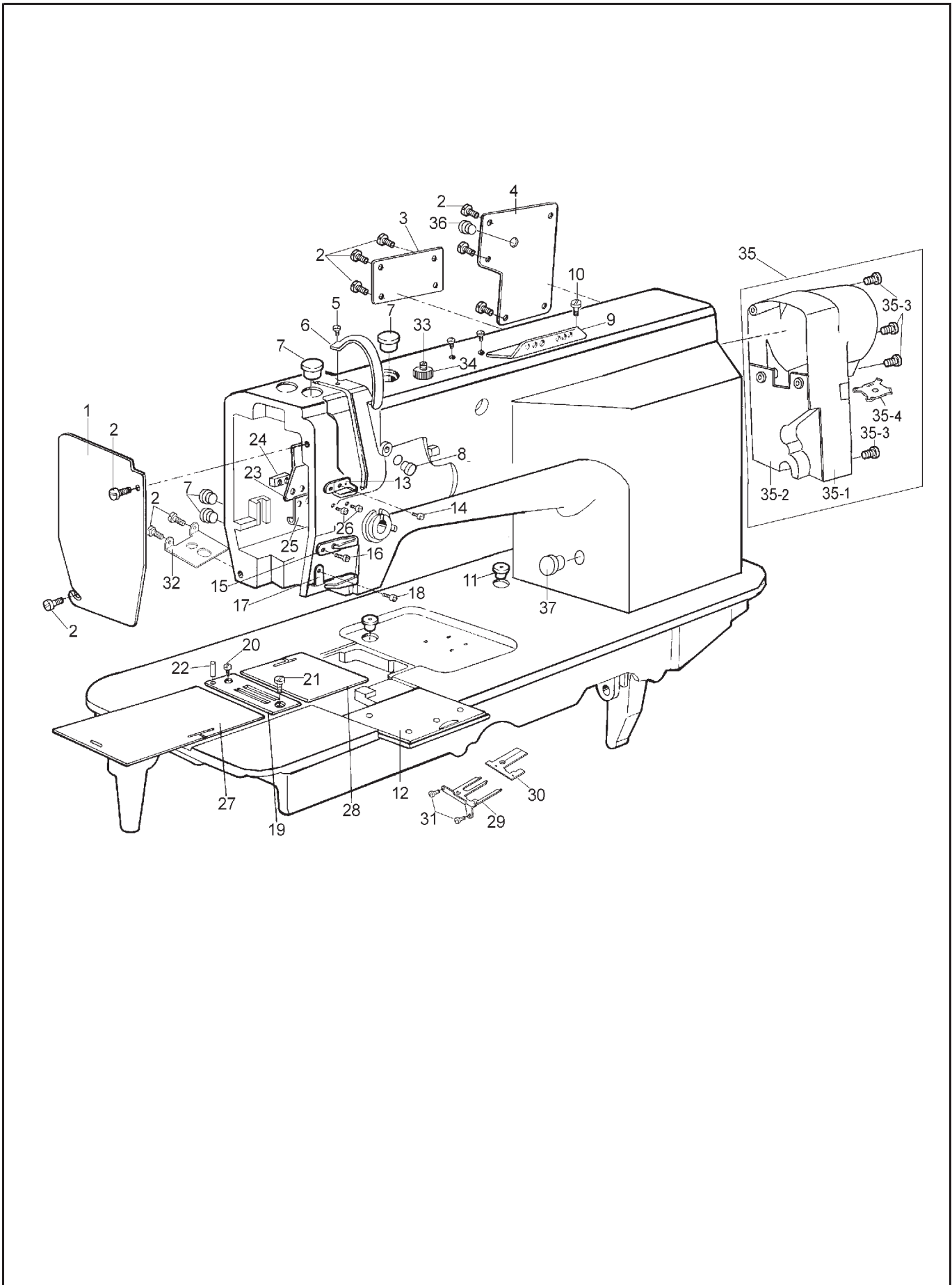




## TROUBLE SHOOTING

Description	Cause	Remedy
Needle.skip	<ol style="list-style-type: none"> <li>1. Needle bent Needle doesn't fit thread</li> <li>2. Insufficient insertion of needle Wrong direction of needle eye Wrong installation of needle</li> </ol>	<p>Replace needle Change needle Insert needle shank to the bottom of the needle adapter Set the needle to the needle eye The long grooves of the two needles opposite to each other</p>
Thread float	<ol style="list-style-type: none"> <li>1. Needle thread tension is too weak</li> <li>2. Thread take up too weak</li> <li>3. Bobbin thread tension is too weak</li> </ol>	<p>Adjust the tension Turn the pressure adjusting lever right for more pressure Tighten the bobbin case spring</p>
Thread breakage	<ol style="list-style-type: none"> <li>1. Thread quality is bad</li> <li>2. Needle bent Wrong installation of needle Needle is slimmer than thread</li> <li>3. Needle thread tension is too strong</li> </ol> <p>Dust fill between the discs Bobbin thread winding is wrong and over the capacity Dust in bobbin case spring deformed or bent Wrong installation of bobbin</p>	<p>Replace with fine thread Replace needle Reset the needle according to the requirements Use the needle that fits the thread Turn the thread tension screw loose Clear it Rewind the thread to 80% of its capacity Clear it Reset or replace Reinstall bobbin</p>
Puckering	<ol style="list-style-type: none"> <li>1. Thread is too thick. compared with materials</li> <li>2. Bobbin and needle thread tension is too strong</li> <li>3. The pressure adjusting screw loose</li> </ol>	<p>Replace with proper needle, thread Adjust with thread tension nut, thread take-up spring Turn the pressure adjusting screw loose</p>

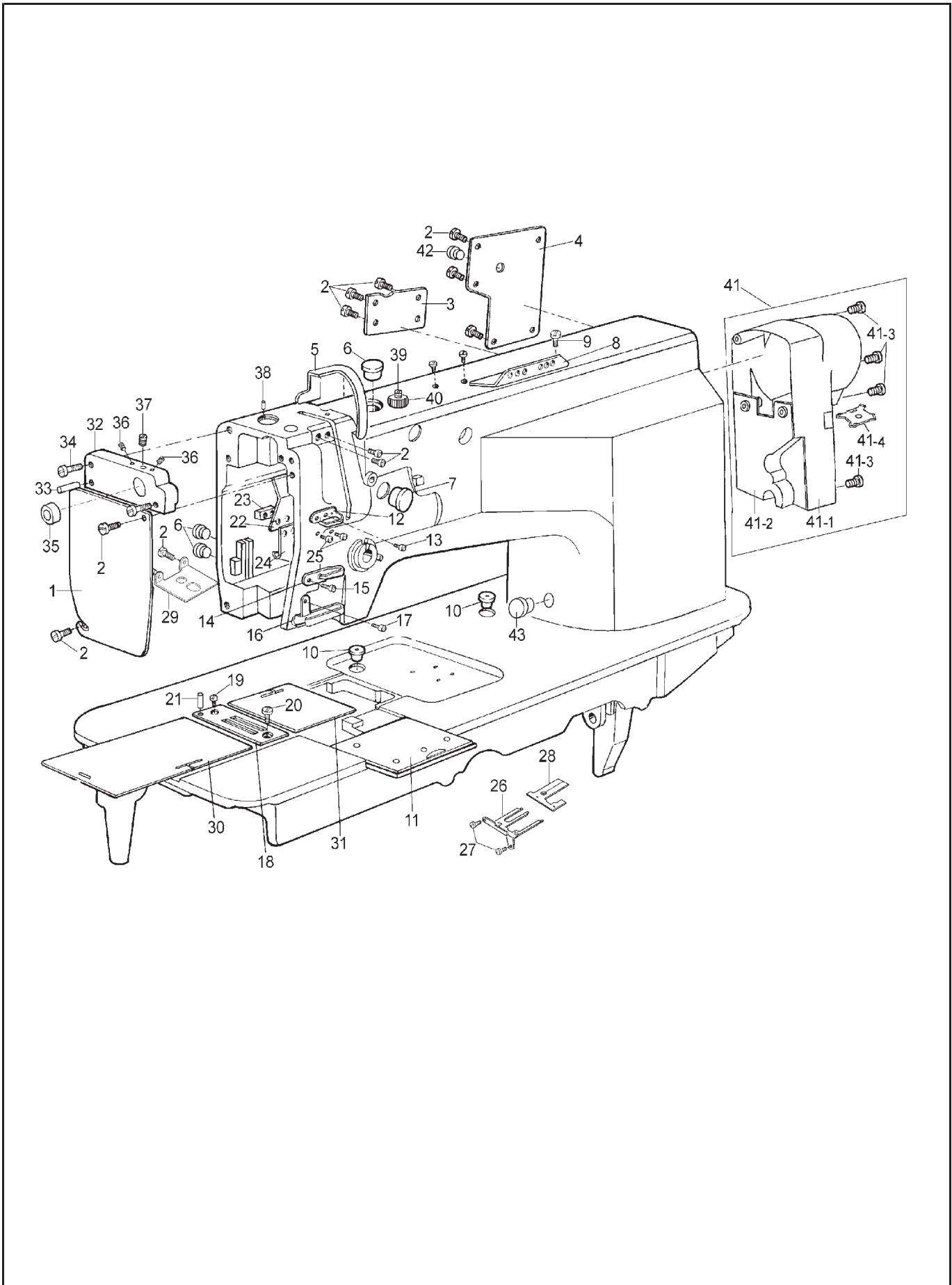
1-1\_ARM AND BED MECHANISM(6220MD/6220BD)



1-1、ARM AND BED MECHANISM(6220MD/6220BD)

No.	Ref.No.	Description	Qt.	
			M	B
1	142100005--w	Face plate	1	1
2	S150237007--d	Screw M4x6	13	13
3	142100006--w	Side cover	1	1
4	142A10002	Side cover	1	1
5	058100005	Screw SM11/64x40	1	1
6	058100009--w	Thread take up lever guard	1	1
7	058100010--v	Rubber plug ( $\phi$ 13/5 )	4	4
8	058100012--v	Rubber plug ( $\phi$ 13/3)	1	1
9	058100013	Upper thread guide plate	1	1
10	036200005	Screw	2	2
11	058100015	Oil plug	2	2
12-1	058120001	Front sliding plate	1	1
12-2	058120002	Screw	1	1
12-3	058120003	Spring	1	1
12-4	022170003	Screw	1	1
13	142100003	Upper thread guide	1	1
14	058100020	Screw	1	1
15	142100007	Middle thread guide	1	1
16	058100020	Screw	1	1
17	142120000	Lower thread guide	1	1
18	058100022	Screw	1	1
19	058100023	Needle plate ( 1/4")	1	
	059100003	Needle plate ( 1/4")		1
20	058100024	Screw	1	1
21	058100025	Screw	1	1
22	058100026	Pin	1	1
23	058100027	Oil Plate	1	1
24	058100028	Bracket for oil retainer	1	1
25	142100013	Oil Plate	1	1
26	058100018	Screw SM3/16x28	2	2
27	058100029	Left sliding plate	1	1
28	058100030	Right sliding plate	1	1
29	142100010	Middle oil plate	1	1
30	142100009	Oil felt	1	1
31	058600005	Screw SM9/64x40	2	2
32	142100004	Lower oil plate	1	1
33	142100011	Screw M10x33	1	1
34	142100012	Nut M10x8.5	1	1
35	142A12000	Motor cover assy	1	1
35-1	142A12001	Motor cover	1	1
35-2	142A12002	Motor cover plate	1	1
35-3	S150237005-d	Screw M5x25	5	5
35-4	238100009	All purpose screwdriver	1	1
36	B906650909-v	Rubber plug 8	3	3
37	142100024--v	Rubber plug	1	1

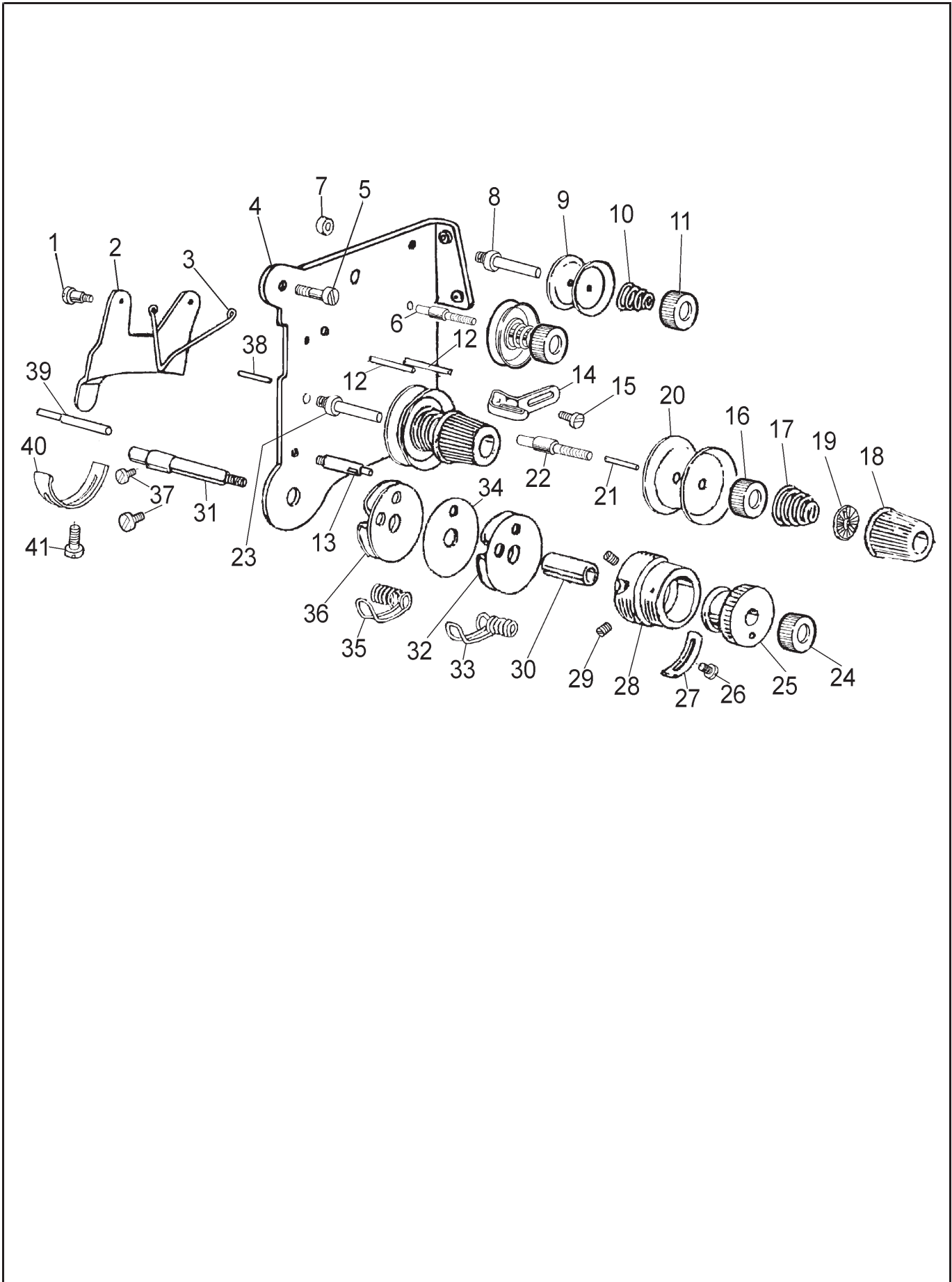
1-2、ARM AND BED MECHANISM(6240MD/6240BD)



1-2、 ARM AND BED MECHANISM(6240MD/6240BD)

No.	Ref.No.	Description	Qt.	
			M	B
1	156100003--w	Face plate	1	1
2	S150237007--d	Screw M4x6	15	15
3	142100006--w	Side cover	1	1
4	142A10002	Side cover	1	1
5	060100005--w	Thread take up lever guard	1	1
6	058100010--v	Rubber plug ( $\phi$ 13/5 )	3	3
7	058100012--v	Rubber plug ( $\phi$ 13/3 )	1	1
8	058100013	Upper thread guide plate	1	1
9	036200005	Screw	2	2
10	058100015	Oil plug	2	2
11	058120001	Front sliding plate	1	1
11-1	058120002	Screw	1	1
11-2	058120003	Spring	1	1
11-3	022170003	Screw	1	1
12	142100003	Upper thread guide	1	1
13	058100020	Screw	1	1
14	142100007	Middle thread guide	1	1
15	058100020	Screw	1	1
16	142120000	Lower thread guide	1	1
17	058100022	Screw	1	1
18	058100023	Needle plate ( 1/4")	1	
	059100003	Needle plate ( 1/4")		1
19	058100024	Screw	1	1
20	058100025	Screw	1	1
21	058100026	Pin	1	1
22	058100027	Oil Plate	1	1
23	058100028	Bracket for oil retainer	1	1
24	142100013	Oil Plate	1	1
25	058100018	Screw SM3/16x28	2	2
26	156100009	Middle oil plate	1	1
27	058600005	Screw SM9/64x40	2	2
28	142100009	Oil felt	1	1
29	156100005	Lower oil plate	1	1
30	058100029	Left sliding plate	1	1
31	058100030	Right sliding plate	1	1
32	156100006--w	Needle bar stand	1	1
33	S150434003	Pin ( 3x20)	2	2
34	B62401612	Screw ( M4x15)	2	2
35	156100007	Bushing	1	1
36	022100011	Screw	2	2
37	022100013	Screw	1	1
38	S150446013	Pin ( $\phi$ 4x12)	1	1
39	142100011	Screw M10x33	1	1
40	142100012	Nut M10x8.5	1	1
41	142A12000	Motor cover assy	1	1
41-1	142A12001	Motor cover	1	1
41-2	142A12002	Motor cover plate	1	1
41-3	S150237005--d	Screw M5x25	5	5
41-4	238100009	All purpose screwdriver	1	1
42	B906650909-v	Rubber plug 8	3	3
43	142100024--v	Rubber plug	1	1

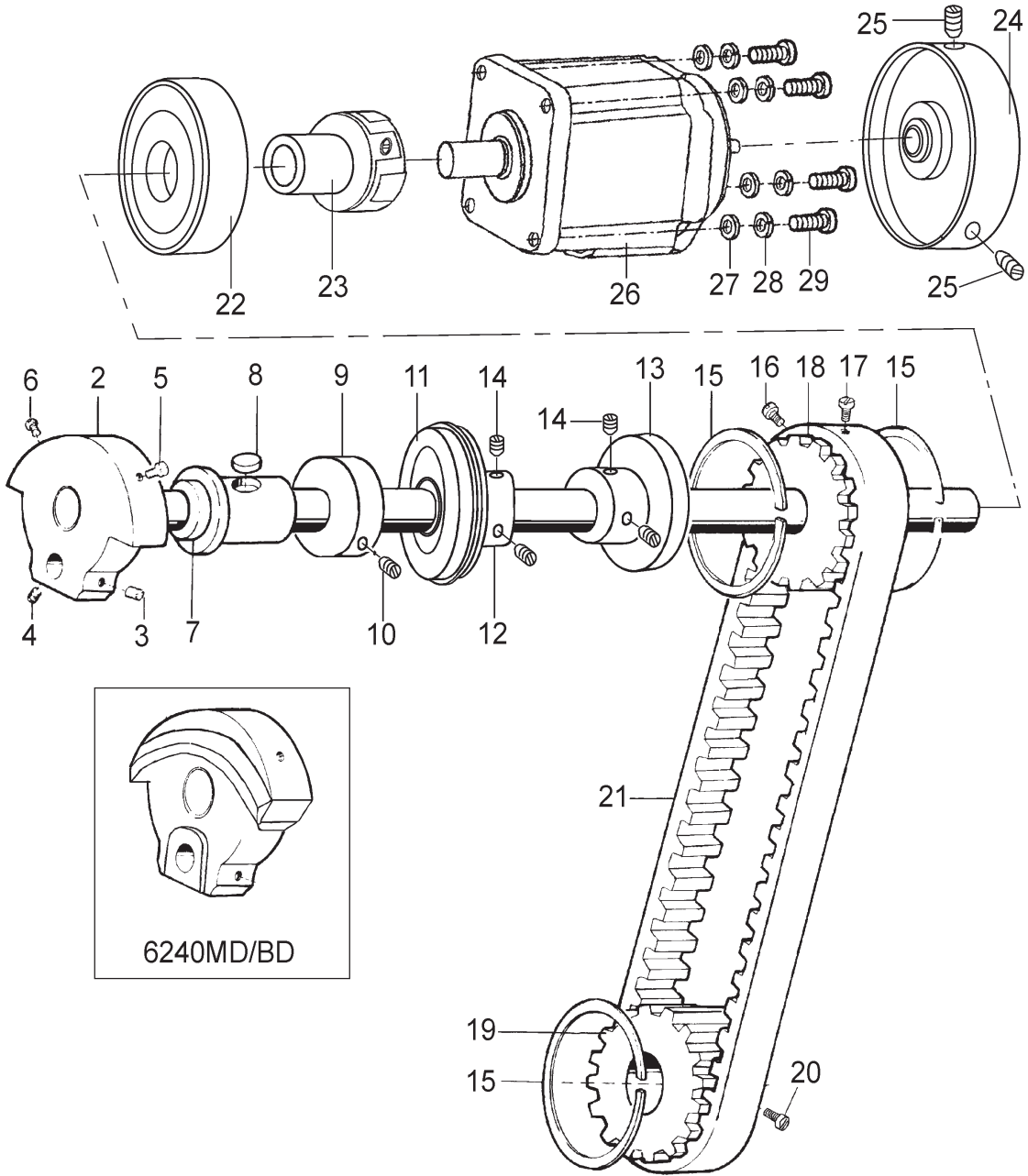
## 2、THREADING MECHANISM



## 2、 THREADING MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	058130017	Screw	2	2
2	142130002	Thread adjusting lever	1	1
3	142130003	Spring	1	1
4	142131001	Thread tension discs fittings	1	1
5	058100005	Screw	1	1
6	142130004	Screw	1	1
7	142130005	Nut	2	2
8	142130006	Screw	1	1
9	022150003	Thread tension discs	4	4
10	142130010	Spring	2	2
11	036240004--w	Nut	2	2
12	142130011	Pin	2	2
13	142130030	Screw	1	1
14	142130013	Thread guide	1	
	179130001	Thread guide		1
15	022130006	Screw	1	1
16	022160004	Thread releasing discs	2	2
17	022160003	Spring	2	
	048110001	Spring		2
18	022160002--w	Nut	2	2
19	022160010	Plate for thread tension	2	2
20	022160005	Thread tension plate	4	4
21	142130017	Thread nail	1	1
22	142130018	Screw	1	1
23	142130019	Screw	1	1
24	142130020	Nut	1	1
25	142130021	Case	1	1
26	058100034	Screw	1	1
27	142130023	Hold piece	1	1
28	142130024	Direct case	1	1
29	060310011	Screw	2	2
30	142130026	Shaft	1	1
31	142130027	Shaft for thread takeup spring	1	1
32	142132000	Thread guide plate assy	1	1
33	142132001	Spring	1	1
34	142132002	Thread guide plate	1	1
35	142132003	Spring	1	1
36	142133000	Thread guide plate assy	1	1
37	058600005	Screw SM9/64x40	1	1
38	142130028	Thread nail	1	1
39	142130029	Pin	1	1
40	142130031	Stop plate for thread takeup spring	1	1
41	058100034	Screw	1	1

### 3、ARM SHAFT MECHANISM

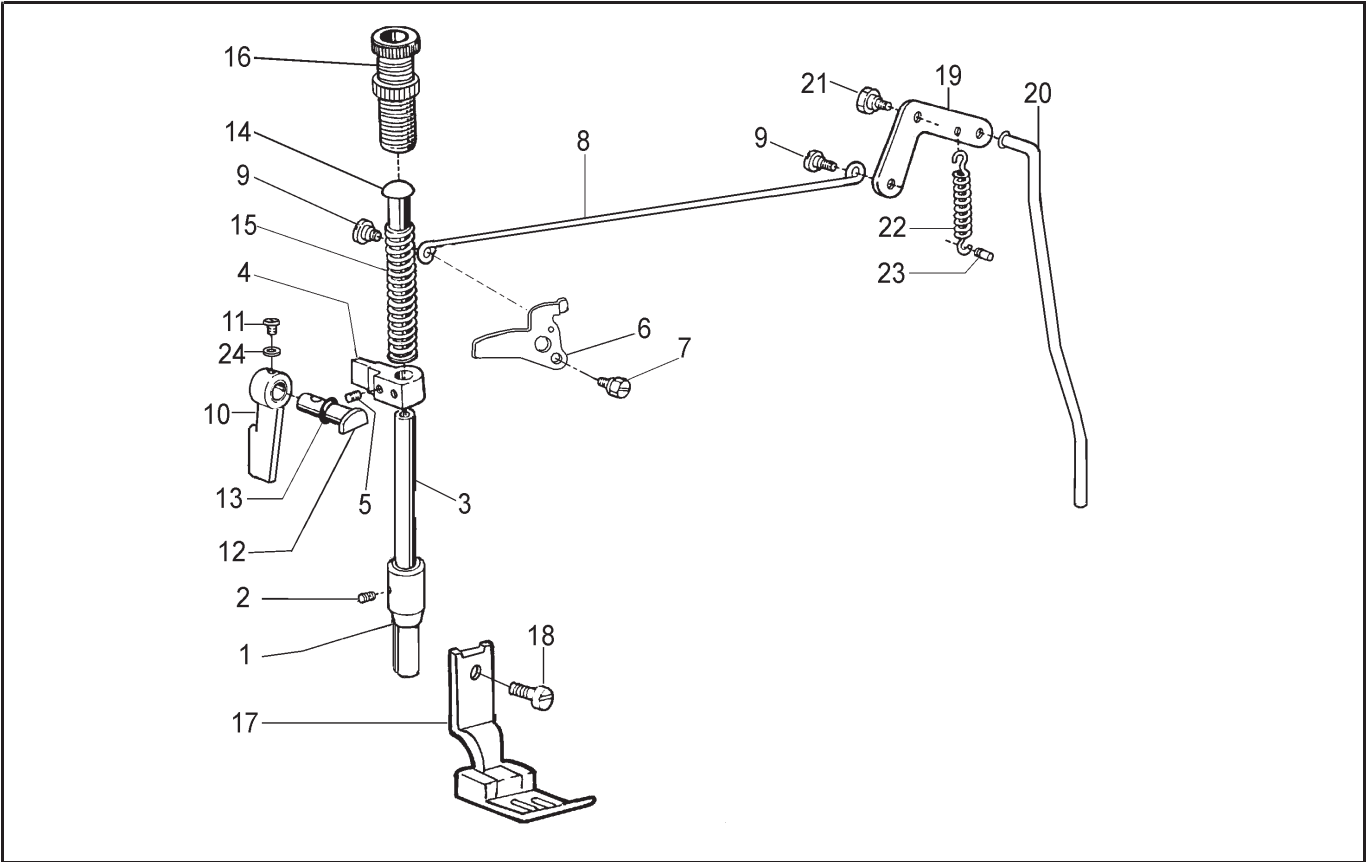




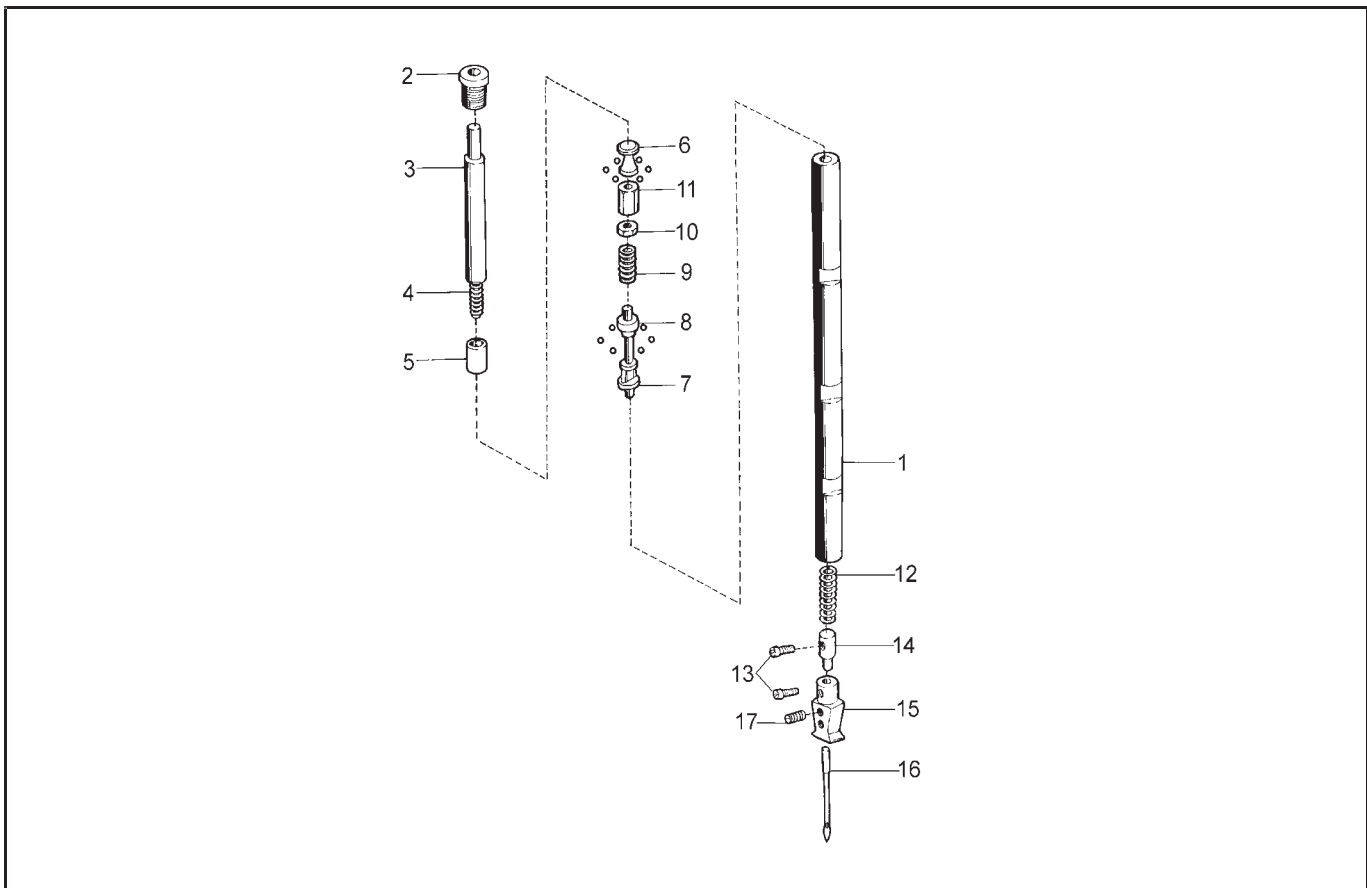
### 3、 ARM SHAFT MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	142A10003	Upper shaft	1	1
2	058211001	Needle bar crank fittings (GC6220MD)	1	
	059211001	Needle bar crank fittings (GC6220BD)		1
	156211001	Needle bar crank fittings (GC6240MD/BD)	1	1
3	058211003	Set screw	1	1
4	058211002	Tension screw	1	1
5	022200007	Set screw	1	1
6	022200006	Tension screw	1	1
7	058220001	Left bushing	1	1
8	058220002	Oil felt	1	1
9	156200001	Balance roll	1	1
10	022510004	Tension screw	2	2
11	058530004	Bearing	1	1
12	142A10004	Bushing	1	1
13	142A10005	Rubber plug	1	1
14	BX87459009	Screw M6x0.75x6	4	4
15	058250003	Ring	3	3
16	022540004	Tension screw	1	1
17	022500013	Screw	1	1
18	058250001	Cog wheel	1	1
19	142230001	Cog wheel	1	1
20	022510004	Screw	2	2
21	058200008	Cog belt	1	1
22	058230004	Bearing	1	1
23	142A14000	coupling	1	1
24	142A10006	Hand wheel	1	1
25	S150227011	Screw	2	2
26	142A13000	Motor assy	1	1
27	B082050864	Spring Washer	4	4
28	B084050974	Flat Washer S5	4	4
29	B048509294	Screw M5x18	4	4

#### 4、PRESSER FOOT MECHANISM



#### 5-1、NEEDLE BAR AND THREAD TAKE-UP MECHANISM(6240MD/6240BD)



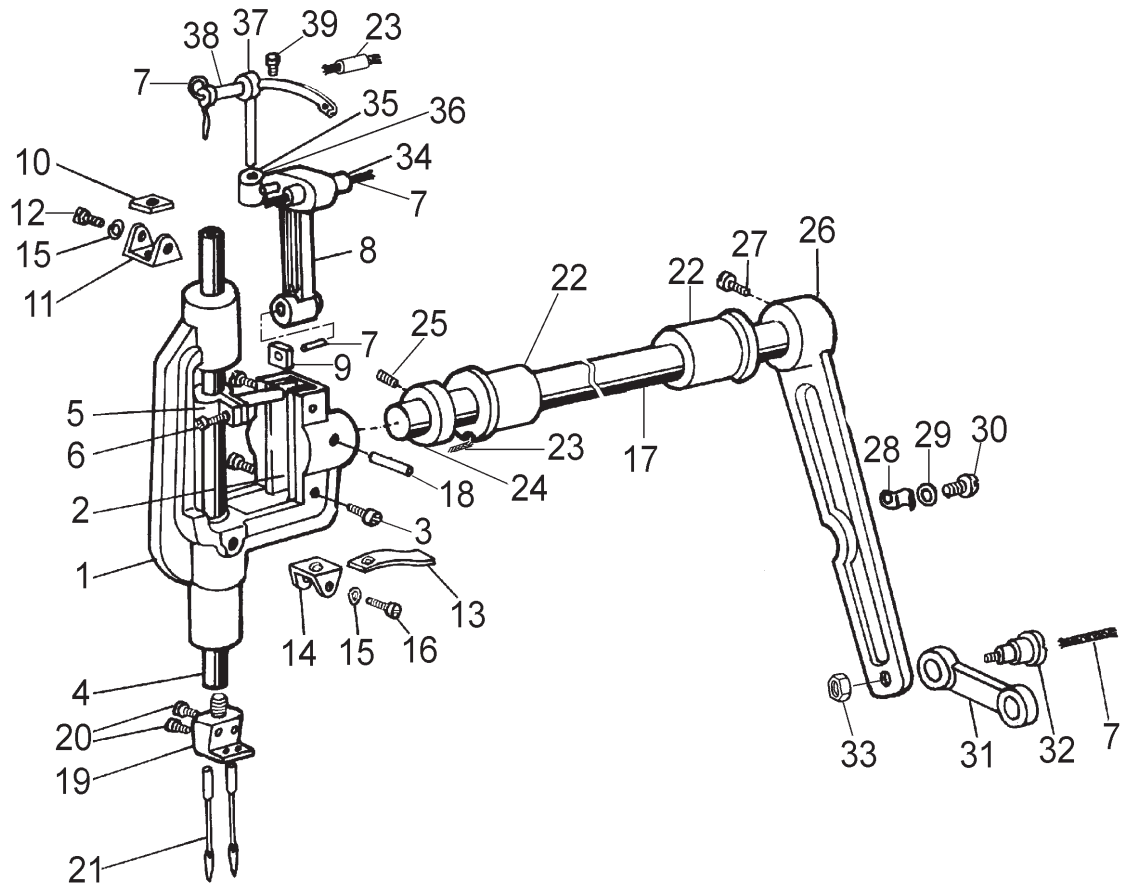
#### 4、PRESSER FOOT MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	142200003	Presser bar upper busing	1	1
2	058200003	Screw	1	1
3	142200004	Presser bar	1	1
4	142240001	Presser bar guide	1	1
5	022510004	Screw	1	1
6	142200005	Thread releasing plate	1	1
7	022700005	Screw	1	1
8	142200006	Presser lift	1	1
9	022720002	Screw	2	2
10	022710001--w	Presser lever	1	1
11	022100006	Screw	1	1
12	142200007	Presser lift crank	1	1
13	022700017	Oil seal for crank	1	1
14	022700012	Presser lift leading bar	1	1
15	048700002	Spring	1	1
16	156201000--w	Screw	1	1
17	05829	Presser foot assy	1	
	05922	Presser foot assy		1
18	058200024	Screw	1	1
19	022730001	Knee lift lever	1	1
20	142200009	Knee lift rod	1	1
21	022730004	Screw	1	1
22	022730002	Spring	1	1
23	022700008	Pin	1	1
24	022100007	Washer	1	1

#### 5-1、NEEDLE BAR AND THREAD TAKE-UP MECHANISM(6240MD/6240BD)

No.	Ref.No.	Description	Qt.	
			M	B
1	156311001	Needle bar	2	2
2	060311702	Adjusting bar guide screw	2	2
3	156311002	Adjusting bar	2	2
4	060311704	Coil spring	2	2
5	060311705	Adjusting bar guide bushing	2	2
6	060311706	Needle bar upper roller	2	2
7	156312001	Triangle pin	2	2
8	060312002	Stud	2	2
9	156312003	Coil spring	2	2
10	156312004	Nut	2	2
11	156312005	Nut	2	2
12	060311708	Spring	2	2
13	060311709	Screw	4	4
14	156311005	Stopper for needle clamp	2	2
15	060310008	Needle clamp	2	2
16	058310010	Needle DPx5 ( 90, 14# )	2	
	048200005	Needle DPx5 ( 110, 18# )		2
17	060310011	Screw	2	2

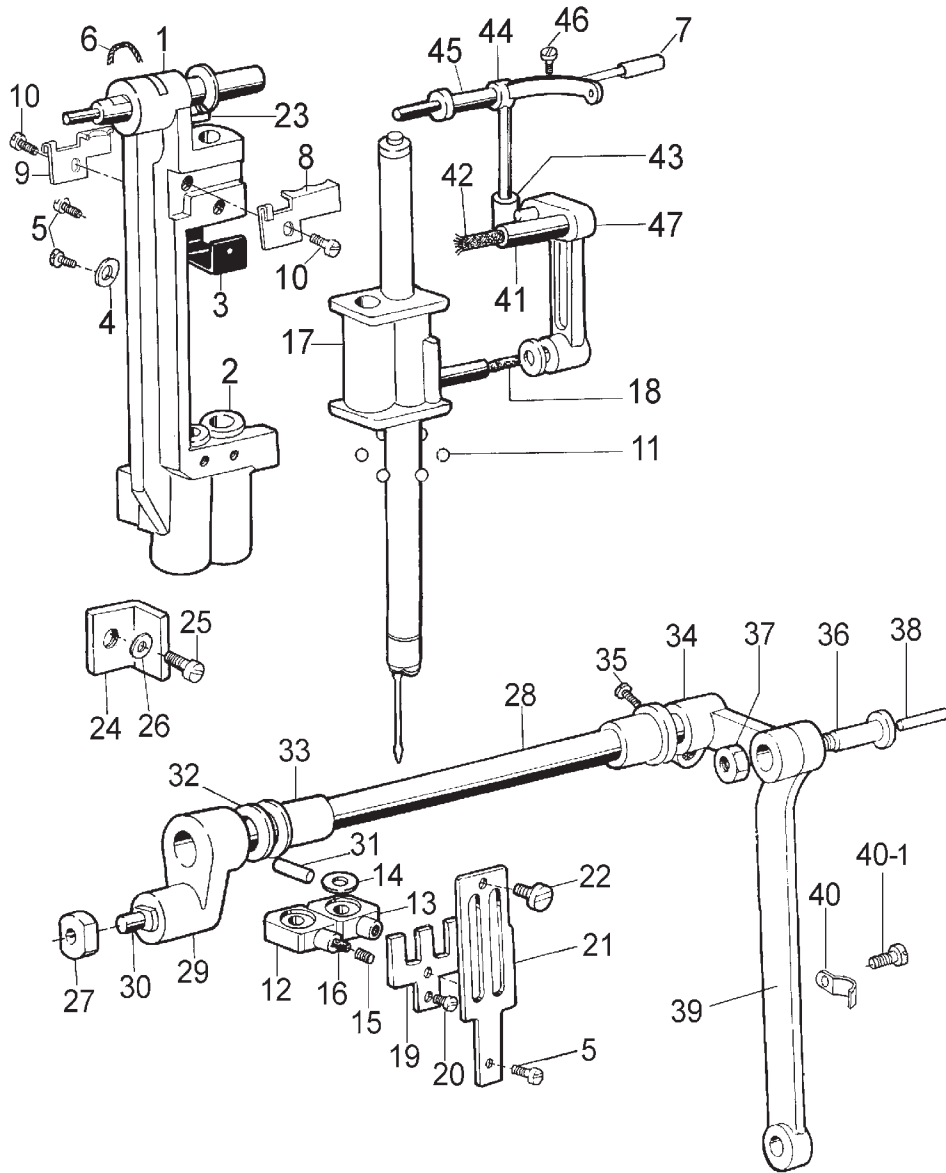
5-2、 NEEDLE BAR AND THREAD TAKE-UP MECHANISM (6220MD/6220BD)



5-2、 NEEDLE BAR AND THREAD TAKE-UP MECHANISM(6220MD/6220BD)

No.	Ref.No.	Description	Qt.	
			M	B
1	058311001	Needle bar rock frame	1	1
2	058311002	Sliding block guide	2	2
3	058311003	Screw	4	4
4	058311004	Needle bar	1	1
5	058311005	Needle bar adapter	1	1
6	036550007	Screw	1	1
7	W180103030	Oil wick	o	i
8	142310001	Needle bar link	1	1
9	058311007	Sliding block	1	1
10	058310002	Felt	1	1
11	058310003	Holder	1	1
12	058310004	Screw	2	2
13	058310005	Felt	1	1
14	058310006	Holder	1	1
15	S8A3103002	Washer	4	4
16	058310007	Screw	2	2
17	058310008	Needle bar vibrating shaft	1	1
18	SFB1402007	Pin	1	1
19	B998400009	Needle clump	1	1
20	B994787009	Screw	2	2
21	048200005	Needle 18#		2
	058310010	Needle 14#	2	
22	058300002	Bushing	2	2
23	W180101030	Oil wick Φ2	1	1
24	058320001	Collar	1	1
25	022100011	Screw	2	2
26	058330401	Needle bar vibrating shaft link fitting	1	1
27	058330002	Screw	1	1
28	058330003	Pipe clamp	1	1
29	SFB1403001	Washer φ 4	1	1
30	058330004	Screw	1	1
31	058300005	Lank	1	1
32	058340001	Screw	1	1
33	058300007	Nut	1	1
34	058350001	Needle bar crank pin	1	1
35	142321001	Thread take-up link bushing	1	
	156321001	Thread take-up link bushing		1
36	058361002	Plug	1	1
37	142320003	Thread take-up lever	1	
	059320001	Thread take-up lever		1
38	142322001	Shaft for thread take-up lever	1	1
39	BX77421008	Screw	3	3

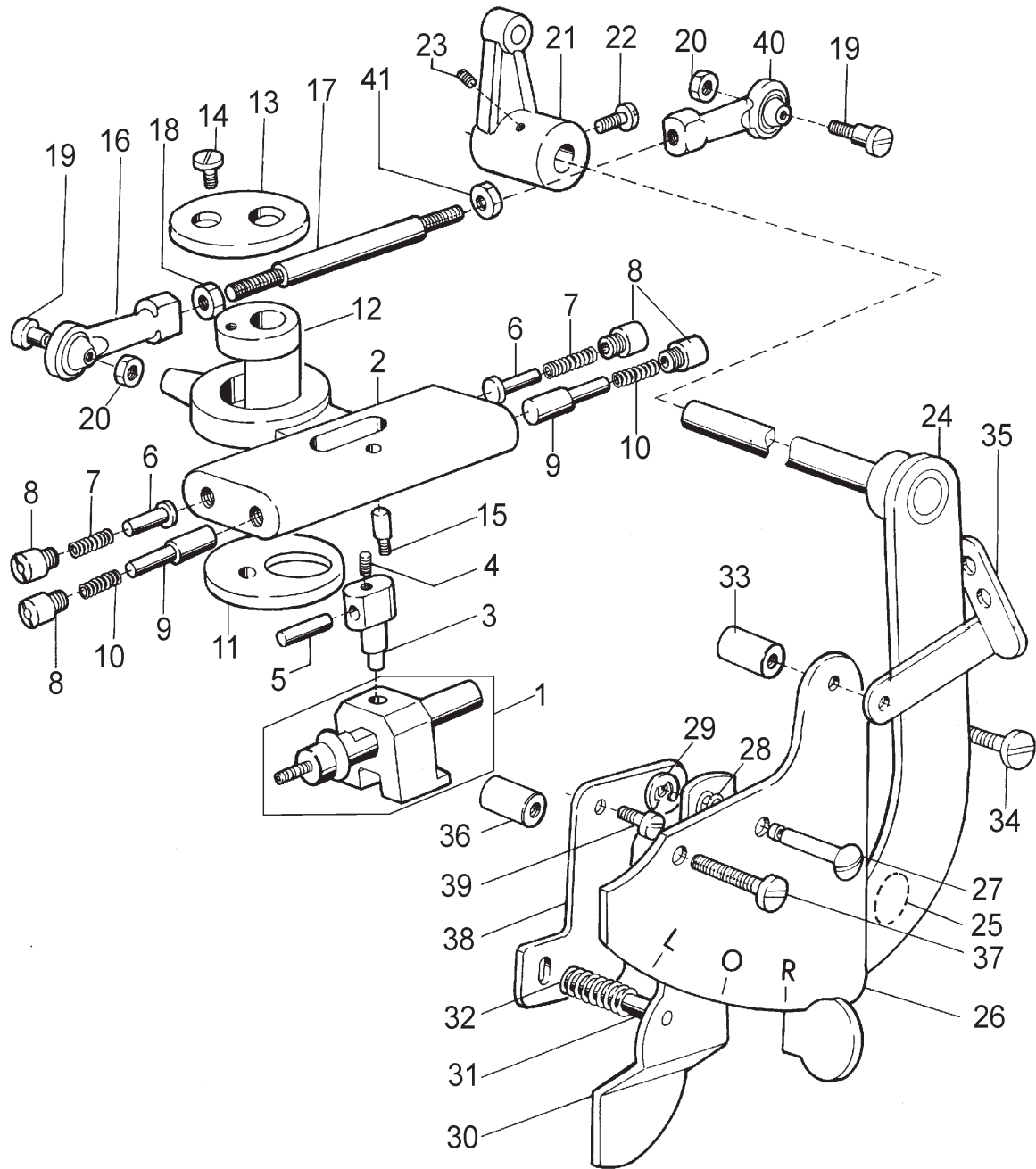
5-3、 NEEDLE BAR AND THREAD TAKE-UP MECHANISM(6240MD/6240BD)



5-3、 NEEDLE BAR AND THREAD TAKE-UP MECHANISM(6240MD/6240BD)

No.	Ref.No.	Description	Qt.	
			M	B
1	156310002	Needle bar holder	1	1
2	060310002	Bushing	2	2
3	060310003	Needle bar stopper	1	1
4	060310004	Washer	1	1
5	022610004	Screw	4	4
6	W180101030	Oil wick Φ2	1	1
7	142322002	Rubber pipe	1	1
8	156310004	Upper oil line clamp	1	1
9	156310005	Lever	1	1
10	058100034	Screw	2	2
11	060910007	Ball 2.5	12	12
12	060310012	Left needle bar stopper	1	1
13	060310013	Right needle bar stopper	1	1
14	060310014	Washer	4	4
15	058500006	Screw	2	2
16	060310016	Washer	2	2
17	156310011	Needle bar connector	1	1
18	060310018	Oil felt	1	1
19	060310019	Stopper inside guide	1	1
20	060310020	Screw	2	2
21	156310012	Stopper outside guide	1	1
22	156310006	Screw	1	1
23	S150446014	Springy pin ( 3x22)	1	1
24	156310013	Needle bar holder guide	1	1
25	156310014	Screw	1	1
26	022100007	Washer	1	1
27	060300003	Needle bar sliding block	1	1
28	058310008	Needle bar vibrating shaft	1	1
29	060320001	Needle bar left vibrating crank	1	1
30	060320002	Shaft for needle bar sliding block	1	1
31	SFB1402007	Pin ( 4x25)	1	1
32	060320003	Washing	1	1
33	058300002	Bushing	2	2
34	060330001	Needle bar vibrating right crank	1	1
35	058330002	Screw	1	1
36	058340001	Screw	1	1
37	058300007	Nut	1	1
38	W180101030	Oil wick Φ2	1	1
39	060330002	Needle bar vibrating connecting lever	1	1
40	058330003	Hold plate	1	1
40-1	058330004	Screw	1	1
41	058350001	Needle bar crank shaft	1	1
42	W180103032	Oil wick Φ4	1	1
43	156321001	Thread takeup lever sliding bushing assembly	1	1
44	180320001	Thread takeup lever		1
	156320002	Thread takeup lever	1	
45	142322001	Thread takeup lever shaft fittings	1	1
46	058200005	Screw	3	3
47	060350001	Needle bar link fittings	1	1

6、 NEEDLE BAR CHANGING MECHANISM(6240MD/6240BD)

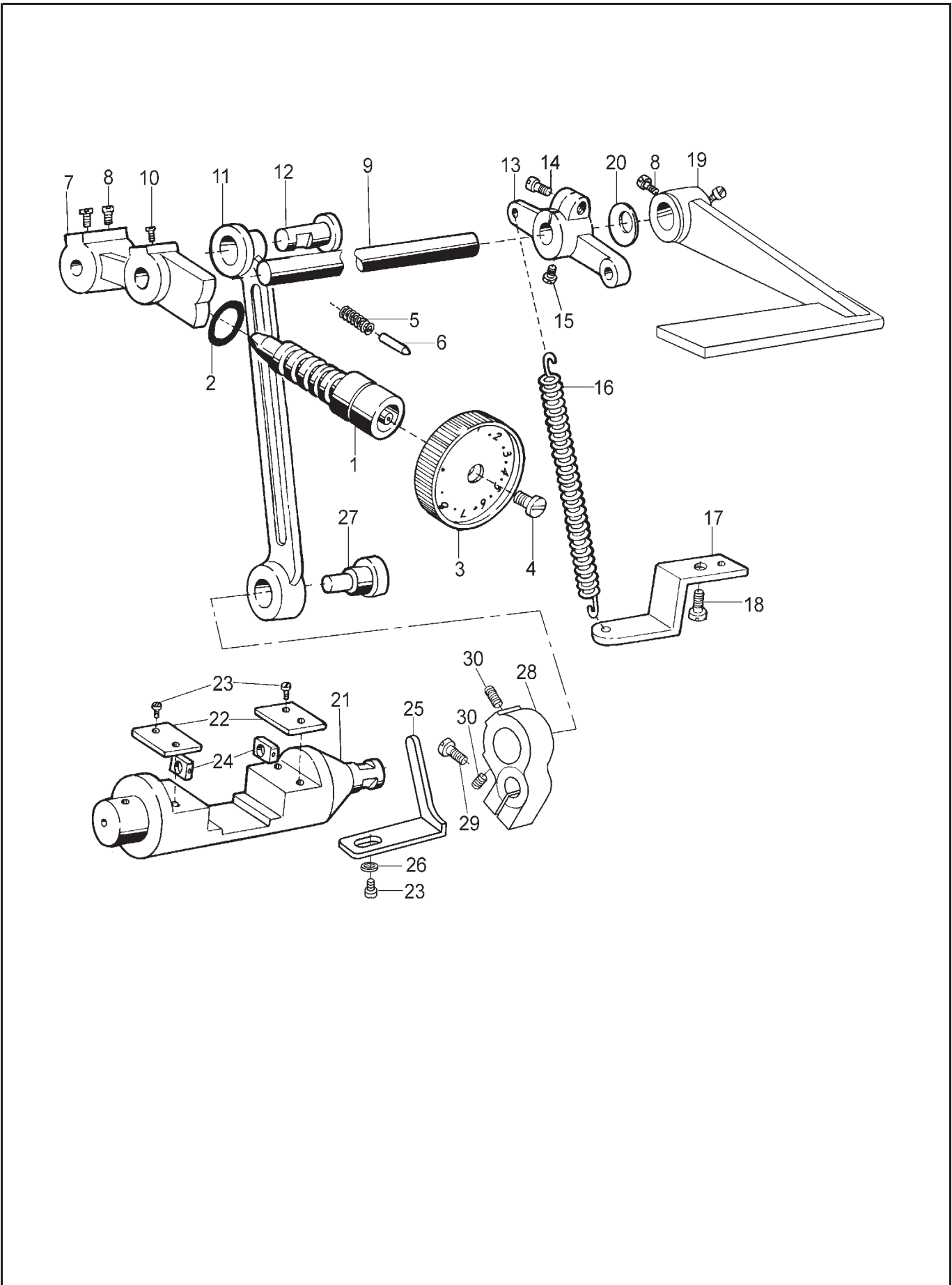




6、 NEEDLE BAR CHANGING MECHANISM(6240MD/6240BD)

No.	Ref.No.	Description	Qt.	
			M	B
1	156410000	Changing block shaft fittings	1	1
2	060421	Needle bar changing guide assembly	1	1
3	060420201	Guide adjusting pin fittings	1	1
4	058710003	Screw	1	1
5	060420003	Pin shaft	1	1
6	060420004	Withstanding stud	2	2
7	060420005	Coil spring	2	2
8	060420006	Screw	4	4
9	060420007	Fulcrum adjusting stud	2	2
10	060420008	Coil spring	2	2
11	156400001	Shim for needle bar changing guide	1	1
12	156200002	Eccentric core block	1	1
13	156400002	Cover	1	1
14	058600005	Screw	1	1
15	060400007	Fulcrum adjusting pin	1	1
16	06043	Needle bar changing link assembly	1	1
17	060430002	Needle bar changing adjusting bar	1	1
18	S120501005	Nut M5	1	1
19	060400009	Screw	2	2
20	060400010	Nut	2	2
21	156420001	Needle bar changing lever crank fittings	1	1
22	058330002	Screw	1	1
23	022100011	Screw	1	1
24	060441--a	Needle bar changing plate fittings	1	1
25	060450002	Stop pin	1	1
26	060460001--a	Needle bar changing set plate	1	1
27	060460002	Pin	1	1
28	060460003	Spring	1	1
29	S4B1202008	Split stop ring	1	1
30	060410134--a	Needle bar changing reset plate	1	1
31	060311005	Pin	1	1
32	060400014	Coil spring	1	1
33	060400015	Bushing nut	1	1
34	060400016	Screw	1	1
35	060400017	Thread guide	1	1
36	060400018	Bushing nut	1	1
37	060400019	Screw	1	1
38	060400020	Needle bar changing stop set plate	1	1
39	058100005	Screw	2	2
40	060430004	link (left)	1	1
41	060430003	Nut M5 (left)	1	1

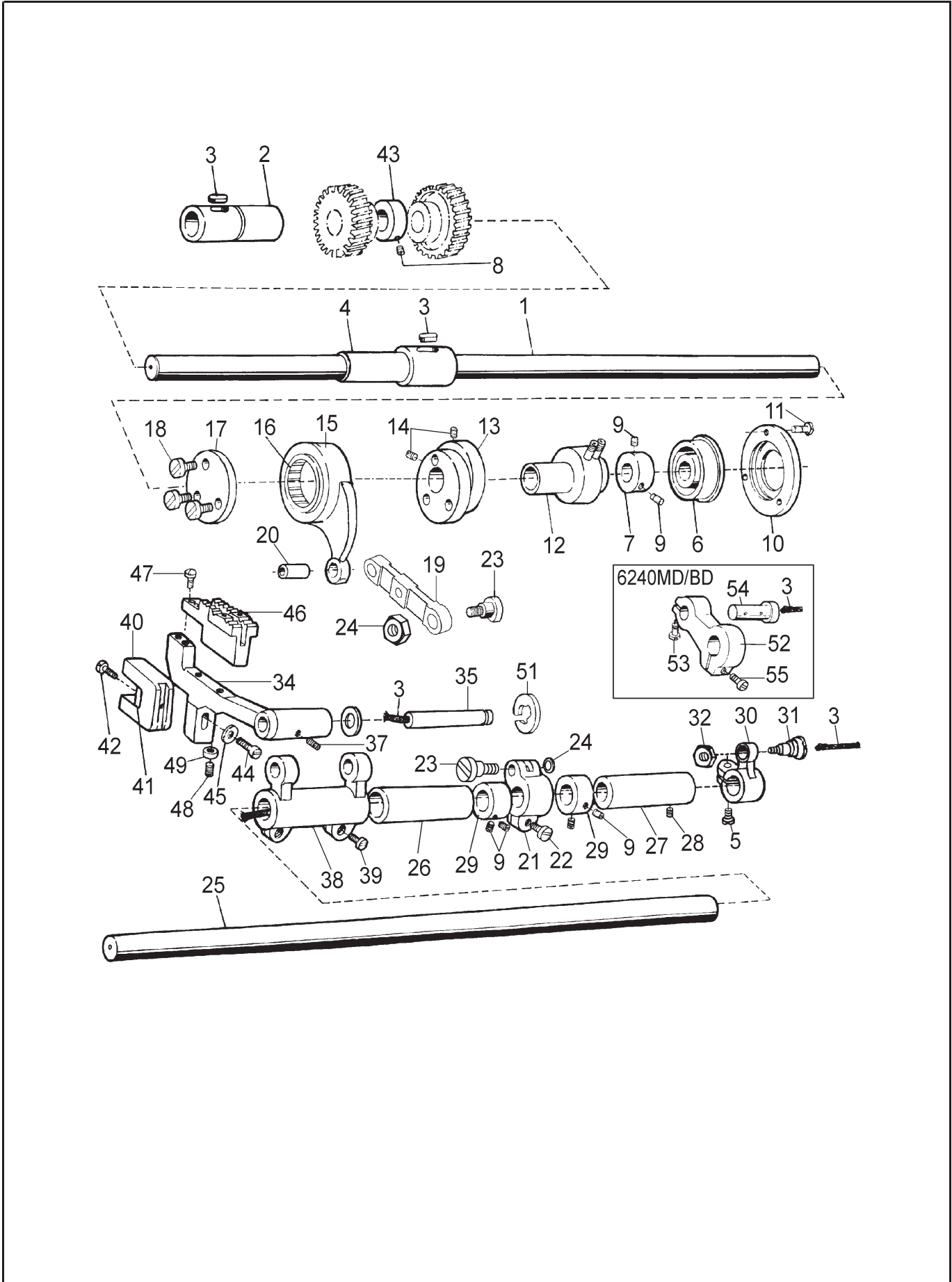
# 7、STITCH LENGTH ADJUSTING MECHANISM



## 7. STITCH LENGTH ADJUSTING MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	022530001	Stitch length adjusting lead screw fittings	1	1
2	142400002	O-type	1	1
3	124510005--w	Dial		1
	124510001--w	Dial	1	
4	036540005	Screw	1	
	022540005	Screw		1
5	058500002	Coil spring	1	1
6	058400003	Stop pin	1	1
7	142410001	Shaft for reverse sewing lever	1	1
8	022540004	Screw	4	4
9	142400001	Reverse sewing shaft	1	1
10	058400006	Screw	1	1
11	142420001	Stitch length link	1	1
12	142430002	Shaft for stitch length adjusting crank	1	1
13	058440001	Reverse sewing shaft	1	1
14	058440002	Screw	1	1
15	058440003	Screw	1	1
16	058440004	Spring	1	1
17	058400009	Bracket for coil spring	1	1
18	058100005	Screw SM11/64x40/8.5	1	1
19	058450001--w	Reverse sewing lever	1	1
20	022500011	Washer	1	1
21	142440001	Reverse sewing adjusting stand	1	1
22	142440002	Guide plate for sliding block	2	2
23	058100005	Screw SM11/64x40/8	5	5
24	142440003	Guide plate for sliding block	2	2
25	142440004	Holder block	1	1
26	142440005	Washer	1	1
27	022600007	Shaft	1	1
28	142430001	Stitch length adjusting crank	1	1
29	S150220031	Screw M5x16	1	1
30	B12500532	Screw M5x5	2	2

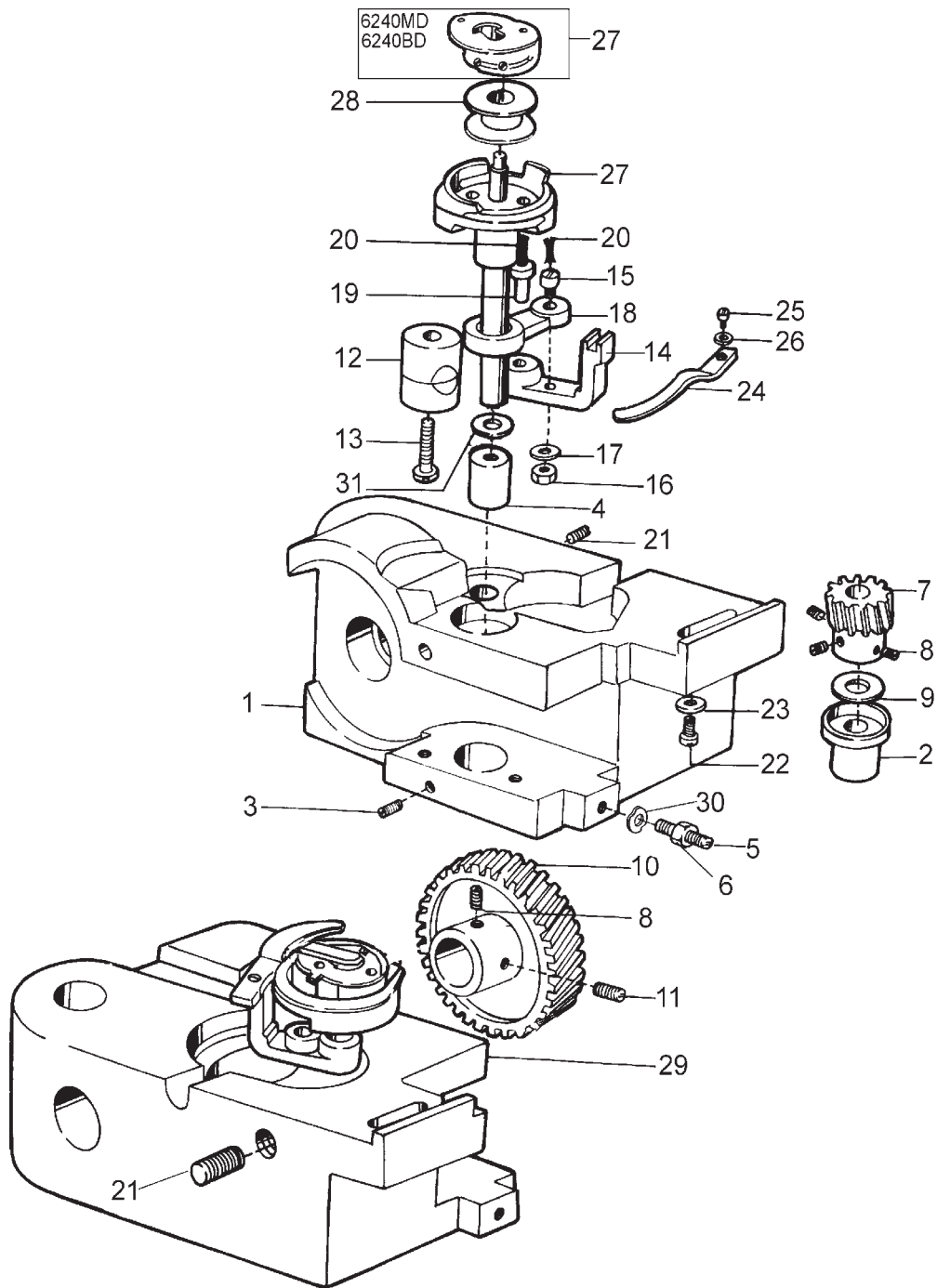
# 8、LOWER SHAFT AND FEED MECHANISM



## 8. LOWER SHAFT AND FEED MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	142500001	Lower shaft	1	1
2	142510001	Lower shaft left bushing	1	1
3	W180101039	Oil wick $\Phi 2$	4	4
4	142540001	Lower shaft right bushing	1	1
5	058330002	Screw	1	1
6	142530000	Lower shaft keening fitting	1	1
7	142530001	Inner bushing for bearing	1	1
8	058530003	Screw	1	1
9	022320002	Screw	6	6
10	058500005	Lower shaft bearing holder	1	1
11	058500006	Screw	3	3
12	142510000	Lower shaft middle bushing assembling	1	1
13	179510001	Feed cam		1
	142560001	Feed cam	1	
14	058560002	Screw	2	2
15	142560002	Feed link	1	1
16	142560008	Needle bearing K32x37x13	1	1
17	142560003	Holder plate	1	1
18	0585A0003	Screw SM11/64x40/7	3	3
19	142560005	Feed link	1	1
20	142560006	Pin	1	1
21	142560009	Feed crank	1	1
22	058440002	Screw	2	2
23	142560007	Screw	2	2
24	058200030	Nut SM1/4x24	2	2
25	058570001	Feed rock shaft fittings	1	1
25-1	W180103082	Felt $\Phi 9$	2	2
26	022600012	Bushing for feed rock left shaft	1	1
27	142500003	Bushing for feed rock right shaft	1	1
28	058200003	Screw SM1/4x24	2	2
29	022620001	Collar	2	2
30	058590001	Feed crank (right)	1	1
31	058340001	Screw	1	1
32	058500017	Nut	1	1
34	142570001	Feed stand	1	1
35	142570003	Feed crank shaft	1	1
37	B12500532	Screw M5x5	1	1
38	142570004	Feed crank	1	1
39	022612001	Screw	2	2
40	142571001	Feed dog fork	1	1
41	0585A1002	Felt	1	1
42	0585A1003	Screw	1	1
43	142571002	Feed dog lift cam	1	1
44	058500020	Screw	1	1
45	058600003	Collar	1	1
46	059520001	Feed dog ( 1/4")		1
	0585A0007	Feed dog ( 1/4")	1	
47	142500004	Screw	2	2
48	S150221002	Screw M3x16	1	1
49	S120501001	Nut M3	1	1
51	S8A3103018	Collar $\Phi 6$	1	1
52	060100001	Feed crank (right) (6240MD/BD)	1	1
53	058610008	Screw (6240MD/BD)	1	1
54	060600002	Pin (6240MD/BD)	1	1
55	058440002	Screw (6240MD/BD)	1	1

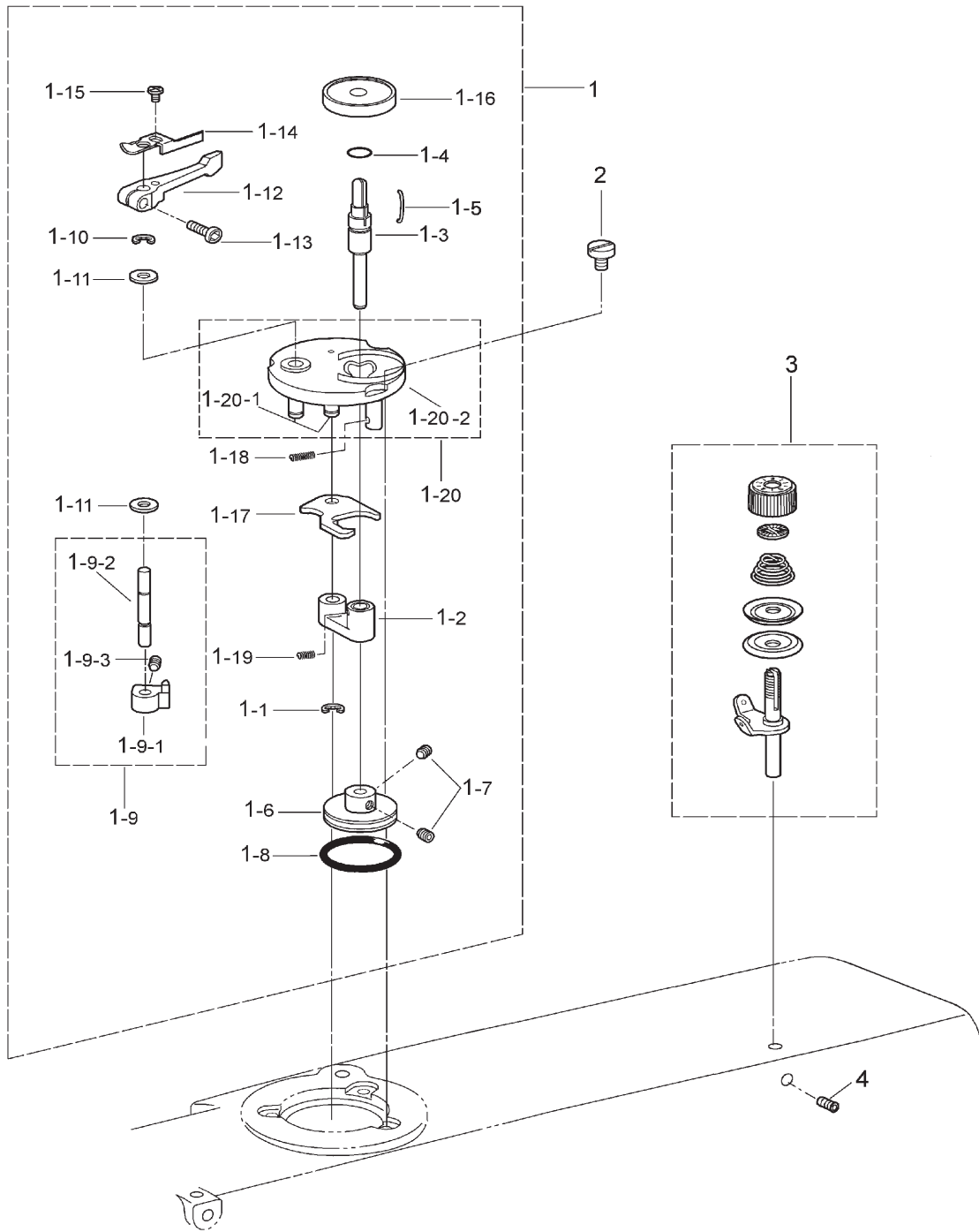
# 9. HOOK AND SADDLE MECHANISM



## 9、HOOK AND SADDLE MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	179611002	Right hook saddle		1
	142611002	Right hook saddle	1	
2	058611002	Lower shaft bushing	2	2
3	022200009	Screw SM15/64x28/4.5	4	4
4	059611004	Upper shaft bushing		2
	058611004	Upper shaft bushing	2	
5	142611007	Screw	2	2
6	142611008	Nut	2	2
7	058612001	Spiral gear	2	2
8	022320002	Screw SM1/4x40	8	8
9	058610003	Washer	2	2
10	142612001	Spiral gear	2	2
11	058613002	Screw SM1/4x40	2	2
12	058615001	Bushing	2	2
13	058615002	Screw	2	2
14	059600002	Bobbin case opener holder		2
	058616001	Bobbin case opener holder	2	
15	058616002	Screw	2	2
16	058616003	Nut	2	2
17	S8A3103012	Washer $\Phi 5$	2	2
18	058616004	Link	2	
	059612002	Link		2
19	058616005	Pin	2	2
20	W180101039	Oil wick $\Phi 2$	2	2
21	058610008	Screw	2	2
22	058600002	Screw	2	2
23	058600003	Washer	2	2
24	058600004	Opener	2	
	059600002	Opener		2
25	058600005	Screw	2	2
26	058600008	Washer	2	2
27	05862	Hook fittings (6220MD)	2	
	05963	Hook fittings (6220BD)		2
	06041	Hook fittings (6240MD)	2	
	06171	Hook fittings (6240BD)		2
28	058600007	Bobbin	2	
	059600004	Bobbin		2
29	142620001	Left hook saddle fittings	1	
	179620001	Left hook saddle fittings		1
30	S150643002	Washer	2	2
31	058610031	Washer (not for 6240MD/BD)	2	2

# 10、BOBBIN WINDER MECHANISM

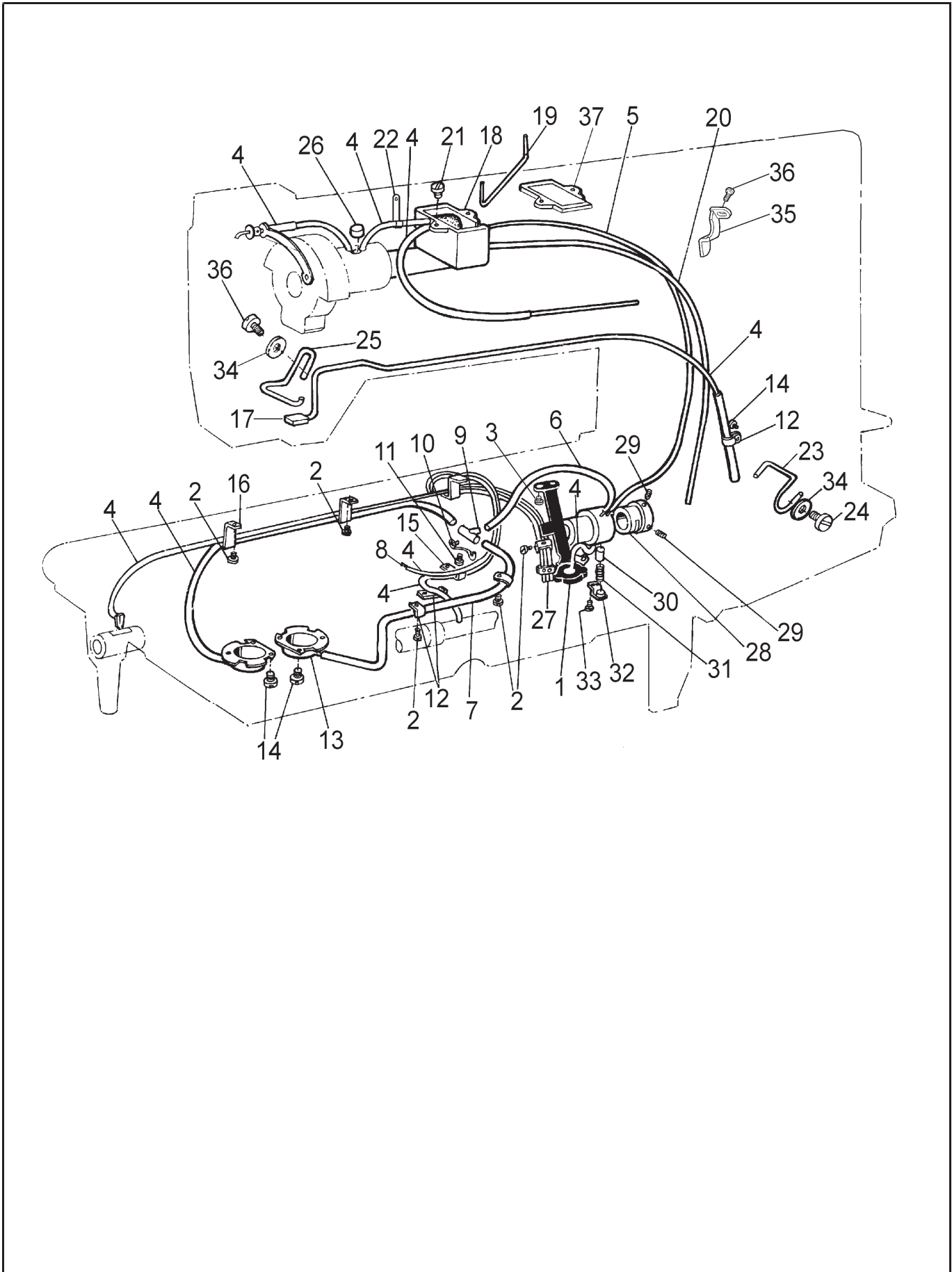




## 10、BOBBIN WINDER MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	142A11000	Bobbin winder complete	1	1
1-1	B062060768	Retaining ting E4	1	1
1-2	BXF9135009	B-winder shaft support assy	1	1
1-3	142A11001	Bobbin winder shaft	1	1
1-4	B029001030	O ring P9	1	1
1-5	217102001	Bobbin fixed spring	1	1
1-6	142A11002	Bobbin winder wheel	1	1
1-7	B098600674	Screw M4x4	2	2
1-8	142A11003	Rubber ring $\phi$ 14x $\phi$ 6	1	1
1-9	BXF9129909	Bobbin presser cam assy	1	1
1-9-1	BXF9128909	Bobbin presser cam	1	1
1-9-2	BXF9127009	Bobbin winder arm shaft	1	1
1-9-3	B098500574	Screw M5x5	1	1
1-10	B062060768	Retaining ting E4	1	1
1-11	B085040974	Washer plain S6	2	2
1-12	BXF9126009	Bobbin presser arm	1	1
1-13	B048609894	Screw M4x12	1	1
1-14	142A11004	Knife	1	1
1-15	BX87692008	Screw M4x5	2	2
1-16	217100033	Bobbin support	1	1
1-17	BXF9121009	Bobbin winder lever	1	1
1-18	BXF9110909	Spring	1	1
1-19	BXF9119009	Spring	1	1
1-20	BXF9138009	Bobbin winder support assy	1	1
1-20-1	BXF9136009	Bobbin winder support shaft	1	1
1-20-2	BXF9137009-w	Bobbin winder support	1	1
2	BXF9118009	Screw	3	3
3	BXF9116009-w	Bobbin winder tension assy	1	1
4	B098500574	Screw M5x5	1	1

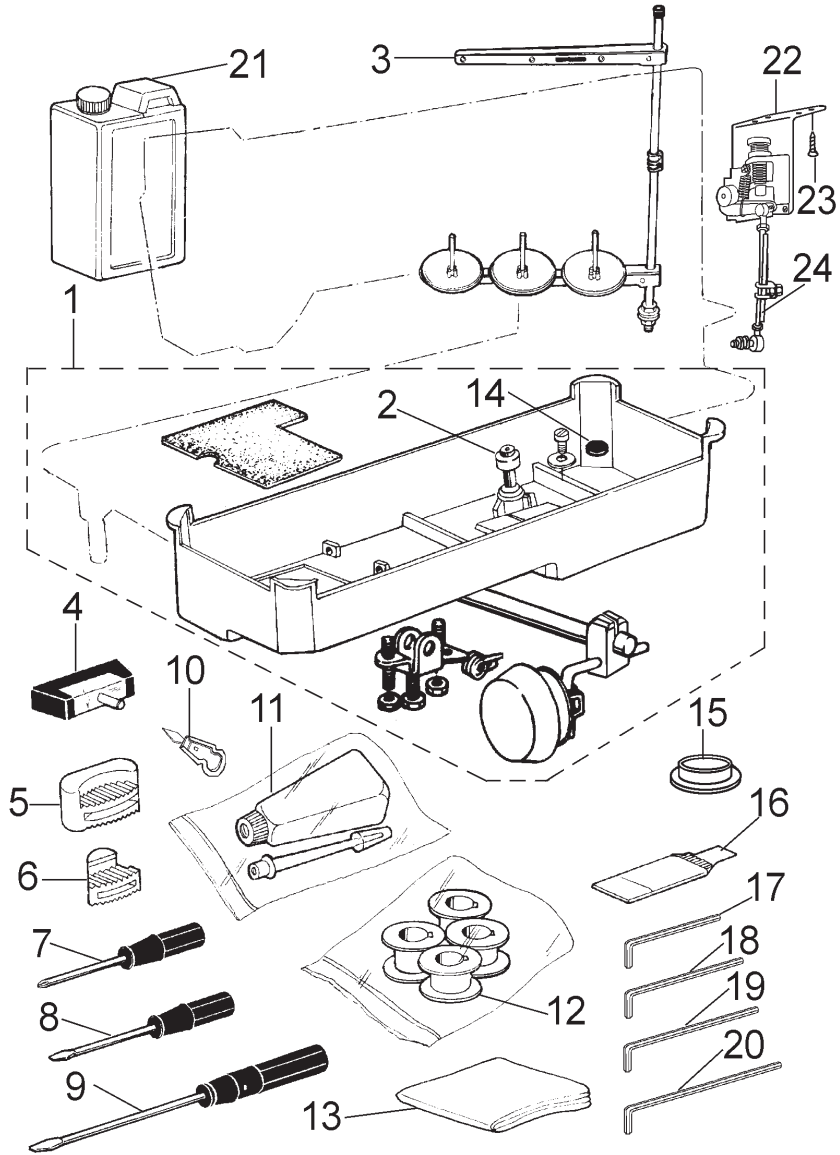
# 11、 OIL LUBRRICATION MECHANISM



## 11、 OIL LUBRRICATION MECHANISM

No.	Ref.No.	Description	Qt.	
			M	B
1	142710000	Filter fittings	1	1
2	058710007	Screw	7	7
3	022100006	Screw	3	3
4	W180202034	Oil sucking pipe $\phi$ 3x $\phi$ 4.8	9	9
5	142730004	Oil pipe	1	1
6	142720001	Oil pipe	1	1
7	142720002	Oil pipe for right hook saddle	1	1
8	W180101030	Oil wick $\Phi$ 2	1	1
9	058720001	3-mouth nozzle fittings	1	1
10	058700005	Nozzle holder	1	1
11	058100022	Screw	1	1
12	058330003	Holder plate	4	4
13		Oil cup assembly	1	1
13-1	058730001	Oil cup for hook saddle	2	2
13-2	022430002	Oil pipe	2	2
14	058330004	Screw	6	6
15	058700009	Oil pipe fittings	1	1
16	058700011	Oil pipe fittings	3	3
17	058780001	Felt	1	1
18	05877	Oil cup assembly	1	1
19	058770004	Press spring	1	1
20	W180202035	Oil drain pipe $\phi$ 5x $\phi$ 7	1	1
21	058700013	Screw M4x16	2	2
22	142700002	Pipe holder	1	1
23	142700003	Pipe holder	1	1
24	0585A0003	Screw SM11/64x40	1	1
25	142700004	Spring	1	1
26	058700018	Felt	2	2
27	022600015	Pipe holder	1	1
28	142550001	Bushing fittings	1	1
29	058550002	Screw	2	2
30	058500009	Plug	1	1
31	058500010	Spring	1	1
32	058500011	Bracket for spring	1	1
33	058310007	Screw	1	1
34	022100007	Washer	2	2
35	142700008	Pipe holder	1	1
36	S150237007	Screw	2	2
37	142700001	Washer	1	1

## 12、 OIL RESERVOIR AND ACCESSORIES



~~X~~ 12、 OIL RESERVOIR AND ACCESSORIES ~~X~~

No.	Ref.No.	Description	Qt.	
			M	B
1	058810000	Oil reservoir asm	1	1
2	05882	Knee lifter lifting pin	1	1
3	058840003--W	Thread spool asm	1	1
4	02299	Hinge with rubber cushion	2	2
5	W210105025-V	Cushion(B)	2	2
6	W210105026-V	Cushion(S)	2	2
7	W050102068	Cross-shaped screwdriver	1	1
8	W050102051	Screw drive 65x3	1	1
9	W050102050	Screw drive 200x6	1	1
10	W050103008	Thread tweezer complete	1	1
11	W050202001	Oil pot	1	1
12	058600007	Bobbin	4	
	059600004	Bobbin		4
13	W060302079	Machine head cover	1	1
14	W050103001	Magnet block	1	1
15	238C00006	Magnets	1	1
16	058310010	Needle 14#	1	
	048200005	Needle 18#		1
17	W050102034	Allen wrench 2	1	1
18	W050102040	Allen wrench 2.5	1	1
19	W050102035	Allen wrench 3	1	1
20	W050102036	Allen wrench 4	1	1
21	W050202009	Oil tank	1	1
22	238C14000	Governor	1	1
23	S150241025	Wood screw M5x20	4	4
24	238C15000	Rod complete	1	1

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GC6220  
GC6240 MD/BD series machine's main technical data

MODLE	GC6220MD	GC6220BD	GC6240MD	GC6240BD
APPLICITION	Light,Medium	Medium,Heavy	Light,Medium	Medium,Heavy
MAX.SPEED	4000SPM	3000SPM	3500SPM	3000SPM
STITCH LENGTH	0-5mm	0-7mm	0-5mm	0-7mm
NEEDLE BAR STROKE	33.4mm	35mm	33.4mm	
PRESSER FOOT LIFT	by hand/7mm			
	by knee/13mm			
NEEDLE	DP×5(90)	DP×5(110)	DP×5(90)	DP×5(110)
HOOK	standard vertical	large vertical	standard vertical	large vertical
NEEDLE GAUGE	standard :6.4mm			
SPECIAL SIZE	2.4 3.2 4.8 5.6 7.9 9.5 12.7 15.9 19.1 25.4 28.1 31.8 mm (For special order)		3.2 4.8 8.0 9.5 12.7mm (For special order)	

- Besides adjusting stitch, please laypeople don't debug or maintaine.
- Parts are subject to changes in design without prior notice.

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