



TYPICAL

GC6220 SERIES

TWO – NEEDLE LOCKSTITCH SEWING MACHINE
INSTRUCTION BOOK / PARTS CATALOGUE

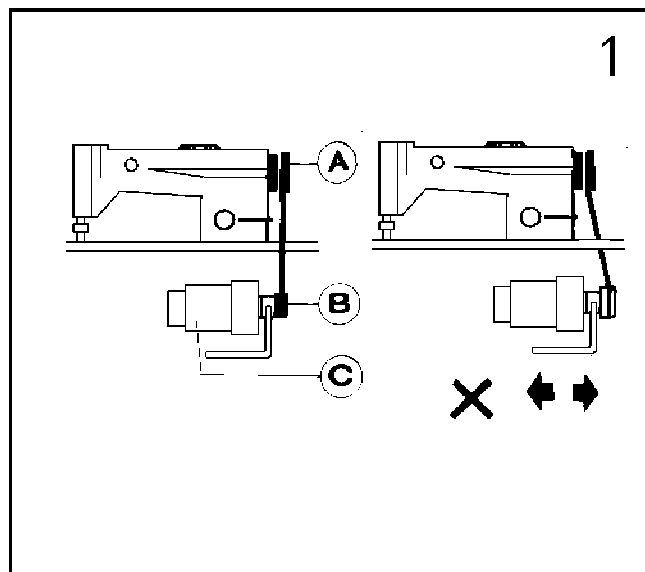
GC6220M GC6220B

ATTENTION

1. Before delivery the machine parts are coated with rust preventive grease, which may be hardened and contaminated by dust during storage and shipment. This grease must be removed by clean cloth with gasoline.
2. Though strict inspection and test before delivery confirm every machine, the machine parts may be loosed or deformed after long distance transportation with jolt. A thorough examination must be performed after cleaning the machine. Turn the balance wheel to see if there is running obstruction, parts collision, uneven resistance or abnormal noise. If these exist, adjustment must be made accordingly before run.

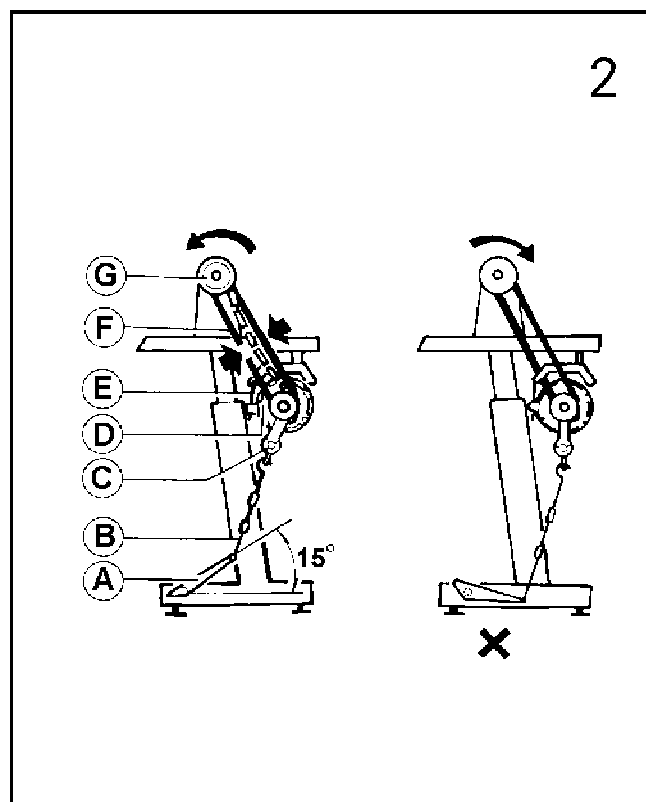
1. MOTOR INSTALL ATION (FIG. 1)

Move motor(C) right and left, align groove(A) of the pulley with groove(B) of the motor pulley.



2. CONNECTING THE CLUTCHLEVER TO THE PEDAL (FIG. 2)

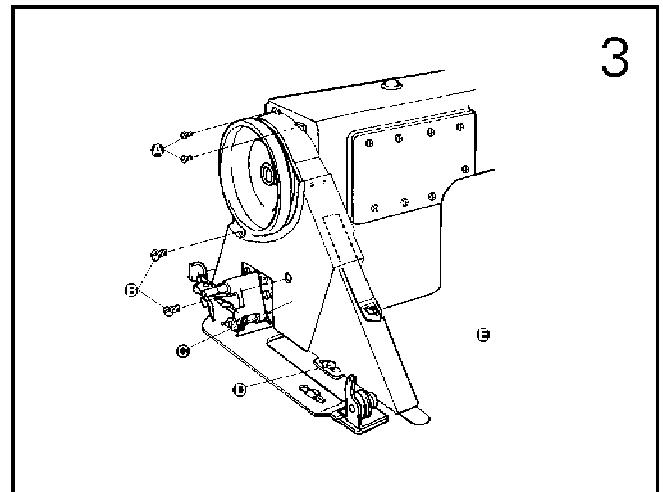
1. the optimum tilt angle of pedal with floor is approx 15 degree.
2. Adjust the clutch of the motor so that clutch lever C and draw bar B run in line.
3. The machine balance wheel should rotate counter-clockwise for normal sewing when view from opposite side of balance wheel. The motor is rotated in the same direction. The rotation can be reversed by reversing (turn over 180 deg.) the plug of motor.
4. Adjust the tension of V-belt F by moving the motor vertically. The proper tension of V-belt is a slack of 10 – 20mm when the belt is depressed at the belt span by finger.



3. BELT COVER INSTALLATION (FIG. 3)

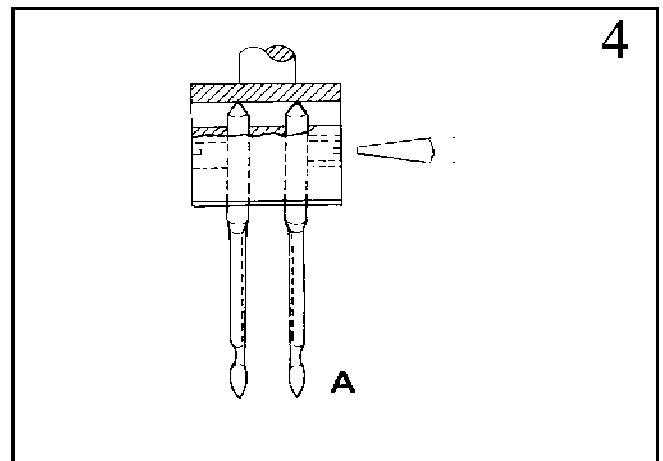
Install the belt cover for the sake of safety.

Install belt cover (C) to arm with screw (A) and screw (B), and install belt cover (E) on board with screw (D).



4. NEEDLE INSTALLTION (FIG. 4)

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

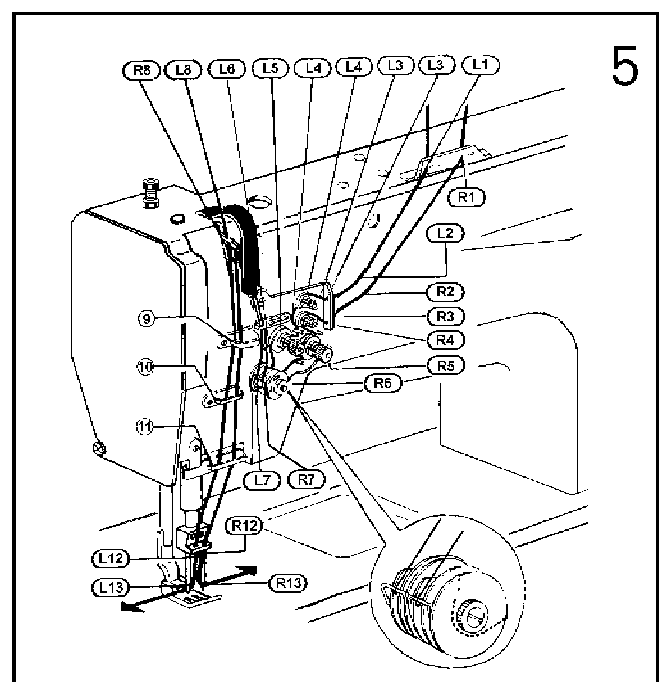
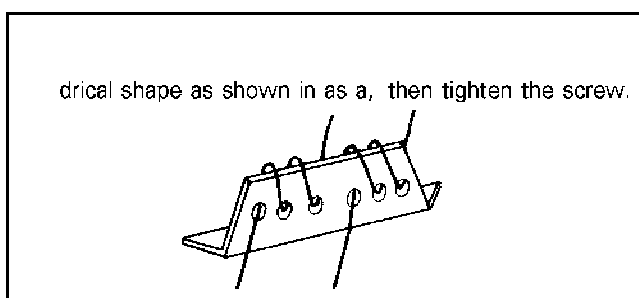


5. THREADING (FIG. 5)

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

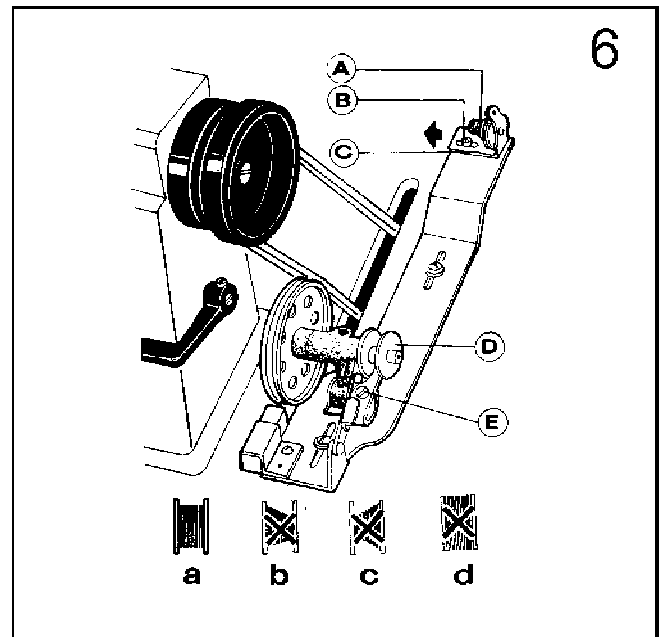


6. INSTALLING THE BOBBIN WINDER (FIG. 6)

The bobbin winder pulley should align with the V-belt and there should be some clearance between them. When the bobbin winder stop latch lever is depressed, the V-belt should be in touch with the bobbin winder pulley in order that the bobbin winder puller can be driven by the V-belt.

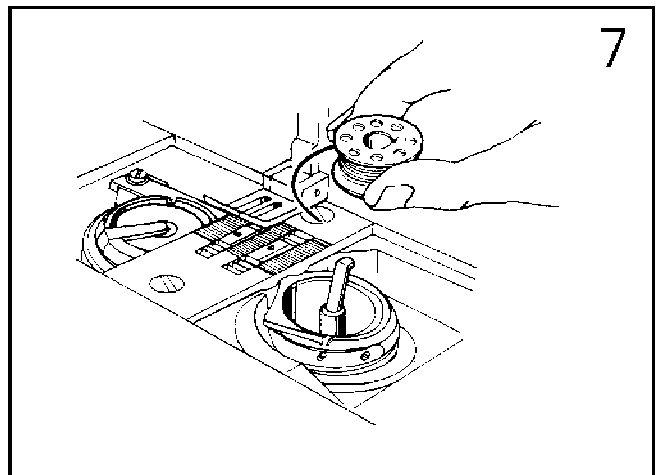
The thread wound on the bobbin should be neat and tight, if not tight, adjust the winding tension by turning the tension stud nut (A) of the bobbin winder tension bracket. When the thread wound on the bobbin does not present a cylindrical shape as shown in Fig.10(a), loosen the set screw (B) of the bobbin winder tension bracket and move the bracket (C) leftward or rightward. If the thread is wound as shown in the figure (b), move the bracket rightward or if wound as shown in the figure (c), move it leftward. After positioning the bracket adequately, tighten the set screw (B).

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



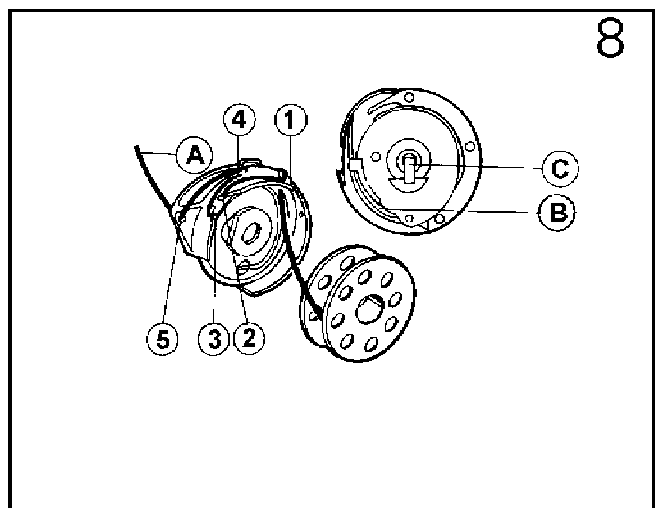
7. BOBBING INSTALLATION (FIG. 7)

Draw about 5mm thread from the bobbin, see the Fig. 7 hold the bobbin in the correct way, and put it in the rotating hook.



8. THREADING BOBBIN THREAD AND INSTALLING BOBBIN CASS (FIG. 8)

1. Draw the bobbin thread from point (A) in the left side of bobbin set into bobbin case.
2. Thread 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 (FIG. 9, 10, 11, 12, 13)

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.

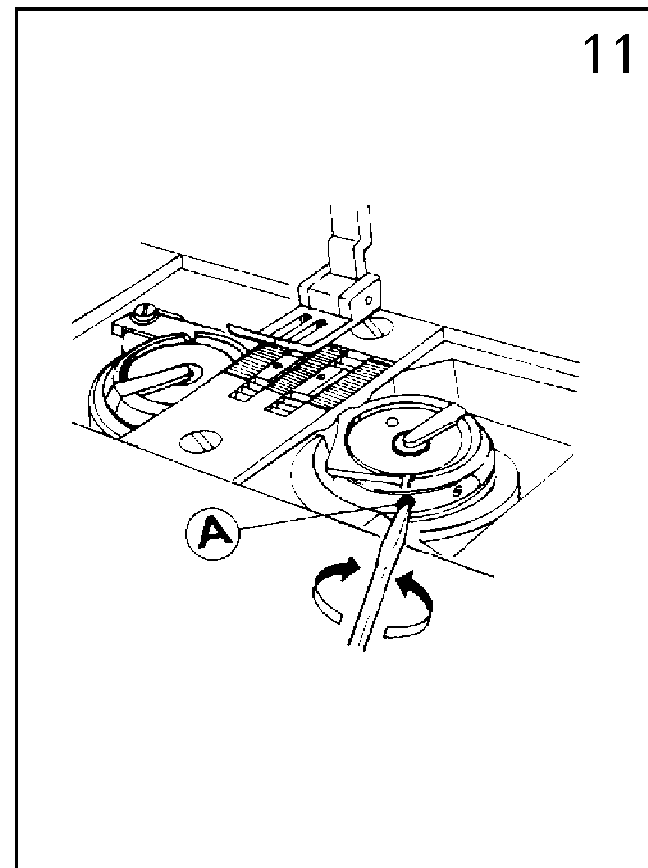
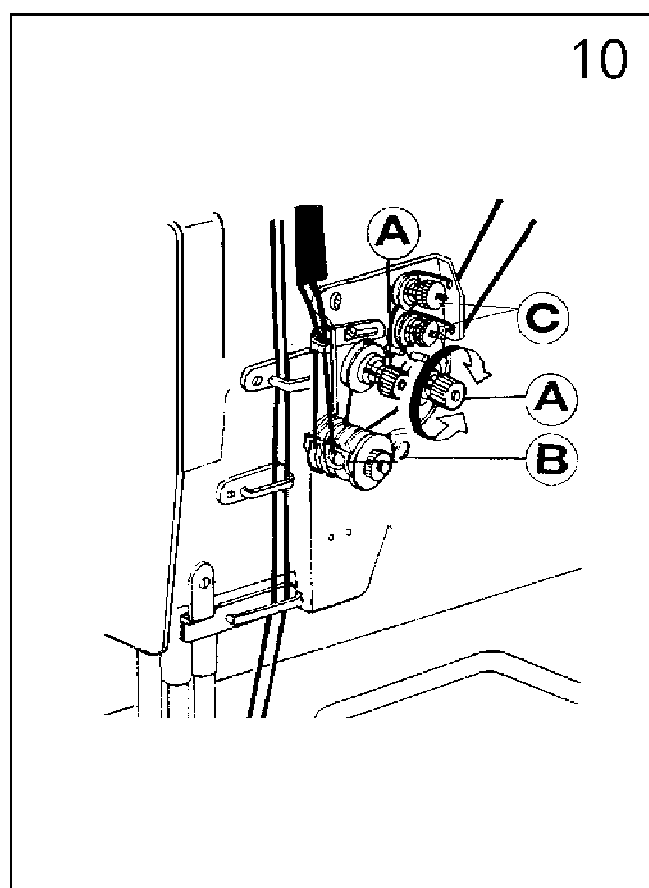
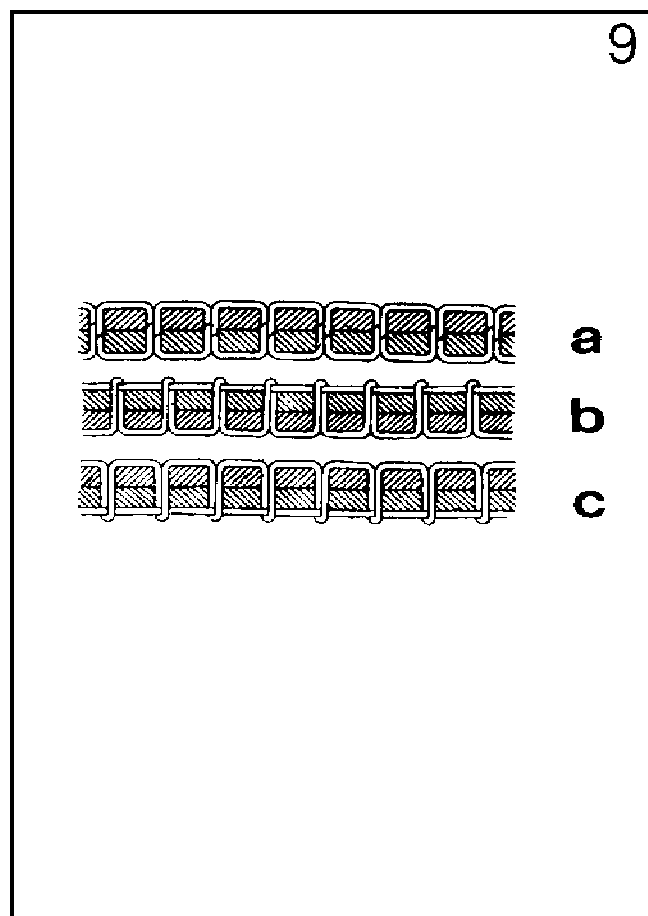
All forms of stitches are shown in Fig. 9. The normal stitch of sewing machine is shown as Fig. a. If stitch is abnormal as Fig b, c the puckering and thread breakage will occur, and the needle thread tension and bobbin thread tension should be adjusted so that the normal stitch can be obtained.

As adjusting needle thread, first adjust bobbin thread as Fig. 10

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. 11

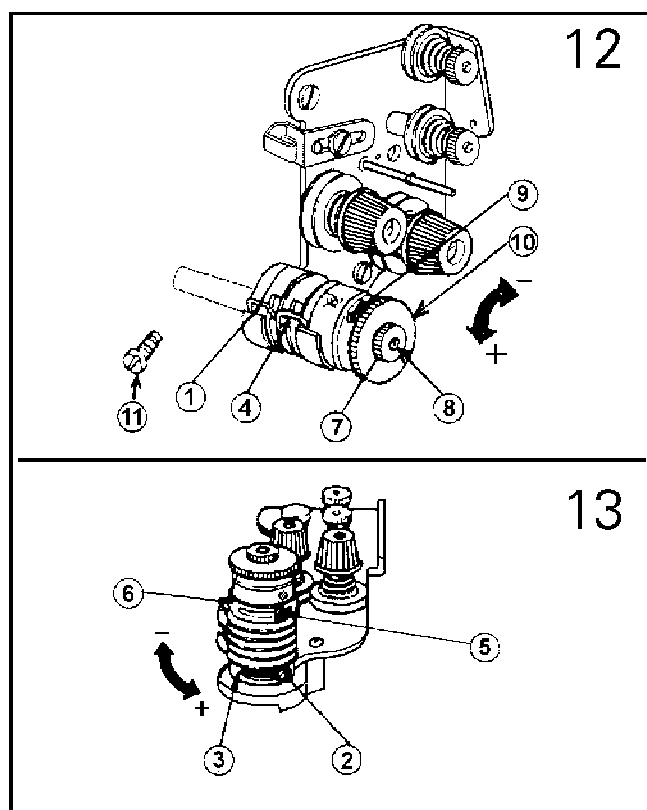


Adjusting thread take – up spring swing range

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.

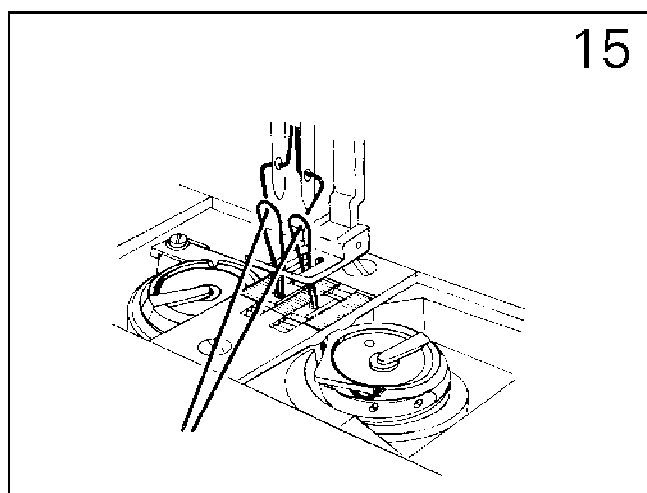
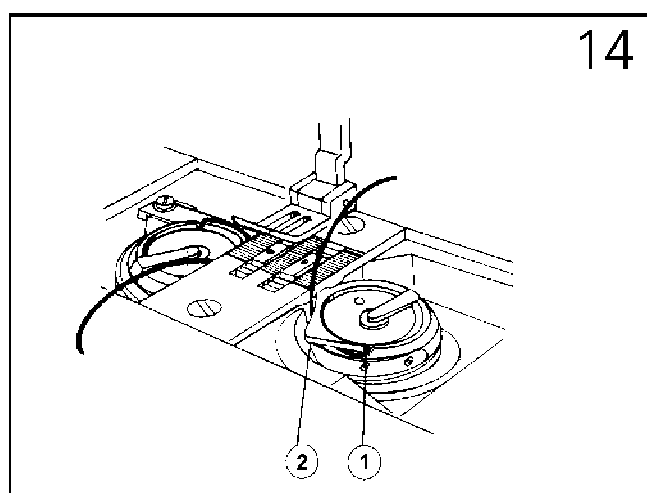


Adjusting thread position according to the sewing material. .

	Left	Middle	Right
Thread guide position			
Sewing material	Heavy	Medium	Light

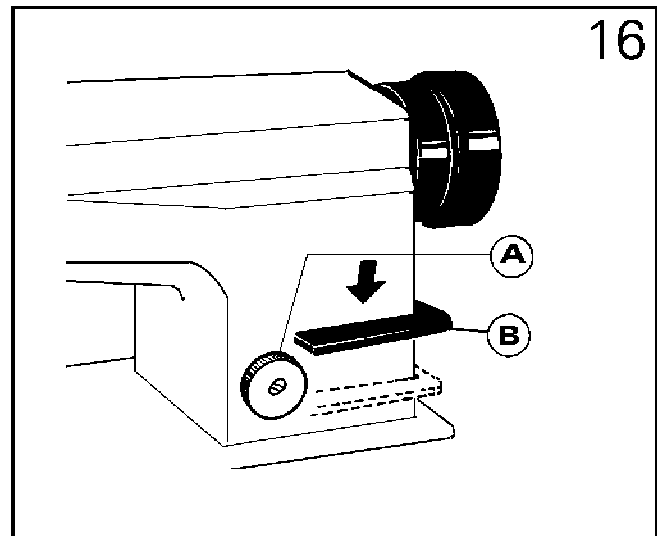
10. THE BOBBIN THREAD THROUGH AND OUT THE HOOK (FIG. 14, 15)

1. Pass the thread end though 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 (FIG. 16)

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 reverse feed lever (B) is released.

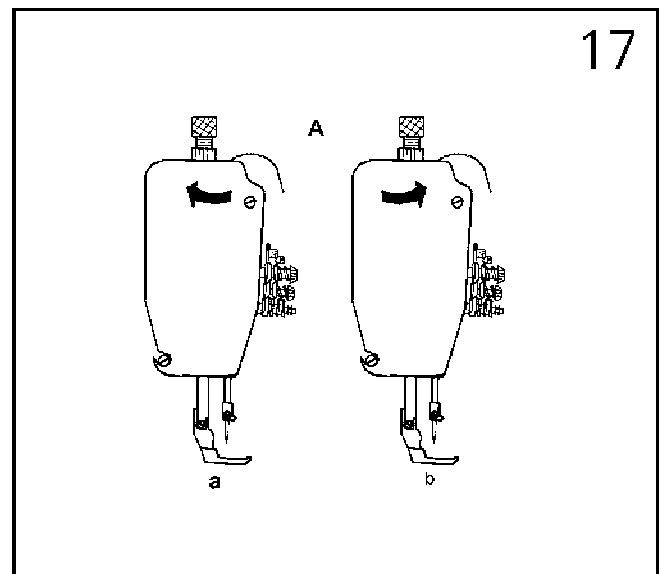


12. ADJUSTING THE PRESSURE OF PRESSER FOOT (FIG. 17)

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

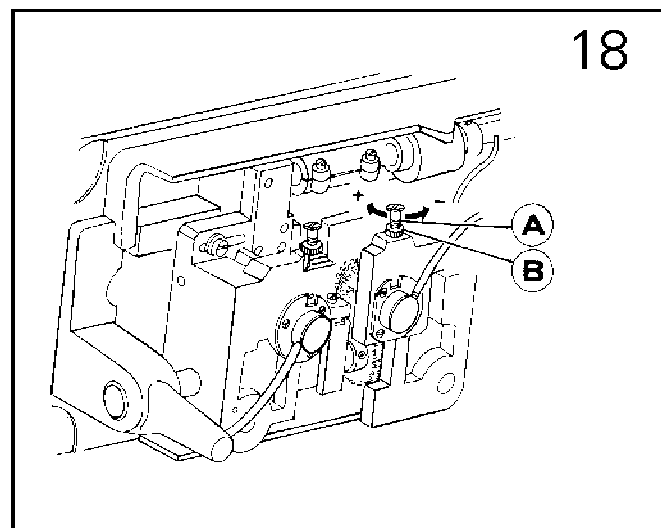
If stitch on heavy -duty material, the pressure should be increased and turn the pressure adjusting screw as Fig. a, if reduce the pressure as Fig. b

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



13. HOOK OIL AMOUNT ADJUSTMENT (FIG. 18)

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.

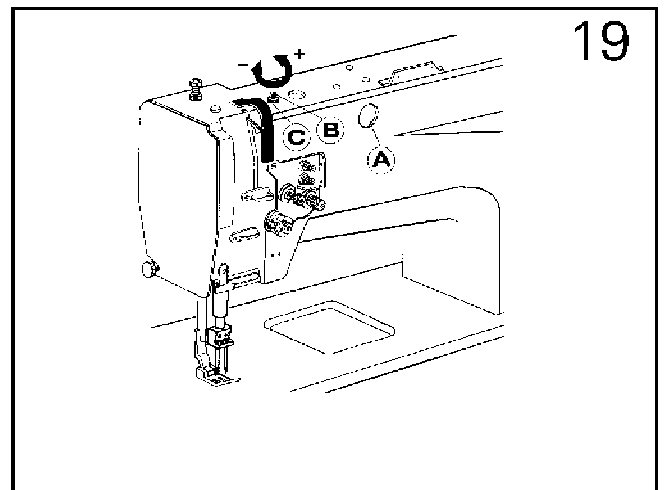


14. OILING EXAMINATION AND TAKE – UP LEVER OILING (FIG19)

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

Adjustment oiling of take – up lever:

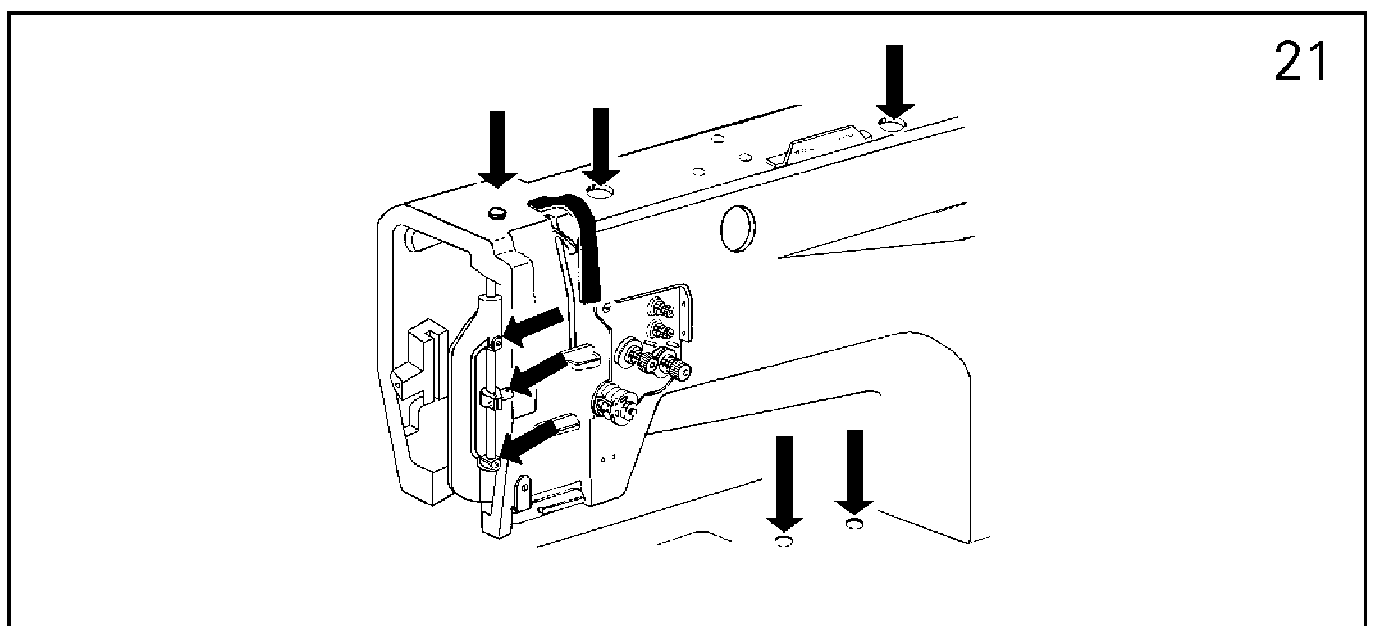
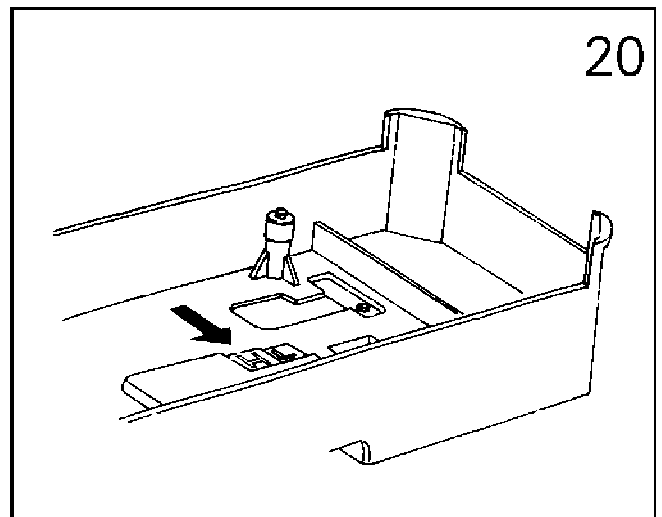
Loosen Screw C, turn Screw B as Fig, then tension Screw C.



15. LUBRICATING (FIG20. 21)

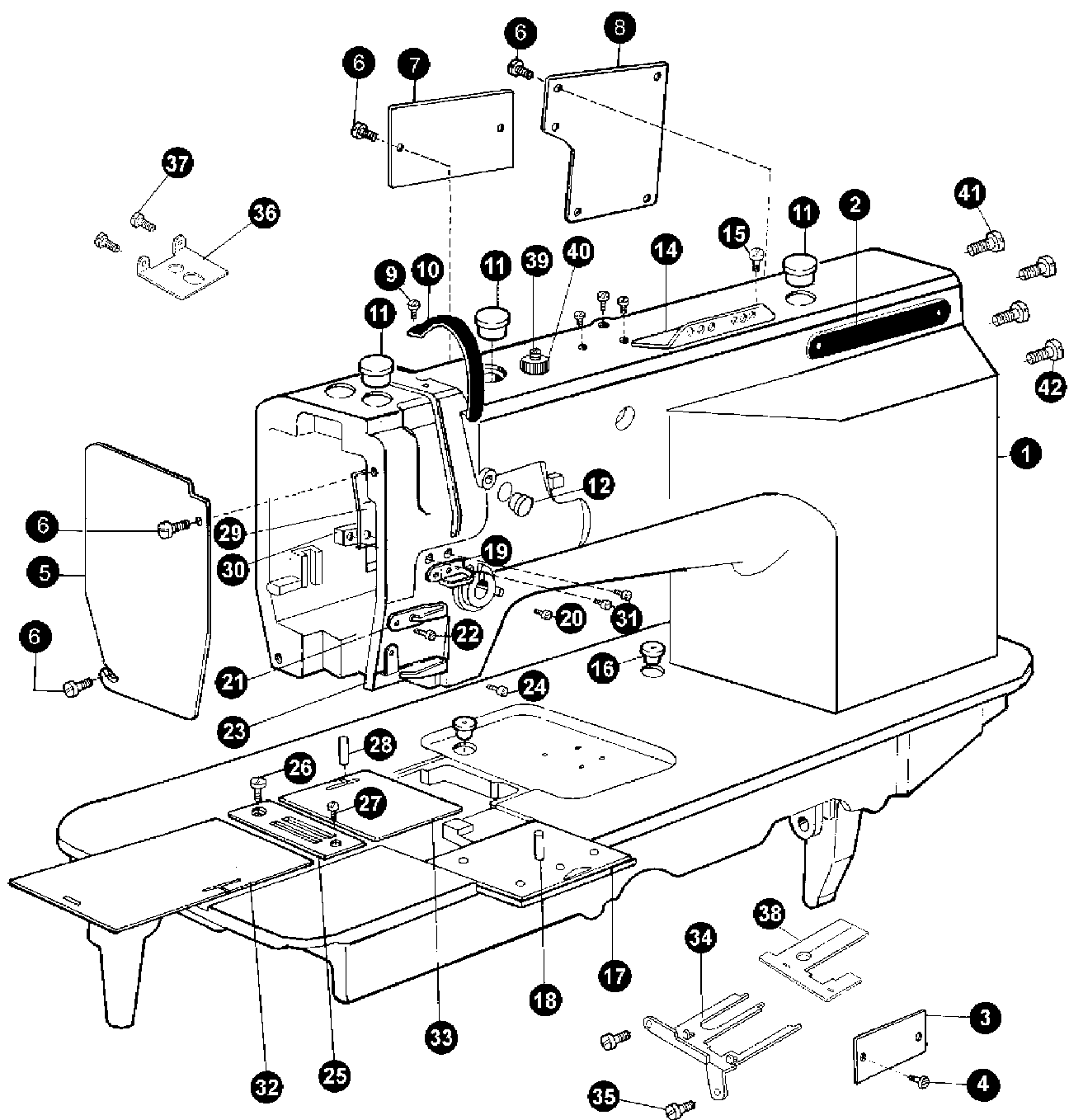
Fill oil (1) Oil amount should be filled according to the marks in the oil reservoir. Mark (H) refers to the highest of oil amount. Please check the oil amount after some time running, if oil amount low mark L, please fill additional oil to mark H. (please use machine oil No. 18)

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.



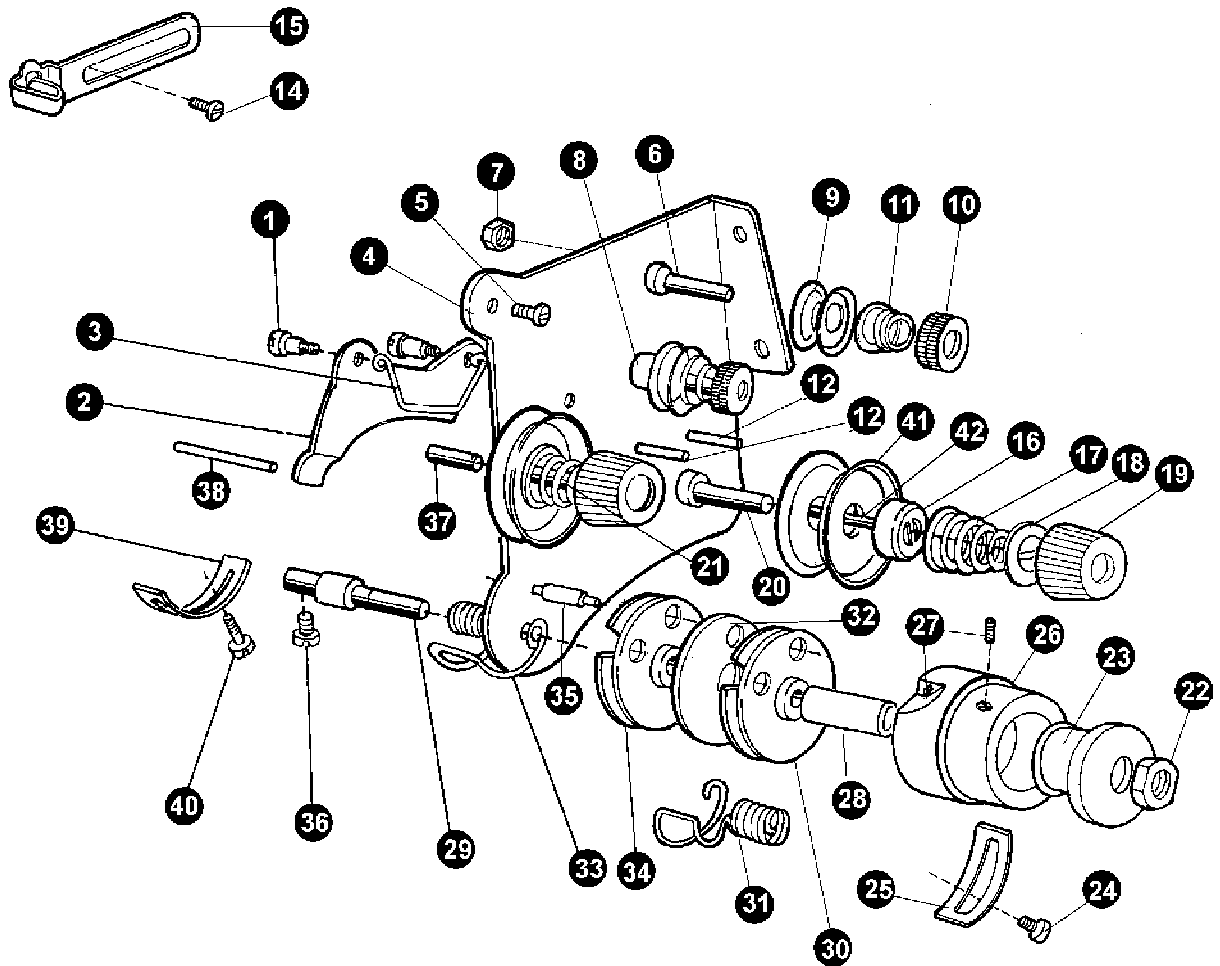
TROUBLE SHOOTING

Description	Cause	Remedy
Needle. skip	1. Needle bent Needle doesn't fit thread 2. Insufficient insertion of needle Wrong direction of needle eye Wrong installation of needles	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
Thread float	1. Needle thread tension is too weak 2. Thread take up is too weak 3. Bobbin thread tension is too weak	Adjust the tension Turn the pressure adjusting lever right for more pressure Tighten the bobbin case spring
Thread breakage	1. Thread quality is bad 2. Needle bent Wrong installation of needle Needle is slimmer than thread 3. Needle thread tension is too strong 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	Replace with fine thread Replace needle Reset the needle according the requirements Use the needle that fit 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
Puckering	1. Thread is too thick. compared with materials 2. Bobbin and needle thread tension is too strong 3. The pressure adjusting screw loose	Replace with proper needle, thread Adjust with thread tension nut, thread take –up spring Turn the pressure adjusting screw loose



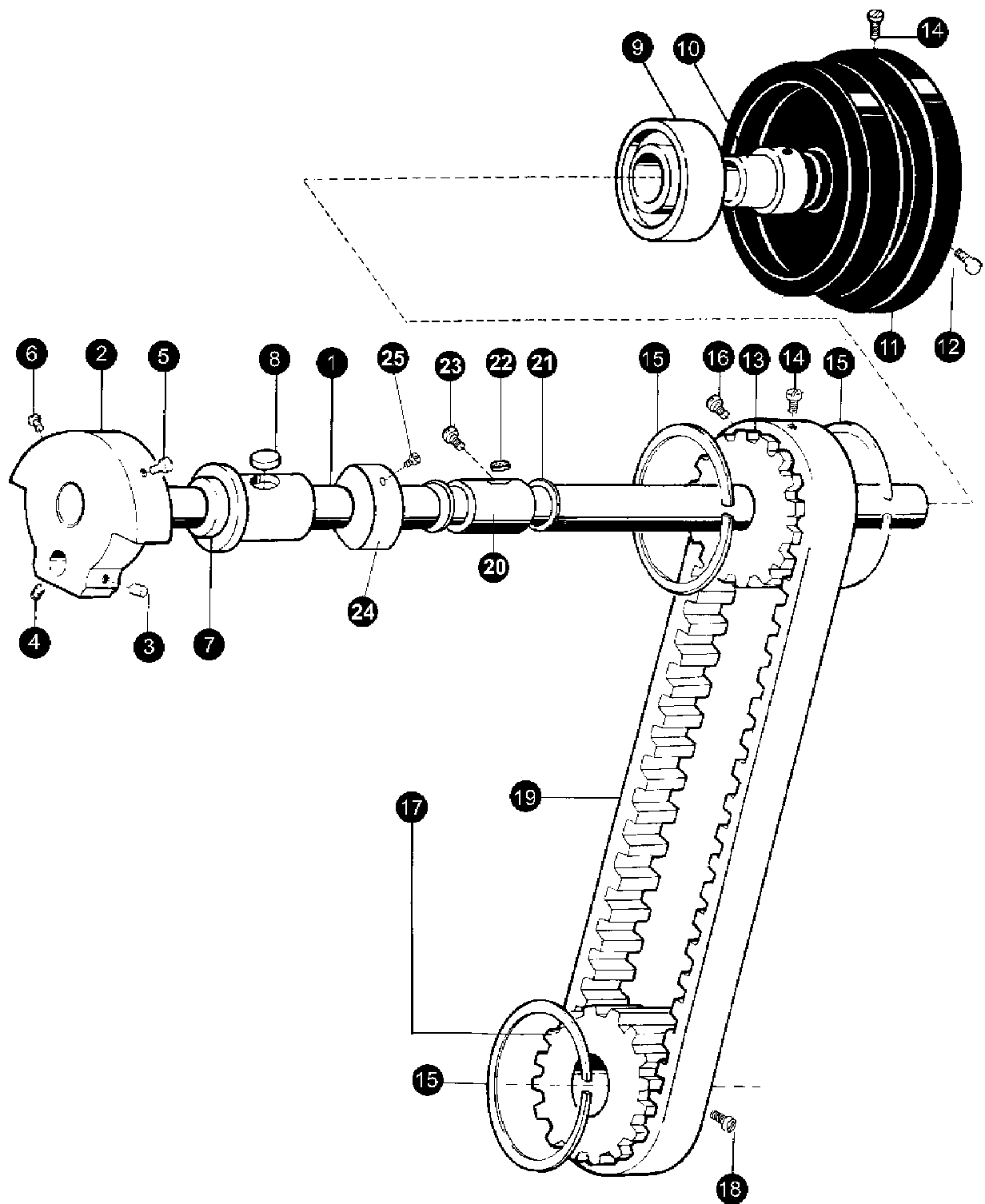
1. MACHINE ARM PARTS(1)

No	Ret . No .	Description	Qt	
			M	B
1	142110000	Machine are assembly	1	1
	142110002	Machine arm	1	1
	142110004	Machine bed	1	1
	58T1 – 001A3	Screw	3	3
	58T1 – 001A4	Hexagonal screw	1	1
	GB117 – 76	Pin	2	2
2	179100001	Model plate		1
	142100001	Model plate	1	
3	179100002	Tradel mark plate		1
	142100002	Tradel mark plate	1	
4	GB827 – 86	Screw	4	4
5	142100005	Face plate	1	1
6	GB818 – 85	Screw	11	11
7	142100006	Side cover	1	1
8	142100008	Back front side cover	1	1
9	58T1 – 005	Screw	1	1
10	58T1 – 009	Thred takeup level guard	1	1
11	58T1 – 010	Rubber plug(13)/5	3	3
12	58T1 – 012	Rubber plug(13)/3	3	3
14	58T1 – 013	Upper thread guide plate	1	1
15	36T2 – 005	Screw	2	2
16	58T1 – 015	Oil plug	2	2
17	58T1 – 016B	Front sliding plate fittings	1	1
	58T1 – 016B1	Front sliding plate	1	1
18	58T1 – 016B2	Screw	1	1
	58T1 – 016B3	Spring for front sliding plate	1	1
	22T1 – 021G3	Screw	1	1
19	142100003	Upper thread guide	1	1
20	58T1 – 020	Screw	1	1
21	142100007	Middle thread guide	1	1
22	58T1 – 020	Screw	1	1
23	142120000	Lower thread guide assembly	1	1
24	58T1 – 022	Screw	1	1
25	59T1 – 003	Throat plate		1
	58T1 – 023	Throat plate	1	
26	58T1 – 024	Screw	1	1
27	58T1 – 025	Screw	1	1
28	58T1 – 026	Set pin	1	1
29	58T1 – 027	Oil retainer	1	1
30	58T1 – 028	Bracket for oil retainer	1	1
31	58T1 – 018	Screw	2	2
32	58T1 – 029	Left sliding plate	1	1
33	58T1 – 030	Right sliding plate	1	1
34	142100010	Middle oil retainer	1	1
35	58T6 – 005	Screw	2	2
36	142100004	Lower oil retainer	1	1
37	GB818 – 85	Screw	2	2
38	142100009	Oil felt	1	1
39	142100011	Screw	1	1
40	142100012	Nut	1	1
41	22T8 – 009	Screw(big)	2	2
42	22T1 – 006	Screw(small)	2	2



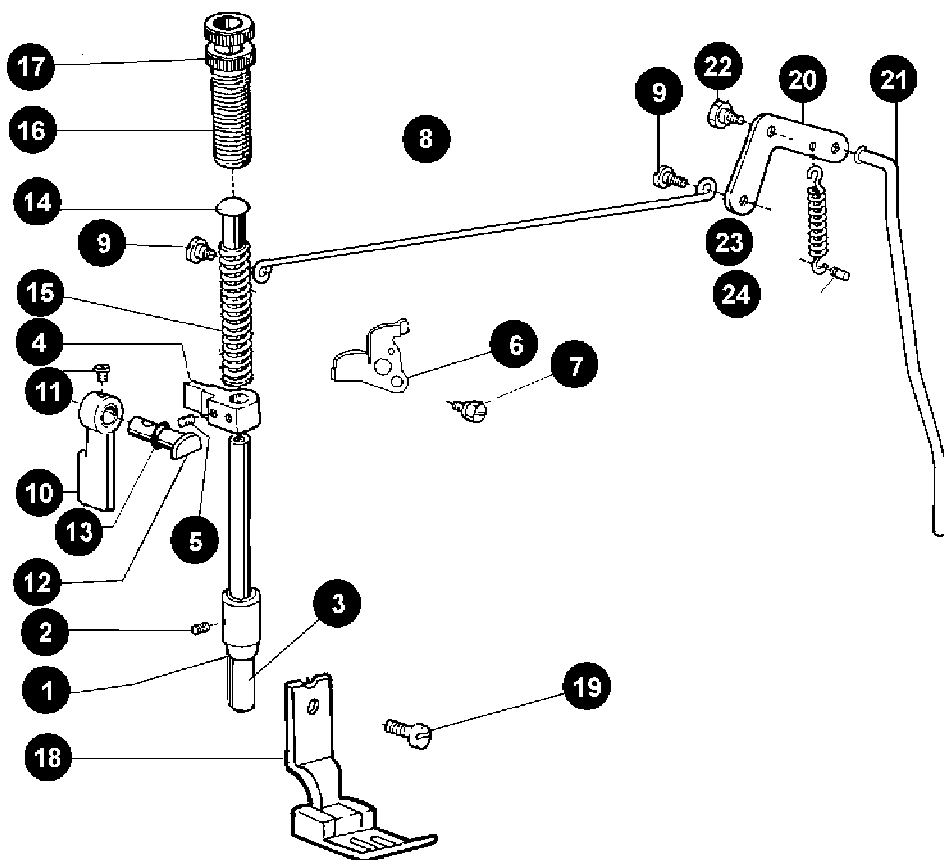
2. MACHINE ARM PARTS(2)

No	Ref. No .	Description	Qt	
			M	B
1	58T1 – 031C17	Screw	2	2
2	142130002	Thread adjusting plate	1	1
3	142130003	Spring	1	1
4	142131001	Thread tension set plate	1	1
5	58T1 – 005	Screw	1	1
6	142130004	Screw	1	1
7	142130005	Nut	2	2
8	142130006	Screw	1	1
9	22T1 – 009E3	Thread tension discs	4	4
10	36T2 – 006D4	Nut	2	2
11	142130010	Spring	2	2
12	142130011	Thread guide pin	3	3
14	22T1 – 003C6	Screw	1	1
15	142130013	Thread catching hook	1	
	179130001	Thread catching hook		1
16	22T1 – 012F4	Thread releasing discs	2	2
17	22T1 – 012F3	Thread tension spring	2	2
18	22T1 – 012F10	Stopping board	2	2
19	22T1 – 012F2	Nut	2	2
20	142130018	Screw	1	1
21	142130019	Screw	1	1
22	142130020	Nut	1	1
23	142130021	Socket	1	1
24	58T1 – 034	Screw	1	1
25	142130023	Stopping block	1	1
26	142130024	Guide socket	1	1
27	60T3 – 001A11	Screw	2	2
28	142130026	Shaft socket	1	1
29	142130027	Spring	1	1
30	142132000	Thread guide plate assembly	1	1
31	142132001	Thread takeup spring	1	1
32	142132002	Thread guide plate	1	1
33	142132003	Thread takeup spring	1	1
34	142133000	Thread guide plate assembly	1	1
35	124130030	Screw	1	1
36	58T6 – 005	Screw	1	1
37	142130028	Thread guide nail	1	1
38	142130029	Thread adjusting pin	1	1
39	58T1 – 033	Stop plate for thread takeup spring	1	1
40	58T1 – 034	Screw	1	1
41	22T1 – 012F5	Thread tension discs	4	4
42	142130017	Thread guide nail	1	1



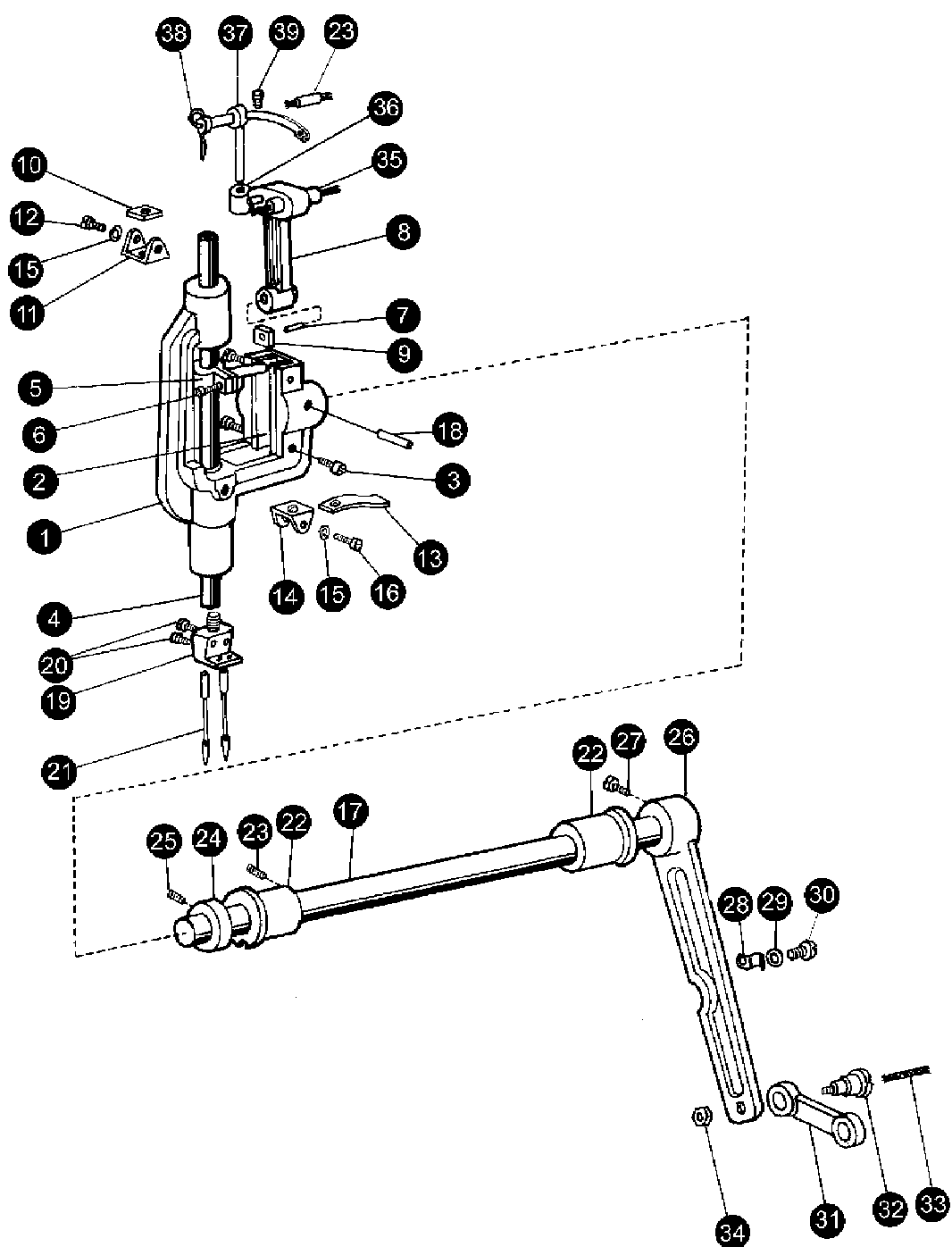
3. PRESSER FOOT LIFT PARTS(1)

No	Ref . No .	Description	Qt	
			M	B
1	142210000	Upper shaft fittings	1	
	179210000	Upper shaft fittings		1
	142210001	Upper shaft	1	1
2	58T2 -001A2a	Needle bar crank fittings	1	
	59T2 -001A1a	Needle bar crank fittings		1
	58T2 -001A2a1	Needle bar crank	1	
	59T2 -001A1a1	Needle bar crank		1
3	22T2 -005B2	Set screw	1	1
4	58T2 -001A2a3	Tension screw	1	1
5	22T2 - 007	Set screw	1	1
6	22T2 -006	Tension screw	1	1
7	58T2 -002B	Upper shaft left bushing fittings	1	1
	58T2 -002B1	Upper shaft left bushing	1	1
8	58T2 -002B2	Oil felt for left bushing	1	1
9	58T2 -004C	Upper shaft bearing fittings	1	1
	GB277 -89	Ball bearing	1	1
	58T2 -004C1	Stop ring	1	1
10	58T2 -004C2	Upper shaft right bushing	1	1
11	142200001	Balance wheel	1	1
12	22T3 -007C2	Screw	2	2
13	58T2 -006E	Upper shaft cog wheel fittings	1	1
	58T2 -006E1	Upper shaft cog wheel	1	1
14	22T5 -013	Set screw	1	1
15	58T2 -006E3	Spring stop ring	3	3
16	22T5 -010D4	Tension screw	1	1
17	142230000	Lower shaft cog wheel fittings	1	1
	142230001	Lower shaft cog wheel	1	1
18	22T5 -001A4	Tension wheel	2	2
19	58T2 -008	Cog belt	1	
20	142220000	Upper shaft middle shaft sheath assembly	1	
	142220001	Upper shaft middle shaft sheath	1	
21	22T3 -006F	Oil seal	1	
22	58T2 -002B2	Oil felt	1	
23	58T4 -011F2	Screw	1	
24	15620001	Balance roll	1	1
25	22T5 -010D4	Screw	2	2



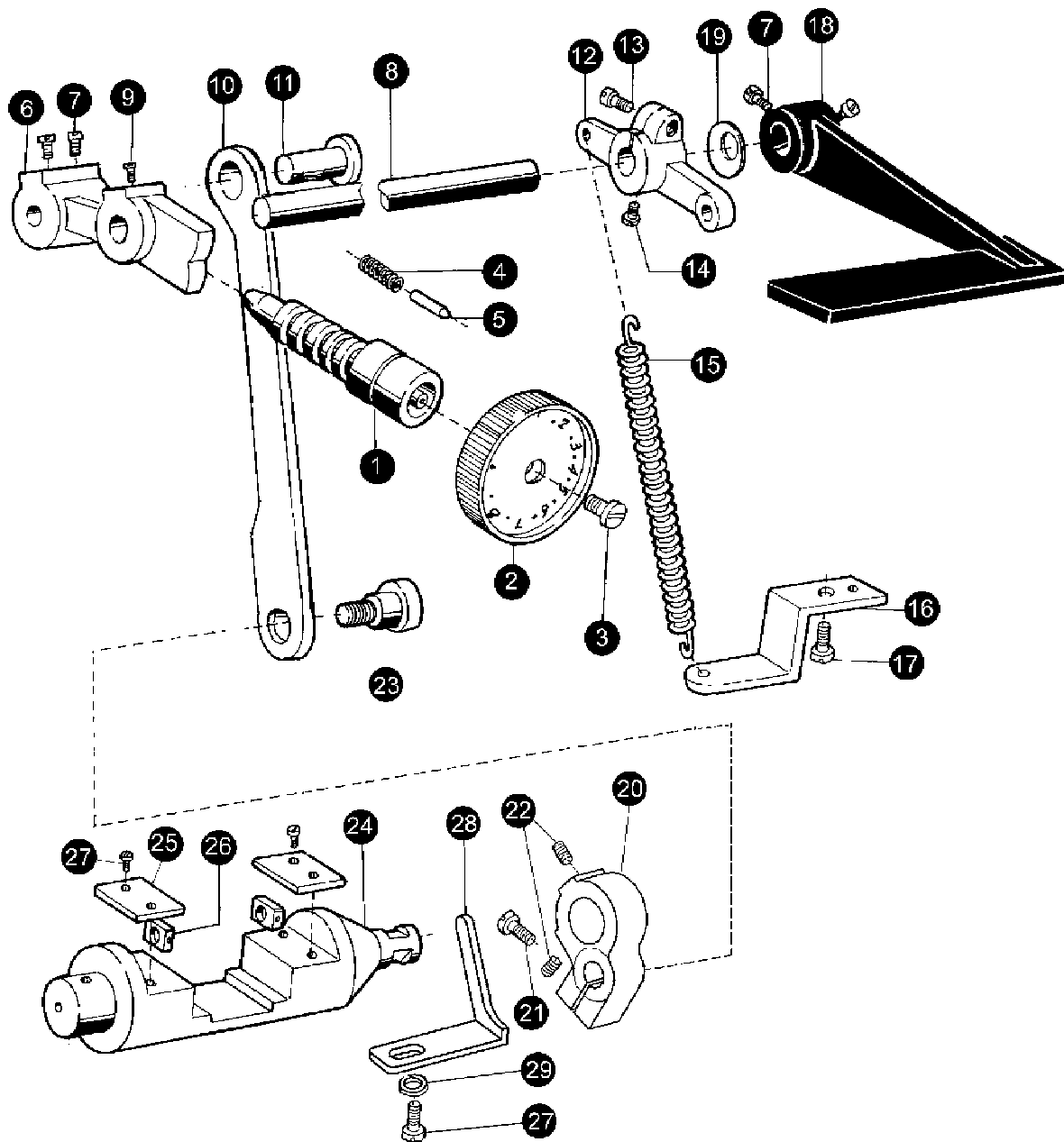
4. RESSER FOOT LIFT PARTS(2)

No	Ref . No .	Description	Qt	
			M	B
1	142200003	Presser bar bushing	2	2
2	58T2 – 003	Screw	1	1
3	142200004	Presser bar	1	1
4	142240001	Presser bar guide	1	1
5	22T5 – 001A4	Tension screw	1	1
6	142200005	Thread releasing plate	1	1
7	22T7 – 005	Tension screw	1	1
8	142200006	Presser lift lever	1	1
9	22T7 – 004B2	Screw	2	2
10	22T7 – 001A1	Presser lift lever	1	1
11	22T1 – 006	Screw	1	1
12	142200007	Lifting cam	1	1
13	GB1235 – 76	Seal	1	1
14	22T7 – 012	Guide stud	1	1
15	48T7 – 002	Coil spring	1	1
16	22T7 – 014E1	Screw	1	1
17	22T7 – 014E2	Nut	1	1
18	58T2 – 023I	Presser foot assembly	1	
	59T2 – 002B	presser foot assembly		1
	58T2 – 023I1	Presser foot handle	1	1
	58T2 – 023I2	Presser foot spring	1	1
	58T2 – 023I3	Presser foot pin	1	1
	58T2 – 023I4	presser foot bed	1	
	59T2 – 002B1	presser foot bed		1
19	58T2 – 024	Screw	1	1
20	22T7 – 007C1	Knee lift crank	1	1
21	142200009	Lever	1	1
22	22T7 – 005	Screw	1	1
23	22T7 – 007C2	Spring	1	1
24	22T7 – 008	Spring pin	1	1
25	22T1 – 007	Washer	1	1



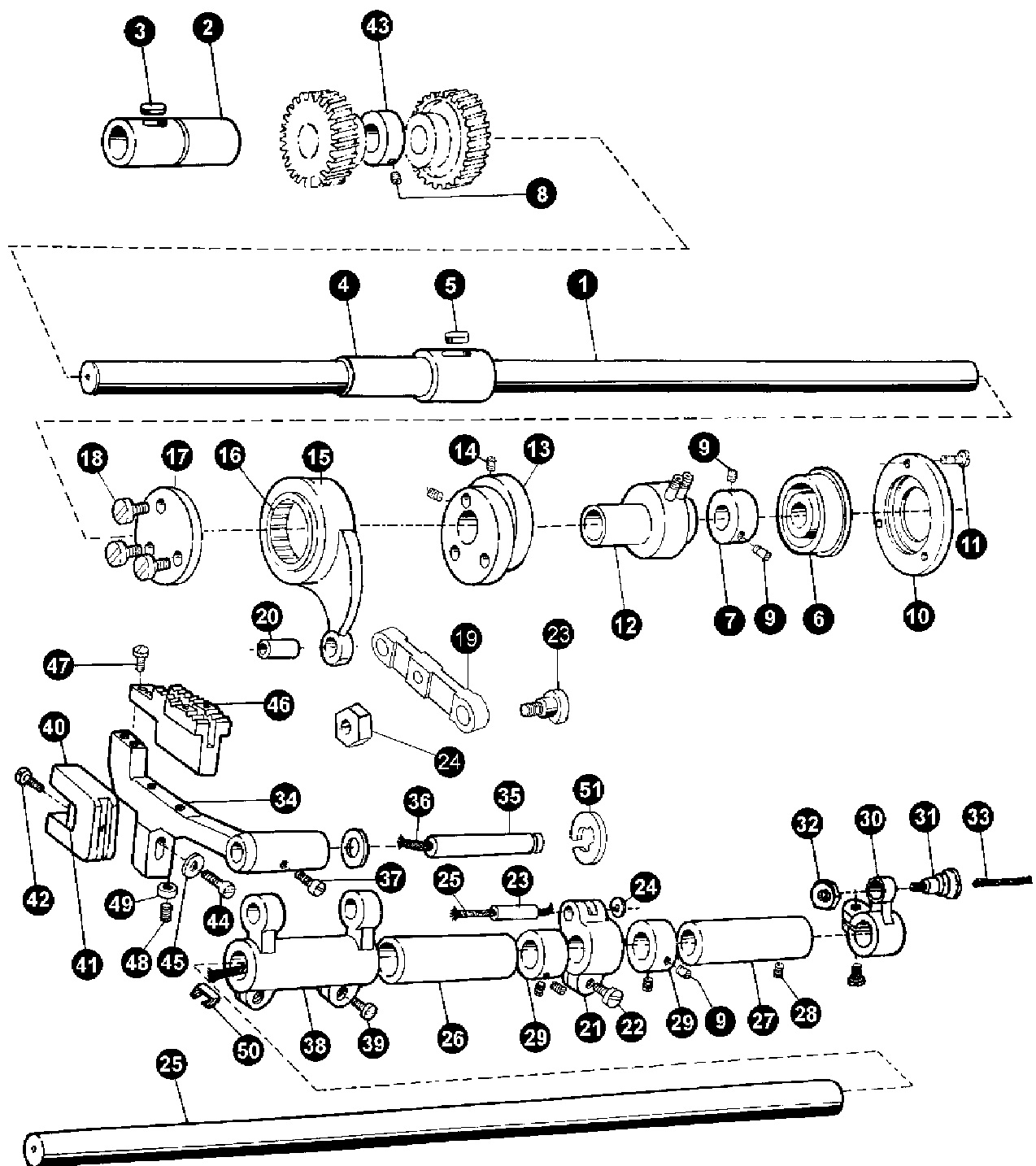
5. NEEDLE BAR AND THREAD TAKE – UP PARTS

No	Ret . No .	Description	Qt	
			M	B
1	58T3 – 001A1a1	Needle bar rock frame	1	1
2	58T3 – 001A1a2	Sliding block guide	2	2
3	58T3 – 001A1a3	Screw	4	4
4	58T3 – 001A1a4	Needle bar	1	1
5	58T3 – 001A1a5	Needle bar adapter	1	1
6	36T5 – 008E7	Screw	1	1
7	58T7 – 019	Oil wick	1	1
8	142310001	Needle bar link	1	1
9	58T3 – 001A1a7	Sliding block	1	1
10	58T3 – 001A2	Felt	1	1
11	58T3 – 001A3	Holder	1	1
12	58T3 – 001A4	Screw	2	2
13	58T3 – 001A5	Felt	1	1
14	58T3 – 001A6	Holder	1	1
15	GB848 – 85	Washer	4	4
16	58T3 – 001A7	Screw	2	2
17	58T3 – 001A8	Needle bar vibrating shaft	1	1
18	GB117 – 76	Pin	1	1
19	58T3 – 001A9b1	Needle clump	1	1
20	58T3 – 001A9b2	Screw	2	2
21	58T3 – 001A10	Needle	2	2
22	58T3 – 002	Bushing	2	2
23	142322002	Rubber pipe line	1	1
24	58T3 – 003B	Collar fitting	1	1
	58T3 – 003B1	Collar	1	1
25	22T1 – 011	Screw	2	2
26	58T3 – 004C	Needle bar vibrating shaft link fitting	1	1
	58T3 – 004C1	Link	1	1
27	58T3 – 004C2	Screw	1	1
28	58T3 – 004C3	Pipe clamp	1	1
29	GB93 – 76	Washer	1	1
30	58T3 – 004C4	Screw	1	1
31	58T3 – 005	Link	1	1
32	58T3 – 006D	Screw fitting	1	1
	58T3 – 006D1	Screw	1	1
33	58T7 – 019	Oil wick	1	1
34	58T3 – 007	Nut	1	1
35	58T3 – 008E	Needle bar crank pin fitting	1	1
	58T3 – 008E1	Needle bar crank pin	1	1
	58T7 – 019	oil wick	1	1
36	142321000	Thread takeup link bushing assembly	1	1
	142321001	Thread takeup link bushing	1	1
	58T7 – 019	Oil wick	1	1
	58T3 – 009F1a2	Plug	1	1
37	142320003	Thread takeup lever	1	
	59T3 – 002B1	Thread takeup lever		1
38	142322000	Pin shaft fittings for thread takeup lever	1	1
	142322001	Shaft for thread takeup lever	1	1
	58T7 – 007D1 – 4	Oil pipe	1	1
	58T7 – 019	Oil wick	1	1
39	22T3 – 007C2	Screw	3	3



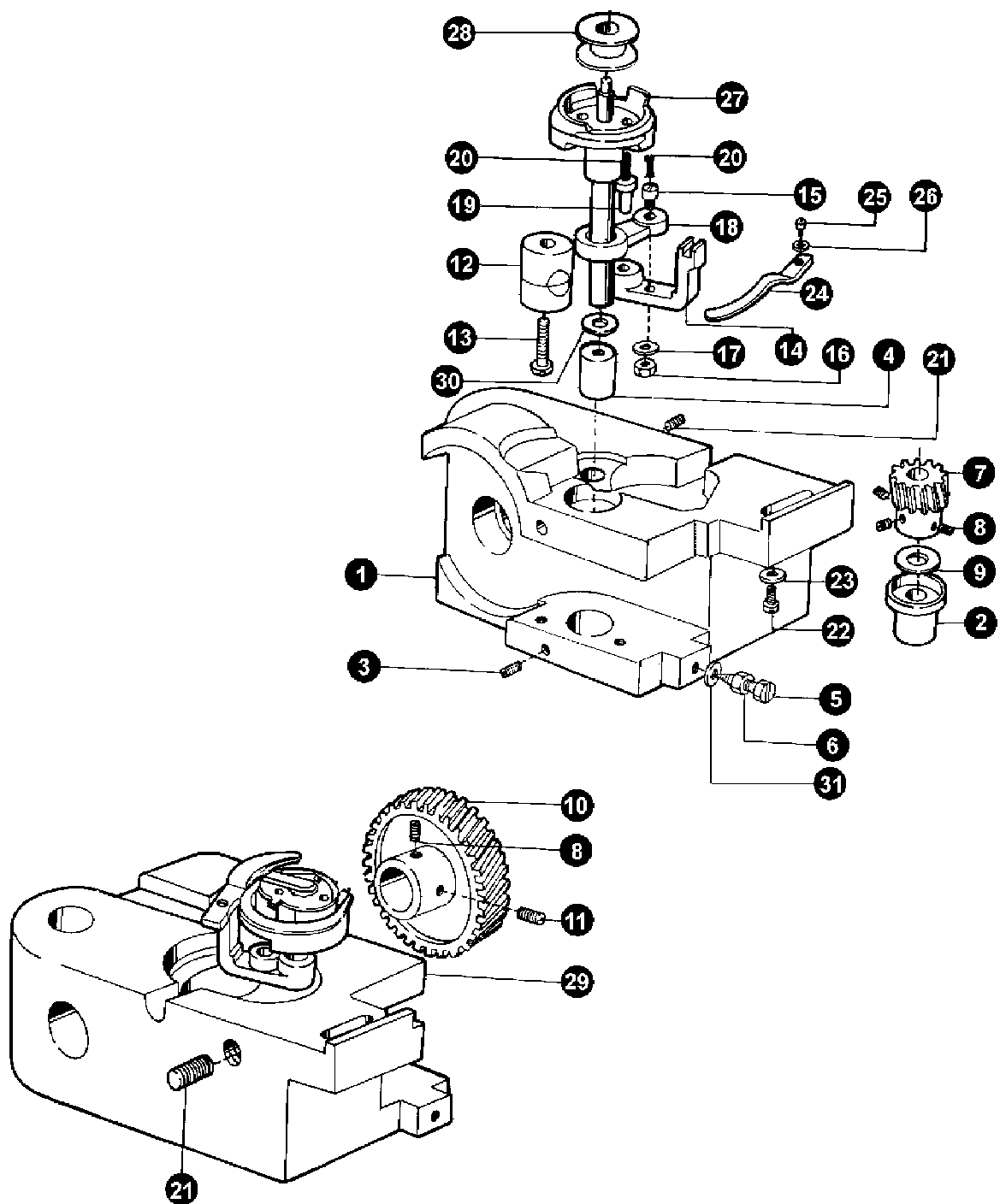
6. STITCH LENGTH ADJUSTING PARTS

No	Ret . No .	Description	Qt	
			M	B
1	59T4 -001A	Stitch length adjusting head screw fittings		1
	22T5 -006C1	Stitch length adjusting head screw	1	
	22T5 -006C4	O - type ring	1	1
2	59T4 -001A1	Dial		1
	57T5 -002A1	Dial	1	
3	36T5 -007D5	Screw	1	
	58T4 -001A2	Screw		1
4	58T4 -002	Coil spring	1	1
5	58T4 -003	stop pin	1	1
6	142410001	shaft for reverse sewing lever	1	1
7	22T5 -010D4	Screw	4	4
8	142400001	Reverse sewing shaft	1	1
9	58T4 -006	Screw	1	1
10	142420001	Stitch length link	1	1
11	142430002	Shaft	1	1
12	58T4 -008D1	Crank for reverse sewing	1	1
13	58T4 -008D2	Screw	1	1
14	58T4 -008D3	Screw	1	1
15	58T4 -008D4	Spring	1	1
16	58T4 -009	Bracket for coil spring	1	1
17	58T1 -005	Screw	1	1
18	58T4 -010E1	Reverse sewing lever	1	1
19	22T5 -011	Washer	1	1
20	142430001	Stitch length adjusting crank	1	1
21	GB70 -85	Screw	1	1
22	GB77 -85	Screw	2	2
23	22T6 -007	Shaft for stitch length adjusting crank	1	1
24	142440001	Reverse sewing adjusting stand	1	1
25	142440002	Guide plate for sliding block	2	2
26	142440003	Sliding block	2	2
27	58T1 -005	Screw	5	5
28	142440004	Bracket	1	1
29	142440005	Washer	1	1



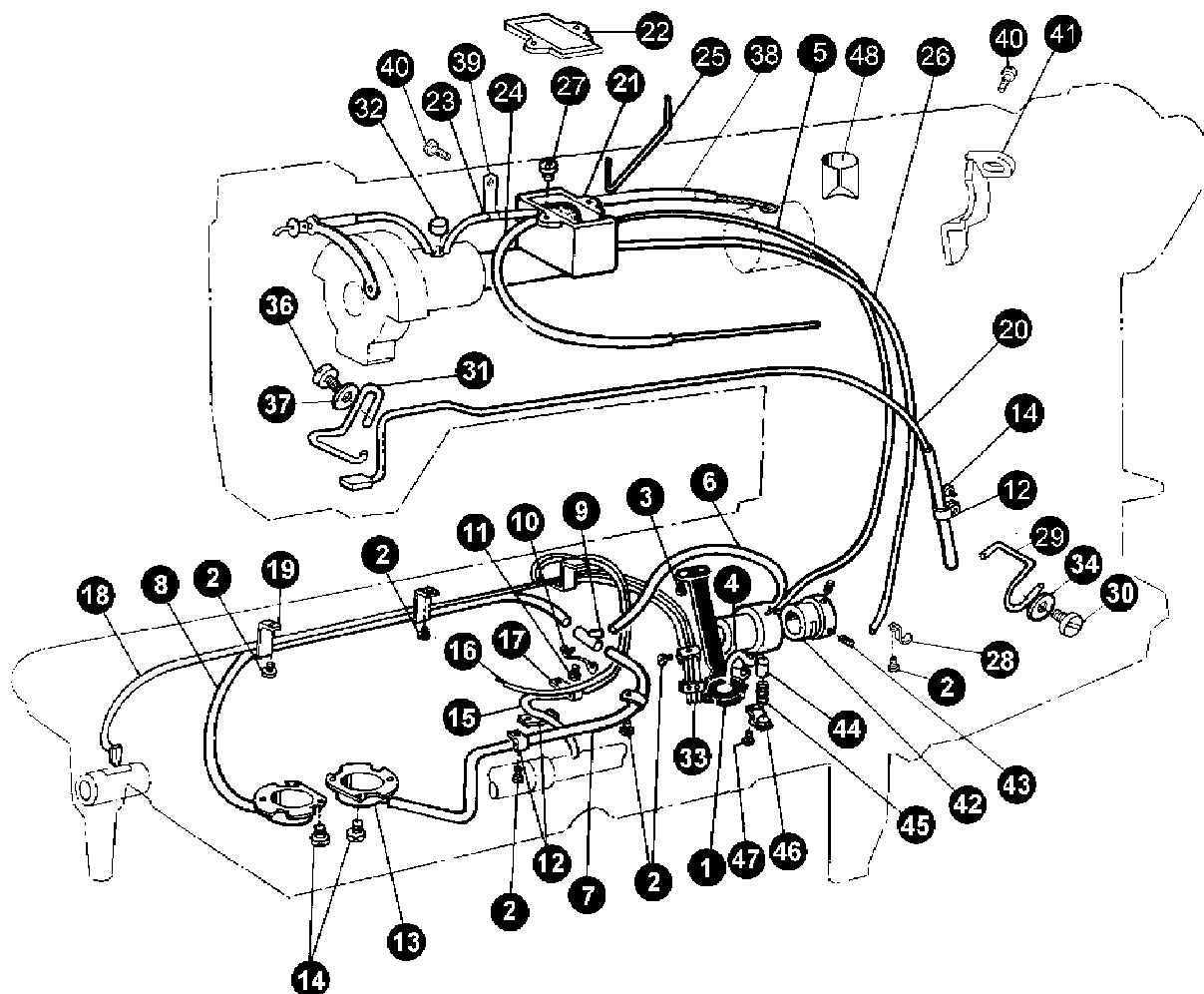
7. LOWER SHAFT AND FEED PARTS

No	Ret . No .	Description	Qt	
			M	B
1	142500001	Lower shaft	1	1
2	142510001	Lower shaft left bushing	1	1
3	58T7 - 019	Oil wick	1	1
4	142520001	Lower shaft right bushing	1	1
5	58T7 - 019	Oil wick	1	1
6	142530000	Lower shaft bearing fittings	1	1
	GB277 - 89	Ball bearing	1	1
	58T5 - 004C1	Bearing stop ring	1	1
7	142530001	Inner bushing for bearing	1	1
8	58T5 - 004C3	Set screw	1	1
9	22T3 - 002B2	Screw	6	6
10	58T5 - 005	Lower shaft bearing holder	1	1
11	58T5 - 006	Screw	3	3
12	142540000	Lower shaft middle bushing assembly	1	1
	142540001	Lower shaft middle bushing	1	1
	22T4 - 007C2	Oil nozzle	3	3
13	179510001	Feed cam		1
	142560001	Feed cam	1	
14	58T5 - 012F2	Screw	2	2
15	142560002	Feed link	1	1
16	142560008	Needle bearing	1	1
17	142560003	Bracket	1	1
18	58T5 - 018T3	Screw	3	3
19	142560005	Feed link	1	1
20	142560006	Pin for feed link	1	1
21	142560009	Feed crank	1	1
22	58T4 - 008D2	Screw	2	2
23	142560007	Screw	2	2
24	58T2 - 030	Nut	2	2
25	58T5 - 013G	Feed rock shaft fittings	1	1
	58T5 - 013G1	Feed rock shaft	1	1
	58T5 - 013G2	Felt	2	2
	58T7 - 019	Oil wick	1	1
26	22T6 - 012	Left bushing for feed rock shaft	1	1
27	142500003	Right bushing for feed rock shaft	1	1
28	58T2 - 003	Screw	2	2
29	22T6 - 005B1	Collar	2	2
30	58T5 - 016I	Feed rock shaft right crank fittings	1	1
	58T5 - 016I1	Feed rock shaft right crank	1	1
	58T3 - 004C2	Screw	1	1
31	58T3 - 006D1	Screw	1	1
32	58T5 - 017	Nut	1	1
33	58T7 - 019	Oil wick	1	1
34	142570001	Feed dog stand	1	1
35	142580003	Crank shaft	1	1
36	58T7 - 019	Oil wick	1	1
37	GB77 - 85	Screw	1	1
38	142570004	Feed dog stand crank	1	1
39	22T6 - 001A1b	Screw	2	2
40	142571001	Feed dog fork	1	1
41	58T5 - 018J6a2	Oil felt	1	1
42	58T5 - 018J6a3	Screw	1	1
43	142571002	Feed dog lift cam	1	1
44	58T4 - 008D2	Screw	1	
45	BQ10024	Washer	1	
46	59T5 - 002B1	Feed dog		1
	58T5 - 018J7	Feed dog	1	
47	142500004	Screw	2	2
48	GB78 - 85	Screw	1	1
49	GB6170 - 86	Nut M3	1	1
50	22T6 - 015	Oil wick clamp	1	1
51	GB896 - 86 - 6	Ring	1	1



8. HOOK AND SADDLE PARTS

No	Ret . No .	Description	Qt	
			M	B
1	179611002	Right hook saddle		1
	142611002	Right hook saddle	1	
2	58T6 – 001A1a2	Lower shaft bushing	2	2
3	22T2 – 009	Screw	4	4
4	59T6 – 001A1a2	Upper shaft bushing		2
	58T6 – 001A1a4	Upper shaft bushing	2	
5	142611007	Screw	2	2
6	142611008	Nut	2	2
7	58T6 – 001A2b1	Spiral gear	2	2
8	22T3 – 002B2	Screw	8	8
9	58T6 – 001A3	Washer	2	2
10	1426120001	Spiral gear	2	2
11	58T6 – 001A4C2	Screw	2	2
12	58T6 – 001A6E1	Bushing	2	2
13	58T6 – 001A6E2	Screw	2	2
14	59T6 – 001A2b1	Bobbin case opener holder		2
	58T6 – 001A7F1	Bobbin case opener holder	2	
15	58T6 – 001A7F2	Screw	2	2
16	58T6 – 001A7F3	Nut	2	2
17	GB93 – 76	Washer	2	2
18	58T6 – 001A7F4	Link	2	
	59T6 – 001A2b2	Link		2
19	58T6 – 001A7F5 – 1	Pin	2	2
20	58T7 – 019	Oil wick	2	2
21	58T6 – 001A8	Screw	2	2
22	58T6 – 002	Screw	2	2
23	58T6 – 003	Washer	2	2
24	58T6 – 004	Opener	2	
	59T6 – 002	Opener		2
25	58T6 – 005	Screw	2	2
26	BQ10005	Washer	2	2
27	58T6 – 006	Hook fittings	2	
	59T6 – 003B	Hook fittings		2
28	58T6 – 007	Bobbin	2	
	59T6 – 004	Bobbin		2
29	142620000	Left hook saddle fittings	1	
	142620001	Left hook saddle	1	
	179620000	Left hook saddle fittings		1
	179620001	Left hook saddle		1
30	58T6 – 001A3 – 1	Hook adjusting shim	2	2
31	GB860 – 87	Washer	2	2

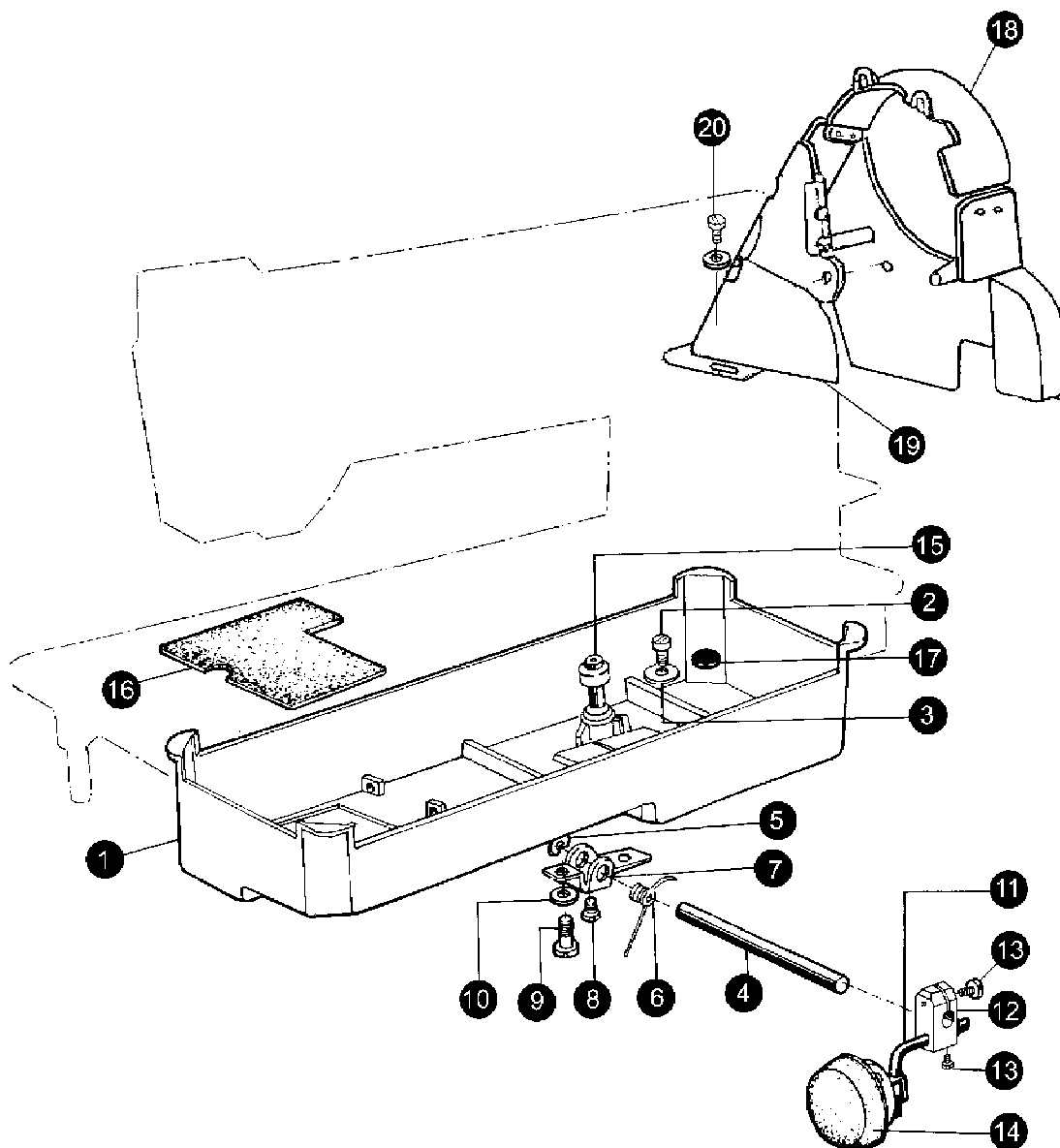


9. OIL LUBRICATION PARTS

No	Ret. No.	Description	Qt	
			M	B
1	142710000	Filter fittings	1	1
	142711000	Filter set plate assembly	1	1
	142711001	Filter set plate	1	1
	58T7-001A1a2	Oil pipe	1	1
	58T7-001A2	Filter	1	1
	58T7-001A3	Screw	1	1
	142711002	Filter holder	1	1
	58T7-001A5	Screw	1	1
	58T7-001A6	Oil pipe clamp	1	1
2	58T7-001A7	Screw	7	7
3	22T1-006	Screw	3	3
	22T1-007	Washer	3	3
4	58T7-003	Oil sucking pipe	1	1
5	142730004	Oil pipe	1	1
6	142720001	Oil pipe	1	1
7	142720002	Oil pipe for right hook saddle	1	1
8	58T7-003-4	Oil pipe for left hook saddle	1	1
9	58T7-004B1	3-mouth nozzle fittings	1	1
10	58T7-005	Nozzle holder	1	1

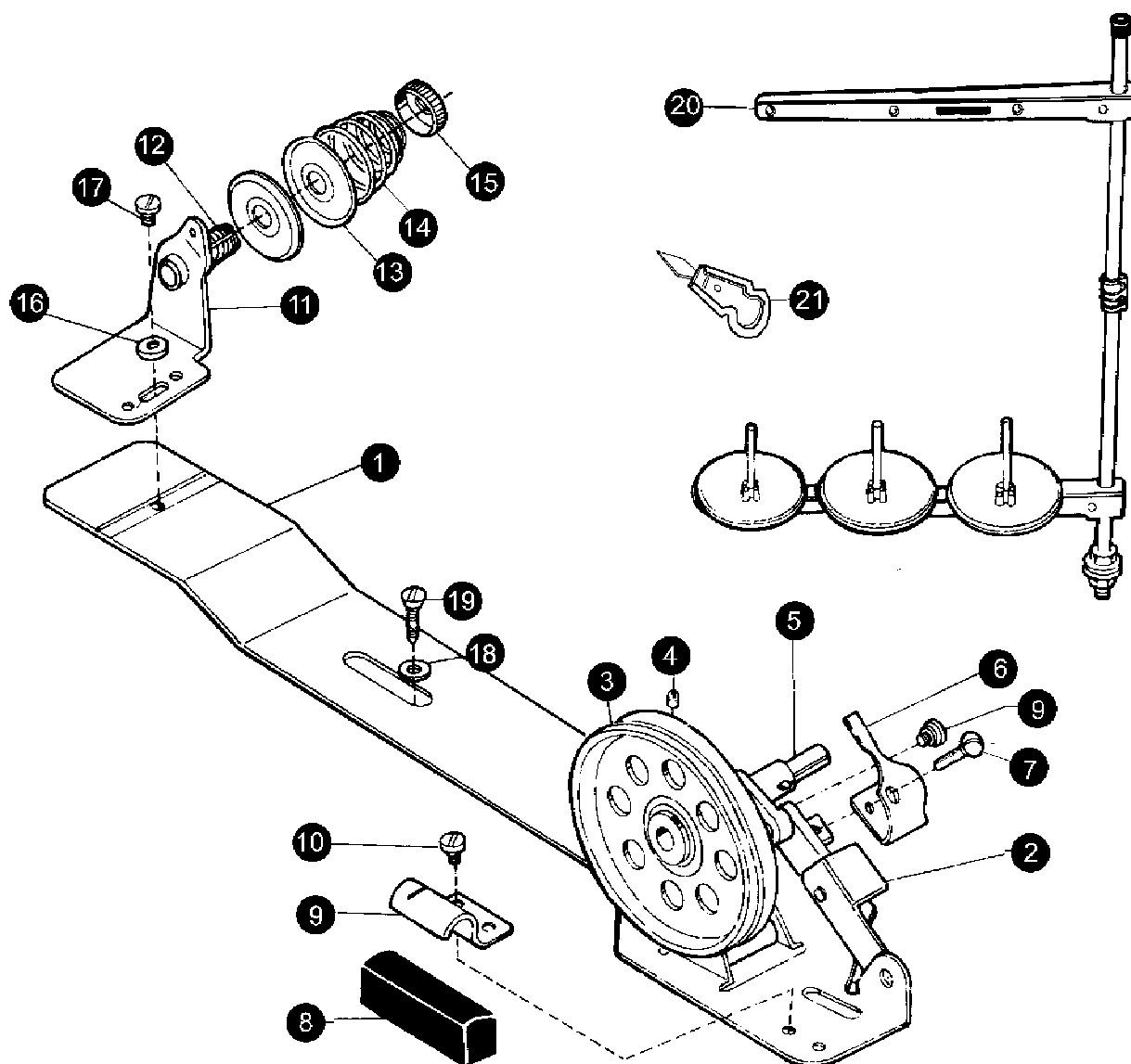
9. OIL LUBRICATION PARTS

No	Ret . No .	Description	Qt	
			M	B
11	58T1 – 022	Screw	1	1
12	58T3 – 004C3	Holder plate	4	4
13	58T7 – 006C	Oil cup assembly	2	2
	58T7 – 006C1	Oil cup for hook saddle	2	2
	22T4 – 007C2	Oil pipe	2	2
14	58T3 – 004C4	Screw	6	6
15	58T7 – 007D	Oil pipe fittings	1	1
	58T7 – 007D1	Oil pipe	1	1
	58T7 – 019	Oil wick	1	1
16	58T7 – 008E	Oil pipe fittings	1	1
	58T7 – 007D1 – 1	Oil pipe	1	1
	58T7 – 019	Oil wick	1	1
17	58T7 – 009	Oil pipe clamp	1	1
18	58T7 – 010F	Oil pipe fittings	1	1
	58T7 – 007D1 – 2	Oil pipe	1	1
	58T7 – 019	Oil wick	1	1
19	58T7 – 011	Oil pipe clamep	3	3
20	58T7 – 016H	Oil pipe fittings	1	1
	58T7 – 007D1 – 3	Oil pipe	1	1
	58T7 – 019	Oil wick	1	1
	58T7 – 016H1	Oil felt	1	1
21	58T7 – 012G1a	Oil cup assembly	1	1
	58T7 – 012G1a1	Oil cup	1	1
	58T7 – 012G1a2	Cover	1	1
	GB879 – 76	Pin	1	1
	GB52002	Hexagonal nut	1	1
22	142700001	Washer		
23	58T7 – 012G2b	Oil pipe fittings	1	1
	58T7 – 012G2b1	Oil pipe	1	1
	58T7 – 019	Oil wick	1	1
24	58T7 – 012G3C	Oil pipe fittings	1	1
	58T7 – 003 – 5	Oil pipe	1	1
	58T7 – 019	Oil wick	1	1
25	58T7 – 012G4	Press spring	1	1
26	58T7 – 012G5	Oil drain pipe	1	1
27	58T7 – 013	Screw	2	2
28	142700002	Pipe holder	1	1
29	142700003	Pipe holder	1	1
30	58T5 – 018J3	Screw	1	1
31	142700004	Spring	1	1
32	58T7 – 018	Felt	2	2
33	22T6 – 015	Pipe holder	1	1
34	BQ10009	Washer	1	1
36	GB818 – 85	Screw	1	1
37	BQ10009	Washer	1	1
38	142730002	Oil drain pipe	1	
39	142700007	Pipe holder	1	1
40	GB818 – 85	Screw	2	2
41	142700008	Oil holder	1	1
42	58T5 – 008E	Bushing fittings	1	1
	58T5 – 008E1	Bushing	1	1
43	58T5 – 008E2	Screw	2	2
44	58T5 – 009	Plug	1	1
45	58T5 – 010	Spring	1	1
46	58T5 – 011	Bracket for spring	1	1
47	58T3 – 001A7	Screw	1	1
48	142700005	Oil pipe	1	



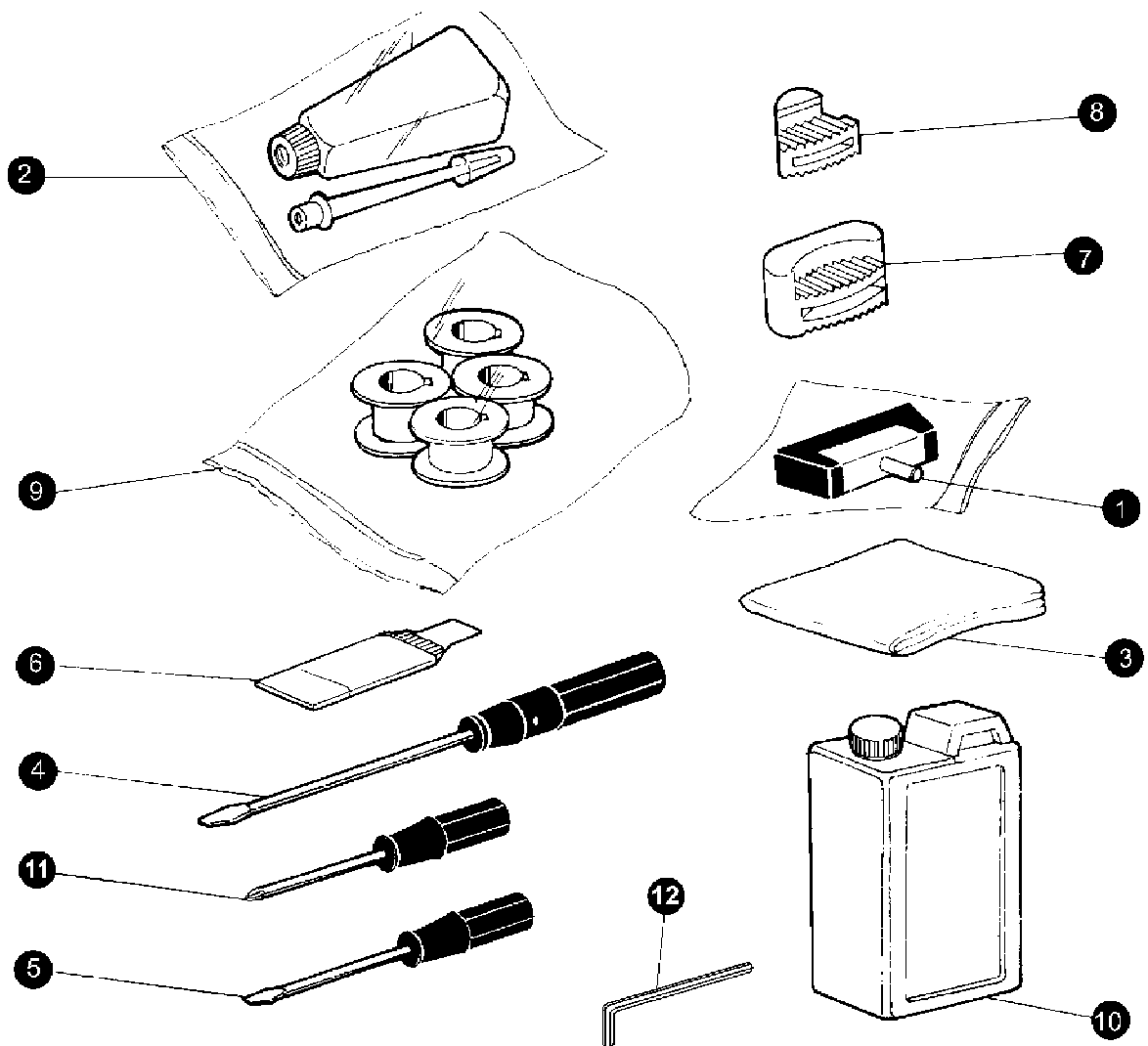
10. OIL RESERVOIR PARTS

No	Ret . No .	Description	Qt	
			M	B
1	58F0 – 001A1	Oil reservoir	1	1
2	22T9 – 001A2	Screw	1	1
3	22T9 – 001A3	Washer	1	1
4	58F0 – 001A2	Hinge pin	1	1
5	GB896 – 86	Split stop ring	1	1
6	22T9 – 001A7	Spring	1	1
7	58T8 – 001A4	knee lifter crank	1	1
8	22T9 – 003B4	Screw	1	1
9	22T9 – 001A9	Screw	1	1
10	22T9 – 001A10	Nut	1	1
11	22T9 – 003B2	Bell crank	1	1
12	22T9 – 003B3	Connector	1	1
13	GB5781 – 86	Screw	2	2
14	58F0 – 002	Pat bracket assembly	1	1
	22T9 – 003B5	Knee lifter pat	1	1
	22T9 – 003B6	Bracket for pat	1	1
	22T9 – 003B7	Screw	1	1
	22T9 – 003B8	Knee lifter pat mat	1	1
15	58F0 – 003B	Knee lifter lifting rod assembly	1	1
	58F0 – 003B1	Knee lifter lifting rod	1	1
	58F0 – 003B2	Cap for rod	1	1
16	58F0 – 004	Oil gasket	1	1
17	22T9 – 012	Magnetic block	1	1
18	124F10000	Belt cover assembly	1	1
19	124F20000	Belt cover assembly	1	1
20	GB99 – 76	Wooden screw	2	2



11. THREAD WINDER AND SPOOL STAND PARTS

No	Ret . No .	Description	Qt	
			M	B
1	6F0 - 001A	Thread winder stand assembly	1	1
	6F0 - 001A1	Thread winder stand	1	1
	6F0 - 001A2	Thread winder	1	1
	6F0 - 001A3	shaft for thread winder	1	1
	6F0 - 001A4	Spring	1	1
	6F0 - 001A5	Screw	1	1
2	6F0 - 001A6a	Thread winding adjusting lever assembly	1	1
	6F0 - 001A6a1	Thread winding adjusting lever	1	1
	6F0 - 001A6a2	Thread winding connecting lever	1	1
	6F0 - 001A6a3	Rivet	2	2
3	6F0 - 002	Pulley	1	1
4	22T1 - 011	Screw	1	1
5	6F0 - 003	Thread winding spindle	1	1
6	6F0 - 004 - 1	Bobbin winding stop latch	1	
	6F0 - 004 - 2	Bobbin winder stop latch		1
7	6F0 - 005	Screw	1	1
8	6F0 - 006	Spacer	1	1
9	6F0 - 007	Spacer holder	1	1
10	6F0 - 008	Screw	1	1
	BQ10008	Washer	1	1
	GB859 - 87	Washer	1	1
	GB859 - 87	Washer	1	1
11	6F0 - 009B1b1	Thread pass -by bracket	1	1
12	6F0 - 009B1b2	Screw	1	1
13	22T1 - 012F5	Thread tension discs	2	2
14	22T1 - 012F3	Spring	1	1
15	J2. 2. 7	Thumb nut	1	1
16	BQ10021	Washer	1	1
17	22T2 - 004	Screw	1	1
18	BQ10021	Washer	2	2
19	GB99 - 76	Screw	2	2
20	GXJ - 3	Spool stand assembly	1	1
21	58F0 - 007C	Thread tweezer complete	1	1



12. ACCESSORIES

No	Ret . No .	Description	Qt	
			M	B
1	22T9 – 007F	Hinge assembly	2	2
	22T9 – 007F1	Hinge	2	2
	22T9 – 007F2	Hinge socket	2	2
	22T9 – 023	Bay	1	1
2	22T9 – 011	Oil pot	1	1
3	22T9 – 018	Machine arm cover	1	1
4	22T9 – 013	Screwdriver	1	1
5	22T9 – 015	Screwdriver	1	1
6	DP x5 – 90	Needle	1	
	DP x5 – 110	Needle		1
7	22T9 – 009	Cushion	2	2
8	22T9 – 010	Cushion	2	2
9	59T6 – 004	Bobbin		4
	58T6 – 007	Bobbin	4	
	22T9 – 021	Bag	1	1
10	58F0 – 017	Oil tank	1	1
11		Cross – shaped screwdriver	1	1
12		Wrench	1	1

GC6220 series machine's main technical data

MODLE	GC6220M	GC6220B
APPLICITION	Light, Medium	Medium, Heavy
MAX. SPEED	4000/SPM	3000/spm
STITCH LENGTH	0 – 5/mm	0 – 7/mm
NEEDLE BAR STROKE	33.4mm	35mm
PRESSER FOOT LIFT	by hand /7/mm	
	by knee/13/mm	
NEEDLE	DP ×5(90)	DP ×5(110)
HOOK	standard vertical	Standard vertical
NEEDLE GAUGE	Standard: 6.4/mm	
SPECIAL SIZE	2.4 3.2 4.8 5.6 7.9 9.5 12.7 15.9 19.1 25.4 28.1 31.8mm (For special order)	

Two – needle high speed lockstitch sewing machine model GC6220M and GC6220B, are suitable for sewing shirt, unifrom, jeans, overcoat and other similar clothing. They have wide application the synchronized feed dog prevents the slippage of materials. They available for hing quality normal stitch and decorative seaming.

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

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