

SMA GC-0323

Operating Instructions and Parts List



SMA GC-0323 Semi-Long Arm Walking Foot Sewing Machine

Please Read and Save This
Instruction Manual Before Use

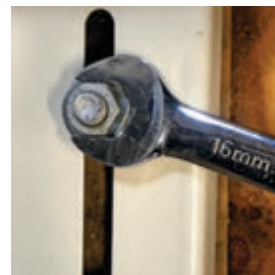
Receiving, Unpacking and Setting Up Your New Machine

UNPACKING

Unpacking your Bench and Stand

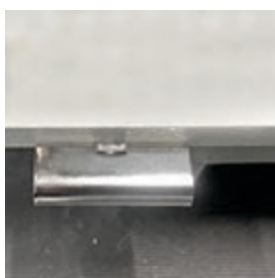
Remove clear wrap & cut straps

Remove the two 16mm transport bolts



Unpacking your Sewing Head

Insert the two pivot hinges at rear of machine before placing sewing head and belt in bench cutout



Connecting Belt & Footlift

CAUTION: 2 Person Operation : Sewing Head Is Heavy

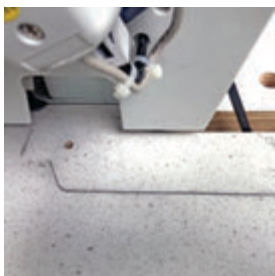
Push headrest into bench cutout, remove beltguard screws & attach belt, then tighten belt cover



Optional Servo Motor Pictured

Attaching Cotton Stand & Bobbin Winder & Guard to Bench

Place cotton stand in hole & tighten nut, attach bobbin winder & guard to bench with screws provided

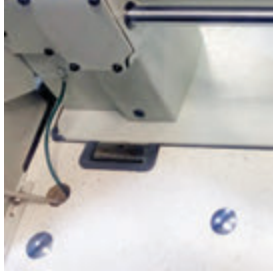


Receiving, Unpacking and Setting Up Your New Machine

UNPACKING

Connection Synchroniser & Earth (Optional)

Remove bubble wrap, pass cables through hole & connect to motor as shown

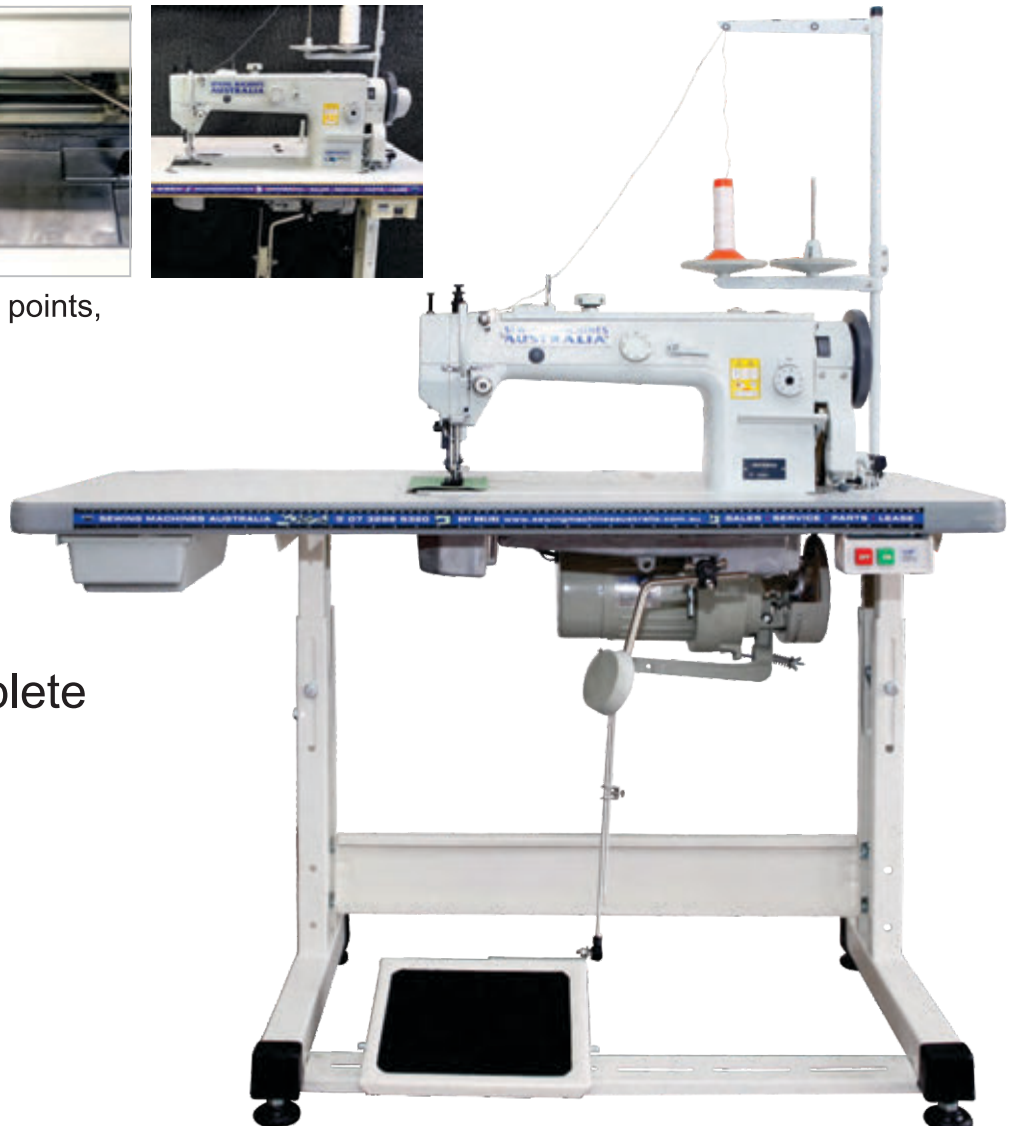


Oiling

Tilt sewing head back against head rest, fill oil to (High) level & place head back down on bench



For all non-pump related oiling points, please refer to manual



Unpacking Complete

Now that you've completed the unpacking and setting up of your new machine, make sure all packaging material is cleared from the area, connect to power and you're ready to start sewing.

Operating Instructions Maintenance and Safety

INTRODUCTION

IMPORTANT:

- Please ensure appropriate safety equipment and clothing is used at all times when operating or maintaining your machine.
- Only authorised personnel should be performing mechanical adjustments. For servicing, please return your machine to SMA or arrange for an on-site service.
- When cleaning, adjusting, oiling or performing any type of maintenance, your sewing machine should be turned off and the clutch motor must be completely wound down.

1 Brief Introduction

Model SMA GC0323 extra heavy-duty single needle top and bottom feed lockstitch sewing machine with large hook. With a special upper feed mechanism, the machine is ideal for medium weight materials, including canvas, shade cloth, PVC and webbing etc. not exceeding 5mm. It is widely used throughout the Canvas, Equine, Shade and Sails industries.

2 Operation and preparation

a. Cleaning Your Machine

Before delivery, the machine parts are coated with a rust preventive grease, which may harden and become contaminated by dust during storage and shipment. The grease and dust must be removed with a clean cloth prior to operation.

b. Cleaning Maintenance

All dust and foreign materials should be blown free from the machine at the end of each working day. At the end of each working week, a more thorough cleaning should be undertaken by removing any external covers and cleaning behind them.

c. Preparation

Your machine has been extensively tested and oiled prior to shipping and it is advisable to remove any external deposits prior to using the machine.

d. Examination

Though every machine is carefully inspected prior to shipping, some machine parts may become loosened or damaged during transit. A thorough examination must be performed after cleaning the machine. Ensure the power is turned off, then turn the balance wheel to see if there is any running obstruction, parts collision, uneven resistance or abnormal noise. If you are unsure, please contact SMA directly for assistance before operating the machine.

TECHNICAL SPECIFICATION

Model	SMA GC-0323
Max Sewing Speed	1800 s.p.m.
Max Stitch Length	9mm
Needle Bar Stroke	38mm
Thread Take-Up Lever Stroke	73mm
Lifting Amount Of Presser Foot	2.0mm - 5.5mm
Climbing Device	Dial Type
Needle Standard	135X17 #20 - #23
Needle Leather	135X16 #20 - #23
Lubrication	Automatic Lubrication
Clutch Motor	1/2Hp 1425 RPM
Servo Motor	Optional 3/4Hp

SMA GC0323

Single needle Top and Bottom Feed
Medium-duty Lockstitch Sewing Machine



Operating Instructions Maintenance and Safety

GETTING STARTED

3 Lubrication (Fig 1)

Tilt sewing head back against head rest. Oil level should be filled to the H (High) line in the sump casting and should be checked periodically.

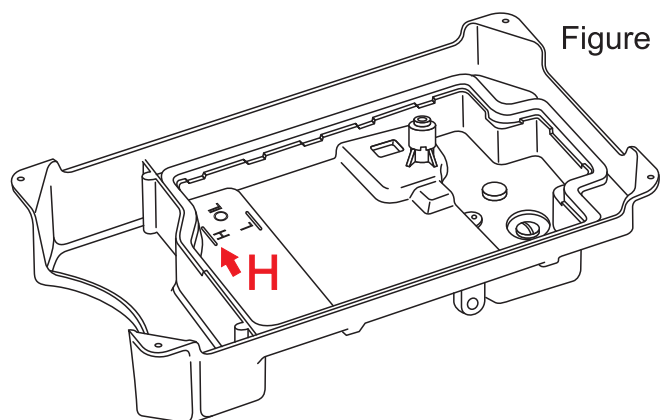
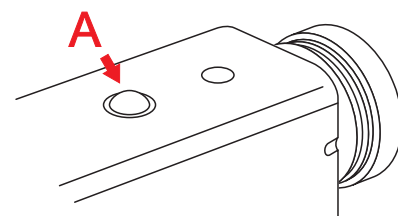


Figure 1

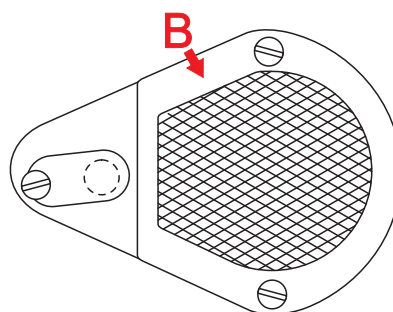
4 Oil Gauge

When the machine is running, you may notice a slight movement of oil in the observation window (A). The amount seen will depend on the running speed of the machine and at a very slow operating speed, may not be noticeable.



5 Oil Pump

Ensure Oil Pump Mesh (B) is clean and free of debris at all times to ensure adequate oil intake.



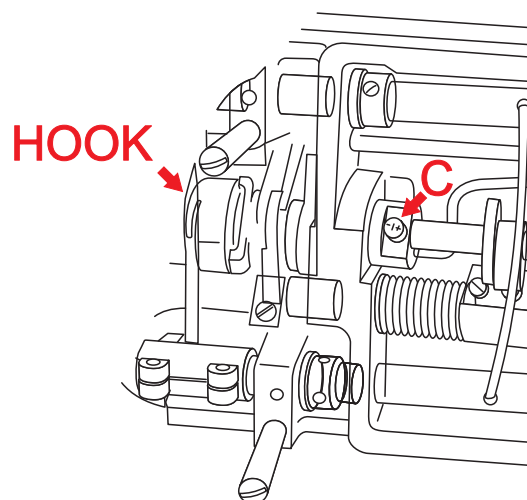
6 Rotary Hook Lubrication

Adjust the lubrication to the Rotary Hook by turning screw (C) Anticlockwise to Decrease and Clockwise to Increase. This is factory set.

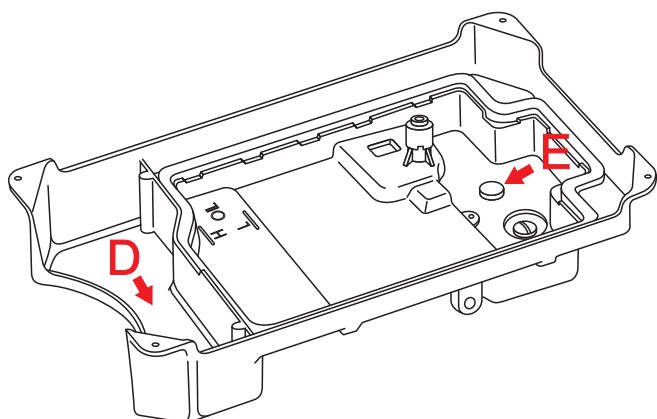
PLEASE NOTE:

A discharge of excess oil in Reservoir (D) should be cleaned periodically.

Magnet (E) will collect metallic floating debris.



DECREASE (⊖) INCREASE



Operating Instructions Maintenance and Safety

NEEDLES

7 Needle System

Please use the needle system 135X17 or 135X16 for leather. Needle size range #18/110 - #23/160. The needle size must be suitable for the materials sewn. Using the incorrect size needle will cause broken thread, skipping stitches and the breaking of needles. If the needle is too heavy, it will also damage the fabric. So please choose a suitable needle according to the materials being sewn.

Needles can be purchased directly from:
www.sewingmachinesaustralia.com.au.

8 Installing the needle (Fig 3)

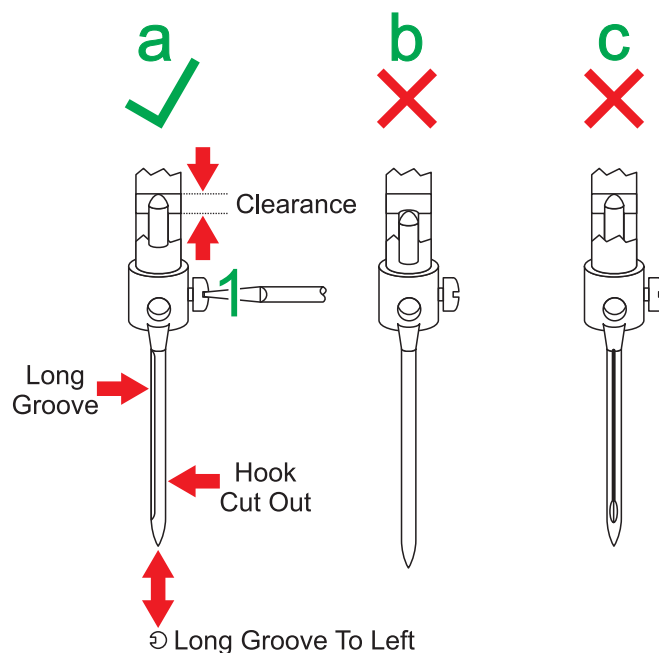
Ensure the power is turned off. Turn the balance wheel to lift needle bar to its highest position, loosen needle set screw (1), keeping the long groove of the needle facing to the left side of operator, then fully insert the needle shank upwards all the way until the needle stops. Lastly, tighten the screw (1) to secure the needle.

Note:

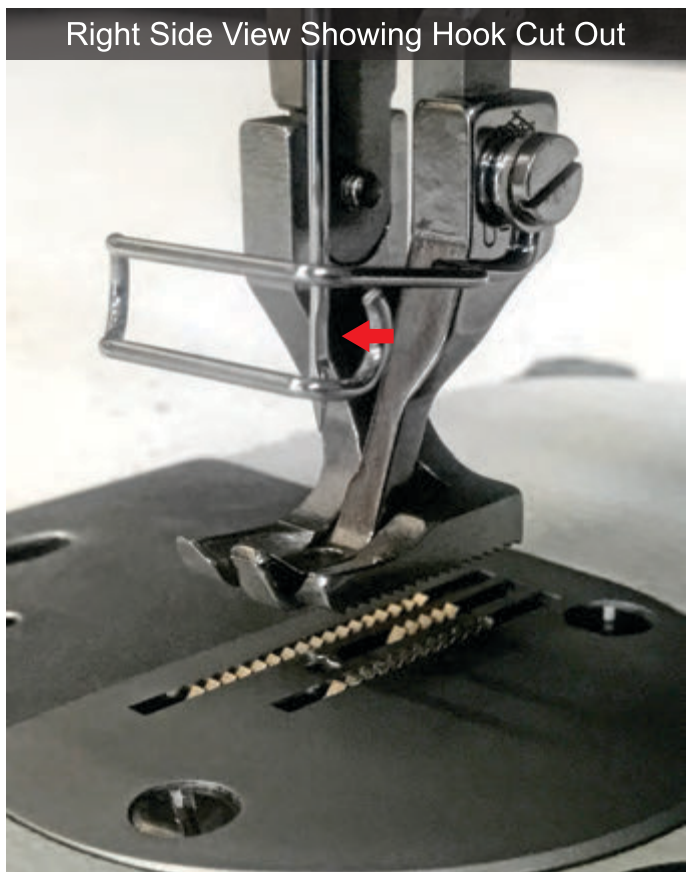
Fig b: not fully inserted/wrong direction of long groove and hook cut out.

Fig c: wrong direction of long groove and hook cut out.

Figure 3



Right Side View Showing Hook Cut Out



Front View Showing Needle Threading



Operating Instructions Maintenance and Safety

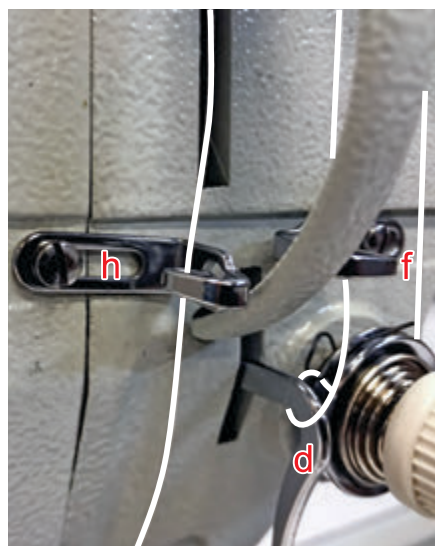
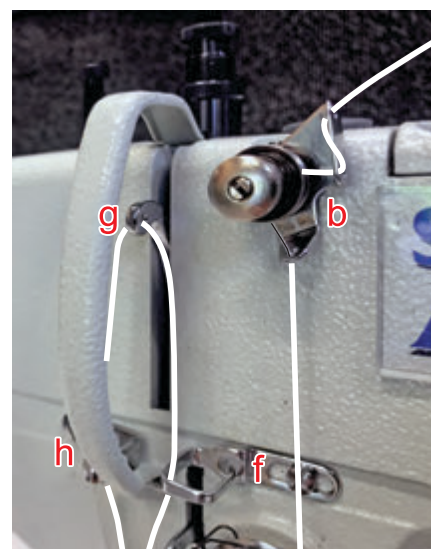
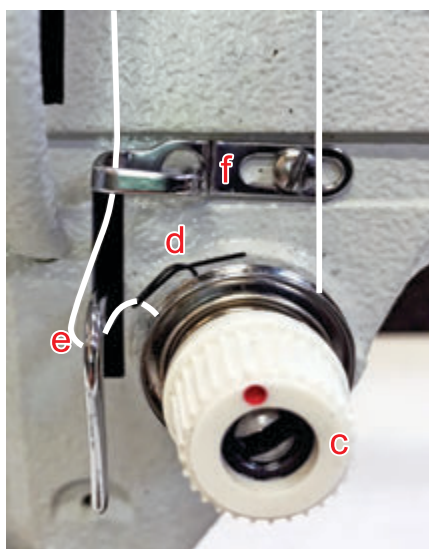
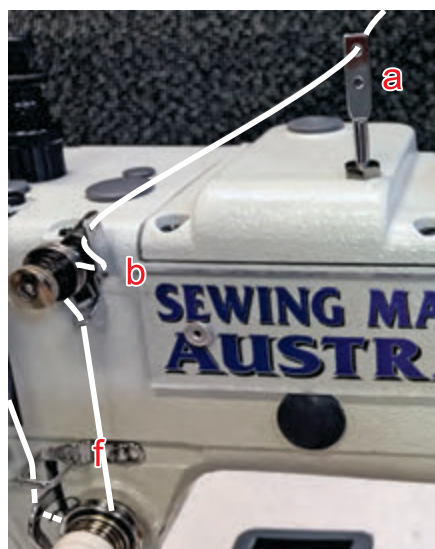
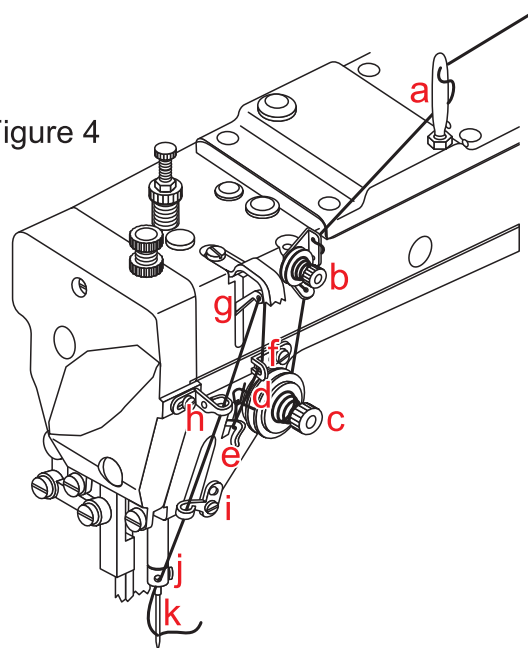
THREADING

7 Threading the needle thread (Fig 4)

When threading the needle, ensure the power is turned off and motor is completely wound down and the thread take up lever must be in its highest position. The correct threading steps are as below:

- a. Thread Post
- b. Pre-Tension Thread Guide
- c. Tension Assembly
- d. Take Up Spring
- e. Thread Guide
- f. Thread Guide
- g. Take Up Lever
- h. Thread Guide
- i. Thread Guide
- j. Needle Bar Thread Guide
- k. Needle

Figure 4



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WINDING

8 Winding A Bobbin (Fig 5)

The bobbin thread should be neat and tight and has been factory set by SMA. Certain threads may require adjusting.

Adjust the thread tension as follows:

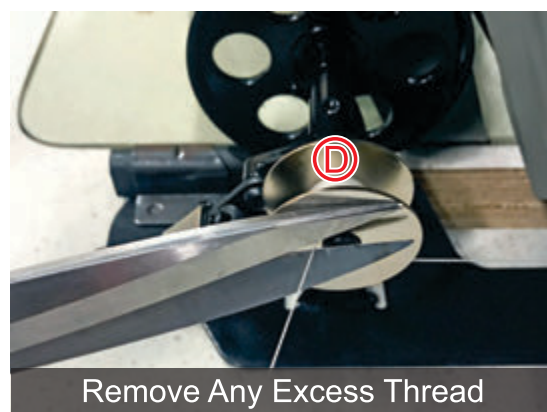
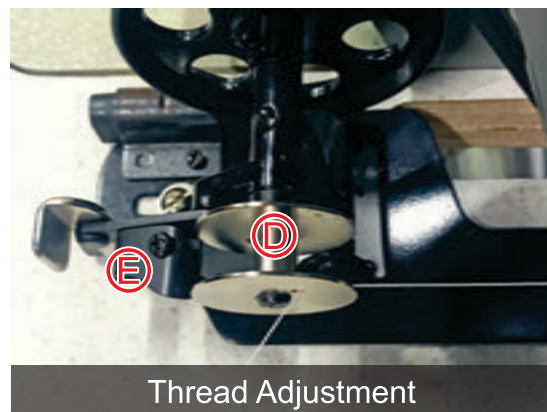
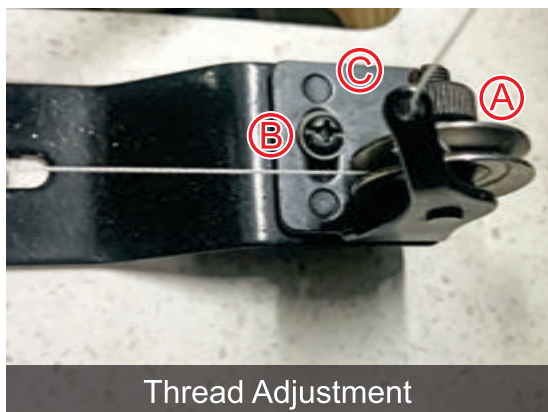
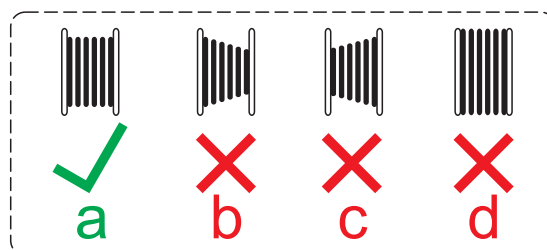
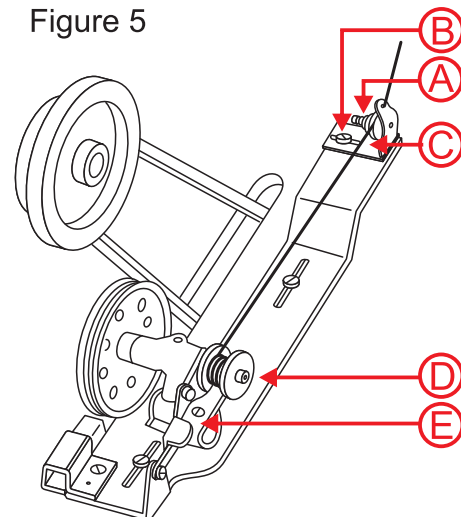
When you turn the thread tension nut (A) on the bobbin winder tension bracket in a clockwise direction, the thread tension will be increased. Minimum tension is required.

When the bobbin thread does not sit evenly on the bobbin as shown in Fig (a), loosen the tension bracket screw (B) and move the tension bracket (C) leftward or rightward.

If the thread is as shown in Fig (b), move the tension bracket rightward. If the thread is as shown in Fig (c), move the tension bracket leftward. See Fig (a) for correct winding.

Do not over fill the bobbin (D) as shown in Fig (d). The maximum capacity of the thread should fill approximately 80% of the bobbin's outside diameter as shown in Fig (a). This can be adjusted by the stop latch screw (E). To increase the amount of thread on the bobbin, turn (E) clockwise. To decrease the amount of thread on the bobbin, turn (E) anti-clockwise.

Figure 5



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BOBBIN CASE

9 Installing Bobbin into the Bobbin Case (Fig 6)

1. Bobbin case.
2. Install bobbin into case and pull thread through slot (a)
3. Pull thread under tension plate (b)
4. Threading complete



10 Installing Bobbin Case Into Machine (Fig 7)

When installing a Bobbin Case or changing a Needle, always make sure the machine is switched off and powered down.

The left hand side of the sump has been cut away, allowing an opening for you to insert your hand and change the Bobbin Case, without having to tip the machine back.

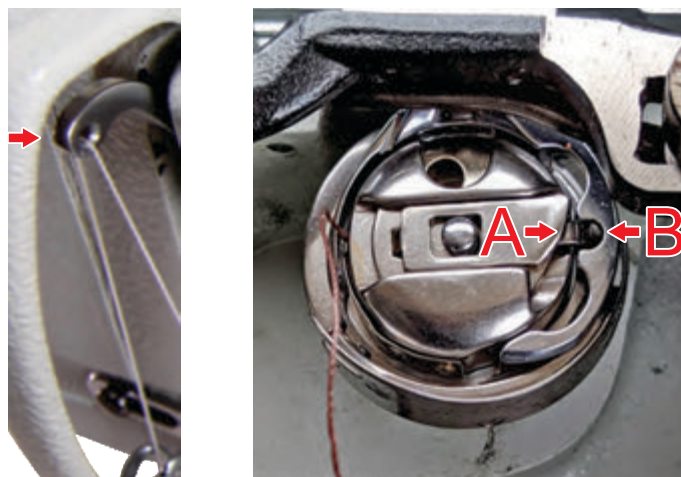
When installing the Bobbin Case into the Rotating Hook you should hear a 'Click' once it has been correctly installed. Lever (A) will line up with Cutout (B).

To remove the Bobbin Case pull Lever (A) towards you.

Please Note: The take up assembly must be in the upper most position to allow the Bobbin Case to be inserted or taken out.



Take Up Lever
at highest
position



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STARTING SEWING

15 Starting to Sew and Cotton Jams (Fig 8)

Cotton Jams are one of the most common problems in commercial sewing. They can be easily avoided by holding both your upper and bobbin threads prior to sewing as shown in Figure 8.

To do this, you must hold your needle thread Figure 8 and turn the hand wheel towards you until the take up lever completes one revolution and returns to its highest position as shown in Figure 9.

This allows the top thread, to pick up the bottom thread, as shown in Figure 10.

Once this has been done, place both threads under the foot as shown in Figure 11.

You must then hold both the upper and the bobbin thread, towards the back of the machine until approximately two stitches have been formed.

This will avoid the threads being drawn back into the machine, causing the machine to jam.

Figure 8



Figure 9

Take Up Lever
at highest
position

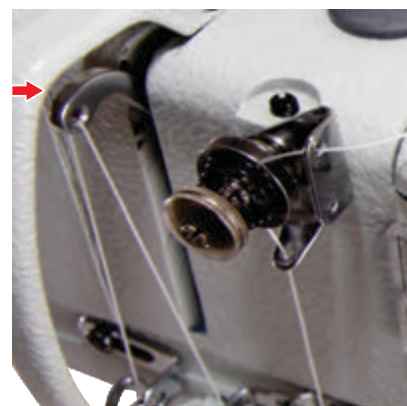


Figure 10

Bottom Thread
picked up



Figure 11



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ADJUSTING

12 Adjusting Needle Thread Tension (Fig 12)

Your machine has been factory preset by SMA to a metric 20 sewing thread however, thread adjustment may be required for different materials and thread. Before adjusting any tensions refer to the Threading Diagram on page (5) as many problems are eliminated by correct threading.

If you are experiencing tension issues and are unsure about any of these adjustments, firstly change your needle and check that your machine is threaded correctly. If this does not resolve the issue, please contact SMA for advice.

1. If the upper tension assembly (A) is too tight, this will cause the bottom thread to be pulled to the top. Decrease the upper tension assembly (A).
2. If the upper tension assembly is too loose, loose cotton will appear underneath the material. Increase the upper tension assembly (A).

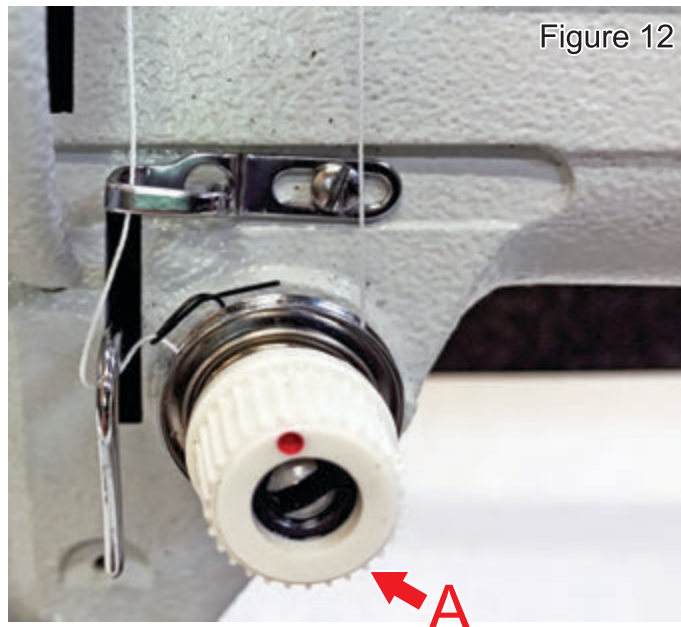


Figure 12

DECREASE (⌚) INCREASE

13 Thread Tension (Fig 13)

The tension on bobbin thread has been preset by SMA and should not be altered under normal operating conditions.

If you are experiencing large amounts of loose cotton as shown in Figure 13 on the underneath of the material, this will not be caused by loose bobbin tension. It is more than likely, that the machine is not threaded correctly on the top thread, or the cotton is not sitting correctly in the upper thread tension assembly disks.

ie. It has no tension on the top thread, so it will not allow the thread to be pulled up tight.



Figure 13

14 Adjusting Bobbin Thread Tension (Fig 14)

Adjustments may be necessary for certain materials even though your Bobbin Case has been factory set.

The bobbin thread tension can be increased or decreased by using a small screwdriver to turn the screw (B) on the bobbin case in a clockwise, or anticlockwise direction.



Figure 14

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ADJUSTING

15 Adjusting Outer Walking Foot Pressure (Fig 15)

Pressure on presser foot is to be adjusted in accordance with the materials to be sewn. If heavy materials are to be sewn, loosen the locknut (a) and turn the presser regulation thumbscrew (b) clockwise as shown in Fig (15) to increase the pressure and hold the material firmly. Then tighten the lock nut (a).

When sewing lighter materials, loosen the locknut (a) and turn the presser regulation thumbscrew (b) counter-clockwise as shown in Fig (15) to decrease the pressure on the presser foot. Then tighten the lock nut (a).

The pressure on the presser foot has been factory set by SMA however, certain materials may require adjustment.

Figure 15



16 Adjusting Inner Walking Foot Pressure (Fig 16)

Pressure on presser foot is to be adjusted in accordance with the materials to be sewn. If heavy materials are to be sewn, loosen the locknut (a) and turn the presser regulation thumbscrew (b) clockwise as shown in Fig (16) to increase the pressure and hold the material firmly. Then tighten the lock nut (a).

When sewing lighter materials, loosen the locknut (a) and turn the presser regulation thumbscrew (b) counter-clockwise as shown in Fig (16) to decrease the pressure on the presser foot. Then tighten the lock nut (a).

The pressure on the presser foot has been factory set by SMA however, certain materials may require adjustment.

Figure 16



Operating Instructions Maintenance and Safety

ADJUSTING

17 Adjusting Walking Foot Height Limit (Fig 17)

Your walking foot height limiter has been factory preset by SMA to a limit of 3.5 on the Limiter Dial (A) aligned at point (B).

The Limiter Dial (A) sets the maximum height allowable for the walking for on Adjustment Dial (C).

At certain times, when sewing piping or high seams are involved, you may wish to increase the height of the limiter to up to 5.5, enabling Adjustment Dial (C) to operate, up to 5.5. This will allow the walking feet not to get caught on and off heavier work.

Under most circumstances, the factory preset should not require adjusting.



Figure 17

18 Adjusting Walking Foot Height (Fig 18)

Your walking foot height can be adjusted by turning Adjustment Dial (C). The greater the number, the higher the lift. This adjustment is determined by Limiter Dial (A).

Under normal operation, a setting of 3.5 suitable for most applications.

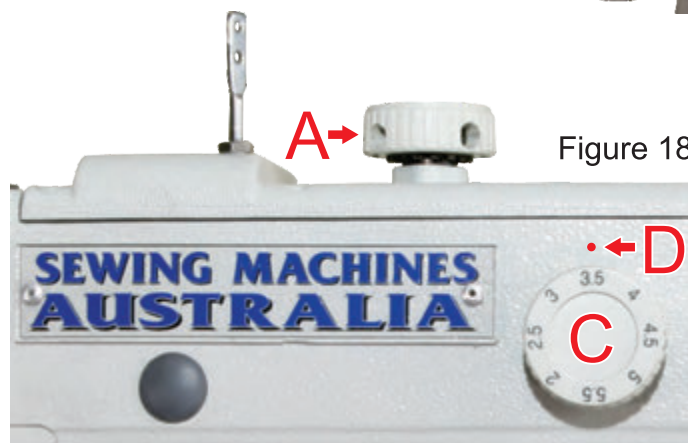
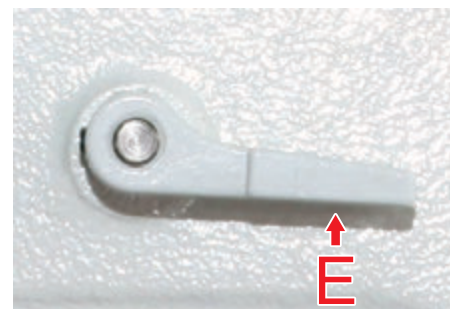


Figure 18

19 Foot Lifting Lever - Hand Adjustment (Fig 19)

By lifting the Foot Lifting Lever (E) upwards, this lifts the walking feet to approximately 8mm in height.

Figure 19

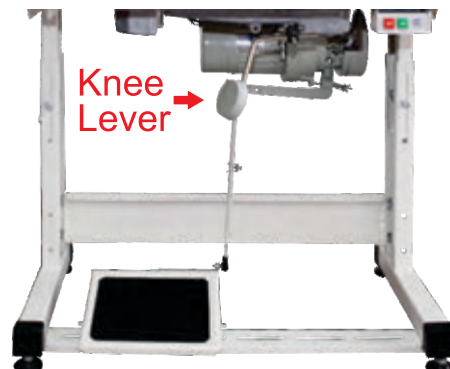


20 Foot Lifting Lever - Knee Adjustment (Fig 20)

By moving your knee to the right, this will allow the presser feet to lift to an approximate maximum height of 16mm.

Caution: Do not excessively force this action.

Figure 20



Optional Accessories and Consumables

Electronic Servo Motor with Needle Positioning

Ho Hsing G60 3/4 Hp Servo Motor

Existing Clutch Motor Replacement

This servo motor is ideal for anyone requiring precision in the stopping and starting of the machine. Whenever you stop, the machine will automatically stop with the needle in the down position. When you heel backwards on the pedal, the needle will automatically return to the up position. This servo motor allows fully adjustable speed control at the push of a button. With your machine powered by this silent, high powered 3/4 Hp servo motor, it is capable of pushing through the heaviest of jobs at the slowest of speeds. This is also a great power saving option and has too many other features to list here.

Your existing clutch motor can be replaced with the i90 Servo Motor without any need for electrical or other installation assistance. For more information about this amazing motor, contact SMA.



Piping Feet Set

A range of piping feet is available for the SMA GC-0323.



Swingaway Binding Assembly

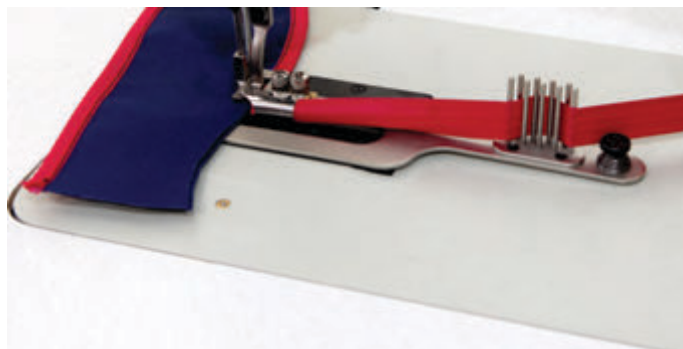
The SMA Swingaway Binding Assembly is ideal for those larger binding jobs.

For tight radiuses, the SMA 1245V Synchronised Binding Machine is recommended.

Sizes available:

- 20mm
- 25mm

For other sizing options, please contact SMA.



SALES • SERVICE • ADVICE

Half Presser Foot / Zipper Foot

The half presser foot is ideal for getting your needle closer to those jobs that require less distance.

Attaching zips, rope tracks and larger piping are just a few of the many uses suited to this half presser foot.



Optional Accessories and Consumables

CONSUMABLES

Industrial Sewing Threads

SMA carry a wide range of UV Treated and Non-UV Treated Sewing Threads designed for harsh Australian conditions.

To order, please visit our web site at:
www.sewingmachinesaustralia.com.au



Industrial Sewing Needles

SMA carry a complete range of both standard and leather point Schmetz Needles in all available sizes.

To order, please visit our web site at:
www.sewingmachinesaustralia.com.au



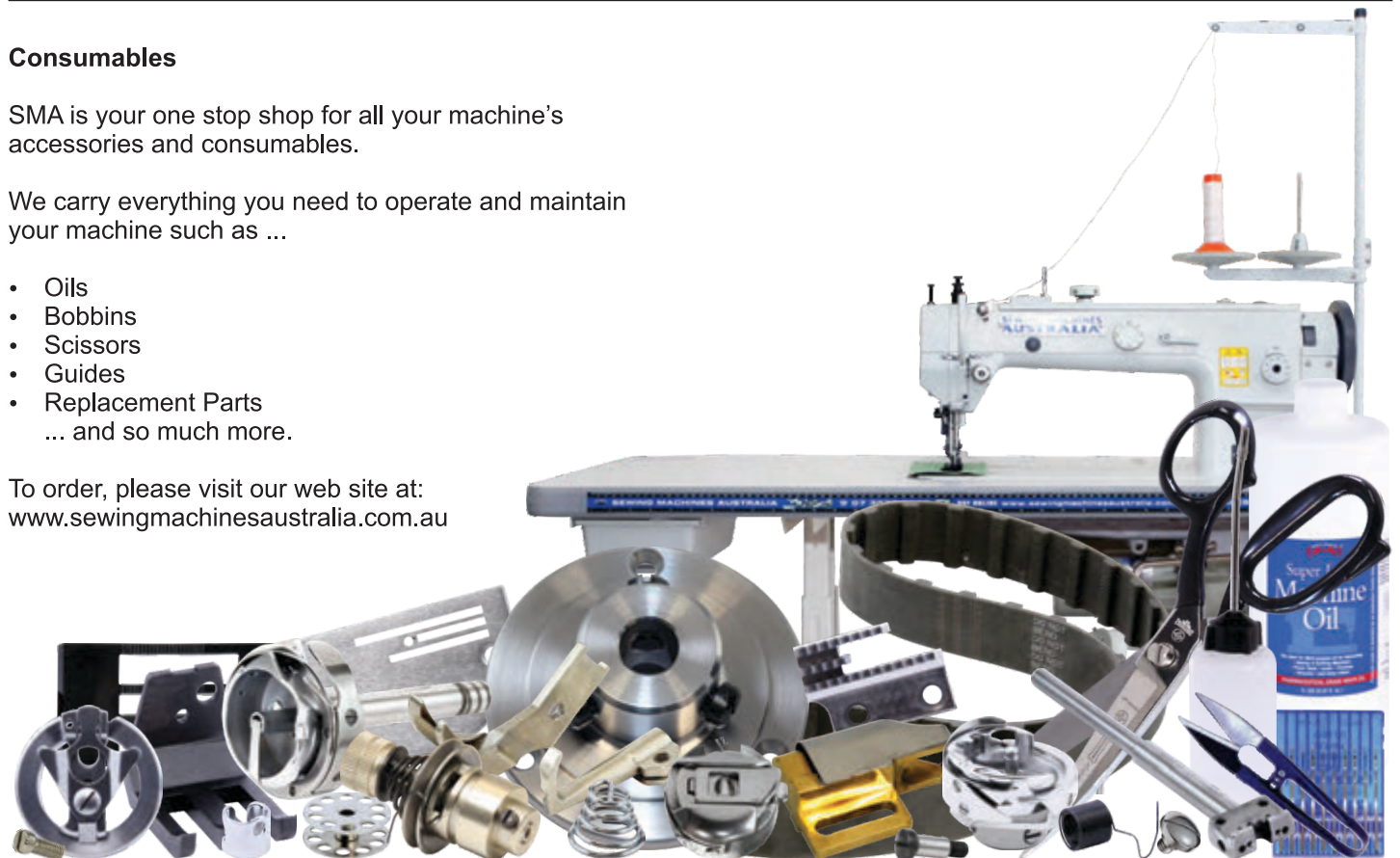
Consumables

SMA is your one stop shop for all your machine's accessories and consumables.

We carry everything you need to operate and maintain your machine such as ...

- Oils
- Bobbins
- Scissors
- Guides
- Replacement Parts
- ... and so much more.

To order, please visit our web site at:
www.sewingmachinesaustralia.com.au



SMA GC-0323

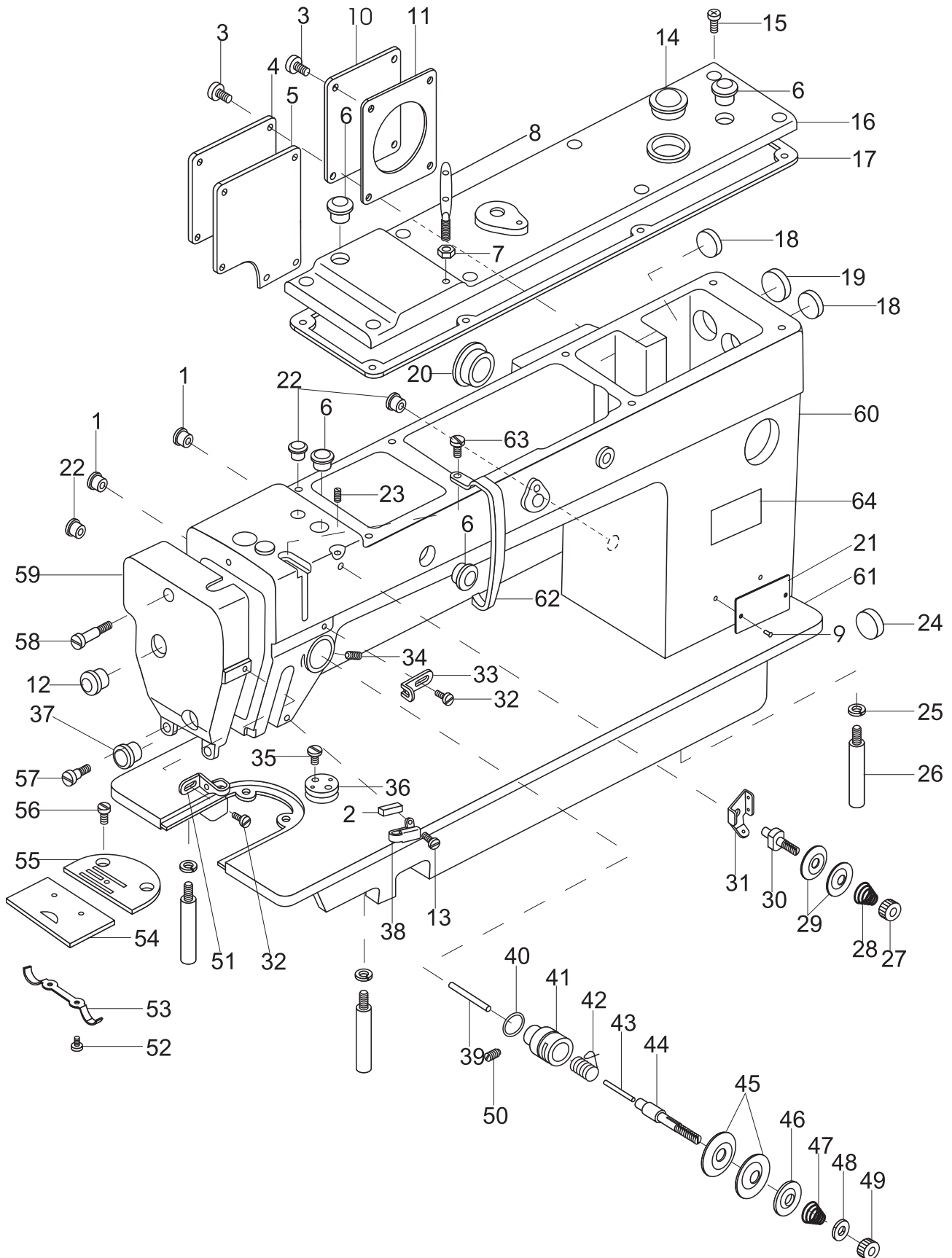
Spare Parts List



Spare Parts Manual

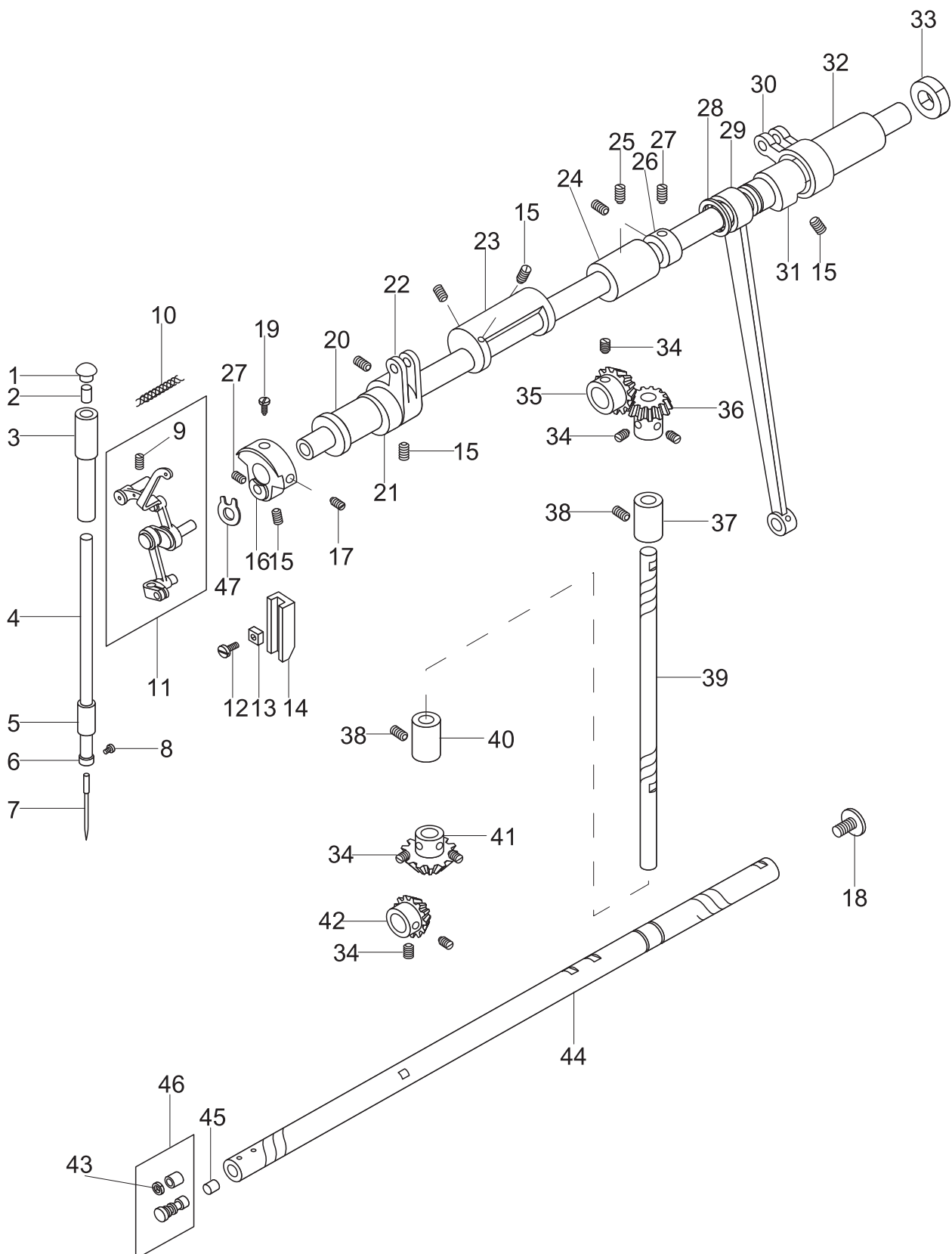
SMA GC-0323
Semi-Long Arm Walking Foot
Sewing Machine

1 Casting Mechanism



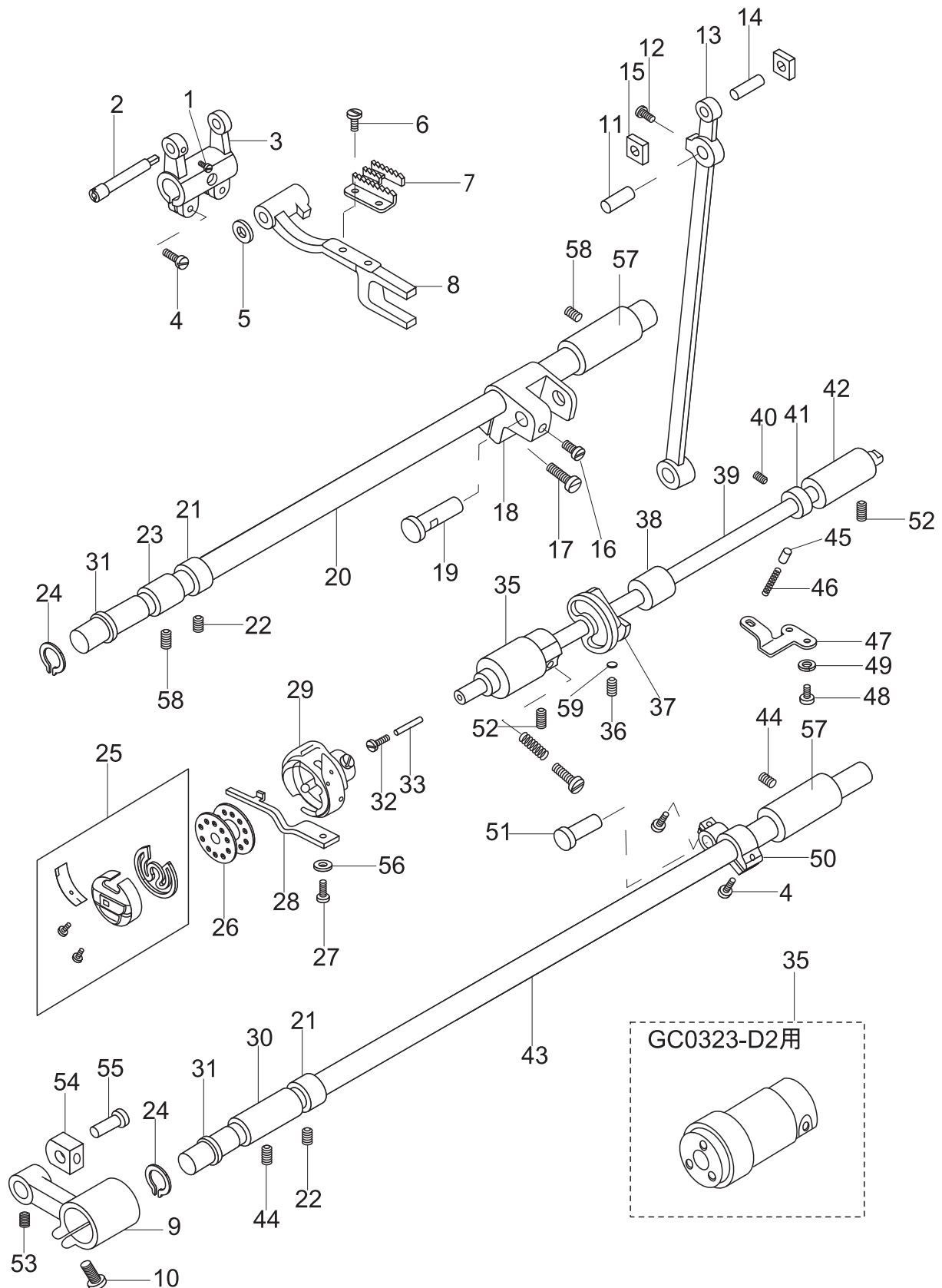
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	22T2-011	Rubber plug	2	2	
2	233WF1-011	Felt	1	1	
3	22T1-006	Screw	9	9	
	22T1-007	Washer	9	9	φ8.8
4	68WF1-001	Cover	1	1	
5	68WF1-002	Seal	1	1	SM11/64"×40×9.4
6	22T1-003C3	Rubber plug	4	4	
7	68WF1-029	Nut	1	1	
8	68WF1-028	Thread guide	1	1	
9		Rivet	2	2	φ19
10	68WF1-018	Back cover	1	-	SM11/64"×40×8
11	68WF1-019	Seal	1	1	
12	7WF4-030	Rubber plug	1	1	GB827 2.5×5镀铬
13	17WF1-018	Screw	1	1	
14	22T1-008	Oil window	1	1	
15	1WF5-039	Screw	8	8	
16	233WF1-003	Upper cover	1	1	
17	68WF1-010	Seal	1	1	
18	68WF1-011	Rubber plug	2	2	SM11/64"×40×12
19	68WF1-012	Rubber plug	1	1	
20	68WF1-013	Rubber plug	1	1	
21	233WF1-006	Model label	-	1	φ21.8
	235WF1-003	Model label	1	-	φ29
22	22T1-015	Rubber plug	3	3	φ26
23	22T1-011	Screw	1	1	
24	22T1-016	Rubber plug	1	1	
25		Washer	4	4	φ8.8
26	68WF1-015	Bed leg	4	4	SM11/64"×40×5.5
27	36T2-006D4	Nut	1	1	φ27
28	36T2-006D3	Spring	1	1	GB93 6 发黑
29	22T1-009E3	Thread tension disc	2	2	
30	36T2-006D2	Screw	1	1	
31	36T2-006D1	Thread guide	1	1	
32	22T1-003C6	Screw	2	2	
33	68WF1-016	Thread guide	1	1	
34	22T1-013	Screw	1	1	
35	1WF3-025	Screw	2	2	SM9/64"×40×6
36	7WF4-005	Holder	1	1	
37	22T1-003C4	Rubber plug	1	1	SM15/64"×28×8
38	233WF1-008	Thread guide	1	1	SM11/64"×40×5.5
39	233WF1-012	Thread release bar	1	1	
40	233WF1-005A	Seal ring	1	1	φ11.8
41	233WF1-005B	Adjusting bracket	1	1	
42	233WF1-005E	Thread take-up spring	1	1	
43	233WF1-005K	Thread release pin	1	1	
44	233WF1-005C	Screw	1	1	
45	233WF1-005F	Thread tension disc	2	2	
46	233WF1-005G	Thread release disc	1	1	
47	233WF1-005H	Spring	1	1	
48	233WF1-005I	Stop disc	1	1	
49	233WF1-005J	Nut	1	1	
50	233WF1-005D	Screw	1	1	
51	68WF1-017	Thread guide	1	1	
52	20T1-013F3	Screw	2	2	
53	20T1-013F2	Spring	1	1	SM9/64"×40×4
54	68WF1-023	Slide plate	1	1	
55	233WF1-009	Needle plate	1	1	SM3/32"×56
56	20T1-020	Screw	2	2	
57	7WF4-004	Screw	2	2	
58	68WF1-008	Screw	1	1	
59	233WF1-004	Face plate	1	1	SM11/64"×40
60	233WF1-001	Arm	-	1	SM11/64"×40×20
	235WF1-001	Arm	1	-	SM11/64"×40×28
61	233WF1-002	Bed	-	1	
	235WF1-001	Bed	1	-	
62	233WF1-010	Thread take-up lever guard	1	1	
63	22T2-004	Screw	1	1	
64	7WF4-019	Caution label	1	1	

2 Thread Take Up Mechanism



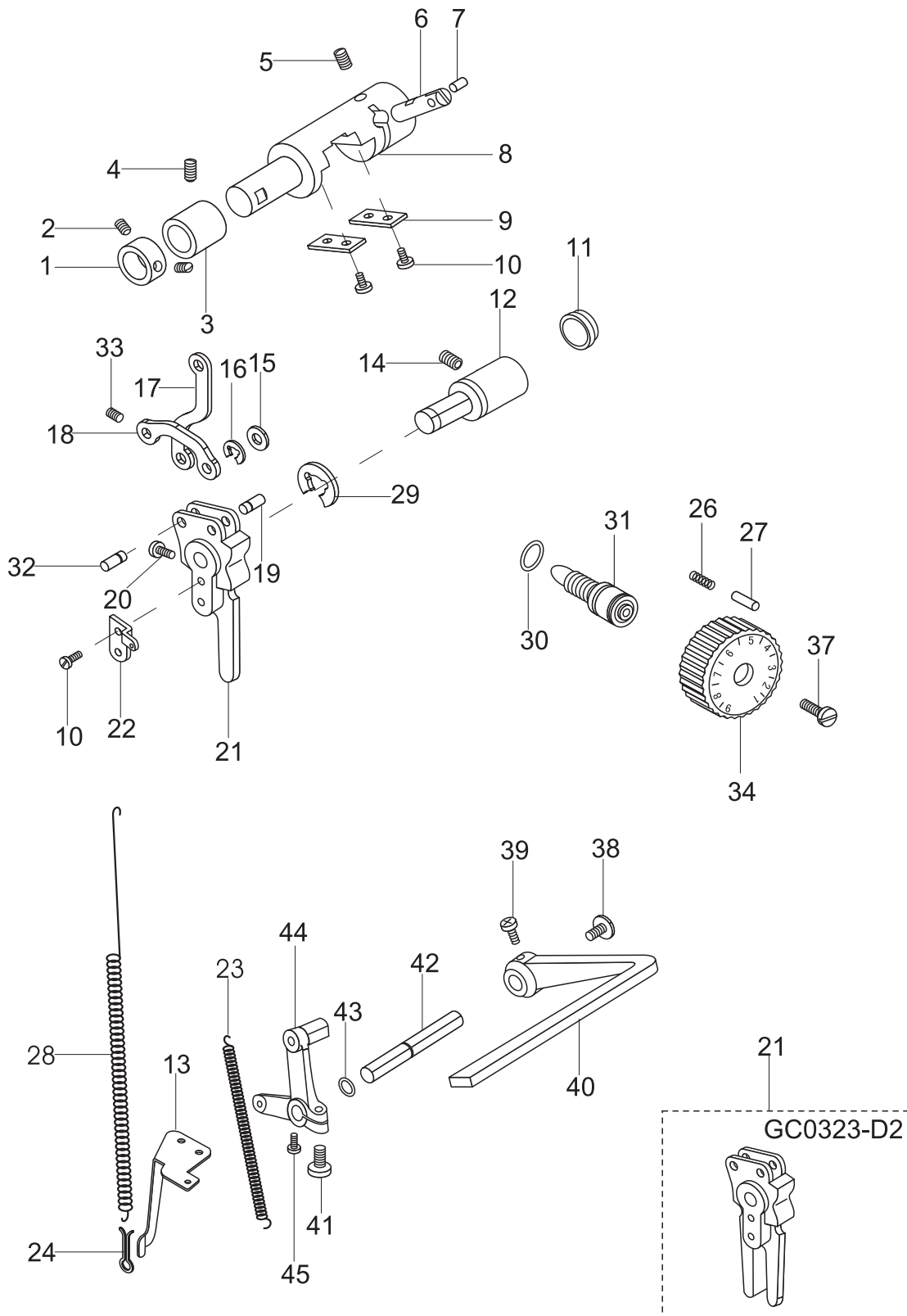
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	22T2-011	Rubber plug	1	1	
2		Felt	1	1	
3	68WF2-001	Needle bar bushing, upper	1	1	
4	233WF2-018	Needle bar	1	1	φ8.8
5	233WF2-007	Needle bar bushing, lower	1	1	φ8×8
6	233WF2-019	Thread guide	1	1	
7		Needle	1	1	
8	22T2-017	Screw	1	1	
9	JO.O.5	Screw	1	1	
10		Oil wick	1	1	DP×17 23#
11	233WF2-006	Thread take-up lever assy.	1	1	SM1/8"×44×4.5
12	21WF4-047	Screw	1	1	SM15/64"×28×10
13	68WF2-006	Slide block	1	1	棉线长130mm
14	81WF2-003	Guide rail	1	1	
15	22T2-005B3	Screw	7	7	SM11/64"×40×7.5
16	233WF2-017	Needle bar crank	1	1	
17	21WF1-012	Screw	1	1	
18	22T3-008	Screw	1	1	SM1/4"×40×7
19	233WF2-015	Screw	1	1	
20	233WF2-001	Bushing, L	1	1	SM9/32"×28×13.3
21	233WF2-010	Feed cam (L)	1	1	SM11/32"×28×11
22	233WF2-011	Feed cam crank (L)	1	1	SM9/32"×28×11.5
23	233WF2-002	Balance block	1	1	
24	233WF2-003	Bushing, M	1	1	
25	JO.O.81	Screw	1	1	
26	233WF2-004	Collar	1	1	
27	22T3-002B2	Screw	3	3	
28	233WF2-012	Retaining ring	1	1	SM15/64"×28×7.5
29	233WF2-013	Link	1	1	
30	233WF2-009	Feed cam crank (R)	1	1	SM1/4"×40×4
31	233WF2-008	Feed cam (R)	1	1	
32	233WF2-005	Bushing (R)	1	1	
33	2KT1-005	Oil seal	1	1	
34	22T2-005B3	Screw	8	8	
35	ZOA140379	Upper shaft gear	1	1	
36	ZOA140380	Vertical shaft gear , upper	1	1	
37	68WF2-018	Bushing, upper	1	1	SM1/4"×40×7
38	61-04-01/B308	Screw	2	2	
39	68WF2-019	Vertical shaft	1	1	
40	68WF2-020	Bushing, lower	1	1	
41	ZOA140382	Vertical shaft gear, lower	1	1	SM15/64"×28×6
42	ZOA140383	Lower shaft gear	1	1	
43	17WF5-021	Oil seal	2	2	
44	233WF2-014	Upper shaft	1	1	
45	22T2-010	Felt	3	3	
46	233WF2-016	Oil adjusting pin assy.	1	1	
47	13WF3-009	Washer	1	1	

3 Lower Feed Mechanism



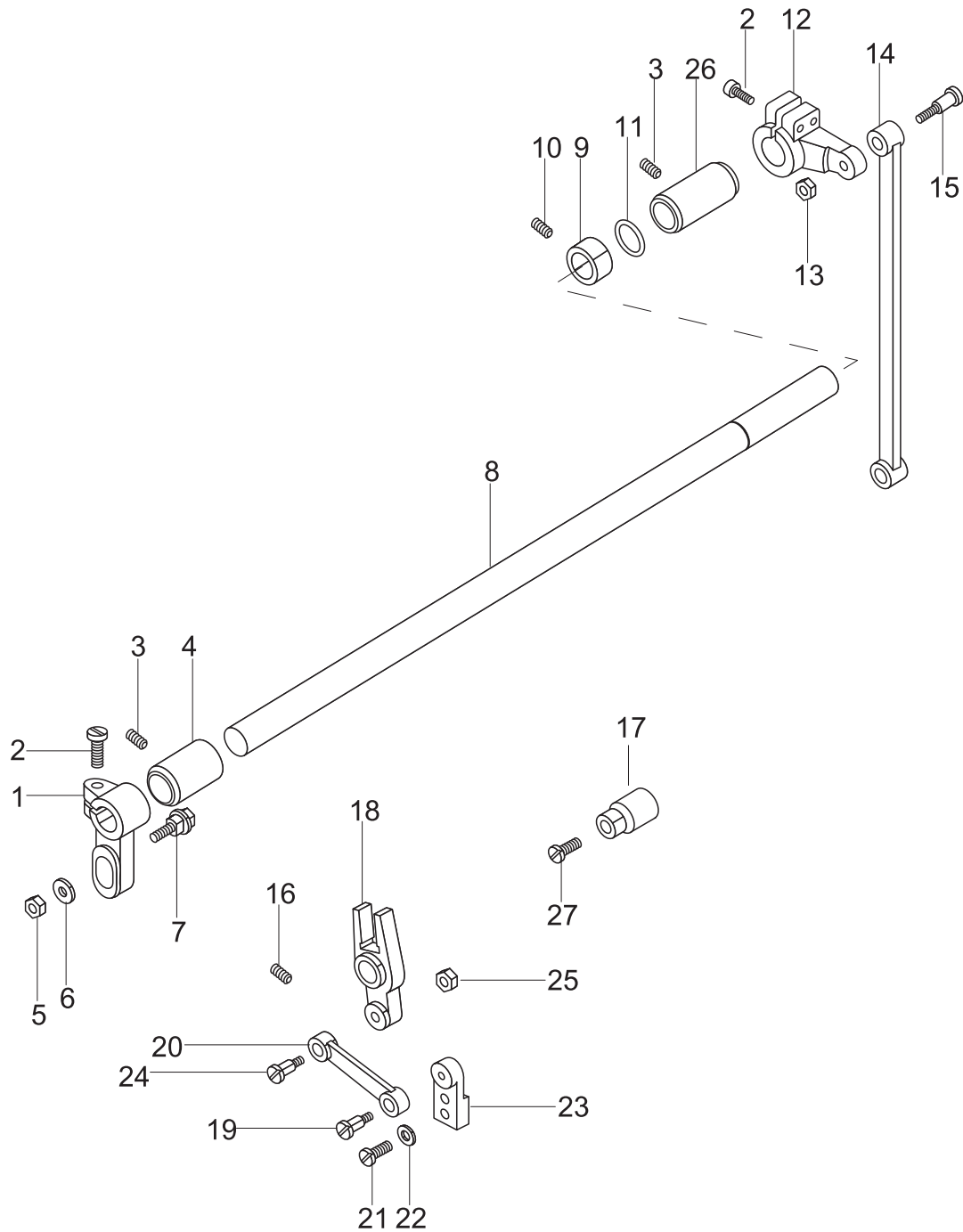
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	21WF4-047	Screw	1	1	
2	36T1-001A2	Eccentric shaft	1	1	
3	22T6-001A1a	Crank	1	1	
4	22T6-001A1b	Screw	4	4	
5	51T5-001A6	Washer	1	1	
6	JO.O.50	Screw	2	2	
7	2KT3-001	Feed dog	1	1	
8	233WF3-017	Feed dog	1	1	
9	233WF3-020	Feed dog carrier	1	1	
10	22T6-001A1b	Feed dog lift crank (L)	1	1	
11	68WF3-004	Screw	1	1	
12	21WF4-047	Pin	1	1	SM11/64"x40x7.5
13	68WF3-005	Screw bar	1	1	
14	68WF3-006	Link	1	1	
15	1WF4-040	Pin	2	2	SM3/16"x28x10
16	1WF2-038	Slide block	1	1	φ10×φ6×1.3
17	16WF3-061	Screw	1	1	SM1/8"x44x6
18	233WF3-013	Screw	1	1	
19	233WF3-028	Feed crank (R)	1	1	
20	68WF3-009	Pin	1	1	
21	233WF3-014	Feed shaft	1	1	
22	22T3-002B2	Collar	2	2	SM3/16"x28x10
23	233WF3-015	Screw	1	1	
24		Bushing	2	2	SM11/64"x40x7.5
25	35T1-104	Retaining ring	1	-	
	151845001	Bobbin case assy.	-	1	
26	33T1-027	Bobbin case assy.	1	-	
	24WF2-001	Bobbin	-	1	SM15/64"x28x10
27	22T4-015	Bobbin	1	-	SM15/64"x28x16
	52WF5-033	Screw	-	1	
28	33T1-029	Bobbin case opener	1	-	
	2KT1-013	Bobbin case opener	-	1	
29	68WF3-018	Rotary hook	1	-	SM1/4"x40x4
	122WF3-002	Rotary hook	-	1	
30	233WF3-010	Bushing	1	1	GB894.1 15 发黑
31	51T5-013	Washer	2	2	
32	22T4-001A1a1	Washer	1	1	
33	22T4-001A1a2	Oil filter	1	1	
35	233WF3-002	Lower shaft bushing, L	-	1	
	235WF2-001	Lower shaft bushing, L	1	-	
36	2KT5-031	Screw	-	2	
37	233WF4-010	Thread trimming cam	-	1	
38	233WF3-016	Lower shaft bushing, M	1	1	
39	68WF3-017	Lower shaft	1	-	
	78WF3-002	Lower shaft	-	1	
40	JO.O.35	Screw	2	2	
41	22T4-002B1	Collar	1	1	
42	233WF3-001	Lower shaft bushing, R	1	1	
43	68WF3-012	Feed dog lift shaft	1	1	
44	JO.O.5	Screw	2	2	
45	36T4-015	Plunger	1	1	
46	36T4-016	Spring	1	1	SM1/4"x40x10
47	22T4-010	Retainer	1	1	
48	22T9-006	Screw	1	1	
49		Washer	1	1	
50	68WF3-011	Crank	1	1	
51	22T6-007	Pin	1	1	SM15/64"x28x4.5
52	JO.O.40	Screw	2	2	SM15/64"x28x13
53	50WF3-020	Screw	1	1	SM15/64"x28x10
54	233WF3-019	Slide block	1	1	GB936 发黑
55	233WF3-018	Shaft	1	1	SM15/64"x28x10
56		Washer	-	1	SM11/64"x40x6
57	233WF3-024	Bushing	2	2	GB859 5 发黑
58	1WF2-044	Screw	2	2	SM15/64"x28x4.5
59	2KT5-032	Washer	-	2	

4 Stitch Length Adjusting Mechanism



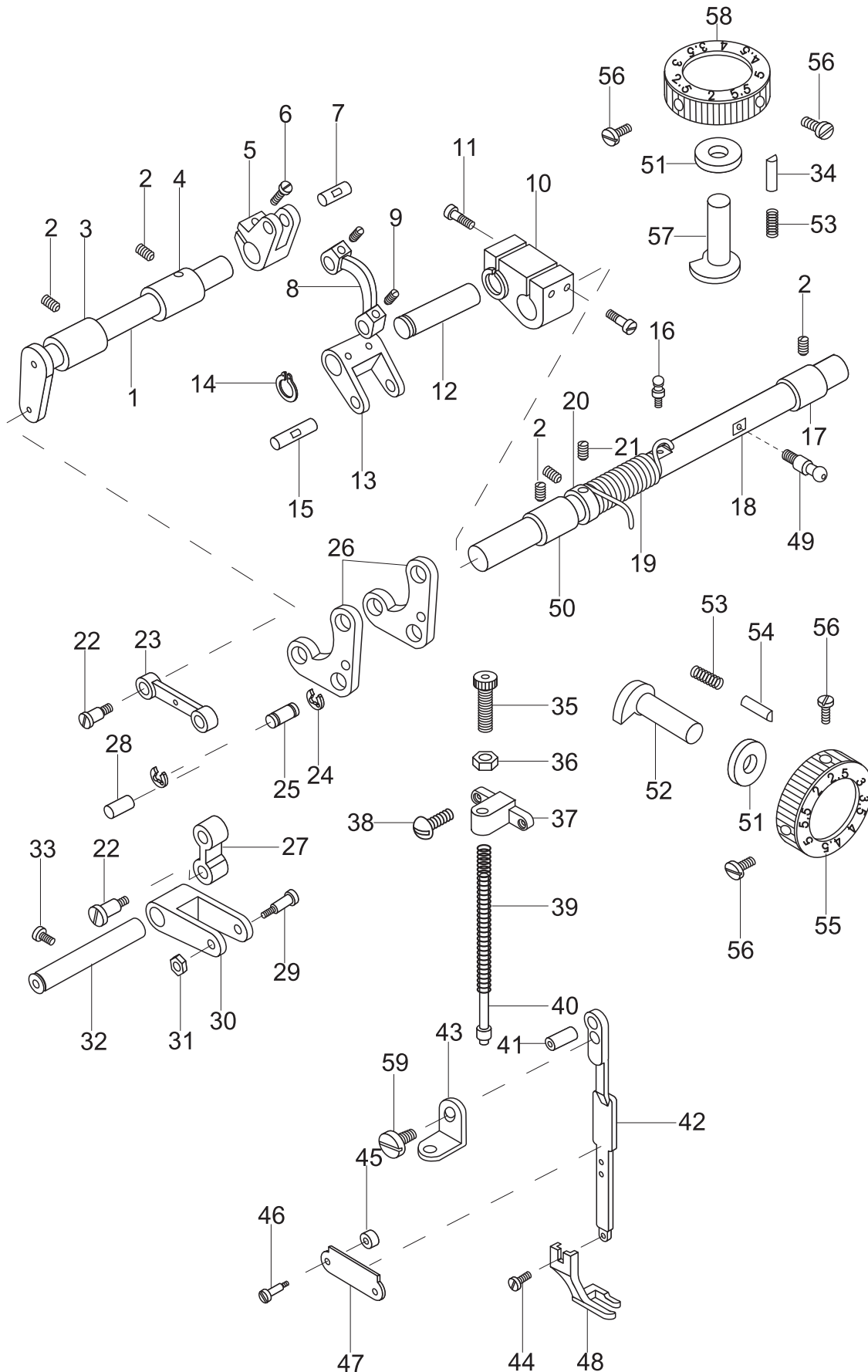
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	22T3-002B1	Collar	1	1	
2	22T3-002B2	Screw	2	2	
3	233WF3-010	Bush ing	1	1	
4	1WF5-022	Screw	1	1	
5	JO.O.40	Screw	1	1	
6	233WF3-012	Support shaft	1	1	
7	68WF4-003	Pin	1	1	
8	68WF4-004	Reverse feed bracket	1	1	
9	233WF3-011	Guide plate	2	2	
10	21WF4-047	Screw	6	6	
11	68WF4-005	Rubber plug	1	1	SM11/4"x40x4
12	233WF3-007	Hinge shaft	1	1	
13	68WF4-019	Bracket	1	1	SM11/64"x40x5.5
14	JO.O.40	Screw	1	1	SM15/64"x28x10
15	68WF4-008	Washer	-	1	
16		Retaining ring	-	1	
17	233WF3-026	Stitch length link	1	1	
18	78WF6-001	Reverse feed link	-	1	
19	68WF4-011	Pin	2	2	SM11/64"x40x7.5
20	1WF2-038	Screw	1	1	φ19.5
21	233WF3-006	Swing bar	-	1	
	235WF2-002	Swing bar	1	-	
22	233WF3-025	Brack et	1	1	SM15/64"x28x10
23	122WF4-005	Screw	1	1	
24	68WF4-020	Spring hook	1	1	GB896 4 发黑
25	22T4-015	Screw	4	4	
26	233WF3-030	Sprin g	1	1	
27	233WF3-005	Stop pin	1	1	
28	68WF4-021	Spring	1	1	SM15/64"x28x10
29	233WF3-029	Retaining spring	1	1	
30	33T2-030-A	Seal	1	1	
31	233WF3-004	Screw bar	1	1	
32	233WF3-003	Pin	1	1	
33	89WF5-005	Screw	1	1	
34	233WF3-027	Dial	1	1	SM11/64"x40x10
37	233WF3-021	Screw	1	1	
38	2KT3-005	Screw	1	1	
39	52WF4-020	Screw	1	1	
40	233WF3-031	Reverse feel lever	1	1	
41	6KT2-030	Screw	1	1	
42	233WF3-008	Shaft	1	1	
43		Seal	1	1	
44	233WF3-009		-	1	M4x5
	235WF2-003		1	-	
45	1WF5-042		1	1	SM3/16"x28x18 SM3/16"x32x6.5 SM3/16"x32x19 SM3/16"x28x17 GB3452.1-92 6.3x1.8G SM11/64"x40x10

5 Upper Feed Mechanism



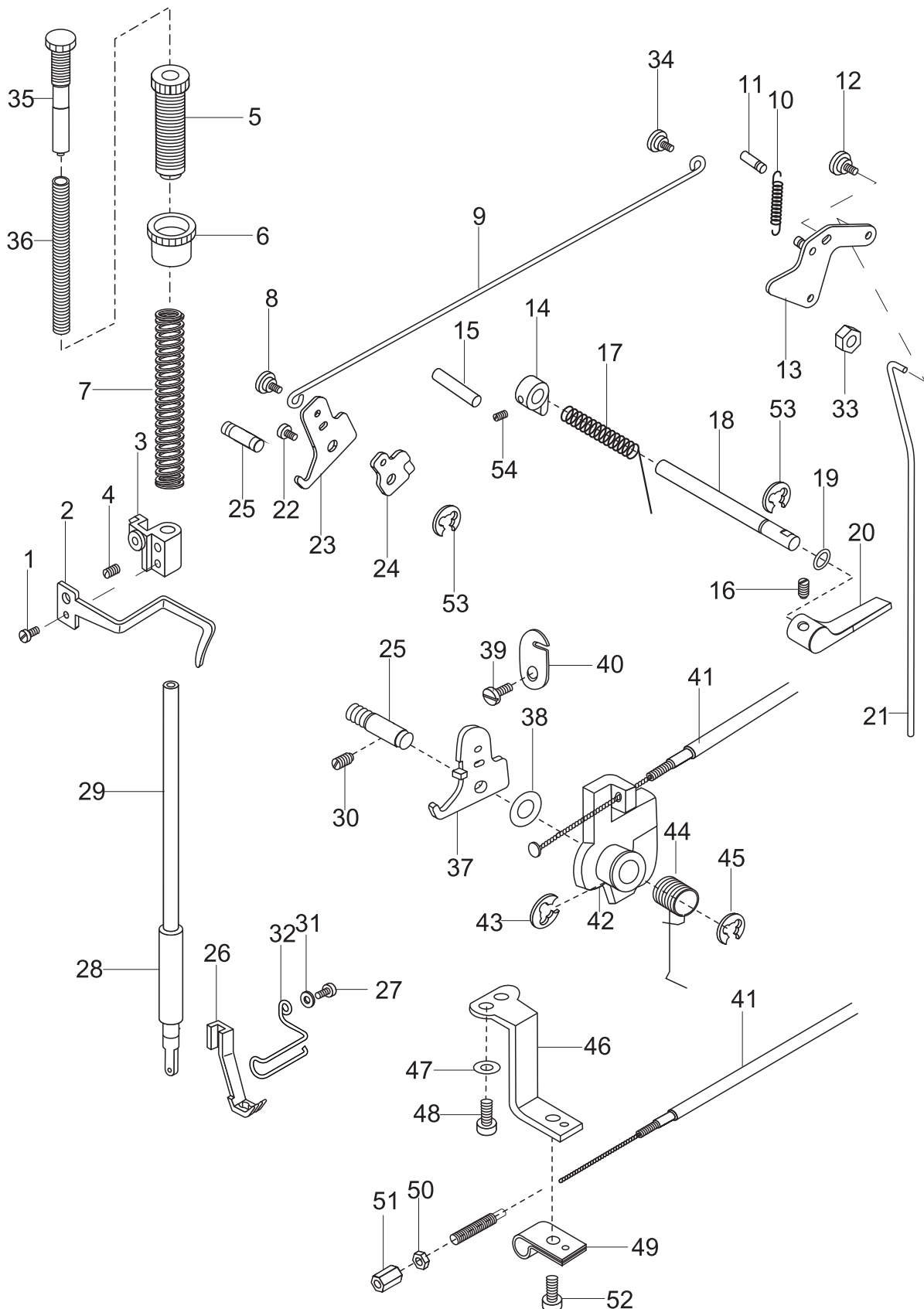
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	233WF5-023	Left crank	1	1	
2	16WF3-061	Screw	2	2	
3	1WF5-022	Screw	2	2	
4	233WF3-024	Upper feed shaft bushing, L	1	1	
5	7WF5-003	Nut	1	1	
6		Washer	1	1	
7	7WF5-014	Crank shaft assy.	1	1	
8	68WF5-003	Upper feed shaft	1	1	
9	22T3-002B1	Collar	1	1	
10	22T3-002B2	Screw	2	2	
11	33T2-030-A	O-ring	1	1	SM15/64"×28×16
12	233WF5-030	Right crank	1	1	SM11/64"×40×5.5
13	7WF5-022	Nut	1	1	
14	68WF5-006	Link	1	1	
15	7WF5-037	Screw	1	1	GB/T97.26 镀镍
16	JO.O.40	Screw	1	1	
17	233WF5-034	Guide column	1	1	
18	233WF5-024	Crank	1	1	
19	7WF5-019a	Screw	1	1	SM1/4"×40×5
20	68WF5-009	Link	1	1	
21	7WF5-008	Screw	2	2	
22		Washer	2	2	
23	233WF5-025	Bracket	1	1	
24	7WF5-011	Screw	1	1	SM9/32"×28
25	7WF5-001	Nut	1	1	SM15/64"×28×7.5
26	68WF5-002	Upper feed shaft bushing, R	1	1	
27	233WF5-035		1	1	SM1/4"×40
					SM9/64"×40×7
					GB934 发黑
					SM1/4"×40×26
					SM15/64"×28×10

6 Walking Foot Mechanism



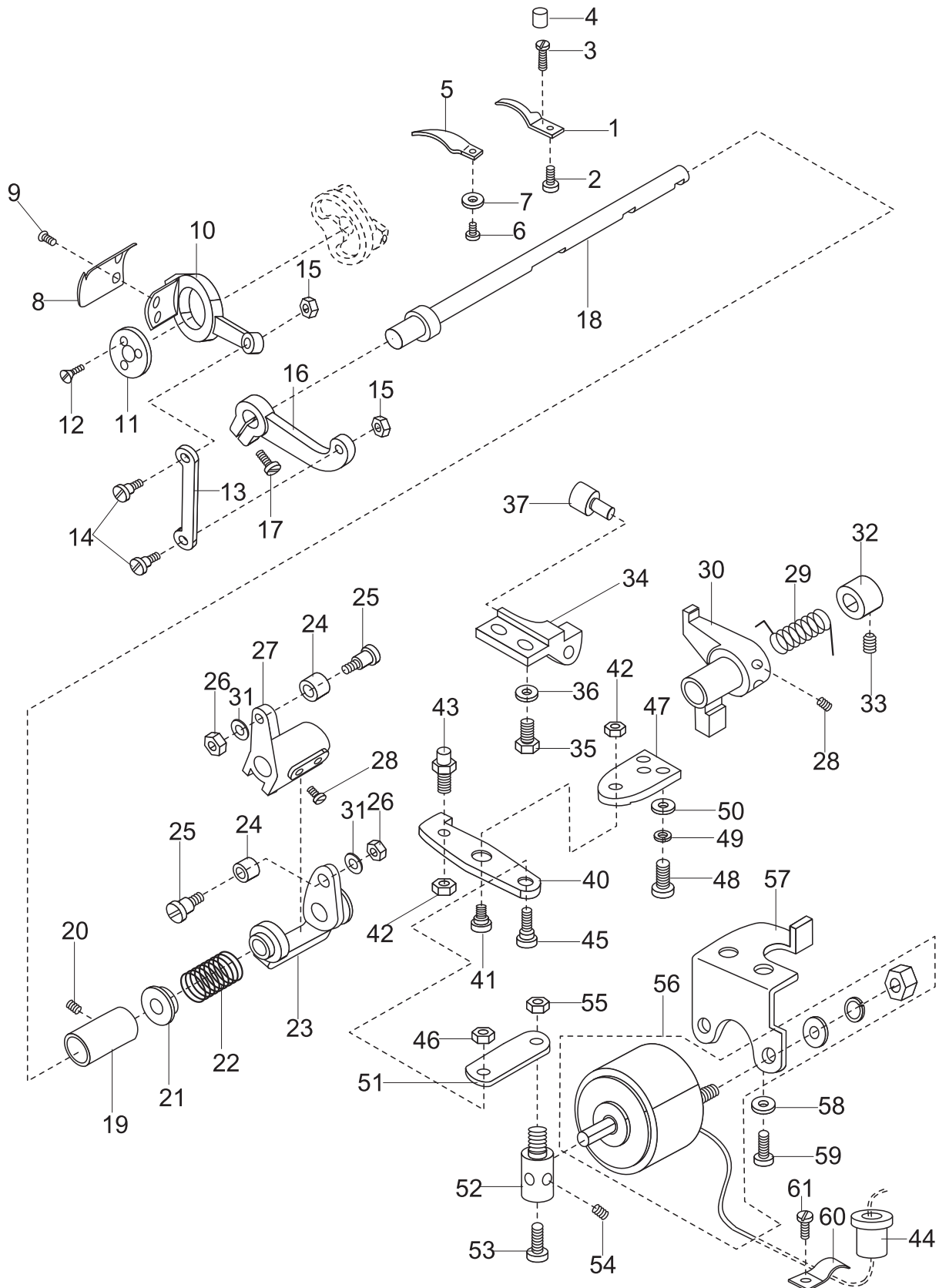
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	68WF6-001	Walking foot lifting shaft	1	1	
2	1WF5-022	Screw	4	4	
3	233WF5-007	Bushing, L	1	1	
4	233WF5-008	Bushing, R	1	1	
5	233WF5-006	Crank	1	1	
6	1WF4-027	Screw	1	1	
7	68WF6-005	Shaft	1	1	
8	233WF5-031	Link	1	1	
9	2KT5-036b	Screw	2	2	
10	233WF5-005	Bracket	1	1	
11	7KT3-035	Screw	4	4	SM11/64"x40x5.5
12	68WF6-008	Shaft	1	1	
13	233WF5-004	Crank	1	1	
14		Retaining ring	1	1	
15	68WF6-010	Pin shaft	1	1	SM15/64"x28x13
16	233WF5-003B	Screw	-	1	
	235WF3-001A	Screw	1	-	
17	233WF5-002	Bushing	2	2	SM11/64"x40x4
18	233WF5-001	Shaft	1	1	
19	233WF5-032	Spring	1	1	SM3/16"x28x14
20	233WF3-014	Collar	1	1	
21	22T3-002B2	Screw	2	2	
22	7WF5-019a	Screw	2	2	GB894.1 10 发黑
23	233WF5-009	Link	1	1	
24		Retaining ring	2	2	SM15/64"x28
25	68WF6-016	Pin shaft	1	1	
26	233WF5-010	Crank	2	2	
27	233WF5-013	Link	1	1	
28	68WF6-019	Shaft	1	1	
29	68WF6-022	Screw	1	1	
30	233WF5-011	Bracket	1	1	SM1/4"x40x4
31	36WF5-008	Nut	1	1	SM1/4"x40
32	233WF5-012	Feed crank shaft	1	1	
33	1WF2-019	Screw	1	1	GB896 6 发黑
34	994131	Stop pin	1	1	
35	7WF5-021	Screw	1	1	
36	7WF5-022	Nut	1	1	
37	233WF5-026	Bracket	1	1	
38	21WF4-047	Screw	2	2	SM15/64"x28
39	81WF6-003	Spring	1	1	
40	81WF6-004	Guide bar	1	1	
41	68WF6-020	Bushing	1	1	
42	233WF5-014	Walking foot connector	1	1	SM15/64"x28x12
43	233WF5-027	Guide bracket	1	1	
44	61-04-01/B316	Screw	1	1	SM9/32"x28
45	7WF5-002	Padding	2	2	
46	22T6-008D3	Screw	2	2	
47	7WF5-031	Press plate	1	1	SM11/64"x40x7.5
48	233WF5-029	Walking foot	1	1	
49	233WF5-003A	Screw	-	1	
	235WF3-001B	Screw	1	-	
50	233WF3-010	Bushing, L	1	1	
51	233WF5-022	Washer	2	2	
52	233WF5-019	Crank	1	1	SM9/64"x40x8
53	233WF5-021	Spring	2	2	
54	233WF5-020	Stop pin	1	1	SM11/64"x40x12
55	233WF5-018	Dial	1	1	
56	50WF1-004	Screw	4	4	
57	233WF5-017	Crank	1	1	
58	233WF5-016	Dial	1	1	
59	233WF5-028	screw	1	1	

7 Presser Foot Mechanism



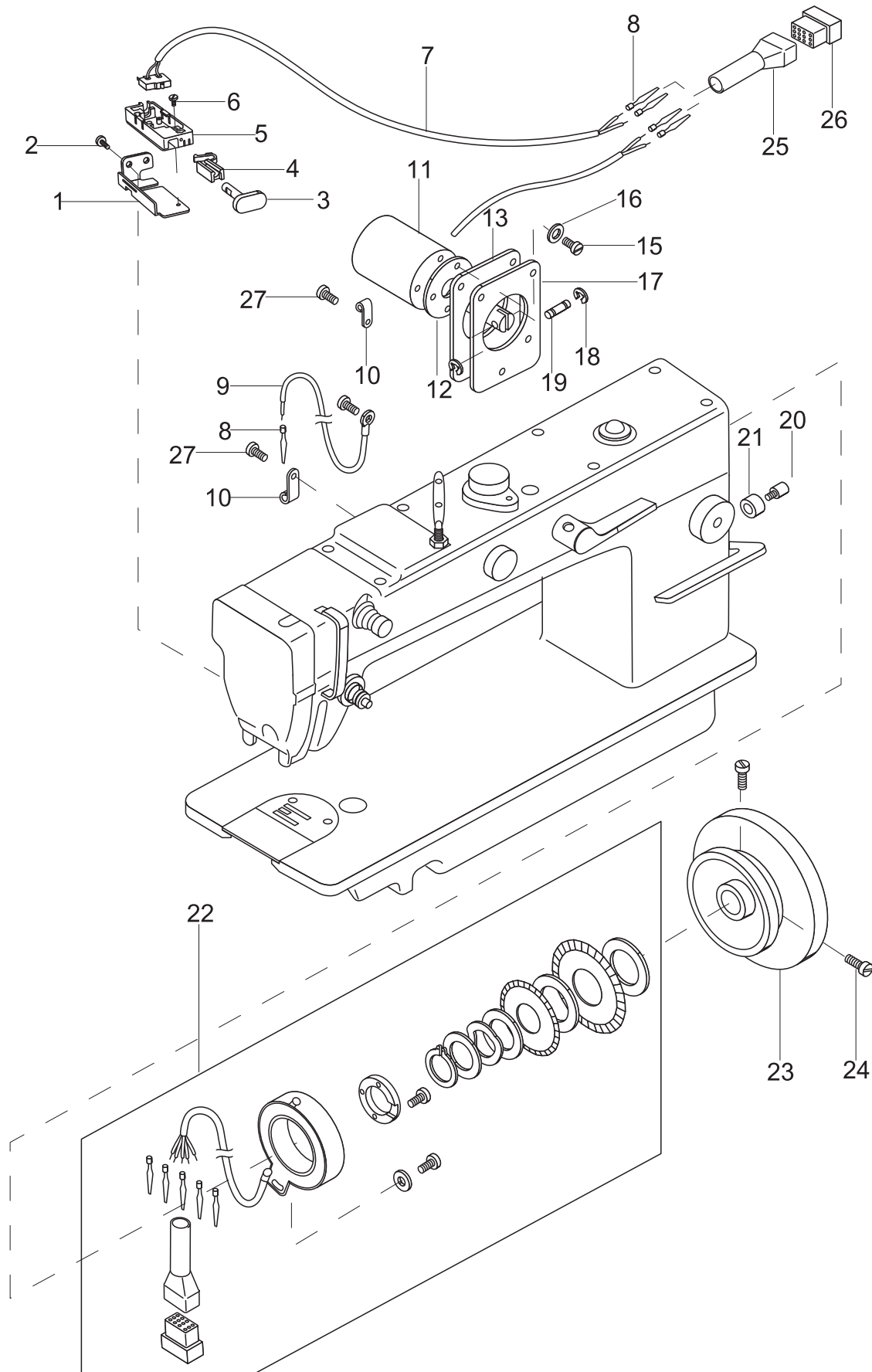
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	22T2-004	Screw	1	1	
2	233WF6-022	Thread guide	1	1	
3	233WF6-006	Guide bracket	1	1	
4	22T1-013	Screw	1	1	
5	233WF6-002	Adjusting screw	1	1	
6	233WF6-003	Nut	1	1	
7	81WF7-011	Spring	1	1	
8	22T7-004B2	Screw	-	1	
	235WF4-003	Screw	1	-	
9	233WF6-019	Connecting rod	1	1	SM11/64"x40x5.5
10	68WF7-005	Spring	1	1	
11	22T7-008	Spring pin	1	1	
12	22T7-005B	Screw	1	1	SM15/64"x28x7.5
13	233WF6-014	Kneel lifter lever	1	1	
14	233WF6-009	Presser bar lifting crank	1	1	
15	68WF7-013	Stop pin	2	2	
16	80WF6-036	Screw	2	2	SM3/16"x28
17	68WF7-008	Spring	1	1	SM3/16"x32
18	233WF6-008	Shaft	1	1	
19	17WF5-021	O-ring	1	1	
20	233WF6-007	Presser foot lift bar	1	1	
21	233WF6-011	Kneel lifter lifting bar (R)	1	1	SM15/64"x28x6.9
22	22T7-004B1c	Screw	1	-	
23	235WF4-001	Kneel lifter lever (L)	1	-	
24	235WF4-002	Thread release plate	1	-	
25	233WF6-013	Thread release shaft	-	1	SM15/64"x28x4.5
	235WF4-004	Pin	1	-	
26	233WF6-020	Presser foot	1	1	
27	22T7-015	Screw	1	1	
28	233WF6-001	Presser bar bush	-	1	
	235WF4-005	Presser bar	1	-	
29	233WF6-021	Screw	1	1	SM11/64"x40x6.5
30	21WF1-060	Washer	1	1	
31		Finger bar	1	1	
32	7WF3-004	Nut	1	1	
33	1WF2-067	Screw	1	1	
34	68WF7-016	Screw	1	1	
35	233WF6-004	Spring	1	1	SM11/64"x40x8
36	233WF6-005	Kneel lifter lever (L)	1	1	
37	233WF6-010	Washer	-	1	
38	17WF5-008	Screw	1	1	
39	36WF2-031	Wire clamp	-	1	SM11/64"x40x6
40	233WF6-016	Tension release steel wire	-	1	GB/T8484 镀镍
41	233WF6-015A	Tension release steel plate	-	1	
42	233WF6-015B	Retaining ring	-	1	SM9/64"x40x4.5
43		Spring	-	1	GB896 8
44	233WF6-012	Retaining ring	-	1	
45		Fixed bracket	-	1	GB896 5
46	233WF6-018	Washer	-	1	
47		Screw	-	1	
48	89WF2-016	Wire clamp	-	1	GB/T954
49	233WF6-017	Nut	-	1	M4x10
50	13WF3-074	Nut	-	1	
51	233WF6-015C	Screw	-	1	M5
52	21WF4-047	Retaining ring	-	1	M5
53	233WF6-023	Screw	2	1	
54	2KT5-027		1	1	SM1/4"x40x6

8 Thread Trimming Mechanism



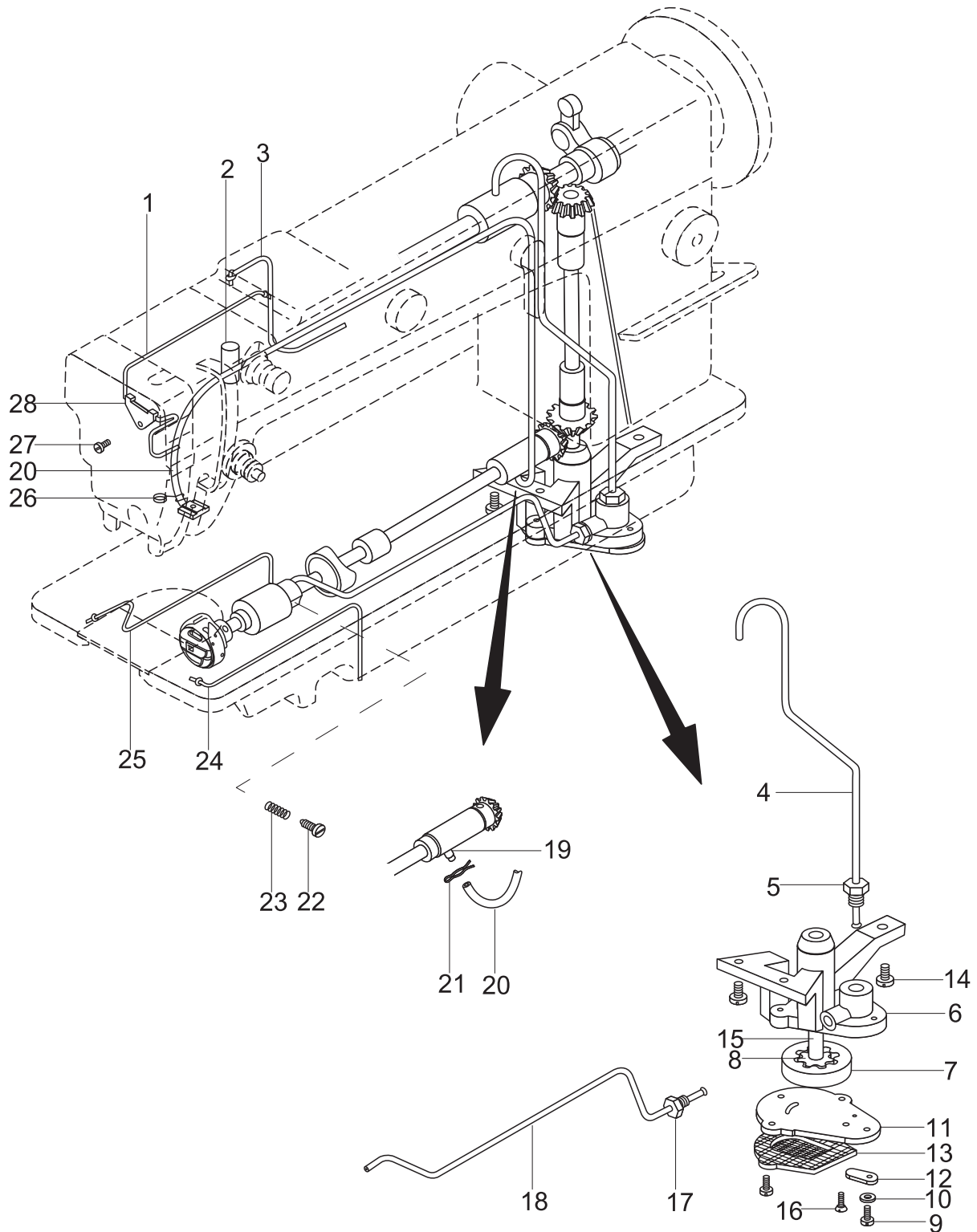
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	78WF1-002	Fixed knife	-	1	
2	2KT5-002	Screw	-	1	SM11/64× 40
3	16WF3-038	Screw	-	1	SM1/8"×40
4	2KT5-042	Nut	-	1	
5	78WF1-016	Thread holding plate	-	1	
6	2KT6-017	Screw	-	1	SM9/64"×40×6
7	79WF3-020	Washer	-	1	
8	78WF1-003	Movable knife	-	1	
9	2KT5-007	Screw	-	2	SM11/64"×40
10	233WF4-026	Movable knife carrier	-	1	
11	233WF4-021	Washer	-	1	
12	2KT5-002	Screw	-	3	
13	233WF4-001	Link	-	1	
14	233WF4-006	Screw	-	2	SM3/16"×32
15	2KT4-020	Nut	-	2	SM3/16"×32
16	233WF4-002	Driving crank	-	1	
17	53WF3-010	Screw	-	1	M6×1×15
18	233WF4-003	Thread trimming shaft	-	1	
19	233WF4-004	Bushing	-	1	
20	21WF1-045	Screw	-	1	SM3/16"×32×6
21	78WF1-025	Cover	-	1	
22	233WF4-025	Spring	-	1	
23	233WF4-019	Crank, R	-	1	
24	233WF4-024	Roller	-	2	
25	233WF4-023	Screw	-	2	SM3/16"×32
26	2KT4-020	Nut	-	2	
27	233WF4-020	Crank, L	-	1	
28	21WF3-010	Screw	-	2	SM15/64"×28
29	78WF1-029	Spring	-	1	
30	233WF4-005	Positioning block	-	1	
31		Washer	-	2	GB 859 5 发黑
32	233WF4-007	Collar	-	1	
33	22T3-002B2	Screw	-	2	SM1/4"×40
34	233WF4-008	Bracket	-	1	
35	6K1-010	Screw	-	2	SM3/16"×32×11
36		Washer	-	2	GB/T95 5 镀镍
37	233WF4-009	Rubber	-	1	
40	233WF4-011	Clutch lever	-	1	
41	233WF4-022	Screw	-	1	
42	22WF3-004	Nut	-	2	SM15/64"×28
43	233WF4-012	Screw	-	1	
44	78WF1-032	Cover	-	1	
45	233WF4-013	Screw	-	1	
46	1WF2-074	Nut	-	1	SM3/16"×32
47	233WF4-014	Base	-	1	
48	49WF4-003	Screw	-	3	M5×0.8×15
49		Washer	-	3	GB859 5 发黑
50		Washer	-	3	GB/T 95 5 镀镍
51	233WF4-015	Link	-	1	
52	233WF4-016	Pin	-	1	
53	17WF3-008	Screw	-	1	SM11/64"×40×8
54	36WF5-025	Screw	-	1	SM11/64"×40×5
55	13WF3-074	Nut	-	1	M5×0.8
56	233WF4-017	Thread trimming solenoid assy.	-	1	
57	233WF4-018	Solenoid base assy.	-	1	
58		Washer	-	2	GB895 6 镀镍
59	1WF4-027	Screw	-	2	SM15/64"×28×13
60	2KT5-040	Wire clamp	-	1	
61	2KT6-017	Screw	-	1	SM9/64"×40×6

9 Reverse Stitching Mechanism



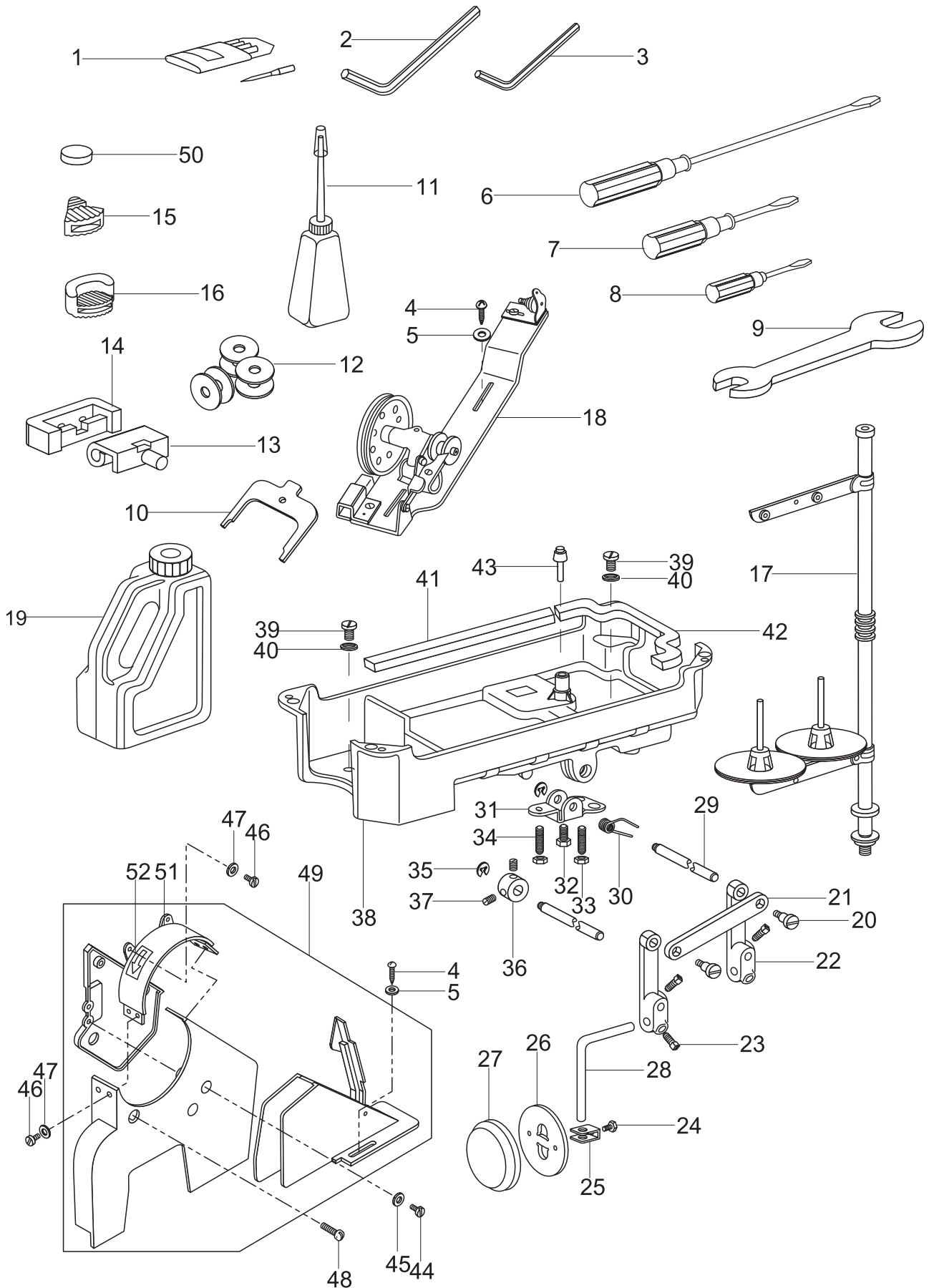
No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1	2KT6-011	Set plate	-	1	
2	21WF1-062	Screw	-	2	
3	2KT6-015	Button	-	1	
4	2KT6-014	Switch	-	1	
5	2KT6-013	Switch base	-	1	
6		Screw	-	1	
7	2KT6-016	Reverse stitching switch assy.	-	1	
8	2KT6-001C	Terminal	-	5	SM3/16"×32×9.5
9	2KT8-001	Ground wire assy.	-	1	
10	2KT5-040	Thread clamp	-	2	
11	233WF7-003	Reverse stitching solenoid assy.	-	1	
12	233WF7-001	Washer	-	1	GB/T818 M3×6 发黑
13	78WF2-003	Back cover	-	1	
14	21WF4-047	Screw	-	1	
15	21WF3-026	Screw	-	4	
16		Washer	-	4	
17	68WF1-019	Washer	-	1	
18		Retaining ring	-	2	
19	78WF1-001A	Pin	-	1	
20	233WF3-022	Screw bar	-	1	SM11/64"×40×7.5
21	233WF3-023	Roller	-	1	SM11/64"×40×9.4
22	233WF7-002	Synchronizer assy.	-	1	GB859 5 发黑
23	7WF1-001	Handwheel	1	-	
	78WF2-004	Handwheel	-	1	GB896 4 发黑
24	22T3-007C2	Screw	-	2	
25	2KT8-002	Connector cover	-	1	
26	2KT8-003	Connector	-	1	
27	2KT6-017	Screw	-	2	
					SM15/64"×28×15
					SM9/64"×40×6

10 Lubrication Mechanism



No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1		Oil wick	1	1	
2	7WF2-013	Felt	5	5	
3		Oil wick	1	1	
4	68WF8-001A	Oil tube	1	1	
5	22T8-013D2	Adaptor	1	1	
6	15WF4-003	Oil pump	1	1	
7	15WF4-006	Big gear	1	1	
8	15WF4-007	Small gear	1	1	
9		Screw	3	3	
10		Washer	1	1	长500mm
11	15WF4-004	Oil pump cover	1	1	
12	22T8-006	Adjusting plate	1	1	长250mm
13	22T8-008A	Oil felt	1	1	
14	22T8-009	Screw	3	3	
15	15WF4-005	Shaft	1	1	
16		Screw	2	2	
17	22T8-010B1	Adaptor	1	1	
18	68WF8-002A	Oil tube	1	1	GB/T67 M3×10 镀镍
19	22T4-007C2	Adaptor	1	1	GB934 发黑
20		Oil pipe	1	1	
	22T8-015	Oil felt	1	1	
21	68WF8-005	Clamp	1	1	
22	233WF8-001	Screw	1	1	SM11/64"×40×13
23	233WF8-002	Spring	1	1	
24		Oil wick	1	1	GB/T68 M3×10 镀镍
25		Oil wick	1	1	
26	68WF8-004	Clamp	1	1	
27	22T1-003C6	Screw	1	1	
28	68WF8-003	Set plate	1	1	
					长250mm 长300mm SM9/64"×40×6

11 Accessories



No .	Parts No .	Name of parts	Qty.		Remarks
			0323	0323-D2	
1		Needle	4	4	
2		Spanner	1	1	
3		Spanner	1	1	
4		Wooden screw	4	4	
5		Washer	4	4	
6	33TF-012	Screwdriver (big)	1	1	
7	33TF-013	Screwdriver (medium)	1	1	
8	33TF-014	Screwdriver (small)	1	1	
9	22WF6-008	Spanner	1	1	DP×17 23#
10	78WF7-001	Adjusting plate	-	1	S=3
11	33TF-011	Oil pot	1	1	S=2
12	33TF1-027	Bobbin	4	-	GB5282 ST4.8×19 镀镍
	24WF2-001	Bobbin	-	4	GB/T956 (外径φ14) 镀镍
13	22T9-007F1	Hinge	2	2	
14	22T9-007F2	Rubber cover	2	2	
15	1KT5-003	Cushion (big)	2	2	
16	1KT5-004	Cushion (small)	2	2	8×10
17	4F-007	Thread stand	1	1	
18	S14420020	Bobbin winder	1	1	
19	22T9-017	Oil tank	1	1	
20	68WF9-007	Screw	2	2	
21	68WF9-006	Link	1	1	
22	68WF9-009	Bell adaptor	2	2	
23	22T9-003B4	Screw	3	3	
24	22T9-003B7	Screw	1	1	
25	22T9-003B6	Bell bracket	1	1	
26	22T9-003B5	Bell	1	1	
27	22T9-003B8	Bell pad	1	1	
28	22T9-003B2	Bent rod	1	1	SM1/4"×24×10.5
29	68WF9-008	Hinge shaft	1	1	
30	22T9-001A7	Spring	1	1	
31	22T9-001A8	Stop bracket	1	1	SM5/16"×18×13
32	1WF4-032	Screw	1	1	SM15/64"×28×8
33	22T9-001A10	Adjusting nut	2	2	
34	22T9-001A9	Screw	2	2	
35		Retaining ring	2	2	
36		Collar	1	1	
37	JO.O.35	Screw	2	2	
38	233WF9-003	Oil pan	1	1	
39	22T9-001A2	Screw	2	2	
40	22T9-001A3	Washer	2	2	SM15/64"×28×15
41	68WF9-011	Pad (big)	1	1	SM15/64"×28
42	68WF9-012	Pad (small)	1	1	SM15/64"×28×27
43	165F01001	Knee lifter lifting bar	1	1	GB896 9 发黑
44	13WF3-018	Screw	1	1	
45		Washer	1	1	SM15/64"×28×4.5
46	21WF4-047	Screw	6	6	
47	22T1-007	Washer	6	6	SM15/16"×28×10
48	22T9-006	Screw	2	2	
49	68WF9-013	Belt cover	1	1	
50	22T9-012	Magnet	1	1	
51	68WF9-013A	Upper belt cover	1	1	
52	36WF1-031E	Turning mark label	1	1	M4×10 GB/T97.1 4 镀镍 SM11/64"×40×7.5 SM15/64"×28×8

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