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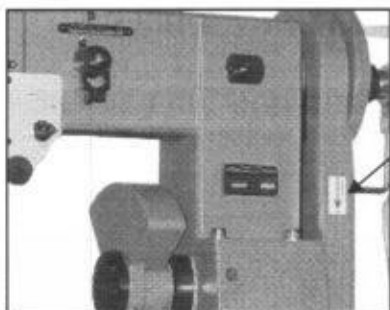
SM 7568 XH DOUBLE THREAD SEATED TYPE
INSEAM SEWING MACHINE



OPERATING INSTRUCTION MANUAL



Thank you very much for your choice of this double thread side seam sewing machine. Please read the manual carefully before use!



Ensure that the rotation of the pulley conformable to the red allow on the belt cover !

Notice: Replace or installation motor belt should pay attention and v-belts can not be adjusted too tight, synchronous belt can not be adjusted too loose!



The machine has passed CE !

Main Warnings:

- ♥It is extremely important that the electrical device must be soundly earthed!
- ♥It is absolutely forbidden to remove any protection system provided by manufacturer while machine is on!
- ♥All setting and replacement operation must be carried out only by the qualified expert personnel!
- ♥For repairs, all tools and replacement parts must be qualified by manufacturer!
- ♥Whenever, and whatever reason, the machine is to be demolished, certain basic rules must be observed to safeguard public health and the environment in which we live!

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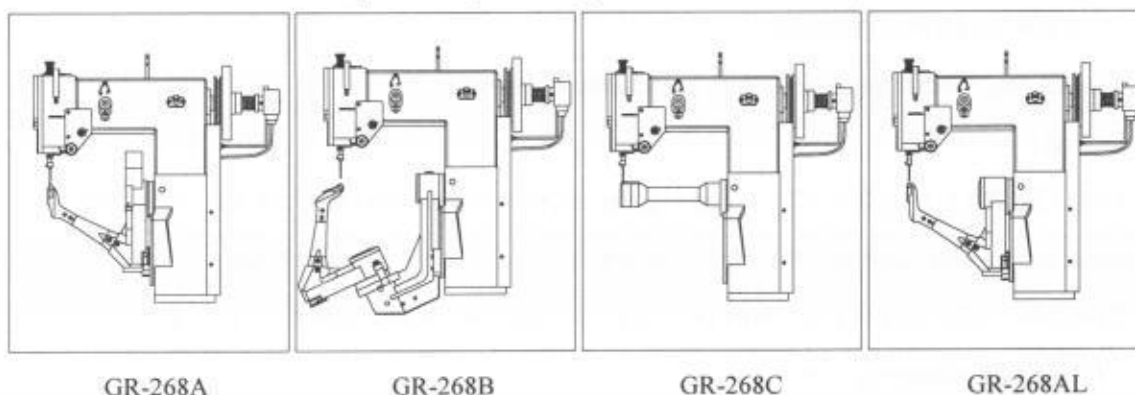


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I . Machine description

GR-268 is a double thread sewing machine. Three kinds of arms can be fixed on this machine(as shown in below pictures). GR-268A equipped with Arm-A to sew the side seams of shoes ; GR-268B equipped with Arm-B to sew bottom of shoes and GR-268C equipped with Arm-C for ideal on the last. It's possibility to change the arm each other (GR-268A/AL/B/C)



This machine is driven by an asynchronous electric motor . The sewing speed can be controlled stepless and the needle stop position can be controlled by asynchronous electric motor , the presser foot can be lifted automatically.

II. Technical features of the machine

Sewing speed:	Stepless speed regulating
Stitch length:	3-12mm
Stitch thickness:	A: 1.5-8mm (AL: 1.5-5mm) B: 1.5-12mm C: 1.5-10mm
Lifting capacity:	20mm
Travel of needle bar:	50mm
Sewing needle:	A、AL: CP×5(23#/25#/27#) B: DD×1(27#) C: CP×1(25#/27#)
Sewing thread:	Compound thread
Motor:	750W/380V three-phase
Lighting:	7W/220V single-phase
Weight:	A、AL: 244kg(N.W.) B: 256kg(N.W.) C: 238kg(N.W.)
Machine dimensions:	110×56×125cm(L×W×H.)

III. Preparation of the machine ready for use

1 Fix the needle

To fix the needle, proceed as follows

-- Turn the pulley in the correct direction as shown on the belt cover by hand so that needle bar comes to its highest position.

-- Loosen the clamping screw.

-- Insert the needle upto the bottom of the needle hole.

Attention:

1. On GR-268A and GR-268C, keeping the short groove positioned on the right side from the operator and rotate it about 10° in the clockwise direction. (look from above)

2. On GR-268B, keeping the short groove positioned on the left side from the operator.

-- Tighten the clamping screw.

2 Needle thread preparation

To prepare the needle thread, proceed as follows

-- Turn the pulley in the correct direction so that the needle bar comes to its highest position.

-- Thread the needle thread by the path indicated in Fig 1.

- (1) Threading rod (2) Guiding ring (3) Thread gripping holder (4) Positioning pin
(5) Thread tighter (6) Upper threading wheel (7) Take-up spring (8) Threading ring
(9) Thread take-up lever (10) Lower threading wheel (11) Needle holder (12) Needle

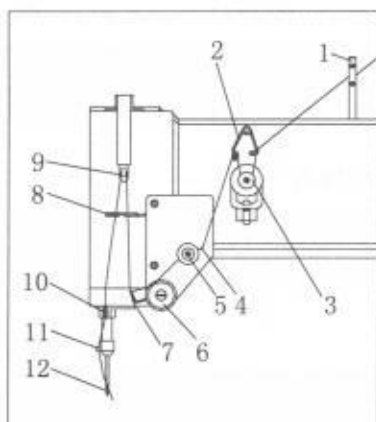


Fig 1

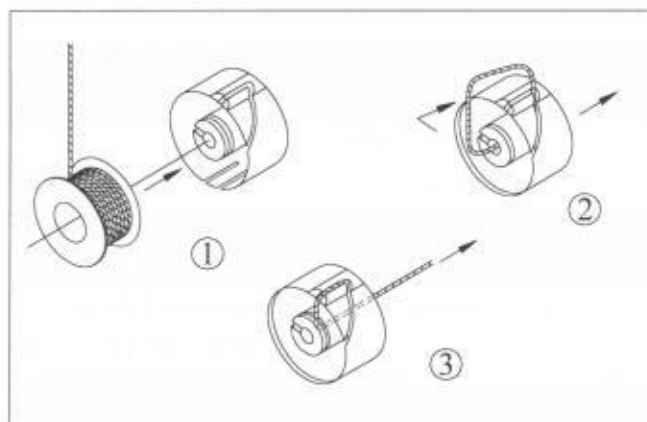


Fig 2

3 Bobbin thread preparation

To prepare the bobbin thread , proceed as follows

- Place the bobbin in the bobbin holder device.
- Thread the bobbin thread by the path indicated in Fig 2.

IV. Use of the machine

1 Start pedal

First of all, switch on the machine to check if the rotation of the motor is conformable to the red arrow on the belt cover. If the direction is opposite, switch in the other way round. Then operate the pedal in three different movement.(Fig 3)

- Stepping on forward(position A) means advance. Stepping on lightly is slow and stepping on heavily is fast. Avoid stepping on heavily at the very beginning.
- Stop in the neutral position.
- Stepping on backward(position B) means lifting the presser foot so that it is easy to place the shoe onto the stitching area.

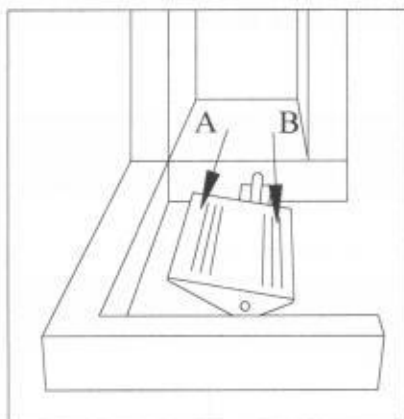


Fig 3

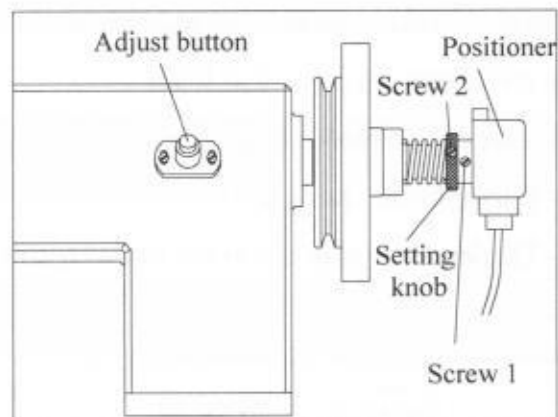


Fig 4

2 Stitch length adjustment setting(Fig 4)

To adjust the stitch length, press the adjust button with one hand and turn the pulley with the other. When a click is heard, turn the pulley slightly to increase or reduce the stitch length according to the arrow on the frame.

3 Tension adjustment setting of the needle thread

To adjust the needle thread tension, proceed as follows(Fig 5)

- Rotate the knob 1 in a clockwise to increase the tension of needle thread. and vice-versa.
- Loosen screw 2 and adjust shell 3 to set the take-up spring 4 drop to the lowest position.
- Loosen the screw 5 ,turn the pin 6 in an anti-clockwise direction to increase the pressure of the take-up spring 4 and vice-versa. After adjustment, tighten the screw 5.

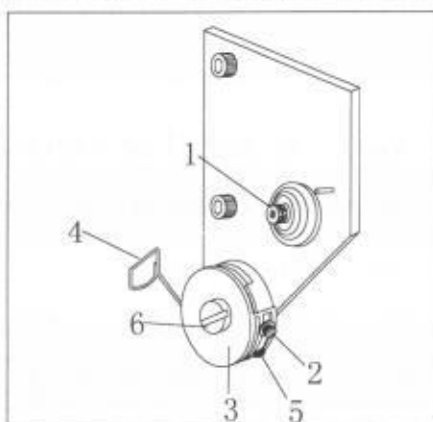


Fig 5

4 Tension adjustment setting of the bobbin thread

Bobbin thread tension is adjusted through the hook spring leaf in the hook. To adjust the bobbin thread tension, proceed as follows

- Take out the bobbin holder from its seat.
 - Prizing up the spring leaf with screwdriver to increase the bobbin thread tension.(Fig 6)
 - Flatting the hem of the spring leaf with screwdriver to reduce the bobbin thread tension.(Fig 7)
- 7)

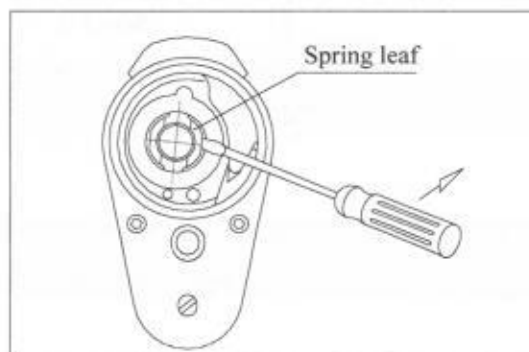


Fig 6



Fig 7

Attention:

Make sure that the spring leaf is not so flat that it can't get in touch with the bobbin. As a result, the bobbin thread tension can't be adjusted.

5 Pressure adjustment setting of the presser foot

To adjust the pressure of the presser foot, proceed as follows(Fig 8)

- Loosen the nut 5.
- Turn the knob 4 in a clockwise direction to increase the pressure of the presser foot. And turn the knob 4 in an anti-clockwise to reduce it.
- After adjustment, tighten the nut 5.

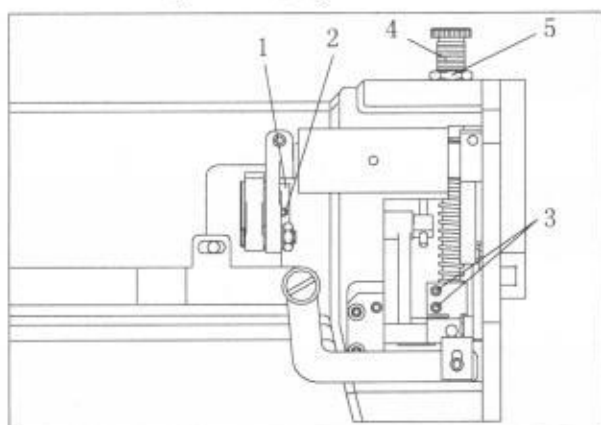


Fig 8

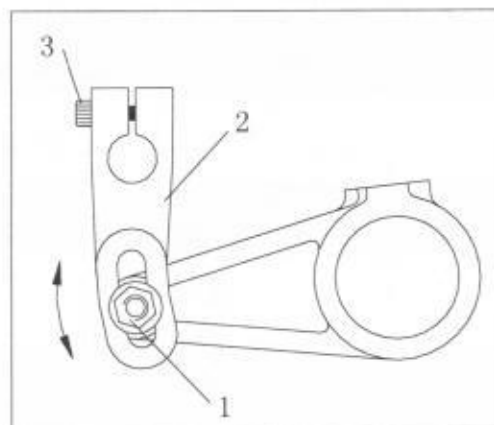


Fig 9

6 Adjustment of the presser foot jump

The inner presser foot jump depends on the thickness of the sewn materials. The inner presser foot must be off the sewn materials when the outer presser foot holds it down.

To adjust the presser foot jump, proceed as follows

- Loosen the nut 1, move it upward in the buttonhole to increase the presser foot jump. And vice-versa.(Fig 9)
- The outer presser foot jump also needs adjusted according to different sewn materials . Loosen the screw 3(Fig 8) and move the outer presser foot up or down to a proper height.
- Movement changes if the inner and the outer presser foot are not equal in position. In this case, the inner presser foot needs adjusting. Put down the presser foot and grasp the inner presser foot. Loosen the screw 3(Fig 8) and move it up or down to a proper height.

V. Replacement and adjustment

1 Adjustment of the needle-foot transport

(1) Turn the pulley in the correct direction. When the needle comes down 32-34mm from its highest position the needle bar supporter together with the needle bar and the inner presser foot begins to move backward.(Fig 10)

To adjust it, proceed as follows

- Loosen the two screws on the eccentric driving block.(Fig 11)
- Turn the pulley in the correct direction to meet the requirements mentioned above.
- After adjustment, tighten the screws.

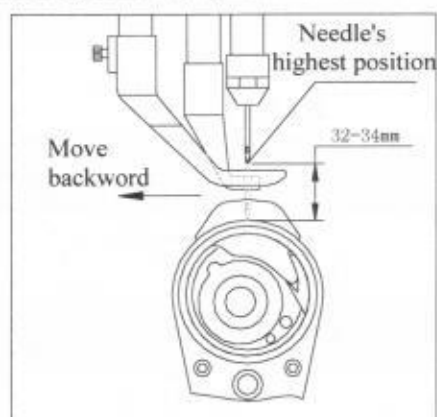


Fig 10

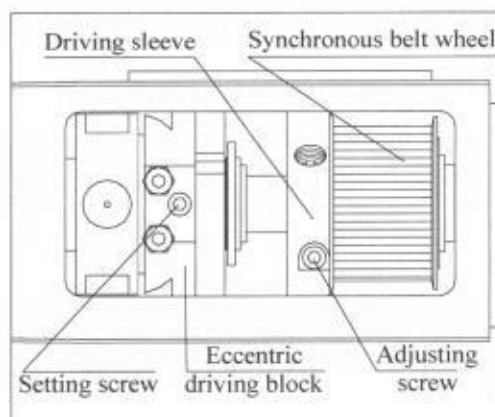


Fig 11

(2) The inner presser foot and needle should remain synchronous. As the needle descends, so does the inner presser foot. The inner presser foot can be made slow.

If the sewn material is thick. To adjust it, proceed as follows

- Loosen the screw 2 of the eccentric gear 1(Fig 8).
- Turn the pulley in the correct direction to adjust it properly.
- After adjustment, tighten the screw 2.

2 Speed adjustment of the hook

To adjust the speed of the hook, proceed as follows

-- Remove the belt cover. Turn the pulley in the correct direction so that the needle bar crank deflect about 15° towards vertical direction or the thread take-up lever raise about 3mm from its lowest position. (as shown in Fig 12a)

-- At this time, watch the elliptic gear case. The plate end of the synchronous belt wheel shaft should be in the vertical direction. (Fig 12b)

-- If the speed of the hook is not correct, please adjust the two adjusting screws of the driving sleeve that is fixed at the end of the main shaft (Fig 11). As thus, the speed of the hook can be adjusted.

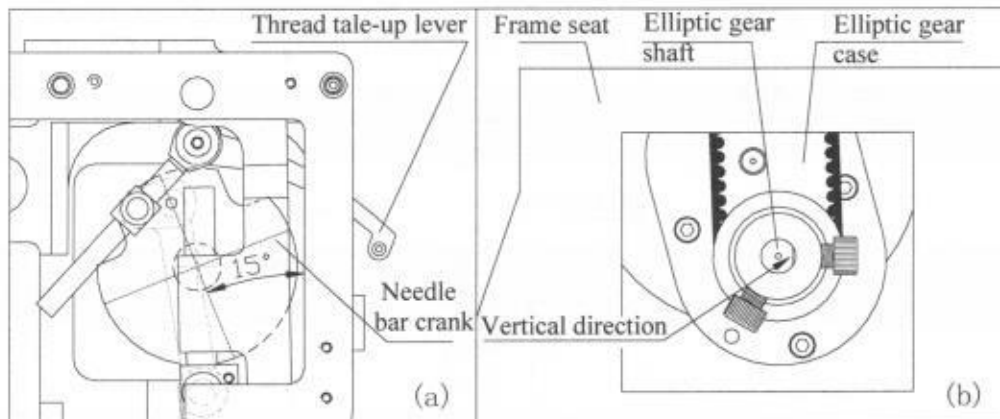


Fig 12

3 Adjustment of the needle-hook relation

To adjust the needle-hook relation, proceed as follows

-- Loosen the two setting screws(M10) of the conical gear or of the driving sleeve(shaft) in the right hole of the frame seat.(Fig 14)

-- Turn the pulley in the correct direction. When the needle bar raise 3-3.5mm from its lowest position, the tip of the hook is just at 1/3 of the upper recess of the needle.(Fig 13)

-- The distance between the hook tip and the needle slot surface is 0.05mm(Fig 13). To adjust it, loosen the four M12 fixing screws(Fig 14) on the frame seat and move the frame.

--The longer the stitch length is, the lower the hook tip will be at the needle slot. Make sure that the hook tip can't be too high or too low.Otherwise it might run into the top or bottom of the needle recess.

--Tighten the screws after adjustment.

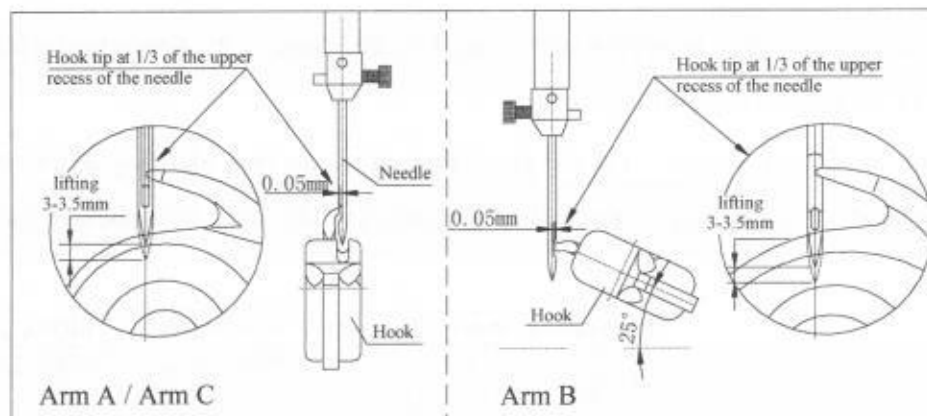


Fig 13

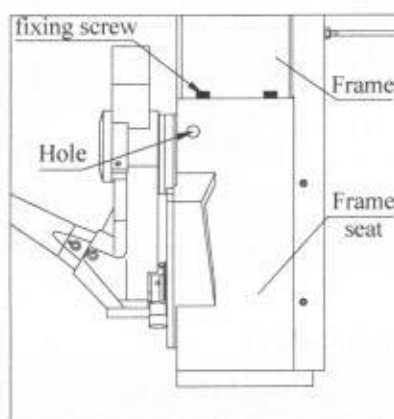


Fig 14

4 Adjustment of stopping position

The positioner is used to control the pause position of the needle bar. To adjust the stopping position, proceed as follows(Fig 4)

- Loosen the screws on the positioner.
- Adjust the relative position between the positioner and the main shaft.
- Tighten the screws after adjustment.

5 Adjustment of the thread gripping holder

Generally, the needle thread should keep loose when the needle pierces the sewn material. When the needle thread is hooked by hook and the thread take-up lever begins to move upwards, the needle thread should be tighten. Otherwise, the relative position between the gripping cam and the main shaft needs adjusting. To adjust it, proceed as follows

- Loosen the two setting screws on the gripping cam.
- Turn the pulley and the adjustment can be done.

-- Tighten the two setting screws after adjustment.

6 Adjustment of the safety clutch

The on-off driver is applied to this sewing machine. When the machine is overchanged, the pulley will run idle, releasing the main shaft automatically. The motor stops running in two seconds to ensure the safety of the machine.

To adjust the safety clutch, proceed as follows(Fig 4)

-- Loosen the screw 2 of the clutch setting knob.

-- Loosen the clutch setting knob, until releasing the spring completely.

-- Place a sewing material to be sewn in the stitching area.

-- Tighten the clutch setting knob, until touch the spring.

-- Rotate the setting knob circle by circle, at the same time turn the pulley.If the needle just can drill the material and the clutch not slide, the safety clutch adjustment setting is correct.

7 Adjustment of the Chain and Replacement of the Ball Connecting Rod (Fig.15)

When the chain in the bent holder ③ becomes loose, it can be adjusted in the following ways.

--Loosen the screw ⑩ to dismantle the cover of bent holder ⑨ Then loosen slowly the two screws ⑥ on the sprocket washer ⑤ in the bent holder ③.

-- Adjust the screw ④ below the bent holder ③.Turn it right to make the tight. After that tighten the screw ⑥. Loosen the screw ⑧ on the cover of bent holder ⑨. The nut ⑦ should also be adjusted.

--After adjustment, the parts should be remounted successively.And tighten the screw.

--Dismantle the cover of bent holder, the sprocket and so on. The ball connecting rod (11) can be removed when the screw ① is loosened. The flat end of the ball connecting rod should be in the same direction as it was dismantled. So it is with the other ball connecting rod.

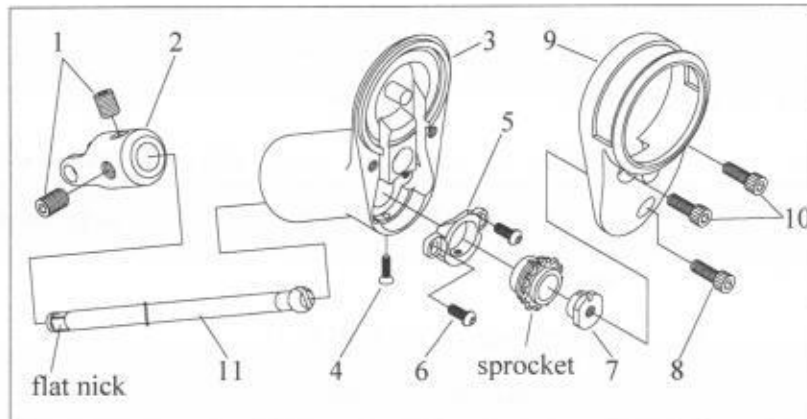


Fig 15

8 Change the different kind of arms on this machine

It has three kinds of arms can be fixed on this machine. It can be fixed according to the operator's requirements.

Arm A、AL fixed on the frame by means of the fixing bushing by four M8 screws.

Arm B fixed on the frame by means of the fixing bushing by four M8 screws. and by four M6 screws on the arm supporter.

Arm C fixed on the frame directly by four M8 screws. (as shown in the Fig 16)

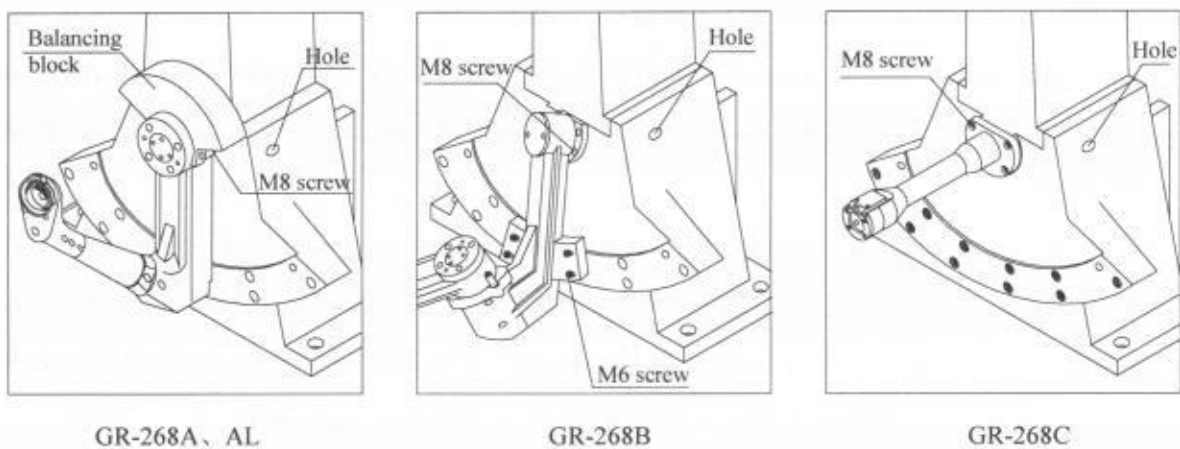


Fig 16

To change the arm, Proceed as follows(Fig 16)

-- Turn the pulley in the correct direction until the needle raise to its highest position, remove the inner and the outer presser foot. (If the Arm A is fixed must remove the balancing block at first.)

-- Loosen the two setting screws of the Synchronous belt wheel(Arm A) or of the driving

shaft(Arm B) or of the driving sleeve(Arm C).

- Remove the whole set of the arm.
- Replace the other whole set of the arm according to the operator's requirements.
- After replacement, tighten the screws again and adjust the needle-hook position as described

in this handbook Par. 5.3 .

VI. Maintenance and repair

1 The troubles can be detected on this sewing machine

(1)Hook jamed by thread

To demedy this trouble, proceed as follows

-- Switch off the machine. Turn the pulley in the count-correct direction to make the thread hook reverse as to remove the thread.

-- If couldn't remove the jamed thread as described above. Remove the relative parts such as needle plate etc. to remove the thread.

-- Fix the relative parts after remedy.

(2)Thread breaking

The reasons cause thread breaking and the way to remedy them as described below.

-- The quality of the thread does not meet the machine standard .The way to remedy it: Using the thread that's quality meet the machine standard.

-- Wrong sequence of the passages during the threading. The way to remedy it: Rethread the needle thread as described in this handbook Par.3.2 .

-- Replacement of the parts invoved in the thread passage.The way to remedy it: Check if there are sharpening edges in the replace parts, otherwise polish them with the cloth or an abrasive thread.

-- Defective needle.The way to remedy it: Needle replacement.

(3)Missing point

The reasons caused missing point and the way to remedy it as described below.

-- The hook is weared.The way to remedy it: Hook replacement.

-- The needle-hook timing is not correct.The way to remedy it: Adjust the needle-hook timing as described in this handbook Par. 5.2 and Par. 5.3 .

-- Obstacles inside the shoe.The way to remedy it: Check if no obstacles inside the shoe,

otherwise clean it completely.

(4) Needle breaking

The main reasons cause the needle breaking and the ways to remedy it as described below.

-- Wearing of the inner presser foot.

The way to remedy it: Replace it with a new one.

-- Breaking, wearing or wrong replacement of the metal cables.

The way to remedy it: Replace it with new ones or adjust it as discribed in this handbook Par.5.6 .

-- The needle-hook position is not correct.

The way to remedy it: Adjust the needle-hook timing as described in this handbook Par.5.2 and Par. 5.3 .

-- Obstacles inside the shoe.

The way to remedy it: Check if there are no obstacles inside the shoe. Otherwise clean it completely

2 Ordinary maintenance

A careful maintenance represents an important factor for a longer life of the machine under the best functioning and performing conditions.

The machine must be daily lubricated at the end of the shift. Rotating parts must be carefully and accurately lubricated. The cable hole, the driving parts in the horn, in the horn seat, in the frame and in the frame seat and the oiling ports indicated in Fig 17 must be lubricated every shift. Other mechanical parts on this machine must be lubricated every week.

The choice of oil is very important, since it must be neither too fluid nor too dense. Viscosity recommended: 209 cSt at 40° .

Always keep the machine clean and clean the presser foot, the hook, and the bobbin holder every shift. Check and oil the machine carefully when it is reused after a longtime. Test run and running slowly are required.

VII. Main warning

1 All the operations described in this handbook must be carried out when the machine is under the following conditions:

- Motor off
- Electric system off

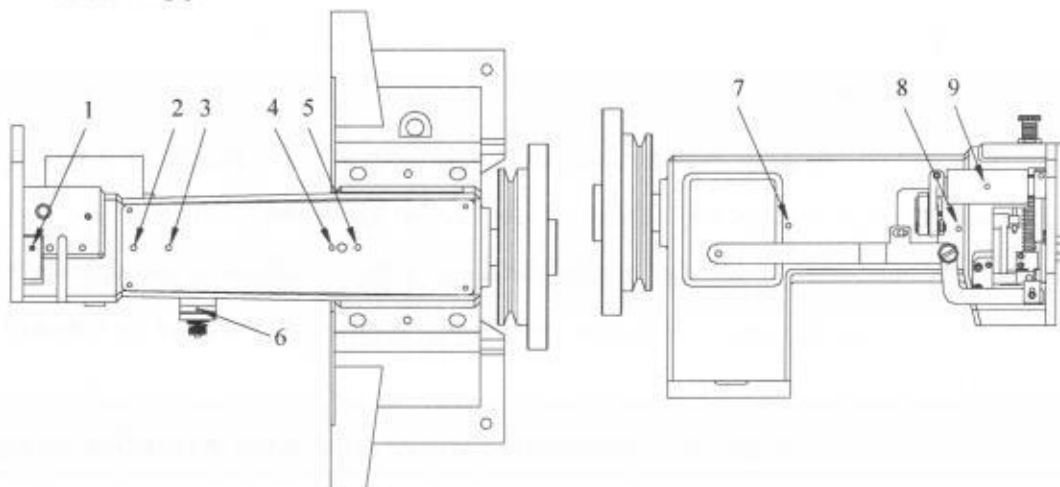
2 All the described adjusting and maintenance operations must be carried out by a skilled and qualified personnel in order to avoid any serious accident or damage to the machine.

3 Protections have been assembled by the builder in order to safeguard the operator's life while performing his tasks. During the machine functioning, protections must not be removed for any reason at all.

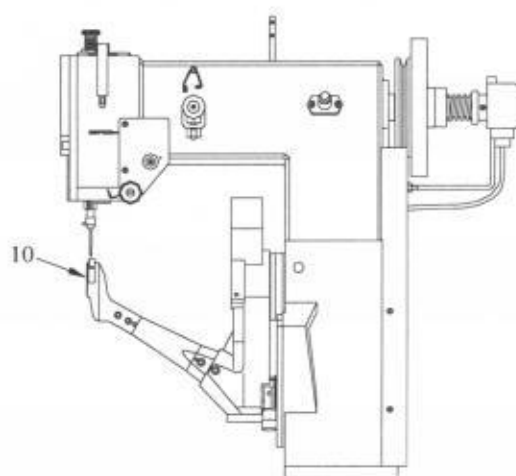
4 It is extremely important that the operator pays attention while using the machine during all the sewing phases. Since it is impossible to assemble a protection device in the sewing area, the operators authorized to use the machine are kindly requested to use it properly, thus avoiding any sort of inattention.

The oiling ports of the machine as indicated in Fig 17 must be lubricated every shift.

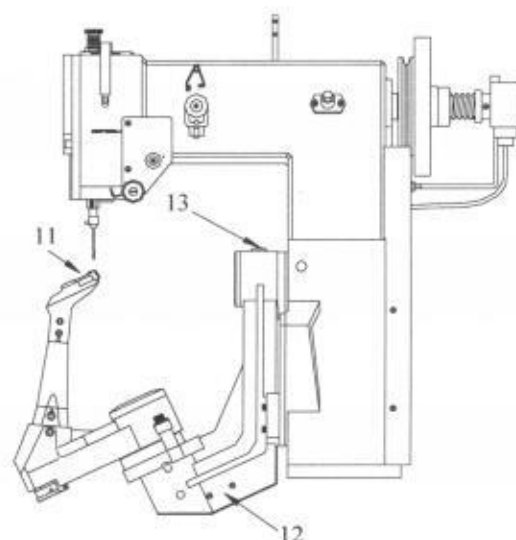
The oiling ports of the frame



The oiling ports of the Arm A on GR-268A



The oiling ports of the Arm A on GR-268B



VIII. Spare part's for the sewing machine

	Fig.No.	Part's name	Quantity
GR-268A	268-921	Ball connecting rod	1
	268-931	Ball connecting rod	1
	168-2339	Needle holder	1
	168-4047	Bobbin	5
	168-4046-2	Hook spring leaf	2
	168-4048-2	Spring leaf	2
	168-4053	Gear	1
	168-4055	Sprocket	1
	168-4056	Sprocket washer	1
	268-319A	Inner presser foot	1
	268-330A	Outer presser foot	1
		Chain	1
		Needle(CP×5)	10
GR-268B	268-921	Ball connecting rod	1
	268-931	Ball connecting rod	1
	268-324B	Needle holder	1
	168-4047	Bobbin	5
	168-4046-2	Hook spring leaf	2
	168-4048-2	Spring leaf	2
	168-4053	Gear	1
	168-4055	Sprocket	1
	168-4056	Sprocket washer	1
	268-319B	Inner presser foot	1
	268-330B-1	Outer presser foot holder	1
	268-330B-2	Outer presser foot	1
		Chain	1
		Needle(DD×1)	10
GR-268C	268-324C	Needle holder	1
	169-4047	Bobbin	5
	168-4046-2	Hook spring leaf	2
	169-4048-2	Spring leaf	2
	268-319C	Inner presser foot	1
	268-330C-1	Outer presser foot holder	1
	268-330C-2	Outer presser foot	1
		Needle(CP×5)	10

IX. Part's supplied with the machine

Part's name	Quantity
Complete series of allen wrenches(1.5-10mm)	1
T-allen wrench(3mm/4mm/5mm)	Each1
Screwdriver(5×200)	1
Wrench(8-10、13-16mm)	Each1
Tweezers	1
Oiler	1
Thread wheel	1
Instruction manual	1

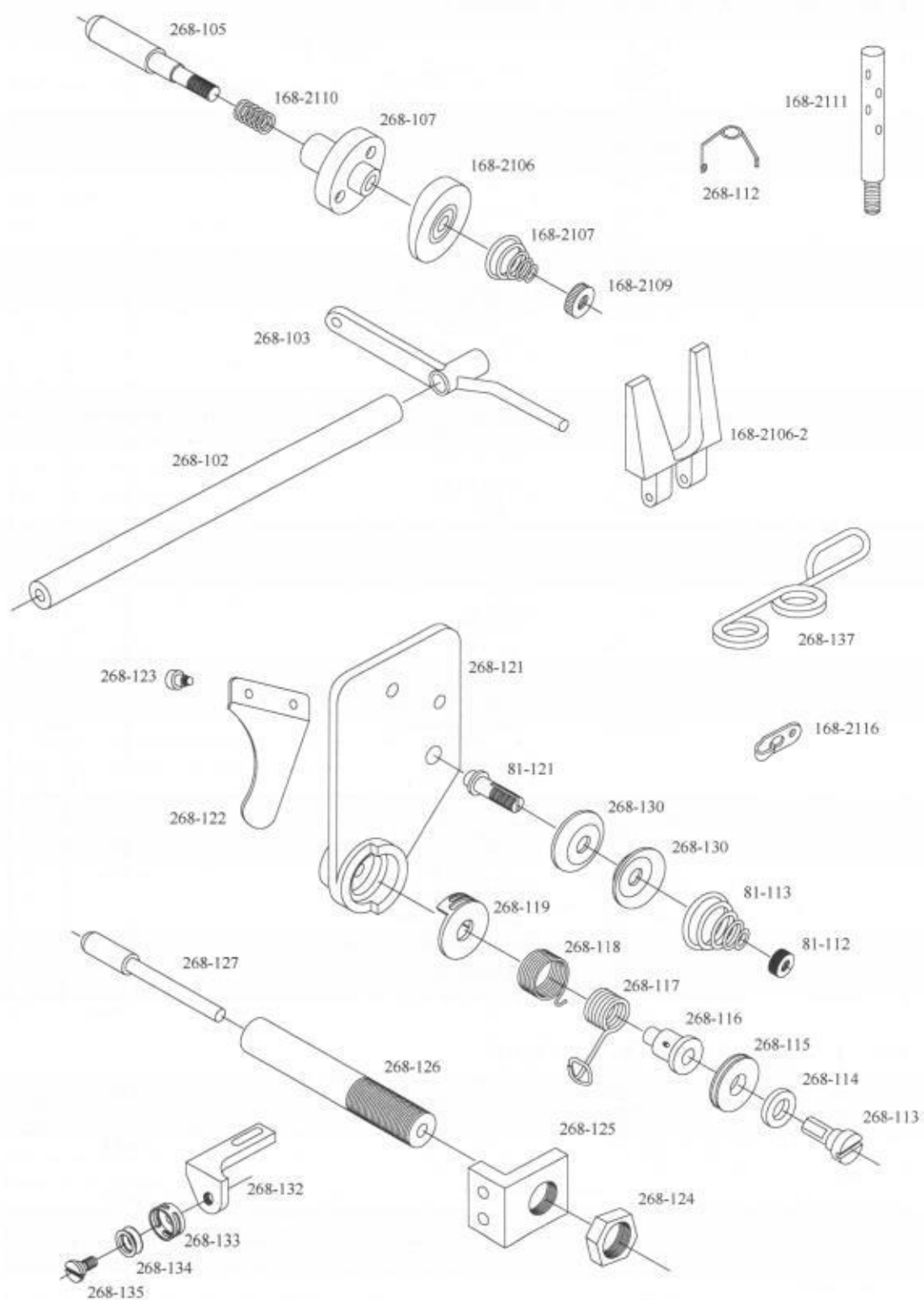


Fig. No.	Part's name	Quantity
268-101	Frame	1
268-102	Shaft	1
268-103	Connecting lever	1
168-2106-2	Thread releasing block	1
268-105	Pushing rod	1
168-2110	Spring	1
268-107	Fixing sleeve	1
168-2106	Clamping sleeve	1
168-2107	Conical spring	1
168-2109	Knob	1
168-2111	Threading rod	1
268-112	Thread guiding ring	1
268-113	Pin	1
268-114	Washer	1
268-115	Threading wheel	1
268-116	Wringing spring holder	1
268-117	Thread take-up spring	1
268-118	Wringing spring	1
268-119	Shell	1
268-121	Fixing plate	1
268-122	Thread releasing plate	1
268-123	Screw	2
268-124	Nut	1
268-125	Supporter	1
268-126	Thread releasing rod sleeve	1
268-127	Thread releasing rod	1
81-112	Knob	1
81-113	Conical spring	1
268-130	Tension disk	2
81-121	Thread tension rod	1
268-132	Supporter	1
268-133	Shell	1
268-134	Threading wheel	1
268-135	Screw	1
168-2116	Thread carrier	1
268-137	Threading ring	1

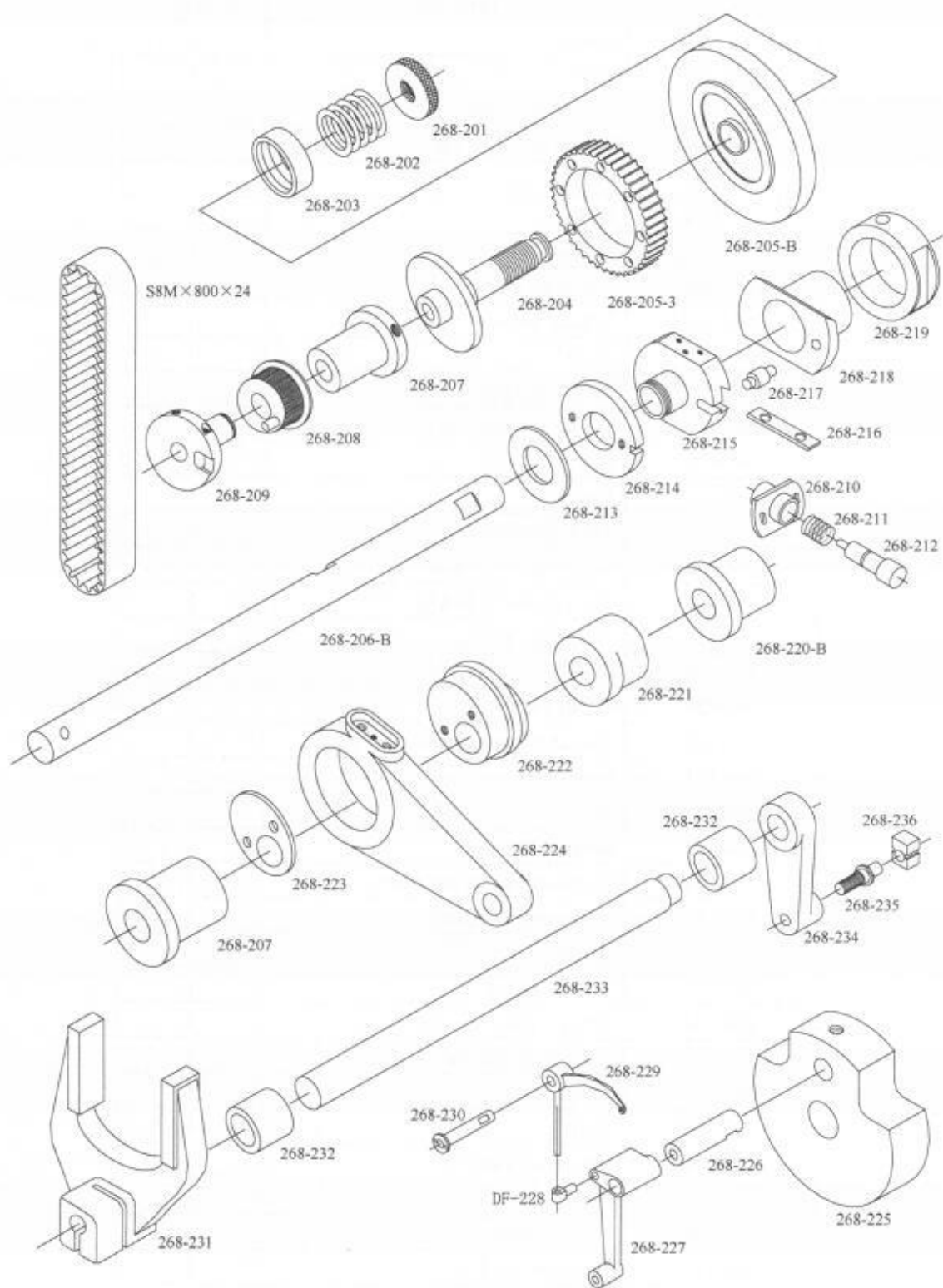


Fig. No.	Part's name	Quantity
268-201	Safety clutch setting knob	1
268-202	Spring	1
268-203	Bearing protecting bushing	1
268-204	Clutch shaft	1
268-205-B	Pulley	1
268-205-3	Synchronous belt wheel	1
268-206-B	Main shaft	1
268-207	Main shaft bushing(front & rear)	2
268-208	Synchronous belt wheel	1
268-209	Driving sleeve	1
268-210	Spring holder	1
268-211	Spring	1
268-212	Stitch length adjusting button	1
268-213	Washer	1
268-214	Eccentric adjusting ring	1
268-215	Eccentric driving block	1
268-216	Gag	1
268-217	Locating pin	1
268-218	Eccentric gear of needle bar swing	1
268-219	Cupreous bushing	1
268-220-B	Main shaft bushing(center)	1
268-221	Gripping cam	1
268-222	Eccentric gear of lifting foot	1
268-223	Caver of eccentric gear	1
268-224	Connecting lever	1
268-225	Needle bar crank	1
268-226	Pin	1
268-227	Connecting lever of needle bar	1
268-228	Slide sleeve	1
268-229	Thread take-up lever	1
268-230	Fixing pin	1
268-231	Fork	1
268-232	Bushing	2
268-233	Needle bar swing shaft	1
268-234	Needle bar swing crank	1
268-235	Pin	1
268-236	Slide plate	1
S8M×800×24	Synchronous belt	1

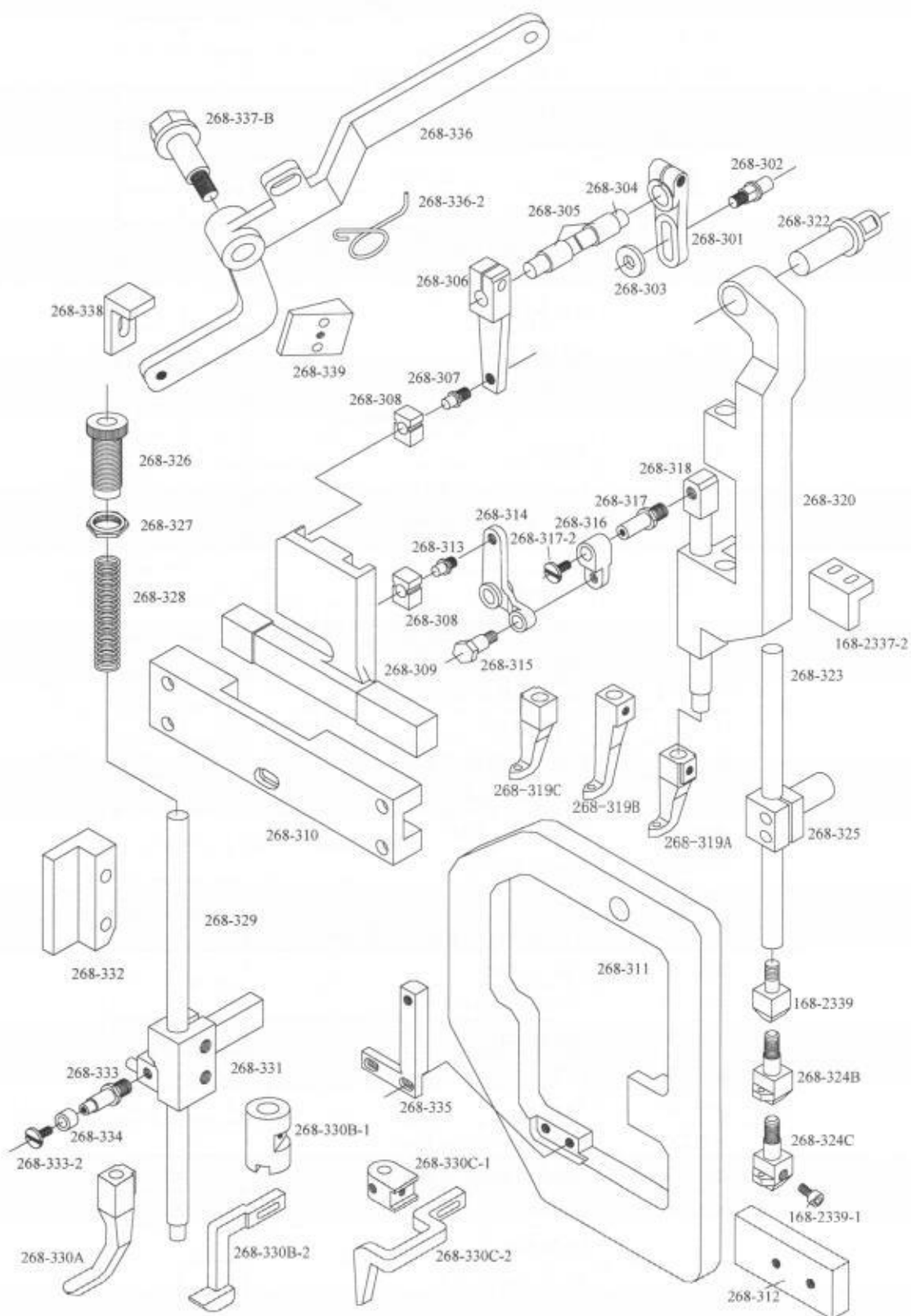


Fig. No.	Part's name	Quantity
268-301	Adjusting crank	1
268-302	Pin	1
268-303	Washer	1
268-304	Short shaft	1
268-305	Bushing	2
268-306	Presser foot lifting crank	1
268-307	Pin	1
268-308	Slide plate	2
268-309	Integrated slide plate	1
268-310	Guiding track	1
268-311	Supporter	1
268-312	Stop off	1
268-313	Pin	1
268-314	Presser foot lifting lever	1
268-315	Screw	1
268-316	Connecting block	1
268-317	Connecting pin	1
268-317-2	Screw	1
268-318	Inner presser foot bar	1
268-319A	Inner presser foot(for GR-268A)	1
268-319B	Inner presser foot(for GR-268B)	1
268-319C	Inner presser foot(for GR-268C)	1
268-320	Needle bar supporter	1
168-2337-2	Rear stop off	1
268-322	Pin	1
268-323	Needle bar	1
168-2339	Needle holder(for GR-268A)	1
168-2339-1	Screw	1
268-324B	Needle holder(for GR-268B)	1
268-324C	Needle holder(for GR-268C)	1
268-325	Needle bar holder	1
268-326	Pressure adjusting knob	1
268-327	Nut	1
268-328	Spring	1
268-329	Outer presser foot bar	1
268-330A	Outer presser foot(for GR-268A)	1
268-330B-1	Outer presser foot holder	1
268-330B-2	Outer presser foot(for GR-268B)	1
268-330C-1	Outer presser foot holder	1
268-330C-2	Outer presser foot(for GR-268C)	1
268-331	Outer presser foot bar guide	1
268-332	Guiding stop off	1
268-333	Pin	1
268-333-2	Screw	1
268-334	Roller	1
268-335	Guiding block	1
268-336	Presser foot lifting rocker arm	1
268-336-2	Spring	1
268-337-B	Pin	1
268-338	Adjusting block	1
268-339	Thread releasing wedgy block	1

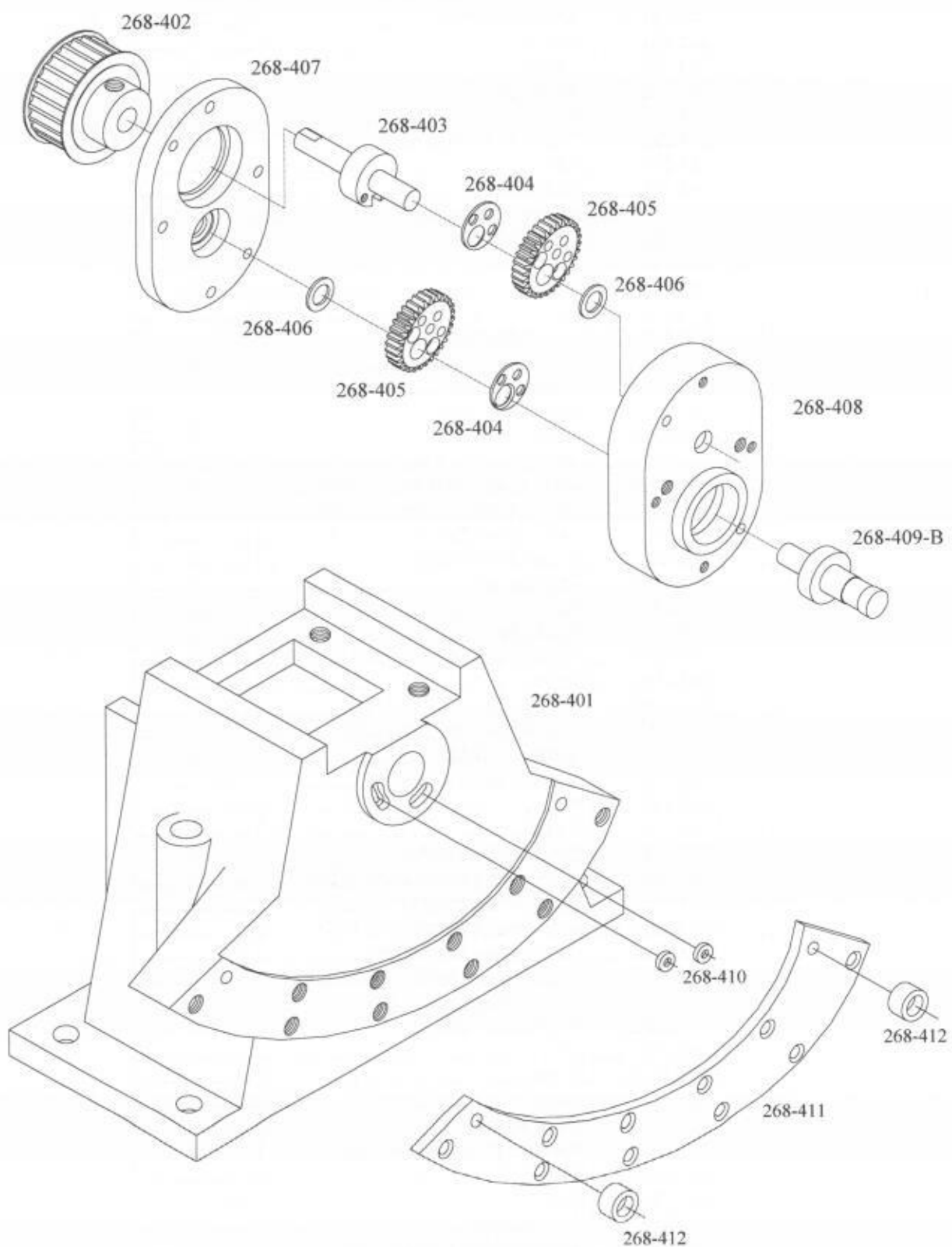


Fig. No.	Part's name	Quantity
268-401	Frame seat	1
268-402	Synchronous belt wheel	1
268-403	Input elliptic gear shaft	1
268-404	Washer	2
268-405	Elliptic gear	2
268-406	Washer	2
268-407	Elliptic gear case cover	1
268-408	Elliptic gear case	1
268-409-B	Output elliptic gear shaft	1
268-410	Washer	2
268-411	Arc plate	1
268-412	Stopping block	2

MOD. 268A

Exploded view diagram of the MOD. 268A mechanical assembly, showing various components and their part numbers:

- 268-918
- 168-4019
- 168-4047
- 268-920
- 168-4057
- 268-937
- 268-938
- 168-4015
- 168-4012
- 268-914
- 268-916
- 268-938
- 168-4048
- 168-4048-2
- 168-4047
- 168-4042
- 168-4045-1
- 168-4045
- 168-4044
- 168-4046-2
- 168-4046
- 168-4043
- 168-4041
- 168-4054
- 168-4053
- 168-4055
- 168-4056
- 168-4040
- 268-921
- 168-4024
- 168-4022-1
- 168-4023-1
- 168-4022-1
- 268-928
- 268-928
- 168-4029
- 268-926
- 268-927
- 268-925
- 268-935
- 168-4036
- 268-931
- 168-4032
- 168-4022-2
- 168-4023-2
- 268-933
- 168-4022-2
- 168-4032
- 268-934
- 268-939
- 5M×385×12
- T5×460×18
- 3/16"×32
- Toothed universal joint
- Universal joint
- 268-910-B

Fig. No.	Part's name	Quantity
268-910-B	Synchronous belt wheel	1
268-913	Clamping ring	1
268-914	Synchronous belt wheel	1
268-916	Hub of bent holder	1
268-918	End cover axle	1
268-920	Bent holder	1
268-921	Ball connecting rod	1
268-925	Fixed pin of gear	1
268-926	Gear support	1
268-927	Composite gear	1
268-928	Toothed universal joint	1
268-931	Ball connecting rod	1
268-935	Support of synchronous belt wheel	1
268-937	Support	1
268-938	Support Bearing	2
268-939	Connecting sleeve	1
168-4011	Washer	1
168-4012	Locking block	1
168-4015	Baffle of synchronous belt wheel	1
168-4017	Cover of bent holder	1
168-4019	Spacer	1
168-4032	Universal joint	1
168-4036	Bearing baffle	1
168-4040	Head end of bent holder	1
168-4041	Shuttle driver	1
168-4042	Cover of bent holder	1
168-4043	Geared ring	1
168-4044	Shuttle stand	1
168-4045	Needle plate	1
168-4045-1	Screw	2
168-4046	Shuttle	1
168-4046-2	Shuttle spring leaf	1
168-4047	Bobbin	1
168-4048	Bobbin cover	1
168-4048-2	Spring leaf	1
168-4053	Gear	1
168-4054	Nut	1
168-4055	Sprocket	1
168-4056	Sprocket washer	1
168-4057	Bent holder weighting	1
T5×460×18	Synchronous belt	1
5M×385×12	Synchronous belt	1
3/16"×32	Chain	1

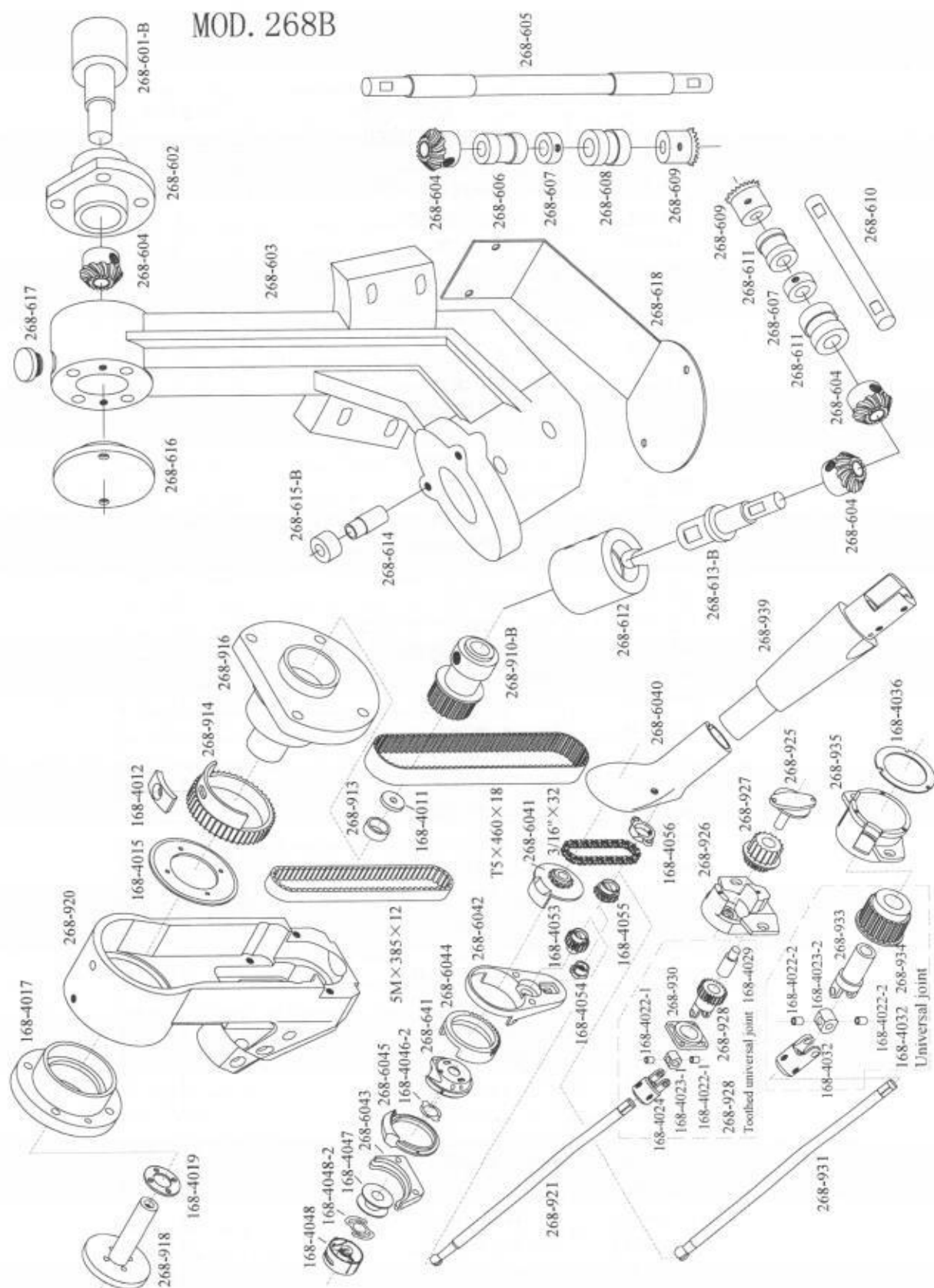


Fig. No.	Part's name	Quantity	Fig. No.	Part's name	Quantity
268-601-B	Shaft	1	268-928	Toothed universal joint	1
268-602	Fixing bushing	1	268-931	Ball connecting rod	1
268-603	Horn seat supporter	1	268-935	Support of synchronous belt wheel	1
268-604	Conical gear	4	268-939	Connecting sleeve	1
268-605	Shaft	1	168-4011	Washer	1
268-606	Bushing	1	168-4012	Locking block	1
268-607	Clamping ring	2	168-4015	Baffle of synchronous belt wheel	1
268-608	Bushing	1	168-4017	Cover of bent holder	1
268-609	Conical gear	2	168-4019	Spacer	1
268-610	Shaft	1	168-4032	Universal joint	1
268-611	Bushing	2	168-4036	Bearing baffle	1
268-612	Bearing seat	1	168-4046-2	Shuttle spring leaf	1
268-613-B	Shaft	1	168-4047	Bobbin	2
268-614	Stopping rod	2	168-4048	Bobbin cover	1
268-615-B	Protecting sleeve	2	168-4048-2	Spring leaf	1
268-616	Cover	1	168-4053	Gear	1
268-617	Oiling cover	1	168-4054	Nut	1
268-618	Cable cover	1	168-4055	Sprocket	1
268-641	Hook	1	168-4056	Sprocket washer	1
268-910-B	Synchronous belt wheel	1	268-6040	Head end of bent holder	1
268-913	Clamping ring	1	268-6041	Shuttle driver	1
268-914	Synchronous belt wheel	1	268-6042	Cover of bent holder	1
268-916	Hub of bent holder	1	268-6043	Geared ring	1
268-918	End cover axle	1	268-6044	Shuttle stand	1
268-920	Bent holder	1	268-6045	Needle plate	1
268-921	Ball connecting rod	1	T5×460×18	Synchronous belt	1
268-925	Fixed pin of gear	1	5M×385×12	Synchronous belt	1
268-926	Gear support	1	3/16"×32	Chain	1
268-927	Composite gear	1			

MOD. 268C

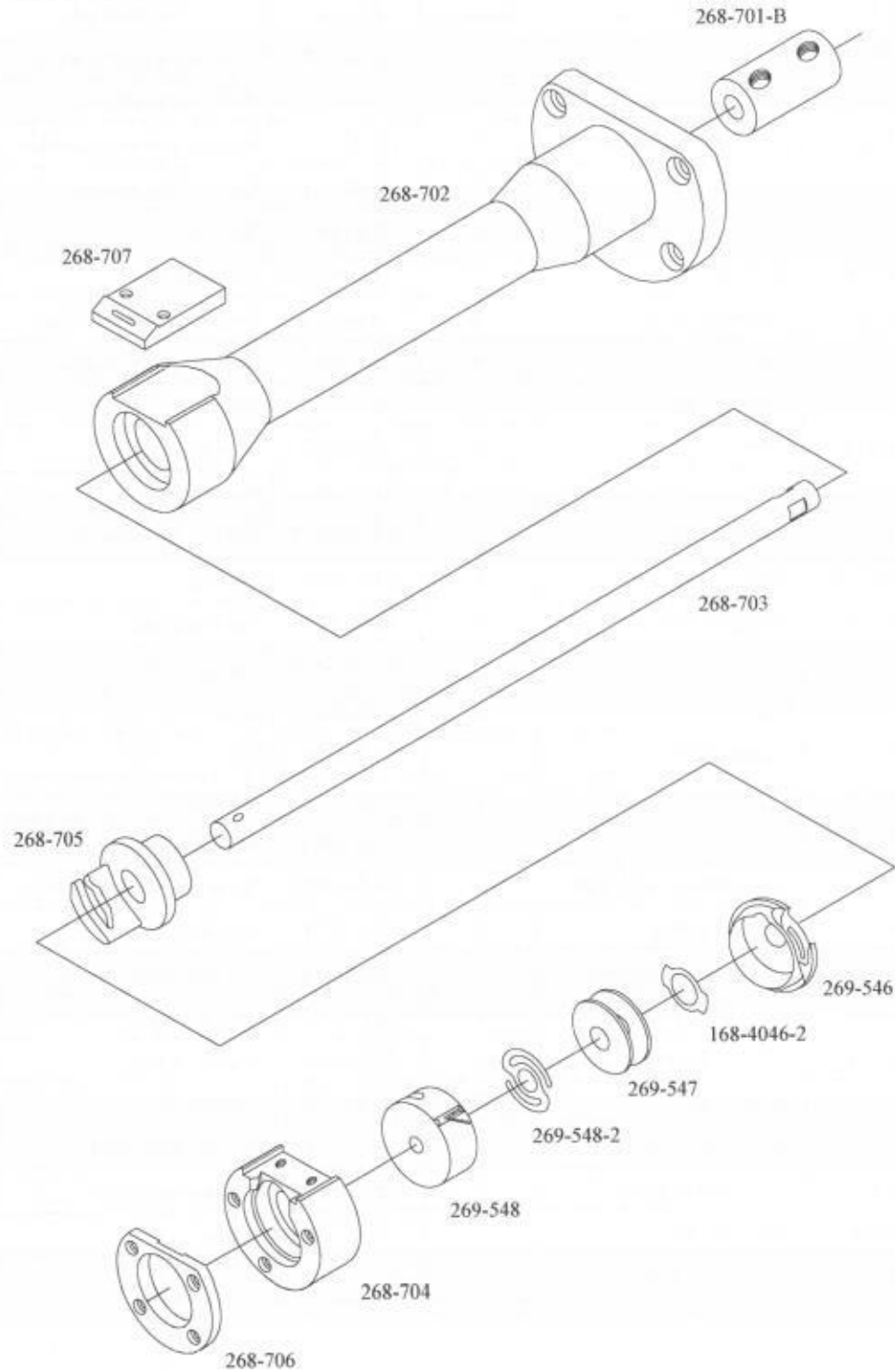


Fig. No.	Part's name	Quantity
268-701-B	Driving sleeve	1
268-702	Arm C	1
268-703	Hook driver shaft	1
268-704	Hook seat(for GR-268C)	1
268-705	Hook driver	1
268-706	Cover	1
268-707	Needle plate	1
168-4046-2	Hook spring leaf	1
269-546	Hook	1
269-547	Bobbin	1
269-548	Bobbin holder	1
269-548-2	Spring leaf	1

MOD. 268AL

Exploded view diagram of the MOD. 268AL mechanical assembly, showing various components and their part numbers:

- 268-918
- 168-4019
- 168-4017
- 268-1037
- 268-938
- 268-1020
- 168-4015
- 168-4012
- 168-4057
- 268-914
- 268-916
- 168-4048
- 168-4048-2
- 168-4047
- 268-1042
- 168-4045-1
- 168-4045
- 168-4044
- 168-4046-2
- 168-4046
- 168-4043
- 168-4041
- 268-1058
- 168-4054
- 168-4053
- 168-4055
- 168-4056
- 268-1059
- 268-921
- 168-4024
- 168-4023-1
- 168-4022-1
- 268-928
- 268-928
- 268-1026
- 268-927
- 268-925
- 268-931
- 168-4032
- 168-4022-2
- 168-4023-2
- 268-933
- 168-4032
- 268-934
- 168-4036
- 5M×385×12
- T5×500×18
- 3/16"×40
- 268-910-B
- 268-1040
- 268-939
- Universal joint
- Toothed universal joint

Fig. No.	Part's name	Quantity
268-910-B	Synchronous belt wheel	1
268-913	Clamping ring	1
268-914	Synchronous belt wheel	1
268-916	Hub of bent holder	1
268-918	End cover axle	1
268-921	Ball connecting rod	1
268-925	Fixed pin of gear	1
268-927	Composite gear	1
268-928	Toothed universal joint	1
268-931	Ball connecting rod	1
268-935	Support of synchronous belt wheel	1
268-938	Support Bearing	2
268-939	Connecting sleeve	1
268-1020	Bent holder	1
268-1026	Gear support	1
268-1037	Support	1
268-1040	Head end of bent holder	1
268-1042	Cover of bent holder	1
268-1058	Transition gear	1
268-1059	Transition gear	1
168-4011	Washer	1
168-4012	Locking block	1
168-4015	Baffle of synchronous belt wheel	1
168-4017	Cover of bent holder	1
168-4019	Spacer	1
168-4032	Universal joint	1
168-4036	Bearing baffle	1
168-4041	Shuttle driver	1
168-4043	Geared ring	1
168-4044	Shuttle stand	1
168-4045	Needle plate	1
168-4045-1	Screw	2
168-4046	Shuttle	1
168-4046-2	Shuttle spring leaf	1
168-4047	Bobbin	2
168-4048	Bobbin cover	1
168-4048-2	Spring leaf	1
168-4053	Gear	1
168-4054	Nut	1
168-4055	Sprocket	1
168-4056	Sprocket washer	1
168-4057	Bent holder weighting	1
T5×500×18	Synchronous belt	1
5M×385×12	Synchronous belt	1
3/16"×40	Chain	1

