

# **26518D/26528D**

**Single needle/twin needle post-bed**

**Needle bar feed lockstitches with auto trimmer**

**OPERATION MANUAL  
PART BOOK**

## 1.Preparation for operation

### 1) Safety precautions

- (1) When turning the power on, keep your hands and fingers away from the area around/under the needle and the area around the pulley.
- (2) Power must be turned off when the machine is not in use, or when the operator leaves the seat.
- (3) Power must be turned off when tilting the machine head, installing or removing the "V" belt, adjusting the machine, or when replacing.
- (4) Avoid placing fingers, hairs, bars etc. near the pulley, "V" belt, bobbin winder pulley, or motor when the machine is in operation.
- (5) Do not insert fingers into the thread take-up cover, under/around the needle, or pulley when the machine is in operation.
- (6) If a belt cover, finger guard, eye guard are installed, do not operate the machine without these safety devices.

### 2) Precautions before starting operation

- (1) Never operate the machine before filling the machine's oil pan.
- (2) When a new sewing machine is first turned on, verify the rotational direction of the pulley with the power on.
- (3) Verify the voltage and phase (single or three) with those given on the machine nameplate.

### 3) Precautions for operating conditions

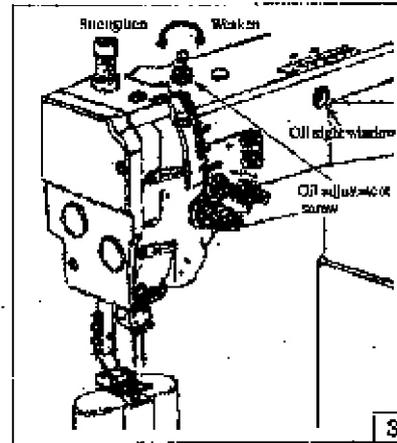
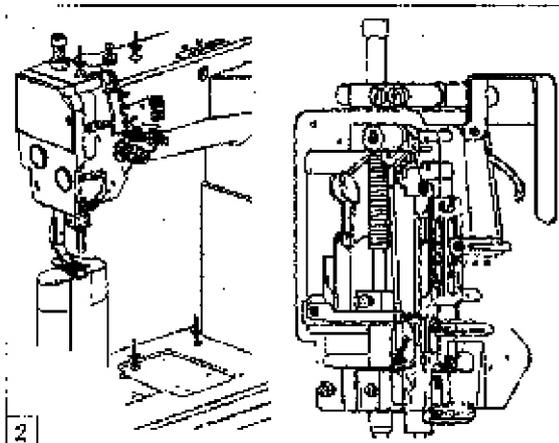
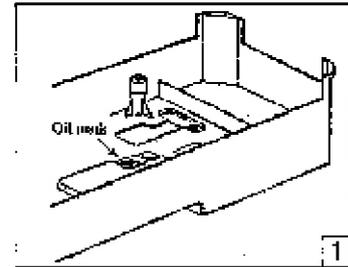
- (1) Avoid using the machine at abnormally high temperatures (35℃ or higher) or low temperatures (5℃ or lower)
- (2) Avoid using the machine in dusty conditions.

### 4) Specifications

Model		single	twin
Max. sewing speed		2000rpm	
Stitch length		0—5mm	
Needle bar stroke		33.4mm	
Presser foot stroke	By hand	7mm	
	By knee	10mm	
Hook		1.6times hook	
Needle		DP×5 (14#-18#)	
Needle gauge			8 mm
Lubrication		Semi-auto lubricated	
Motor		220V550W Servo motor	

## 2. Lubrication (Fig.1、 Fig.2、 Fig.3)

- 1) Before starting operation, be sure to pour oil up to the position H of oil tank. If the oil below position L, replenish the oil supply up to position H. (Fig.1)
- 2) When a new sewing machine is first operated, or when a sewing machine which left out of use for a long period of time is operated, it will be necessary to oil through the oilholes after removing the rubber plugs shown below(the direction shown in arrows). (Fig. 2)
- 3) While operating the machine, check the condition of oil lubrication through the oil check window. The oil amount can be adjusted by oil adjustment screw.(Fig. 3)



## 3. How to attach needle(Fig.4、 Fig.5)

**Note:** Before attach needle, be sure to turn off the power.

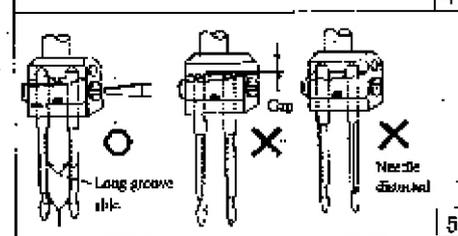
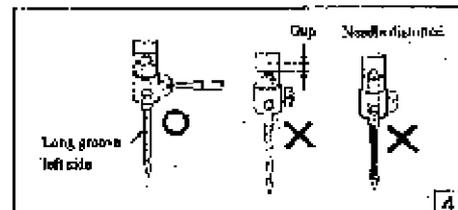
- 1) Turn the balance wheel by hand to raise the needle bar to its highest position.
- 2) Loosen the needle clamping screw.
- 3) H7200-1 (Fig.4)

Hold the needle to its side with the long groove side (left), then insert the needle as deeply as it will go into the needle clamping hole.

### H7200-2 (Fig.5)

Hold the needles so that the two needles side with the long grooved (faces each other), and insert it as deeply as it will go into the needle clamping holes.

- 4) Tighten the needle clamping screw.



#### 4. How to wind the lower thread (Fig.6)

##### Strength of winding

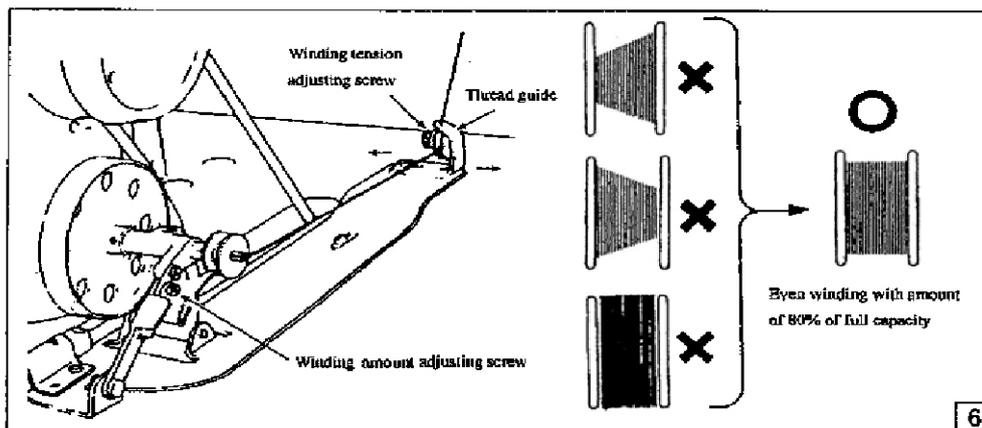
Particularly in the case of nylon or polyester thread, wind the bobbin loosely.

##### Uneven winding

If the bobbin is wound unevenly, slide the thread guide toward the less wound portion of bobbin.

##### Winding amount

When the bobbin is wound excessively, loosen the adjusting screw. When the bobbin is wound insufficiently, tighten the adjusting screw.

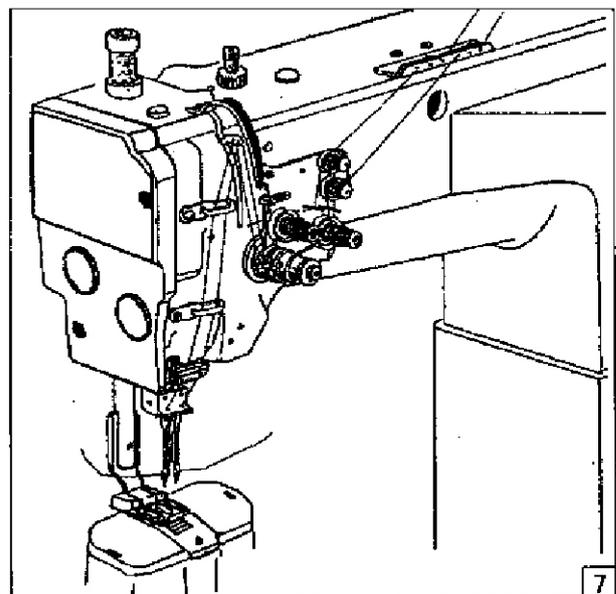


#### 5. How to route the upper thread (Fig.7)

Raise the thread take-up lever to its highest position and lead the upper thread as shown in fig.7

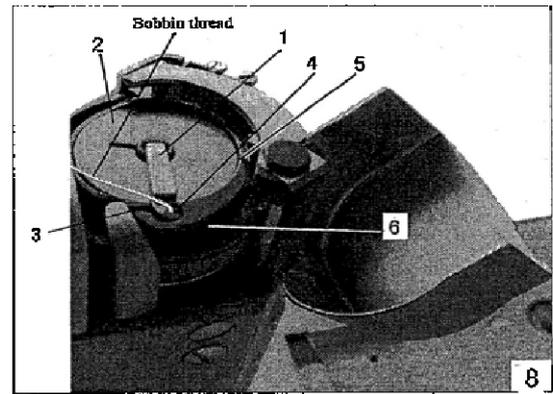
#### 6. Setting of bobbin (Fig.8)

- 1) Raise flap 1 and remove the empty bobbin.
- 2) Insert bobbin 2 in such a way that when the thread is unwound from it moves in the opposite direction to the gripper.
- 3) Pass the thread through slit 5 and below spring 6, pass the thread through slit 3 and pull about 3 cm through.
- 4) Close flap 1 and pass the thread through the flap's guide 4.



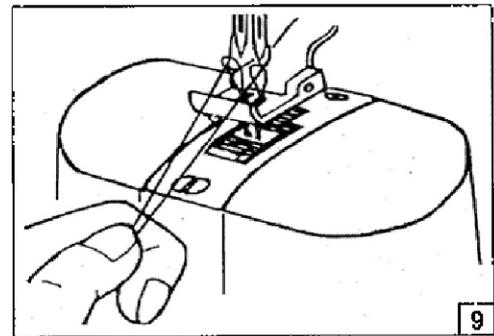
### 7. How to adjust the lower thread (Fig.9)

Pick up the end of needle thread by left hand and lightly press down the pedal by toe to run the machine one turn. When the needle thread is pulled up, the bobbin thread will be drawn out as shown in the right figure.



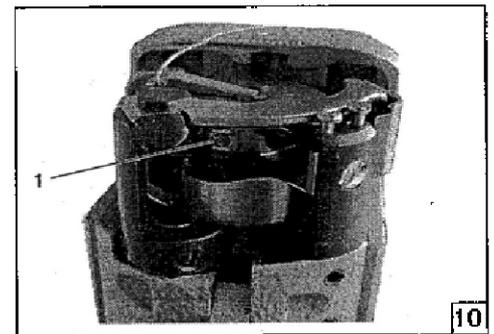
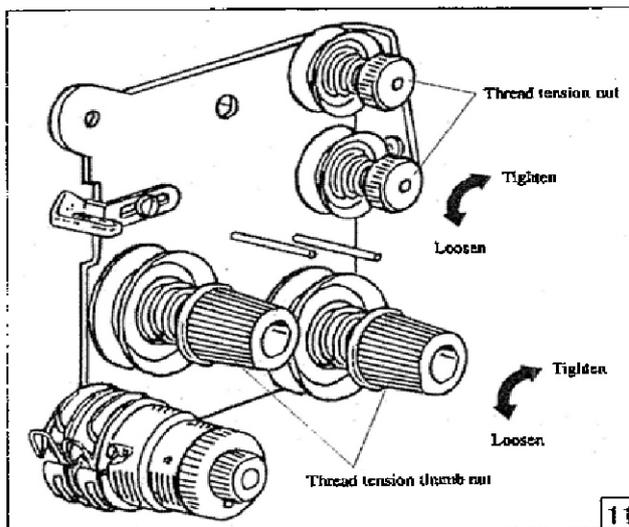
### 8. How to adjust the lower thread (Fig.10)

The lower-thread tension should be set in accordance with the type of seam required. Adjust the tension with screw 1.



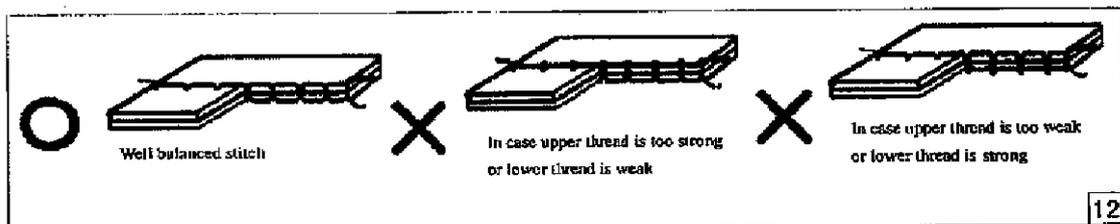
### 9. Adjustment of upper thread (Fig.11)

Turn the Thread Tension Nut left or right to loosen or tighten the pressure of upper thread.



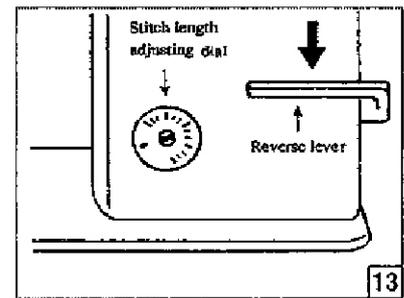
### 10. Adjusting of thread tension (Fig.12)

For ordinary stitching, the tension of the upper and the lower threads should be equal.



## 11. Adjustment of stitch length and reverse sewing (Fig.13)

- 1) Rotate the stitch length adjusting dial to change the stitch length.
- 2) Pressing the stitch length adjusting lever for reverse stitching.
- 3) Reverse feeding starts when Reverse Feed Lever is depressed, and the machine will feed forward again if Reverse Feed Lever is released.



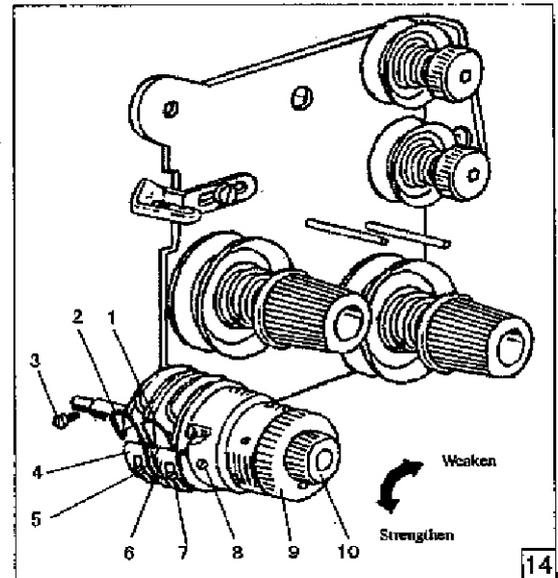
## 12. Adjusting thread take-up spring (Fig.14)

### 1) Adjusting the thread take-up spring stroke

- Thread take-up spring for left upper thread 2  
Loosen the screw 5, adjusting the stopper block 4.
- Thread take-up spring for right upper thread 1  
Loosen the screw 7, adjusting the stopper block 6.

### 2) Adjusting the thread take-up spring tension

- Thread take-up spring tension for left upper thread 2  
Loosen the nut 10 and screw 3, then adjusting the tension screw. After adjustment, tighten the nut 10 and screw 3.
- Thread take-up spring tension for right upper thread 1  
Loosen the screw 8, adjusting the nut 9. After adjustment, tighten screw 8.



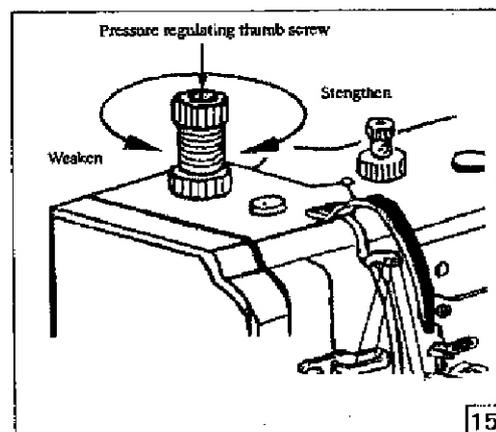
## 13. Adjustment of pressure of presser foot (Fig.15):

As shown in Fig.15, turn the pressure regulating thumb screw to increase or decrease the pressure of presser foot.

## 14. Adjust the thread guide

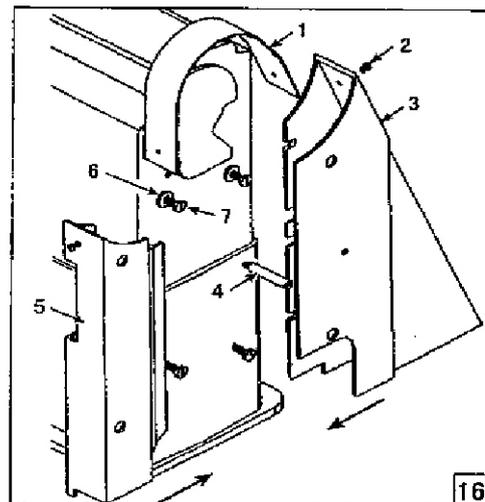
The position of the thread guide affects stitch tightness, and therefore must be adjusted according to sewing materials and sewing conditions.

Thread guide position	Leftward	Center	Rightward
Material weight	Heavy	Medium	Light
Supply	More	Standard	Less



## 15. Installation of Belt cover (Fig. 16)

Set the screw 4, 6 and the washer 7 on the arm as illustrated. Assemble the belt guard 3 in the direction of the arrow, tighten its screw. The assembling of the belt guard 5 is the same as the belt guard 3, then, insert the belt guard 1 from the top of the pulley into the inside of the 3 and 5, tighten the screw 2.



## 16. Driving knife adjustment (Fig. 17)

In resting position the rear edge of the driving knife should be flush with the front edge of the counter-knife.

The fixed knife should abut on the thread pulling knife along its total width.

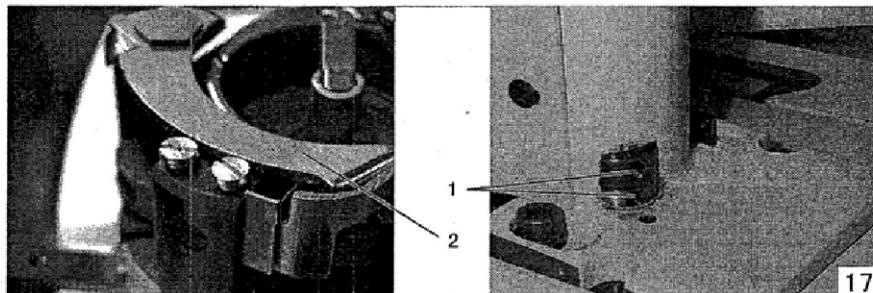
The pivoting driving knife should abut on the fixed knife after approx. 1/3 of its width.

The driving knife must not collide with the bobbin case.

The clearance between the lower blade edge of the driving knife a and the lower surface of the inner rotary hook b should be 0.3-0.4mm.

### Checking:

Loosen two screws 1 for adjusting the resting position of the driving knife 2 and adjust the knife according to the standard, then tighten screws 1.



### Attention:

Check the axial clearance of the knife shaft when tightening the screws 1. The driving knife must be easily movable and the axial clearance as low as possible.

## 17. Adjusting the fixed knife position and bobbin thread clamping (Fig. 18).

### Checking:

The clamping spring 5 has the function to hold the cut bobbin thread in order to avoid skipped stitches at the seam beginning.

Fixed knife 4 and driving knife 6 must be in parallel position standing under a slight cutting pressure.

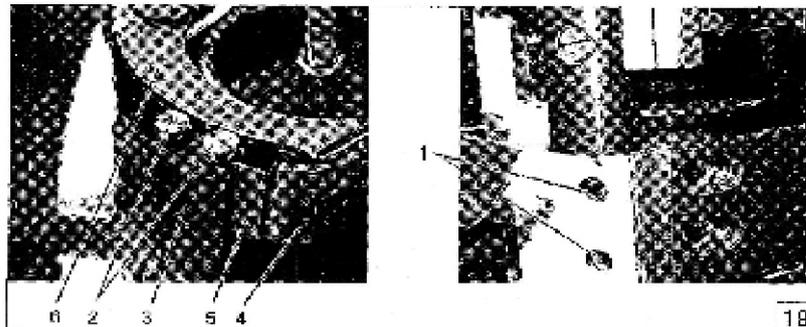
### Parallel position correction

Loosen screw **3** slightly for adjusting the parallel position of thread pulling knife **6** and counter-knife **4**, then change counter-knife **4** by setting the screws **2** in such a way that the edges of thread pulling knife and counter-knife are in parallel position. Tighten screw **3** at last.

### Cutting pressure adjustment

The knives should guarantee a safe cut at the lowest possible pressure of the counter-knife against the thread pulling knife. This is normally the case when the edge of the counter-knife just touches the thread pulling knife with a knife overlapping of 1/3.

Loosen screws **1**, then turn counter-knife support in such a way that the condition is fulfilled, at last, tighten screws **1**.



## 18. Adjustment of trimmer cam

- 1) Rotate the balance wheel to lower the needle to the DOWN position .
- 2) While keeping the DOWN position, press the cam follower crank to enter the roller into the trimmer cam groove.
- 3) Adjust the trimmer cam so that the movable knife starts moving when the balance wheel is turned by hand and the green mark point on the balance wheel meets the black point on the arm.

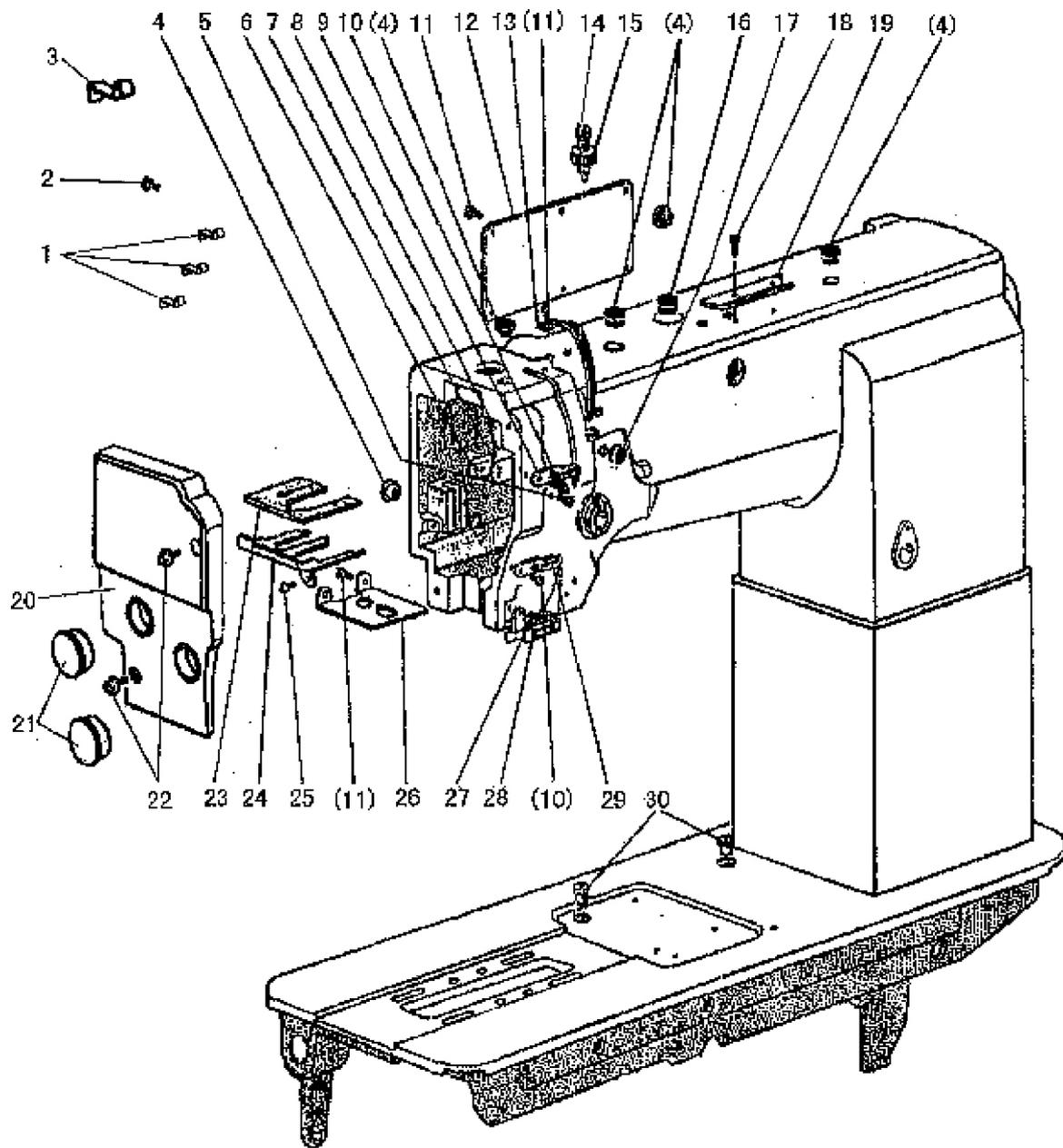
To adjust, loosen two trimmer cam screws

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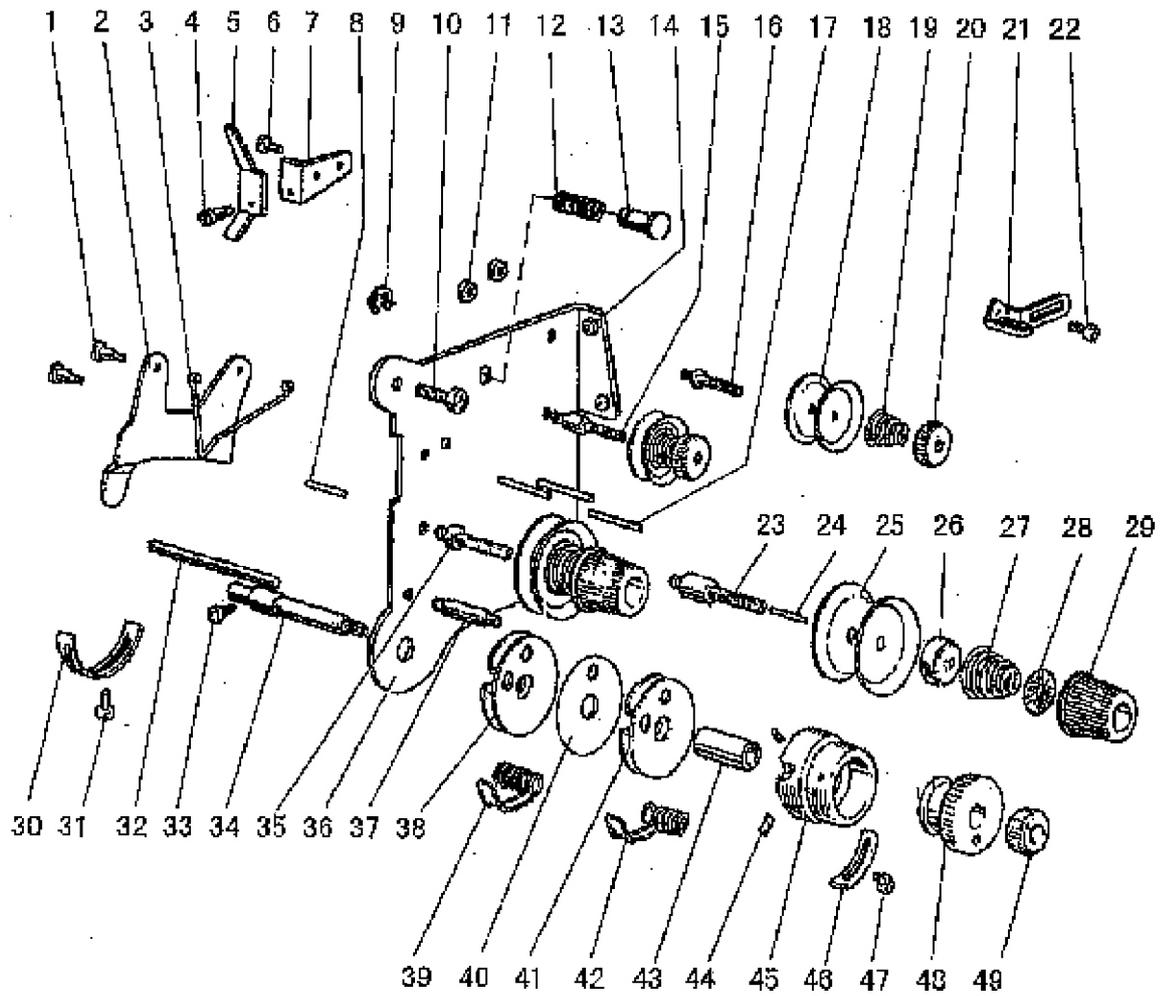
## A. Arm Bed & Accessories

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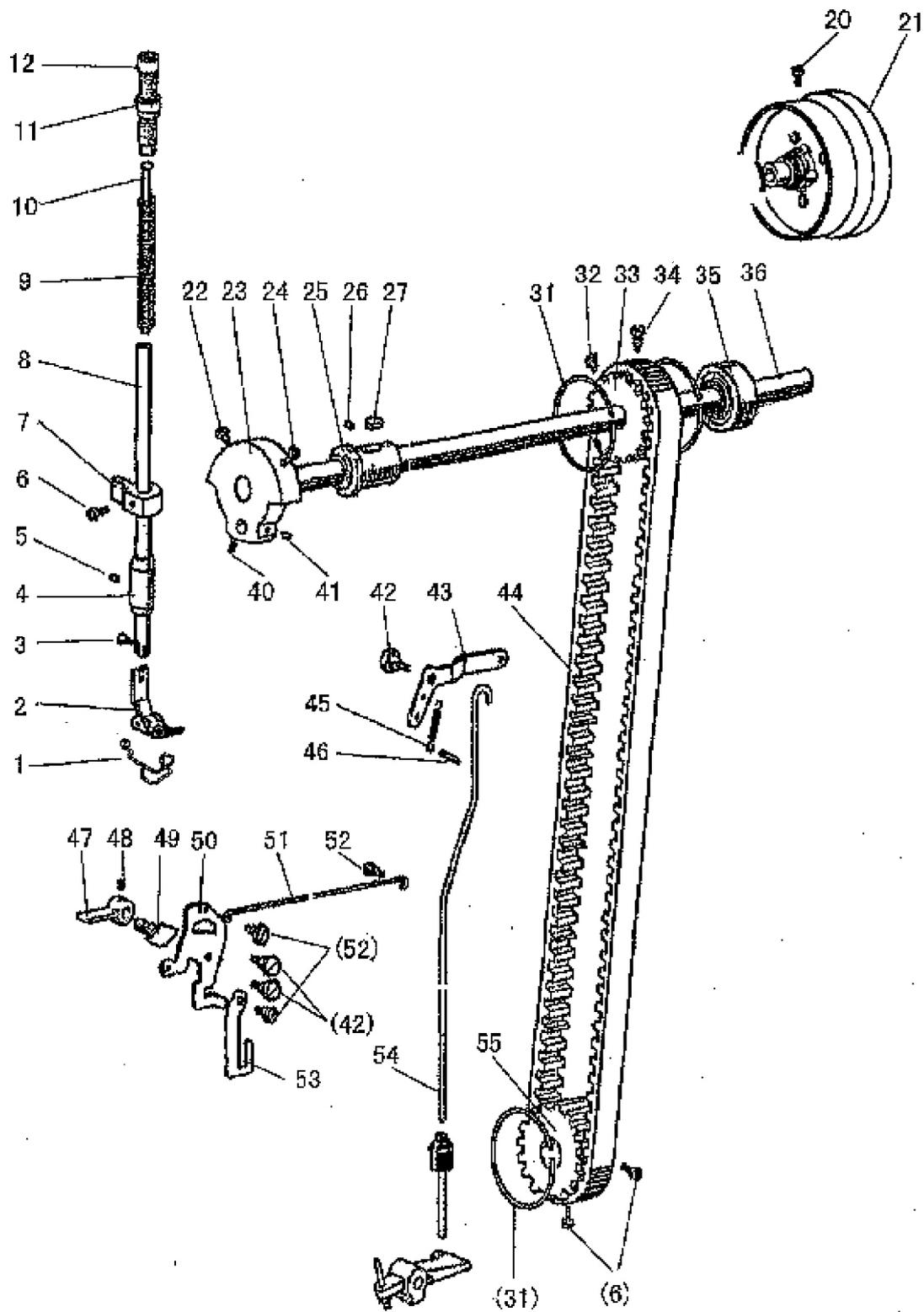
## B. Thread Tension Regulator Mechanism



## B. Thread Tension Regulator Mechanism

No.	Code No.	Parts Name	Q'ty	
			single	twin
1	H3221B6811	Screw	2	2
2	H4910C8001	Tension Releasing Plate	1	1
3	H3221B6812	Tension Releasing Spring	1	1
4	H4705C8001	Screw	1	1
5	H4076C8001	Lever	1	1
6	HA7311C306	Screw	1	1
7	H4707C8001	Mounting Plate	1	1
8	H3221B6817	Pin	1	1
9	H007013050	E-Type Ring	1	1
10	HA300C2030	Screw	2	2
11	H3221B6810	Nut	1	2
12	H4708C8001	Spring	1	1
13	H4709C8001	Push Button	1	1
14	H3221B0681	Porcelain Cluct	2	2
15	H3221B0685	Thread Tension Stud		1
16	H3221B0683	Thread Tension Stud	1	1
17	H3221B0682	Pin	2	3
18	HA112B0693	Thread Tension Disc	2	4
19	H3221B0684	Spring	1	2
20	HA710B0671	Thumb Nut	1	2
21	H3306B0661	Thread Guide	1	1
22	HA106B0676	Screw	1	1
23	H3221B0689	Thread Tension Stud	0	1
24	H3221B6816	Pin	0	1
25	HA310B0705	Thread Tension Disc	2	4
26	HA310B0702	Tension Releasing Plate	1	2
27	H4710C8001	Spring	1	2
28	HA115B7010	Thumb Nut Revolution Stopper	1	2
29	HA310B0701	Thumb Nut	1	2
30	H3221B6819	Stopper	1	1
31	H3200B2100	Screw	1	1
32	H3221B6818	Pin	1	1
33	H2004J0067	Screw	1	1
34	H32481B121	Screw	0	1
	H4805C8001	Screw	1	0
35	H3221B0686	Thread Tension Stud	1	1
36	H4908C8001	Mounting Plate	1	1
37	H32481B421	Screw	0	1
	H4804C8001	Screw	1	0
38	H32481BD21	Plate Complete	1	1
39	H4713C8001	Thread Take-Up Spring	1	1
40	H32481BE21	Plate	0	1
41	H32481BF21	Plate Complete	0	1
42	H4712C8001	Thread Take-up Spring	0	1
43	H32481B821	Bushing	0	1
44	H32481B521	Screw	0	2
45	H32481B921	Thread Tension Post	0	1
46	H32481BB21	Stopper	0	1
47	H32481BC21	Screw	0	1
48	H32481B621	Bushing	0	1
49	H32481B721	Thumb Nut	1	1

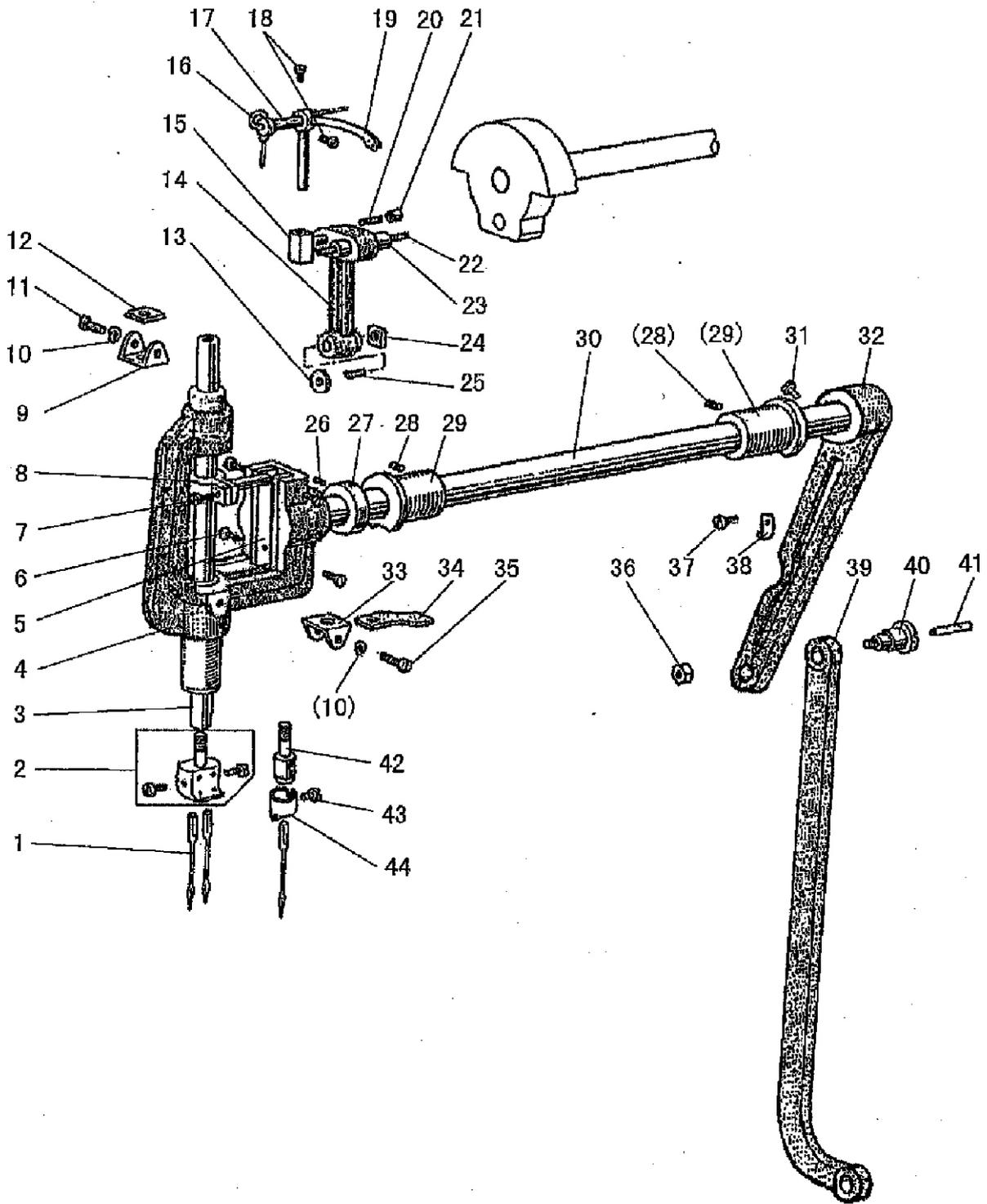
### C. Presser Bar Lifter Mechanism



## C. Presser Bar Lifter Mechanism

No.	Code No.	Parts Name	Q'ty	
			single	twin
1	H6200E2250	Walking Foot Guard Cover	1	1
2	H3306E0067	Presser Foot Complete		1
	H6204E7101	Presser Foot Complete	1	
3	H3200E2020	Screw	1	1
4	HA704B0651	Bushing	1	1
5	HA100C2020	Screw	1	1
6	HA104F0654	Screw	3	3
7	H3207E0661	Presser Bar Guide Bracket	1	1
8	H3200E2010	Presser Bar	1	1
9	H3200E2100	Spring	1	1
10	HA100H2120	Presser Spring Guide	1	1
11	HA117H0692	Nut	1	1
12	HA309H0681	Screw	1	1
20	HA110D0672	Screw	2	2
21	H4931L8001	Pulley	1	1
22	HA100C2060	Screw	1	1
23	H32121C104	Crank	1	1
24	HA100C2070	Screw	1	1
25	H32111B204	Arm Shaft Bushing Left (Complete)	1	1
26	H2405D0664	Screw	1	1
27	H32111B104	Felt	1	1
31	H3205C0661	Spring Flange	3	3
32	HA110D0672	Screw	1	1
33	H3205C1021	Pully	1	1
34	HA100F2130	Screw	1	1
35	H3205J0662	Needle Bearing	1	1
36	H9606D8001	Arm Shaft	1	1
37	HA703R0065	Detector Bracket (Complete)	1	1
40	HA105D0662	Screw	1	1
41	HA307C0662	Screw	1	1
42	HA100H2050	Screw	3	3
43	H3211E0691	Knee Lifter Lever (Right)	1	1
44	H6304C8001	Cog Belt	1	1
45	H3211E0692	Spring	1	1
46	H3200E2090	Pin Type	1	1
47	H3208E0067	Presser Bar Lifter	1	1
48	HA100B2110	Screw	2	2
49	H3200E2060	Eccentric	1	1
50	H3210E0682	Knee Lifter Lever Left	1	1
51	H3210E0681	Knee Lifter Rod	1	1
52	HA107H0662	Screw	3	3
53	H3210E0683	Operation Plate	1	1
54	H6307E8001	Operation Rod	1	1
55	H3207C0671	Pully	1	1

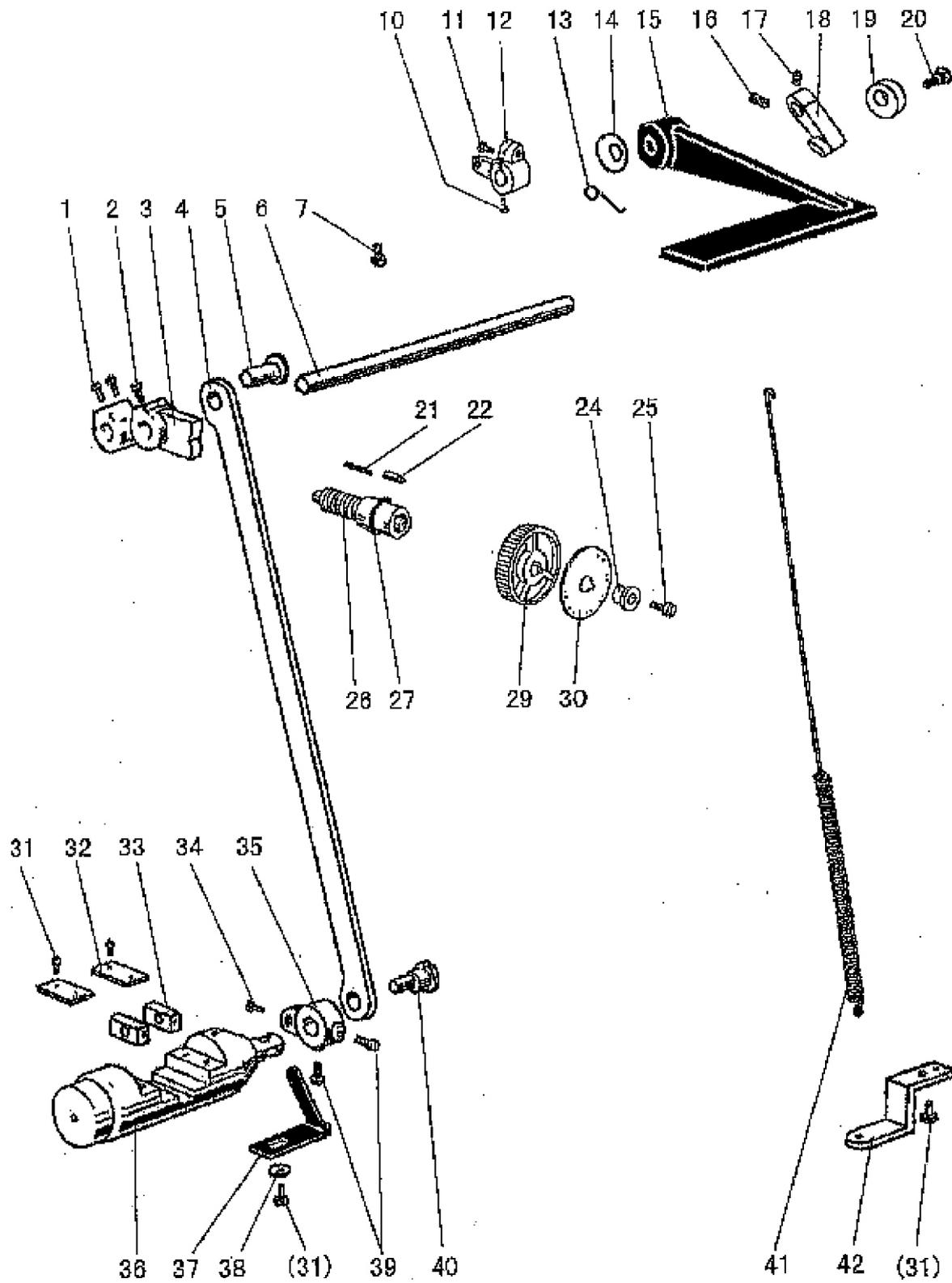
# D. Thread Take-up & Needle Bar Rock Motion Mechanism



## D. Thread Take-up & Needle Bar Rock Motion Mechanism

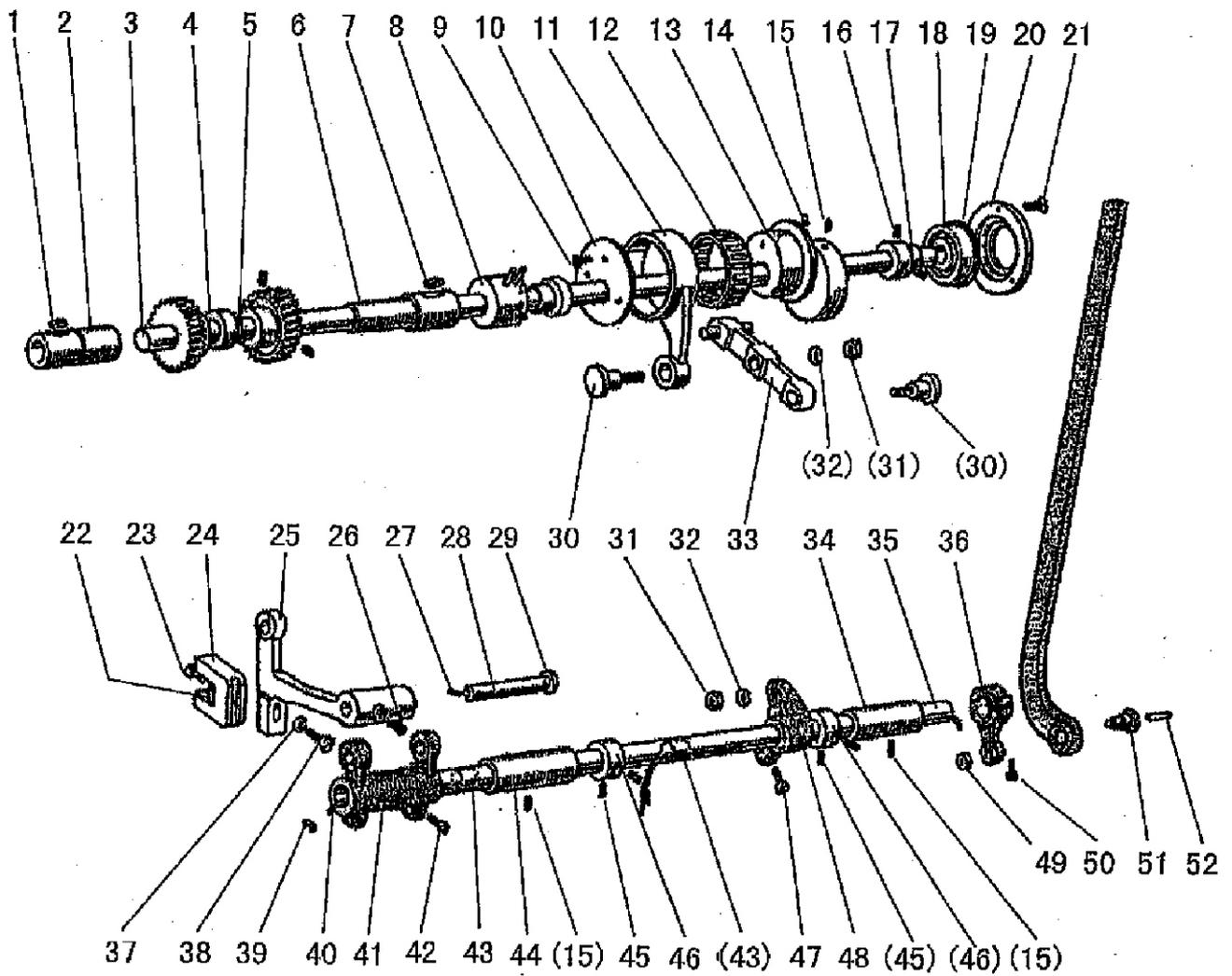
No.	Code No.	Parts Name	Q'ty	
			single	twin
1	JZDP5000G1803	Needle	1	2
2	H3200D2090	Needle Clamp	0	1
3	H32111D404	Needle Bar	1	1
4	H32111D104	Needle Bar Rock Frame	1	1
5	H32111D204	Washer	2	2
6	H32111D304	Screw	4	4
7	H32111D604	Screw	1	1
8	H32111D504	Needle Bar Connecting Stud	1	1
9	H3204D0655	Holder	1	1
10	H005008030	Spring Flange	4	4
11	H3204D6511	Screw	2	2
12	H3204D0654	Felt	1	1
13	H3204D6512	Washer	1	1
14	H32111D704	Lever For Pulley	1	1
15	H2405D1112	Thread Take-Up Slide Block	1	1
16	H2405D1122	Oil Wick	1	1
17	H32422C108	Shaft	1	1
18	HA110D0672	Screw	3	3
19	H2405D1111	Thread Take-Up Lever	1	0
	H3504B0651	Thread Take-Up Lever	0	1
20	H24211D405	Oil Wick	1	1
21	H24211D305	Plug	1	1
22	H2405D0663	Oil Wick	1	1
23	H2405D0662	Pin	1	1
24	H32111D804	Slide Block	1	1
25	H3204D6513	Felt	1	1
26	HA307C0662	Screw	1	1
27	H3205D0066	Collar	1	1
28	H2405D0664	Screw	2	2
29	H3204B0652	Bushing	2	2
30	H3204D0652	Needle Bar Rock Shaft	1	1
31	H2012N0652	Screw	1	1
32	H6306D8001	Crank	1	1
33	H3204D0657	Holder	1	1
34	H3204D0656	Felt	1	1
35	H3204D6510	Screw	2	2
36	H32311D506	Nut	1	1
37	HA7311CC06	Screw	1	1
38	H32311D606	Holder	1	1
39	H6304D8001	Link	1	1
40	H32311D306	Screw	1	1
41	H32311D406	Oil Wick	1	1
42	H6204D8001	Needle Clamp	1	0
43	HA100C2170	Screw	1	0
44	HA500C2030	Thread Guide	1	1

# E. Feed Regulator Mechanism





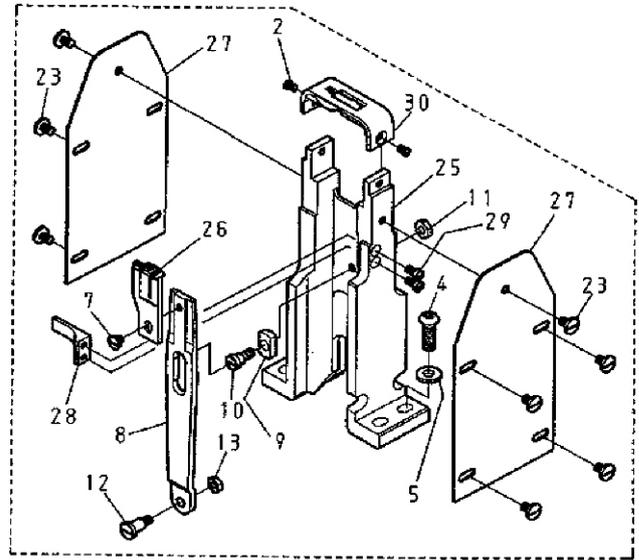
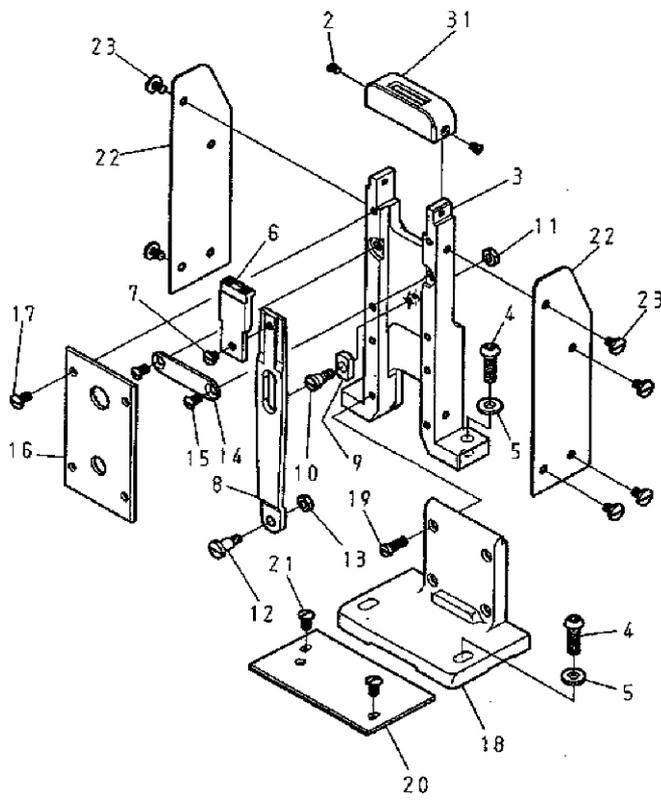
# F. Lower Shaft Mechanism



## F. Lower Shaft Mechanism

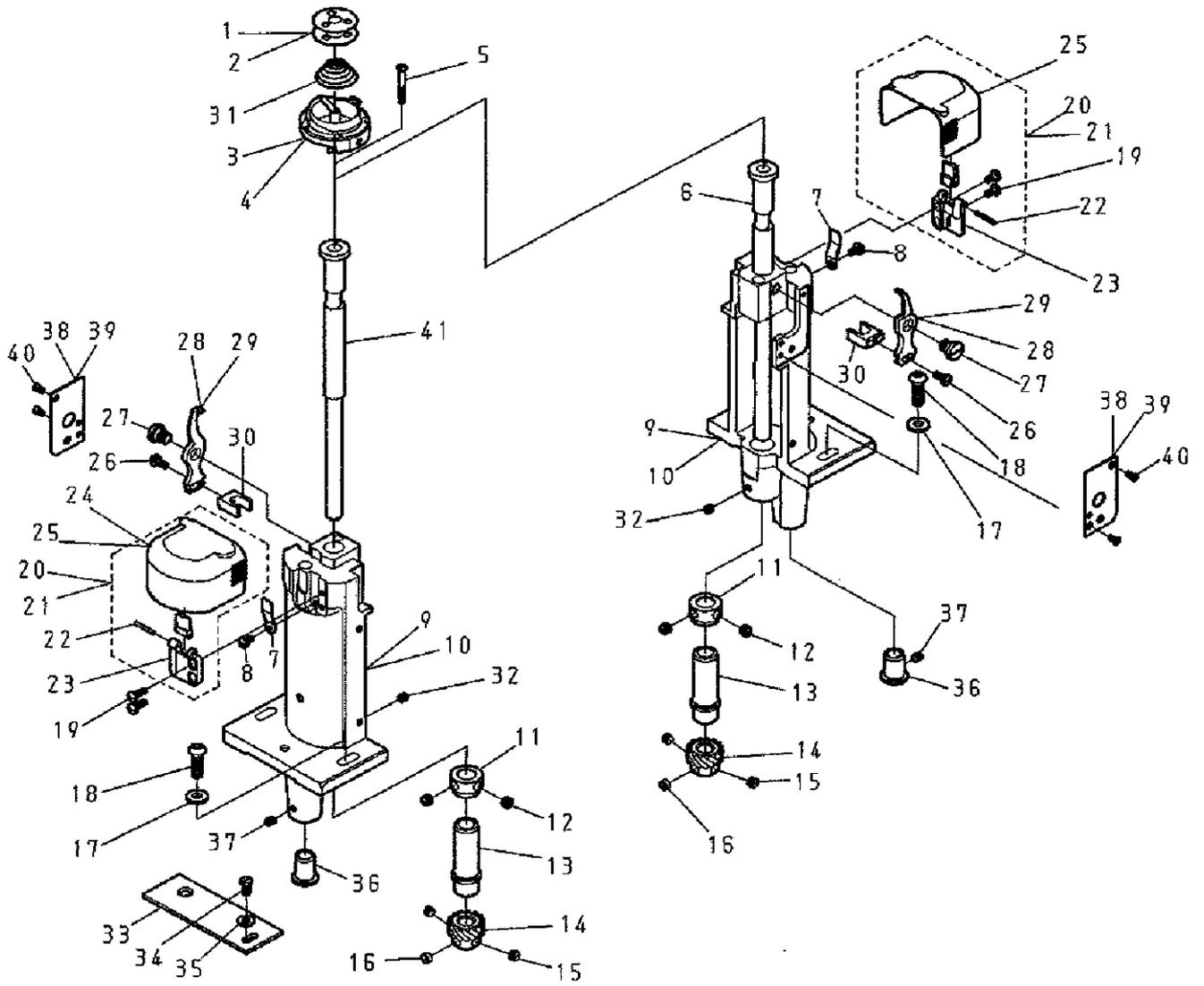
No.	Code No.	Parts Name	Q'ty	
			single	twin
1	H32132B204	Oil Wick	1	1
2	H6315B8001	Lower Shaft Bushing (Left)	1	1
3	HH30H48001	Lower Shaft	1	1
4	H3205H0655	Feed Lifting Cam	1	1
5	H3205H0654	Screw	1	1
6	H6317B8001	Lower Shaft Bushing (Right)	1	1
7	H32132B204	Oil Wick	1	1
8	HH30B97101	Lower Shaft Bushing Complete	1	1
9	HA700F2100	Screw	3	3
10	H32372G208	Washer	1	1
11	H32372G408	Feed Connecting Rod	1	1
12	H32372G308	Needle Bearing	1	1
13	H32372G108	Feed Eccentric	1	1
14	HA100C2020	Screw	1	1
15	H2405D0664	Screw	3	3
16	HA105D0662	Screw	2	2
17	H3208H0662	Bushing	1	1
18	H3208H0661	Needle Bearing	1	1
19	HA112D3012	Washer	1	1
20	H3200H2060	Bearing Holder	1	1
21	HA7311C306	Screw	3	3
22	H3205H0652	Felt	1	1
23	H3205H0653	Screw	1	1
24	H3205H0651	Feed Bar Connecting Fork	1	1
25	H6305G8001	Feed Bar	1	1
26	H42905005	Screw	1	1
27	H3205G0662	Oil Wick	1	1
28	H32243G205	Feed Bar Shaft	1	1
29	H007009070	Retaining Ring C-Type	1	1
30	H3208G0674	Screw	2	2
31	H3208G0675	Nut	2	2
32	H005008060	Spring Flange	2	2
33	H3208G2011	Link (Complete)	1	1
34	H3204B0656	Feed Rock Shaft Bushing	1	1
35	H3204G0651	Feed Rock Shaft	1	1
36	H6305D8001	Feed Rock Shaft Crank (Right)	1	1
37	H006001060	Washer	1	1
38	H3200H2040	Bolt	1	1
39	H3200G2030	Holder	1	1
40	H3204G0031	Oil Wick	1	1
41	H3205G1032	Feed Connecting Crank (Left)	1	1
42	HA104G0012	Screw	2	2
43	H3204G0652	Felt	2	2
44	HA100G2120	Bushing	1	1
45	HA105D0662	Screw	4	4
46	HA106G0661	Collar	2	2
47	H3208G0676	Screw	1	1
48	H3208G0673	Connecting Rod Crank (Middle)	1	1
49	H3206D0674	Nut	1	1
50	H2012N0652	Screw	1	1
51	H32311D306	Screw	1	1
52	H32311D406	Oil Wick	1	1

# G. (1) Hook Saddle Mechanism



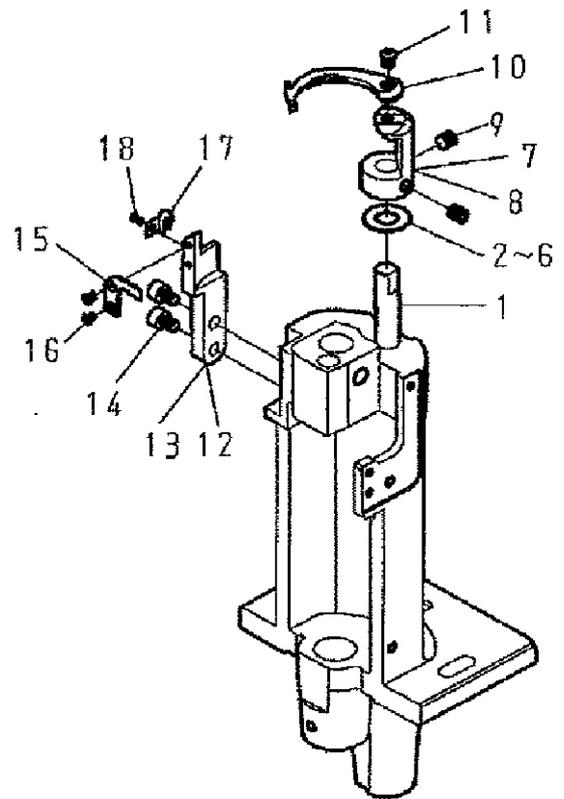
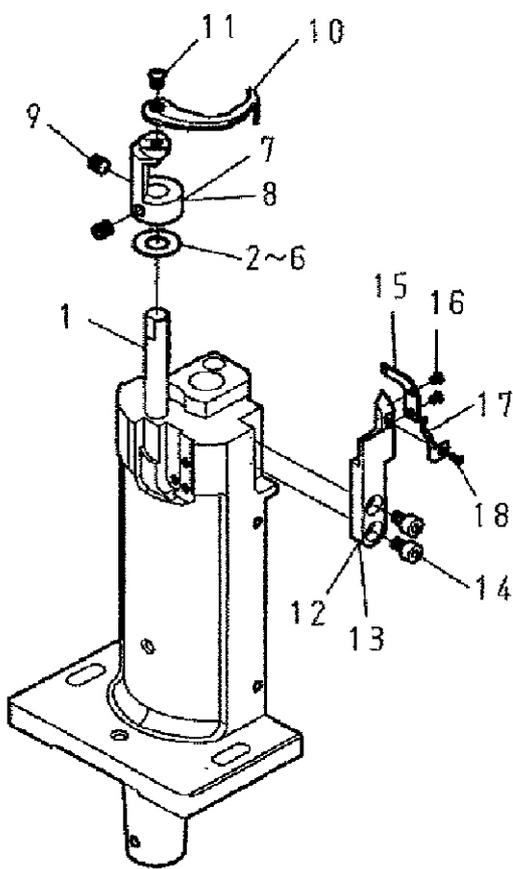


## G. (2) Hook Saddle Mechanism



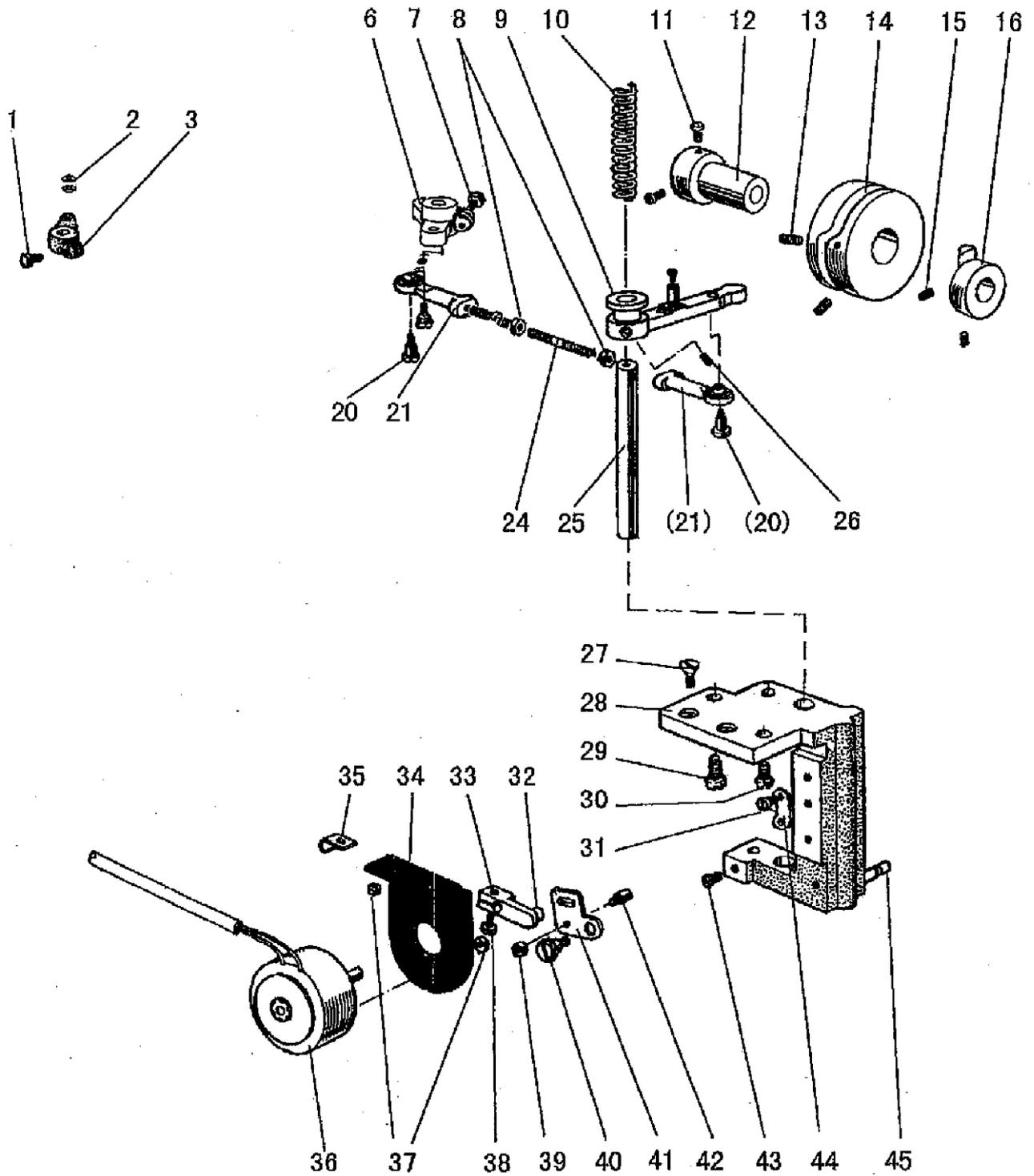


## H. (1) Thread Trimmer Mechanism





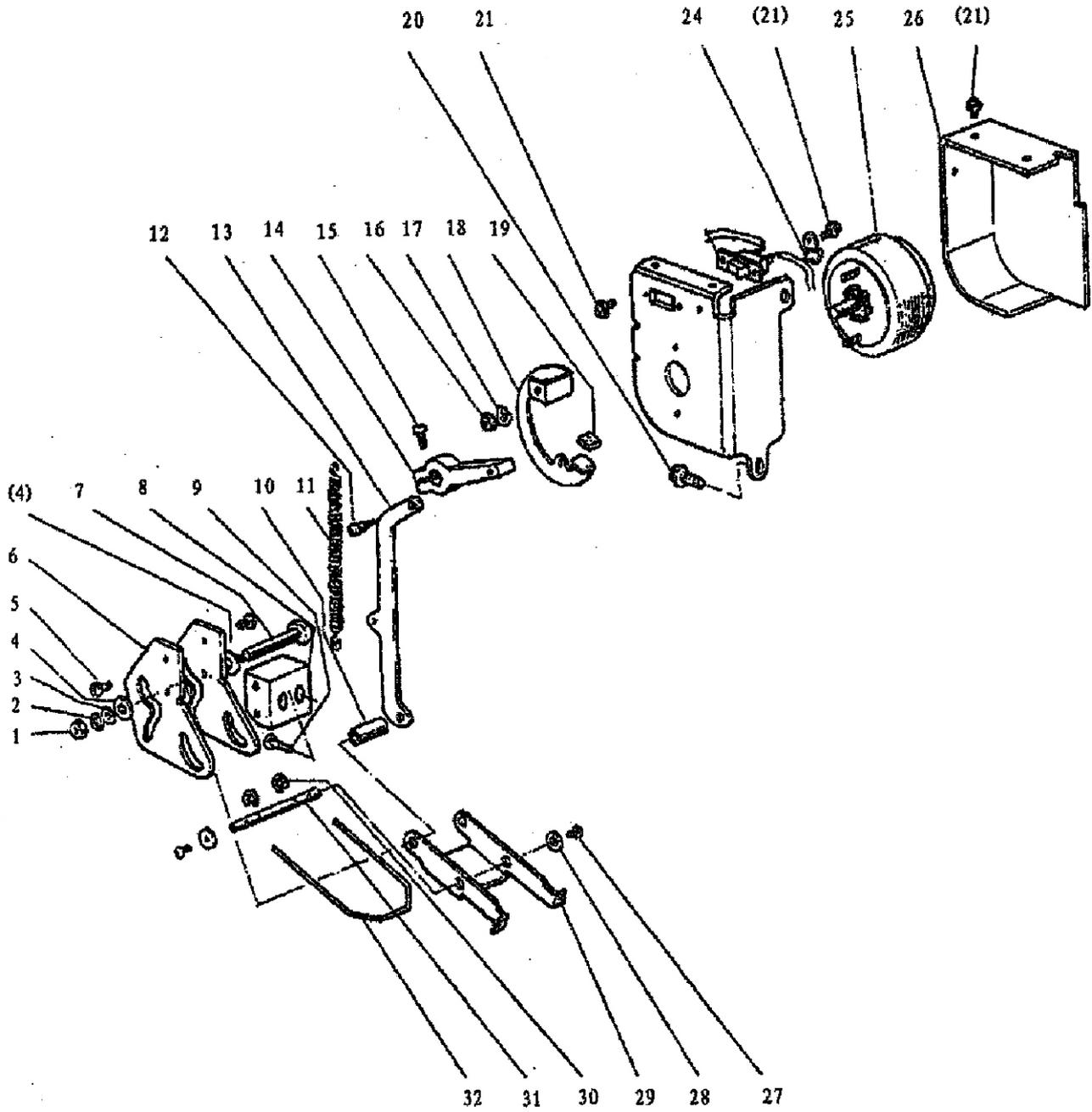
## H. (2) Thread Trimmer Mechanism



## H. (2) Thread Trimmer Mechanism

No.	Code No.	Parts Name	Q'ty	
			single	twin
1	H4907K8001	Screw		1
2	H7314G8001	Washer		2
3	HH31M58001	Arm		1
6	HH10M58001	Arm		
6	HH30M58001	Arm	1	1
7	H4913K8001	Screw	1	1
8	H003002050	Nut	2	2
9	HH30M87101	Vibrating crank complete	1	1
10	H4945K8001	Spring	1	1
11	HA113F0684	Screw	2	2
12	H6904J8001	Bushing	1	1
13	HA710E0692	Screw	2	2
14	HH31M68001	Cam	1	1
15	H431050050	Screw	2	2
16	H4934K8001	Cam	1	1
20	H4936K8001	Bolt	2	2
21	H3405D0663	Screw	2	3
24	H3405D0661	Screw bar	1	2
24	HH10M68001	Screw bar		
25	H4963K8001	Shaft	1	1
26	H431050050	Screw	2	2
27	H411050160	Screw	2	2
28	H4965K8001	Set plate	1	1
29	H2012N0652	Screw	1	1
30	H4983K8001	Screw	1	1
31	H4967K8001	Screw	2	2
32	H4973K8001	pin	1	1
33	H4974K8001	Arm	1	1
34	H4977K8001	Mounting plate	1	1
35	H4987K8001	Holder	1	1
36	H4979K8002	Solenoid complete	1	1
37	H003008050	Nut	2	2
38	HA111G0683	Screw	1	1
39	HA7111N304	Nut	1	1
40	H4972K8001	Screw	1	1
41	H4971K8001	Lever	1	1
42	H4970K8001	Spring	1	1
43	H4969K8001	Screw	1	1
44	H4966K8001	Stopper	1	1
45	HA100H2080	Pin type	1	1

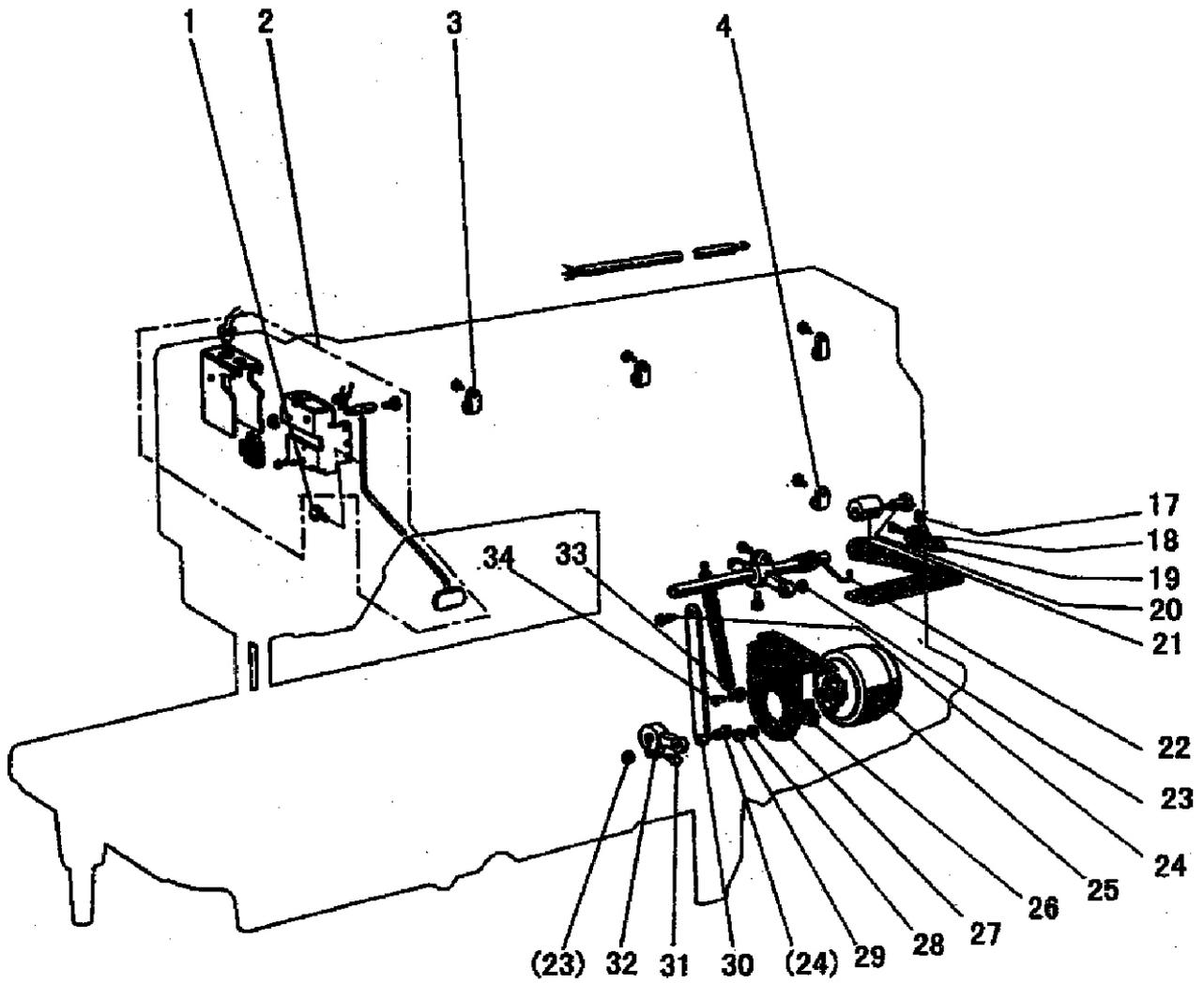
# I. Wiper Mechanism





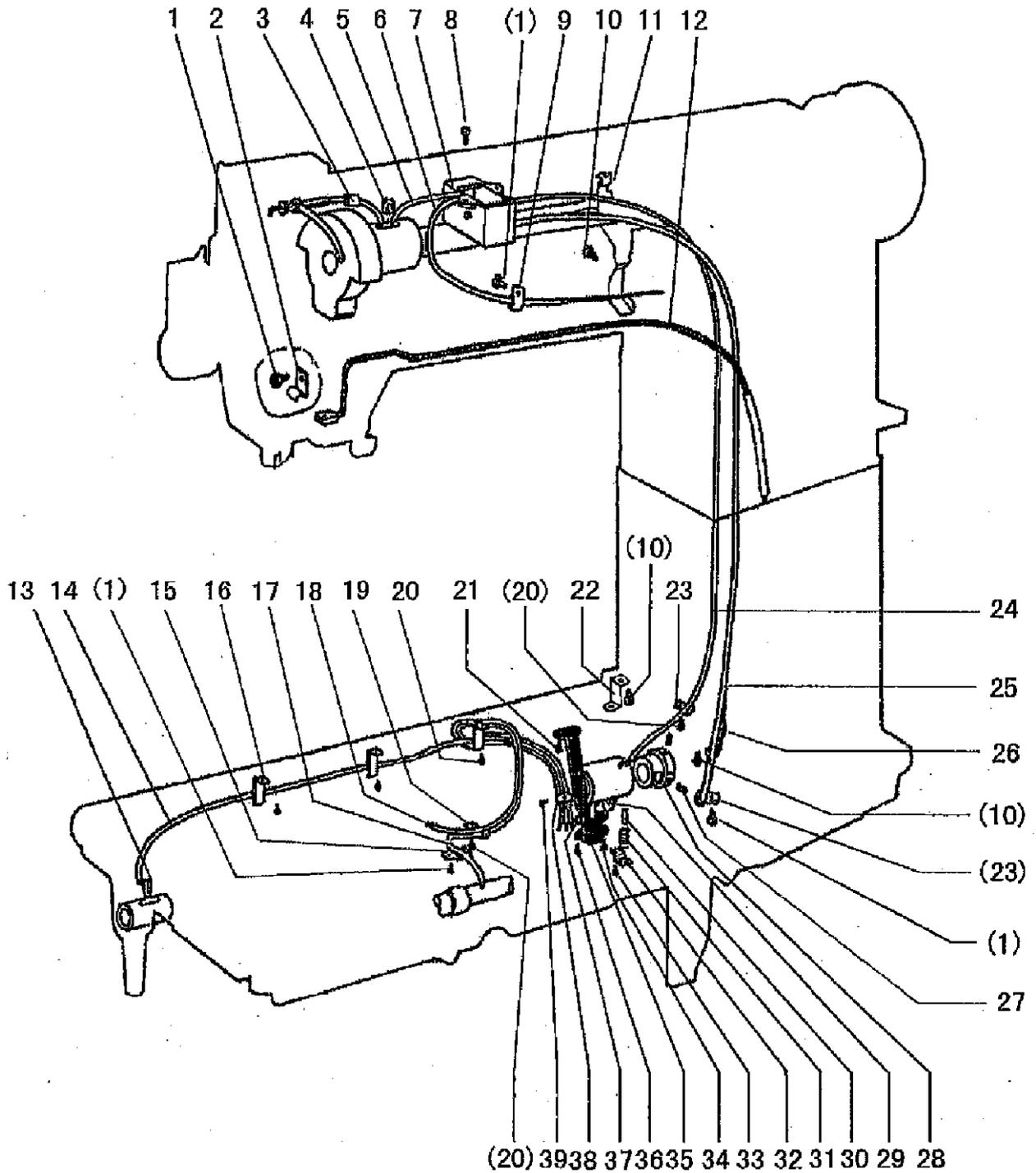
# J. Reverse Mechanism

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# K. Oil Lubrication Mechanism







## L. (1) Accessories

No.	Code No.	Parts Name	Q'ty	
			single	twin
2	816	Wood Screw	2	2
3	835	Spanner	1	1
5	126003	Cable Tie	2	2
6	813	Driver(S)	1	1
7	814	Driver(M)	1	1
8	268003	Head Rest	1	1
9	154019	Knee Lifter Rod	1	1
10	805	Magnet	1	1
11	880	Head Hinge	2	2
12	809	Hinge Rubber	2	2
13	152046	Bobbin	4	4
17	867	Hexagonal Wrench 5mm	1	1
18	830	Hexagonal Wrench 4mm	1	1
19	824	Hexagonal Wrench 3mm	1	1
20	828	Hexagonal Wrench 2.5mm	1	1
21	823	Hexagonal Wrench 2mm	1	1
22	156010	Needle DP×5#21	5	5
23	804	Accessories Bag	1	1
25	852	Bobbin Winder ASSY	1	1
26	801	Oil Tank	1	1
28	853	Thread Stand ASSY	1	1
29	803	Head Cover	1	1
30	827	Oil Tank(S)	1	1
34	133051	Panel Cover	1	1
35	136001	Spring Washer	2	2
36	1005	Screw M3-8	2	2
37	153069	Operation Panel Bracket	1	1
38	807	Cushion Rubber(S)	2	2
39	808	Cushion Rubber(L)	2	2
42	116001	Spring Washer	1	1
43	182123	Nut M6	1	1
44	153080	Wiper(L)	1	1
45	153079	Wiper(R)	1	1
46	2078	Screw 1/4(24)-13	2	2
55	815	Driver	1	1
56	223027	Washer	2	2
57		Operation Panel	1	1

## L. (2) Accessories

