



**GC24518-1RDZ** single needle

**GC24518-2DZ** double needles

**HLS INDUSTRIAL SEWING MACHINE  
POST BED NEEDLE FEEDING WITH AUTOMATIC TRIMMER**

# Products Manual

## 产品说明书

(Computerized single-needle  
(double-needle) thread cutting /  
automatic oil supply)

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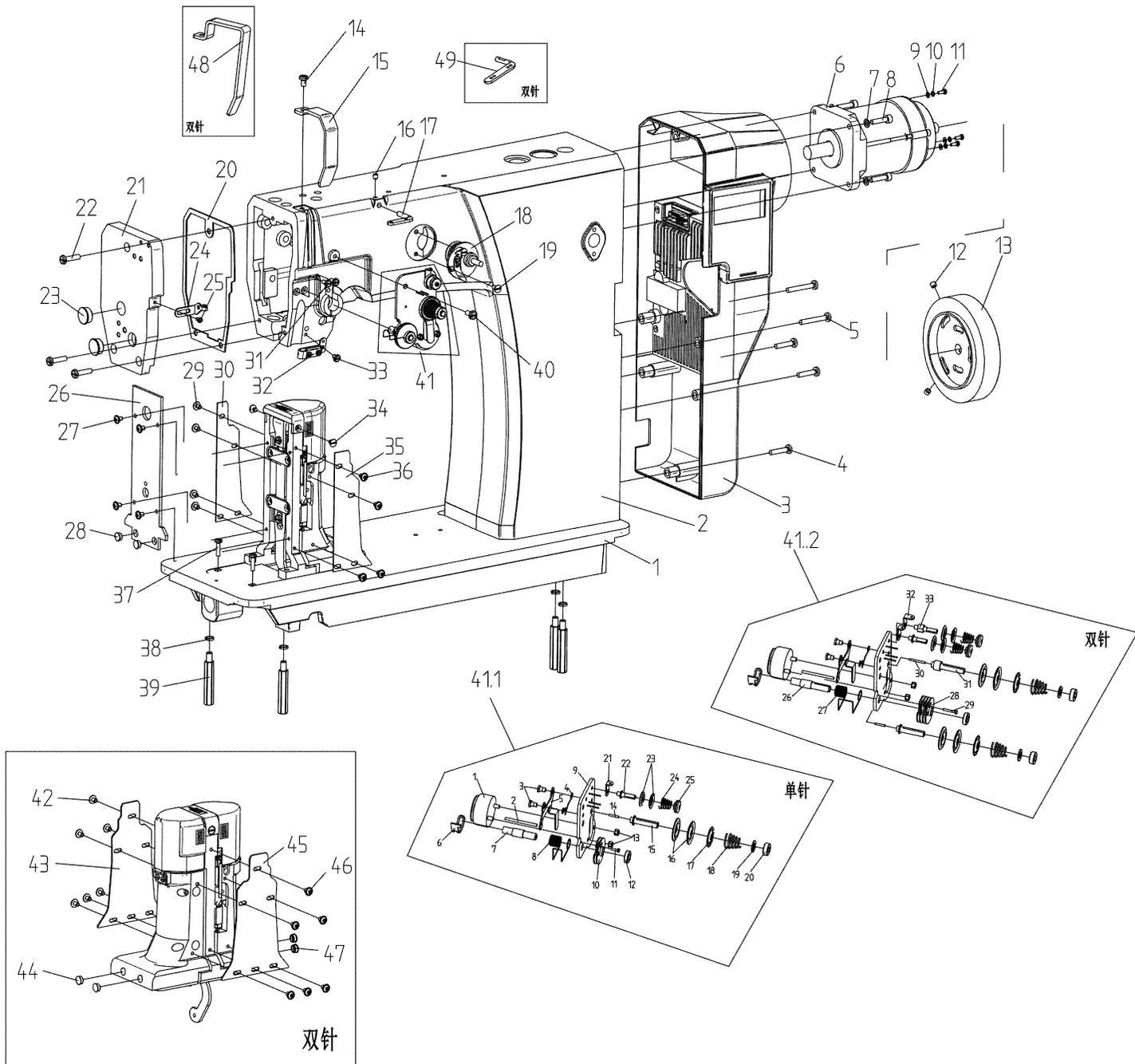
## 主要技术参数表

### Main Technical Specification

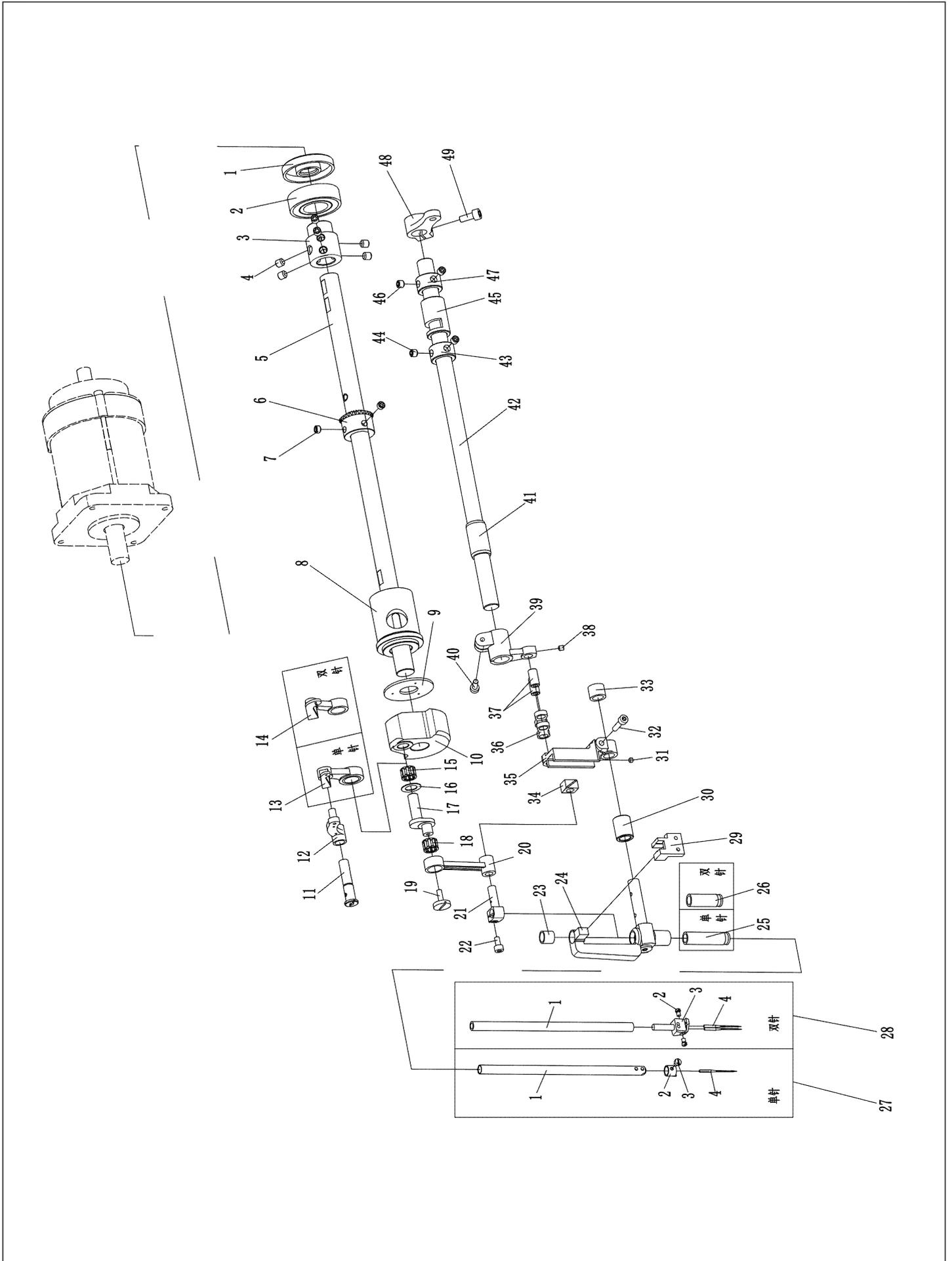
型号 Model	GC24518-1RDZ	GC24518-2DZ
适用范围 Application	中厚料厚料 Medium Heavy Materials	
最高缝速 Max Speed	3000针/分 3000steps/min	
针距 Stitch Length	0-5毫米 0-5mm	
压脚提升高度 Lift of Presser Foot	手动5毫米膝控10毫米 5mm by hand/16mm by knee	
采用机针 Needle	DP×5 11-21#	
电机功率 Power Of Motor	0.75千瓦 0.75KM	
针间距 Needle Gauge Set		标配：1/4英寸 Standard:1/4IN

# 零件配件

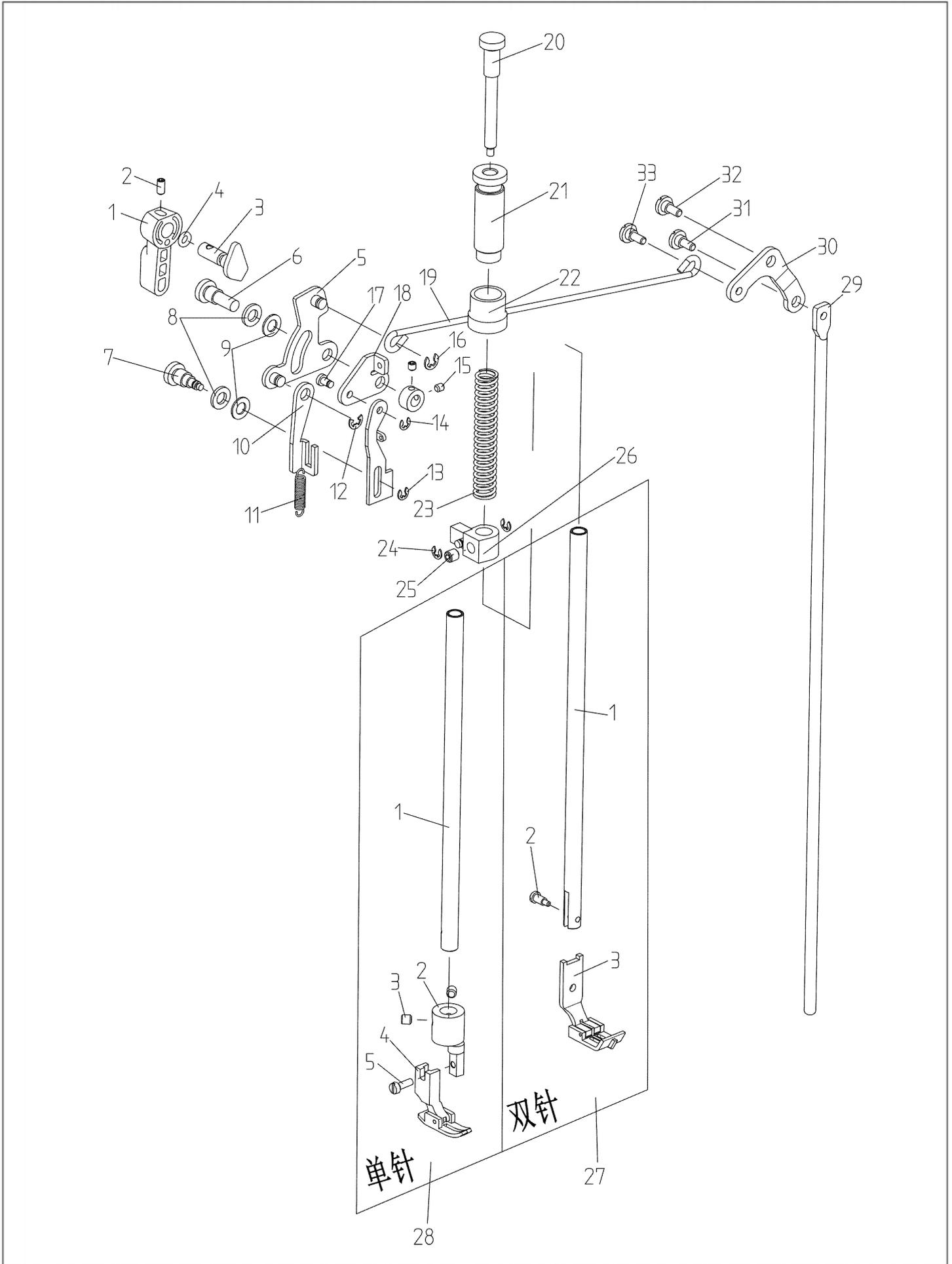
# 一、机头部分



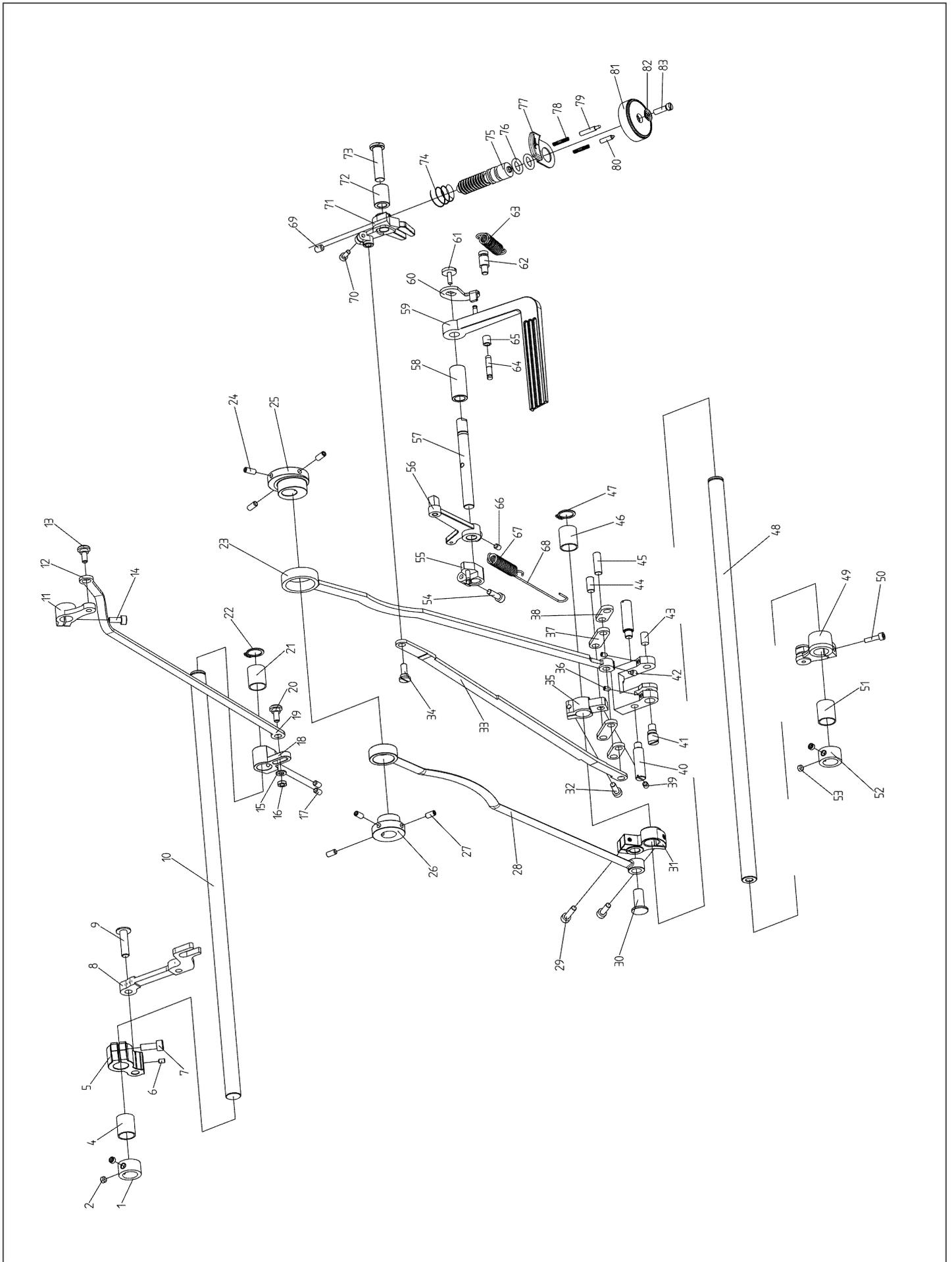
## 二、针杆挑线部件



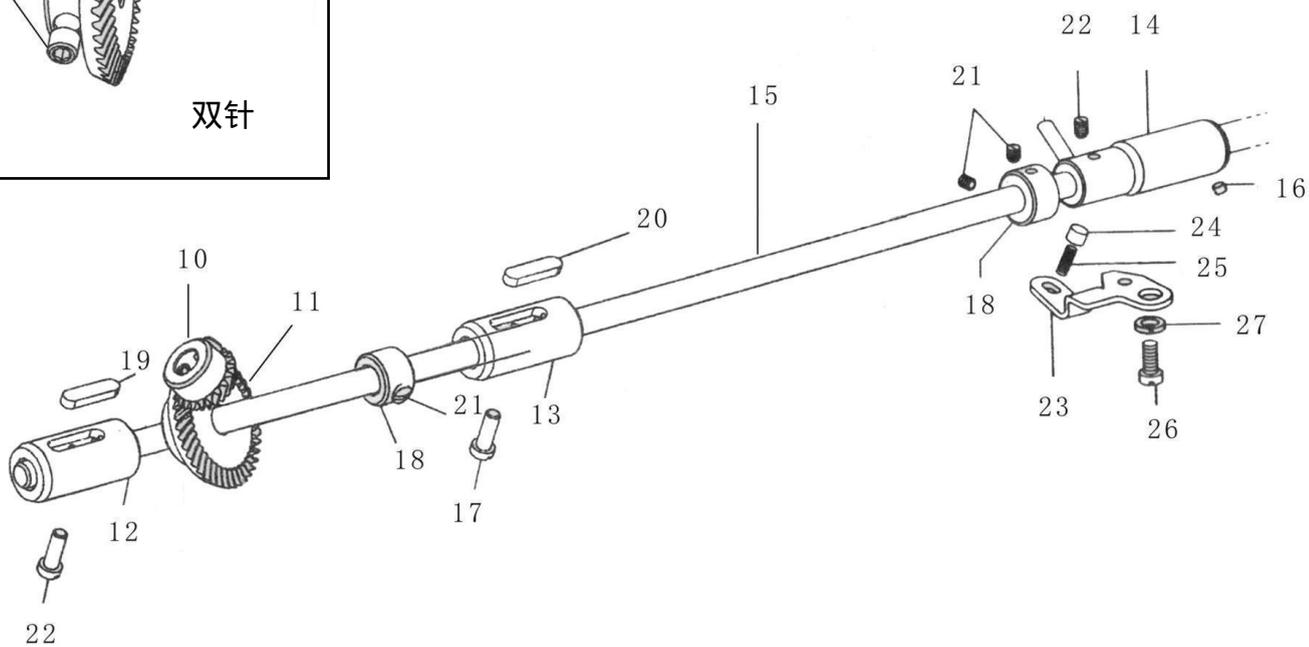
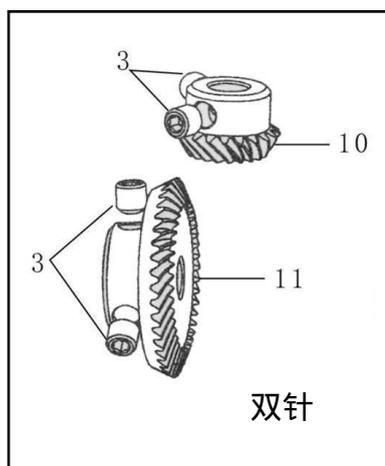
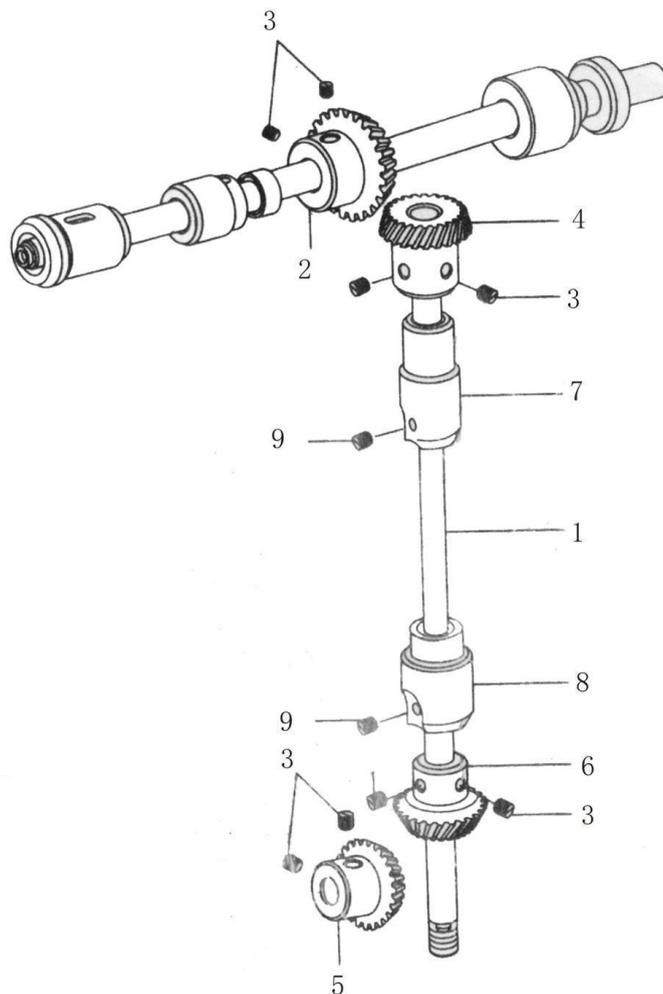
### 三、压脚部件



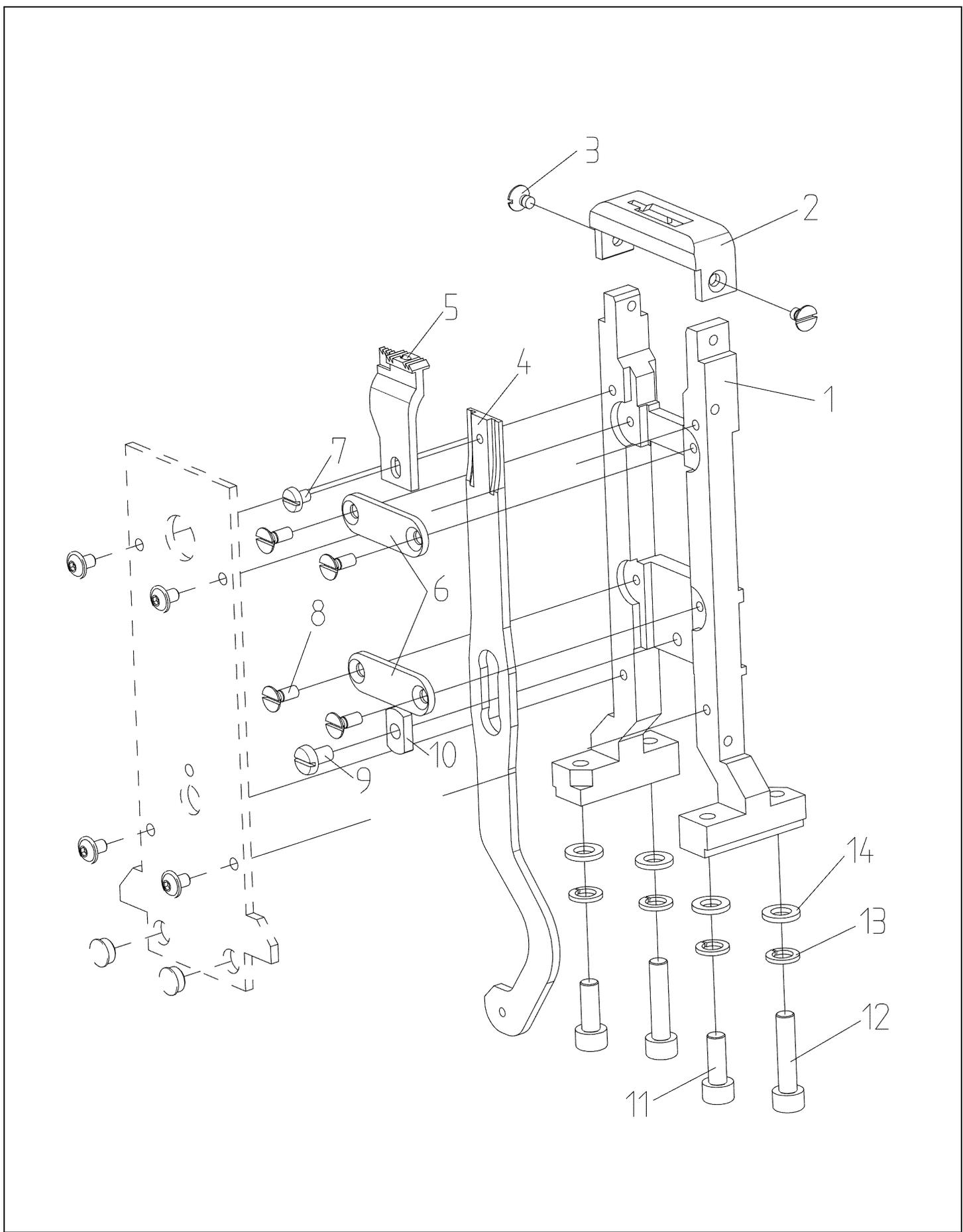
# 四、送料部件



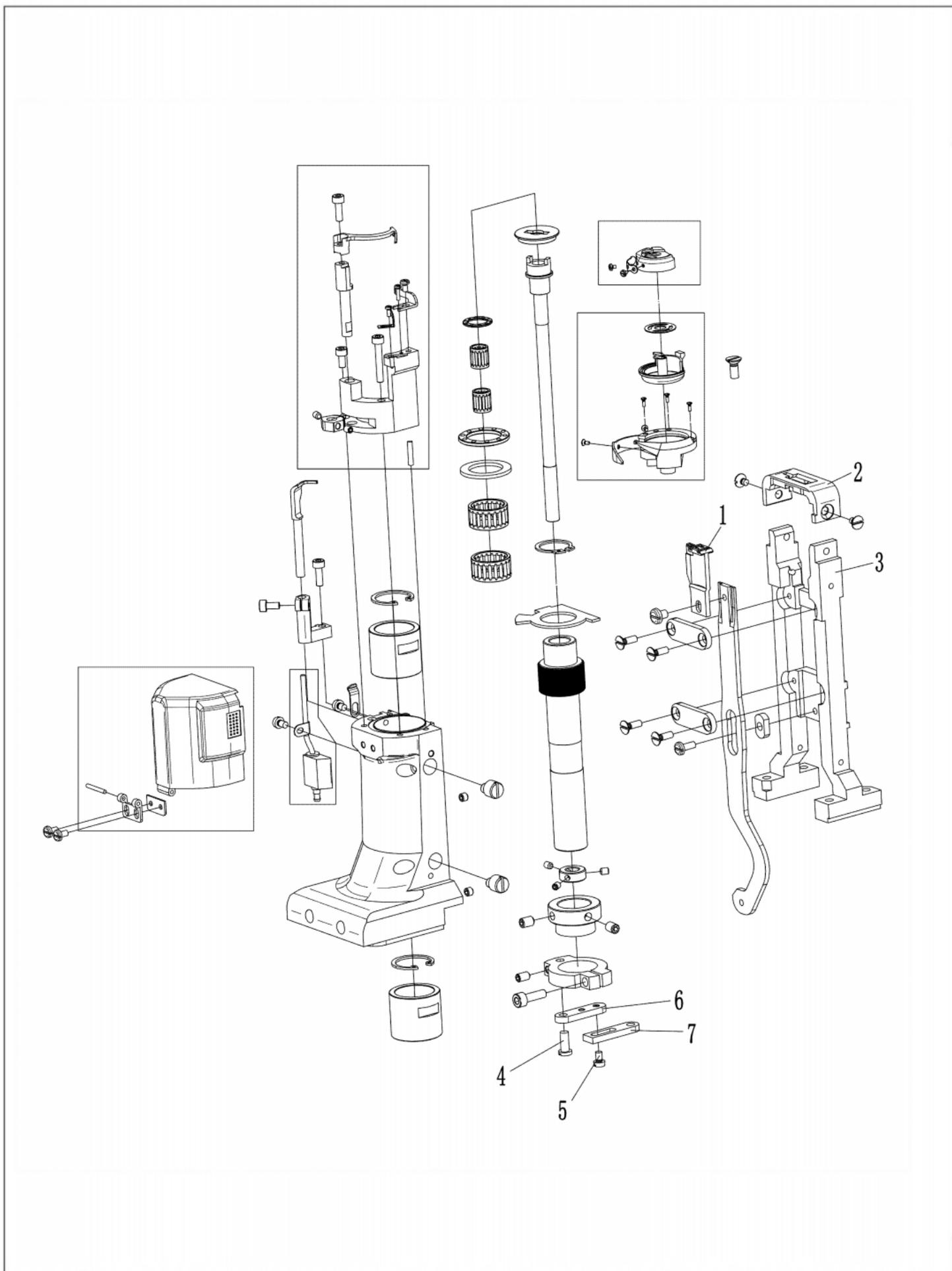
# 五、齿轮传动部件



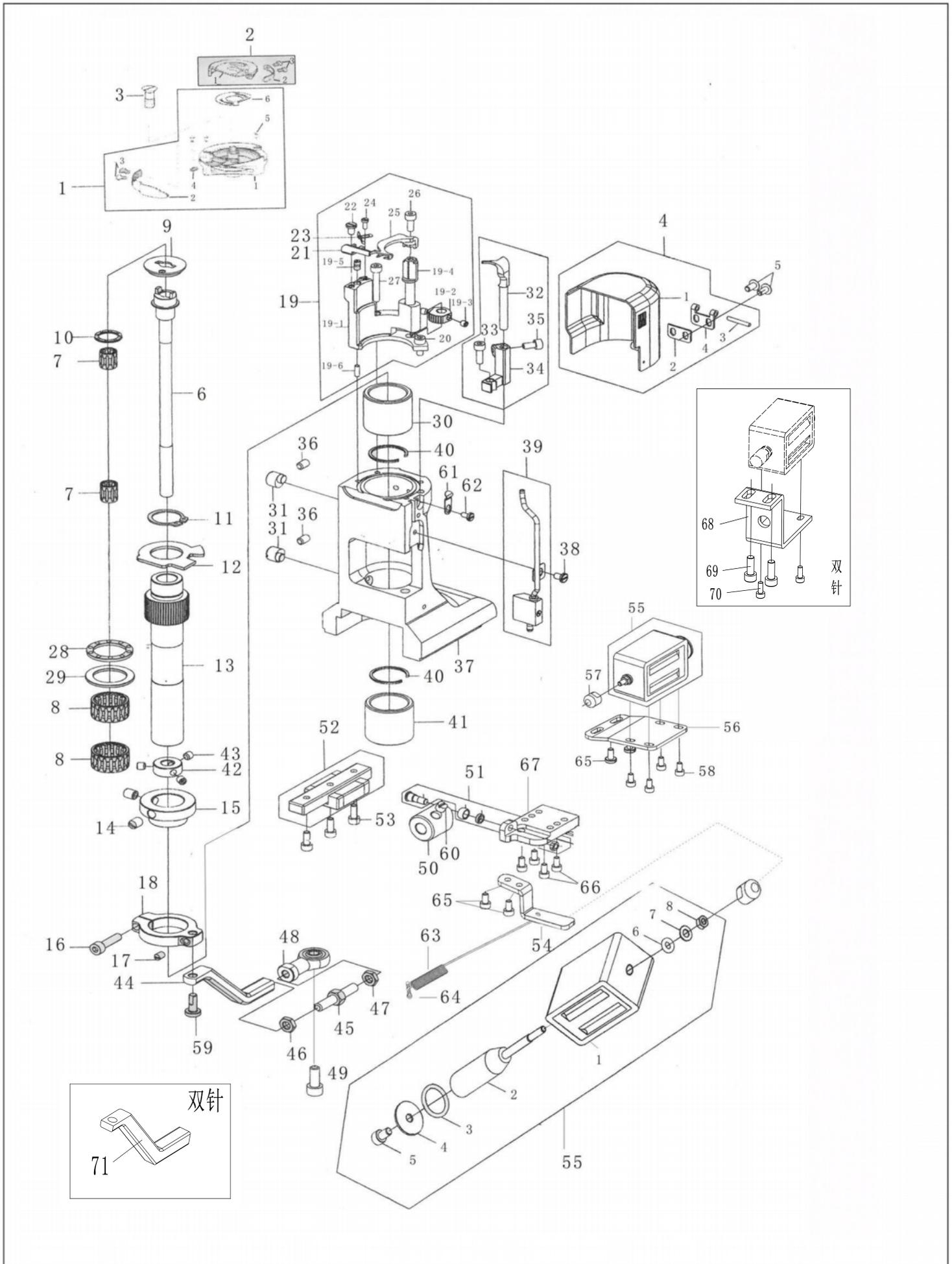
# 六、中座机构部件



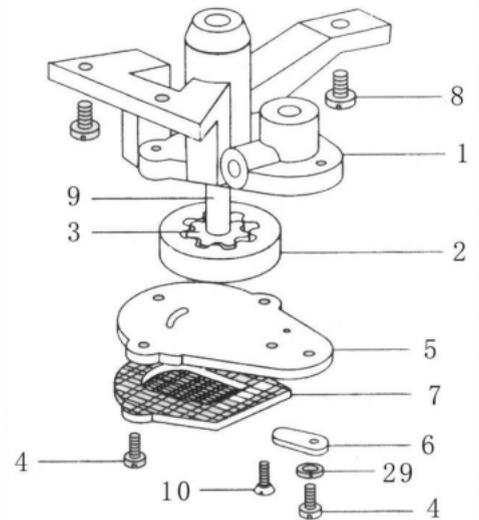
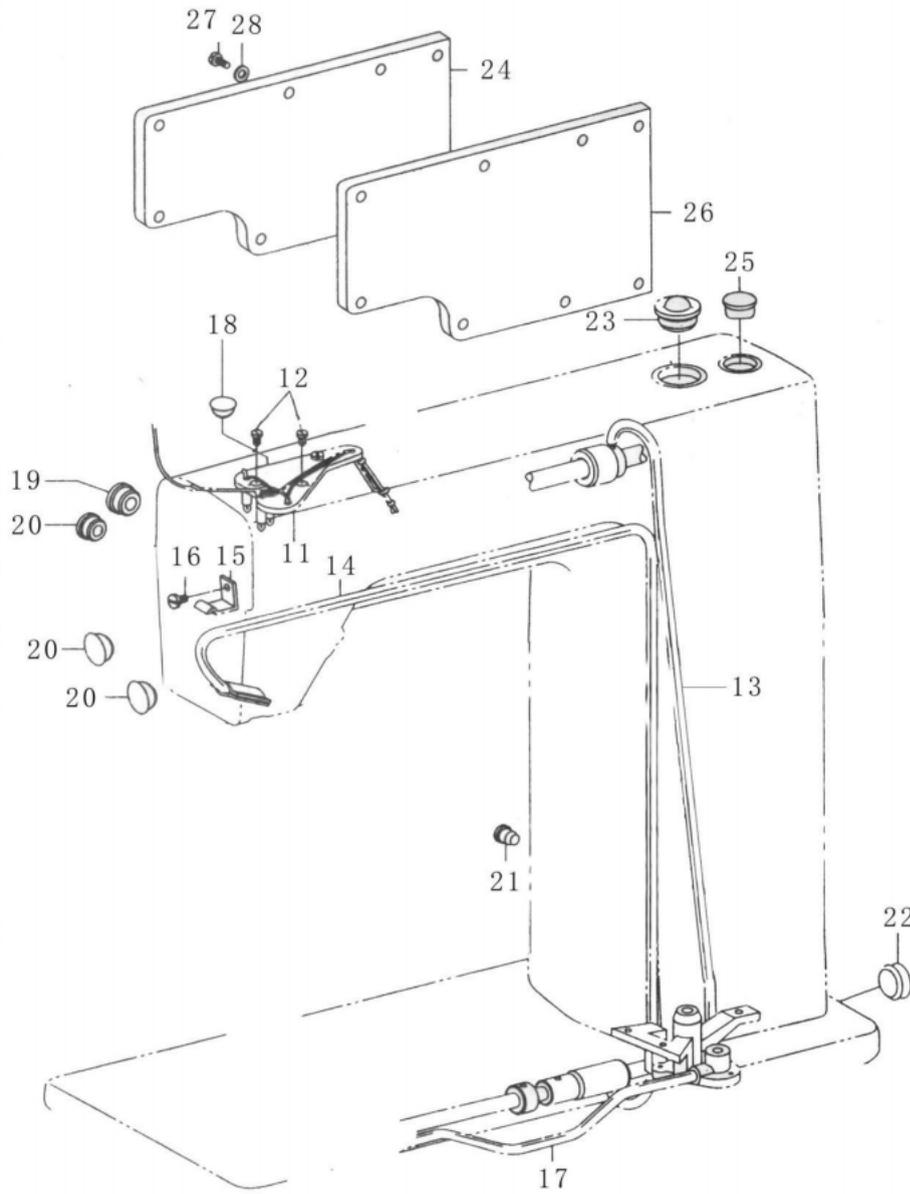
## 七、左边旋梭及中座部件(双针)



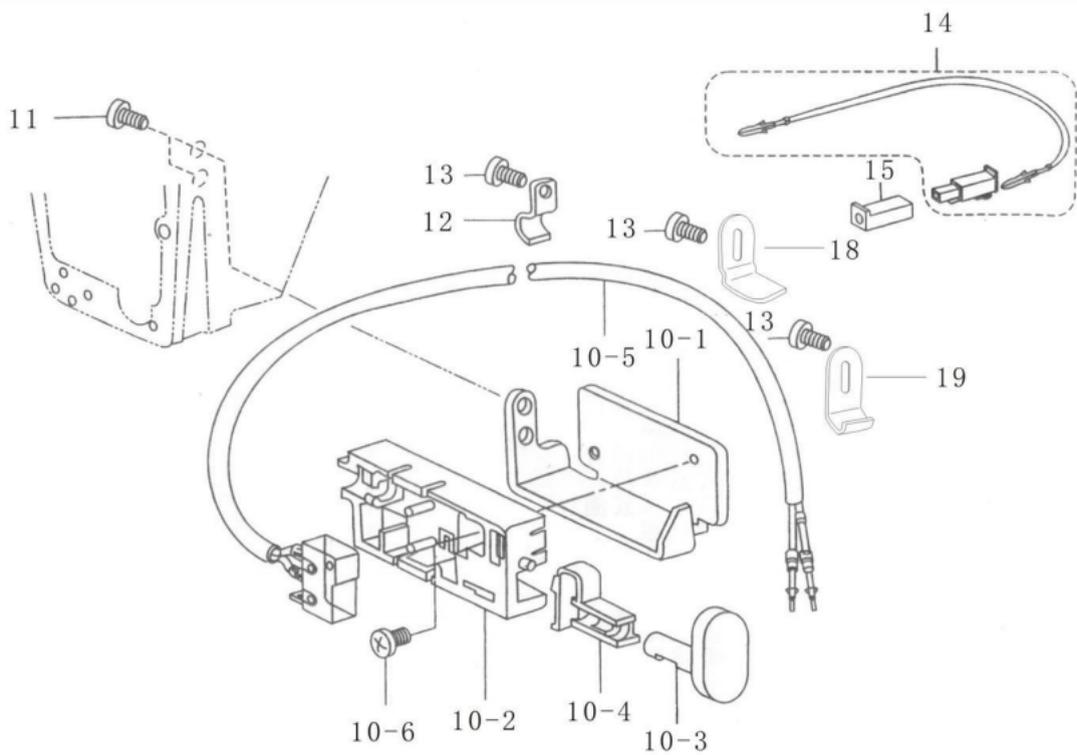
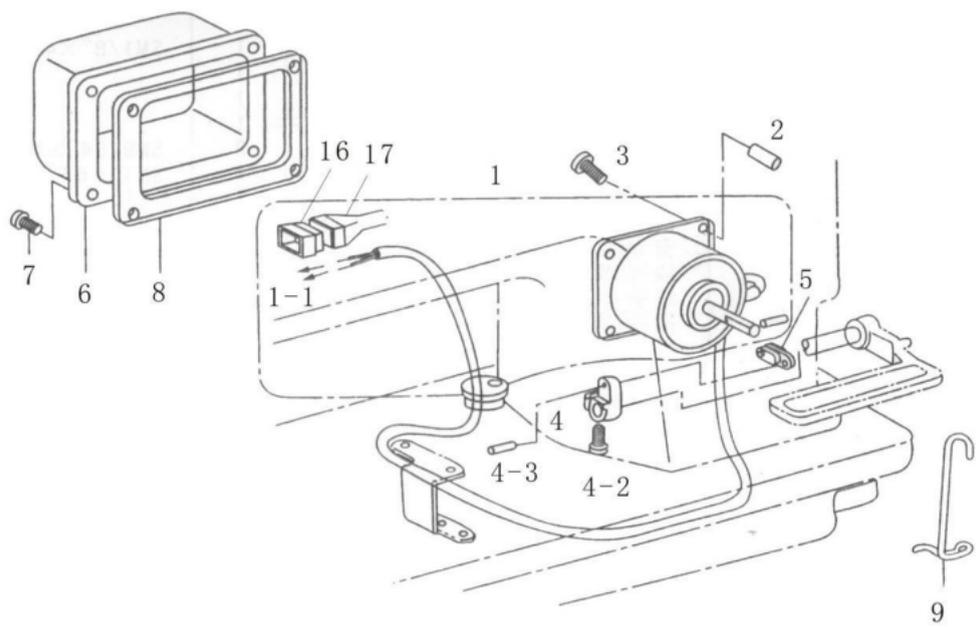
# 八、旋梭及剪线机构



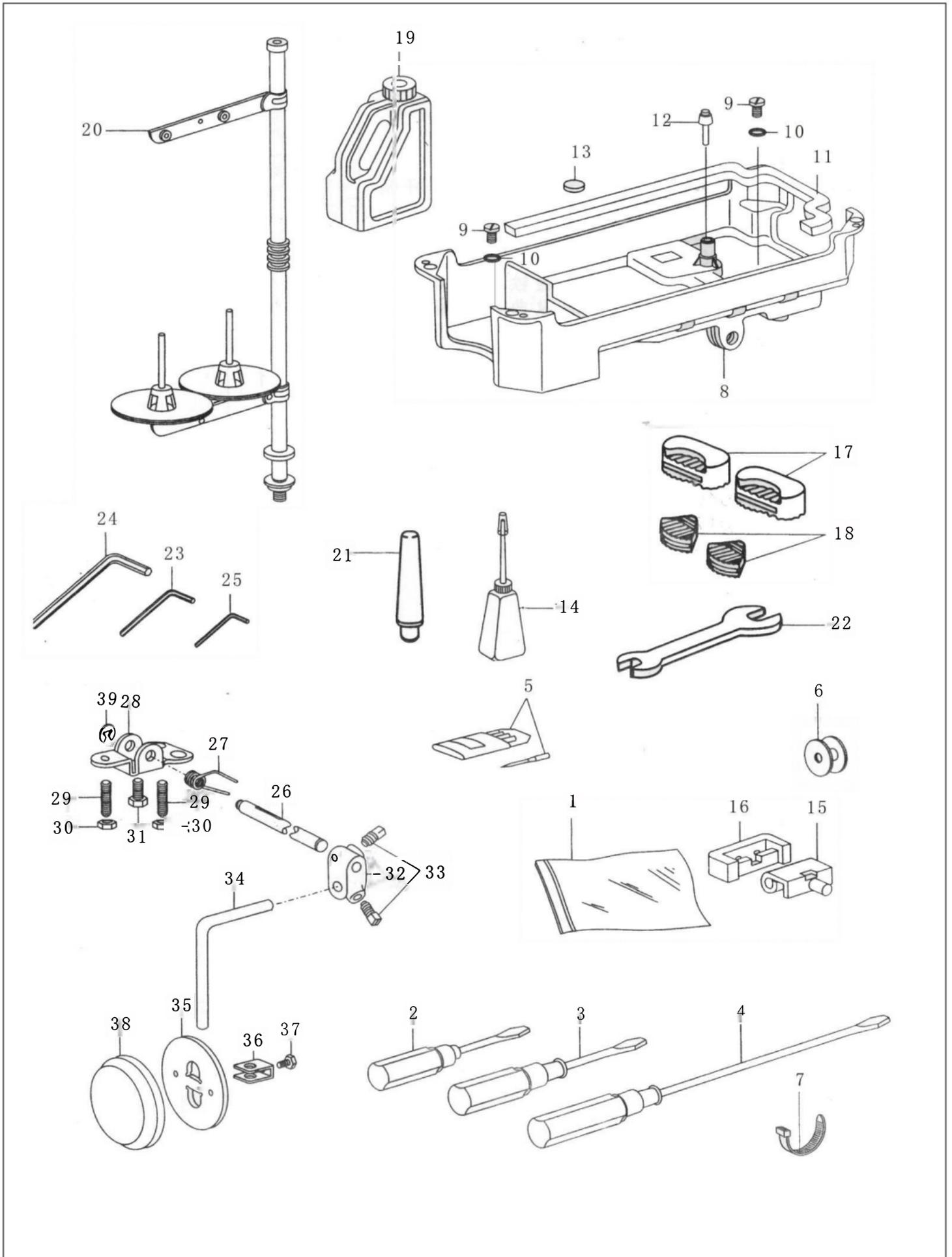
# 九、供油润滑部件



# 十、倒缝部件



# 十一、附件



# 故障分析及处理方法

<p>常见故障 Trouble</p>	<p>产生原因 Cause</p>	<p>处理方法 Remedy</p>
<p><b>跳针</b> Trouble</p>	<p>(1)由机针引起的: 机针弯曲 机针与缝线规格不符 (2)由机针安装错误引起的: 插入不足 插入偏针  (1)Reasons caused by needle Needle curving Needle not fit the thickness of Thread. (2)Reasons caused by wrongly installing needle. When inserting needle, the depth of its not enough. When inserting needle, the needle is inclined</p>	<p>换机针 换上与缝线粗细相符的机针 插入至针杆的定位面 重新装机针  Replace needle Replace a needle which fit the thickness of thread. Insert needle to the fixed-position plane of needle bar. Re-installing needle.</p>
<p><b>浮线</b> Trouble</p>	<p>(1)面线张力过轻 (2)挑线簧过松 (3)底线张力过大  (1)Tension of needle thread is too small. (2)Take-up spring is too loosen (3)Tension of bobbin thread is too big.</p>	<p>把夹线调节螺母顺时针方向旋转，调整面线挑线簧张力，缝厚料(针距长)时，应增强张力旋紧松心套梭皮螺钉调节。  Turn round tension adjusting nut clockwise to regulate Needle thread. Adjusting the tension of take-up spring, when sewing thicker material (stitch length is long), the tension of Take-up spring should be increased. Tighten the spring plate screw of hook case.</p>
<p><b>断线</b> Trouble</p>	<p>(1)缝线质量低劣 (2)由机针引起 机针弯曲 安装有误 机针过细(相对缝线来说) (3)面线张力过紧  (1)The quality of thread is poor. (2)Caused by needle Needle curving Needle installing wrong Needle is too small (compared with thread) (3)The tension of needle thread is too big.</p>	<p>换上优质缝线。粗细不匀，有接头的缝线不能使用。  换新机针。 重新装机针 换上与缝线粗细相符的机针。 调松夹线螺母。  Replace thread which is very good. if the thickness of thread is not even or there is some joint in thread, do not use it. Replace a new needle Re-installing needle. Replace a needle which fit the thickness of thread. Loosening threading nut.</p>