



TYPICAL

GC24677-D2T3

GC24676-D2T3

**POST BED COMPOUND FEED
LOCKSTITCH SEWING MACHINE**

OPERATION INSTRUCTION / PARTS MANUAL

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Operation Instruction

1. Brief introduction

This series of post bed sewing machines feature automatic thread trimmer, automatic backtacking, automatic presser foot lifter, walking foot movement changeover, and stitch length quick change. The said machines are equipped with pneumatic presser foot lifter and backtacking, large dial mounted on machine head for easy setting of walking foot movement and sewing speed. Reverse feeding, auto backtacking and alternate stitch can be easily set. Automatic lubrication system, long durability and smooth running. Suitable for sewing such as car seats, upholstery, tents, luggage, sports goods, etc

2. Main specifications

Model	GC24677-D2T3	GC24676-D2T3
Max speed	2400 s. p. m.	
Max stitch Length	9mm	
Presser Height	By hand	≥9mm
	By knee	≥16mm
	Auto lifter	≥16mm
Amount of walking foot movement	1~7mm	
Needle	DP×17 19 [#]	
Needle Gauge		6, 8, 10mm

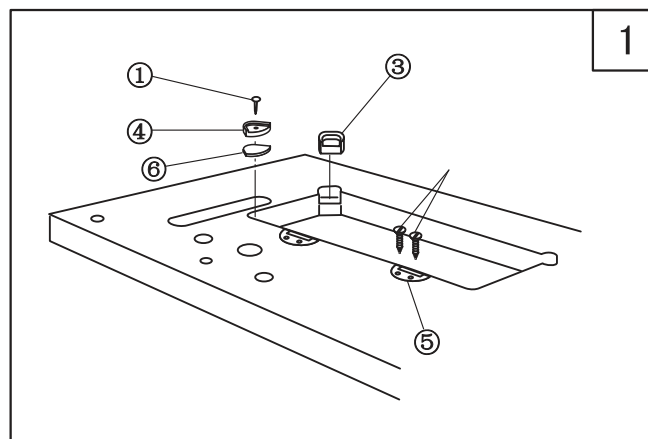
Sewing speed range

Amount of walking foot movement	Stitch length	
	≤6mm	6~9mm
1~4mm	2400 s. p. m.	1500 s. p. m.
5~6mm	2000 s. p. m.	

Note: Sewing speeds should be subject to amounts of walking foot movement shown in the left column of the table.

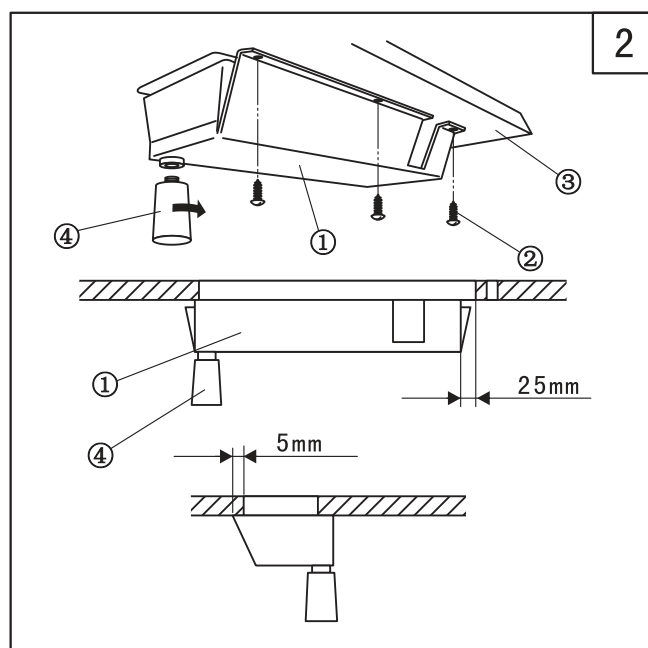
3. Installing hinge and cushion(fig.1)

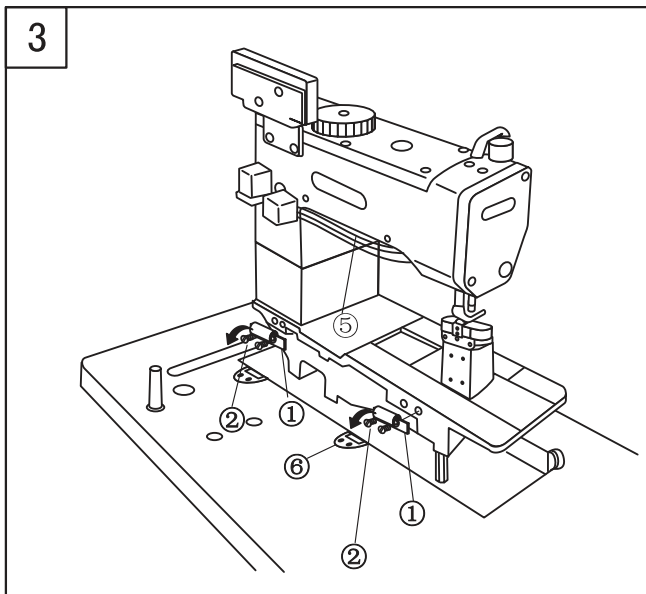
1. Fix the machine head hinge⑤ on the table with screw ②.
2. Fix cushion ③.
3. Fix cushion ④ with space ⑥ and nail ①



4. Installing the oil pan(fig.2)

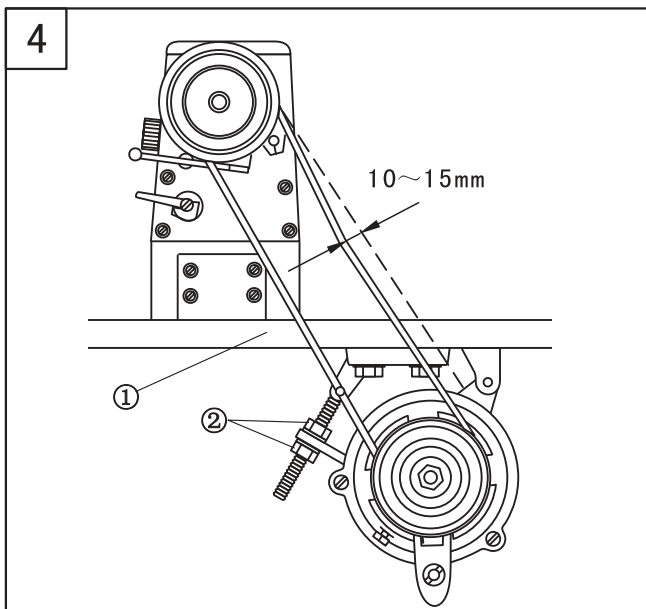
Install the oil pan ① to the underside of the table ③ in the place shown in the illustration using the wooden screws ②. Screw the poly oiler ④ into the oil pan ①.





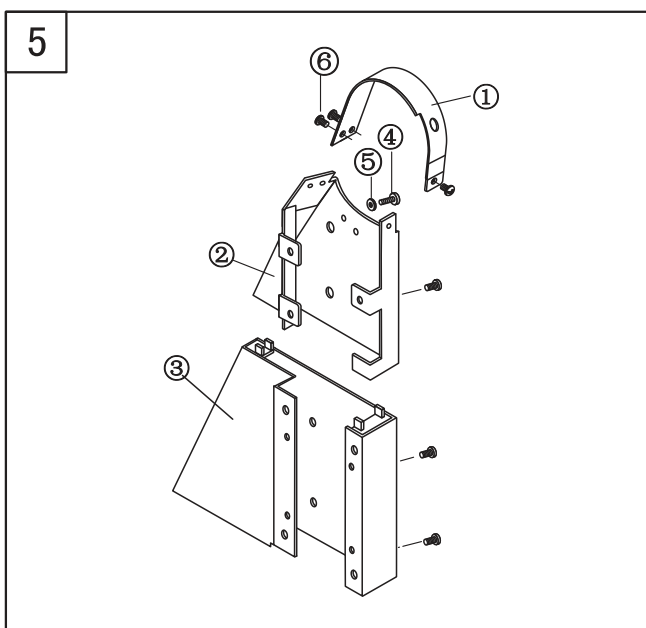
5. Installing the machine head(fig.3)

1. Install the hinge ① on the machine bed with screw ②
2. Put the hinge ① into another hinge ⑥, then put the machine into the cutout of table.



6. Installing the belt(fig.4)

1. Lay down the machine head, install V-belt ① around the handwheel and the motor pulley.
2. Adjust tension of belt ① by nut ②. The appropriate tension incurs the belt a clearance 10~15mm when it's pressed by fingers.



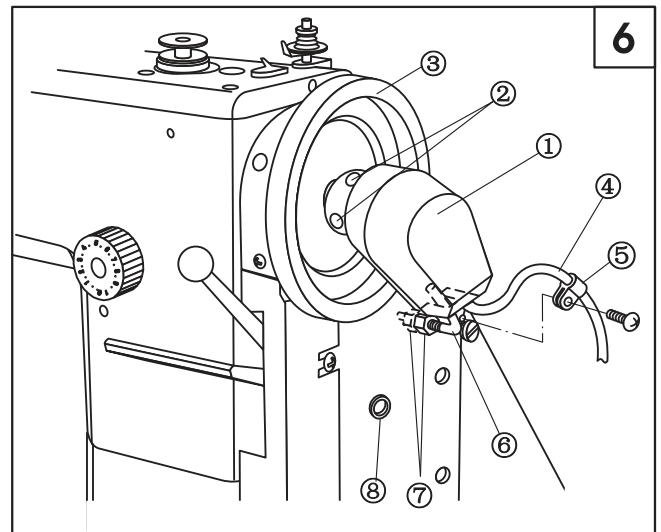
7. Installing belt covers (fig 5).

1. Install the belt guard ② with screw ④ and space ⑤
2. Install the belt guard ① on the belt guard ② with screw ⑥
3. Install the belt guard ③ on the belt guard ②, then fix it on the machine head with screw ④ and washer ⑤
4. Finally adjustment the match among three parts.

8. Installing the external synchronizer(Fig. 6)

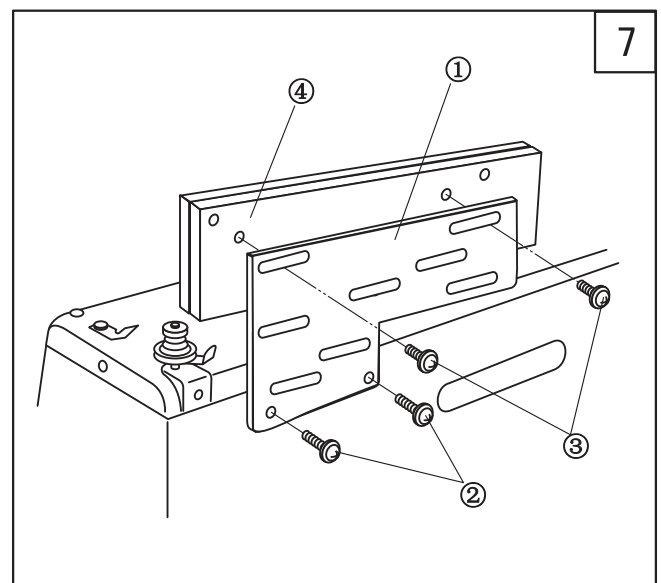
- 1) Fix synchronizer ① to the handwheel ③ by screws ②
- 2) First install the nut ⑦ and washer ⑧ on the supporter ⑥, then fix the supporter on the belt guard with another nut ⑦, make sure that the another end of the supporter is inserted into the groove of external synchronizer.

Note: Needle stop-position adjustment should be made AFTER installation and oil of the machine.



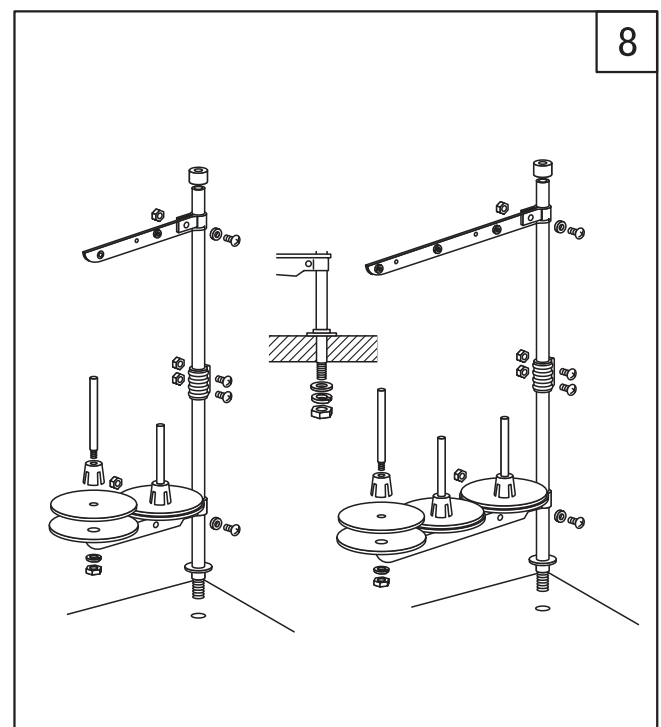
9. Installing the operation panel(fig.7)

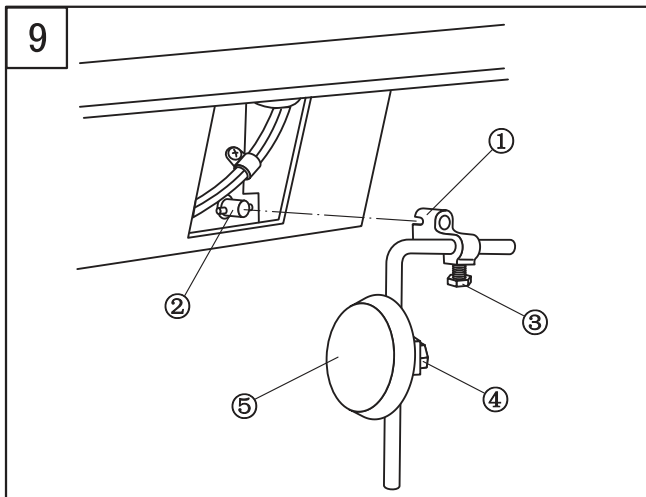
1. Fix the operation panel ④ on setting plate ① by screws ③
2. Fix setting plate ① onto the machine head by screw ②



10. Installing the thread stand(fig.8)

Install the thread stand on the table shown in the picture.

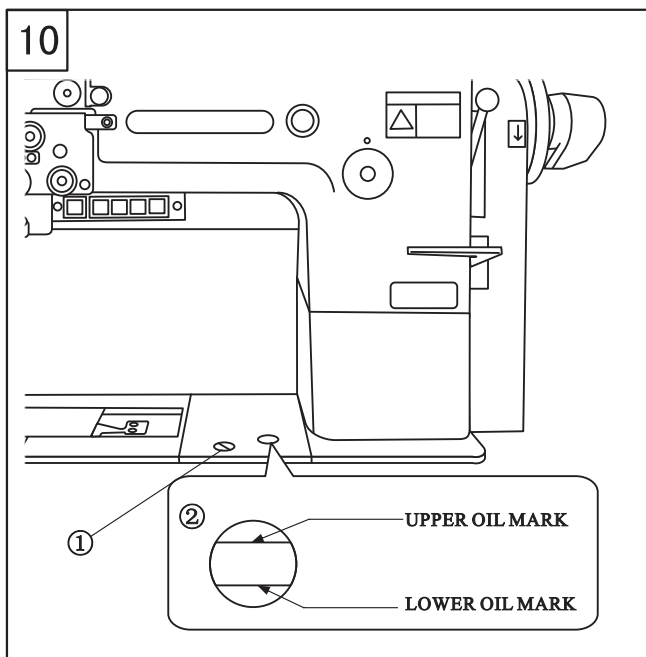




11. Installing the knee lifter(fig.9)

1. Connect the knee lifter bracket ① with knee lifter shaft ② under the table to install.
2. Loosen bolt ③ and ④, adjust knee lifter plate ⑤ to a comfortable position.
3. Fasten bolt ③ and ④.

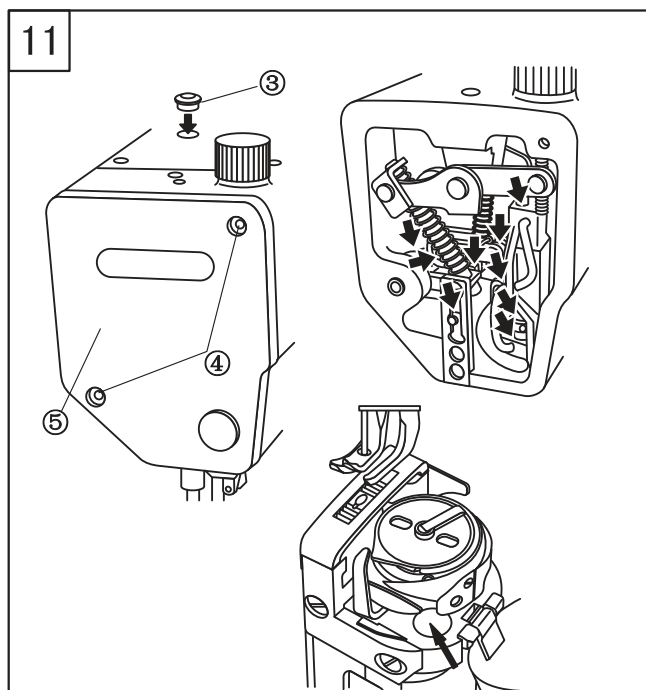
Note: Be sure to remove the knee lifter crank ① when you are laying down the machine head.



12. Lubrication(fig10, 11)

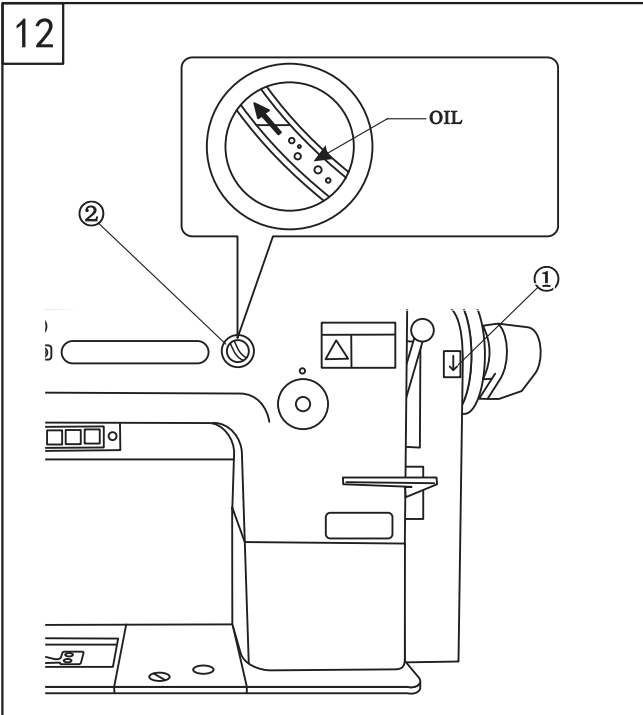
Lubrication should be made for the initial running or reuse after long periods of idleness.

1. Loosen setscrew ① of the oil tank filler hole.
2. Fill lubricant into the oil tank as per marks ②
3. Fasten screw ③ after oiling.



4. Take off rubber cover ③
5. Infuse about 10cc of lubricant into the oil tank
6. Insert the rubber cover
7. Loosen screw ④, remove face plate ⑤. Drip 2 or 3 drops of oil respectively to positions illustrated by arrows.
8. Open the hook cover ⑥ and lubricate shown by arrow in the picture.

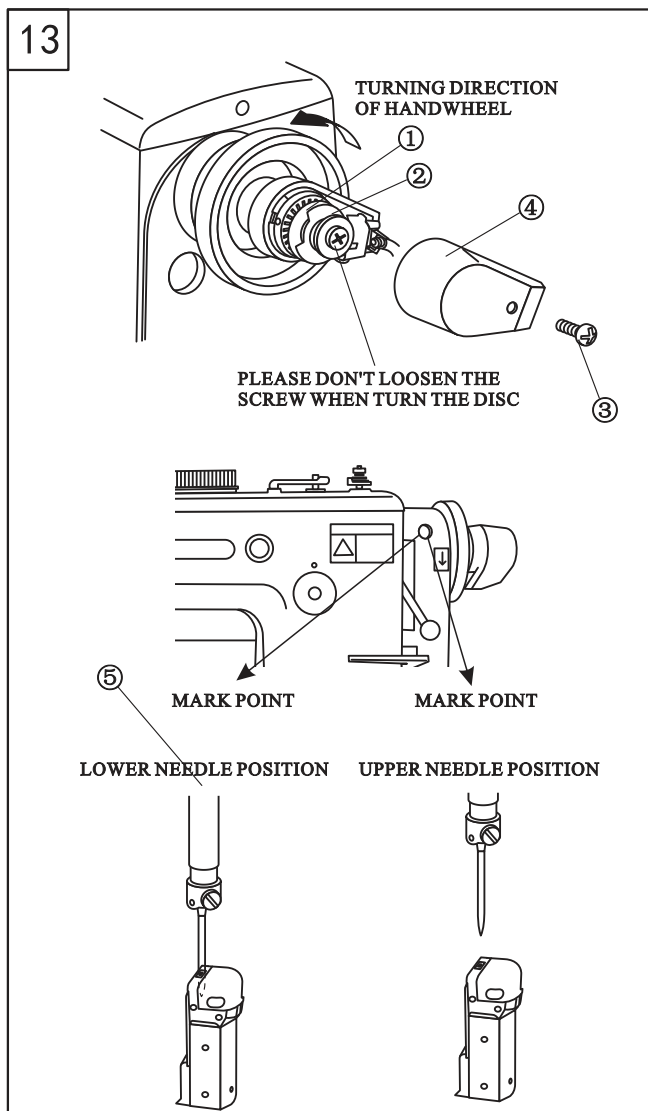
Note: If the oil in use is down to the lower mark, replenish oil immediately.



13. Rotating direction of pulley(fig.12)

1. Insert the power plug and switch on the machine.
2. Step the foot pedal slightly to confirm the pulley rotates clockwise illustrated by arrow ①.
3. Step the foot pedal slightly to confirm the oil goes up in the oil window.

Note: Oil will arrive at positions need lubrication after running for 1 minute.



14. Adjusting stop position of machine (fig.16)

Confirm all DIPA switches in control box of motor are OFF before adjustment.

1. Needle up-stop position adjustment

By operating the pedal to sew a stitch and stop the machine at a needle up-stop position, then step back. See if the sign C is visible in the slot of the belt cover. If not, there may be problems with the trimming.

Adjust the synchronizer as bellows:

- 1) Switch off the machine
- 2) Loosen screw ③ and take off cover ④
- 3) Turn the needle up-stop position disc ① in direction of the pulley rotation, the sign C will stop in a position before the former position. Otherwise if the disc ① is turned in the opposite direction, the sign C will stop at a point after the former position.

2. Needle down-stop position (thread trimming signal position) adjustment

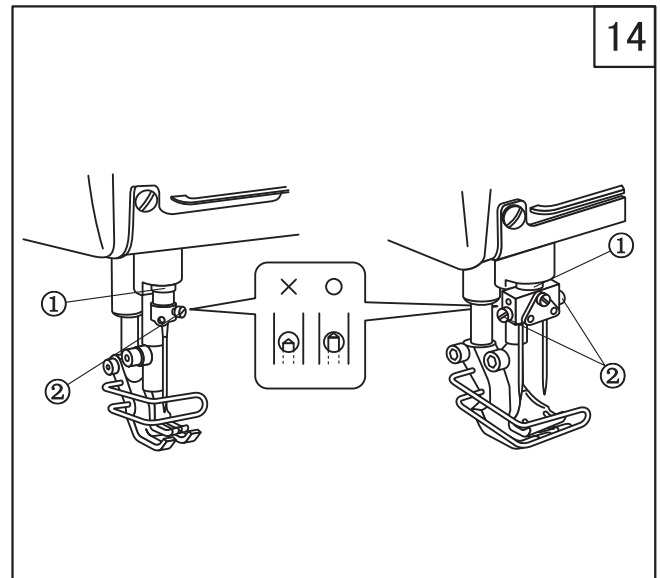
Stop the machine at a needle down-stop position, the setscrew ⑤ should be visible in the slot of the belt cover. If not, lower thread take-up errors may occur.

Adjust the synchronizer as bellows:

- 1) Switch off the power
- 2) Turn the needle down-stop position disc ② in direction of the pulley rotation, the setscrew ⑤ will stop at a point before the former position. Otherwise if the disc ② is turned oppositely, the setscrew will stop at a point after the former position.
- 3) Install cover ④ with screw ③

15. Installing the needle(fig.14)

1. Turn the pulley to rise the needle bar ① to it's highest point.
2. Loosen screw ②.
3. Insert the needle fully into the needle bar, making sure that the long groove is facing leftward. Tighten screw ② Securely.

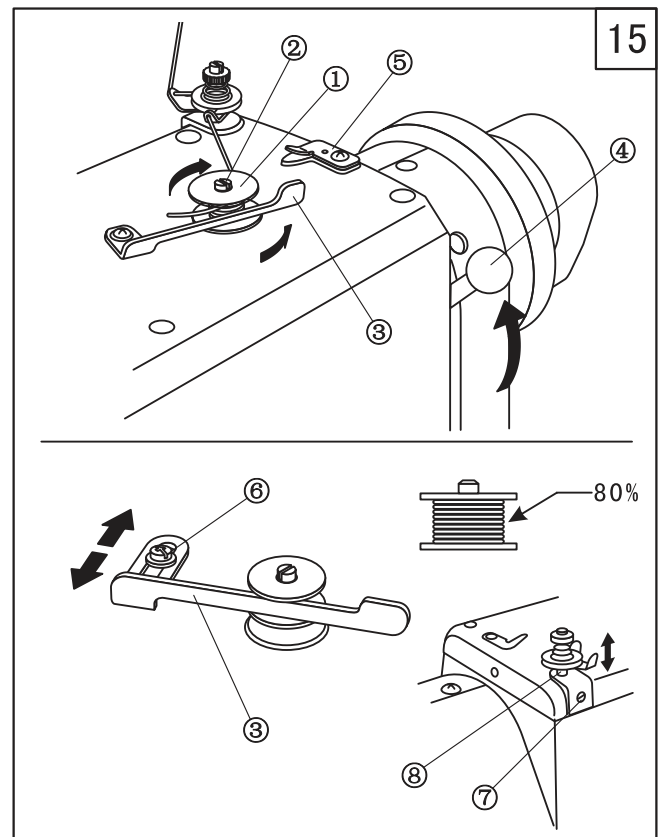


16. Winding the bobbin thread(fig.15)

1. Turn on the power
2. Insert bobbin ① onto the bobbin winder shaft ②
3. Wind the thread several times around the bobbin in the direction indicated by the arrow
4. Push the bobbin presser ③ toward the bobbin
5. Raise the presser foot by presser lifter bar ④
6. Step the pedal to start winding
7. Bobbin presser ③ will return automatically when winding is completed
8. Remove bobbin ① and cut the thread with knife after winding.

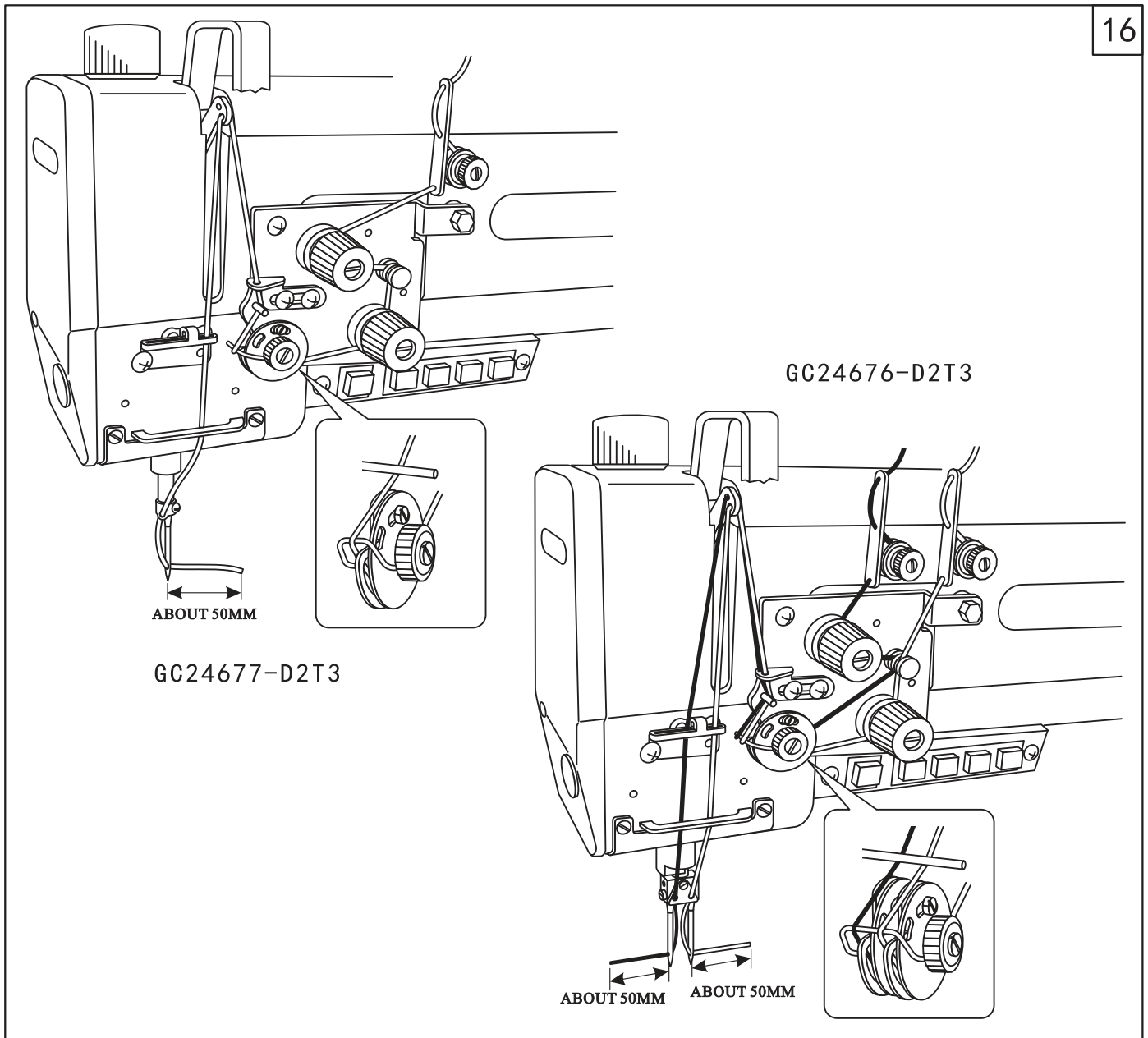
Note:

- 1) Thread amount wound should be a maximum of 80% to the bobbin capacity, which can be adjusted by loosening screw ⑥ and moving bobbin presser ③ sideways.
- 2) If the thread is wound unevenly, loosen the setscrew ⑦ and move the stud ⑧ vertically to adjust.

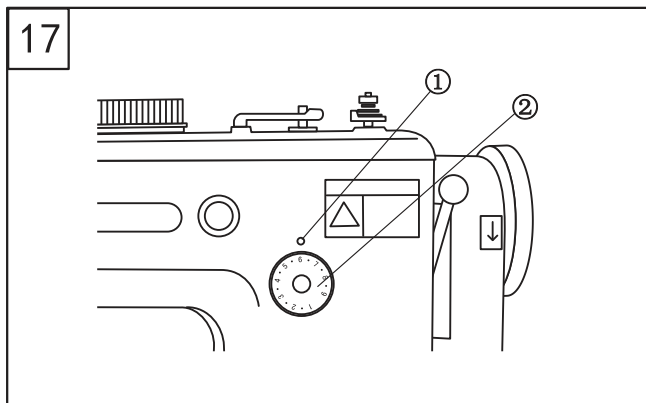


17. Threading the upper thread(fig.16)

Raise the thread take-up lever before threading the upper thread. This will make threading easier and it will prevent thread from coming out at the sewing start. Threading as per illustration in fig.16



17



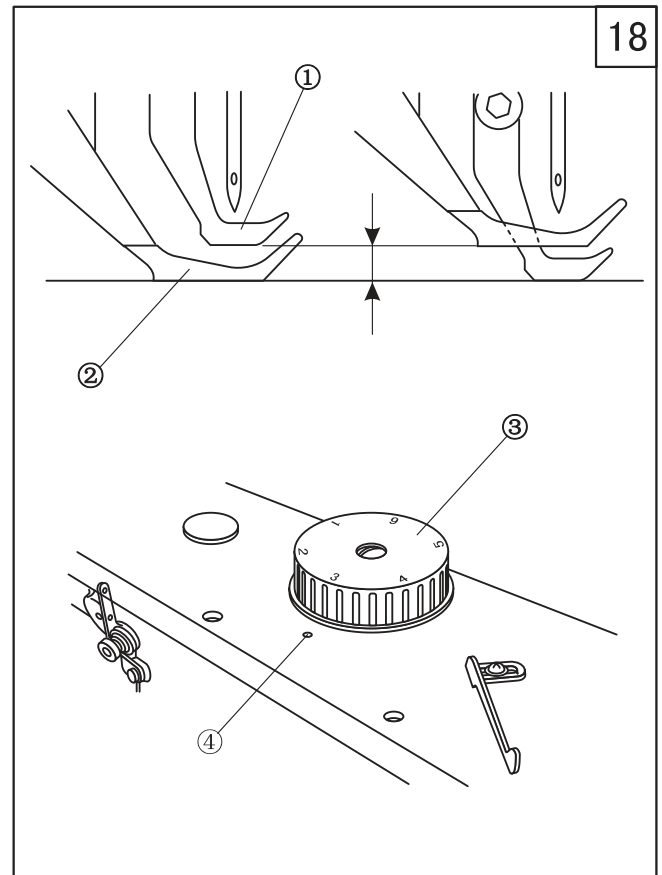
18. Adjusting the stitch length(fig.17)

Turn the feed adjustment dial ① clockwise or counter clockwise to align the number with the mark ②. The number aligned is the stitch length in mm.

19. Alternating presser foot movement amount(fig.18)

The alternating movement amount for the inner presser foot ① and the outer presser foot ② can be adjusted within the range of 1-7mm using the alternating presser foot movement dial ③.

Turn the dial ③ clockwise or counterclockwise to align the number(mm) with the mark ④.



20. Using the manual switches(fig.19)

① Quick reverse switch

Backtacking is carried out when this switch ① is pressed

② Alternating presser foot movement change switch
Machine can be switched between two different alternating presser foot movement amounts each time when button ② is pressed

◆ If the indicator is off, the alternating presser foot movement amount equals that set by dial ⑦

◆ If the indicator is on, the alternating presser foot movement amount equals the maximum amount (7mm).

③ Auto backtack select switch

If this switch ③ is pressed when either start backtacking or end backtacking has been set to ON at the operation panel, backtacking is canceled for the first time only.

Furthermore, if this switch ③ is pressed when neither start nor end backtacking has been set, backtacking is carried out for the first time only.

④ Half stitch switch

If this switch ④ is pressed while the sewing machine has been stopped during sewing, the needle can then be moved up and down. (it will not move after thread trimming has been carried out.)

⑤ Stitch length change switch

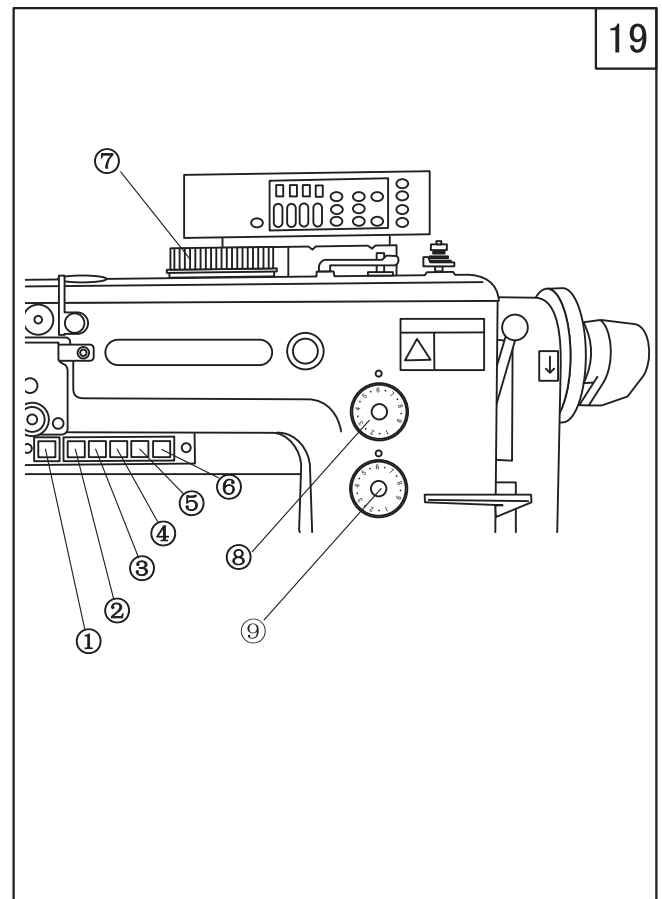
Stitch length changes alternately between 2 different stitch lengths set each time switch ⑤ is pressed.

◆ OFF—sewing with the stitch length set by dial ⑦ (longer stitch length).

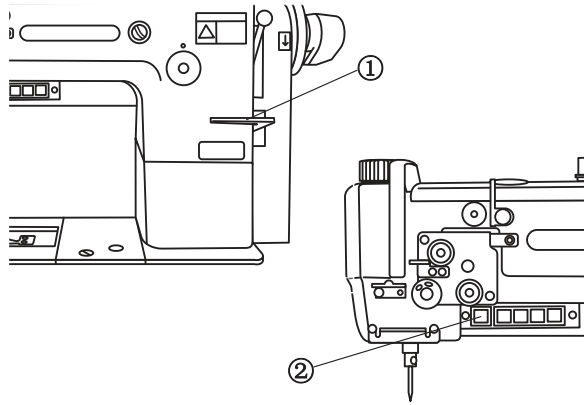
◆ ON—sewing with the stitch length set by dial ③ (shorter stitch length).

⑥ Central guide

When switch ⑥ is ON, the function is activated.



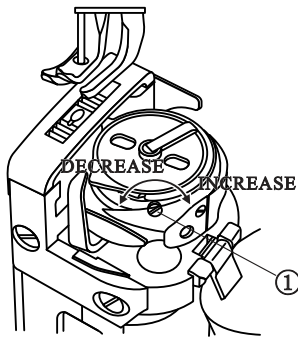
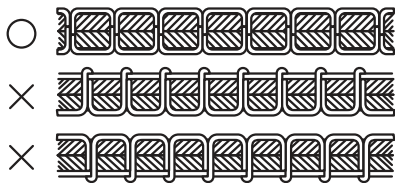
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21. Backtacking(fig.20)

When the reverse lever ① or the quick reverse switch ② is pressed during sewing, the feed direction will be reversed. When it is released, the feed direction will return to normal.

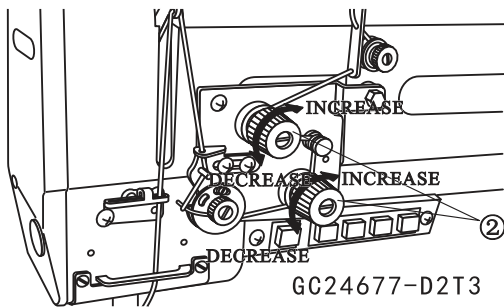
21



22. Thread tension(fig.28)

1. Lower thread tension

Turn the adjustment screw ① to adjust the lower thread tension.

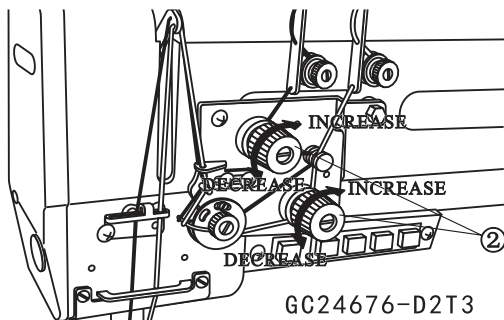


2. Upper thread tension

After the lower thread tension has been adjusted, adjusted the upper thread tension so that a good, even stitch is obtained.

1) Lower the presser foot.

2) Adjust by turning the thread tension nuts ②



23. Adjusting the presser foot pressure(fig.22)

1. If the presser adjusting dial ① is turned clockwise, the presser foot pressure will become stronger, and if it is turned counterclockwise, the pressure will become weaker.

2. The presser foot pressure should be as weak as possible, but strong enough so that the material does not slip.

22

————— NORMAL SEAM

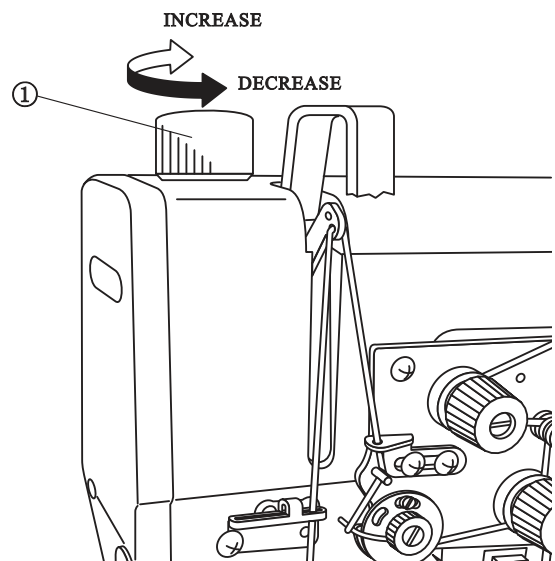
INCREASE PRESSER FOOT PREASURE

————— NEEDLE SKIP

————— STITCH LENGTH
DIFFERENT

DECREASE PRESSER FOOT PREASURE

————— STITCH SEAM
SHRINK



24. Adjusting the trailing length after thread trimming (fig.23)

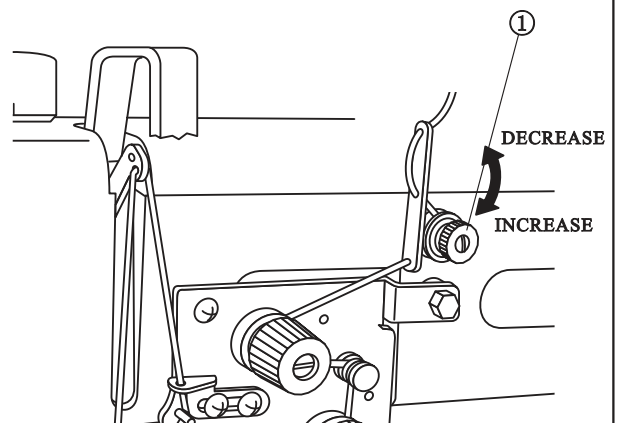
Adjust by turning the pretension ①.

1. At the time of thread trimming, the thread tension is loosened and tension is applied by the pretension ① only.

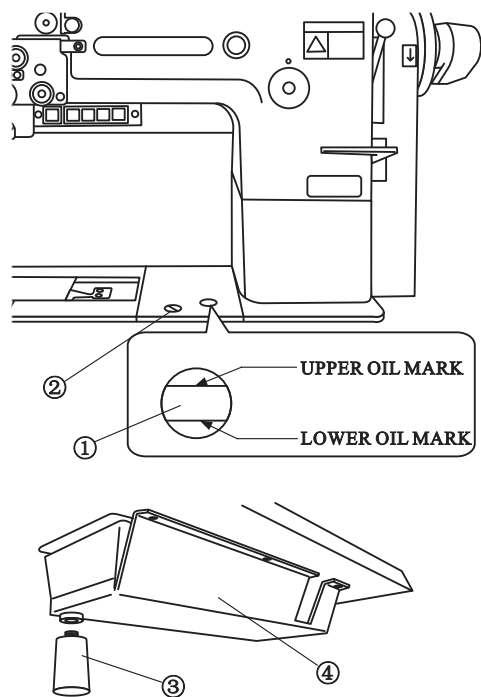
2. The standard trailing length for the upper thread is 65-80 mm (when the highest needle position stop function has been set to ON).

3. If the tension of the pretension ① is increased, the lengths of the threads trailing from the needle tips will be reduced. If the tension is reduced, the lengths will be increased.

23



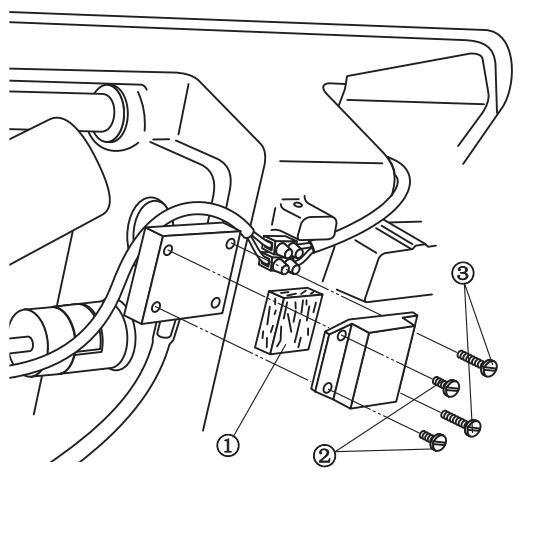
24



25. Lubrication(fig.24)

1. If the oil level drops to the lower reference line on the oil gauge ①, add more oil. Remove the screw ②, and then pour lubricating oil into the oil tank from the filter hole until the oil level reaches the upper reference line on the oil gauge ①
2. If oil has collected in the poly oiler ③, unscrew and remove the poly oiler and discard the oil which it contains. Screw the poly oiler ③ back into the oil pan ④?

25



26. Cleaning the oil filter(fig.25)

- If the filter ① is dirty, or if the amount of oil consumption increases dramatically, remove 2 screws ② and 2 screws ③, and then remove the filter ①. Clean or replace the filter ① as required. Fasten screws after cleaning.

27. Adjusting the thread tension spring(fig.26)

1. Thread tension spring position

The standard operation range for the thread tension spring ① is 5-10 mm.

a. Loosen the screw ② and then turn the stopper ③ to adjust the operating range.

b. Tighten the screw ②

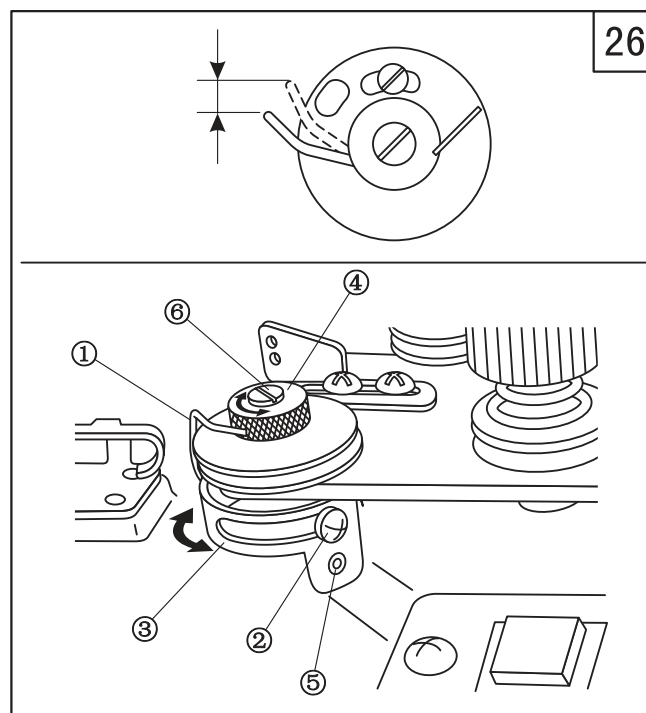
2. Thread tension spring tension

The standard tension for the thread tension spring ① is 0.4-0.8N.

a. Loosen the nut ④

b. Loosen the screw ⑤, and then turn the tension adjusting stud ⑥ to adjust the tension.

c. Tighten the screw ⑤, and then tighten the nut ④.



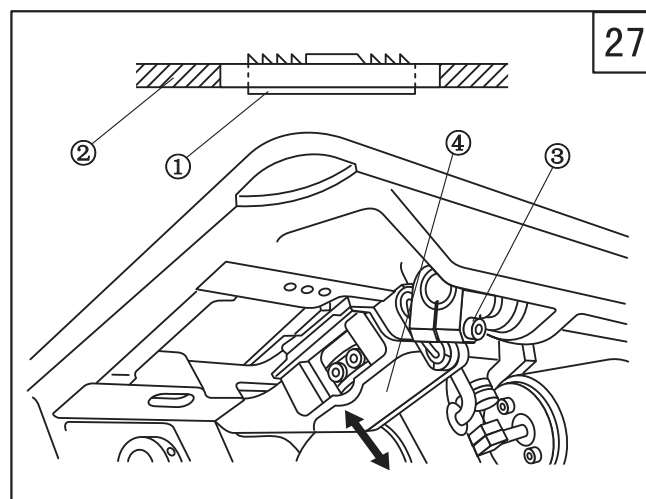
28. Adjusting the feed dog height(fig.27)

The standard height when the feed dog ① is at its highest point above the needle plate ② is 1.2 mm.

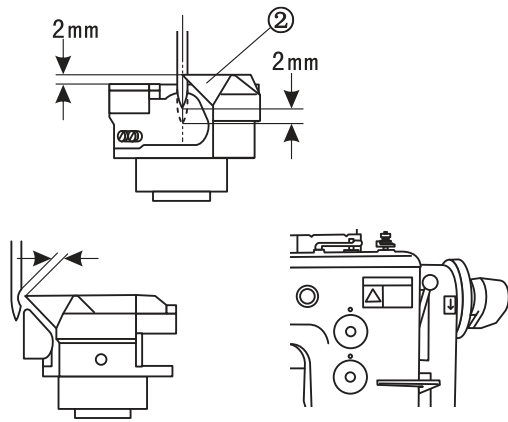
1. Turn the machine handwheel to set the feed dog ① to its highest point.

2. Loosen the bolt ③, and then move the feed bracket ④ up or down to adjust the height of the feed dog ①.

3. Tighten the bolt ③.



28



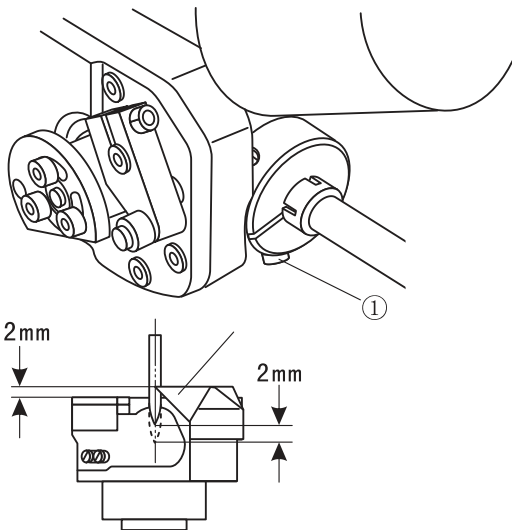
29. Needle and rotary hook timing(fig.28, 29)

1. Set the feed adjustment dials:

1-Needle: Max. stitch length.

2-Needle: to set left hook, set the stitch length zero, to set the right hook, set the stitch length 5.5mm

29



2.Uninstall the needle plate

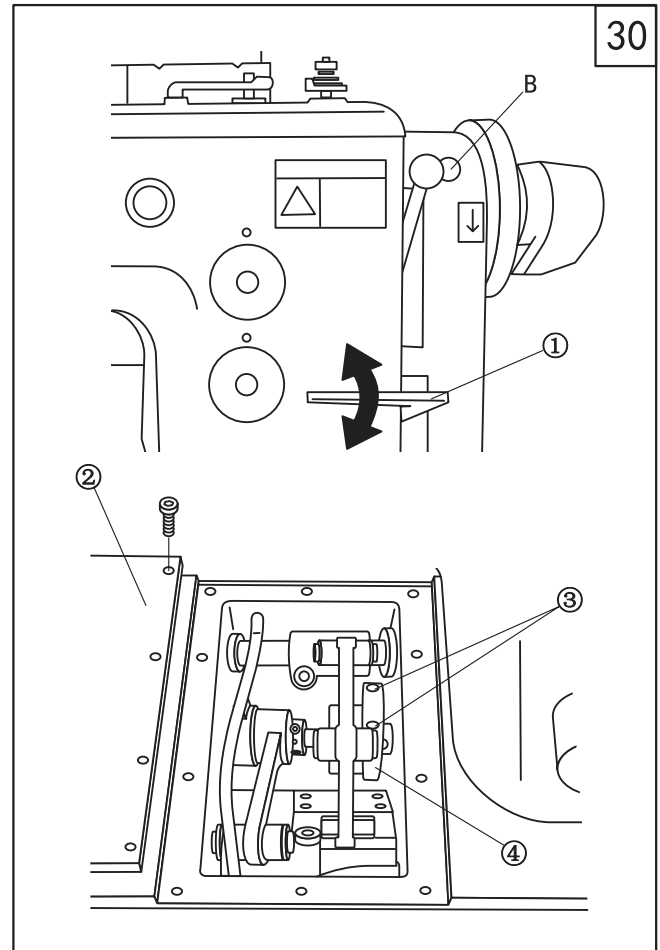
Loosen the screw ①, turn the handwheel to lift the needle from lowest position 2mm, then turn the hook to make the hook tip point to the needle central., tighten the screw ①

30. Adjusting the needle and feed mechanism timing (fig.30, 31)

1. Horizontal feed direction

Set the feed adjustment dials to the maximum. Then turn the machine pulley until "B" is visible in the belt cover slot. Then adjust so that the needle and the feed dog do not move even when the reverse lever ① is moved up and down at this time.

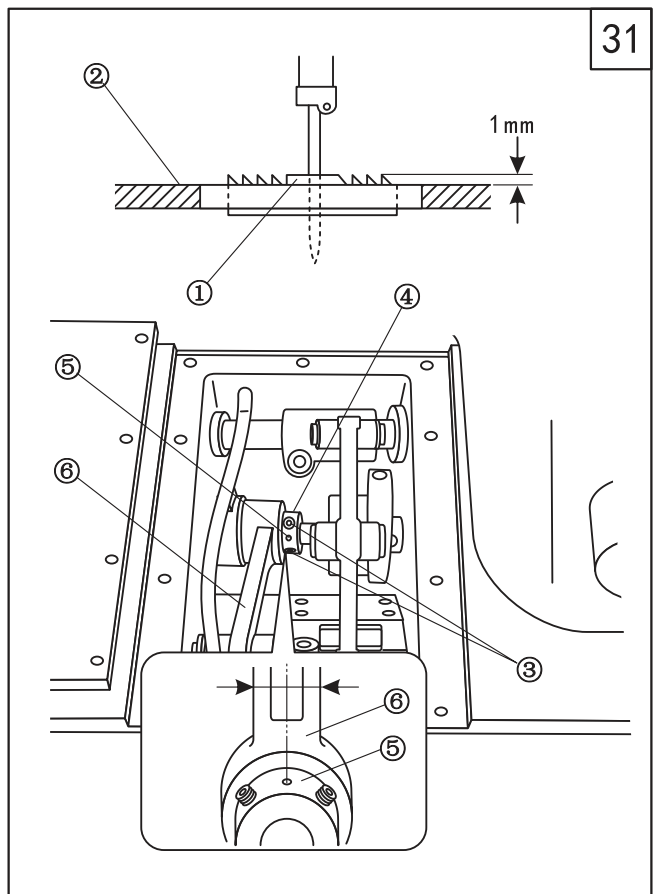
- a. Remove the bed upper cover ②.
- b. Set the feed adjustment dial to the maximum settings.
- c. Loosen the two set screws ③.
- d. Turn the machine pulley until "B" is visible in the belt cover slot.
- e. Turn the lower feed cam until the set screw ④ nearest to you is provisionally facing straight up.
- f. Turn the lower feed cam ④ gradually until it is at the position where the needle and the feed dog do not move even when the reverse lever ① is moved up and down.
- g. Tighten the two set screws ③.



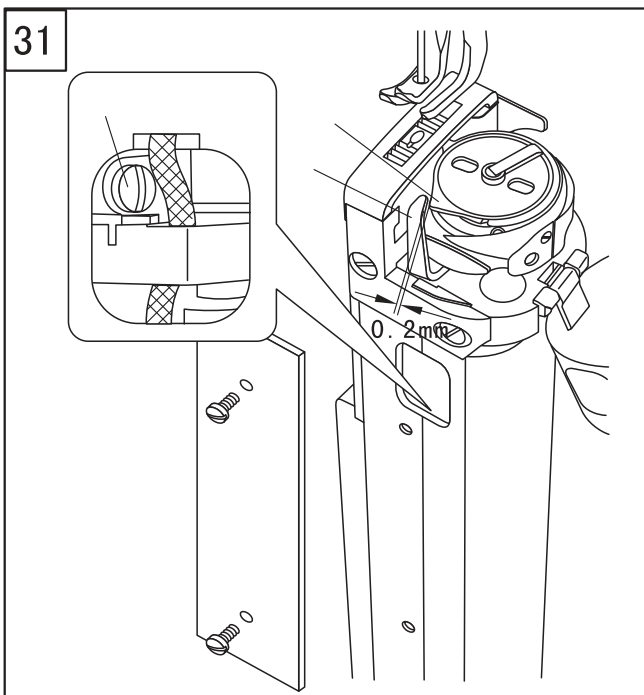
2. Vertical feed direction

Set the feed adjustment dials to the minimum. Then adjust as follows so that the feed dog ① is at its highest position (0.5 mm above the top of the needle plate ②) when the needle bar is at its lowest position.

- a. Loosen the two set screws ③.
- b. Turn the machine pulley to set the needle bar to its lowest position.
- c. Turn feed cam ④ to align the point ⑤ of feed cam ④ with the center line of feed rod ⑥.
- d. Tighten the set screws ③.



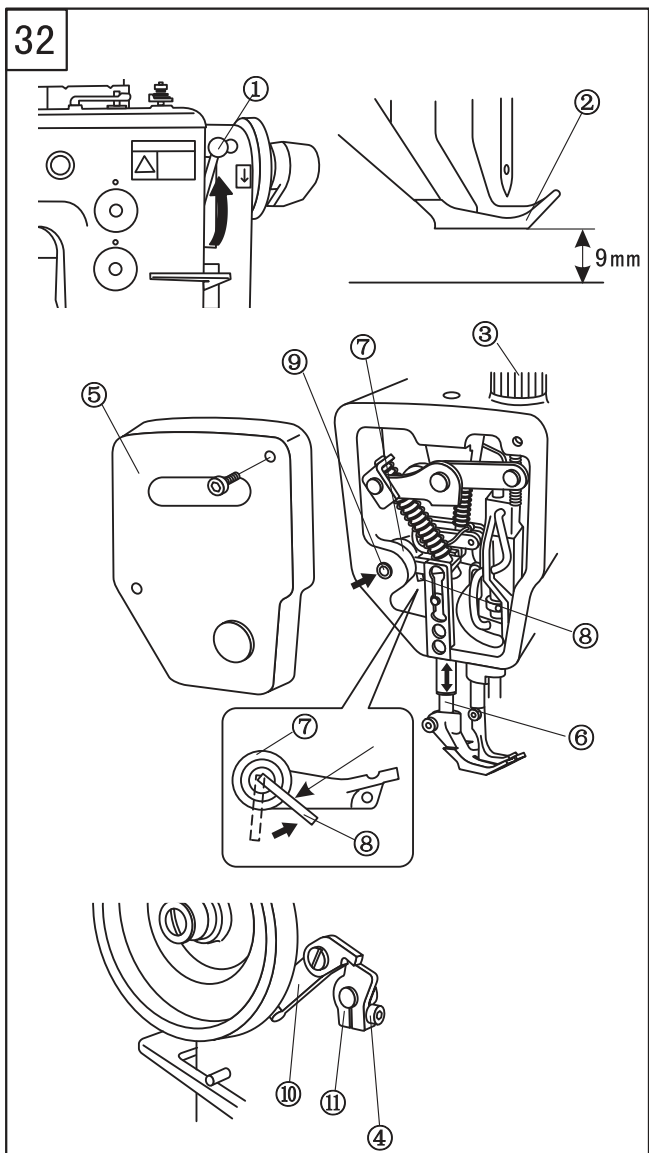
31



31. Adjusting the opener (fig.32)

The min. clearance between opener and hook is 0.2mm, loosen the screw ③, turn the opener ② to make the clearance between hook ① is 0.2mm, finally tighten the screw ③

32



32. Adjusting the presser foot height(fig.33)

The standard height of the outer presser foot ② is 9 mm when it is raised by the presser lifter bar ①.

1. Remove the belt guards.
2. Loosen the presser adjusting dial ③, to release the presser foot pressure.
3. Raise the presser lifter bar ① and then loosen the screw ④.
4. Remove the face plate ⑤.
5. Move the outer presser bar ⑥ up or down to adjust so that the height of the outer presser foot ② is 9 mm.
6. While the stopper pin ③ is touching against the notch ⑦ in the presser foot lifter connection ⑦ and while pushing the presser lifter shaft ⑨ so that there is no play in the thrust direction, tighten the screw ④. Tighten the screw ④ while presser bar lifter cam ⑩ is meshed with presser bar lifter cam ⑪ as shown in the illustration.
7. Turn the presser adjusting dial ③ to adjust the presser foot pressure.
8. Install the belt covers.

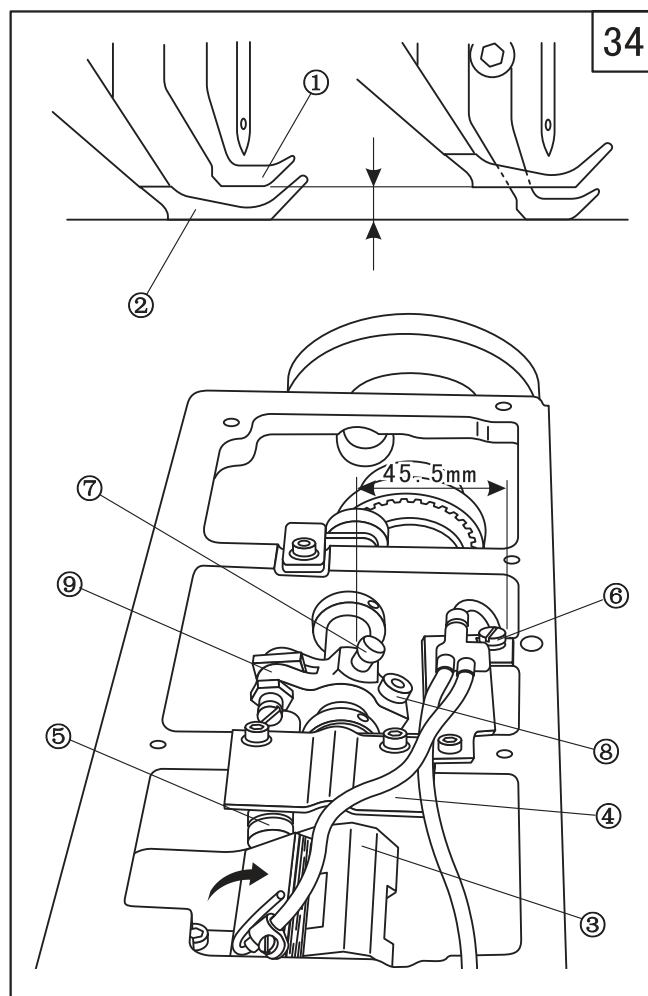
33. Adjusting the alternating presser foot movement amount (fig.34, 35, 36)

1. Maximum alternating presser foot movement amount

Carry out the following adjustment to set the maximum alternating movement amounts for the inner presser foot ① and outer presser foot ② to the maximum of 7mm.

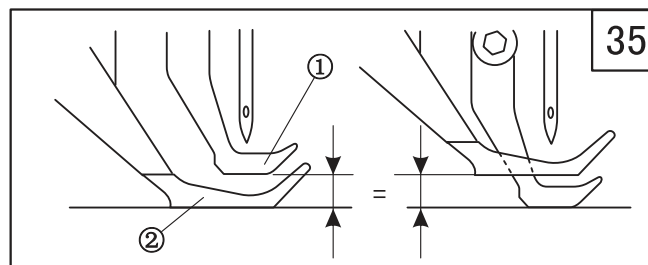
- Remove the upper plate.
- Lift up adjusting bracket ③ so that adjusting bracket collar ⑤ touches the stopper support plate ④.
- Loosen the bolt ⑧ and turn connecting lever ⑨ to adjust so that the distance from the outer edge of the screw ⑥ to the outer edge of pin ⑦ is 45.5 mm at this time. Then tighten the bolt ⑧.

When installing the upper plate, set the alternating presser foot movement dial to the "1" Position.



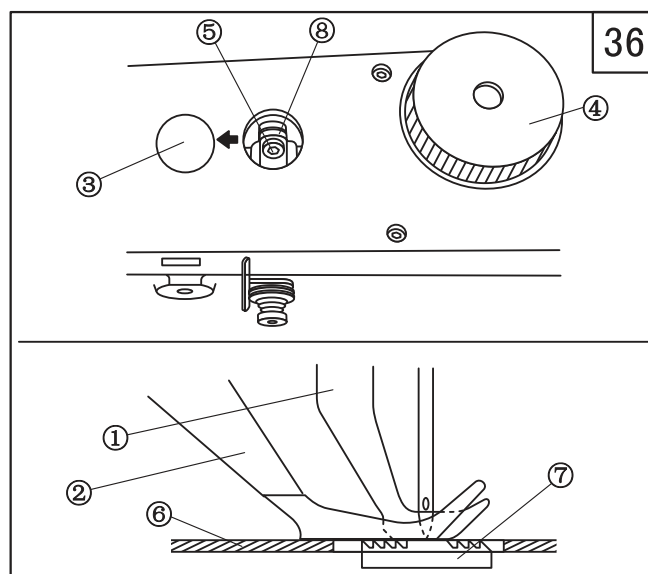
2. Inner presser foot and outer presser foot movement amounts

Carry out the following adjustment to make the movement amounts for the inner presser foot ① and the outer presser foot ② equal when the presser feet are lowered and the machine pulley is turned.

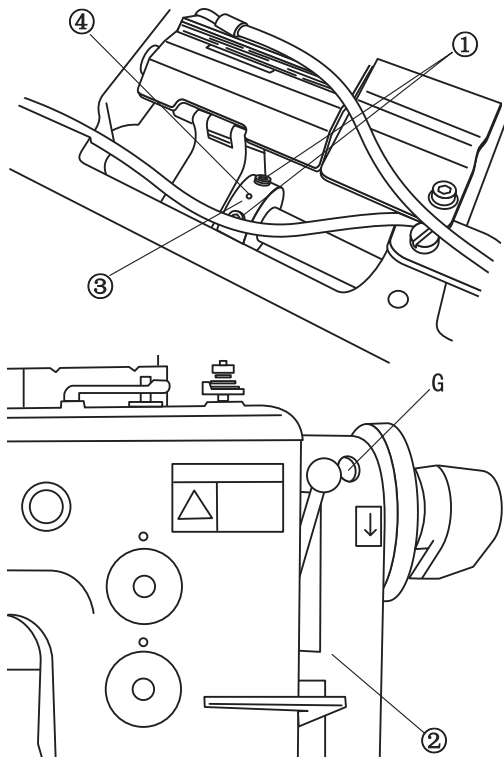


3. Adjustment

- First, carry out the "feed dog height", "needle bar height" and "needle and feed mechanism timing" adjustment.
- Set the feed adjustment dials to the maximum.
- Remove the rubber cap ③.
- Turn the alternating presser foot movement dial ④ to the "3" position.
- Loosen the screw ⑤.
- Turn the machine pulley toward you to align the tip of the needle and the top of the feed dog ⑦ with the top of the needle plate ⑥.
- Move the connecting lever ⑧ to adjust so that both the inner presser foot ① and outer presser foot ② are in contact with the top of the needle plate ⑥ at this time. Then tighten the screw ⑤.



37

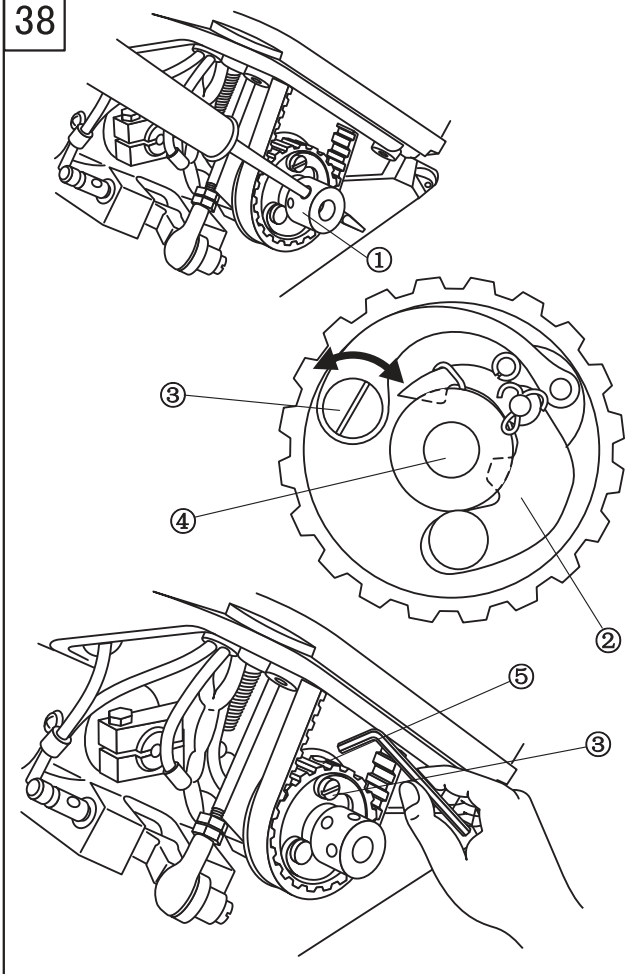


34. Adjusting the presser foot timing(fig.37)

When the presser feet are lowered and the machine pulley is turned toward you, the inner presser foot should touch the feed dog before the needle arrives at the feed dog. Then when the needle lifts up, the tip of the needle should move away from the feed dog before the inner presser foot moves away.

1. Remove the upper cover.
2. Loosen the two screws ①.
3. Turn the machine pulley until "C" is visible in the slot of the belt cover ② (highest take-up lever position).
4. Turn inner presser cam UD ③ to adjust so that the point ④ of inner presser cam UD ③ is facing straight up.
5. Tighten the screws ①.

38



35. Safety equipment(fig.38)

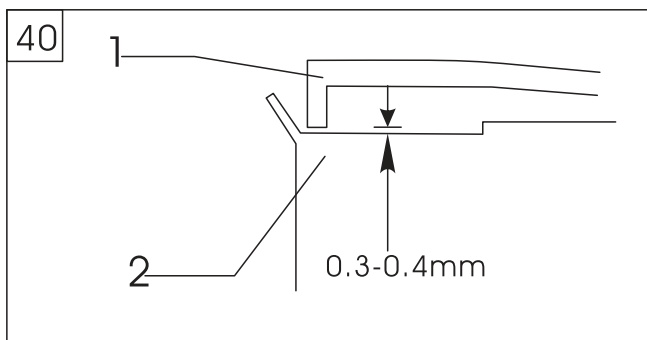
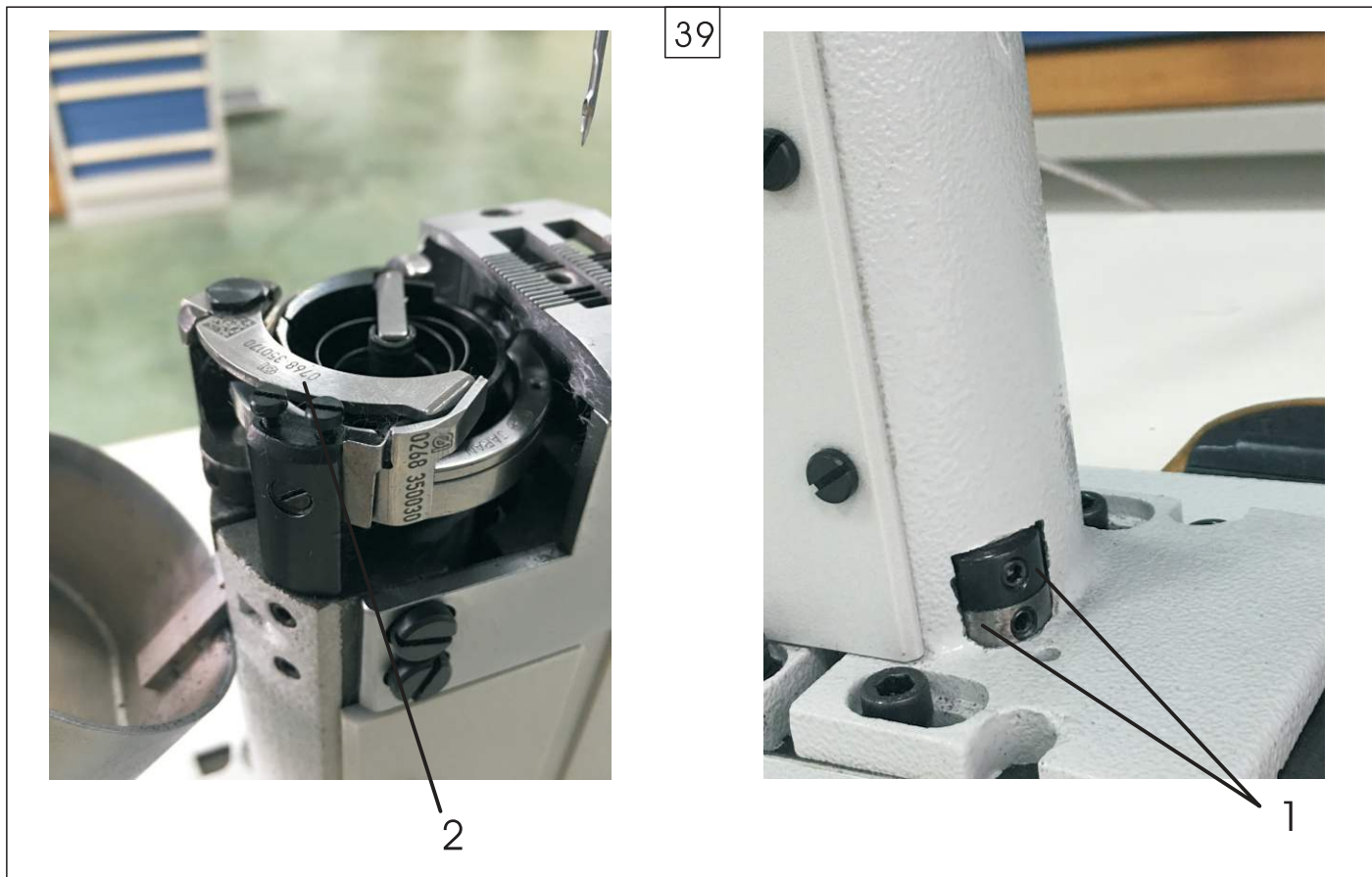
If the thread becomes tangled up in the rotary hook during sewing, the lower belt pulley safety equipment will operate to protect parts such as the rotary hook and the timing belt from damage. The lower shaft will stop rotating, and only the lower belt pulley will rotate in idleness.

1. Resetting the safety equipment
 - a. Remove the thread which has become tangled up in the rotary hook.
 - b. Do not use a sharp-tipped instrument to do this, otherwise the rotary hook may become damaged.
 - c. Insert a screwdriver into the hole in the lower belt shaft ①, hold the screwdriver so that it does not turn, and then turn the machine pulley in reverse (clockwise) by hand.
 - d. Turn the machine pulley again but harder. The safety equipment will then be reset. (Check that the lock lever ② is fitting securely into the groove of the lower belt shaft ①.)
2. Safety equipment engagement strength

The engagement strength of the safety equipment is weakest when the arrow on the lock lever spring shaft ③ is pointing toward the center of the shaft ④, and strongest when it is pointing toward the outside.

 - a. Turn the machine pulley to the position where an Allen key can be inserted into the set screw ⑤.
 - b. Loosen the set screw ⑤, and then turn the lock lever spring shaft ③ to adjust.
 - c. After adjusting, securely tighten the set screw ⑤.

36. Adjusting the position of movable knife(fig.39. 40)



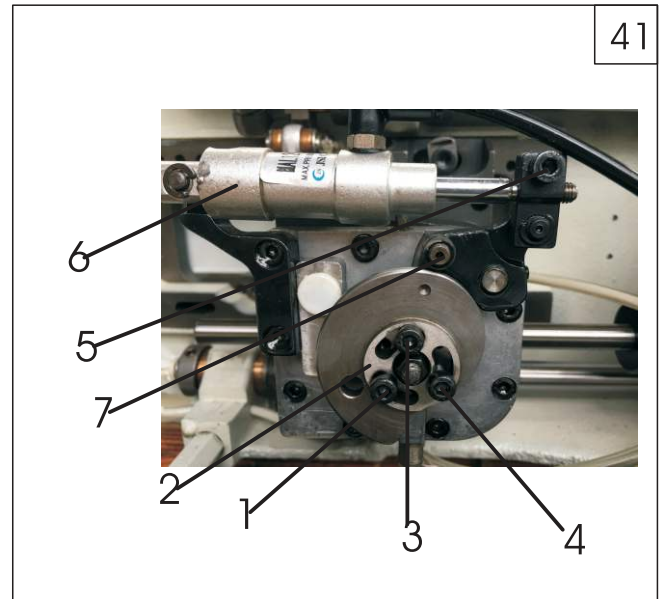
Requirements: the clearance between the lower surface of movable knife ① and hook lower level ② is 0.3-0.4mm shown in Fig 40.

Adjust according to Fig 39:

- 1.Loosen the screw ①;
- 2.Adjust the movable knife ② to the required clearance;
- 3.Tighten the screw ①

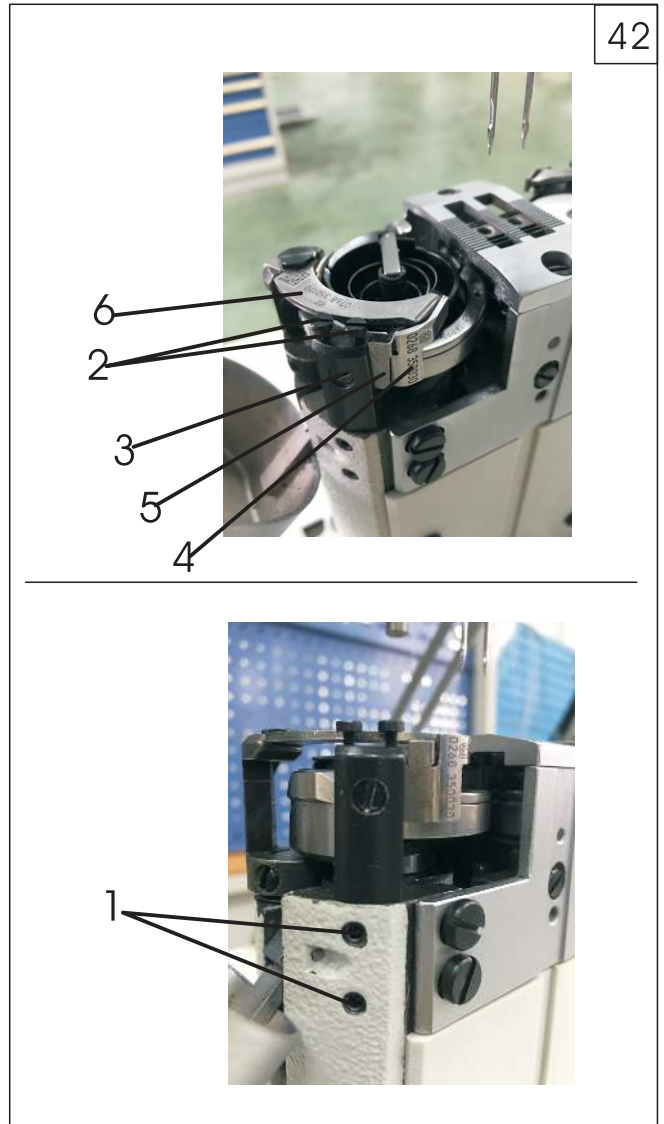
37. Adjusting the trimming time(fig.41)

- 1.Trimming is up to the position of cam, when the needle bar is at its highest position, roller 7 should be touched with the highest point of cam ②
- 2.When sewing, the roller cannot be touched with the cam, the clearance should be 0.1mm
- 3.Adjustment: loosen the screw ⑤, adjust the clearance between roller and cam, then adjust the cylinder shaft ⑥, finally tighten the screw ⑤
- 4.Adjustment of cam,
 - 1)Loosen the cam screw 1, 3, 4
 - 2)Turn the cam to adjust the clearance
 - 3)Tighten the screw 1, 3, 4.



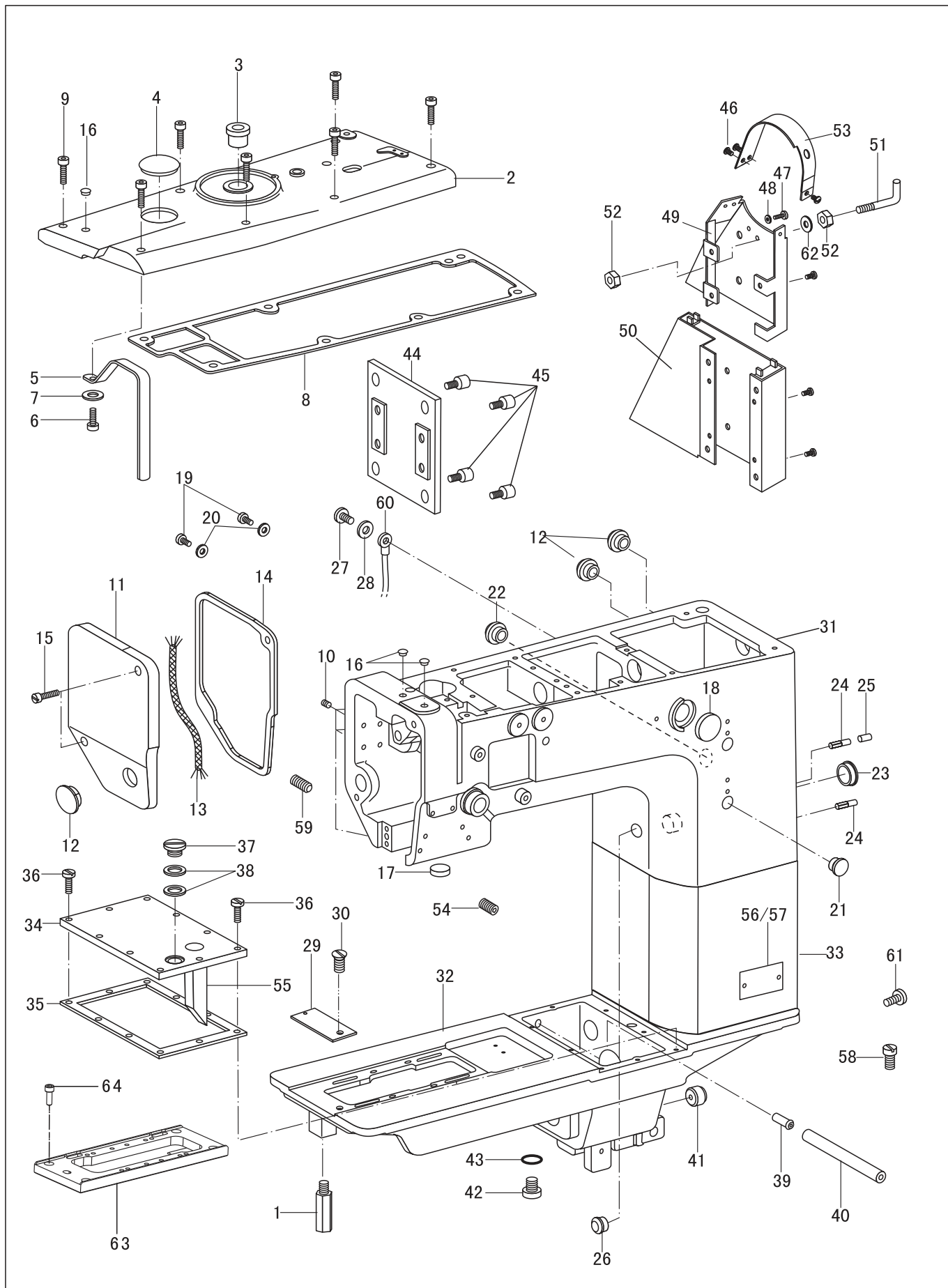
38. Adjusting the fixed knife and thread clamp spring(fig.42)

- Thread clamp spring ⑤ can hold the bobbin thread after trimming to prevent needle skip.
Fixed knife ④ should be parallel installed with movable knife ⑥.
- 1.Parallel position adjustment
Loosen the screw ③, adjust the parallel between movable knife ⑥ and fixed knife ④, and adjust screw ②, finally tighten the screw ③
 - 2.Adjust the trimming pressure
To make sure that the pressure is lowest when trimming smoothly.. usually the overlap between movable knife and fixed knife should be 1/3.
Loosen the screw ≠ to adjust the fixed knife base.
 - 3.Adjust the clamp spring
Slightly blend the spring to adjust the thread clamp spring.



Parts Manual

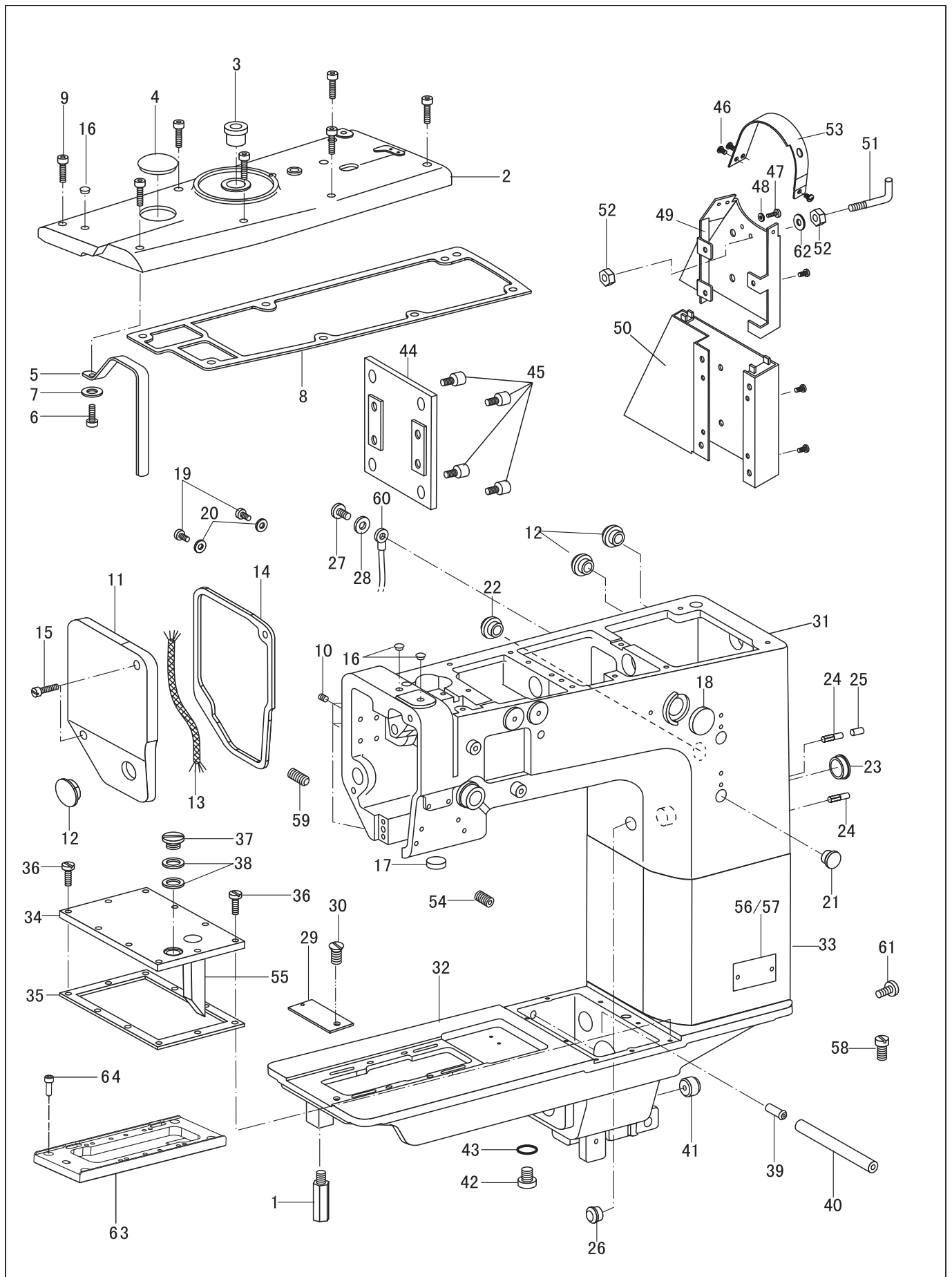
1. Machine body



1. Machine body

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	994387	Support bar	1	1	
2	99423001	Top cover	1	1	
3	93WF1-001	Dial bushing	1	1	
4	93WF1-002	Rubber cap, 32.8	1	1	
5	994232	Thread take-up lever cover	1	1	
6	93WF1-024	Bolt	1	1	
7		Washer	1	1	GB/T 97.1 4
8	93WF1-003	Sheet packing	1	1	
9	93WF1-026	Bolt	7	7	
10	93WF1-027	Set screw	5	5	
11	994005	Face plate	1	1	
12	93WF1-004	Rubber cap, 20.5	2	2	
13	994007	Oil wick	1	1	L=130
14	93WF1-005	Packing	1	1	
15	93WF1-029	Bolt	2	2	
16	93WF1-006	Rubber cap, 9.5	3	3	
17	93WF1-007	Rubber cap	1	1	
18	93WF1-008	Oil window	1	1	
19	13WF2-008	Screw	2	2	SM9/64"×40
20	93WF1-009	Washer	2	2	
21	93WF1-049	Rubber cap	2	2	
22	93WF1-048	Rubber cap	1	1	
23	93WF1-010	Bushing	2	2	
24	2KT3-006	Pin	2	2	140063-0
25	2KT3-007	Nylon tube	1	1	153132-0
26	93WF1-11	Rubber cap, 10.5	1	1	
27		Screw	1	1	GB/T 818 M4×6
28		Washer	1	1	GB/T 97.1 4
29	89WF2-029A	Plate	-	1	1/8, 3/16
	89WF2-029B	Plate	-	1	1/4, 5/16, 3/8
	89WF2-029C	Plate	-	1	1/2
	16WF2-034	Plate	1	-	
30	16WF2-035	Screw	1	1	
31	93WF1-046	Machine arm	1	1	
32	211WF2-001	Machine bed	1	1	
33	211WF2-002	Connector	1	1	
34	994361	Upper cover assy	1	1	
35	93WF1-014	Sheet packing	1	1	
36	93WF1-024	Bolt	10	10	
37	93WF1-015	Screw	1	1	
38	93WF1-016	Packing	2	2	
39	93WF1-017	Pipe	1	1	
40		Tube	1	1	L=120
41	93WF1-018	Oil cap	1	1	
42	93WF1-019	Screw	1	1	
43		O-ring	1	1	6.9×1.8A GB 3452.1
44	211WF2-006	Cover plate	1	1	
45		Screw	4	4	GB818-85 M4X6
46	93WF1-058	Screw	3	3	
47	93WF1-040	Screw	7	7	GB/T 70.1 M6×10
48	93WF1-041	Washer	7	7	GB/T 97.1 6
49	386WF8-001B	Belt cover, B	1	1	
50	386WF8-001C	Belt cover, C	1	1	
51	214WF-009	Supporting rod	1	1	
52	42WF5-013	Nut	2	2	

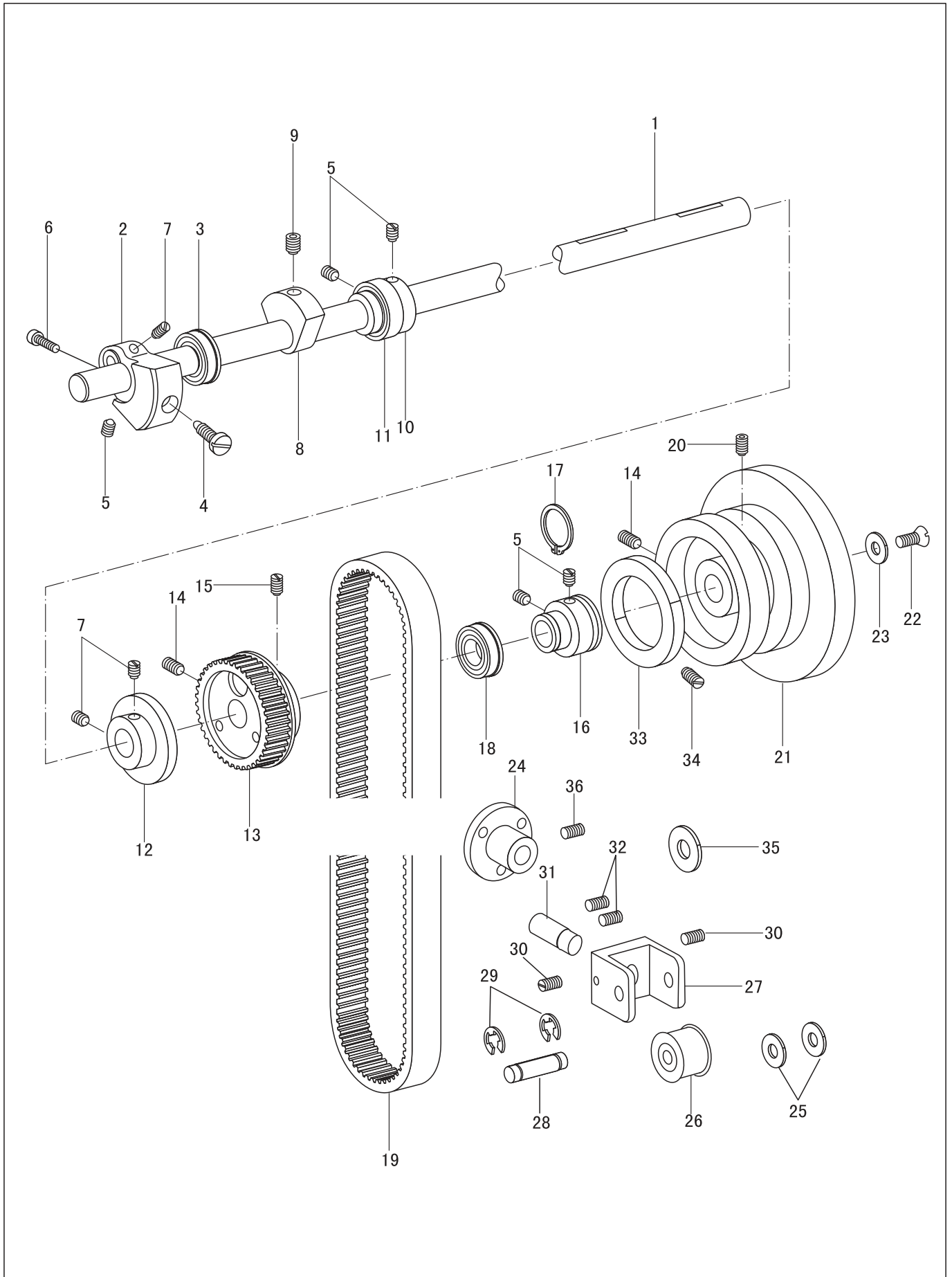
1. Machine body



1. Machine body

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
53	386WF8-001A	Belt cover, A	1	1	GB/T77 M4X5
54		Screw	2	2	
55	994363	Oil gauge	1	1	
56	7WF4-033	Model label	1	1	
57	7WF4-034	Model label	1	1	
58	200WF5-009	Screw	2	2	GB/T80 M4X5
59	93WF8-036	Screw	2	2	SM9/64"X40
60	117WF1-006A	Ground wire	1	1	
61	13WF2-008	Screw	2	2	
62	72WF2-010	Washer	2	2	
63	386WF2-009	Plate	1	1	
64	42WF2-018	Screw	4	4	

2. Upper shaft mechanism



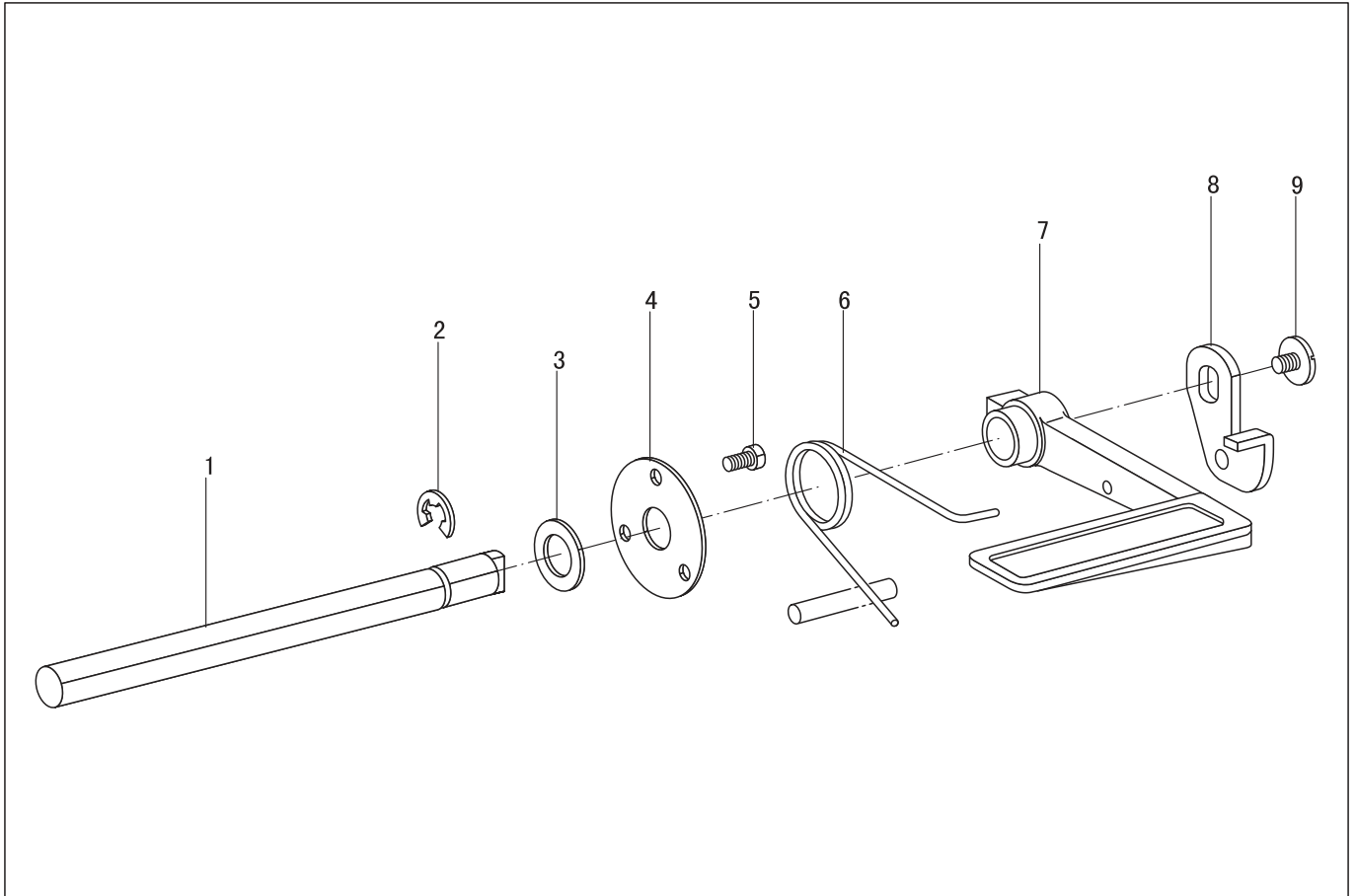
2. Upper shaft mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	994010	Upper shaft	1	1	6204-2ZNR 20×47×14
2	994018	Crank motion cam	1	1	
3		Bearing, upper shaft	1	1	
4	93WF2-001	Screw	1	1	
5	93WF1-027	Set screw	5	5	
6	93WF1-026	Bolt	2	2	GB/T 80 M8×12
7	93WF2-008	Set screw	3	3	
8	994014	Balancer	1	1	
9		Set screw	1	1	
10	994012	Collar, middle upper shaft	1	1	62/22-2Z 22×50×14
11	93WF2-012	Bearing	1	1	
12	994226	Collar, bobbin winder	1	1	
13	213WF-013	Upper belt pulley	1	1	
14	93WF2-014	Set screw	2	2	
15	93WF2-015	Set screw	1	1	GB 894.2 20 6034-2ZNR 20×52×15
16	994011	Collar, back upper shaft	1	1	
17		Retaining ring	1	1	
18		Bearing	1	1	
19	213WF-015	Timing belt	1	1	
20	93WF2-015	Set screw	1	1	
21	211WF1-007	Machine pulley	1	1	
22	13WF1-051	Screw	1	1	
23	13WF1-050	Washer	1	1	
24	211WF1-014	Bush	1	1	
25	211WF1-013	Washer	4	4	GB896 6 GB/T80 M5X10
26	213WF-002	Tensioner	1	1	
27	211WF3-007	Block	1	1	
28	211WF3-005	Pin shaft	1	1	
29	W01462	Retaining ring	2	2	
30	93WF5-030	Screw	2	2	998537 GB/T80 M6X8
31	211WF3-006	Shaft	1	1	
32	57WF-009	Screw	1	1	
33	211WF1-008	Gauge ring	1	1	
34	93WF1-027	Screw	1	1	
35	13WF3-002	Washer	1	1	
36	89WF5-017	Screw	2	2	

3. Upper feed mechanism

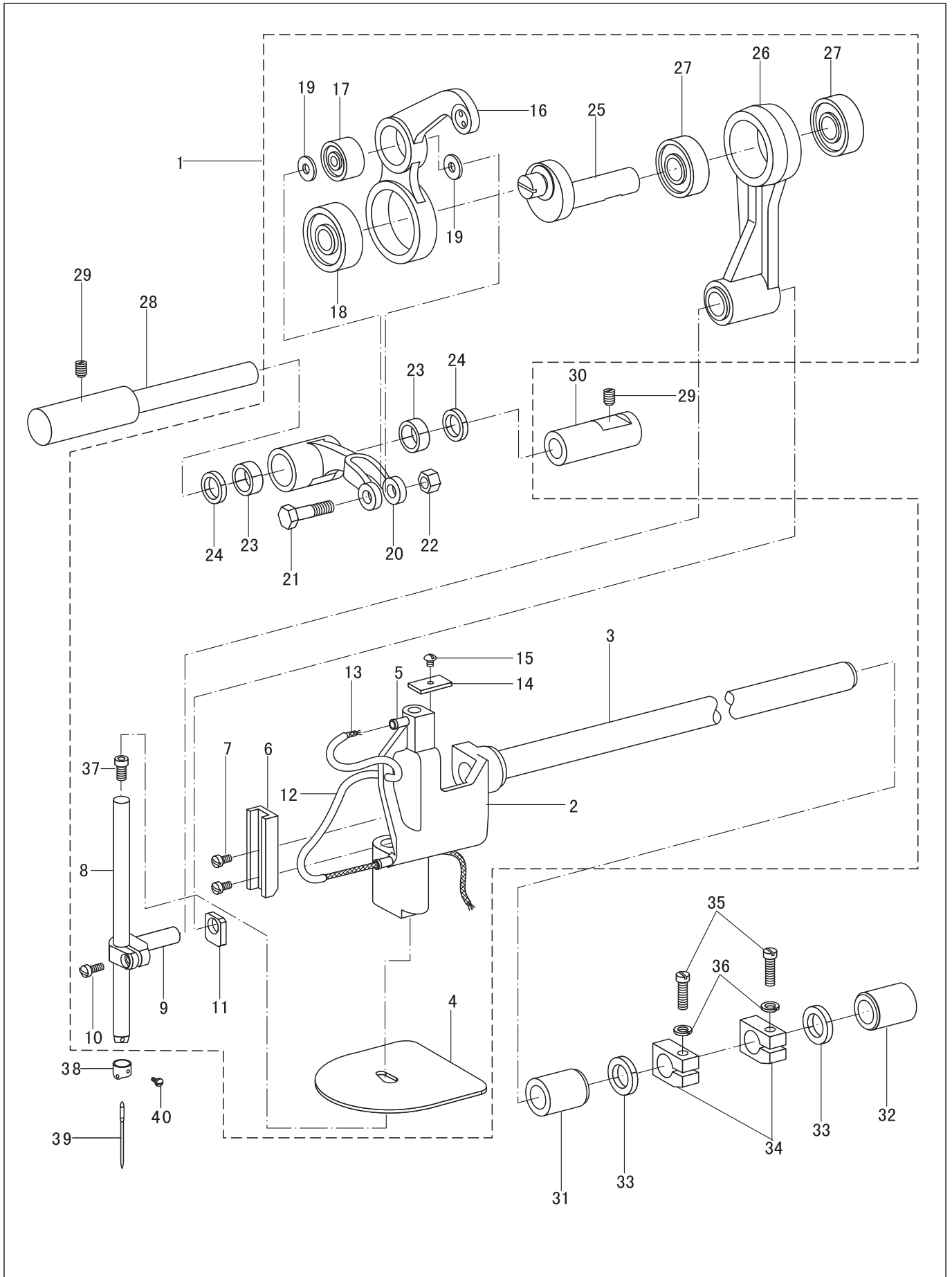
NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	994217C	Upper feed connecting rod assy	1	1	
2	994217	Upper feed connecting rod	1	1	
3	93WF3-005	Bolt	2	2	
4	994218	Connecting lever	1	1	
5	994220	Upper feed connection assy	2	2	
6	93WF3-001	Pipe	2	2	
7	93WF3-002	Shoulder screw	4	4	
8		Retaining ring	4	4	GB 896 8
9		Tube	1	1	φ5X280
10	0148-F	Felt	1	1	3×8
11		Oil tube	1	1	φ5X180
12	93WF3-009	Fastening band	3	3	3X80
13	994082	Rubber cap	1	1	
14	211WF3-002	Link assy.	1	1	
	211WF3-002A	Link	1	1	
	211WF3-002B	Bush	1	1	
15	008018	Screw	1	1	
16		Oil tube	1	1	φ7X180
17		Oil wick	1	1	3X550
18		Oil wick	1	1	3X500
19		Oil wick	1	1	3X500
20	211WF3-003	Block	1	1	
21	213WF-003	Screw	1	1	
22		Oil tube	1	1	φ5X100
23		Oil wick	1	1	3X170

4. Quick reverse mechanism



NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	994206	Shaft, Reverse stitching lever	1	1	
2	93WF4-004	Retaining ring	1	1	
3	93WF4-001	Washer	1	1	
4	93WF4-002	Spacer	1	1	
5		Bolt	3	3	GB/T 70.1 M4×6
6	21WF3-043	Spring	1	1	
7	62WF2-003	Reverse stitching lever	1	1	
8	62WF5-024E	Reverse stitching lever plate	1	1	
9	2KT3-005	Screw	1	1	100511-003

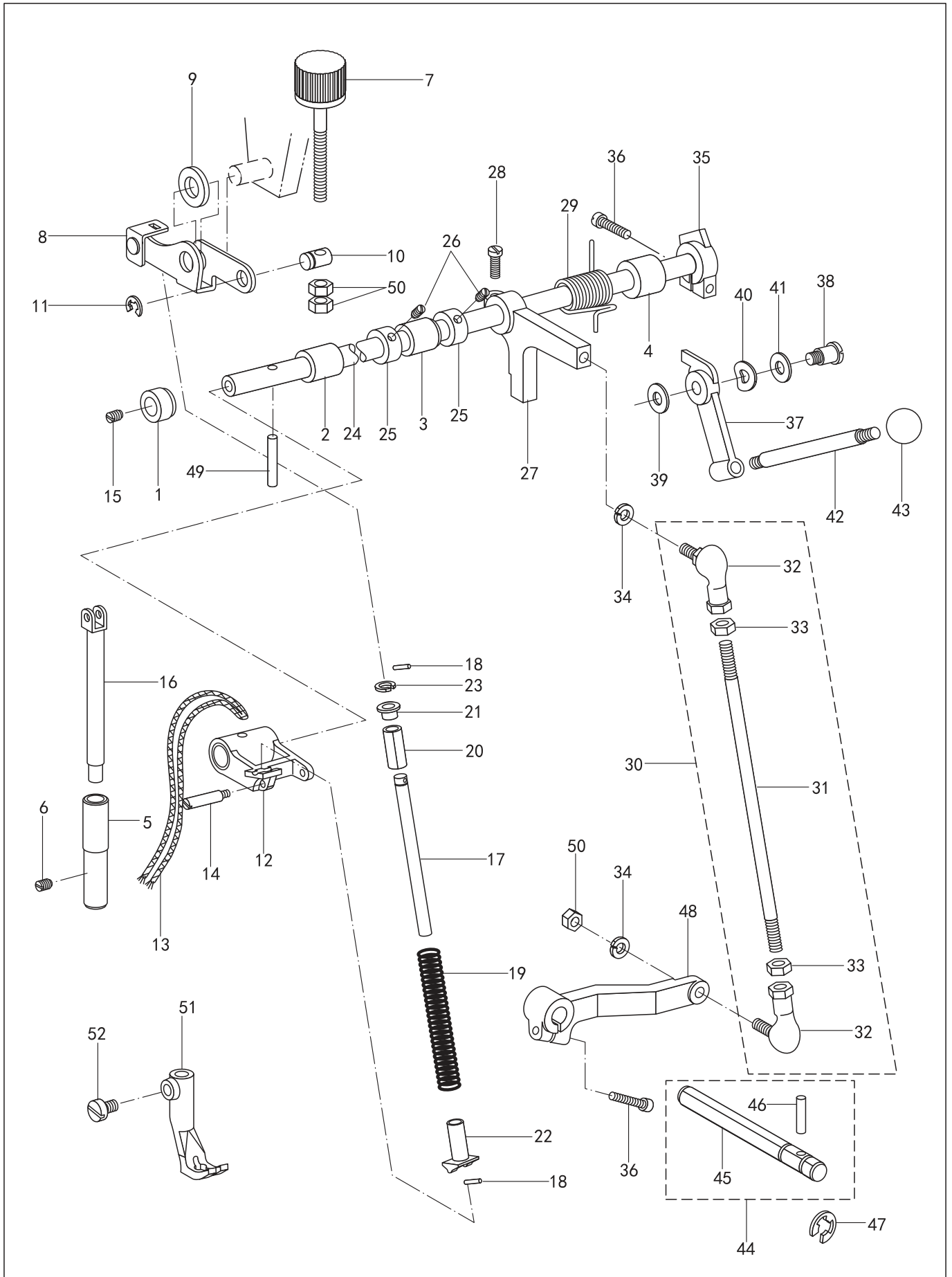
5. Needle bar and thread take-up mechanism



5. Needle bar and thread take-up mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1		Needle bar bracket assy	1	1	
2	99403101	Needle bar bracket	1	1	
3	99403102	Needle bar bracket shaft	1	1	
4	93WF5-001	Rubber sheet	1	1	
5	93WF3-001	Tube	2	2	
6	994047	Guide rail	1	1	
7	491115	Screw	2	2	
8	93WF5-014	Needle bar	1	-	
	997625	Needle bar	-	1	
9	994044	Needle bar clamp	1	1	
10	13WF3-018	Screw	1	1	
11	994045	Slide block, N-bar clamp	1	1	
12	994037	Oil tube	1	1	110
13	994035	Oil wick	1	1	700
14	93WF5-003	Sponge	1	1	
15		Screw	1	1	GB/T 65 M4×6
16	386WF1-025	Thread take-up lever complete	1	1	
17	491049	Bearing, S, T-take-up	1	1	80024 4×13×5
18	491050	Bearing, L, T-take-up	1	1	80018 8×22×7
19	491054	Washer, T-take-up	2	2	GB/97.1 4
20	994022	Thread take-up support	1	1	
21	994024	Support screw	1	1	
22		Nut	1	1	GB/T 6170 M4
23	491056	Needle bearing	2	2	29241/7 7×10×8
24	93WF5-004	Support ring	2	2	
25	994025	Crank	1	1	
26	994026	Needle bar crank rod assy	1	1	
27		Bearing	2	2	698-2Z 8×19×6
28	994020	Pin, T-take-up	1	1	
29	93WF5-030	Set screw	2	2	
30	93WF5-005	Bushing, T-take-up pin	1	1	
31	93WF5-006	Bushing	1	1	
32	93WF5-007	Bushing	1	1	
33	93WF5-008	Ring	2	2	
34	994042	Collar	2	2	
35	93WF1-029	Bolt	2	2	
36		Washer, spring	2	2	GB 859 5
37	200WF5-009	Screw	1	1	
38	93WF5-002	Thread guide	1	-	
39		Needle	1	2	DP×17 19#
40	17WF5-037	Screw	1	-	

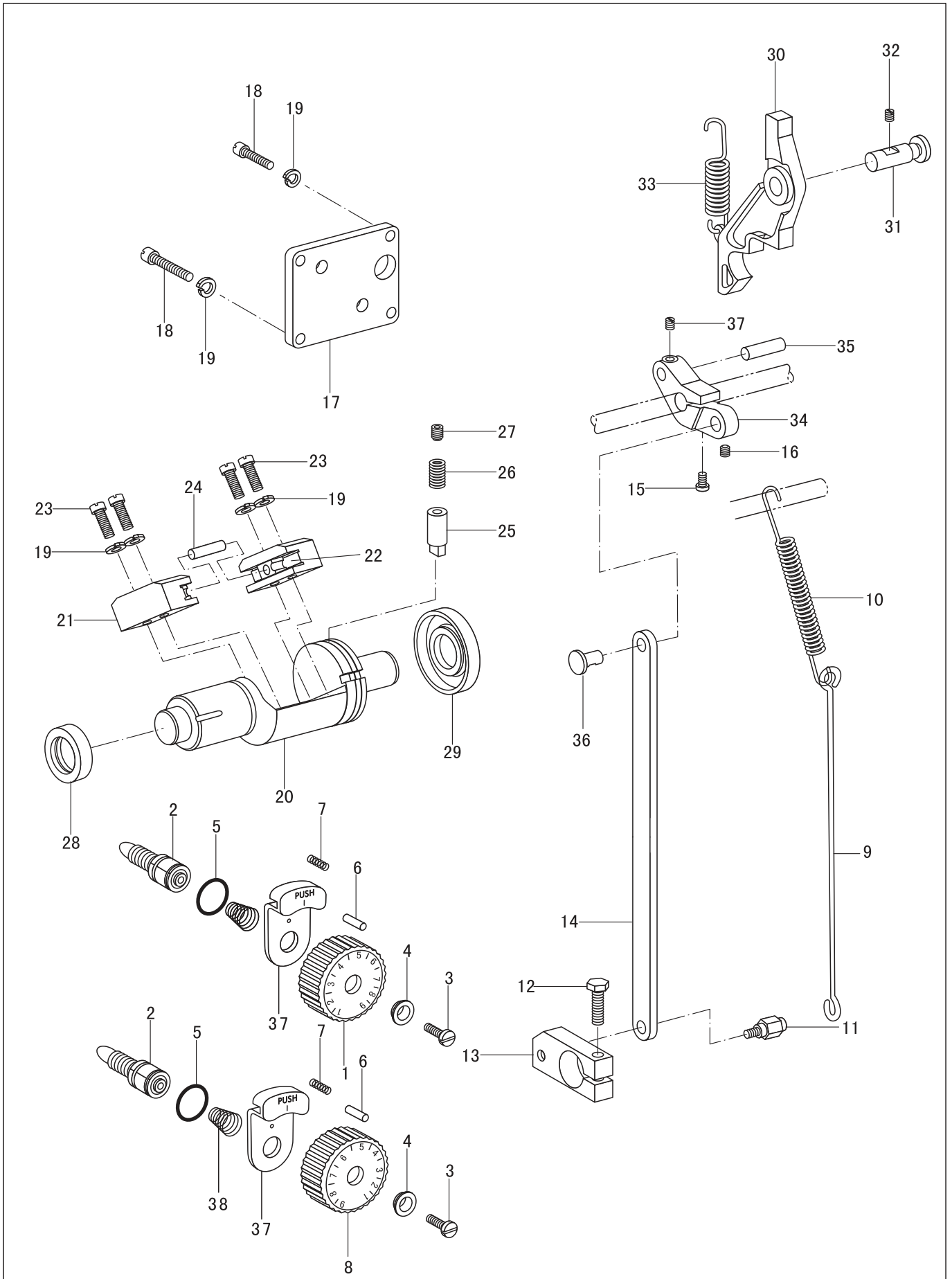
6. Presser bar mechanism



6. Presser bar mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	93WF6-001	Bushing A, P-foot lifter shaft	1	1	
2	93WF6-002	Bushing B	1	1	
3	93WF6-003	Bushing C, P-foot lifter shaft	1	1	
4	93WF6-004	Bushing D	1	1	
5	93WF6-021	Bushing, P-bar	1	1	
6	93WF5-030	Set screw	1	1	
7	93WF6-005	Pressure adjusting screw	1	1	
8	994073	Pressure adjusting plate assy.	1	1	
9	93WF6-006	Felt	1	1	
10	994079	Pin	1	1	
11	93WF6-007	Retaining ring	1	1	
12	994159	P-foot lifter connection assy.	1	1	
13	994160	Oil wick	1	1	L=400
14	994161	Pin	1	1	
15	93WF2-015	Set screw	1	1	
16	386WF5-002	Presser bar	1	1	
17	994077	Shaft, presser bar spring	1	1	
18		Pin	2	2	GB/T 879.1 3×8
19	93WF6-008	Presser spring	1	1	
20	93WF6-009	Collar	1	1	
21	994075	Spring support, U	1	1	
22	994076	Spring support, D	1	1	
23	93WF6-031	Retaining ring	1	1	
24	994158	Presser bar lifter shaft	1	1	
25	93WF6-010	Set screw collar	2	2	
26	93WF2-008	Set screw	2	2	
27	994383	Knee lifter arm, U	1	1	
28	93WF6-035	Bolt	1	1	
29	994166	Spring	1	1	
30	211WF3-001	K-lifter connecting bar assy.	1	1	
31	211WF3-001A	Knee lifter connecting bar	1	1	
32	93WF6-011A	Link ball	2	2	
33		Nut	2	2	GB/T 6172 M6
34		Retaining ring	2	2	GB 859 5
35	994168	Presser bar lifter cam, U	1	1	
36	93WF6-042	Bolt	2	2	
37	994167	Presser bar lifter cam, D	1	1	
38	200WF6-001	Shoulder screw	1	1	
39	200WF6-002	Washer	1	1	
40	200WF6-003	Washer	1	1	
41	93WF6-015	Washer	1	1	
42	93WF6-016	Presser lifter bar	1	1	
43	93WF6-017	Lever grip	1	1	
44	994382C	Knee lifter shaft assy.	1	1	
45	994382	Knee lifter shaft	1	1	
46	93WF6-018	Pin	1	1	
47	93WF6-019	Retaining ring	1	1	
48	994384	Knee lifter arm	1	1	
49	93WF6-020	Pin	1	1	
50	30804	Nut	1	1	
51	93WF13-003	Walking foot	1	-	
52	93WF13-004	Screw	1	-	

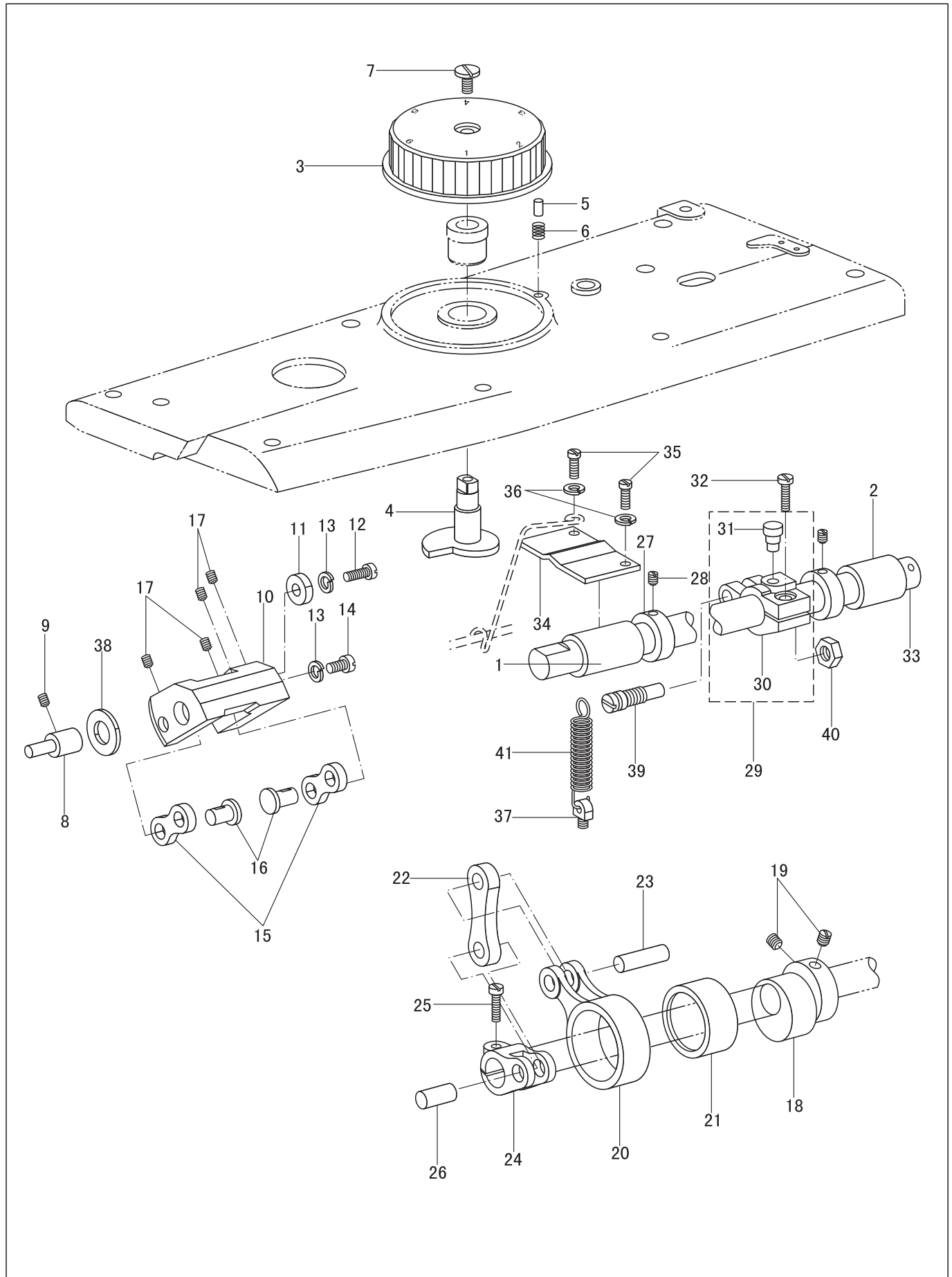
7. Feed mechanism



7. Feed mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	386WF4-017	Feed adjusting dial, U	1	1	
2	386WF4-015	Adjusting screw	2	2	
3	27WF3-005	Screw	2	2	
4	36T5-007D4	Bushing	2	2	
5	124T5-001A3	O ring	2	2	
6	386WF4-014	Positioning pin	2	2	
7	22T5-009	Spring, compression	2	2	
8	386WF4-018	Feed adjusting dial, D	1	1	
9	211WF3-010	Linking bar	1	1	
10	994345	Spring	1	1	
11	994352	Bar screw	1	1	
12	93WF7-033	Screw	1	1	
13	994351	Block	1	1	
14	211WF3-004	Link	1	1	
15		Screw	1	1	GB/T65 M5X25
16	93WF7-029	Screw	2	2	
17	93WF1-028	Setting plate	1	1	
18	93WF7-014	Bolt	4	4	
19		Washer	8	8	GB 859 5
20	994343	Roller	1	1	
21	994349	Guide rail	2	2	
22	994347	Guide rail	2	2	
23	93WF1-029	Bolt	4	4	
24	994350	Pin	1	1	
25	994353	Cylinder guide pin	1	1	
26	994233	Spring	1	1	
27		Set screw	1	1	GB/T 77 M10×10
28	93WF7-022	Oil seal, front	1	1	20×30×7
29	93WF7-023	Oil seal, back	1	1	20×47×7
30	994191	Feed adjustment arm	1	1	
31	994192	Pin	1	1	
32	93WF1-027	Set screw	1	1	
33	994193	Spring	1	1	
34	994197	Feed adjusting lever	1	1	
35	93WF7-004	Pin	1	1	
36	994118	Pin	1	1	
37	386WF4-013	Stopper	2	2	
38	36T5-011	Spring	2	2	

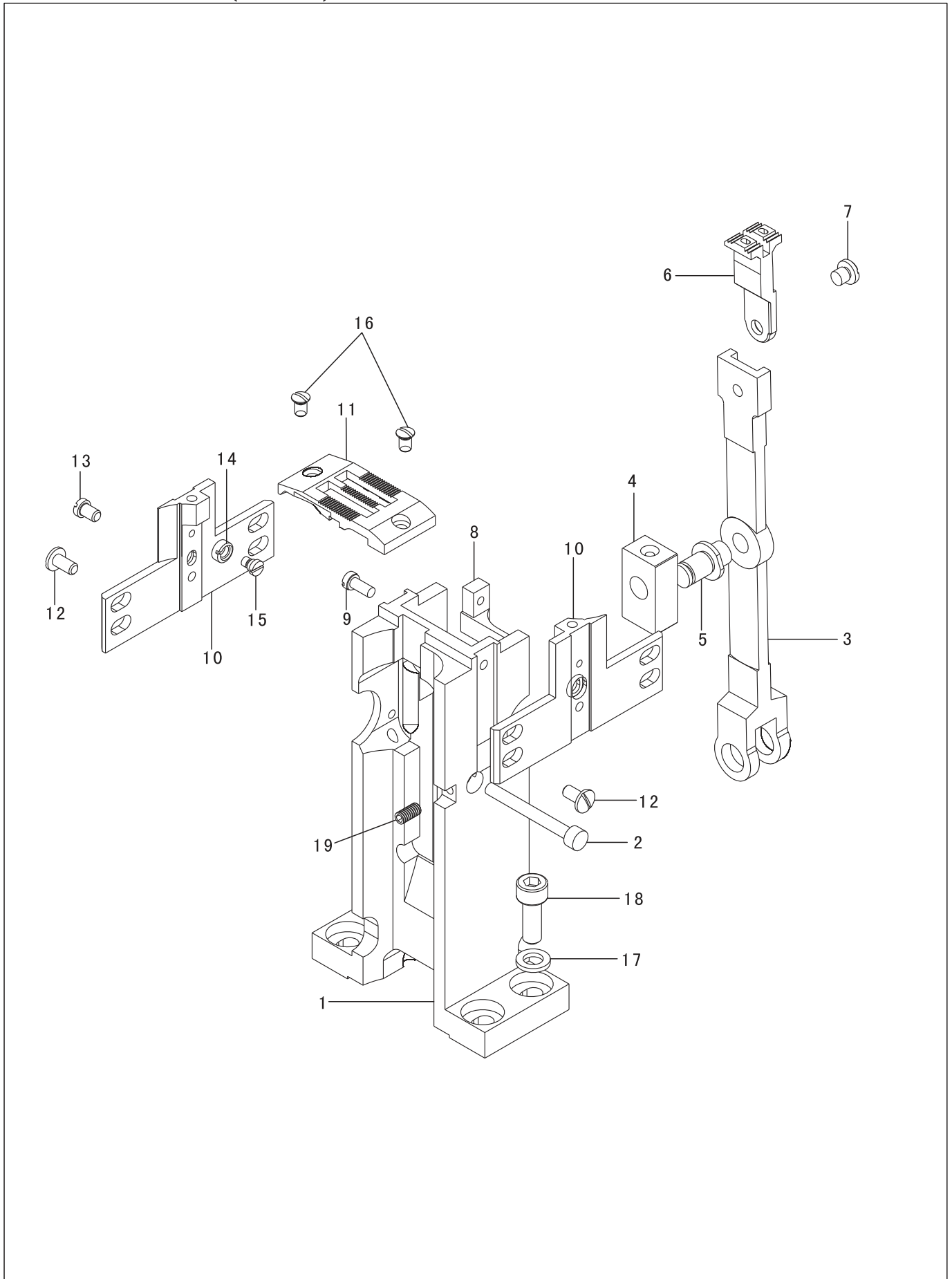
8. Presser foot adjusting mechanism



8. Presser foot adjusting mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	994123	Bushing, adjusting shaft	1	1	
2	93WF5-007	Bushing	1	1	
3	93WF8-001	Dial	1	1	
4	994130	Dial cam	1	1	
5	994131	Dial pin	1	1	
6	93WF8-002	Spring	1	1	
7	302395	Set screw	1	1	
8	994110	Support pin	1	1	
9	93WF5-030	Set screw	1	1	
10	994106	Adjusting bracket	1	1	
11	994112	Adjusting bracket collar	1	1	
12	93WF1-026	Bolt	1	1	
13		Washer, spring	2	2	GB 859 5
14	93WF8-037	Bolt	1	1	
15	994117	Link assy.	2	2	
16	994118	Link pin	2	2	
17	93WF8-015	Set screw	4	4	
18	994102	Inner presser cam	1	1	
19	93WF1-027	Set screw	2	2	
20	994104	Link	1	1	
21	93WF8-018	Needle bearing	1	1	HK3016 30×37×16
22	994116	Link	1	1	
23	994105	Pin	1	1	
24	994086	Connecting crank	1	1	
25	93WF6-042	Bolt	1	1	
26	994087	Pin	1	1	
27	994109	Collar	2	2	
28	93WF7-029	Set screw	2	2	GB/T 80 M5×5
29	994132	Connecting lever assy.	1	1	
30	99413201	Connecting lever	1	1	
31	99413202	Pin	1	1	
32	93WF3-005	Bolt	1	1	
33	994125	Adjusting shaft	1	1	
34	994120	Support plate	1	1	
35	93WF8-031	Bolt	2	2	
36		Washer	2	2	GB 859 4
37	93WF8-003	Support screw	1	1	
38	93WF8-004	Felt	1	1	
39	994133	Spring hook	1	1	
40		Nut	1	1	GB/T 6172 M8
41	117WF8-001	Spring	1	1	

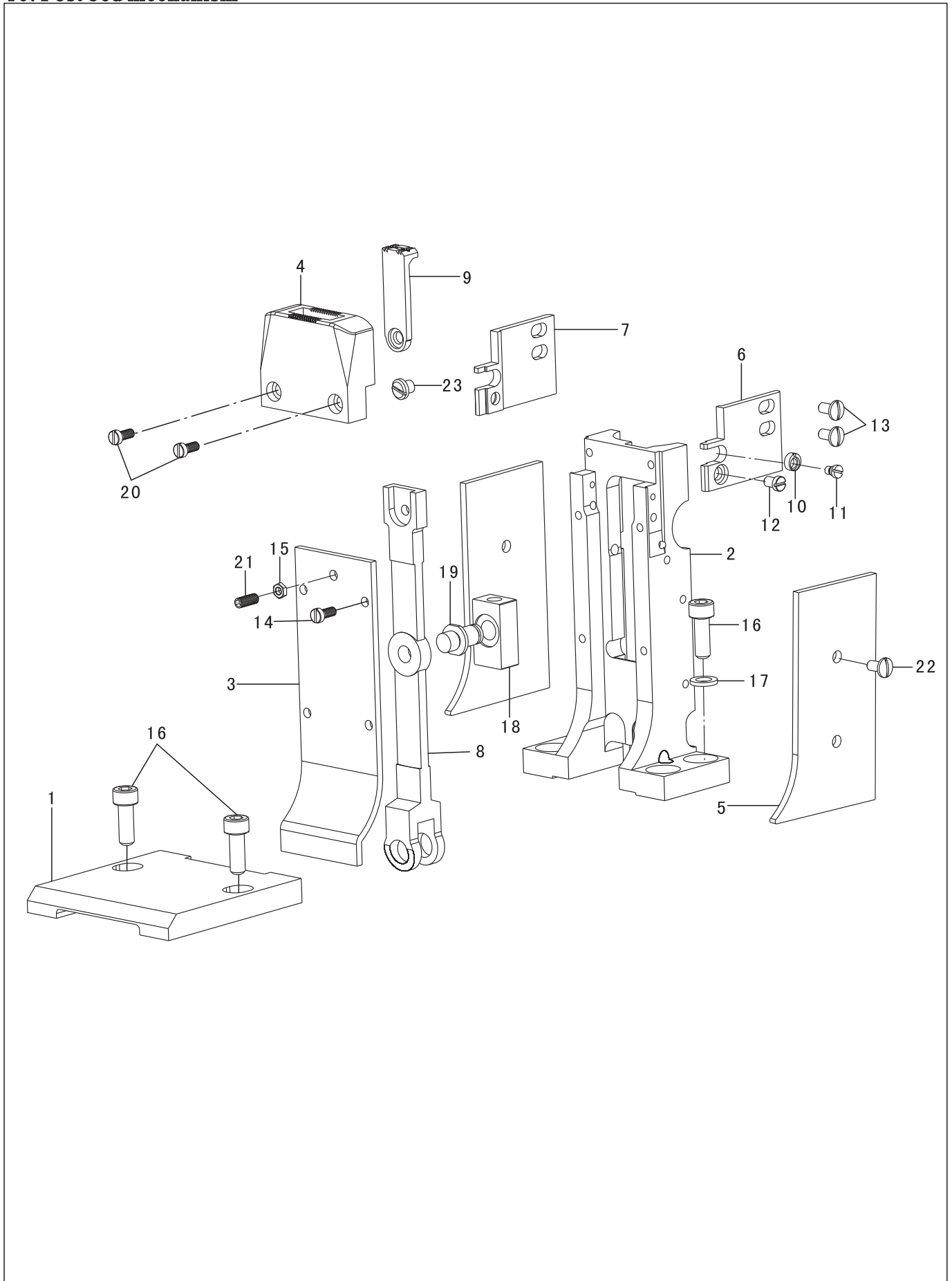
9. Post bed mechanism (2-needle)



9. Post bed mechanism (2-needle)

NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24676-D2T3	
1	386WF2-008	Post bed	1	
2	386WF4-006	Screw	1	
3	386WF4-003	Feed plate	1	
4	386WF4-004	Slide block	1	
5	386WF4-005	Shaft	1	
6	386WF4-001B	Feed dog 8mm	1	
	386WF4-001C	Feed dog 10mm	1	
7	386WF4-002	Screw	1	
8	386WF4-009	Guide plate	1	
9	386WF4-010	Screw	2	
10	386WF2-010B	Support plate 8mm	2	
	386WF2-010C	Support plate 10mm	2	
11	386WF2-006B	Needle plate 8mm	1	
	386WF2-006C	Needle plate 10mm	1	
12	13WF2-040	Screw	8	
13	386WF2-011	Screw	2	
14	240WF2-021B	Eccentric	2	
15	240WF2-021C	Screw	2	
16	386WF2-007	Screw	2	
17	17WF2-010	Washer	4	
18	42WF2-018	Screw	4	
19	123WF3-094	Screw	1	

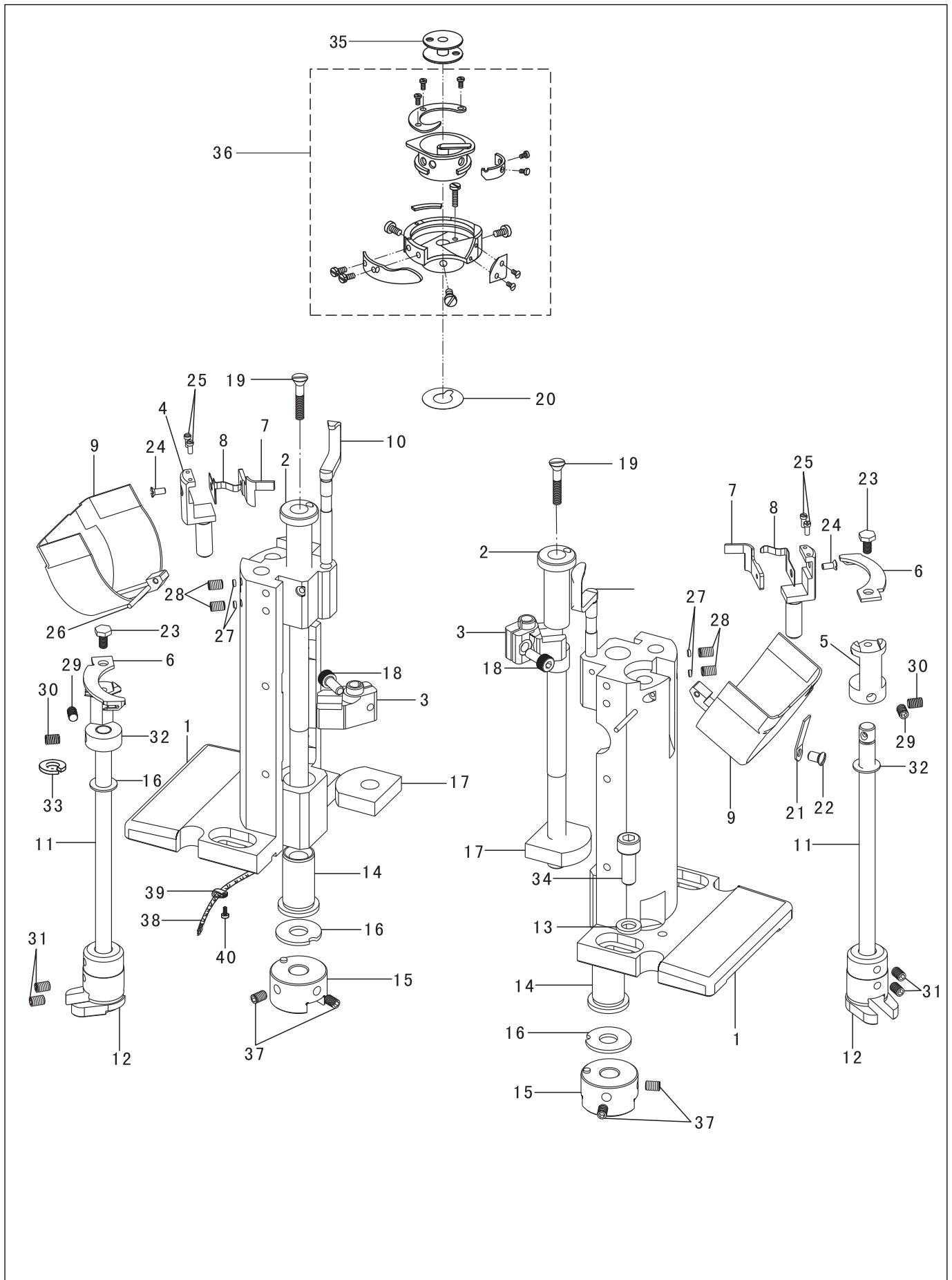
10. Post bed mechanism



10. Post bed mechanism (single needle)

NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24677-D2T3	
1	450WF2-007	Cover	1	
2	450WF2-002	Post bed	2	
3	450WF2-006	Plate	2	
4	450WF2-001	Needle plate	1	
5	450WF2-005	Plate	4	
6	450WF2-003	Support plate(front)	1	
7	450WF2-004	Support plate (back)	1	
8	386WF4-003	Feed plate	1	
9	450WF4-001	Feed dog	2	
10	240WF2-021B	Eccentric	1	
11	340WF2-021C	Screw	1	
12	386WF2-011	Screw	2	
13	13WF2-040	Screw	4	
14	13WF3-018	Screw	4	
15		Nut	1	GB6170 M5
16	42WF2-018	Screw	4	
17	72WF-010	Washer	4	
18	386WF4-004	Slide block	1	
19	386WF4-005	Shaft	1	
20	13WF3-018	Screw	2	
21	89WF5-017	Screw	1	
22	13WF2-040	Screw	4	
23	386WF4-002	Screw	1	

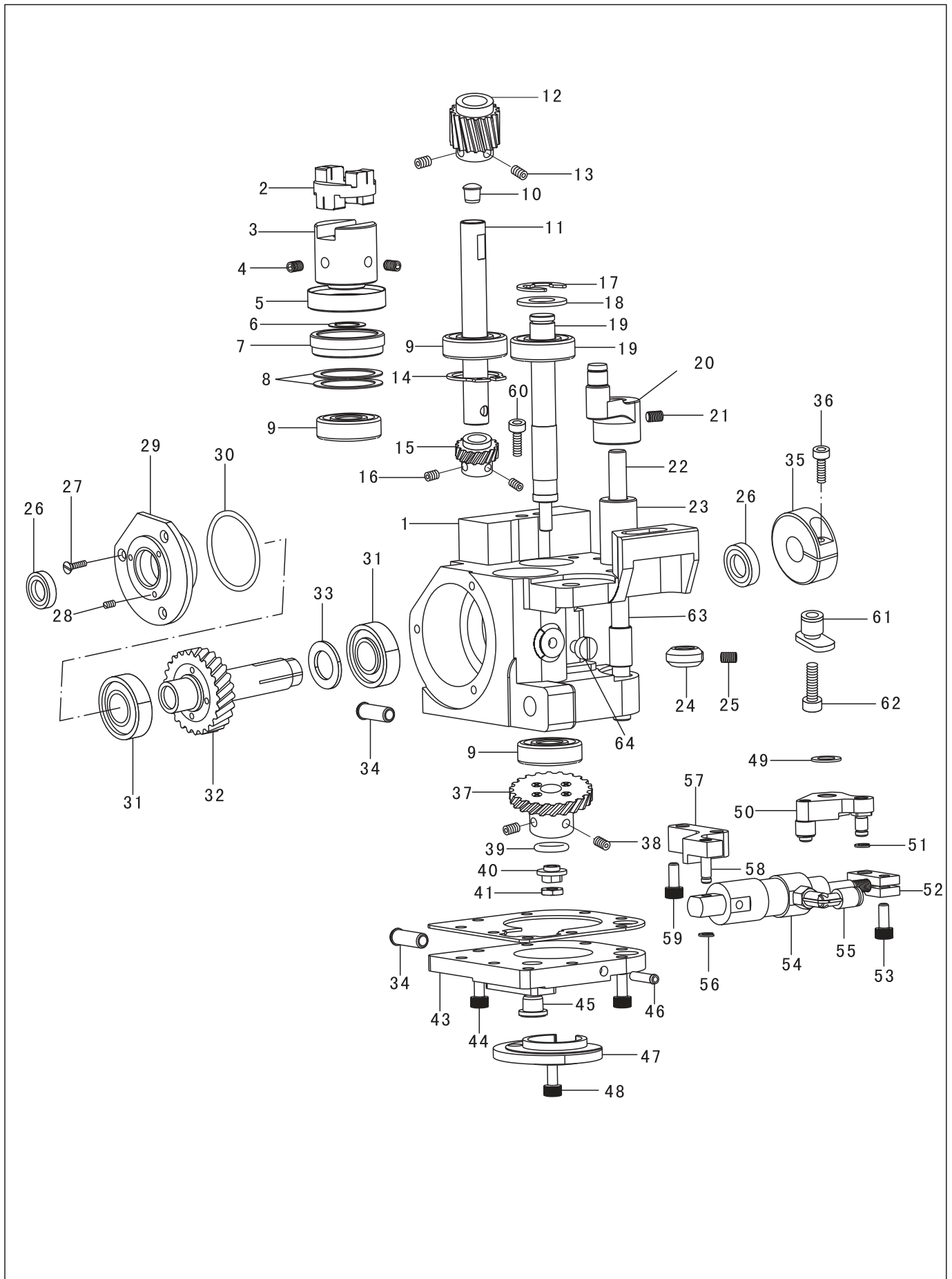
11. Hook mechanism



11. Hook mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	386WF2-002	Hook post saddle	1	2	
2	386WF1-005	Hook shaft	1	2	
3	386WF1-009	Bracket	1	2	
4	386WF3-004	Fixed knife bracket	1	2	
5	386WF3-008	Fixed knife base	1	2	
6	386WF3-006	Movable knife	1	2	
7	386WF3-001	Fixed knife	1	2	
8	386WF3-003	Bobbin thread catch spring	1	2	
9	386WF2-003	Hook cover	1	2	
10	386WF1-008	Opener	1	2	
11	386WF3-011	Trimming shaft	1	2	
12	386WF3-013	Trimming crank	1	2	
13	72WF1-010	Washer	2	4	
14	386WF1-007	Bush	1	2	
15	386WF1-010	Coupling (upper)	1	2	
16	386WF1-024	Washer	1	2	
17	386WF1-006	Oil felt	1	2	
18	89WF2-016	Screw	1	2	
19	386WF1-003	Screw	1	2	
20	386WF1-004	Washer	1	2	
21	386WF2-005	Spring plate	1	2	
22	13WF1-015	Screw	1	2	
23	386WF-007	Screw	1	2	
24	13WF3-031	Screw	1	2	
25	386WF3-002	Screw	2	4	
26	386WF2-004	Pin	1	2	
27	386WF3-005	Washer	2	4	
28	123WF3-003	Screw	2	4	
29	386WF3-009	Screw	1	2	
30	386WF3-010	Screw	1	2	
31	80WF6-036	Screw	2	4	
32	386WF3-012	Washer	1	2	
33		Retaining ring	1	2	GB896 8
34	42WF2-018	Screw	2	4	
35	386WF1-002	Bobbin	1	2	
36	386WF1-001	Hook	1	2	
37	386WF1-011	Screw	2	4	
38	386WF1-012	Oil wick assy.	1	2	
39	1WF6-036	Oil tube clamp	1	2	
40	13WF2-040	Screw	1	2	

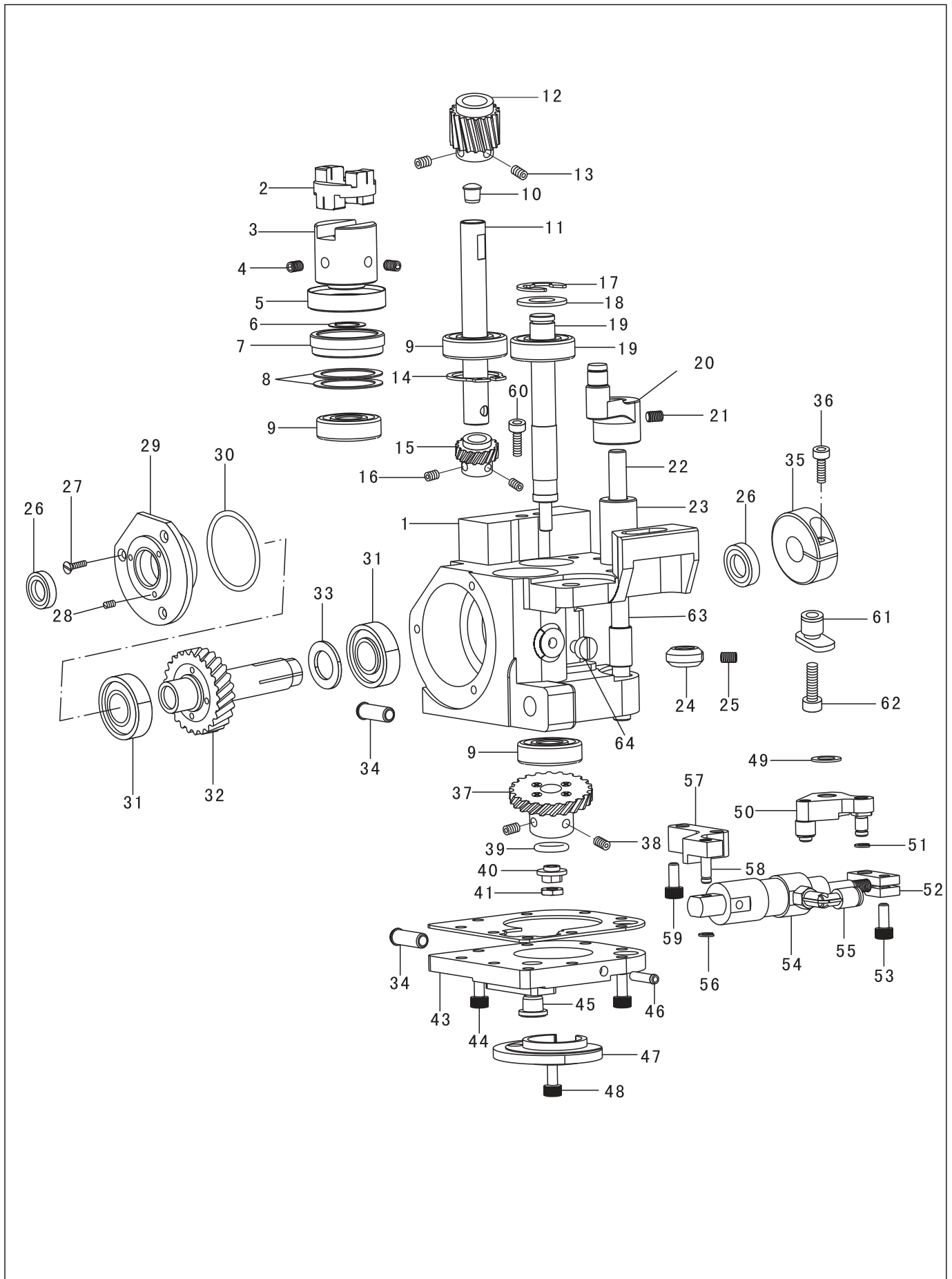
12. Hook gear mechanism (right)



12. Hook gear mechanism (right)

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	386WF2-014	Hook gear saddle	1	1	
2	386WF1-013	Connector	1	1	
3	386WF1-023	Coupling (lower)	1	1	
4	42WF2-010	Screw	2	2	
5	386WF1-022	Cover	1	1	
6	386WF1-021	Washer	1	1	
7	386WF1-020	Base	1	1	
8	386WF1-019	Washer	2	2	
9		Bearing	3	3	Φ10×Φ26×8
10	386WF2-026	Plastic plug	1	1	
11	386WF1-018	Hook shaft	1	1	
12	93WF14-003	Gear	1	1	
13	93WF7-029	Screw	2	2	
14		Retaining ring	1	1	GB893.1 26
15	93WF14-002	Gear	1	1	
16	93WF7-029	Screw	2	2	
17		Retaining ring	1	1	GB896 8
18	386WF3-029	Washer	1	1	
19	386WF3-027	Trimming cam shaft	1	1	
20	386WF3-014	Trimming crank assy.	1	1	
21	123WF3-094	Screw	2	2	
22	386WF3-015	Trimming crank shaft	1	1	
23	386WF3-016	Bush	1	1	
24	386WF3-017	Collar	1	1	
25	80WF6-036	Screw	2	2	
26	93WF14-015	Oil seal	2	2	
27		Screw	3	3	GB/T68 M4×6
28	B1245032	Screw	3	3	
29	386WF1-017	Cover	1	1	
30	93WF14-005	O-ring	1	1	
31		Bearing	2	2	Φ15×Φ32×8
32	93WF14-047	Gear assy.	1	1	
33	93WF14-023	Washer	1	1	
34	386WF2-017	Joint	2	2	
35	93WF14-025	Block	1	1	
36	42WF2-018	Screw	1	1	
37	93WF14-048	Gear assy.	1	1	
38	42WF2-010	Screw	2	2	
39	33T2-030-A	Oil seal	1	1	
40	386WF3-026	Block	1	1	

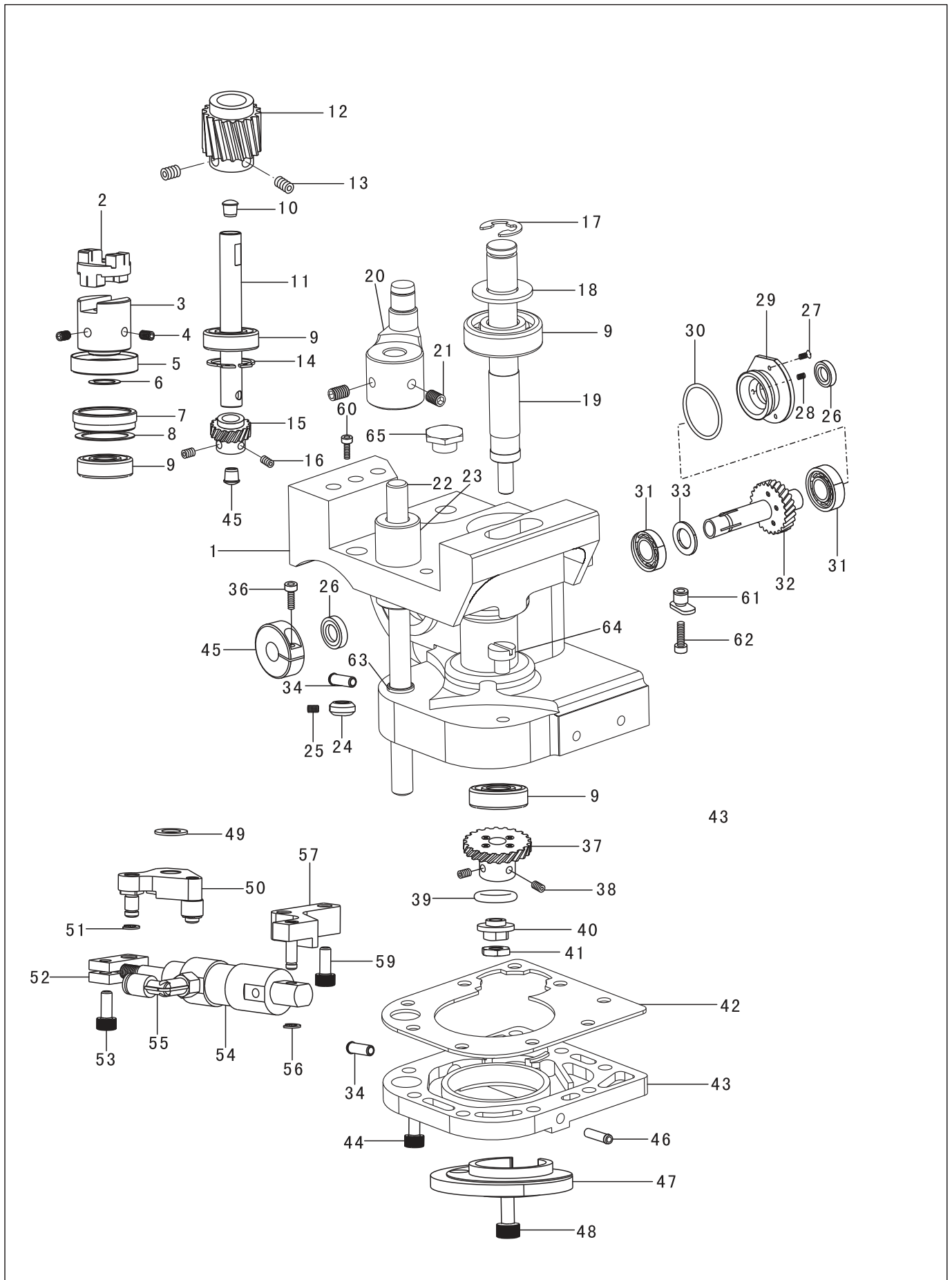
12. Hook gear mechanism (right)



12. Hook gear mechanism (right)

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
41	386WF3-025	Screw	1	1	
42	386WF2-021	Washer	1	1	
43	386WF2-016	Bottom cover	1	1	
44	18WF3-021	Screw	6	6	
45	386WF2-019	Plastic plug	1	1	
46	386WF2-018	Joint	1	1	
47	386WF3-024	Trimming cam	1	1	
48	6K2-019	Screw	3	3	
49	386WF3-012	Washer	1	1	
50	386WF3-020	Crank assy.	1	1	
51		Retaining ring	1	1	
52	386WF3-021	Block	1	1	
53	18WF3-021	Screw	1	1	
54	386WF3-022	Cylinder	1	1	
55	386WF3-030	Joint	1	1	
56		Retaining ring	1	1	
57	386WF3-023B	Bracket	1	1	
58	386WF3-023A	Pin	1	1	
59	6K2-020	Screw	2	2	
60	386WF2-024	Screw	1	1	
61	93WF14-044	Block	1	1	
62	93WF14-043	Screw	1	1	
63	386WF3-018	Bush	1	1	
64	19WF1-010	Screw	1	1	

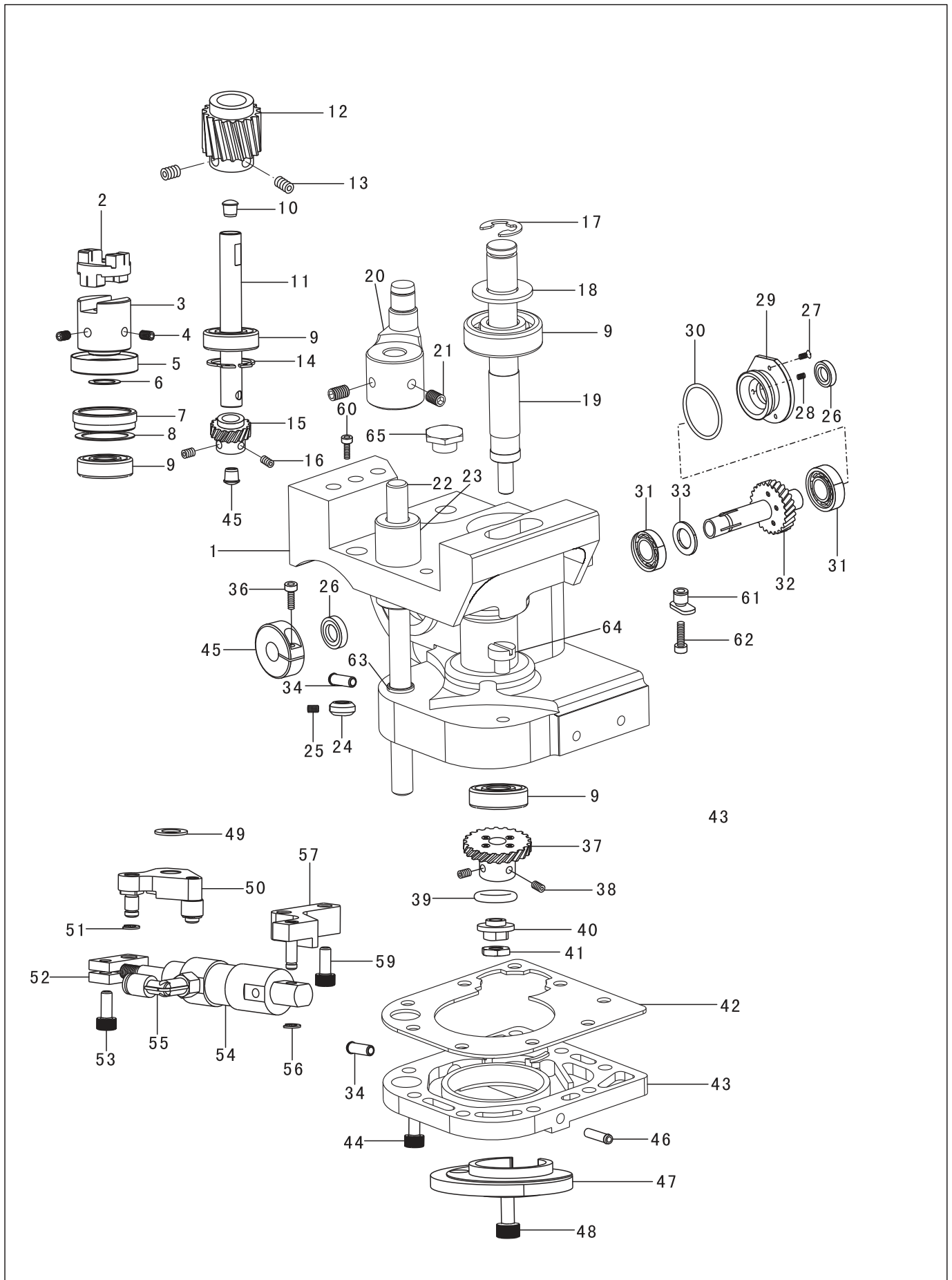
13. Hook gear mechanism (left)



13. Hook gear mechanism (left)

NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24676-D2T3	
1	386WF2-014	Hook gear saddle (left)	1	
2	386WF1-013	Connector	1	
3	386WF1-023	Coupling (lower)	1	
4	42WF2-010	Screw	2	
5	386WF1-022	Cover	1	
6	386WF1-021	Washer	1	
7	386WF1-020	Base	1	
8	386WF1-019	Washer	2	
9		Bearing	3	Φ10×Φ26×8
10	386WF2-026	Plastic plug	1	
11	386WF1-018	Hook shaft	1	
12	93WF14-003	Gear	1	
13	93WF7-029	Screw	2	
14		Retaining ring	1	GB893.1 26
15	93WF14-002	Gear	1	
16	93WF7-029	Screw	2	
17		Retaining ring	1	GB896 8
18	386WF3-029	Washer	1	
19	386WF3-027	Trimming cam shaft	1	
20	386WF3-014	Trimming crank assy.	1	
21	123WF3-094	Screw	2	
22	386WF3-015	Trimming crank shaft	1	
23	386WF3-016	Bush	1	
24	386WF3-017	Collar	1	
25	80WF6-036	Screw	2	
26	93WF14-015	Oil seal	2	
27		Screw	3	GB/T68 M4×6
28	B1245032	Screw	3	
29	386WF1-017	Cover	1	
30	93WF14-005	O-ring	1	
31		Bearing	2	Φ15×Φ32×8
32	93WF14-047	Gear assy.	1	
33	93WF14-023	Washer	1	
34	386WF2-017	Joint	2	
35	93WF14-025	Block	1	
36	42WF2-018	Screw	1	
37	93WF14-048	Gear assy.	1	
38	42WF2-010	Screw	2	
39	33T2-030-A	Oil seal	1	
40	386WF3-026	Block	1	

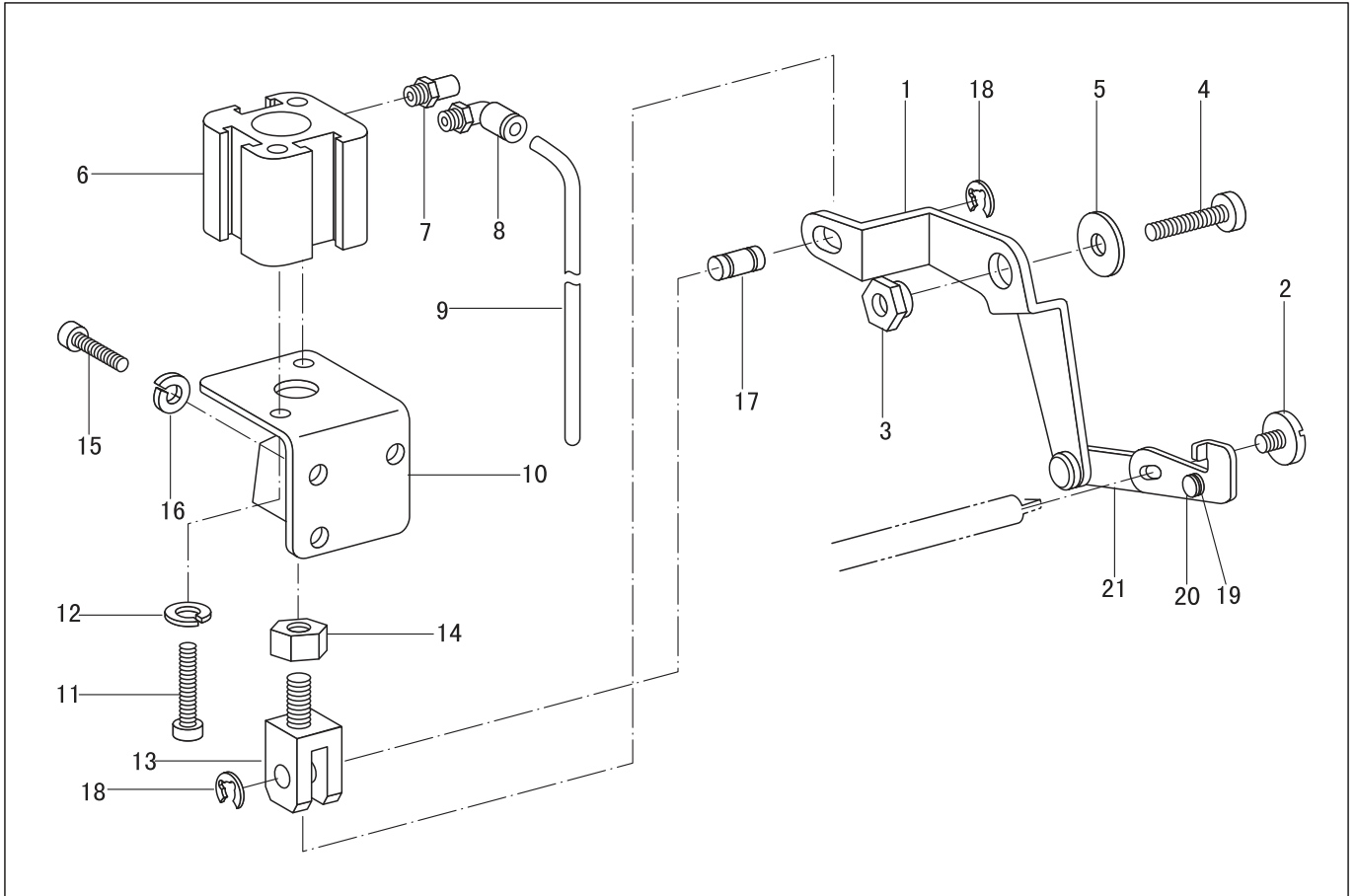
13. Hook gear mechanism (left)



13. Hook gear mechanism (left)

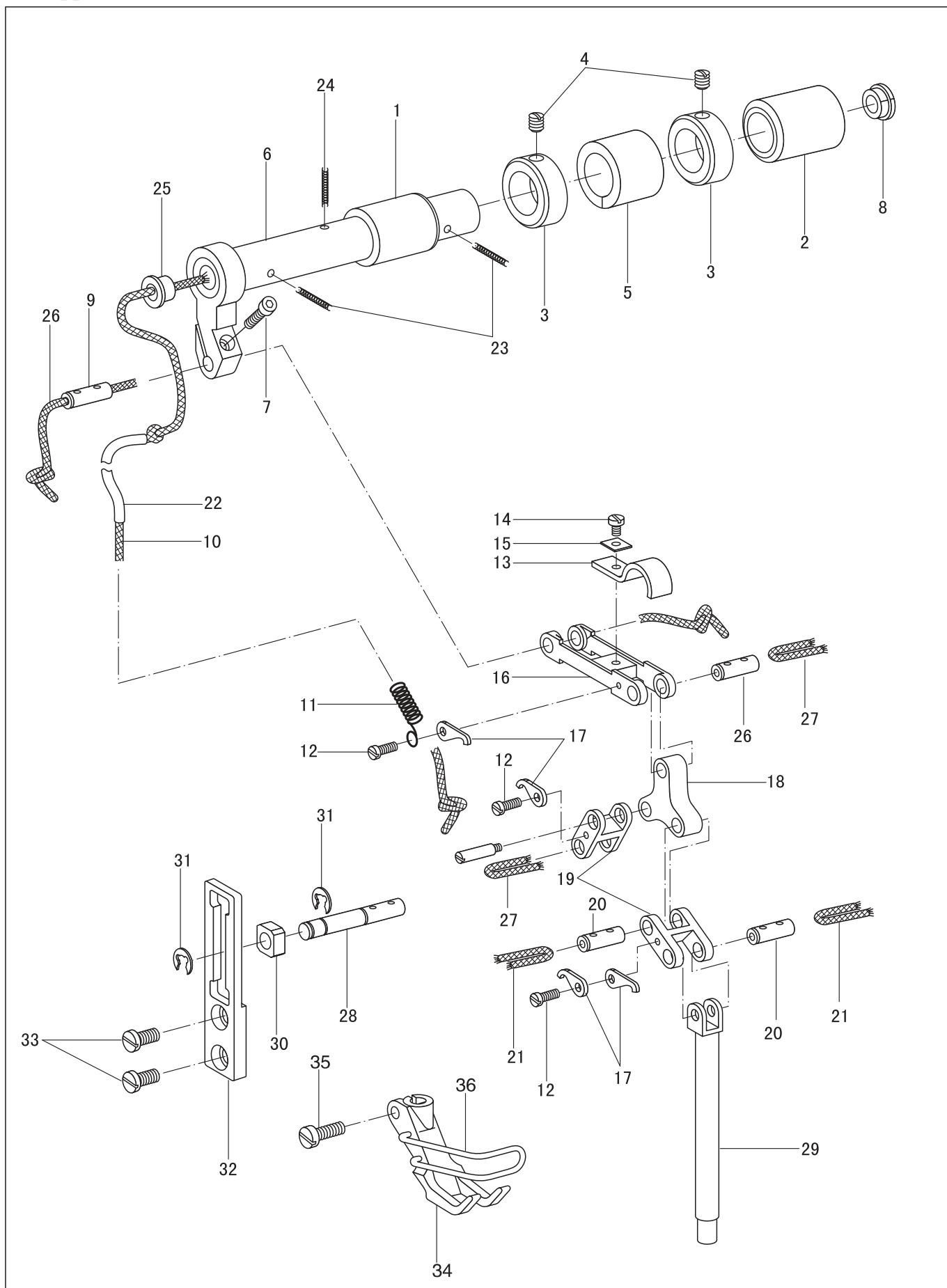
NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24676-D2T3	
41	386WF3-025	Screw	1	
42	386WF2-021	Washer	1	
43	386WF2-016	Bottom cover	1	
44	18WF3-021	Screw	6	
45	386WF2-019	Plastic plug	1	
46	386WF2-018	Joint	1	
47	386WF3-024	Trimming cam	1	
48	6K2-019	Screw	3	
49	386WF3-012	Washer	1	
50	386WF3-020	Crank assy.	1	
51		Retaining ring	1	
52	386WF3-021	Block	1	
53	18WF3-021	Screw	1	
54	386WF3-022	Cylinder	1	
55	386WF3-030	Joint	1	
56		Retaining ring	1	
57	386WF3-023B	Bracket	1	
58	386WF3-023A	Pin	1	
59	6K2-020	Screw	2	
60	386WF2-024	Screw	1	
61	93WF14-044	Block	1	
62	93WF14-043	Screw	1	
63	386WF3-018	Bush	1	
64	19WF1-010	Screw	1	
65	386WF3-023	Screw	1	

14. Quick reverse mechanism



NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	99421001	Cylinder connection assy	1	1	
2	2KT3-005	Screw	1	1	
3	62WF5-025	Stud	1	1	
4	21WF2-048	Screw	1	1	SDA25×15 SU046
5	62WF5-026	Washer	1	1	BSL-M5
6	93WF10-004	Cylinder	1	1	APL4-M5
7	93WF7-009	Silencer	1	1	PU4X2 960
8	93WF7-008	Joint	1	1	
9	214WF-007	Air tube, 4mm	1	1	
10	93WF10-001	Setting plate	1	1	
11	93WF10-006	Bolt	2	2	
12		Washer, spring	2	2	GB859 6
13	994212	Knuckle	1	1	GB/T6172 M6
14		Nut	1	1	
15	93WF7-014	Bolt	3	3	GB/T 859-5
16		Washer, spring	3	3	
17	93WF10-002	Coupling pin	1	1	GB/T 896 4
18		Retaining ring	2	2	
19	62WF5-024D	Nylon washer	2	2	
20	62WF5-024C	Pin	2	2	
21	62WF5-024B	Link rod, reverse stitching lever	1	1	

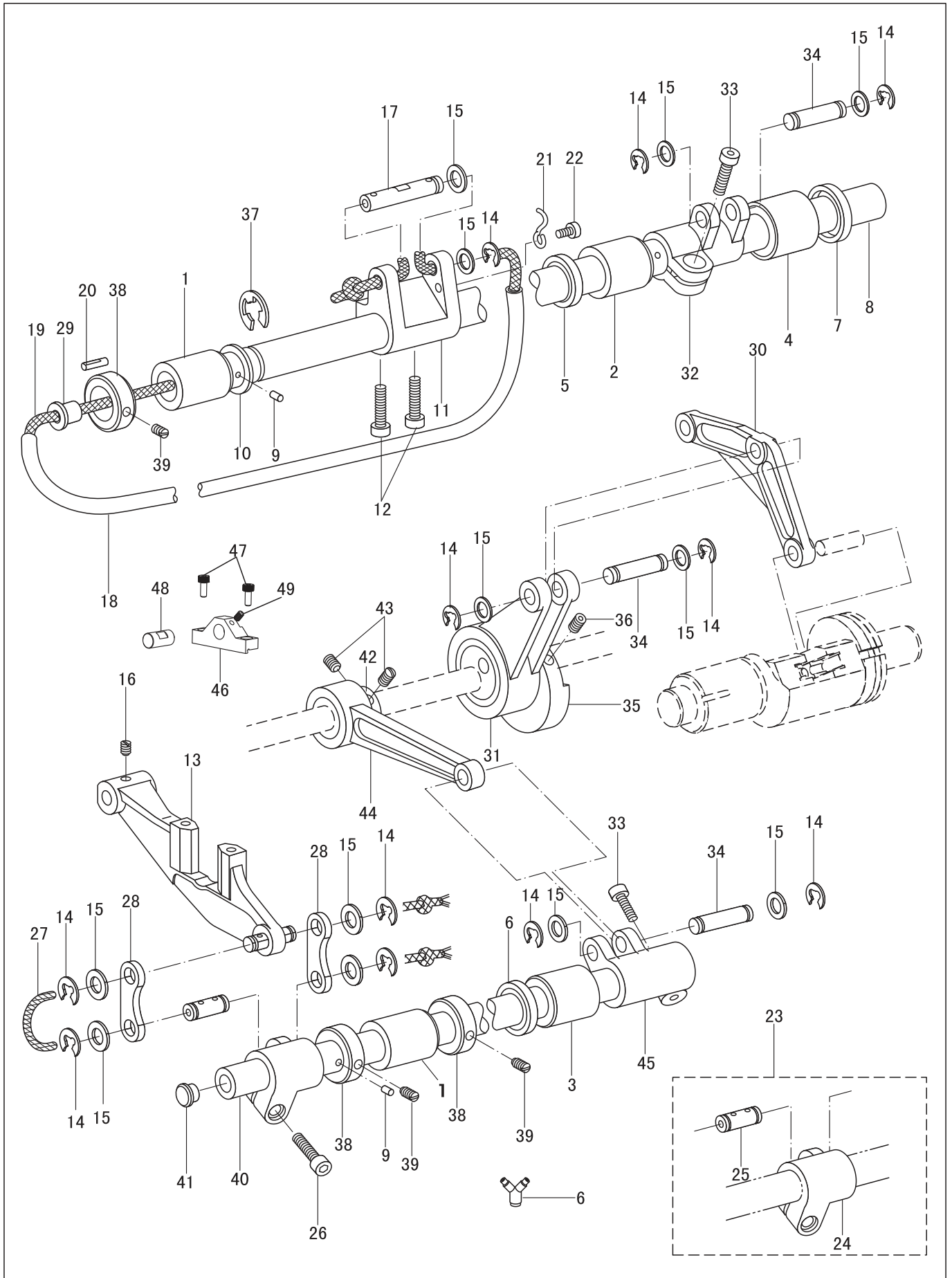
15. Upper feed mechanism



15. Upper feed mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	93WF5-007	Bushing, F	1	1	
2	93WF11-001	Bushing, B	1	1	
3	994109	Collar	2	2	
4	93WF7-029	Set screw	2	2	
5	93WF11-002	Sponge	1	1	
6	994083	Shaft assy.	1	1	
7	93WF8-031	Bolt	1	1	
8	93WF11-003	Rubber cap	1	1	
9	994060	Connecting pin	1	1	
10	994531	Oil wick	1	1	235
11	994071	Tube guide	1	1	
12	93WF11-011	Bolt	3	3	
13	93WF11-004	Leather	1	1	
14	93WF8-036	Bolt	1	1	
15	990486	Washer	1	1	
16	994068	Connection	1	1	
17	93WF11-005	Stopper claw	4	4	
18	994063	Presser connection plate	1	1	
19	994059	Presser bar connection	2	2	
20	994060	Connection pin	3	3	
21		Oil wick	1	1	50
22		Oil tube	1	1	75
23	BS51277	Oil wick	1	1	75
24	BS51803	Felt	1	1	20
25	994082	Rubber cap	1	1	
26	994089	Oil wick	1	1	80
27	994099	Oil wick	1	1	
28	994066	Inner presser bar	1	1	
29	386WF4-012	Presser bar	1	1	
30	994065	Slide block	1	1	
31	93WF11-006	Retaining ring	2	2	
32	994064	Steady plate	1	1	
33	13WF7-015	Screw	2	2	
34	93WF13-005	Presser foot	1	-	
35	93WF13-006	Screw	1	-	
36	93WF13-011	Finger guard	1	-	

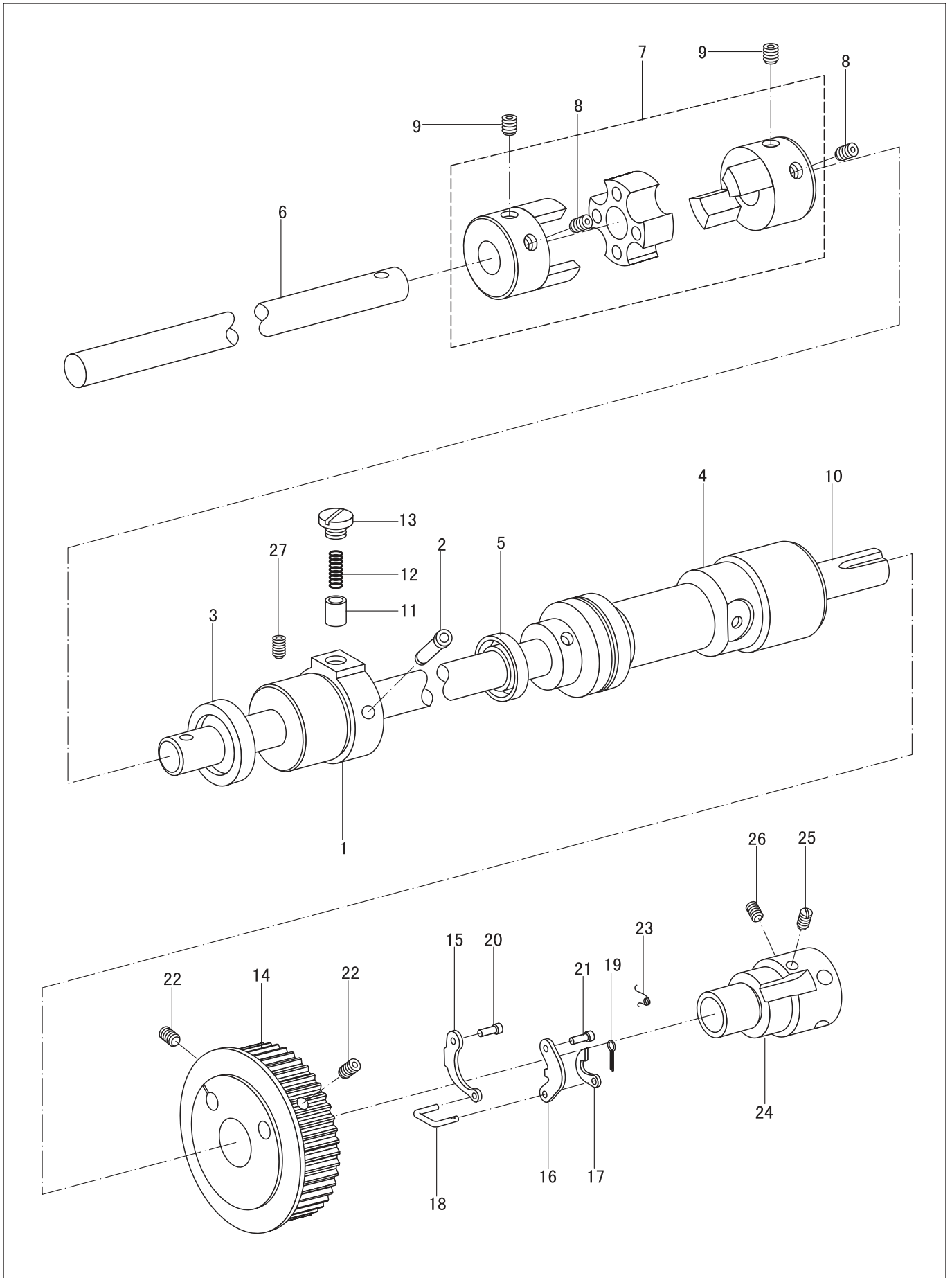
16. Feed shaft mechanism



16. Feed shaft mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	93WF5-007	Feed shaft bushing, F	2	2	
2	93WF12-001	Feed shaft bushing, M	1	1	
3	93WF12-002	Bushing, F	1	1	
4	93WF12-003	Feed shaft bushing	1	1	
5	93WF12-008	Oil seal	1	1	15×24×7
6	1WF6-029	Oil nozzle	-	1	15×24×7
7	93WF12-010	Oil seal	1	1	15×24×7
8	994316	Feed shaft	1	1	
9	BS12718	Felt	2	2	
10	93WF12-004	Ring	1	1	
11	994319	Feed arm	1	1	
12	93WF10-006	Bolt	2	2	GB/T70.1 M6X20
13	994313	Feed bracket assy.	1	1	
14		Retaining ring	11	11	GB896 5
15	93WF12-005	Washer	12	12	
16	93WF12-035	Set screw	1	1	
17	994314	Pin	1	1	
18	994376	Oil tube	1	1	200
19	994315	Oil wick	1	1	300
20	0148-F	Felt	1	1	3×18
21	93WF12-006	Tube holder	1	1	
22		Bolt	1	1	GB/T 70.1 M4×6
23	994320	Feed connection arm assy.	1	1	
24	99432001	Feed connection arm	1	1	
25	99431302	Pin	1	1	
26	93WF12-019	Bolt	1	1	
27	994336	Oil wick	1	1	110
28	994321	Feed link assy.	2	2	
29	994082	Rubber cap	1	1	
30	994346	Back cylinder connection	1	1	
31	994342	Connection rod assy., L-feed	1	1	
32	994318	Feed shaft arm	1	1	
33	93WF7-012	Bolt	2	2	
34	994341	Pin	3	3	
35	994340	Lower feed cam	1	1	
36	93WF1-027	Set screw	2	2	
37	93WF12-007	Retaining ring	1	1	
38	994109	Collar, adjust shaft	3	3	
39	93WF7-029	Set screw	3	3	
40	994322	Adjust-shaft	1	1	
41	93WF11-003	Rubber cap	1	1	
42	211WF3-011	Feed cam	1	1	
43	93WF2-008	Set screw	2	2	
44	994339	Feed rod	1	1	
45	994318	Feed shaft arm	1	1	
46	386WF4-008	Bracket	1	1	
47	18WF3-021	Screw	2	2	
48	386WF4-007	Pin	1	1	
49	123WF3-094	Screw	1	1	

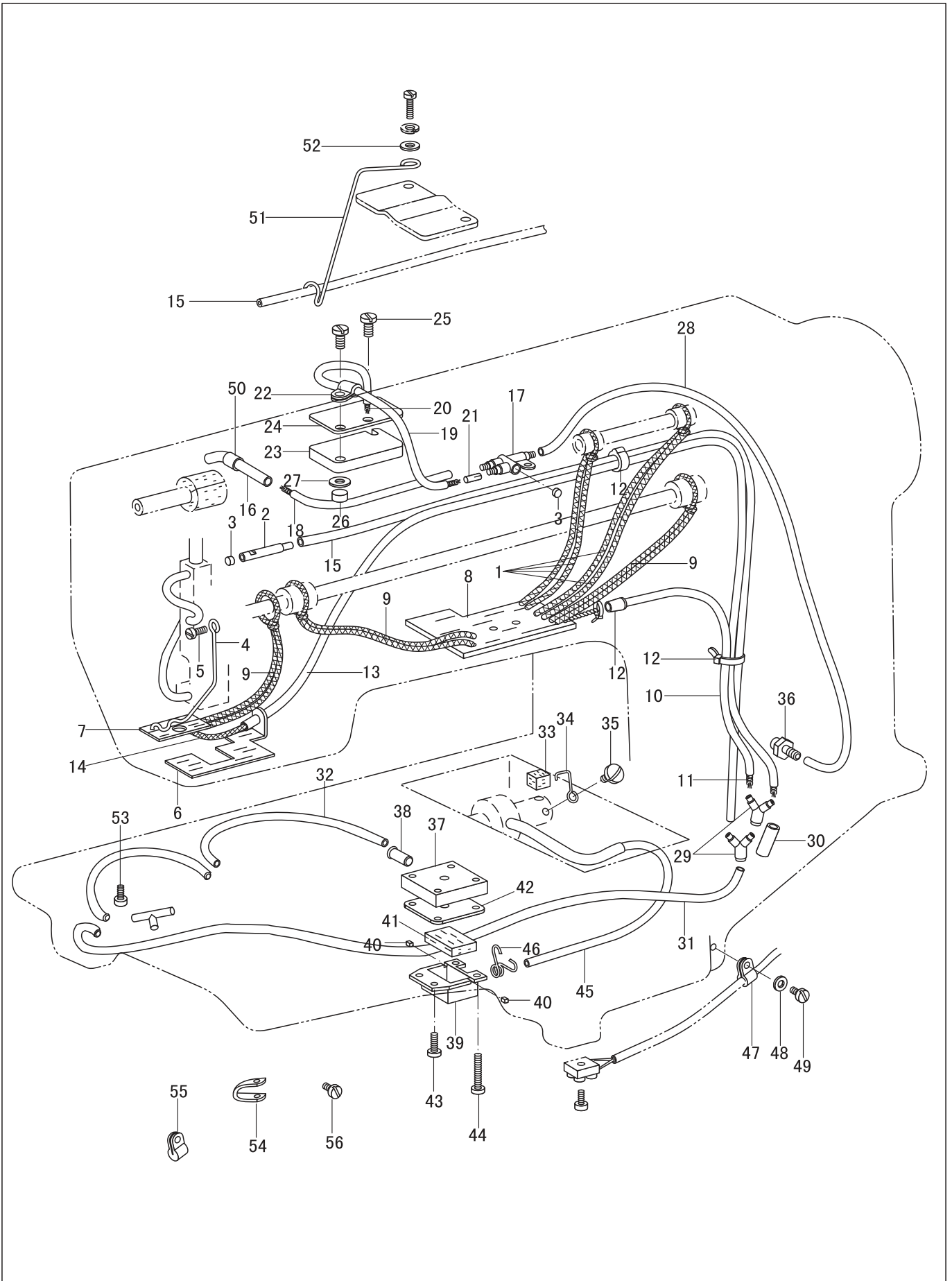
17. Lower shaft mechanism



17. Lower shaft mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24677-D2T3	
1	93WF15-006	Bushing, F; L-shaft	1	1	
2	93WF3-001	Pipe	2	2	
3	93WF15-007	Oil seal	1	1	12×30×7
4	93WF15-008	Bushing, B; L-shaft	1	1	
5	93WF15-009	Oil seal	1	1	12×22×7
6	93WF15-010	Lower shaft	1	1	
7	93WF15-001A	Lower shaft coupling assy	1	1	
	93WF15-001B	Lower shaft coupling, R	1	1	
	93WF15-001C	Lower shaft coupling, L	1	1	
8	93WF15-011	Screw	2	2	
9	93WF15-012	Screw	2	2	
10	93WF15-013	Lower shaft, B	1	1	
11	93WF15-002	Plunge	1	1	
12	93WF15-003	Spring, compression	1	1	
13	93WF15-004	Screw	1	1	
14	93WF15-005	Belt pulley assy, Lower	1	1	
15	22WF1-013	Spring, lock lever	1	1	
16	22WF1-018	Lock lever	1	1	
17	22WF1-016	Rachet	1	1	
18	22WF1-017	Connecting link	1	1	
19		Pin	1	1	GB/T 91 1.2×8
20	22WF1-015	Lock lever shaft	1	1	
21	22WF1-019	Shaft, spring	1	1	
22	93WF8-015	Set screw	2	2	
23	22WF1-014	Spring	1	1	
24	93WF15-015	Bushing	1	1	
25	93WF15-016	Set screw	1	1	
26	93WF15-017	Set screw	1	1	
27	93WF2-015	Set screw	1	1	

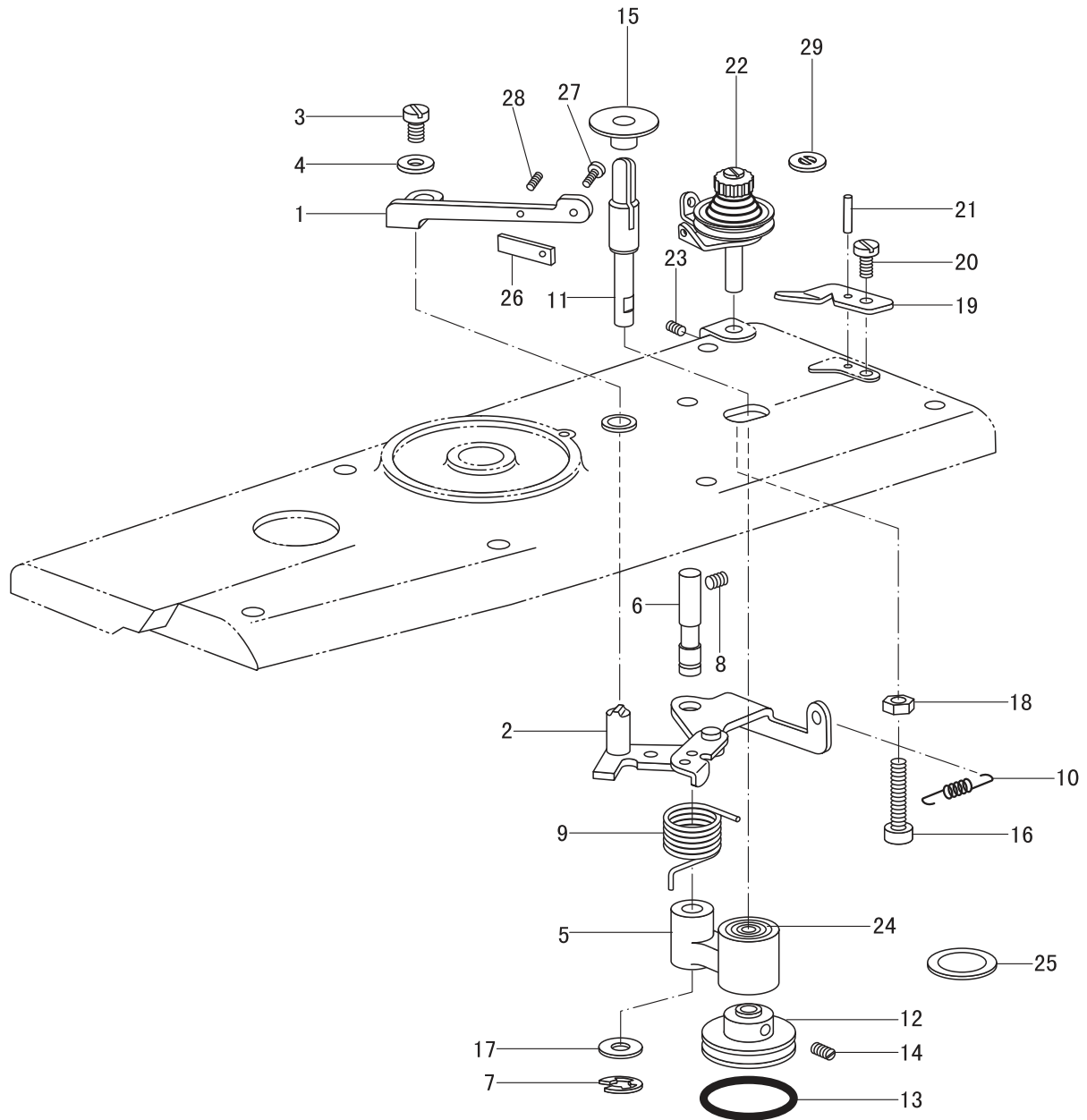
18. Lubrication mechanism



18. Lubrication mechanism

NO.	PARTS NO.	PARTS NAME	QTY		REMARK	
			24677-D2T3	24676-D2T3		
1	994160	Oil wick	2	2	400	
2	994092	Oil tube	1	1		
3	93WF14-006	Rubber cap, 4.2mm	2	2		
4	994091	Oil wick support	1	1		
5	93WF8-037	Bolt	1	1		
6	93WF16-001	Felt	1	1	400	
7	93WF16-002	Felt	1	1		
8	93WF16-003	Felt	1	1		
9	994160	Oil wick	3	3		
10	994100	Oil tube	1	1		200
11		Oil wick	1	1	250	
12		Tube tie	3	3	3×80	
13	994038	Oil tube	1	1	490	
14	994039	Oil wick	1	1	620	
15	994095	Oil tube	1	1	480	
16	93WF16-004	Pipe	1	1	180	
17	21WF7-016	Joint	1	1		
18	994369	Oil tube	1	1		
19	994121	Oil tube	1	1		150
20	994122	Oil wick	1	1		220
21	0148-A	Felt	1	1	3×25	
22	256025	Tube clamp	1	1		
23	93WF16-005	Felt	1	1		
24	994107	Felt support	1	1		
25	13WF7-015	Screw	1	1		
26	93WF16-006	Collar	1	1	GB/T97.1 5 380	
27		Washer	1	1		
28	994094	Oil tube	1	1		
29	93WF16-007	Y-joint	2	2		
30	994380	Oil tube	1	1		40
31	994252	Oil tube	1	1	400	
32	994251	Oil tube	1	1	190	
33	93WF16-008	Sponge	1	1	450	
34	93WF16-009	Sponge support	1	1		
35	999055	Screw	1	1		
36	93WF16-010	Oil feed pipe	1	1		
37	994359	Plate, filter bracket	1	1		
38	93WF1-017	Pipe	2	2	5	
39	93WF16-011	Sub-tank	1	1		
40	93WF16-012	Rubber cap	2	2		
41	93WF16-013	Felt	1	1		
42	93WF16-014	Packing	1	1		
43	33T3-007	Screw	3	3	450	
44	93WF16-015	Screw	2	2		
45	994368	Oil tube	1	1		
46	21WF7-006	Tube clip	1	1		
47	93WF16-016	Cushion clamp	1	1		
48	93WF1-009	Washer	1	1	5	
49	93WF16-025	Screw	1	1		
50	994530	Oil tube	1	1		
51	93WF16-017	Tube support	1	1		
52		Washer	1	1		GB/T 97.1 4
53	37209	Screw	1	1	GB/T65 M5X12	
54	88WF6-001	Clamp	1	1	5	
55	88WF6-003	Clamp	2	2		
56	1WF1-005	Screw	3	3		

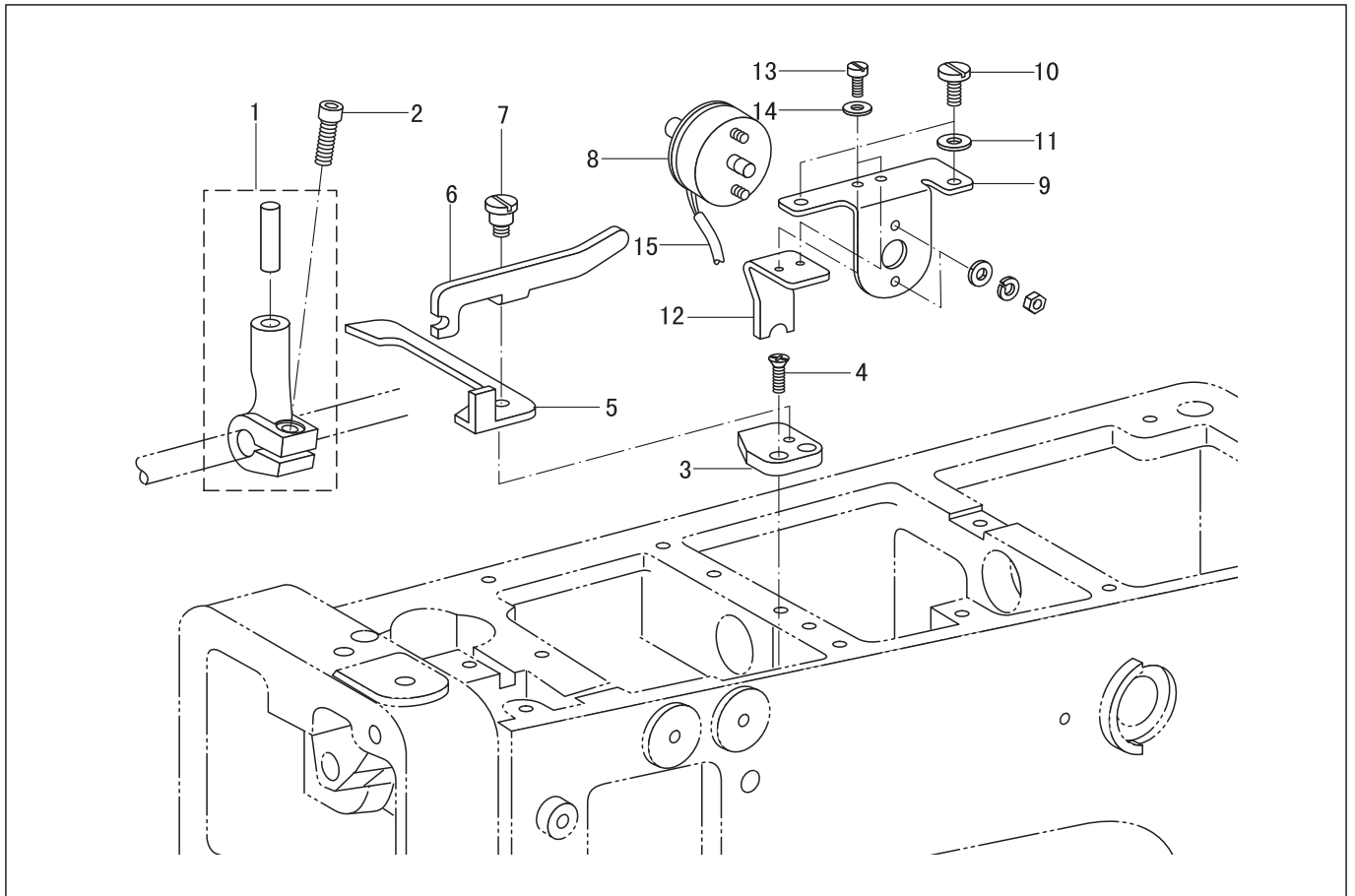
19. Bobbin winder mechanism



19. Bobbin winder mechanism

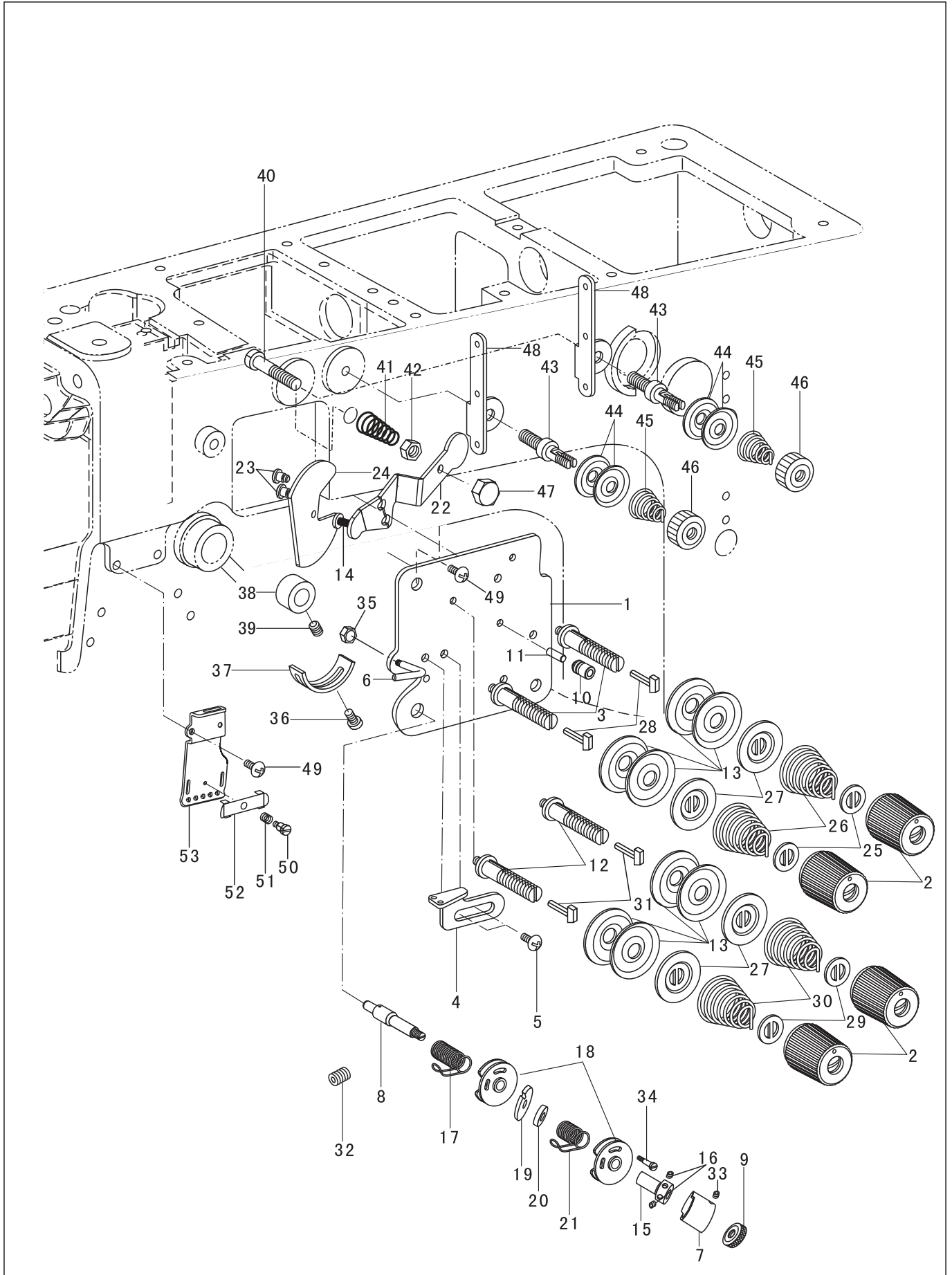
NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	93WF17-001a	Bobbin presser	1	1	
2	89WF5-008	Bobbin presser shaft assy	1	1	
	89WF5-008A	Shaft	1	1	
	89WF5-008B	Joint plate	1	1	
	89WF5-008C	Pin	2	2	
	89WF5-008D	stopper	1	1	
	89WF5-015	Rubber cover	1	1	
3		Screw	1	1	GB/T 818 M4×8
4		Washer	1	1	GB/T 97.1 4
5	93WF17-002	B-winder shaft bracket assy.	1	1	
6	994225	Bobbin winder shaft	1	1	
7	93WF17-003	Retaining ring	1	1	
8	93WF15-012	Set screw	1	1	
9	93WF17-004	Spring	1	1	
10	93WF17-005	Spring	1	1	
11	BS25409	Bobbin winder shaft	1	1	
12	93WF17-006	Bobbin winder sheel	1	1	
13	93WF17-007	Rubber ring	1	1	
14	93WF17-012	Set screw	2	2	
15	93WF17-008	Dust guard plate	1	1	
16	93WF17-013	Bolt	1	1	
17	93WF17-014	Washer	1	1	
18		Nut	1	1	GB/T 41 M5
19	93WF17-009	Knife	1	1	
20	21WF4-047	Screw	1	1	
21		Pin	1	1	GB/T 879.1 2×4
22	BS38376	Bobbin winder tension assy	1	1	
23		Set screw	1	1	GB/T 77 M4×5
24		Bearing	2	2	625-2Z5×16×5
25	89WF5-018	Washer	2	2	
26	88WF8-037	Spring plate	1	1	
27	88WF8-036	Screw	1	1	
28		Screw	1	1	GB/T70.1 M3X8
29	153209	Stopper	1	1	

20. Tension release mechanism



NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	93WF18-003	Thread float lever assy.	1	1	
2	93WF7-010	Bolt	2	2	
3	93WF18-005	Lever setting plate	1	1	
4		Screw	1	1	GB/T 68 M4×12
5	93WF18-007	Thread float lever	1	1	
6	93WF18-008	Thread float plate	1	1	
7	93WF18-001	Shoulder screw	1	1	
8	93WF18-012	Tension release solenoid	1	1	SMT3418SL
9	93WF18-009	Setting plate, solenoid	1	1	
10	13WF2-040	Screw	2	2	
11		Washer	2	2	GB/T 97.1 4
12	93WF18-002	Bracket, solenoid	1	1	
13	93WF1-024	Bolt	2	2	
14		Washer, spring	2	2	GB859 4
15	117WF18-001	Wire	1	1	1000

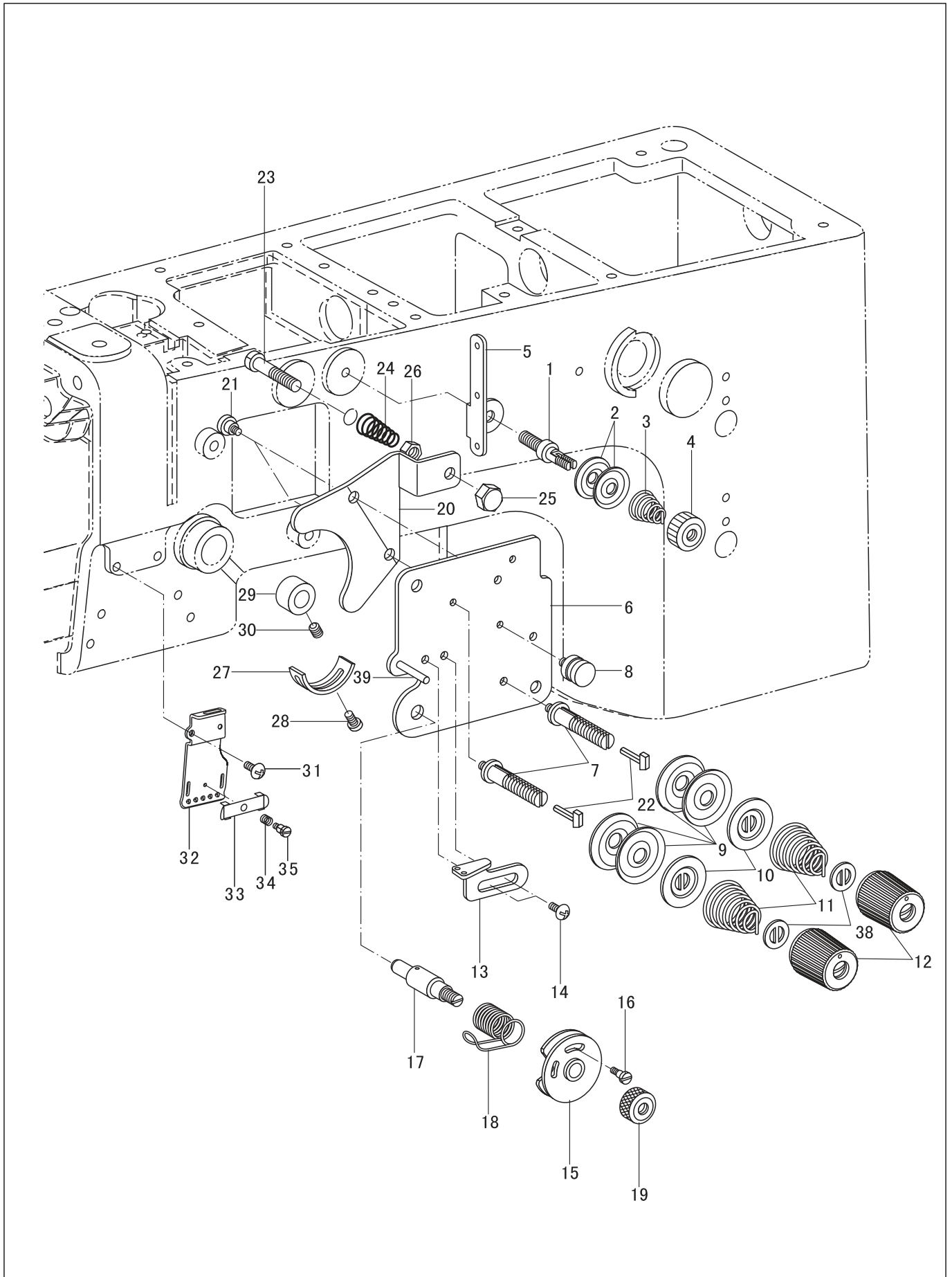
21. Thread tension mechanism(2-needle)



21. Thread tension mechanism(2-needle)

NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24676-D2T3	
1	318WF20-002	Tension fixed plate	1	RAL7015
2	386WF2-027B	Tension nut	4	
3	93WF20-009	Tension stud	2	
4	92WF20-011	Thread guide	1	
5	211WF2-007	Screw	2	
6	386WF2-027A	Pin	1	
7	242422	Spring cover	1	
8	212WF2-003	Shaft	1	
9	037537	Nut	1	
10	318WF20-007	Bush	1	
11	318WF20-004	Shaft	1	
12	193WF20-001	Screw	2	
13	22T1-012F5	Tension disc	8	
14	318WF20-006	Screw	1	
15	93WF20-022	Collar	1	
16		Screw	2	GB/80 M4×5
17	242414	Thread take-up spring	1	
18	103697	Thread tension controller	2	
19	242416	Washer (big)	1	
20	11KT6-039	Washer (small)	1	
21	103692	Thread take up spring	1	
22	318WF20-008	Tension release plate (A)	1	
23	21WF4-029	Screw	2	
24	318WF20-003	Tension release plate (B)	1	
25	153209	Stopper	2	
26	21WF4-031	Spring	2	
27	22T1-012F4	Tension release disc	4	
28	318WF20-009	Pin	2	
29	318WF20-011	Stopper	2	
30	103696	Spring	2	
31	318WF20-010	Pin	2	
32	242421	Collar	1	
33	661106	Screw	3	
34	576465	Screw	1	
35		Nut	1	
36	21WF4-015	Screw	1	GB/T80 M4×5
37	103693	Stopper	1	
38	994140	Collar	1	
39		Screw	1	
40	994146	Screw	1	
41	93WF20-001	Spring	1	GB/T6170 M4
42		Nut	1	
43	994137	Screw	2	
44	22T1-009E3	Tension disc	4	
45	13WF2-009	Spring	2	
46	36T2-006D4	Nut	2	GB/T818 M4X8
47	93WF20-002	Nut	1	
48	994136	Thread guide	2	
49		Screw	3	
50	93WF20-005	Screw	1	
51	1WF1-028	Spring	1	
52	93WF20-004	Tension plate	1	
53		Thread guide	1	

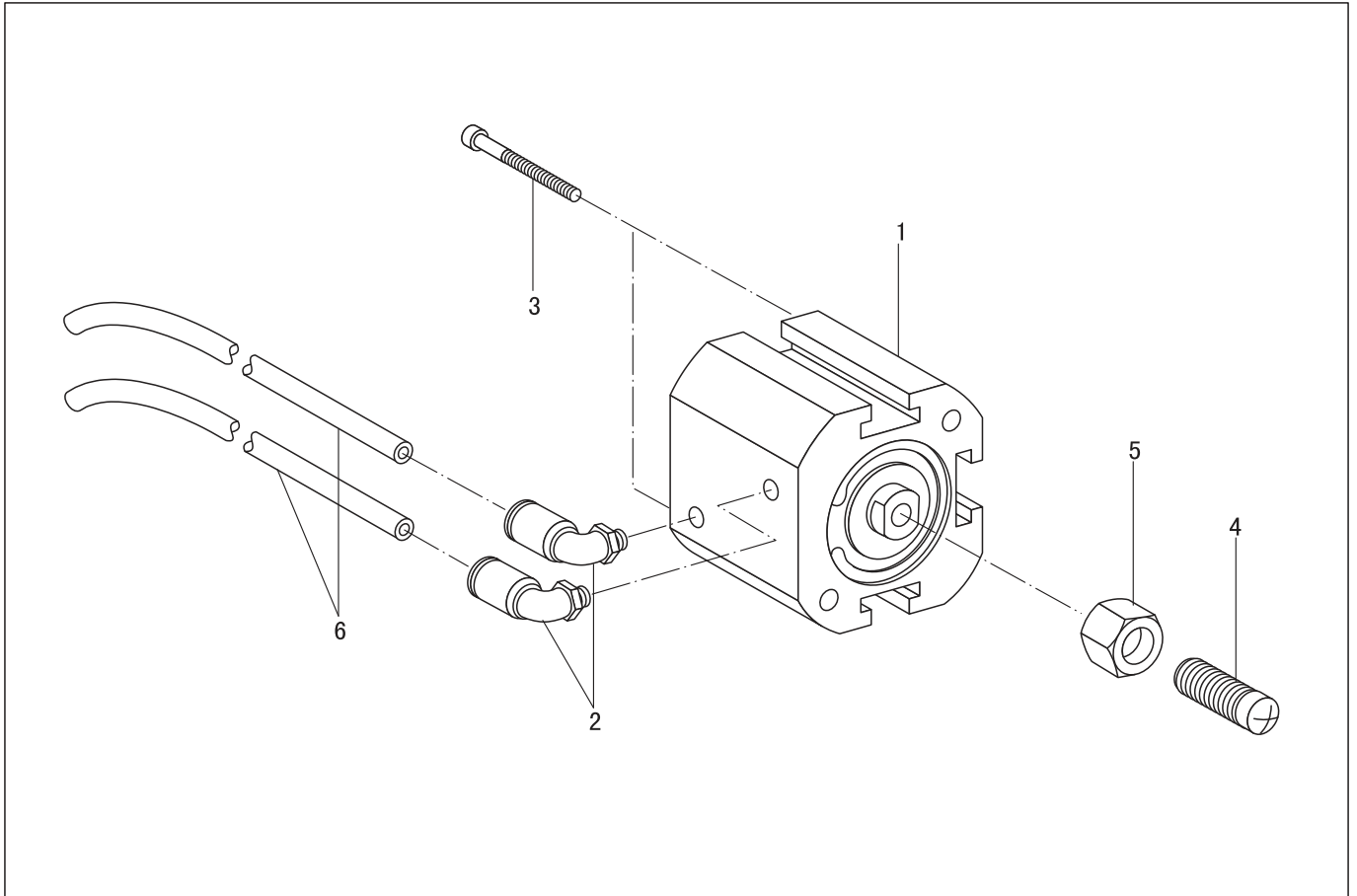
22. Thread tension mechanism (1-needle)



22. Thread tension mechanism (1-needle)

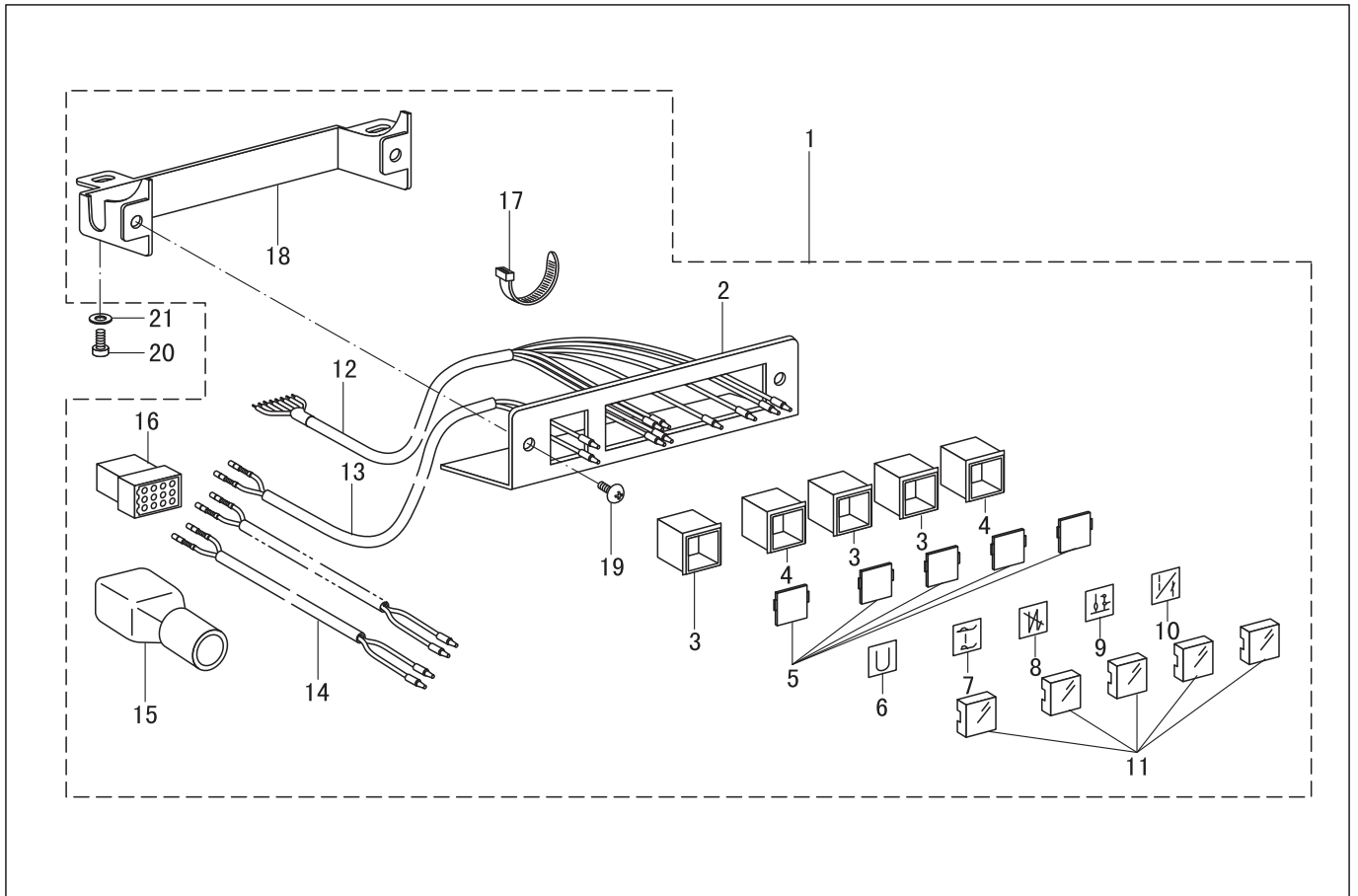
NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24677-D2T3	
1	93WF20-006	Tension adjusting stud	1	
2	22T1-009E3	Tension disc	2	
3	13WF2-009	Tension spring	1	
4	36T2-006D4	Nut	1	
5	93WF20-007	Thread guide	1	
6	93WF20-008	Tension plate assy.	1	
7	93WF20-009	Screw	2	
8	93WF20-010	Tension guider	1	
9	22T1-012F5	Tension disc	4	
10	22T1-012F4	Disc presser, tension	2	
11	21WF4-031	Tension spring	2	
12	21WF4-030	Tension nut	2	
13	93WF20-011	Thread retainer	1	
14		Screw	2	GB818 M4×5
15	103697	Thread tension controller	1	
16	9WF1-003C	Screw	1	GB/T 818 M4×5
17	037515	Screw	1	
18	103692	Thread take-up spring	1	
19	037537	Tension nut	1	
20	93WF20-017	Tension release plate	1	
21	21WF4-029	Shoulder screw	2	
22	93WF20-018	Shoulder pin, tension release	2	
23	93WF20-019	Pusher pin, tension release	1	
24	93WF20-001	Spring	1	
25	93WF20-002	Nut, cap	1	
26		Nut	1	GB/T 6170 M4
27	103693	Stopper	1	
28	21WF4-015	Screw	1	
29	93WF20-022	Collar, tension stud	1	
30		Set screw	1	GB/T 80 M4×5
31	200WF20-002	Screw	3	
32	93WF20-003	Thread guide	1	
33	93WF20-025	Thread hook	1	
34	93WF20-004	Thread clamp	1	
35	1WF1-028	Spring, compression	1	
36	93WF20-005	Shoulder screw	1	
37		Screw	2	GB/T 68 M5×8
38	153209	Stopper	2	
39	93WF20-028	Pin, opener	1	

23. Air presser lifter mechanism



NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	224676-D2T3	
1	93WF23-001	Cylinder	1	1	SU239 32×20
2	93WF23-002	Joint	2	2	APL6-01
3		Screw	2	2	GB/T 70.1 M5×45
4	93WF23-004	Screw	1	1	
5		Nut	1	1	GB/T 6172.1 M8
6	214WF-008	Air tube	2	2	PU 6X4 950mm

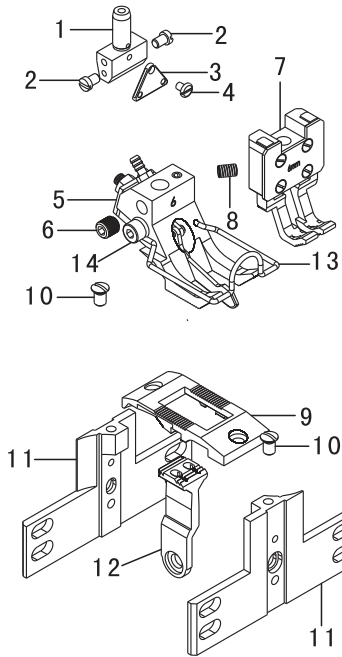
24. Manual switch mechanism



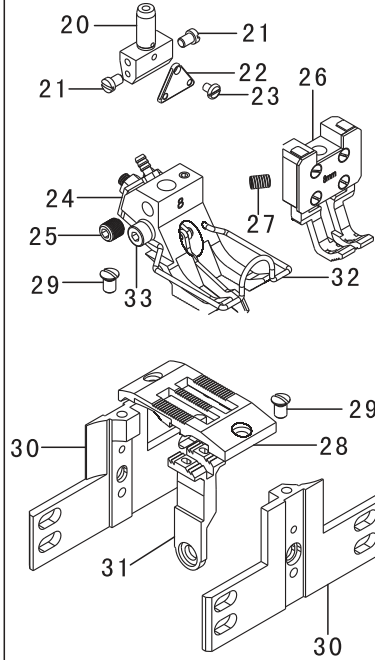
NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24677-D2T3	
1	365WF4-001	Switch assy.	1	360WF7-001 (24676-D2T3)
2	93WF21-002	Switch setting plate	1	
3	93WF21-003	Switch	3	
4	93WF21-004	Switch	2	
5	93WF21-005	Lens	5	
6	93WF21-006	Push button mark	1	
7	93WF21-007	Push button mark	1	
8	93WF21-008	Push button mark	1	
9	93WF21-009	Push button mark	1	
10	93WF21-010	Push button mark	1	
11	93WF21-011	Push button	5	
12	93WF21-012	Wire assy.	1	
13	365WF4-002	Wire assy.	1	
14	365WF4-003	Wire assy.	1	
15	129WF6-016b	Cover	1	
16		Connector	1	5557-16P
17		Clamp	1	
18	93WF21-020	Plate	1	
19		Screw	2	GB/T 818 M4×5
20		Screw	2	GB/T 70.1 M4×6
21		Washer	2	GB/T 97.1 4

25. Needle plate, presser foot components (2-needle)

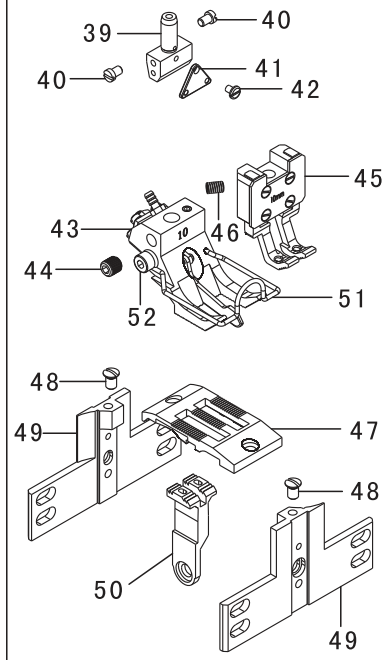
Gauge sets (with central guider) 6MM



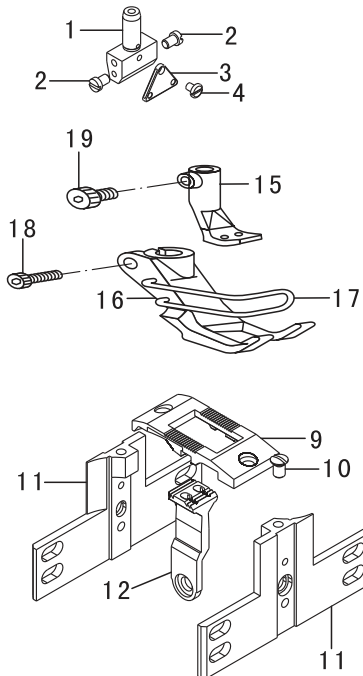
Gauge sets (with central guider) 8MM



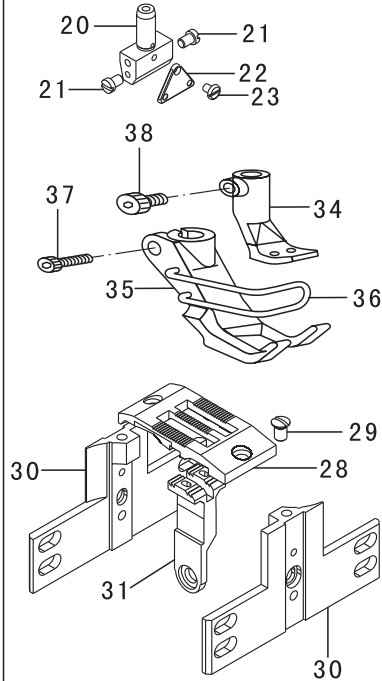
Gauge sets (with central guider) 10MM



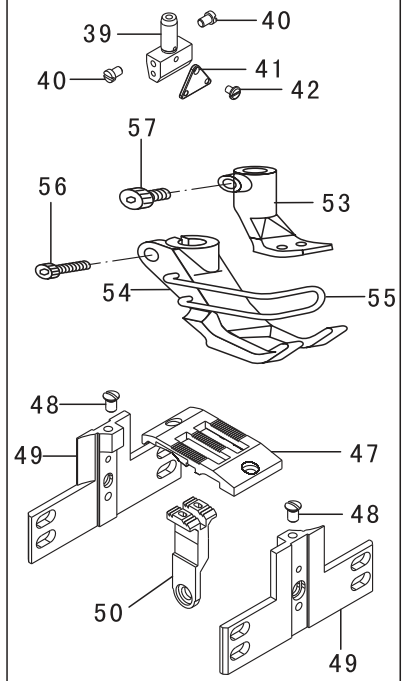
Standard gauge sets 6MM



Standard gauge sets 8MM



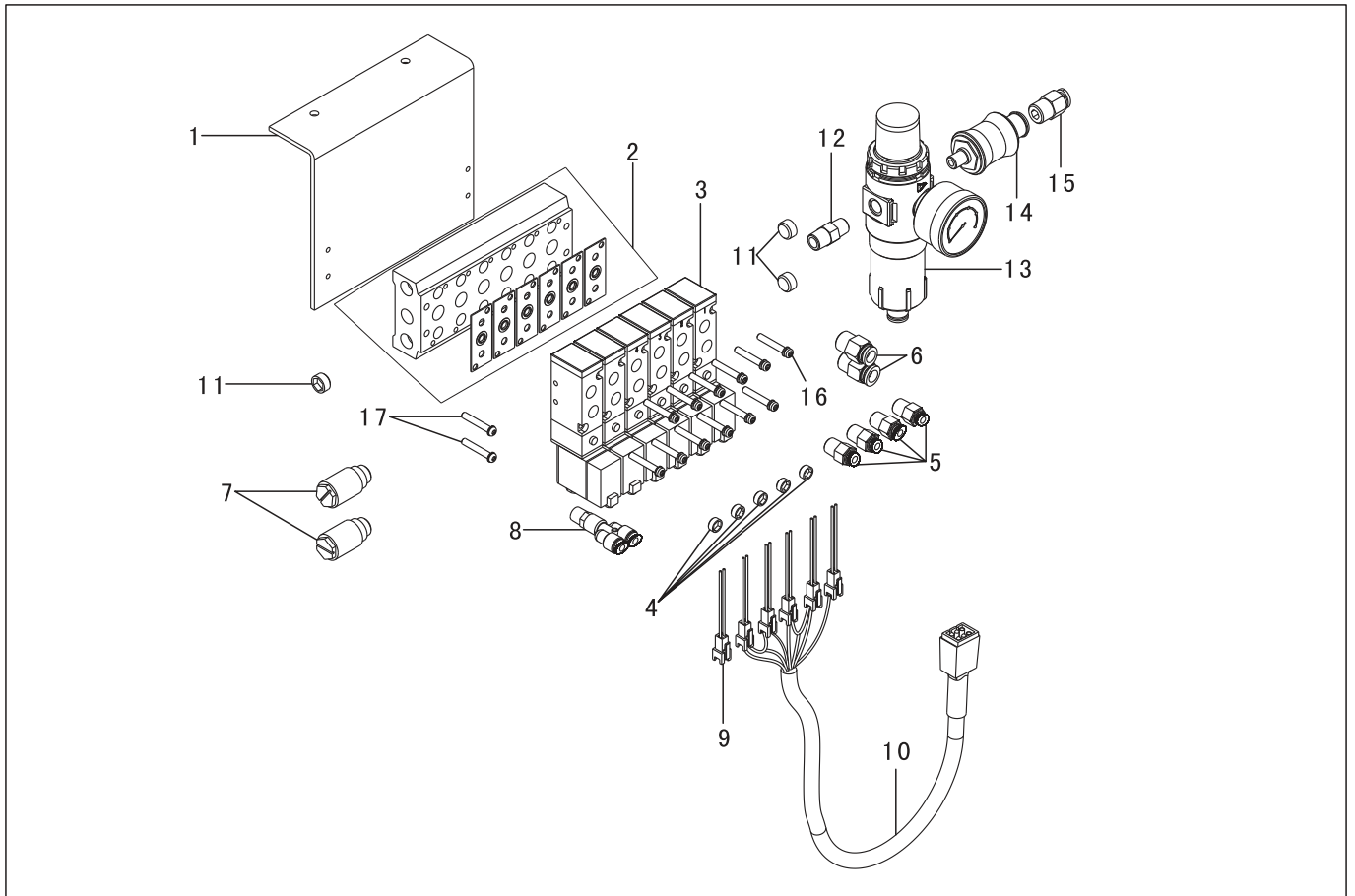
Standard gauge sets 10MM



25. Needle plate, presser foot components (2-needle)

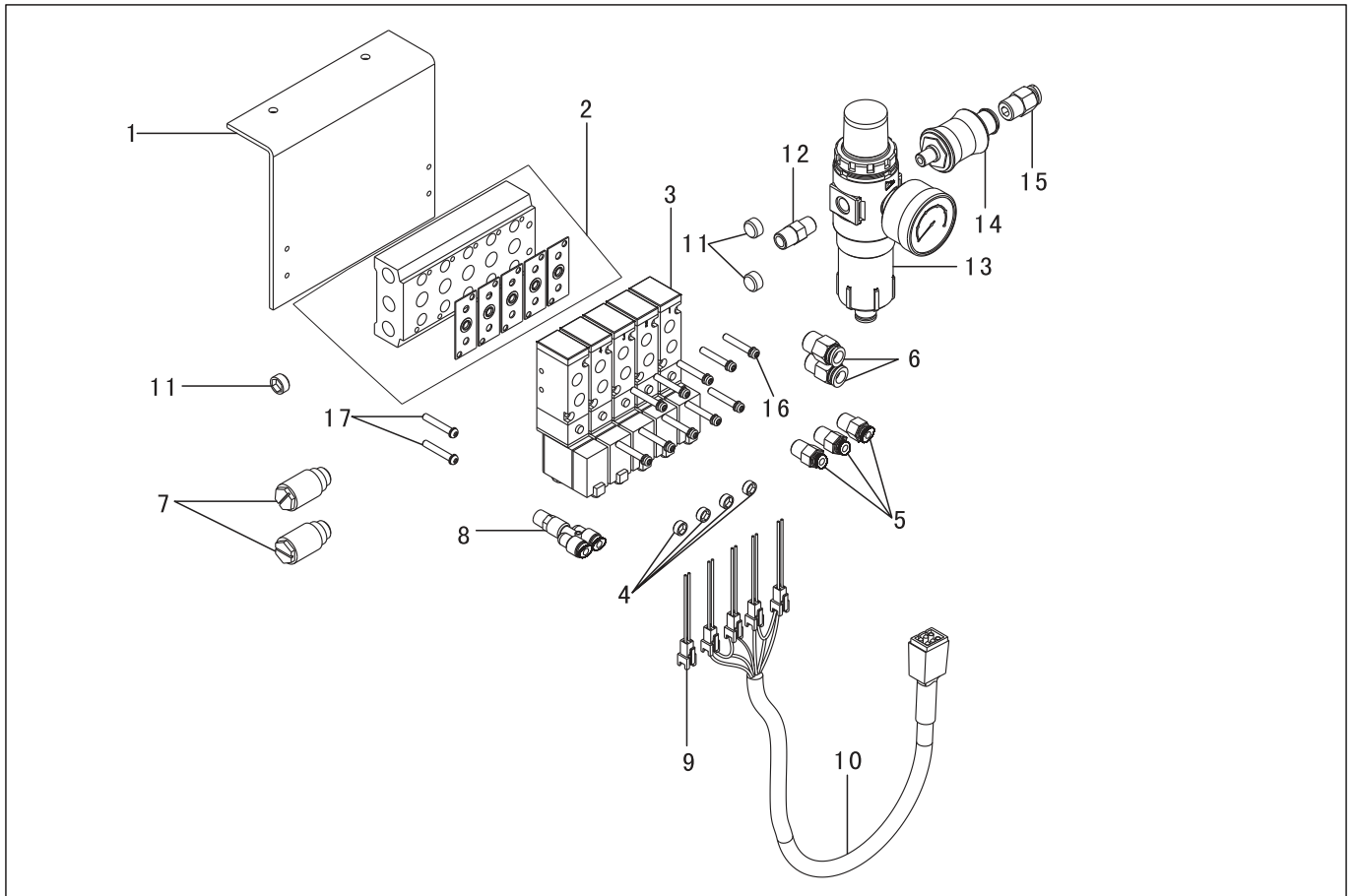
NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24676-D2T3	
1	193WF13-001c	Needle clamp	1	
2	17WF2-037	Screw	2	
3	193WF5-002a	Thread guide	1	
4	16WF1-006	Screw	1	
5	386WF5-005	Presser foot with guider	1	
6	57WF-009	Screw	1	
7	386WF4-021	Compensative foot	1	
8	123WF3-094	Screw	1	
9	386WF2-006D	Needle plate	1	
10	386WF2-007	Screw	2	
11	386WF2-010A	Support plate	2	
12	386WF4-001D	Feed dog	1	
13	218WF13-009	Finger guard	1	
14	13WF2-040	Screw	1	
15	193WF13-001c	Walking foot(6mm)	1	
16	193WF13-002b	Presser foot (6mm)	1	
17	193WF13-006a	Finger guard	1	
18	93WF13-006	Screw	1	
19	93WF13-004	Screw	1	
20	193WF5-001d	Needle clamp	1	
21	17WF2-037	Screw	2	
22	193WF5-002a	Thread guide	1	
23	16WF1-006	Screw	1	
24	218WF13-007	Presser foot with guider	1	
25	57WF-009	Screw	1	
26	218WF13-006	Compensative foot	1	
27	123wf4-021	Screw	1	
28	386WF2-006B	Needle plate	1	
29	386WF2-007	Screw	2	
30	386WF2-010B	Support plate	2	
31	386WF4-001B	Feed dog	1	
32	218WF13-010	Finger guard	1	
33	13WF2-040	Screw	1	
34	193WF13-001d	Walking foot(8mm)	1	
35	193wf13-002c	Presser foot (8mm)	1	
36	193WF13-006b	Finger guard	1	
37	93WF13-006	Screw	1	
38	93WF13-004	Screw	1	
39	193WF5-001e	Needle clamp	1	
40	17WF2-037	Screw	2	
41	193WF5-002b	Thread guide	1	
42	16WF1-006	Screw	1	
43	28WF13-005	Presser foot with guider	1	
44	57WF-009	Screw	1	
45	218WF13-004	Compensative foot	1	
46	123WF3-094	Screw	1	
47	386WF2-006c	Needle plate	1	
48	386WF2-007	Screw	2	
49	386WF2-010c	Support plate	2	
50	386WF4-001c	Feed dog	1	
51	218WF13-011	Finger guard	1	
52	13WF2-040	Screw	1	
53	193WF13-002c	Walking foot (10mm)	1	
54	193WF13-002c	Presser foot (10mm)	1	
55	193WF13-006b	Finger guard	1	
56	93WF13-006	Screw	1	
57	93WF13-004	Screw	1	

26. Air presser mechanism (with central guider)



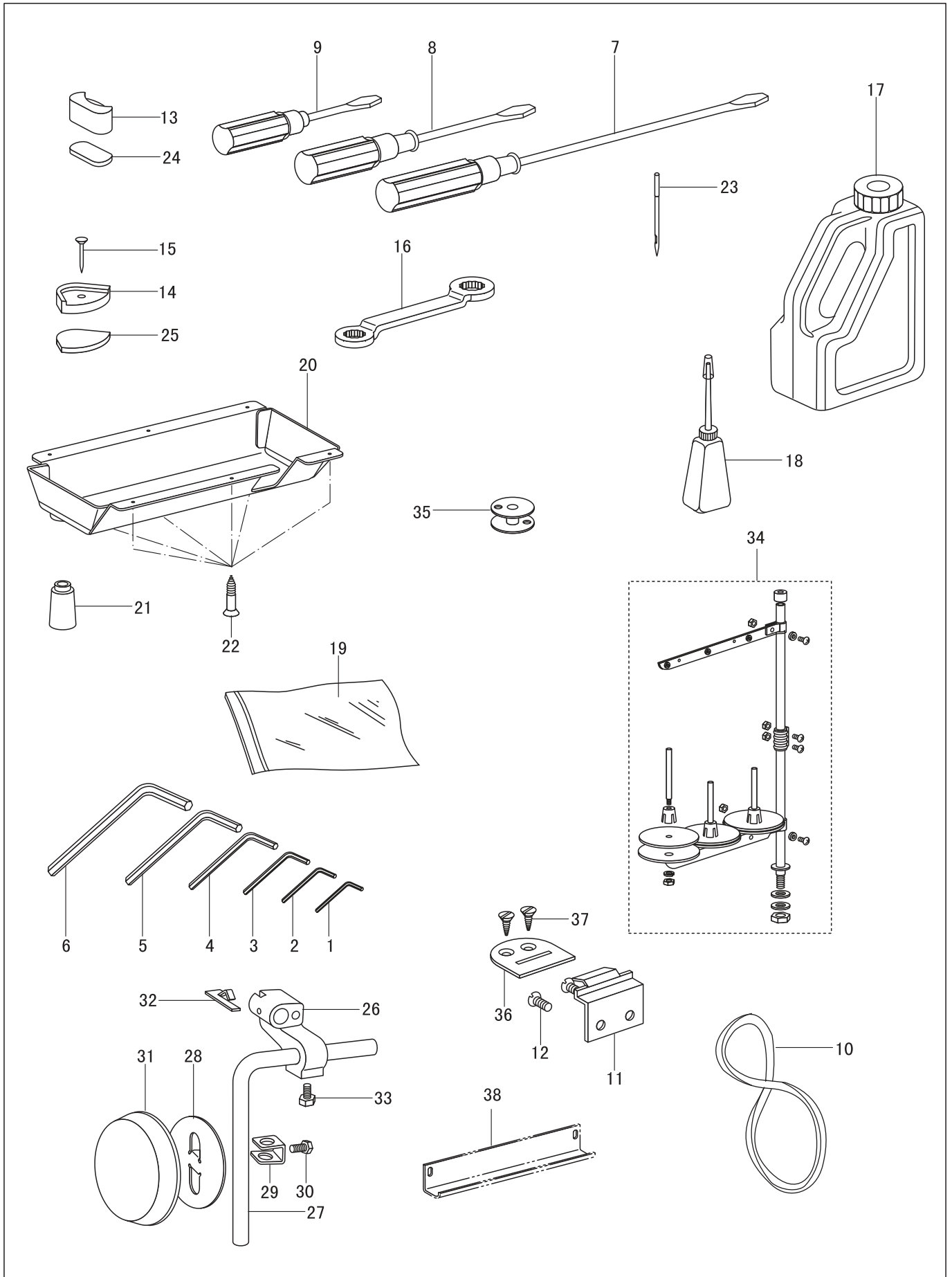
NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24676-D2T3	
1	386WF6-001	Bracket	1	
2	386WF6-002	Valve base	1	
3	93WF22-002	Valve	1	
4	93WF22-004	Plug	5	
5	93WF22-005	Joint	4	
6	93WF22-006	Joint	2	
7	93WF22-008	Silence	2	
8	386WF6-003	Joint	1	
9	386WF6-004	Wire assy.	1	
10	93WF22-007	Wire assy.	1	
11	93WF22-015	Plug	3	
12	93WF22-009	Joint	1	
13	93WF22-010	Air filter	1	
14	93WF22-011	Connector	1	
15	93WF22-012	Joint	1	
16		Screw	12	M3×30
17		Screw	2	GB/T818 M4×30

27. Air presser mechanism



NO.	PARTS NO.	PARTS NAME	QTY	REMARK
			24677-D2T3	
1	218WF22-002	Bracket	1	
2	218WF22-001	Valve base	1	
3	93WF22-002	Valve	1	
4	93WF22-004	Plug	4	
5	93WF22-005	Joint	3	
6	93WF22-006	Joint	2	
7	93WF22-008	Silence	2	
8	386WF6-003	Joint	1	
9	386WF6-004	Wire assy.	1	
10	365WF4-002	Wire assy.	1	
11	93WF22-015	Plug	3	
12	93WF22-009	Joint	1	
13	93WF22-010	Air filter	1	
14	93WF22-011	Connector	1	
15	93WF22-012	Joint	1	
16		Screw	10	M3×30
17		Screw	2	GB/T818 M4×30

28. Accessories



28. Accessories

NO.	PARTS NO.	PARTS NAME	QTY		REMARK
			24677-D2T3	24676-D2T3	
1	91WF6-006	Hexagonal wrench	1	1	S=1.5
2		Hexagonal wrench	1	1	2 GB/T5356-1998
3		Hexagonal wrench	1	1	2.5 GB/T5356-1998
4		Hexagonal wrench	1	1	3 GB/T5356-1998
5		Hexagonal wrench	1	1	4 GB/T5356-1998
6	33TF-012	Hexagonal wrench	1	1	5 GB/T5356-1998
7		Screw driver, L	1	1	
8		Screw driver, M	1	1	
9		Screw driver, S	1	1	
10		V-belt	1	1	M54
11	3KT2-006	Hinge	2	2	
12	211WF5-001	Screw	4	4	
13	93WF24-002	Rubber cushion(B)	2	2	
14	93WF24-003	Rubber cushion (S)	2	2	
15		Nail	2	2	SG162 19
16	1F-009	Double wrench	1	1	8×10 GB/T4388-1995
17		Oil tank	1	1	
18		Oiler	1	1	
19		Accessories bag	1	1	
20		Oil pan	1	1	
21	93WF24-004	Poly oiler	1	1	
22		Wooden screw	6	6	GB 100 3.5×12
23		Needle	4	8	DP×17 24#
24		Spacer	2	2	
25		Spacer	2	2	
26	994481	Knee lifter bracket	1	1	
27	22T9-003B2	Knee lifter bar	1	1	
28	22T9-003B5	Knee lifter plate	1	1	
29	22T9-003B6	Stopper, k-lifter plate	1	1	
30	22T9-003B7	Bolt	1	1	SM11/64"×28/8
31	22T9-003B8	Cover, k-lifter plate	1	1	
32	93WF24-006	Leaf spring	1	1	
33		Bolt	1	1	GB/T 5781 M8×10
34	89F-001	Thread stand assy.	-	1	
	113F-001	Thread stand assy.	1	-	
35	200WF14-003	Bobbin	3	6	
36	3KT2-005	Hinge (2)	2	2	
37	16F-002	Wooden screw	4	4	
38	994015	Cover	1	1	