

**HIGHLEAD**

**GC24698-1L/-1R**

**Super Post-Bed Compound-feed Lockstitch  
Industrial Sewing Machine**

**Instruction Manual  
Parts Catalog**

**SHANGHAI BIAOZHUN HAILING SEWING MACHINERY CO., LTD.**

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## ■ 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.

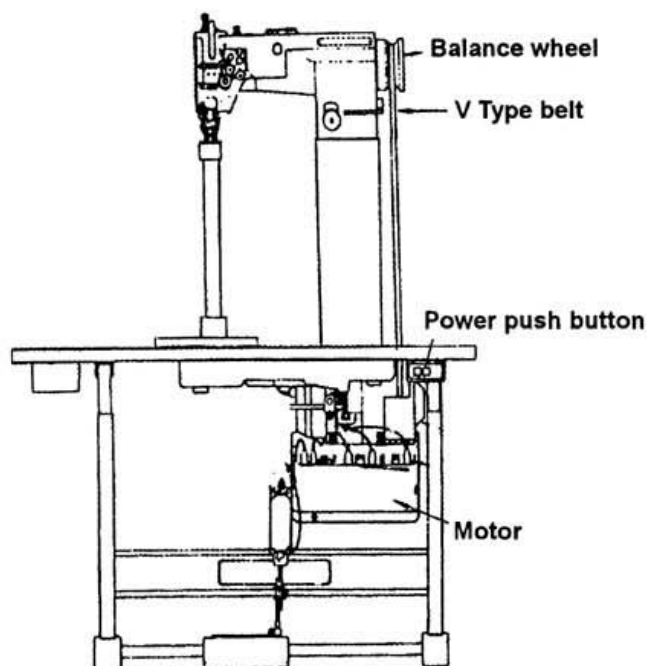
### 2. Precautions before starting operation:

- 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°C or higher) or low temperatures (5°C or lower) .
- 2) Avoid using the machine in dusty conditions.

### Overall view of assembled sewing machine



## ■ Cautions on use

### 1. Oiling (1) (Fig.1)

Filling the oil reservoir with oil up to "H" mark. Oil level should be periodically checked. If oil level is found below "L"; level replenish oil to "H" level.

Use white spindle oil.

### 2. Oiling (2) (Fig.2、 Fig.3)

When a new sewing machine is used for the first time, or sewing machine left out of use for considerably long time is used again, replenish a suitable amount of oil to the portions indicated by arrow in the below figure.

### 3. Oiling condition (Fig.3)

See dripping of oil through the oil sight hole to check oiling condition during operation.

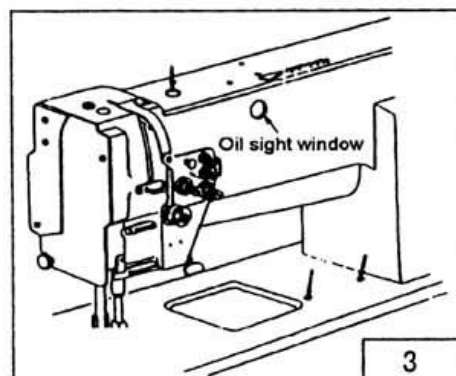
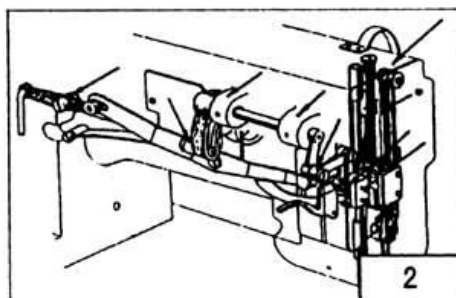
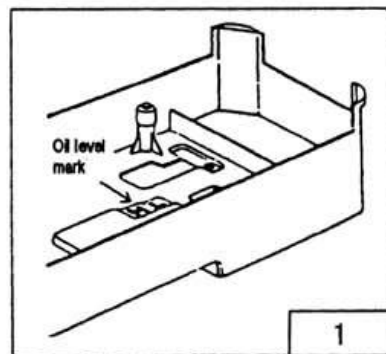
### 4. Cautions on operation

1) When the power is turned on or off, keep foot away from the pedal.

2) It should be noted that the brake might not work when the power is interrupted or power failure occurs during sewing machine operation.

3) Since dust in the control box might cause malfunction or control troubles, be sure to keep the control box cover close during operation.

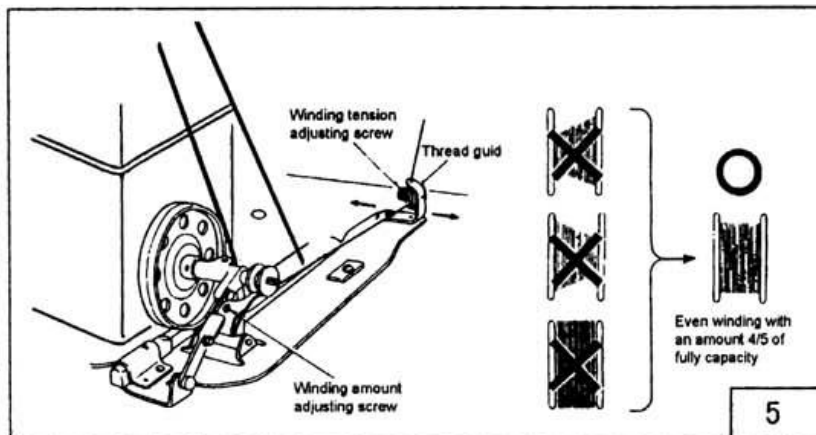
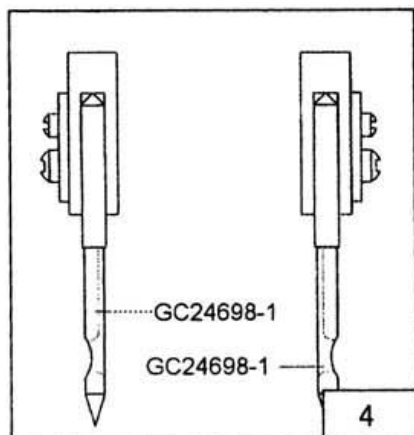
4) Do not apply a Multimeter to the control circuit for checking; Otherwise voltage of Multimeter might damage semiconductor components in the circuit.



## ■ Operation

### 1. Installation of needles (Fig.4)

Note: Before installing the needles, be sure to turn off the power.



## 2. Winding of bobbin thread (Fig.5)

**Note:** When bobbin thread is wound, keep the presser foot lifted.

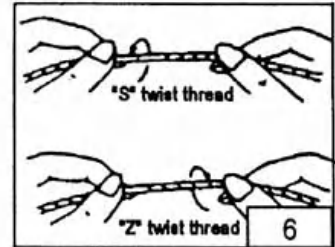
Adjustment:

- Tension of wound thread: Slack winding is recommended for polyester thread and nylon thread.  
 Conically wound thread: Move the thread guide toward smaller diameter of wound thread layer.  
 Length of wound thread: Loosen the thread length adjusting screw to increase length of thread and tighten the screw to decrease length of thread.

## 3. Selection of thread (Fig.6)

It is recommended to use "S" twist thread in the left needle (viewed from front), and "Z" twist thread in the right needle.

When discriminate use of needle threads is impossible, use "Z" twist thread in both the needles. For bobbin thread, "S" twist thread as well as "Z" twist thread can be used.



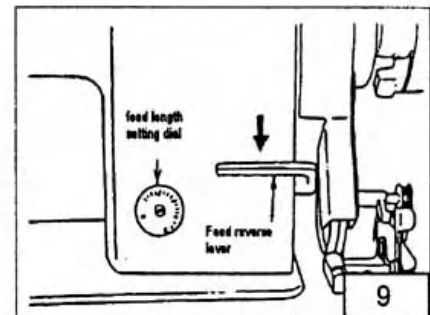
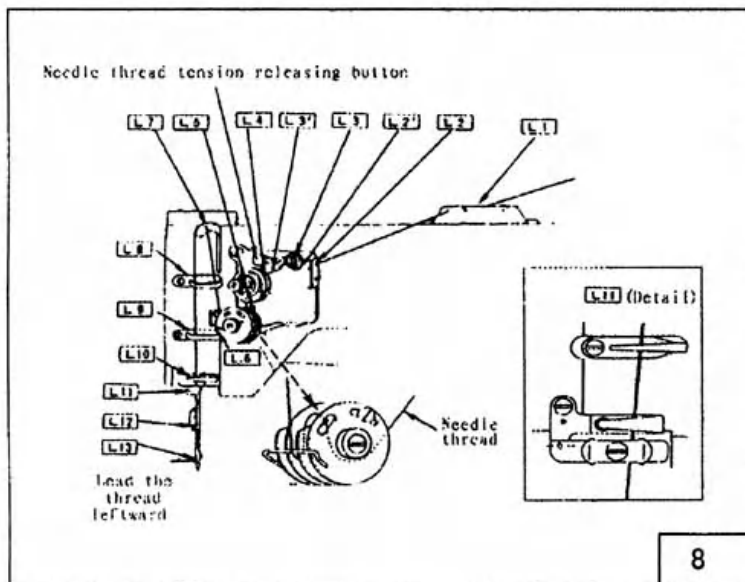
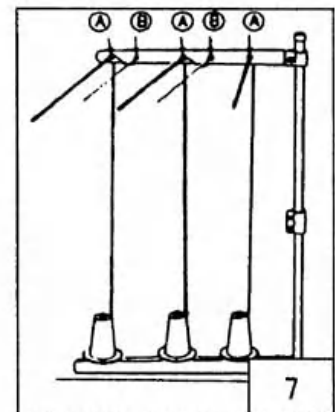
## 4. Threading of needle threads

(1) Pass each needle thread through thread guide A (Fig.7)

**Note:** When thin slippery thread (polyester thread or filament thread, for example) is used pass the thread through thread guide B as well.

(2) With the take-up lever located at the upper most position, pass each needle thread in the order shown in the following figure (Fig.8).

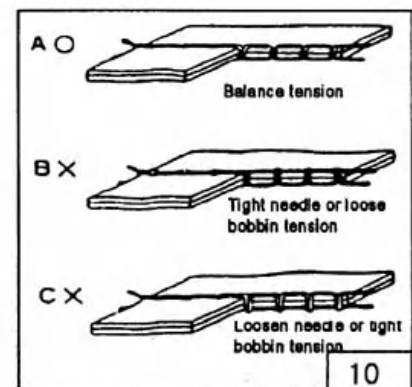
**Note:** Pressing the upper thread-loosening button shown in the figure below opens the saucer of the upper thread tension adjuster, and the upper thread can easily pulled out.



## 5. Adjustment of stitch length and reverse sewing (Fig.9)

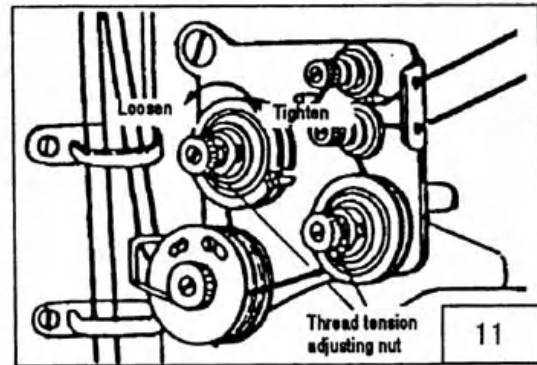
- 1). Rotate the stitch length adjusting dial to change the stitch length.
- 2). Pressing the stitch length adjusting lever for reverse stitching.

## 6. Balance of thread tension (Fig.10)



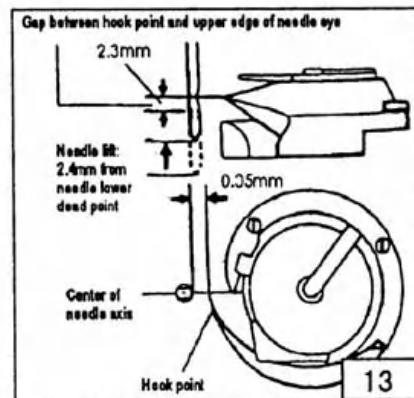
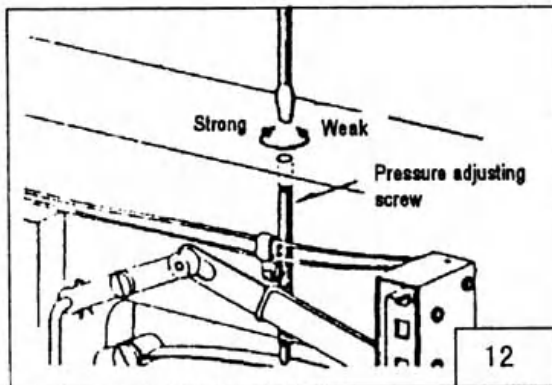
## 7. Needle thread tension (Fig.11)

- Needle thread tension should be adjusted in reference to bobbin thread tension.
- To adjust needle thread tension, turn each tension adjusting nut. Needle thread tension can be also adjusted for special fabric and thread by changing intensity and movable range of slack thread adjusting spring.



## 8. Adjustment of presser foot pressure (Fig.12)

Pressure to fabric(s) can be adjusted by turning the pressure adjusting screw.



## 9. Timing between rotating hook motion and needle motion (Fig.13)

- 1) Set feed length (stitch length) to "6" on the feed setting dial.
- 2) When needle is lifted 2.4mm from the lower dead point, as shown in Figure, the following positional relationship should be maintained.

The upper edge of needle eye should be 2.3mm below the hook point.

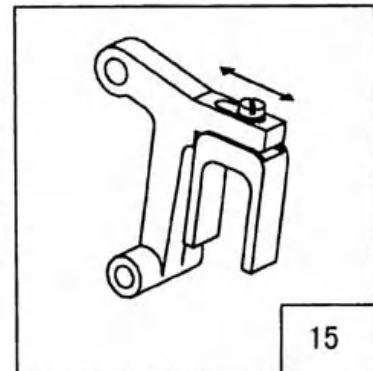
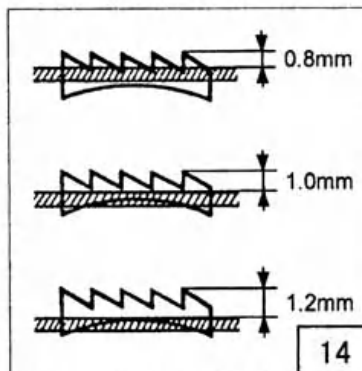
- The hook point should be located at the center of needle axis.
- Gap between the hook point and the side face of needle should be 0.05mm.

## 10. Adjustment of feed dog height (Fig.14)

Height of feed dog and pressure of presser Foot should be adjusted for individual fabric(s) with the following cautions:

- Fabric will be damaged if the feed dog extends too high, or pressure of presser foot is too large.
- Even stitch length cannot be assured if the feed dog is too low or pressure of presser foot is too small.
- Feed dog height should be measured at the point where the needle is at the top position.

For light fabric: Approx 0.8mm  
 For usual fabric: Approx 1.0mm  
 For heavy fabric: Approx 1.2mm





## Adjustment procedure (Fig.15)

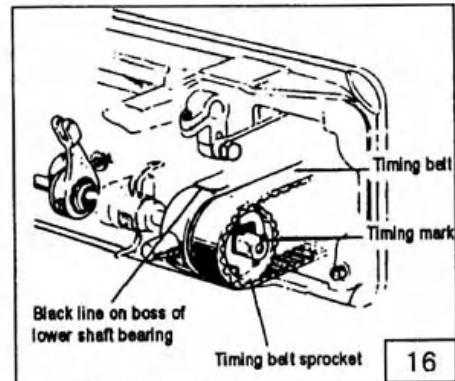
- 1) Lean the machine head backward.
- 2) Turn the hand wheel by hand and stop when the feed dog rises to the maximum height.
- 3) Loosen the feed bar setscrew.
- 4) Vertically move the feed bar (in the direction indicated by arrow in the figure) to adjust it to adequate height.
- 5) After the adjustment, tighten the feed bar setscrew.

The feed dog height is factory-adjusted to 1.2mm

## 11. Relationship between rotating hook motion and take-up lever motion (Fig.16)

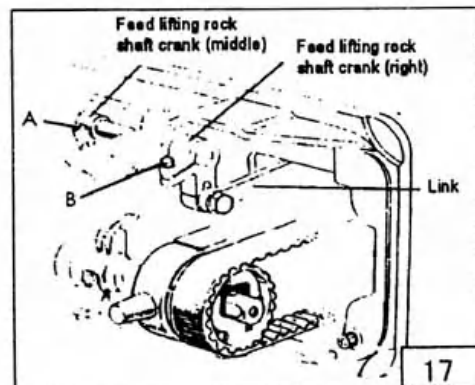
When the timing belt (toothed belt) was removed for its replacement, for example, the relationship between rotating hook motion and take-up lever motion should be adjusted as follows:

- 1) Turn the balance wheel and stop when the take-up lever is lifted to its upper dead point.
- 2) Lean the machine head backward and make sure the arrow (timing mark) put on the timing belt is in line with the black line on the boss of lower shaft bearing.
- 3) If the timing mark is not in line with the black line, remove the timing belt and install it again to adjust



## 12. Relationship between needle motion and feed dog motion (Fig.17.18.19)

- 1) Set feed length to "0" on the feed setting dial
- 2) Lean the machine head backward.
- 3) Loosen the feed lifting rock shaft crank set Screws A and B
- 4) Set the needle at the lowest position.
- 5) Adjust the distance between presser rod and Vibration prevention rod to 8mm and temporarily tighten the feed lifting rock shaft crank set screws A and B

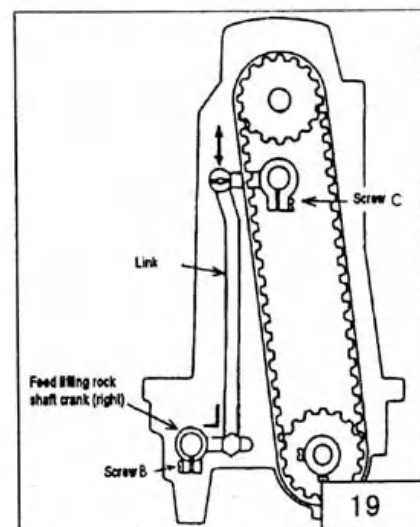
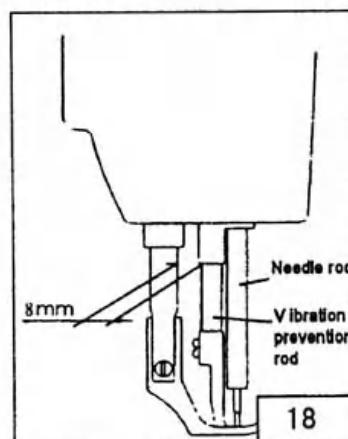


6) Check that the right feed lifting rockshaft crank is connected with the link at right angle, as shown in Figure.

7) If the connection is not at right angle, remove the back cover, loosen screw C and move the right link to connect the right feed lifting rockshaft with the link at right angle.

8) After the completion of adjustment, fully tighten the screws A, B and C

At this time make certain that needle can enter the feed dog needle hole at the center of the hole.





### 13. Safety clutch device (Fig.20.21)

Safety clutch device is installed to prevent the hook and cog belt from damage in case the thread is caught into the hook when the machine is loaded abnormally during operation.

#### 1) Function of safety clutch

A. When the safety clutch acts, the cog belt pulley will be unloaded. Then the rotation of hook shaft will stop. The arm shaft only will rotate. Stop the operation of machine.

B. Clean the thread thoroughly which is caught into the hook.

C. Turn the cog belt hub by hand, and check. Whether the hook shaft rotates lightly and Properly, place the clutch device as follows.

#### 2) How to set the safety clutch

A. While pressing down the push button on the opposite side of bed by left hand, turn the balance wheel slowly by right hand away from you as shown in the figure.

B. The balance wheel will stop by the gear plate, but turn the balance wheel more firmly.

C. Release the push button.

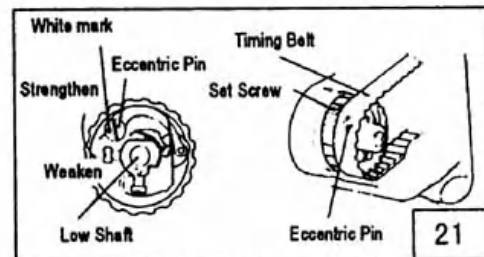
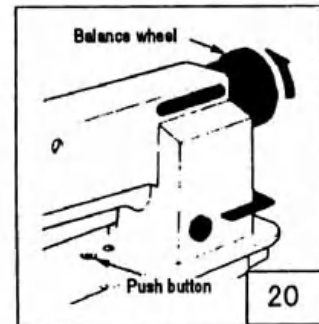
D. As shown in the Figure, the safety clutch device is set.

#### 3) Force applied to the safety clutch

A. The force applied to the safety clutch is the smallest when the white mark of the eccentric pin faces the center of the lower shaft. The force proportionally increases as the white mark faces the outside.

B. To adjust the force slide the timing belt, Loosen the set screw, and turn the eccentric pin.

C. After the adjustment, make sure to fasten the setscrew.



### 14. Upper feed adjustment (needle side) (Fig.22)

If the uneven feeding occurs according to the fabric, adjust the long hole of the horizontal feed shaft crank (right) to adjust the upper feed length.

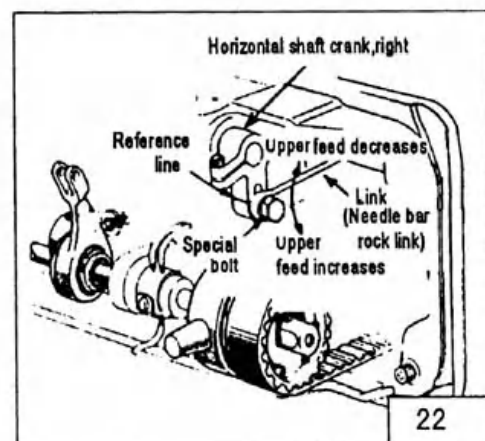
#### (How to adjust)

1) Loosen the special bolt.

2) Move the special bolt upward to decrease upper feed.

3) Move the special bolt downward to Increase the upper feed. The upper feed and the lower feed theoretically becomes equal at the reference line on the horizontal feed shaft crank.

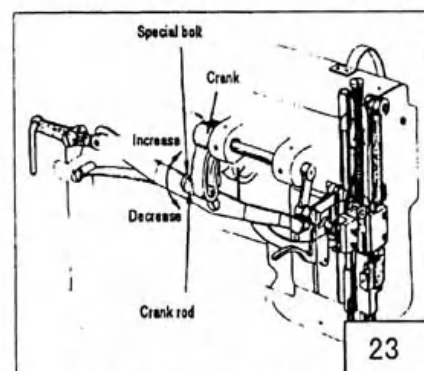
4) Securely tighten the special bolt after adjustment.



### 15. Outside presser foot and inside presser vertical stroke adjustment (Fig.23)

When fabric with large elasticity is sewn, Or When thickness of fabric changes, the vertical Stroke (movable range) of the press feet should be adjusted as follows:

#### Adjustment



- 1) Loosen the special bolt.
- 2) The vertical strokes of the presser feet become maximum when the crank rod is moved upward and set.
- 3) The vertical strokes become minimum when the nut is moved downward and set.
- 4) After the adjustment, fully tighten the special bolt.

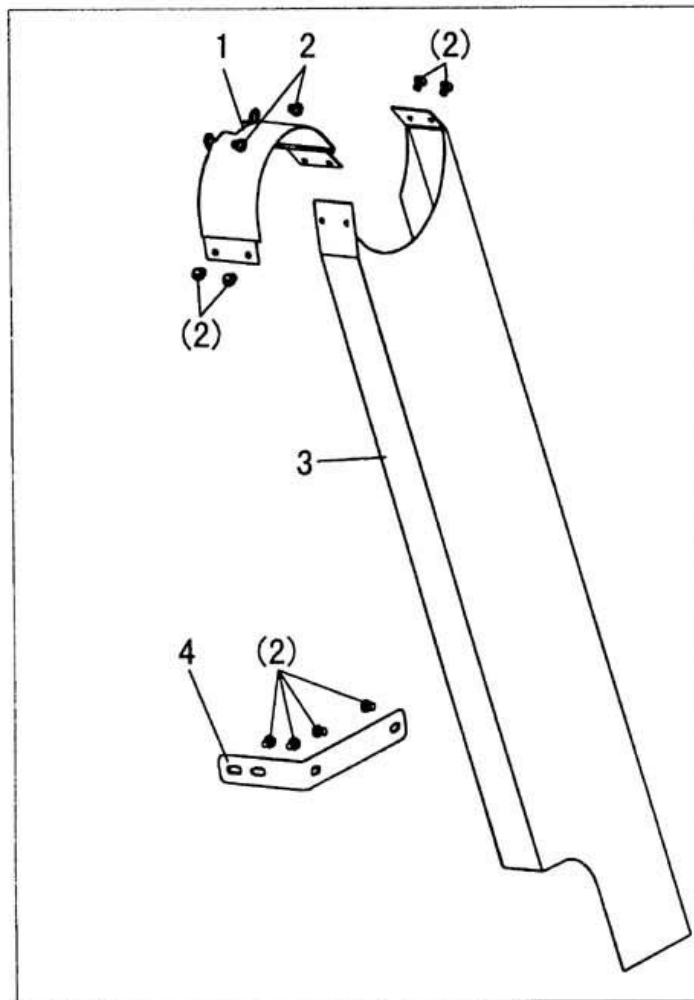
The vertical strokes of the presser feet can be adjusted within a range from 6mm to 2mm.

## 16. Adjustment

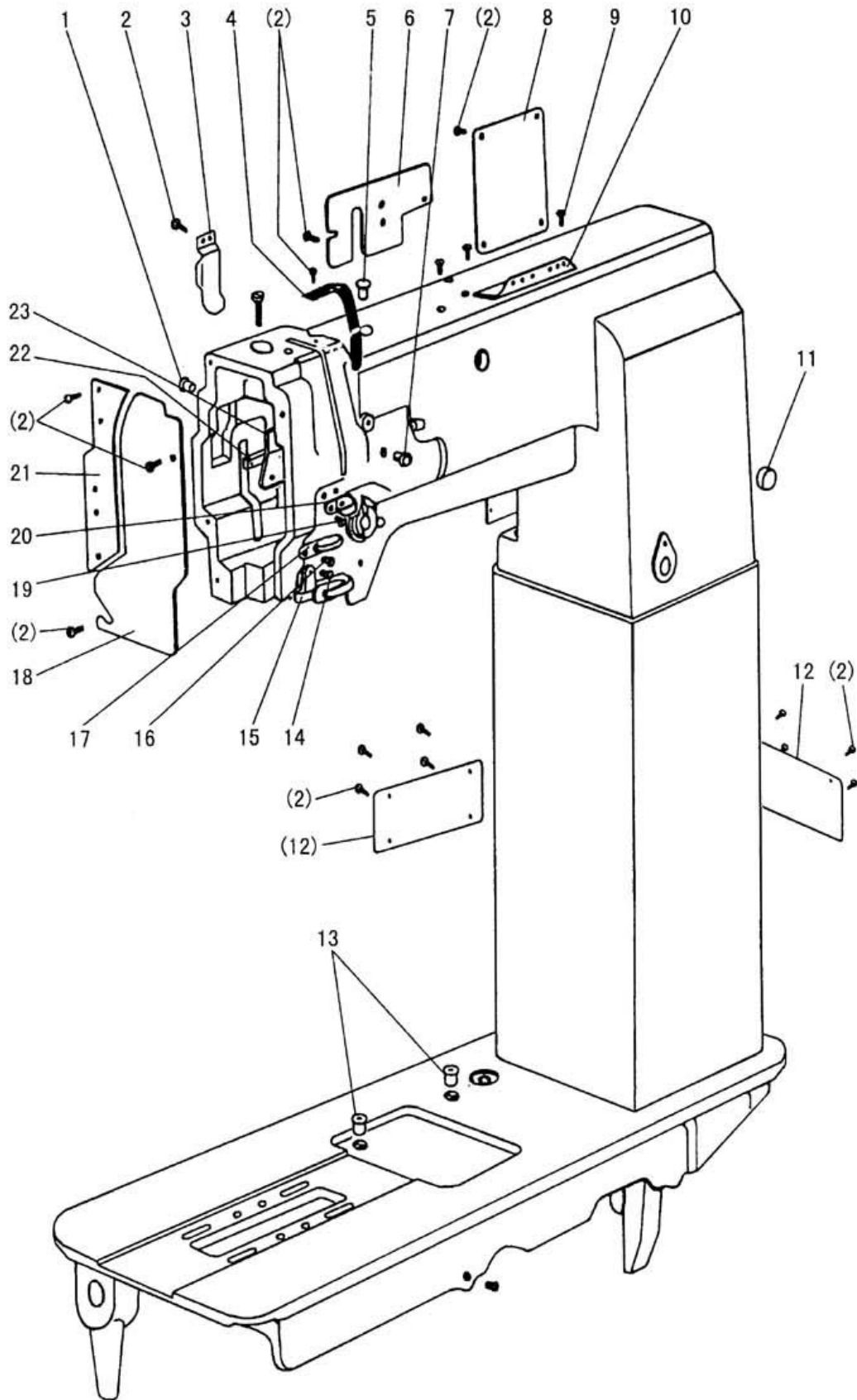
Screwing the pin that connects the link of back sewing with the crank of back sewing (down) can adjust the tolerance of between the stitches. Screwing the pin in clockwise can increase the stitch of forward sewing; otherwise, the stitch of back sewing will be increased.

## 17. Installation of Belt cover:

- 1) Fixed 1 to the arm with screws
- 2) Fixed 3 to 1 with screws
- 3) Fixed 4 to 3 and arm with screws



# A.ARM BED AND ITS ACCESSORIES

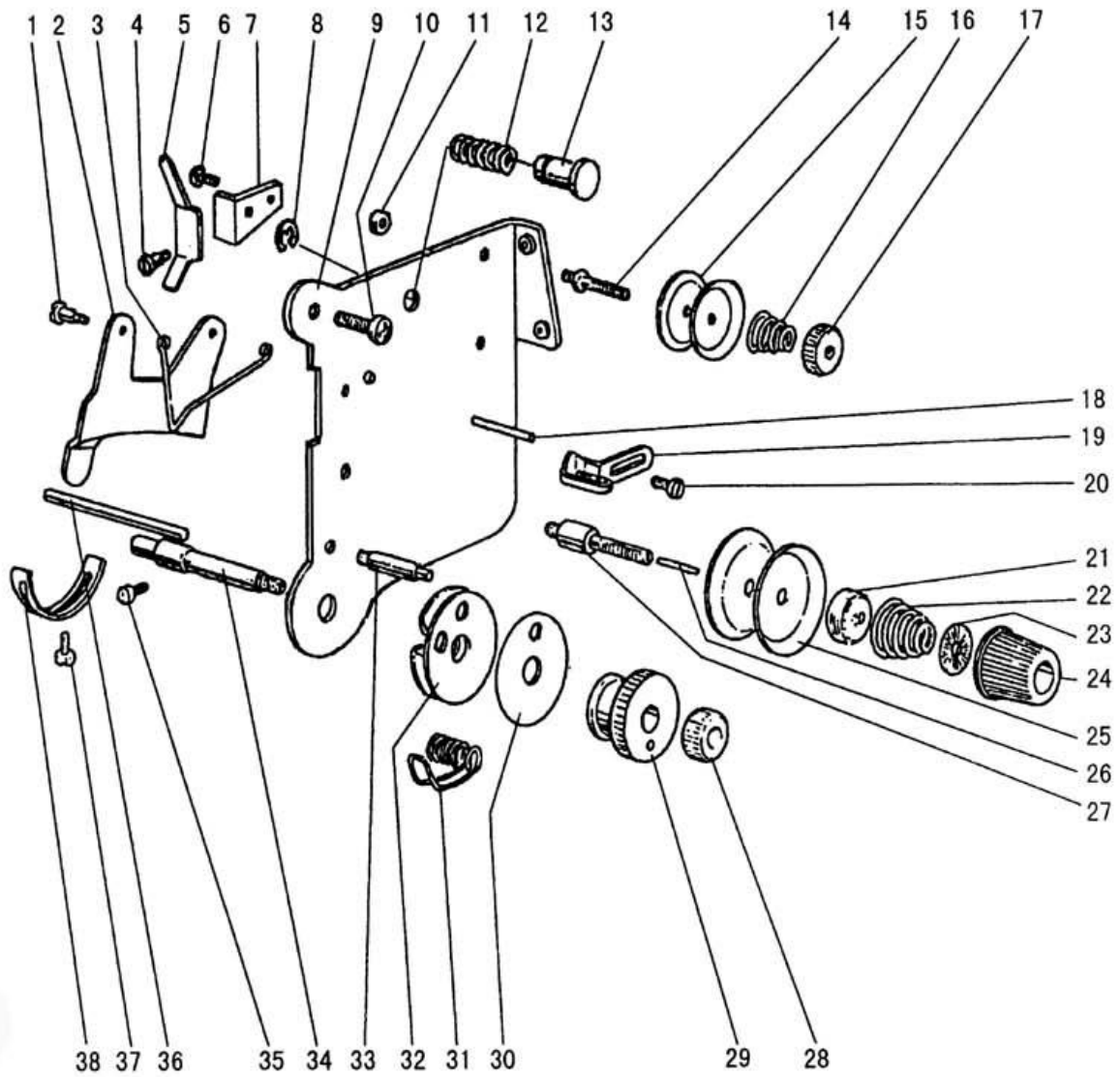


## A.ARM BED AND ITS ACCESSORIES

| Fig No. | Part No.   | Description            | GC24698-IL | GC24698-IR | Remarks         |
|---------|------------|------------------------|------------|------------|-----------------|
| A01     | HA300B2090 | Rubber plug            | 2          | 2          |                 |
| A02     | HA300B2170 | Screw                  | 42         | 42         | 11/64 (40) ×9   |
| A03     | H4716B8001 | Oil guide plate        | 1          | 1          |                 |
| A04     | H4717B8001 | Thread take-up cover   | 1          | 1          |                 |
| A05     | H4715B8001 | Rubber plug            | 1          | 1          |                 |
| A06     | H4718B8001 | Arm side cover (left)  | 1          | 1          |                 |
| A07     | H2000B2010 | Rubber plug            | 1          | 1          |                 |
| A08     | H4719B8001 | Arm side cover (right) | 1          | 1          |                 |
| A09     | HA700B2060 | Screw                  | 2          | 2          | 11/64 (40) ×8   |
| A10     | H2400B2100 | Thread guide           | 1          | 1          |                 |
| A11     | HA307B0673 | Rubber plug            | 1          | 1          |                 |
| A12     | H7117B8001 | Arm side cover         | 2          | 2          |                 |
| A13     | H2000M0080 | Cap                    | 2          | 2          |                 |
| A14     | H3200B2100 | Screw                  | 1          | 1          | 9/64 (40) ×6.5  |
| A15     | H3212B0066 | Thread guide           | 1          | 1          |                 |
| A16     | H3000D2160 | Screw                  | 1          | 1          | 9/64 (40) ×4.5  |
| A17     | H4727B8001 | Face plate             | 1          | 1          |                 |
| A18     | H4726B8001 | Thread guide           | 1          | 1          |                 |
| A19     | H2400B2080 | Screw                  | 2          | 2          | 3/16 (28) ×12.1 |
| A20     | H2400B2070 | Thread guide           | 1          | 1          |                 |
| A21     | H4730B8001 | Guide mounting plate   | 1          | 1          |                 |
| A22     | H2400B2060 | Spacer                 | 1          | 1          |                 |
| A23     | H3200B2060 | Oil guide plate        | 1          | 1          |                 |

## B. THREAD TENSION REGULATOR MECHANISM

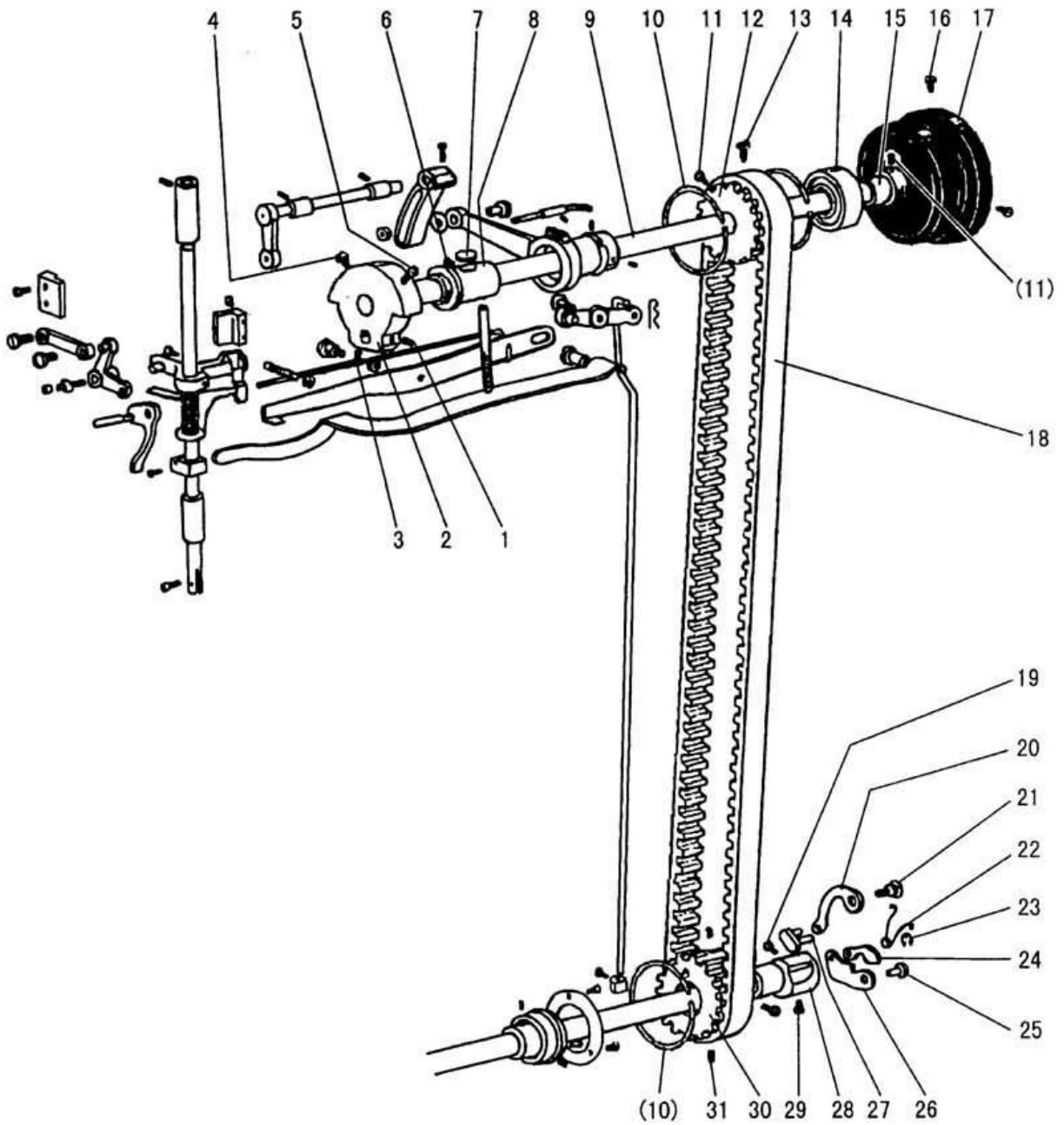
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## B.THREAD TENSION REGULATOR MECHANISM

| Fig. No. | Part No.   | Description                  | GC24698-1L | GC24698-1R | Remarks        |
|----------|------------|------------------------------|------------|------------|----------------|
| B01      | H2504C6510 | Screw                        | 2          | 2          | 9/64 (40) ×3   |
| B02      | H3221B3142 | Tension releasing plate      | 1          | 1          |                |
| B03      | H3221B6812 | Tension releasing spring     | 1          | 1          |                |
| B04      | H4705C8001 | Screw                        | 1          | 1          |                |
| B05      | H4706C8001 | Lever                        | 1          | 1          |                |
| B06      | HA7311C306 | Screw                        | 1          | 1          | 9/64 (40) ×7   |
| B07      | H4707C8001 | Mounting plate               | 1          | 1          |                |
| B08      | H007013050 | E-type ring                  | 1          | 1          | GB/T896 5      |
| B09      | H3221B6820 | Mounting plate               | 1          | 1          |                |
| B10      | HA300C2030 | Screw                        | 2          | 2          | 11/64 (40) ×8  |
| B11      | H3221B6810 | Nut                          | 2          | 2          |                |
| B12      | H4708C8001 | Spring                       | 1          | 1          |                |
| B13      | H4709C8001 | Push button                  | 1          | 1          |                |
| B14      | H3221B0683 | Thread tension stud          | 1          | 1          | 11/64 (40) ×14 |
| B15      | HA112B0693 | Thread tension disc          | 2          | 2          |                |
| B16      | H3221B0684 | Spring                       | 1          | 1          |                |
| B17      | HA710B0671 | Thumb nut                    | 1          | 1          |                |
| B18      | H3221B0682 | Pin                          | 2          | 2          |                |
| B19      | H3306B0661 | Thread guide                 | 1          | 1          |                |
| B20      | HA106B0676 | Screw                        | 1          | 1          | 9/64 (40) ×6   |
| B21      | HA310B0702 | Tension releasing disc       | 1          | 1          |                |
| B22      | H4710C8001 | Spring                       | 1          | 1          |                |
| B23      | HA115B7010 | Thumb nut revolution stopper | 1          | 1          |                |
| B24      | HA310B0701 | Thumb nut                    | 1          | 1          |                |
| B25      | HA310B0705 | Thread tension disc          | 2          | 2          |                |
| B26      | H3221B6817 | Pin                          | 1          | 1          |                |
| B27      | H3221B0686 | Thread tension stud          | 1          | 1          | 1/4 (40) ×23   |
| B28      | H32481B721 | Thumb nut                    | 1          | 1          |                |
| B29      | H32481B621 | Take-up spring guide         | 1          | 1          |                |
| B30      | H32481BE21 | Plate complete               | 1          | 1          |                |
| B31      | H4713C8001 | Thread take-up spring        | 1          | 1          |                |
| B32      | H32481BD21 | Plate complete               | 1          | 1          |                |
| B33      | H4804C8001 | Thread tension stud          | 1          | 1          | 9/64 (40) ×2.9 |
| B34      | H4805C8001 | Thread tension stud          | 1          | 1          | 1/4 (40) ×14.5 |
| B35      | H3230K0751 | Screw                        | 1          | 1          | 11/64 (40) ×10 |
| B36      | H3221B6817 | Pin                          | 1          | 1          |                |
| B37      | H4769E8001 | Pin                          | 1          | 1          |                |
| B38      | H3200B2100 | Screw                        | 1          | 1          | 9/64 (40) ×6.5 |
| B39      | H3221B6819 | Stopper                      | 1          | 1          |                |

# C. ARM SHAFT MECHANISM

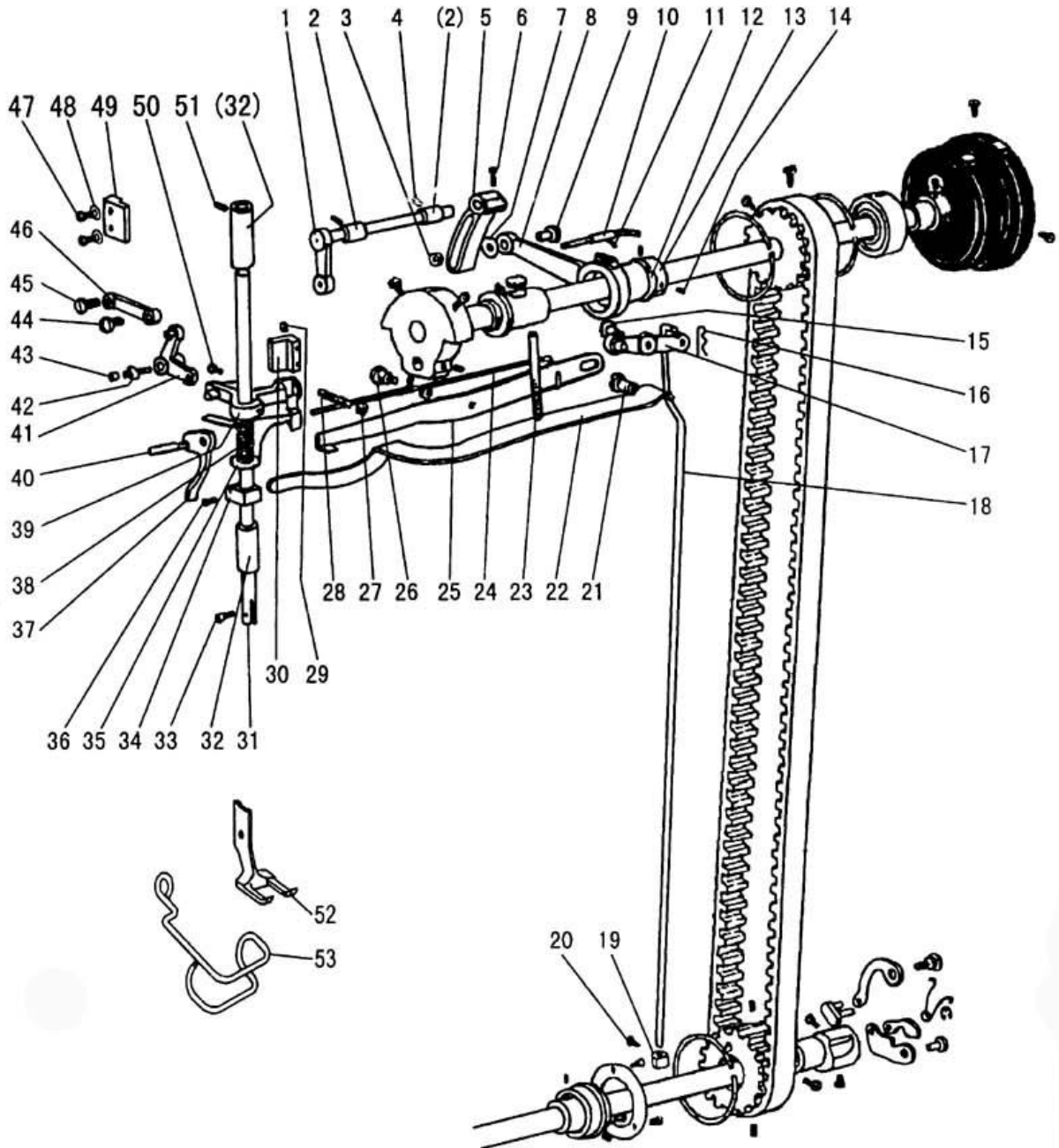




## C.ARM SHAFT MECHANISM

| Fig. No. | Part No.   | Description              | GC24698-1L | GC24698-1R | Remarks          |
|----------|------------|--------------------------|------------|------------|------------------|
| C01      | HA307C0662 | Set screw                | 1          | 1          | 1/4 (40) ×6      |
| C02      | H4706D8001 | Crank                    | 1          | 1          |                  |
| C03      | HA105D0662 | Set screw                | 1          | 1          | 1/4 (40) ×4      |
| C04      | HA100C2060 | Screw                    | 1          | 1          | 9/32 (28) ×13    |
| C05      | HA100C2070 | Screw                    | 1          | 1          | 9/32 (28) ×14    |
| C06      | H4708D8001 | Set screw                | 1          | 1          | 1/4(24)×13       |
| C07      | H32111B104 | Felt                     | 1          | 1          |                  |
| C08      | H32111B204 | Arm shaft bushing (left) | 1          | 1          |                  |
| C09      | H4709D8001 | Arm shaft                | 1          | 1          |                  |
| C10      | H3205C0661 | Spring flange            | 3          | 3          |                  |
| C11      | HA113F0684 | Screw                    | 3          | 3          | 15/64 (28) ×8.5  |
| C12      | H3205C1021 | Pulley                   | 1          | 1          |                  |
| C13      | HA100F2130 | Screw                    | 1          | 1          | 15/64 (28) ×14.5 |
| C14      | H3205J0662 | Bearing                  | 1          | 1          |                  |
| C15      | H3205J0661 | Collar                   | 1          | 1          |                  |
| C16      | HA110D0672 | Screw                    | 2          | 2          | 15/64 (28) ×12   |
| C17      | H4100C2040 | Pulley                   | 1          | 1          |                  |
| C18      | H7104D8001 | Cog belt                 | 1          | 1          |                  |
| C19      | HA104F0654 | Screw                    | 1          | 1          | 15/64 (28) ×10   |
| C20      | H4713D8001 | Link                     | 1          | 1          |                  |
| C21      | H4714D8001 | Pin                      | 1          | 1          |                  |
| C22      | H4716D8001 | Spring                   | 1          | 1          |                  |
| C23      | H007013025 | E-type ring              | 1          | 1          | GB/T896 2.5      |
| C24      | H4717D8001 | Link                     | 1          | 1          |                  |
| C25      | H4718D8001 | Pin                      | 1          | 1          |                  |
| C26      | H4719D8001 | Link                     | 1          | 1          |                  |
| C27      | H4715D8001 | Pin                      | 1          | 1          |                  |
| C28      | H4720D8001 | Bushing                  | 1          | 1          |                  |
| C29      | H4721D8001 | Screw                    | 1          | 1          | 15/64(28)×10.5   |
| C30      | H4722D8001 | Pulley                   | 1          | 1          |                  |
| C31      | H4723D8001 | Screw                    | 2          | 2          | 15/64(28)×4.5    |

# D. UPPER SHAFT & PRESSER FOOT MECHANISM



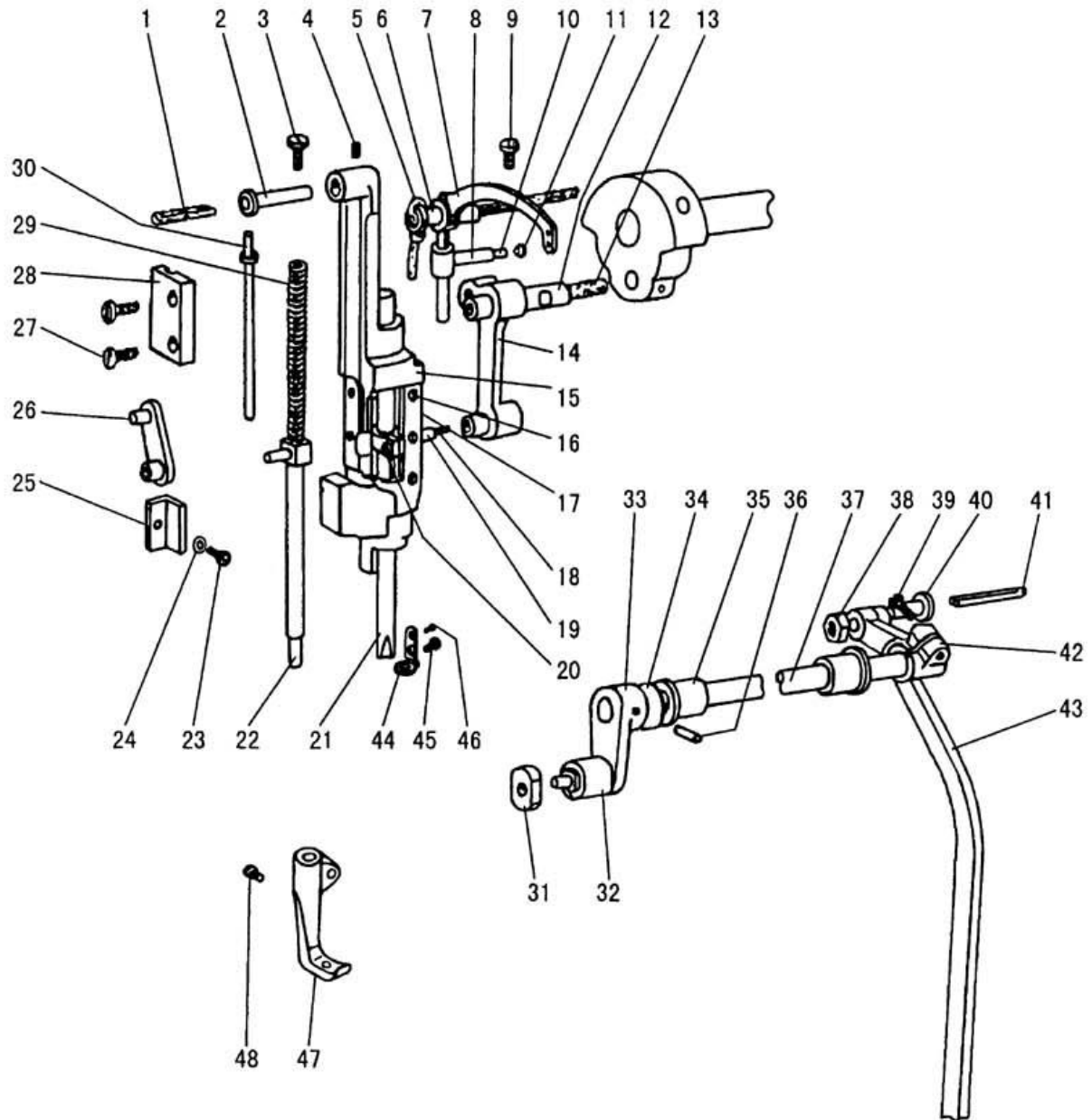
## D.UPPER SHAFT & PRESSER FOOT MECHANISM

| Fig. No. | Part No.   | Description               | GC24698-IL | GC24698-IR | Remarks         |
|----------|------------|---------------------------|------------|------------|-----------------|
| D01      | H4705E8001 | Feed lifting rock shaft   | 1          | 1          |                 |
| D02      | H4707E8001 | Bushing                   | 2          | 2          |                 |
| D03      | H003055060 | Nut                       | 1          | 1          | (M6×0.75)       |
| D04      | H4706E8001 | Set screw                 | 2          | 2          | 1/4 (24)×7      |
| D05      | H4709E8001 | Crank                     | 1          | 1          |                 |
| D06      | H3115F0671 | Screw                     | 1          | 1          | 1/4 (28) ×16    |
| D07      | H2013J0065 | Washer                    | 1          | 1          |                 |
| D08      | H2014J0066 | Connecting rod            | 1          | 1          |                 |
| D09      | H2000J2100 | Screw                     | 1          | 1          |                 |
| D10      | H4713E8001 | Oil wick                  | 1          | 1          |                 |
| D11      | H20111C106 | Holder                    | 1          | 1          |                 |
| D12      | H007009250 | C-type ring               | 1          | 1          | GB/T894.1 25    |
| D13      | H4714E8001 | Eccentric                 | 1          | 1          |                 |
| D14      | HA307C0662 | Screw                     | 2          | 2          | 1/4 (40) ×6     |
| D15      | H4732E8001 | Screw                     | 1          | 1          | 1/4 (24) ×14    |
| D16      | H4739E8001 | Snap pin                  | 1          | 1          |                 |
| D17      | H4734E7101 | Knee lifter lifting lever | 1          | 1          |                 |
| D18      | H7104E8001 | Operation rod             | 1          | 1          |                 |
| D19      | H4741E8001 | Collar                    | 1          | 1          |                 |
| D20      | H4742E8001 | Screw                     | 1          | 1          | 11/64 (40) ×5.5 |
| D21      | H3100G2170 | Screw                     | 1          | 1          | 1/4 (24) ×17    |
| D22      | H4730E8001 | Lever spring              | 1          | 1          |                 |
| D23      | H4729E8001 | Screw                     | 1          | 1          | 15/64 (28) ×79  |
| D24      | H4727E8001 | Twist spring              | 1          | 1          |                 |
| D25      | H4728E8001 | Knee lifting lever        | 1          | 1          |                 |
| D26      | H3100G2130 | Screw                     | 1          | 1          | 1/4 (24) ×7     |
| D27      | H4726E8001 | Nut                       | 1          | 1          |                 |
| D28      | H4725E8001 | Screw                     | 1          | 1          | 1/4 (24) ×19    |
| D29      | HA111G0683 | Screw                     | 2          | 2          | 11/64(40)×12    |
| D30      | H4723E8001 | Guide                     | 1          | 1          |                 |
| D31      | H4754E8001 | Presser bar               | 1          | 1          |                 |
| D32      | H4744E8001 | Bushing                   | 1          | 1          |                 |
| D33      | H3200E2020 | Screw                     | 1          | 1          | 1/8(44)×9       |
| D34      | H4746E8001 | Spring bracket            | 1          | 1          |                 |
| D35      | H4768E8001 | Thread releasing plate    | 1          | 1          |                 |
| D36      | H2404I0034 | Screw                     | 1          | 1          | 9/64 (40) ×8.5  |
| D37      | H4748E8001 | Lift lever                | 1          | 1          |                 |
| D38      | H4767E8001 | Spring                    | 1          | 1          |                 |
| D39      | H4752E8001 | Bracket                   | 1          | 1          |                 |
| D40      | H4749E8001 | Screw                     | 1          | 1          | 11/64 (40) ×8.5 |
| D41      | H4715E8001 | Bell crank                | 1          | 1          |                 |
| D42      | H2004J0655 | Screw                     | 1          | 1          | 3/16 (28) ×10   |
| D43      | H4717E8001 | Roller                    | 1          | 1          |                 |

## D.UPPER SHAFT & PRESSER FOOT MECHANISM

| Fig. No. | Part No.   | Description      | GC24698-1L | GC24698-1R | Remarks          |
|----------|------------|------------------|------------|------------|------------------|
| D44      | H4718E8001 | Screw            | 1          | 1          | 11/64(32)×6      |
| D45      | H2004J0662 | Screw            | 1          | 1          | 1/4(40)×5        |
| D46      | H4719E8001 | Link             | 1          | 1          |                  |
| D47      | HA100E2150 | Screw            | 2          | 2          | 11/64 (40) ×10   |
| D48      | H4722E8001 | Washer           | 2          | 2          |                  |
| D49      | H4721E8001 | Bell crank guide | 1          | 1          |                  |
| D50      | H4753E8001 | Screw            | 1          | 1          | 11/64 (40) ×17.5 |
| D51      | H4708D8001 | Set screw        | 2          | 2          | 1/4(24)×13       |
| D52      | H7105E8001 | Lifting presser  | 1          |            |                  |
| D52      | H7905E8001 | Lifting presser  |            | 1          |                  |
| D53      | HE204I8001 | Finger gusrd     | 1          | 1          |                  |

# E. TAKE-UP THREAD AND ARM SHAFT MECHANISM



## E.TAKE-UP THREAD AND ARM SHAFT MECHANISM

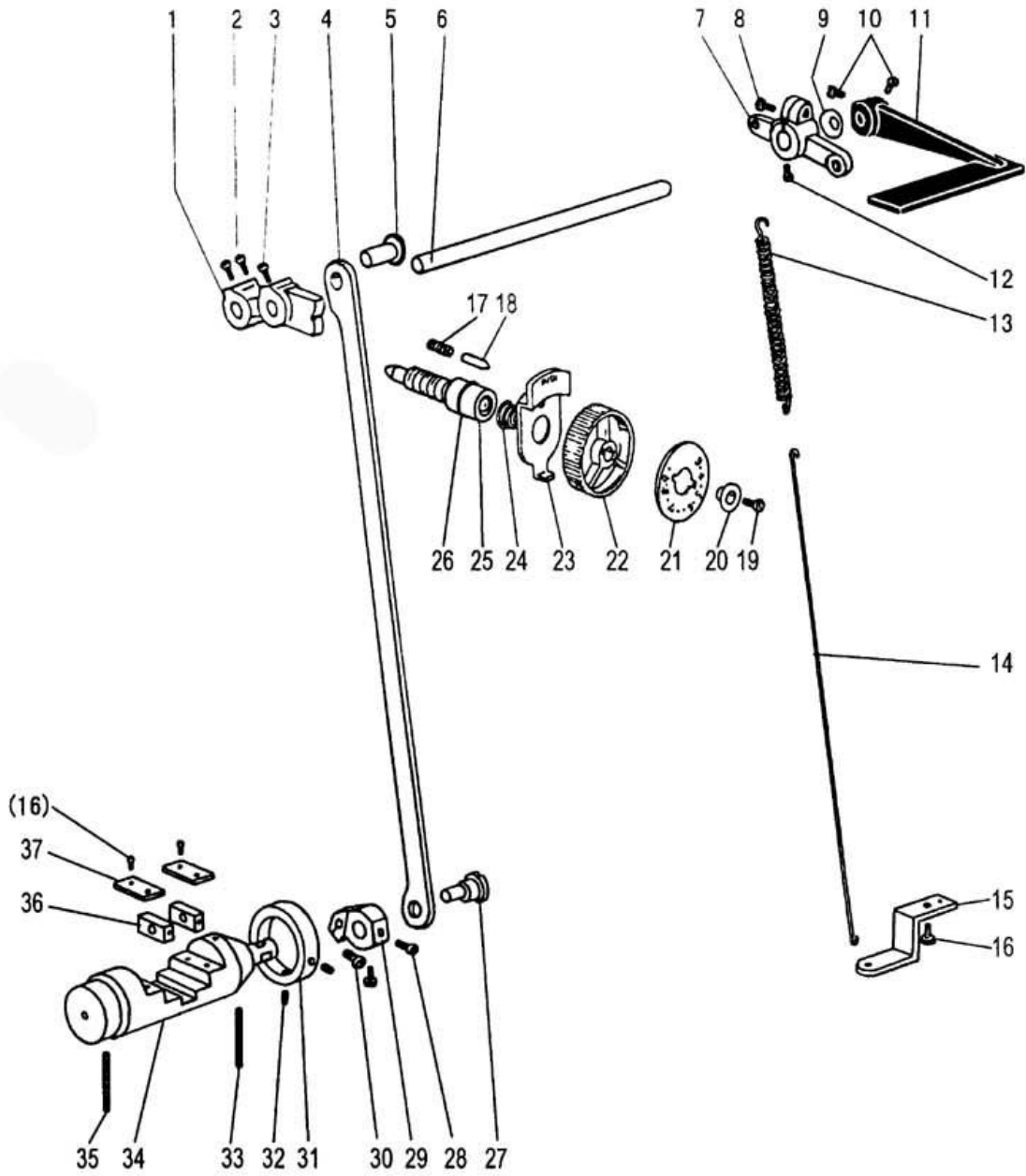
| Fig. No. | Part No.   | Description                       | GC24698-IL | GC24698-IR | Remarks          |
|----------|------------|-----------------------------------|------------|------------|------------------|
| E01      | H24211DN05 | Oil wick                          | 1          | 1          |                  |
| E02      | H4706F8001 | Needle bar guide bracket stud     | 1          | 1          |                  |
| E03      | H4707F8001 | Screw                             | 1          | 1          | 5/16 (28) ×10.4  |
| E04      | HA100C2020 | Set screw                         | 1          | 1          | 15/64 (28) ×10   |
| E05      | H24211DN05 | Oil wick                          | 1          | 1          |                  |
| E06      | H24211DM05 | Thread take-up lever support stud | 1          | 1          |                  |
| E07      | H4712F8001 | Thread take-up lever              | 1          | 1          |                  |
| E08      | H2405D1112 | Thread take-up slide brock        | 1          | 1          |                  |
| E09      | HA110D0672 | Screw                             | 1          | 1          | 15/64 (28) ×12   |
| E10      | H24211D405 | Oil wick                          | 1          | 1          |                  |
| E11      | H24211D305 | Plug                              | 1          | 1          |                  |
| E12      | H2405D0662 | Needle bar crank pin              | 1          | 1          |                  |
| E13      | H4716F8001 | Oil wick                          | 1          | 1          |                  |
| E14      | H4717F8001 | Needle bar connecting link        | 1          | 1          |                  |
| E15      | H4719F8001 | Needle bar rock frame             | 1          | 1          |                  |
| E16      | H32111D304 | Screw                             | 6          | 6          | 3/32 (56) ×4     |
| E17      | H4721F8001 | Washer                            | 2          | 2          |                  |
| E18      | H3204D6513 | Felt                              | 1          | 1          |                  |
| E19      | H4722F8001 | Needle bar connecting stud        | 1          | 1          |                  |
| E20      | H32111D604 | Screw                             | 1          | 1          | 9/64 (40) ×8.5   |
| E21      | H4806F8001 | Needle bar                        | 1          | 1          |                  |
| E22      | H4725F8001 | Vibrating presser bar             | 1          | 1          |                  |
| E23      | H3400C2020 | Bolt                              | 1          | 1          |                  |
| E24      | H3200I2030 | Washer                            | 1          | 1          |                  |
| E25      | H3400C2010 | Needle bar guide                  | 1          | 1          |                  |
| E26      | H4726F8001 | Vibrating presser bar link        | 1          | 1          |                  |
| E27      | H4753E8001 | Screw                             | 2          | 2          | 11/64 (40) ×17.5 |
| E28      | H4728F8001 | Vibrating presser bar guide       | 1          | 1          |                  |
| E29      | H4729F8001 | Spring                            | 1          | 1          |                  |
| E30      | H4730F8001 | Vibrating presser spring guide    | 1          | 1          |                  |
| E31      | H3410C301P | Square block                      | 1          | 1          |                  |
| E32      | H3406C0671 | Screw                             | 1          | 1          | 15/64(28)×10     |
| E33      | H3406C0672 | Needle bar vibrating crank(left)  | 1          | 1          |                  |
| E34      | H4734F8001 | Washer                            | 1          | 1          |                  |
| E35      | H3204B0652 | Bushing                           | 2          | 2          |                  |
| E36      | H602040240 | Taper pin                         | 1          | 1          | GB/T117 4×24     |
| E37      | H4736F8001 | Needle bar vibrating shaft        | 1          | 1          |                  |
| E38      | H7107F8001 | Nut                               | 1          | 1          |                  |
| E39      | H2012N0652 | Screw                             | 1          | 1          | 1/4 (24) ×16     |
| E40      | H7108F8001 | Screw                             | 1          | 1          | 5/16 (24) ×5     |
| E41      | H32311D406 | Oil wick                          | 1          | 1          |                  |
| E42      | H7104F8001 | Needle bar vibrating crank(right) | 1          | 1          |                  |
| E43      | H7105F8001 | Connecting link                   | 1          | 1          |                  |

## E.TAKE-UP THREAD AND ARM SHAFT MECHANISM

| Fig. No. | Part No.   | Description            | GC24698-1L | GC24698-1R | Remarks        |
|----------|------------|------------------------|------------|------------|----------------|
| E44      | H3129F0693 | Thread guide           | 1          | 1          |                |
| E45      | HA100C2170 | Screw                  | 1          | 1          | 1/8 (44) ×4.5  |
| E46      | H3129F0691 | Screw                  | 1          | 1          | 3/32 (56) ×2.5 |
| E47      | H7106F8001 | Vibrating presser foot | 1          | 1          |                |
| E48      | HA700F2100 | Screw                  | 1          | 1          | 11/64 (40) ×7  |



# F. STITCH REGULATOR MECHANISM

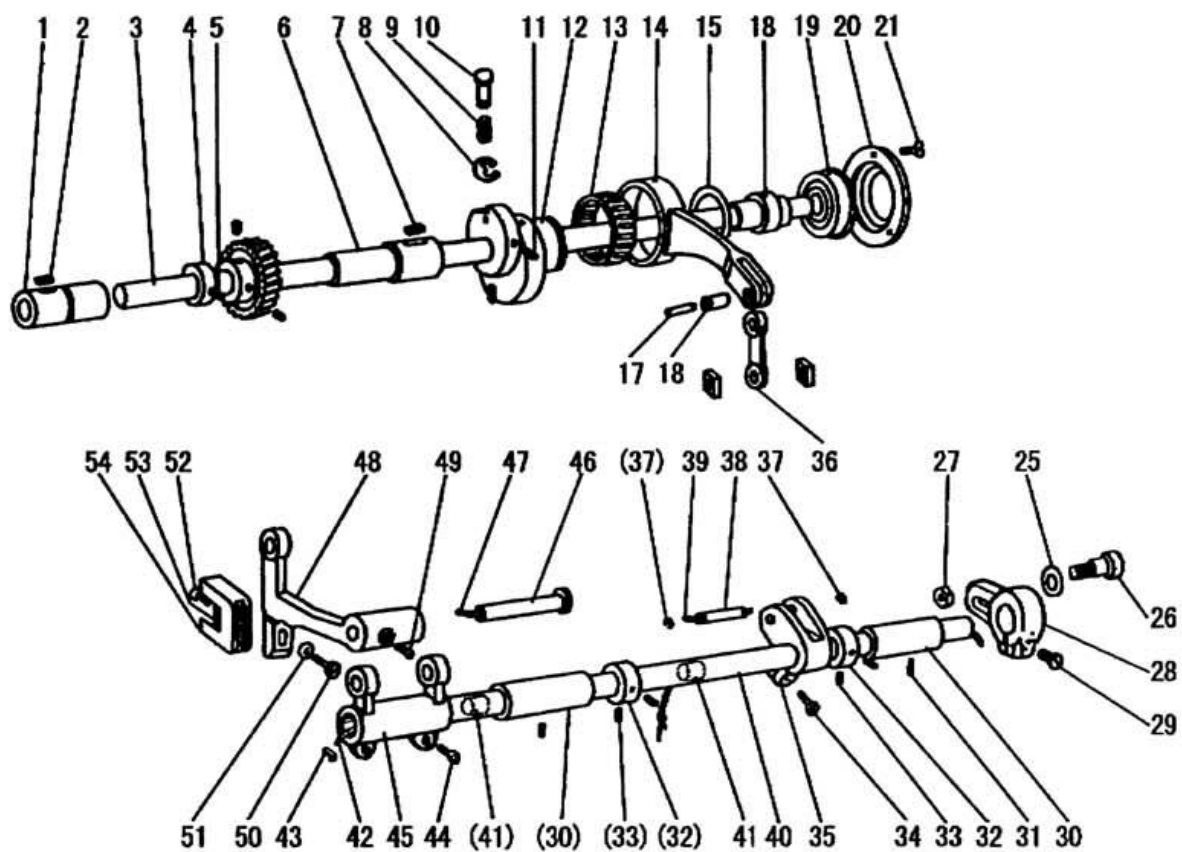


## F.STITCH REGULATOR MECHANISM

| Fig. No. | Part No.   | Description                    | GC24698-IL | GC24698-IR | Remarks           |
|----------|------------|--------------------------------|------------|------------|-------------------|
| F01      | H4706G8001 | Feed regulator                 | 1          | 1          |                   |
| F02      | HA113F0684 | Screw                          | 2          | 2          | 15/64 (28) × 8.5  |
| F03      | H3200F2020 | Screw                          | 1          | 1          | 15/64 (28) × 12   |
| F04      | H7104G8001 | Link                           | 1          | 1          |                   |
| F05      | HA100G2070 | Eccentric shaft                | 1          | 1          |                   |
| F06      | H4709G8001 | Reverse stitch shaft           | 1          | 1          |                   |
| F07      | H3207F0671 | Reverse stitch crank           | 1          | 1          |                   |
| F08      | HA800F2020 | Screw                          | 1          | 1          | 15/64 (28) × 13.5 |
| F09      | HA100F2110 | Washer                         | 1          | 1          |                   |
| F10      | HA113F0684 | Screw                          | 2          | 2          | 15/64 (28) × 8.5  |
| F11      | H4711G8001 | Feed reversing lever           | 1          | 1          |                   |
| F12      | H3207F0672 | Screw                          | 1          | 1          | 11/64 (40) × 8.5  |
| F13      | H4710G8001 | Spring                         | 1          | 1          |                   |
| F14      | H7105G8001 | Spring hook                    | 1          | 1          |                   |
| F15      | H3200F2050 | Bracket for spring             | 1          | 1          |                   |
| F16      | HA300C2030 | Screw                          | 5          | 5          | 11/64 (40) × 8    |
| F17      | H3200F2110 | Spring                         | 1          | 1          |                   |
| F18      | HA100F2080 | Stopper pin                    | 1          | 1          |                   |
| F19      | HA720F0686 | Screw                          | 1          | 1          | 3/16(28)×18       |
| F20      | HA720F0685 | Bushing                        | 1          | 1          |                   |
| F21      | H7107G8001 | Stitch length indicating plate | 1          | 1          |                   |
| F22      | HA7421F120 | Dial                           | 1          | 1          |                   |
| F23      | HA720F0683 | Stopper pin releasing          | 1          | 1          |                   |
| F24      | HA720F0687 | Spring                         | 1          | 1          |                   |
| F25      | HA109F0671 | Screw bar                      | 1          | 1          |                   |
| F26      | HA109F0674 | O-ring                         | 1          | 1          |                   |
| F27      | H3206F0662 | Pin                            | 1          | 1          |                   |
| F28      | H415050060 | Screw                          | 1          | 1          | M5×6              |
| F29      | H7109G8001 | Reverse stitch shaft crank     | 1          | 1          |                   |
| F30      | H428050200 | Screw                          | 2          | 2          | M5×20             |
| F31      | H4716G8001 | Coolar                         | 1          | 1          |                   |
| F32      | HA3411D308 | Screw                          | 2          | 2          | 15/64(28)×7       |
| F33      | H4719G8001 | Felt                           | 1          | 1          |                   |
| F34      | H4720G8001 | Reverse bar                    | 1          | 1          |                   |
| F35      | H4721G8001 | Felt                           | 1          | 1          |                   |
| F36      | H4722G8001 | Square block                   | 2          | 2          |                   |
| F37      | H4723G8001 | Guide plate                    | 2          | 2          |                   |

# G. LOWER SHAFT & FEED ROCK SHAFT MECHANISM

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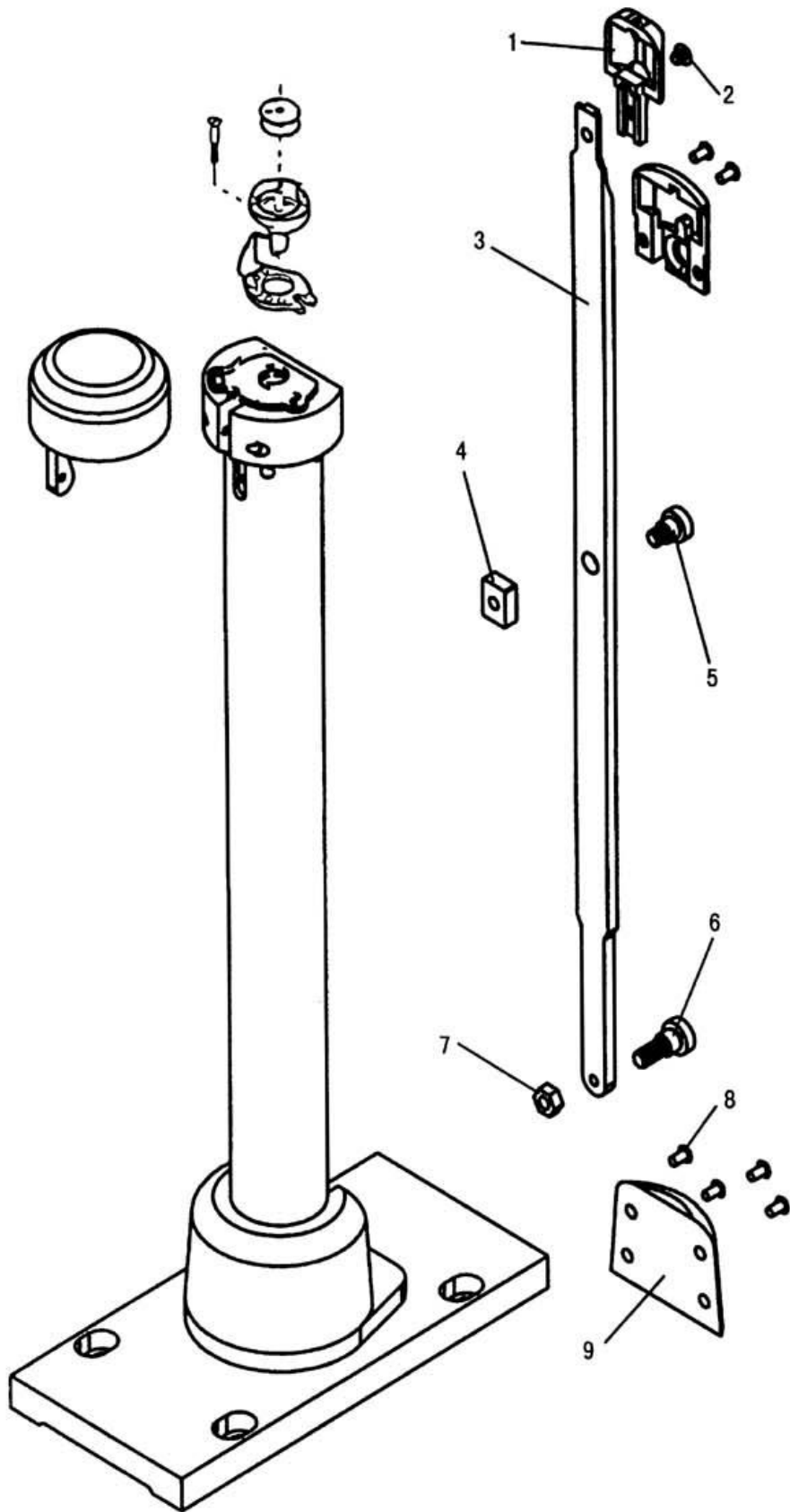
## G.LOWER SHAFT & FEED ROCK SHAFT MECHANISM

| Fig. No. | Part No.   | Description                          | GC24698-IL | GC24698-IR | Remarks      |
|----------|------------|--------------------------------------|------------|------------|--------------|
| G01      | H4706H8001 | Lower shaft bushing(left)            | 1          | 1          |              |
| G02      | H4707H8001 | Oil wick                             | 1          | 1          |              |
| G03      | H7107H8001 | Lower shaft                          | 1          | 1          |              |
| G04      | H4710H8001 | Feed lifting cam                     | 1          | 1          |              |
| G05      | H3205H0654 | Set screw                            | 1          | 1          | 1/4(40)×5    |
| G06      | H4712H8001 | Lower shaft bushing(right)           | 1          | 1          |              |
| G07      | H4713H8001 | Oil wick                             | 1          | 1          |              |
| G08      | H007013050 | Stop ring                            | 2          | 2          | GB/T896 5    |
| G09      | H4714H8001 | Spring                               | 1          | 1          |              |
| G10      | H4715H8001 | Push button                          | 1          | 1          |              |
| G11      | H2405D0664 | Screw                                | 2          | 2          | 15/64(28)×14 |
| G12      | H4717H8001 | Feed eccentric                       | 1          | 1          |              |
| G13      | H4718H8001 | Feed connecting rod                  | 1          | 1          |              |
| G14      | H4719H8001 | Needle bearing                       | 1          | 1          |              |
| G15      | H007009260 | C-type stop ring                     | 1          | 1          | GB/T894.1 26 |
| G16      | H4720H8001 | Oil wick                             | 1          | 1          |              |
| G17      | H4721H8001 | Shaft                                | 1          | 1          |              |
| G18      | H4722H7101 | Lower shaft bushing complete(middle) | 1          | 1          |              |
| G19      | H3904B0656 | Ball bearing                         | 1          | 1          |              |
| G20      | H4727H8001 | Bearing holder                       | 1          | 1          |              |
| G21      | HA7311C306 | Screw                                | 3          | 3          | 9/64 (40) ×7 |
| G25      | H4728H8001 | Washer                               | 1          | 1          |              |
| G26      | H4729H8001 | Screw                                | 1          | 1          | M6(0.75)×24  |
| G27      | H003055060 | Nut                                  | 1          | 1          | M6×0.75      |
| G28      | H7105H8001 | Feed connection crank (right)        | 1          | 1          |              |
| G29      | H2012N0652 | Screw                                | 1          | 1          | 1/4 (24) ×16 |
| G30      | HA100G2120 | Feed rock shaft bushing              | 2          | 2          |              |
| G31      | H4708D8001 | Screw                                | 2          | 2          | 1/4(24)×13   |
| G32      | HA108G0661 | Collar                               | 2          | 2          |              |
| G33      | HA105D0662 | Screw                                | 4          | 4          | 1/4 (40) ×4  |
| G34      | H2012N0652 | Screw                                | 1          | 1          | 1/4 (24) ×16 |
| G35      | H4736H8001 | Feed connection crank (middle)       | 1          | 1          |              |
| G36      | H4737H8001 | Link                                 | 1          | 1          |              |
| G37      | H007013050 | E-type stop ring                     | 2          | 2          | GB/T896 5    |
| G38      | H4738H8001 | Pin                                  | 1          | 1          |              |
| G39      | H4739H8001 | Oil wick                             | 1          | 1          |              |
| G40      | H3204G0651 | Feed rock shaft                      | 1          | 1          |              |
| G41      | H4740H8001 | Felt                                 | 2          | 2          |              |
| G42      | H3204G0031 | Oil wick                             | 1          | 1          |              |
| G43      | H3200G2030 | Clip                                 | 1          | 1          |              |
| G44      | HA104G1012 | Screw                                | 2          | 2          | 3/16(28)×12  |
| G45      | H3205G1032 | Feed connection crank (left)         | 1          | 1          |              |
| G46      | H32243G205 | Feed bar shaft                       | 1          | 1          |              |

## G.LOWER SHAFT & FEED ROCK SHAFT MECHANISM

| Fig. No. | Part No.   | Description                | GC24698-IL | GC24698-IR | Remarks        |
|----------|------------|----------------------------|------------|------------|----------------|
| G47      | H3205G0662 | Oil wick                   | 1          | 1          |                |
| G48      | H7106H8001 | Feed bar                   | 1          | 1          |                |
| G49      | H429050050 | Screw                      | 1          | 1          |                |
| G50      | H3200H2040 | Screw                      | 1          | 1          | 15/64(28)×20.5 |
| G51      | H2013J0065 | Washer                     | 1          | 1          |                |
| G52      | H3205H0653 | Screw                      | 1          | 1          | 1/8(44)×4      |
| G53      | H3205H0652 | Felt                       | 1          | 1          |                |
| G54      | H4743H8001 | Feed bar forked connection | 1          | 1          |                |

# H. FEED BAR MECHANISM

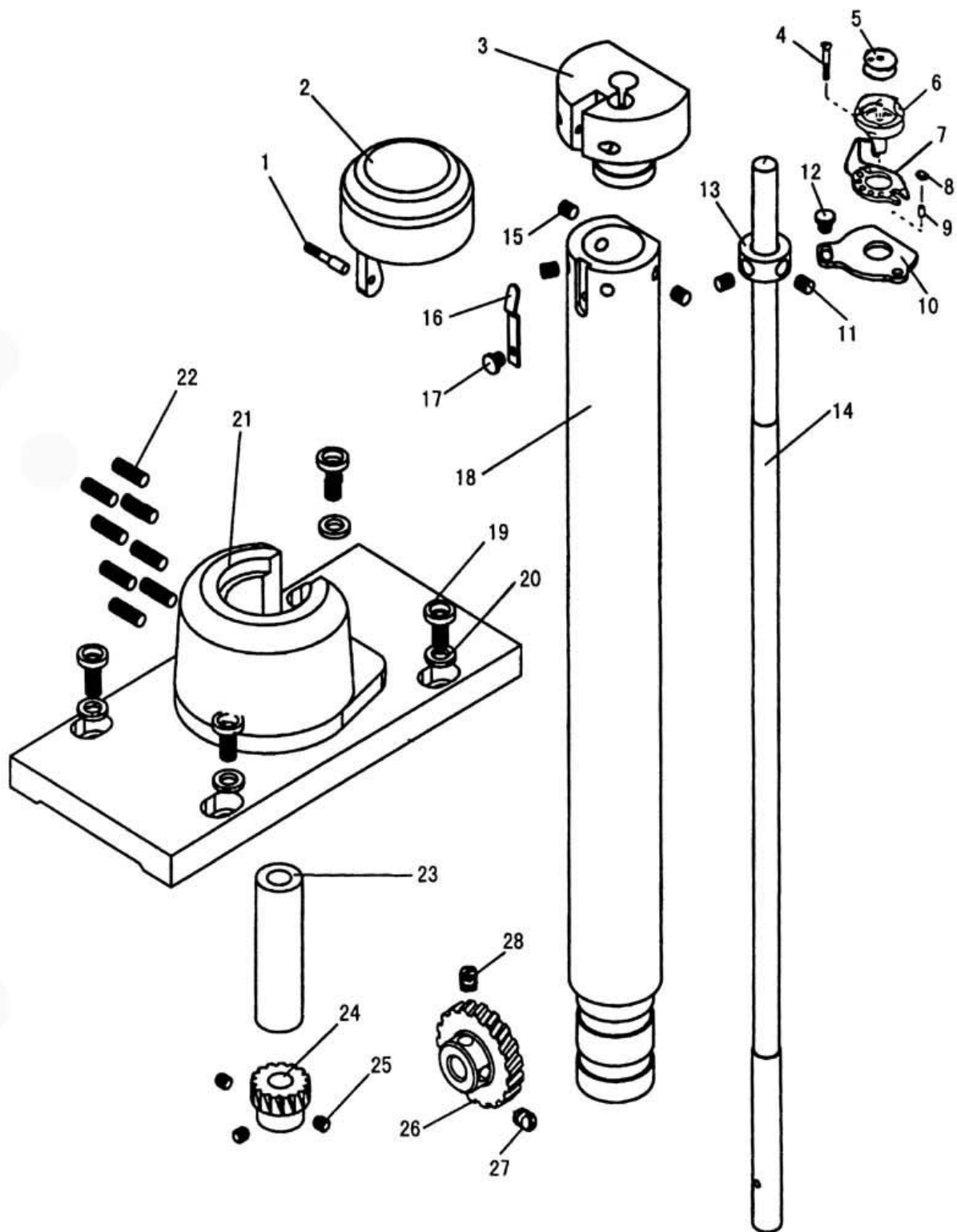


## H.FEED BAR MECHANISM

| Fig. No. | Part No.   | Description  | GC24698-1L | GC24698-1R | Remarks      |
|----------|------------|--------------|------------|------------|--------------|
| H01      | H7107I8002 | Feed dog     | 1          | 1          |              |
| H02      | H7108I8001 | Screw        | 1          | 1          |              |
| H03      | H7104I8001 | Feed bar     | 1          | 1          |              |
| H04      | H7105I8001 | Square block | 1          | 1          |              |
| H05      | H7106I8001 | Screw        | 1          | 1          |              |
| H06      | H7113I8001 | Screw        | 1          | 1          |              |
| H07      | H3208G0675 | Nut          | 1          | 1          |              |
| H08      | HA300B2160 | Screw        | 4          | 4          | 11/64(40)×10 |
| H09      | H7109I8001 | Cover plate  | 1          | 1          |              |



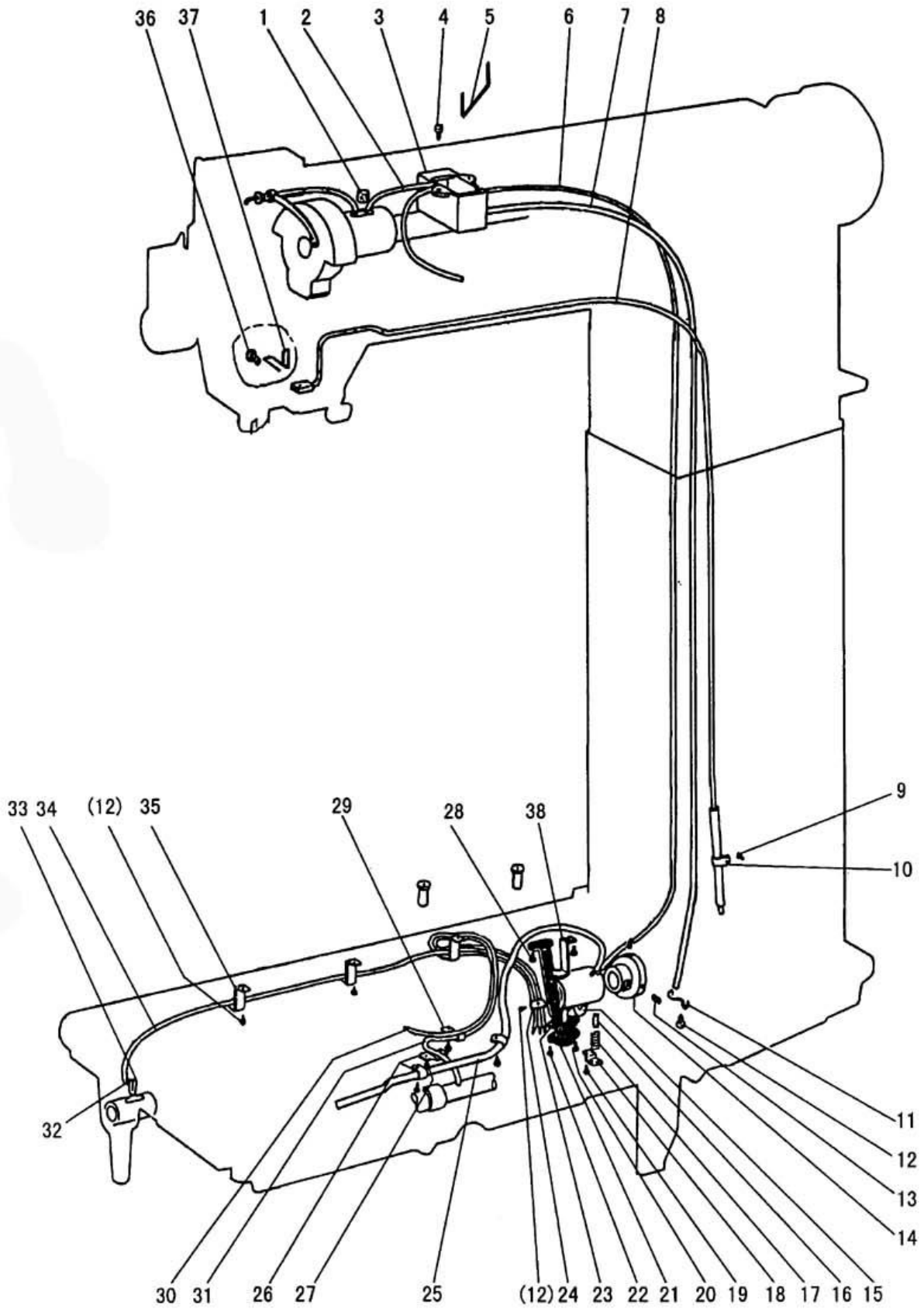
# I. HOOK SADDLE MECHANISM



# I.HOOK SADDLE MECHANISM

| Fig. No. | Part No.   | Description          | GC24698-1L | GC24698-1R | Remarks        |
|----------|------------|----------------------|------------|------------|----------------|
| I01      | H7124J8001 | Screw                | 1          | 1          |                |
| I02      | H7123J8001 | Slide plate          | 1          | 1          |                |
| I03      | H7109J8001 | Hook saddle          | 1          | 1          |                |
| I04      | H5337D8001 | Screw                | 3          | 3          | 9/64(36)×30    |
| I05      | H2400I2020 | Bobbin               | 1          | 1          |                |
| I06      | H7127J7101 | Hook                 | 1          | 1          |                |
| I07      | H7125J8001 | Opener               | 1          | 1          |                |
| I08      | H41622D216 | Square block         | 4          | 4          |                |
| I09      | H410270D16 | Pin                  | 1          | 1          |                |
| I10      | H7115J8001 | Cover plate          | 1          | 1          |                |
| I11      | HA105D0662 | Screw                | 1          | 1          | 1/4 (40) ×4    |
| I12      | H2204C0651 | Screw                | 1          | 1          | 9/64(40)×6.5   |
| I13      | H7106J8001 | Collar               | 1          | 1          |                |
| I14      | H7104J8002 | Hook shaft           | 1          | 1          |                |
| I15      | H3210F0681 | Screw                | 1          | 1          | M5×6           |
| I16      | H7122J8001 | Spring               | 1          | 1          |                |
| I17      | H3204D6511 | Screw                | 1          | 1          | 1/8(44)×3.5    |
| I18      | H7113J8001 | Hook saddle post bed | 1          | 1          |                |
| I19      | H415080200 | Screw                | 4          | 4          | GB/T70.1 M8×20 |
| I20      | H005004080 | Washer               | 4          | 4          | GB/T848 8      |
| I21      | H7116J8001 | supporter            | 1          |            |                |
| I21      | H7904J8001 | supporter            |            | 1          |                |
| I22      | H2000H2020 | Screw                | 1          | 1          | 15/64(28)×14   |
| I23      | H7121J8001 | Bushing              | 1          | 1          |                |
| I24      | H4705I8001 | Gear (small)         | 1          | 1          |                |
| I25      | HA105D0662 | Screw                | 3          | 3          | 1/4 (40) ×4    |
| I26      | H4706I8001 | Gear (Big)           | 1          | 1          |                |
| I27      | H4707I8001 | Screw                | 1          | 1          | 1/4(40)×6.5    |
| I28      | HA307C0662 | Screw                | 1          | 1          | 1/4 (40) ×6    |

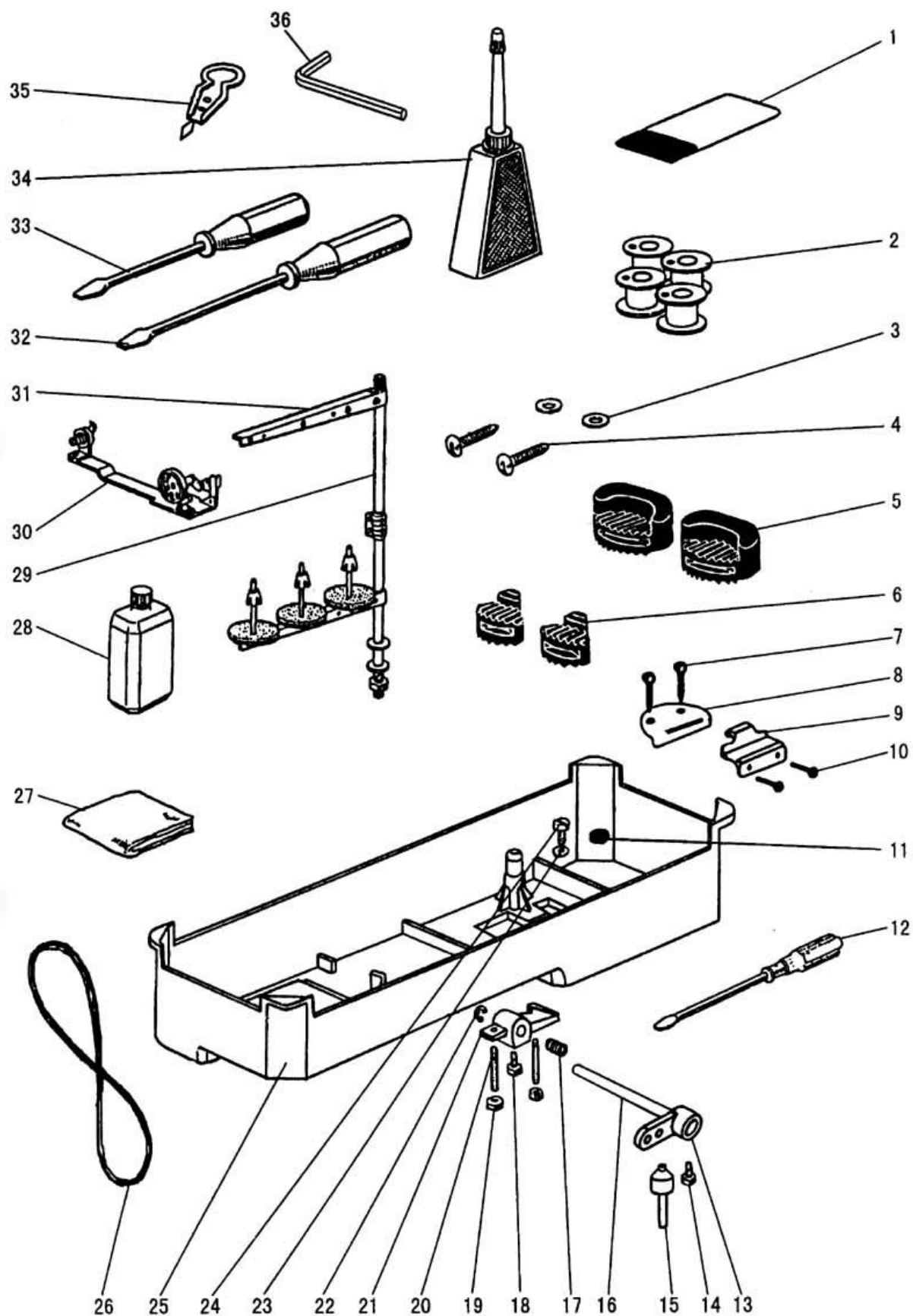
# J. OIL LUBRICATION MECHANISM



## J.OIL LUBRICATION MECHANISM

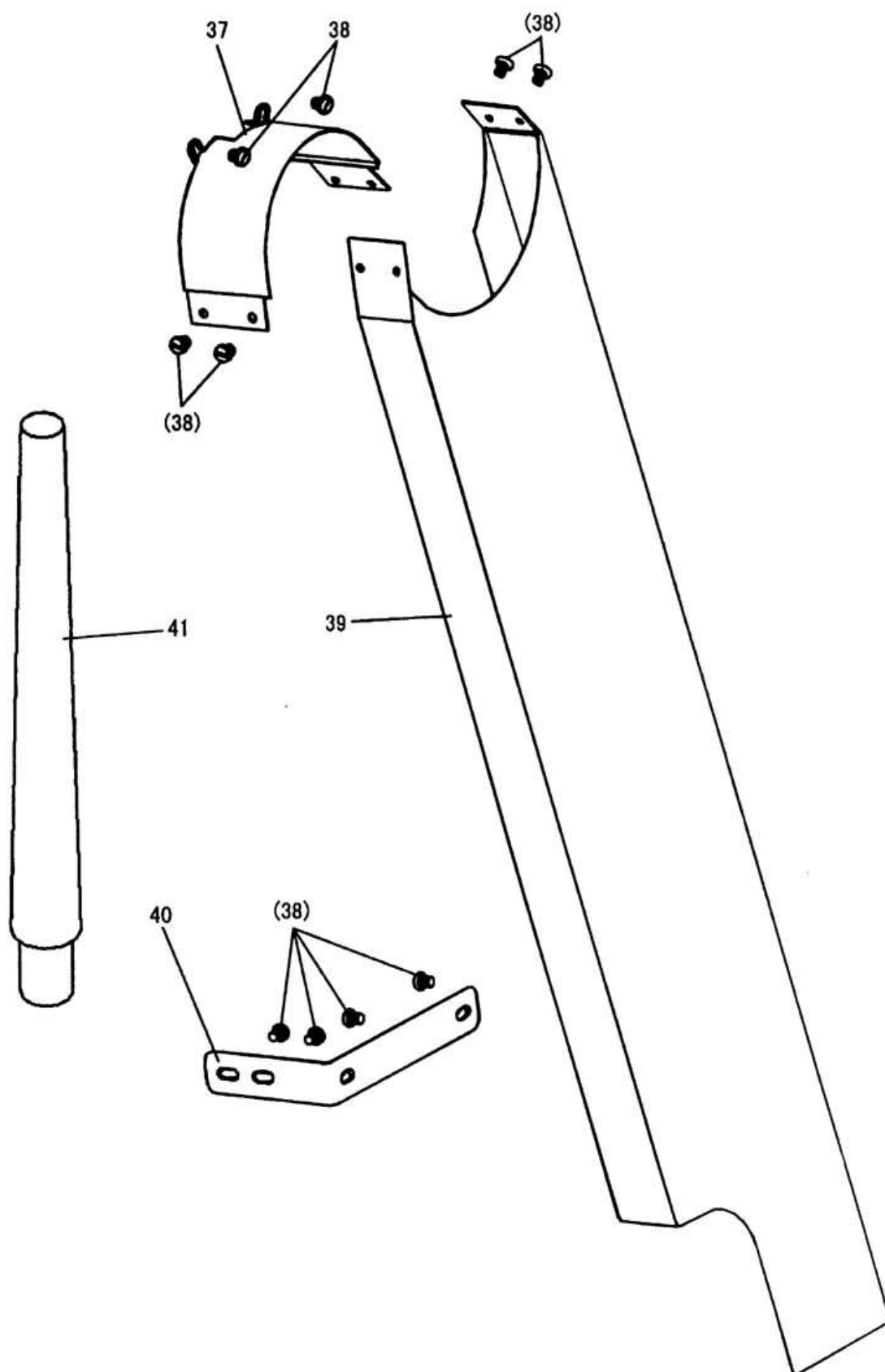
| Fig. No. | Part No.   | Description              | GC24698-1L | GC24698-1R | Remarks         |
|----------|------------|--------------------------|------------|------------|-----------------|
| J01      | H4731J8001 | Holder                   | 1          | 1          |                 |
| J02      | H4705J7101 | Oil pipe & wick complete | 1          | 1          |                 |
| J03      | H3204K0011 | Oil tank complete        | 1          | 1          |                 |
| J04      | H411040160 | Screw                    | 2          | 2          | GB/T819.1 M4×16 |
| J05      | H4707J8001 | Holder                   | 1          | 1          |                 |
| J06      | H7109K8001 | Oil pipe                 | 1          | 1          |                 |
| J07      | H7110K8001 | Oil pipe                 | 1          | 1          |                 |
| J08      | H7111K7101 | Oil pipe complete        | 1          | 1          |                 |
| J09      | HA7311CC06 | Screw                    | 1          | 1          | 9/64(40)×6.5    |
| J10      | H2000M0110 | Holder                   | 1          | 1          |                 |
| J11      | H4714J8001 | Holder                   | 1          | 1          |                 |
| J12      | HA106B0676 | Screw                    | 8          | 8          | 9/64 (40) ×6    |
| J13      | H3230K0751 | Set screw                | 2          | 2          | 11/64(40)×10    |
| J14      | H4716J8001 | Bushing                  | 1          | 1          |                 |
| J15      | H3215K0696 | Oil pipe                 | 1          | 1          |                 |
| J16      | H1100I2070 | Plunger                  | 1          | 1          |                 |
| J17      | H1100I2090 | Coil spring              | 1          | 1          |                 |
| J18      | H1100I2110 | Guide plate              | 1          | 1          |                 |
| J19      | H3204D6510 | Screw                    | 1          | 1          | 1/8 (44) ×4.8   |
| J20      | H3215K0693 | Screw                    | 1          | 1          | 9/64 (40) ×5    |
| J21      | H3215K0692 | Filter                   | 1          | 1          |                 |
| J22      | H3215K0694 | Screw                    | 4          | 4          | 9/64 (40) ×7    |
| J23      | H4718J7101 | Base plate complete      | 1          | 1          |                 |
| J24      | H4720J8001 | Holder                   | 1          | 1          |                 |
| J25      | H4805J8001 | Oil pipe                 | 1          | 1          |                 |
| J26      | H2000M0110 | Holder                   | 3          | 3          |                 |
| J27      | HA106B0676 | Screw                    | 1          | 1          | 9/64 (40) ×6    |
| J28      | HA100E2150 | Screw                    | 2          | 2          | 11/64 (40) ×10  |
| J29      | H3200K0170 | Holder                   | 1          | 1          |                 |
| J30      | H4728J7101 | Oil pipe & wick complete | 1          | 1          |                 |
| J31      | H3216K0070 | Oil pipe & wick complete | 1          | 1          |                 |
| J32      | H3216K0701 | Oil wick                 | 1          | 1          |                 |
| J33      | H3200K0180 | Oil wick                 | 1          | 1          |                 |
| J34      | H4726J8001 | Oil pipe                 | 1          | 1          |                 |
| J35      | H3200K0160 | Holder                   | 3          | 3          |                 |
| J36      | H4731J8001 | Holder                   | 1          | 1          |                 |
| J37      | HA100C2040 | Screw                    | 1          | 1          | 11/64(40)×5.5   |
| J38      | H4722J8001 | Supporter                | 1          | 1          |                 |

# K. ACCESSORIES ( I )



K. ACCESSORIES ( I )

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## K.ACCESSORIES ( I )

| Fig. No. | Part No.   | Description                 | GC24698-IL | GC24698-IR | Remarks        |
|----------|------------|-----------------------------|------------|------------|----------------|
| K01      | H4705K8001 | Needle                      | 3          | 3          | DP×17 23#      |
| K02      | H2400I2020 | Bobbin                      | 2          | 2          |                |
| K03      | HA300J2230 | Washer                      | 4          | 4          |                |
| K04      | H801045200 | Wood screw                  | 4          | 4          | GB/T99 4.5×20  |
| K05      | H3200L0020 | Vibration preventing rubber | 2          | 2          |                |
| K06      | H3200L0030 | Vibration preventing rubber | 2          | 2          |                |
| K07      | H802060250 | Screw                       | 4          | 4          | GB/T100 6×25   |
| K08      | H2404K0654 | Hinge(1)                    | 2          | 2          |                |
| K09      | H2404K0655 | Hinge(2)                    | 2          | 2          |                |
| K10      | H2404K0656 | Screw                       | 4          | 4          |                |
| K11      | HA100J2120 | Magnet                      | 1          | 1          |                |
| K12      | HA300J2070 | Screw driver (larger)       | 1          | 1          |                |
| K13      | H7122L8001 | Crank                       | 1          | 1          |                |
| K14      | HA106J0664 | Screw                       | 1          | 1          | 15/64(18)×13   |
| K15      | H3214L2011 | Knee lifter pin             | 1          | 1          |                |
| K16      | H3213L0662 | Knee lifter shaft           | 1          | 1          |                |
| K17      | HA104J0657 | Spring                      | 1          | 1          |                |
| K18      | HA106J0664 | Screw                       | 1          | 1          | 15/64 (18) ×13 |
| K19      | HA104J6510 | Nut                         | 2          | 2          |                |
| K20      | HA104J0659 | Screw                       | 2          | 2          | 15/64 (28) ×28 |
| K21      | H3213L0664 | Knee lifter crank           | 1          | 1          |                |
| K22      | H007013090 | E-type ring                 | 1          | 1          | GB/T896 9      |
| K23      | HA104J0653 | Washer                      | 1          | 1          |                |
| K24      | HA104J0652 | Screw                       | 1          | 1          | 5/16 (28) ×10  |
| K25      | H3213L0661 | Oil reservoir               | 1          | 1          |                |
| K26      | H7116L8001 | M-type belt                 | 1          | 1          |                |
| K27      | H7114L8001 | Vinyl cover                 | 1          | 1          |                |
| K28      | H3200L0130 | Oil tank                    | 1          | 1          |                |
| K29      | H7112L8001 | Cotton stand pipe           | 1          | 1          |                |
| K30      | HA706S0067 | Bobbin winder               | 1          | 1          |                |
| K31      | H3200L0120 | Cotton stand                | 1          | 1          |                |
| K32      | HA100J2140 | Screw driver(middle)        | 1          | 1          |                |
| K33      | HA100J2150 | Screw driver (small)        | 1          | 1          |                |
| K34      | HA100J2110 | Oiler                       | 1          | 1          |                |
| K35      | H3207L0065 | Thread a needle kit         | 1          | 1          |                |
| K36      |            | Spanner                     | 1          | 1          | 2.5mm          |
| K37      | H2008O0068 | Belt cover (upper)          | 1          | 1          |                |
| K38      | HA300B2170 | Screw                       | 10         | 10         | 11/64 (40) ×9  |
| K39      | H7115L8001 | Belt cover                  | 1          | 1          |                |
| K40      | H7123L8001 | Belt cover stand            | 1          | 1          |                |
| K41      | H7124L8001 | Supporter                   | 1          | 1          |                |



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The description covered in this manual is subject to change for improvement of the commodity without notice

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