



®

FINEST QUALITY

PURCHASING DEPT.
Union Special®
LEWIS® • COLUMBIA®

**INDUSTRIAL
SEWING
MACHINES**

CLASSES

51200
51300
51400
51500
51700
51900



STYLE 51400BP

PURCHASING DEPT.

CATALOG

No.

104 L

SECOND EDITION

**STREAMLINED
FIFTY THOUSAND SERIES**

UNION SPECIAL CORPORATION

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Union Special Wants to Help You Cut Sewing Machine Maintenance Costs

Union Special is offering two practical systems to help pinpoint and reduce your sewing machine maintenance costs: a record keeping system to help spot machines requiring abnormally high maintenance, and a parts inventory system to speed routine repairs.

Machine Maintenance Records

Repair-prone machines or inexperienced competent operators can eat up your maintenance dollars in short order. To help spot these problems, Union Special suggests two variations of a simple maintenance record keeping system using cards provided by Union Special.

The first system utilizes a "Machine Maintenance Record" card (Form 237) for each sewing machine in a plant. When a repair is required, the card is pulled from the file and the repair date, parts used, and their cost are entered in the spaces provided and the card is refilled.

The second system is normally used when more detailed information on repair costs is desired. Two record cards are used: a "Repair Request Card" (Form 234), and a "Machine Repair Record" (Form 233). When a machine requires service, the forelady or foreman fills out the top of a "Repair Request Card" and gives it to a mechanic. He fills in the time the repair work is started, the parts used and their cost,

and the completion time. This data is then transferred to the permanent "Machine Repair Record" kept in the office.

Whichever system is used, management now has an invaluable tool to reduce needless maintenance costs.

Repair Part Inventories

While record keeping tells management which machines require abnormally high maintenance, it does little to help reduce the downtime caused by routine repairs. To alleviate this situation, Union Special recommends that manufacturers establish a formal parts inventory system for each type of sewing machine they operate.

Excessive machine downtime and wasted hours by mechanics can be eliminated with an orderly in-plant inventory of the most commonly needed parts. There is no longer a need to cannibalize other machines for spare parts. Long waits for deliveries are avoided and machine downtime is kept to a minimum. The cost of a parts inventory is small when the overall savings are considered.

For free sample copies of the machine record cards and spare part inventory lists for a variety of the most popular machines, contact your local Union Special Representative or write direct to Union Special.



Style 51200 BW

Suggested Minimum Spare Parts List*

Part Number	Description	Minimum Quantity Per 5 Machines	Part Number	Description	Minimum Quantity Per 5 Machines
51220 W	Presser foot	1	15438 C	Nipper spring	2
51205 W	Feed dog	1	57 WD	Nipper spring screw	2
22528	Screw for feed dog	2	57 WB	Nipper plate	2
51224 E	Throat plate	1	73	Screw for looper	2
22570	Screw for throat plate	4	56	Needle clamp nut	2
110 GS	Needles (specify size)	100	22564	Needle bar clamp screw	2
51208 W	Looper	1	21225-5/32	Looper gauge	1
21210	Looper collar	2	29484	Screw assortment	1

*The parts and quantities listed above are intended to assist you in setting up the initial inventory of spare parts. An efficient inventory can only be established according to actual usage. The nature of the sewing operation will determine actual usage.

Catalog No. 104 L

LIST OF PARTS

CLASSES

51200, 51300, 51400, 51500, 51700, 51900

STYLES

51200 BG	51300 BM	51400 BY
51200 BK	51400 BA	51500 BJ
51200 BL	51400 BB	51500 BK
51200 BM	51400 BD	51500 BM
51200 BP	51400 BP	51500 BN
51200 BR	51400 BQ	51500 BP
51200 BS	51400 BR	51500 BR
51200 BT	51400 BS	51700 BJ
51200 BW	51400 BT	51700 BK
51200 BX	51400 BU	51700 BQ
51300 BG	51400 BV	51700 BR
51300 BH	51400 BW	51900 BG
51300 BJ	51400 BX	51900 BH
51300 BL		51900 BJ

Second Edition

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UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES

CHICAGO

Printed in U.S.A.

March, 1981

PURCHASING DEPT.

FOREWORD

The 50000 series streamlined machines covered by this catalog represent the latest design of the Union Special flatbed line. Light weight needle bars and driving mechanisms and light weight presser bars make it possible to attain the utmost in speed and production. Automatic lubrication, with a pump for returning filtered oil to the main reservoir, has made maintenance simple. All parts are made by precision methods insuring complete interchangeability.

It is our constant aim to furnish carefully prepared information that will enable the customer to secure all possible advantages from the use of UNION SPECIAL machines. The following pages illustrate and describe the parts used in all of the machines covered by this catalog.

Additional catalogs, containing information relative to these machines, and which will be furnished on request, are listed below:

Catalog No. 45 N
Form 357

Needle Manual
Engineering Department Adjusting
Instructions. Specify the style of
machine for which the adjusting
instructions are required.

In all manufacturing centers will be found Union Special representatives, who will co-operate with those who desire in planning and estimating their requirements.

NOTE: Machine Styles listed in this catalog are discontinued. In most instances, component parts can be ordered for customer repair.

UNION SPECIAL CORPORATION

IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine carries a style number which is stamped in the name plate on the machine. Style numbers are classified as standard and special. Those which are standard have one or more letters suffixed, but never contain the letter "Z". Example: "51400 BP". Style numbers containing the letter "Z" are special. When only minor changes are made in a standard machine, a "Z" is merely suffixed to the respective standard style number. Example: "51400 BPZ".

Styles of machines similar in construction are grouped under a class number which differs from the style number in that it contains no letters. Example: "51400".

The distance between the rows of stitches on machines in Classes 51400, 51500, 51700, 51900 is represented by a gauge number measured in 1/64ths of an inch. Thus, 12 gauge represents a distance of 12/64 or 3/16 inch. Similarly, 64 gauge represents a distance of 64/64 or 1 inch.

APPLICATION OF CATALOG

This catalog applies only to the standard styles of machines as listed herein. It can also be applied with discretion to the special machines in Classes 51200, 51300, 51400, 51500, 51700 and 51900.

STYLES OF MACHINES IN CLASS 51200

Streamlined Flat Bed, One Needle, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Light and Medium Duty, Single Reservoir Enclosed Automatic Lubricating System and Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

51200 BG Light duty, for seaming light to medium weight trousers and similar operations; seam Type SSa-1. Type 106 GLS needle.

51200 BK Light duty, for binding aprons, dresses and similar garments; seam Type BSc-1. Type 106 GLS needle. Uses cut edge strips, standard widths 3/4, 7/8, 1, 1 1/8 and 1 1/4 inch.

51200 BL Medium duty, for binding mattress ticks and similar operations; seam Type BSa-1. Type 126 GS needle. Uses selvage edge binding, standard widths 5/8, 7/8 and 3/4 inch.

51200 BM Medium duty, for seaming mattress ticks; seam Type SSa-1. Type 128 GAS needle.

51200 BP Light duty, for stitching side stays to shoe linings; seam Type LSa-1. Type 301 GS needle.

51200 BR Light duty, for joining shoulders on shirts and similar garments in one operation; seam Type LSe-1. Type 106 GLS needle.

51200 BS Light duty, for miscellaneous operations on knitted drawer bands and knitted shirt fronts; seam Type SSa-1. Type 101 GS needle.

51200 BT Medium duty, for facing sleeves and attaching one piece button stays to fronts and sleeves of woven shirts; seam Type BSc-1. Type 106 GLS needle. Strips used in either garment lengths or long lengths, standard widths 1/2, 3/4, 7/8 and 1 inch.

51200 BW Medium duty, for seaming canton flannel or leather palm gloves. Knee lifter. Seam Type SSa-1. Type 110 GAS needle.

51200 BX Medium duty, for seaming light weight canton flannel and jersey cloth gloves. Knee lifter. Seam Type SSa-1. Type 109 GS needle.

STYLES OF MACHINES IN CLASS 51300

Streamlined Flat Bed, One Needle, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Medium and Heavy Duty, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51300 BG Medium duty, for seaming trousers, coats and similar garments; seam Type SSa-1. Type 128 GAS needle.
- 51300 BH Heavy duty, for seaming couch covers with or without rope welt. Welt guided to left of needle, seam Type SSk-1. Type 143 GS needle.
- 51300 BJ Medium duty, for welt seaming trousers, coats and similar garments; seam Type LSb-1. Type 128 GAS needle.
- 51300 BL Heavy duty, for seaming heavy weight auto cushions and similar operations; seam Type SSa-1. Type 143 GS needle.
- 51300 BM Heavy duty, for binding mattress ticks and similar operations; seam Type BSa-1. Type 126 GS needle. Uses selvage edge binding, standard widths 5/8, 7/8 and 3/4 inch.

STYLES OF MACHINES IN CLASS 51400

Streamlined Flat Bed, Two Needle, Left Needle in Front, Independent Row, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Light and Medium Duty, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51400 BA Light duty, for folding and attaching single piece facing to sleeves of shirts and similar garments in one operation; seam Type BSc-2. Facing used in garment lengths. Type 106 GS needle. Standard gauge No. 48.
- 51400 BB Light duty, for "cut-on" button stay operation on shirts. Starts operation at neck; stitching Type EFb-2. Type 106 GHS needle. Standard gauge No. 48.
- 51400 BD Light duty, for hemming and simultaneously inserting elastic in tops and legs of knitted undergarments. Prepared for use with Galkin close coupled puller. No attachments; stitching Type EFg-2. Type 106 GS needle. Standard gauge Nos. 12 and 16.
- 51400 BP Light duty, for piecing sleeves, joining shoulders and setting sleeves of ordinary quality light weight shirts and similar garments; seam Type LSc-2. Type 106 GHS needle. Standard gauge Nos. 6, 8, 10, 12, 16 and 18.
- 51400 BQ Light duty, for one operation folding and attaching extension center plait, interlining strip and facing strip to fronts of shirts and similar garments; seam Type LSj-2. Starts operation at neck. Plaits used in garment lengths and have 1/4 inch margins on each side. Facing and interlining strips used in long lengths. Type 106 GHS needle. Standard gauge No. 48.
- 51400 BR Light duty, for folding and attaching set-on center plait and interlining strip. No body guide or lower strip folder required; seam Type LSm-2. Type 106 GHS needle. Standard gauge No. 48.
- 51400 BS Light duty, for one operation folding and attaching inside button facing to shirts and similar garments; seam Type LSk-2. Starts operation at neck. Seam produced with 1/16 inch margin on each side. Facing strip used in long lengths and guided next to feed dog. Type 106 GHS needle. Standard gauge Nos. 32 and 48.

STYLES OF MACHINES IN CLASS 51400 (Cont'd.)

- 51400 BT Light duty, for piecing sleeves, joining and setting sleeves of light and medium weight extra fine quality shirts and similar garments; seam Type LSc-2. Type 106 GHS needle. Standard gauge Nos. 8, 10, 12 and 16.
- 51400 BU Light duty, for "cut-on" button stay operations on shirts, Starts operation at neck; stitching Type EFb-2 inverted. Type 106 GHS needle. Standard gauge No. 32.
- 51400 BV Light duty, for uniting the lower edge of French drawer bands to body fabric; seam Type LSd-2. Type 101 GS needle. Standard gauge Nos. 12 and 16.
- 51400 BW Light duty, for piecing sleeves of shirts and pajamas and for joining operations on woven shorts, where the majority of the work consists of straight seams; seam Type LSc-2. Type 106 GHS needle. Standard gauge Nos. 8, 10, 12 and 16.
- 51400 BX Light duty, for quilting collar bands of shirts and similar garments; seam Type SSa-2. Type 106 GHS needle. Standard gauge Nos. 24 and 26.
- 51400 BY Light duty, for folding and attaching "set-on" button stays to fronts of work shirts and similar garments. Starts operation at neck. Seam produced with 1/32 inch margin on both sides. Stays used in garment lengths and guided next to presser foot; seam Type LSk-2. Type 106 GHS. Standard gauge No. 32.

STYLES OF MACHINES IN CLASS 51500

Streamlined Flat Bed, Two Needle, Independent Row, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Heavy Duty, Single Reservoir Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51500 BJ For felling overalls, coats, combination suits and similar garments, left needle in front; seam Type LSc-2. Type 128 GAS needle. Standard gauge Nos. 16 and 18.
- 51500 BK For seaming trousers and similar garments. Tandem needle seat. Right needle in front, seam Type SSa-2. Type 130 GS needle. 10 stitches per inch. Standard gauge No. 1.
- 51500 BM For facing bibs of overalls. Facing strip cut parallel with selvage, used in long lengths and guided next to feed dog. Left needle in front; seam Type LSk-2. Type 128 GAS needle. Standard gauge No. 18.
- 51500 BN For seaming trousers and similar garments. Tandem needle seat. Right needle in front; seam Type SSa-2. Type 130 GS needle. 7 stitches per inch. Standard gauge No. 1.
- 51500 BP For seaming windbreakers and mackinaws, coats and similar garments made from heavy weight melton and similar fabrics, left needle in front; seam Type LSb-2. Type 128 GAS needle. Standard gauge No. 18.
- 51500 BR For felling overalls and similar garments, left needle in front; seam Type LSc-2. Type 128 GAS needle. Standard gauge No. 18.

STYLES OF MACHINES IN CLASS 51700

Streamlined Flat Bed, Two Needle, Independent Row, Needles Abreast, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Driving Mechanism, Light and Heavy Duty, Single Reservoir Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51700 BJ Light duty, for one operation folding and attaching "set-on" center plait and interlining strips to fronts of shirts and similar garments. Starts operation at neck. Plaits used in garment lengths and extend 1/4 inch beyond the rows of stitching; seam Type LSm-2. Type 108 GKS needle. Standard gauge Nos. 56 and 64.

STYLES OF MACHINES IN CLASS 51700 (Cont'd.)

- 51700 BK Light duty, for one operation folding and attaching extension center plait, interlining strip and facing strips to fronts of shirts and similar garments. Starts operation at neck. Plaits used in garment lengths and extend 1/4 inch beyond the rows of stitching; seam Type LSj-2. Type 108 GKS needle. Standard gauge No. 64.
- 51700 BQ Light duty, for one operation folding and attaching "set-on" center plaits to fronts of medium weight army shirts and similar garments. Starts operation at neck. Plaits used in garments lengths and extend 1/4 inch beyond rows of stitching; seam Type LSk-2. Type 108 GKS needle. Standard gauge No. 64.
- 51700 BR Light duty, for one operation folding and attaching inside button facings to medium weight army shirts and similar garments. Starts operation at neck. Facing strip cut from body fabric, used in long lengths and guided next to feed dog. Seam has 1/16 inch margins; seam Type LSk-2. Type 108 GKS needle. Standard gauge No. 64.

STYLES OF MACHINES IN CLASS 51900

Streamlined Flat Bed, Three Needle, Left Needle in Front, Independent Row, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Light and Heavy Duty, Single Reservoir Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51900 BG Light duty, for piecing sleeves, joining shoulders and setting sleeves of light and medium weight shirts and similar garments; seam Type LSc-3. Type 108 GKS needle. Standard gauge Nos. 5, 6 and 7.
- 51900 BH Heavy duty, for seaming overalls, dungarees, coats, combination suits and similar garments; seam Type LSc-3. Type 128 GAS needle. Standard gauge Nos. 7, 8 and 9.
- 51900 BJ Heavy duty, for seaming windbreakers, mackinaws, lumber jackets and similar garments; seam Type LSb-3. Type 147 GS needle. Standard gauge No. 9.

NEEDLES

TYPE NUMBERS AND SIZES

Each needle has a type number and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number denotes the largest diameter of the blade, measured midway between the shank and the eye and is stamped in the needle shank. Collectively, the type number and size number is the complete symbol.

To have orders promptly and accurately filled, an empty package, a sample needle, or type and size number should be forwarded. Use description on label. A complete order would read: "1000 Needles, Type 108 GKS, Size 090/036".

The type numbers of the needle recommended for each style of machine covered by this catalog are given in the machine style description. Other needles are available but the ones indicated are those recommended to produce the most satisfactory results. The type numbers of the recommended needles together with their descriptions and the sizes available are listed below:

<u>Type No.</u>	<u>Description</u>
101 GS	Round shank, round point, extra short, double groove, struck groove, chromium plated - sizes 022, 025, 027, 080/032, 049, 054.
106 GS	Round shank, round point, extra short, double groove, struck groove, ball eye, chromium plated - size 090/036.
106 GHS	Round shank, round point, extra short, double groove, struck groove, ball eye, ball point, chromium plated - sizes 070/027, 075/029, 080/032, 090/036.

TYPE NUMBER AND SIZES (Continued)

<u>Type No.</u>	<u>Description</u>
106 GLS	Round shank, round point, extra short, double groove, struck groove, oversize ball eye, ball point, chromium plated - sizes 036, 040.
108 GKS	Round shank, round point, extra short, double groove, struck groove, oversize ball eye, spotted, chromium plated - sizes 080/032, 090/036, 100/040.
109 GS	Round shank, round point, extra short, double groove, struck groove, ball eye, government point, chromium plated - sizes 070/027, 090/036, 100/040, 110/044, 125/049, 140/054.
110 GAS	Round shank, round point, extra short, double groove, struck groove, ball eye, long spot, government point, chromium plated - sizes 090/036, 100/040, 110/044, 125/049.
126 GS	Round shank, round point, short, double groove, struck groove, ball eye, chromium plated - sizes 080/032, 100/040, 054.
128 GAS	Round shank, round point, short, double groove, struck groove, ball eye, spotted, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060, 170/067.
130 GS	Round shank, round point, short, double groove, struck groove, ball eye, spotted, government point, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060.
143 GS	Round shank, round point, No. 2 bag, double groove, struck groove, spotted, chromium plated - sizes 140/054, 150/060, 170/067.
147 GS	Round shank, round point, long, double groove, struck groove, ball eye, spotted, short point, undersize eye in grooves, one step reduction, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060, 170/067.
301 G	Round shank, stay point, extra short, double groove, chromium plated - sizes 085/034, 100/040.
306 GS	Round shank, stay point, extra short, double groove, struck groove, ball eye, chromium plated - sizes 090/036, 100/040, 110/044, 125/049, 140/054.

ORDERING REPAIR PARTS

ILLUSTRATIONS

This catalog has been so arranged as to simplify the ordering of repair parts. Exploded views of the various sections of the mechanism are shown so that the parts may be seen in their actual position in the machine. On the page opposite the illustration will be found the listing of the parts with their part numbers, descriptions and the number of pieces required in the particular view being shown.

The numbers in the first column are reference numbers only and indicate the position of that part in the illustration. The reference number should never be used in ordering parts. Always use the part number shown in the second column.

Those component parts of sub-assemblies which can be furnished for repairs are indicated by the fact that their descriptions are indented under the description of the main sub-assembly. Example:

3	29105 Z	Looper Drive Eccentric Assembly, for Styles in Classes 51300, 51500; Styles 51200 BL, BM, BT, BW, BX; 51900 BH, BJ--1
4	22559 A	Bearing Cap Screw, lower -----2
5	22559 B	Bearing Cap Screw, upper -----2
6	22894 C	Eccentric Set Screw -----4
7	22894 D	Eccentric Spot Screw -----1

It will be noted in the above example that the eccentric, ball stud and bearing are not listed. The reason for this is that the replacement of any of these parts individually is not recommended and the complete sub-assembly should be ordered.

ORDERING REPAIR PARTS

ILLUSTRATIONS (Continued)

In those cases where a part is common to all of the machines covered by this catalog, no specific usage will be mentioned in the description. However, when the parts for the various machines are not the same, the specific usage will be mentioned in the descriptions and, if necessary, the difference will be shown in the illustration.

At the back of the book will be found a numerical index of all the parts shown in the illustrations, which will facilitate locating the illustration and description when only the part number is known.

IDENTIFYING PARTS

Where the construction permits each part is stamped with its part number. On some smaller parts and on those where the construction does not permit, an identification letter is stamped to distinguish the part from similar ones.

All part numbers represent the same part, regardless of the catalog in which they appear.

USE GENUINE REPAIR PARTS

Success in the operation of these machines can be secured only by the use of genuine UNION SPECIAL Repair Parts as furnished by the Union Special Corporation, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles and made with the utmost precision. The maximum efficiency and durability are assured.

TERMS

Prices are strictly net cash and subject to change without notice. All shipments are forwarded at the buyer's risk f.o.b. shipping point. Parcel post shipments are insured unless otherwise directed. A charge is made to cover the postage and insurance.

OILING AND THREADING INSTRUCTIONS

The oil has been drained from the machine before shipping and the reservoir must be filled before beginning to operate. Use a straight mineral oil with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit.

Oil is filled at the spring cap in the top cover and the level is checked at the sight gauge on the front of the machine. The oil level should be maintained between the red lines on the gauge. The capacity of the oil reservoir is 12 ounces.

The machine is automatically lubricated and no oiling other than keeping the main reservoir filled is necessary.

A daily check before the morning start should be made and oil added if required. Oil which has gone through the machine is filtered and pumped back into the main reservoir making too frequent oilings unnecessary. Excessive oil in the main reservoir may be drained at the plug screw in the main frame directly under the handwheel.

The accompanying drawing also shows the manner in which a two needle machine is threaded. Single and three needle machines are threaded in substantially the same manner. The looper threading of the various classes is indicated in the inserts.

FILL
MAIN
RESERVOIR
HERE

KEEP OIL
LEVEL
BETWEEN
LINES

Union Special!

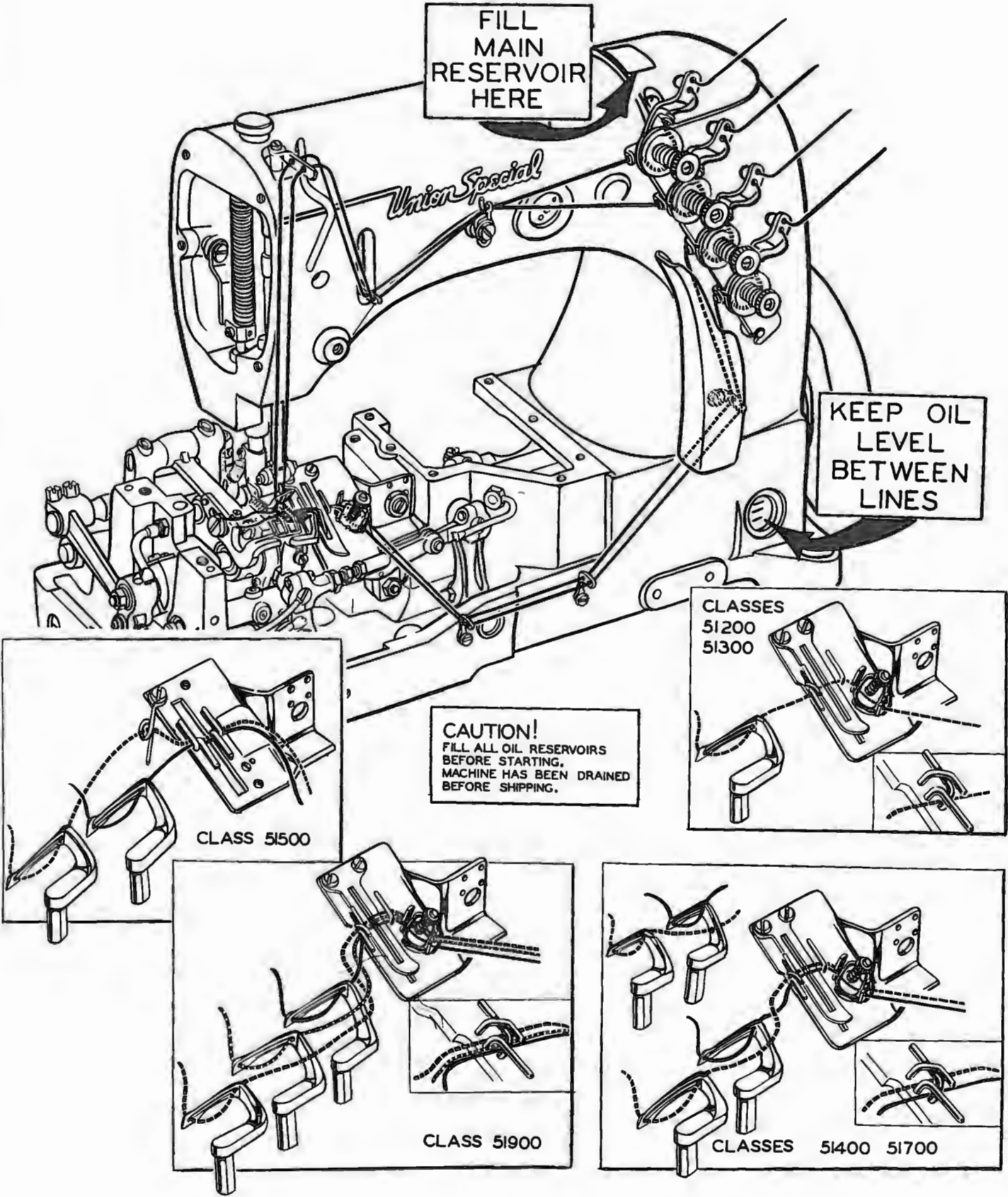
CAUTION!
FILL ALL OIL RESERVOIRS
BEFORE STARTING.
MACHINE HAS BEEN DRAINED
BEFORE SHIPPING.

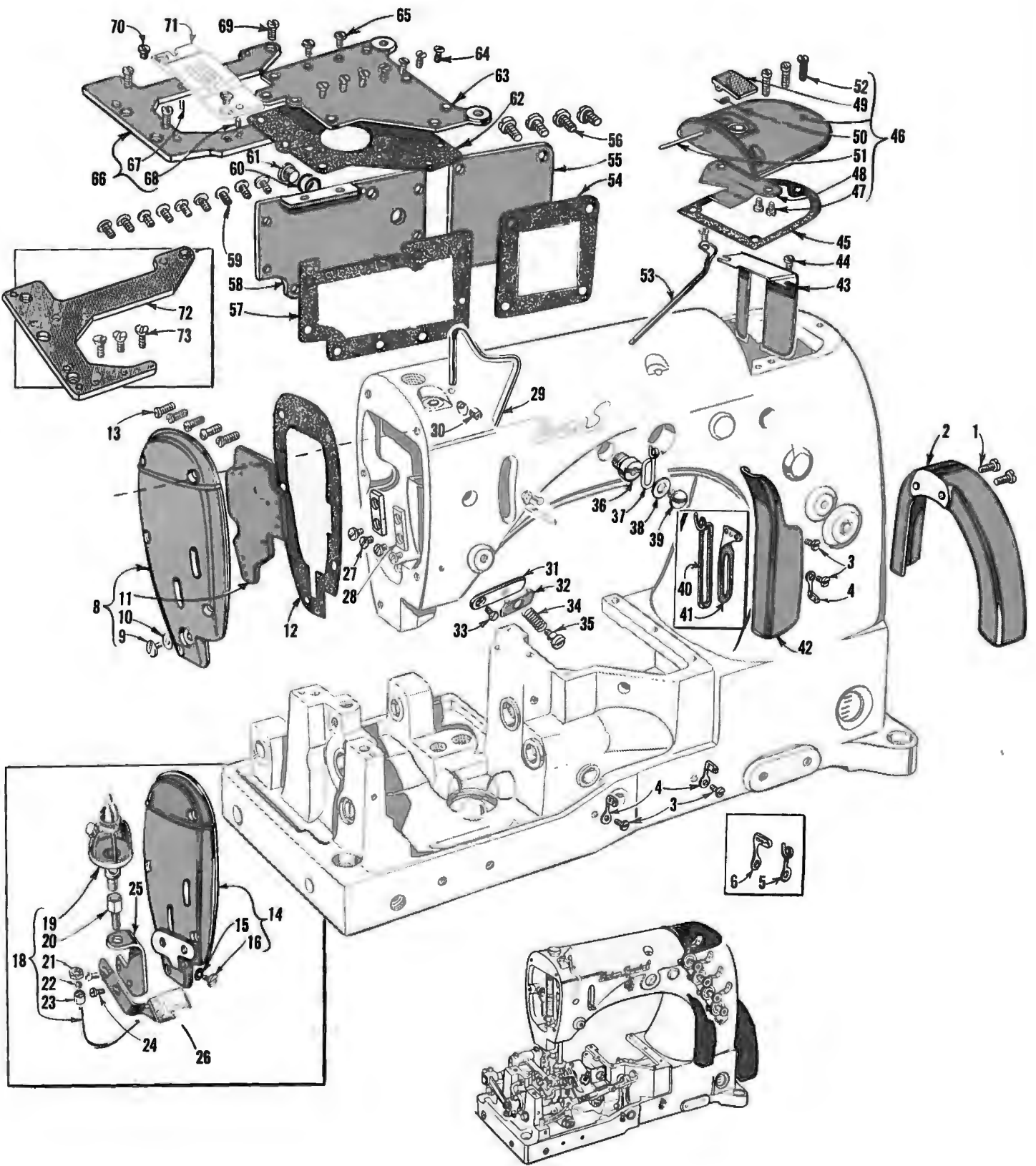
CLASSES
51200
51300

CLASS 51500

CLASS 51900

CLASSES 51400 51700



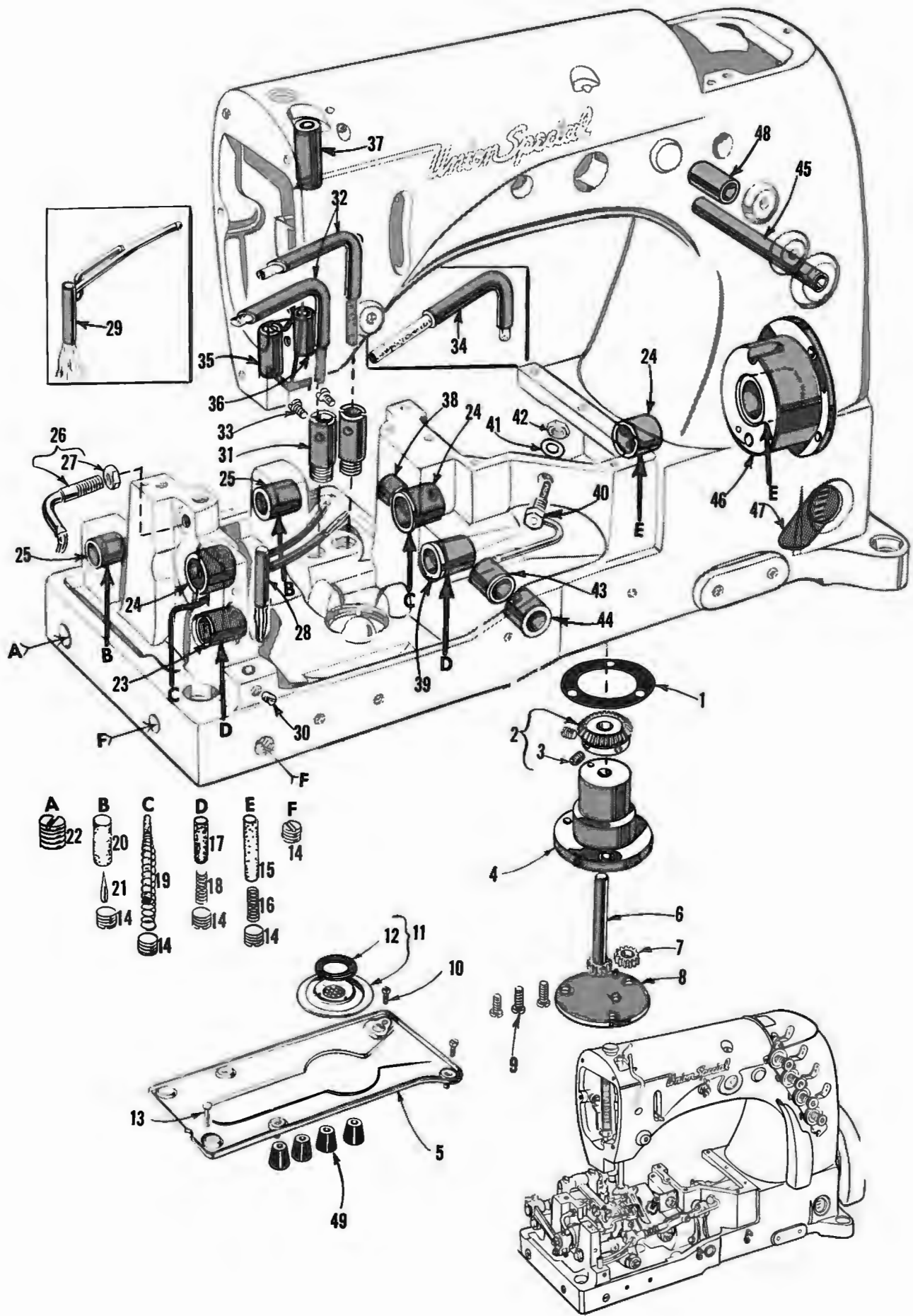


MAIN FRAME, MISCELLANEOUS COVERS AND PLATES

Ref. No.	Part No.	Description	Amt. Req.
1	93	Screw	2
2	B21375 AH	Belt Guard	1
3	98 A	Screw	4
4	158 B	Thread Eyelet, for two needle machines	3
5	52 A	Thread Eyelet, for one needle machines	3
6	158 A	Thread Eyelet, for three needle machines	3
8	51282 Y	Head Cover, for Styles in Classes 51200, 51300, 51900; Styles 51400 BA, BB, BD, BP, BS, BT, BU, BV, BW, BX, BY; 51500 BJ, BK, BM, BN, BR; 51700 BR	1
9	22542	Screw	1
10	52882 W	Gasket	1
11	51282 AC	Felt Liner	1
12	51282 Z	Gasket	1
13	22569 B	Screw	5
14	51782 A	Head Cover, for Styles 51400 BQ, BR; 51500 BP; 51700 BJ, BK, BQ	1
15	52882 W	Gasket	1
16	22542	Screw	1
18	21396 BJ	Needle Thread Lubricator Oil Reservoir, for Style 51500 BP	1
19	666-79	Oil Cup	1
20	61394 V	Adapter	1
21	11638 M	Nut	1
22	660-74	Connection Sleeve	1
23	660-75	Coupling	1
24	22569 C	Screw	2
25	21396 BK	Needle Thread Lubricator Oil Reservoir Bracket, for Style 51500 BP	1
26	21396 BP	Needle Thread Lubricator, for Styles 51500 BP, 51900 BJ (felt No. 21396 AG)	1
27	22513	Screw	4
28	35731 A	Presser Bar Connection Guide Plate	2
29	51270 B	Needle Thread Take-up Wire	1
30	95	Screw	1
31	43296	Nipper Spring Base, for Styles 51200 BG, BW, BX; 51300 BG, BJ	1
32	57 WB	Nipper Spring Plate, for Styles 51200 BG, BW, BX; 51300 BG, BJ	1
33	605 A	Screw, for Styles 51200 BW, BX	1
	22798 A	Screw, for Styles 51200 BG; 51300 BG, BJ	1
34	15438 C	Nipper Spring, for Styles 51200 BG, BW, BX; 51300 BG, BJ	1
35	57 WD	Nipper Spring Stud, for Styles 51200 BG, BW, BX; 51300 BG, BJ	1
36	22889 A	Adapter Screw	1
37	51758	Frame Needle Thread Eyelet, for Styles in Classes 51200, 51400, 51500, 51700	1
38	20	Washer	1
39	22848	Screw	1
40	539	Frame Needle Thread Eyelet, for Styles in Class 51300	1
41	51858	Frame Needle Thread Eyelet, for Styles in Class 51900	1
42	51291 A	Looper Thread Guard	1
43	52882 Y	Baffle Plate	1
44	90	Screw	2
45	52882 P	Gasket	1
46	52882 AD	Crank Chamber Cover, upper	1
47	90	Screw	2
48	52882 AA	Oil Drip Plate	1
49	39582 L	Oil Cap	1
50	52882 AC	Spring	1
51	50-789 Blk.	Pin	1
52	22541 B	Screw	3
53	51282 AE	Needle Lever Bearing Oiler	1
54	52882 U	Gasket	1
*55	52882 AE	Crank Chamber Cover, lower	1
56	22548	Screw	4
57	52882 M	Gasket	1
58	52882 L	Oil Reservoir Back Cover	1
59	22848	Screw	9
60	41394 A	Gasket	2
61	22733 B	Plug Screw	1
62	51382 A	Gasket	1
63	53782 B	Oil Reservoir Top Cover	1
64	22524	Screw	7
65	22585 A	Screw	2
66	51480	Throat Plate Support, for Styles in Classes 51500, 51700, 51900; Styles 51200 BG, BK, BL, BW, BX; 51300 BH, BM; 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY	1
67	51280 J	Dowel Pin, lower	2
68	51280 K	Dowel Pin, for Throat Plate	2
69	22839	Screw	3
70	22570	Throat Plate Screw, fillister head	2
	87	Throat Plate Screw, countersunk head	2
71		Throat Plate (See Pages 33, 35, 37, 39, 41, 43)	1
72	51280 A	Throat Plate Support, for Styles 51200 BM, BN, BP, BR, BS, BT; 51300 BG, BJ, BL; 51400 BV	1
†73	80	Screw	3

* NOTE: Use No. 52882 AF on late model machines.

† NOTE: Use No. 22839 counter bore head screw for late model No. 51280 A.

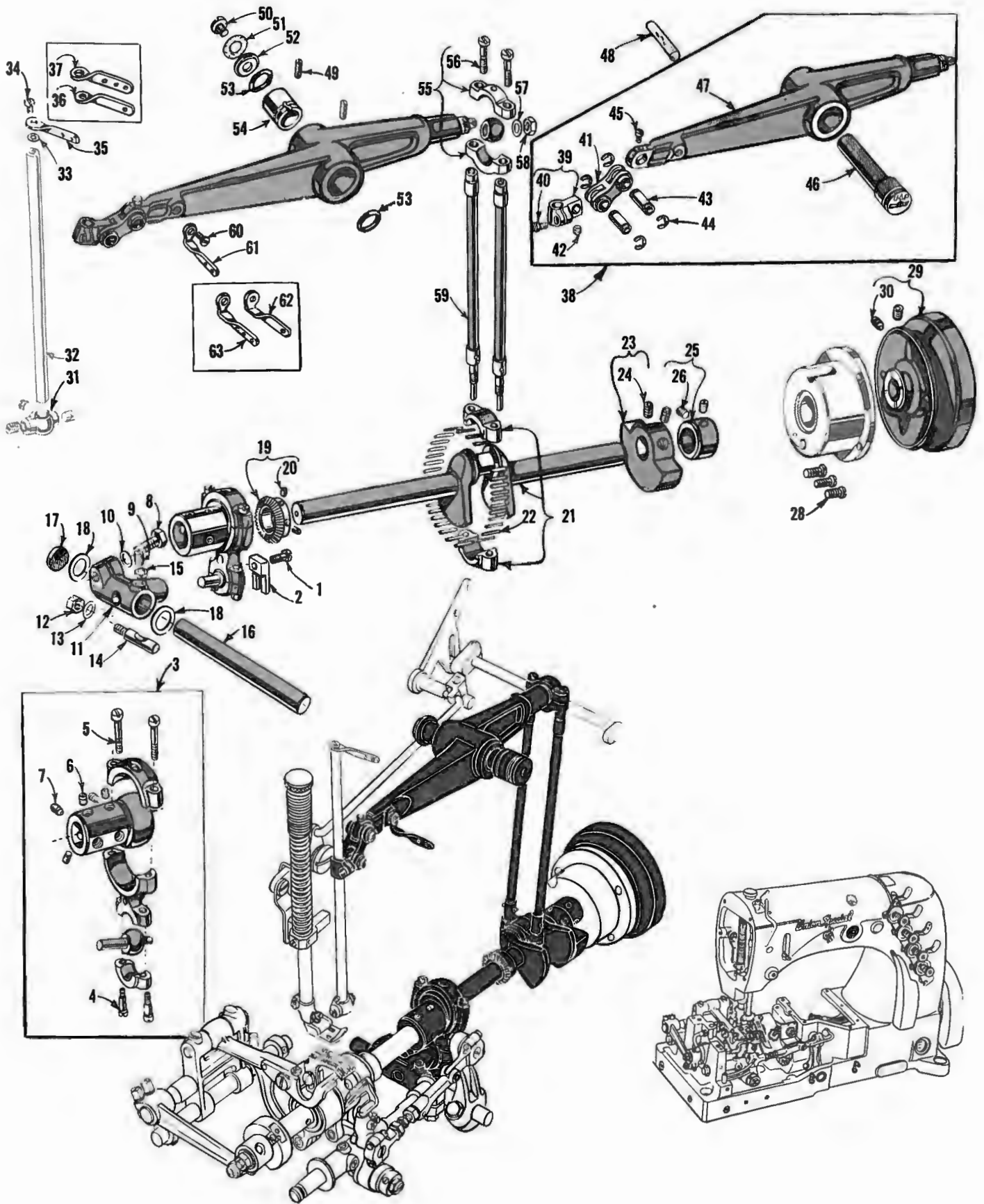


MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1	643-127 Blk.	Gasket -----	1
2	51493 BQ	Oil Pump Driven Gear -----	1
3	531	Screw-----	2
4	51493 AG	Oil Pump Housing -----	1
5	51493 BA	Base Plate-----	1
6	51493 D	Oil Pump Driving Shaft-----	2
7	51493 E	Oil Pump Driving Shaft Gear-----	2
8	51493 AH	Oil Pump Housing Cover -----	1
9	22569 B	Screw -----	3
10	22823 A	Screw -----	2
†11	51493 BH	Filter Cap Assembly-----	1
12	51493 BJ	Washer, rubber -----	1
13	22823 B	Screw -----	1
14	22571 A	Plug Screw -----	18
15	666-114	Oil Wick-----	2
16	35178 D	Spring-----	2
17	666-65	Oil Wick-----	2
18	35178 D	Spring-----	2
19	666-118	Oil Wick-----	2
20	666-111	Oil Wick-----	2
21	666-179	Wedge Pin -----	2
22	22539 H	Plug Screw -----	1
23	52944 T	Looper Rock Shaft Bushing, left-----	1
24	52890 C	Main Shaft Bushing, left, middle, inner right-----	3
25	52936	Feed Rocker Shaft Bushing -----	2
26	660-136	Oil Tube for feed crank link -----	1
27	258 A	Nut -----	1
28	52894 AK	Oil Tube for looper rocker ball joint, left, on Styles in Classes 51200, 51300, 51400, 51500, 51900 -----	1
29	51794 C	Oil Tube for looper rocker ball joint, left on Styles in Class 51700 -----	1
30	22560 B	Screw -----	1
31	52894 AB	Oil Tube Holder -----	2
*32	51293 T	Oil Tube for feed lift eccentric; also for looper avoid eccentric on Styles in Classes 51200, 51300, 51400, 51500, 51900 -----	2
33	90	Screw -----	2
34	51794 A	Oil Tube for looper avoid eccentric on Styles in Class 51700 -----	1
35	51257 AA	Lower Presser Bar Bushing -----	1
36	51254 D	Lower Needle Bar Bushing -----	1
37	51254 C	Upper Needle Bar Bushing-----	1
38	51242 S	Rear Looper Drive Lever Shaft Bushing-----	1
39	52944 U	Looper Rock Shaft Bushing, right -----	1
40	52894 AM	Oil Tube for looper connecting rod ball joint, right---	1
41	6042 A	Washer-----	1
42	258 A	Nut -----	1
43	51242 R	Middle Looper Drive Lever Shaft Bushing -----	1
44	51242 Z	Front Looper Drive Lever Shaft Bushing -----	1
45	21657 X	Tension Release Lever Shaft Bushing -----	1
46	52891 B	Crank Shaft Bushing Housing, including bushing-----	1
47	50-648 Blk.	Lucite Oil Gauge -----	1
48	52883 R	Foot Lifter Lever Bushing-----	1
49	51295 A	Mounting Isolator-----	4

† Use No. 51493 BG base plate oil pad with No. 51493 BH filter.

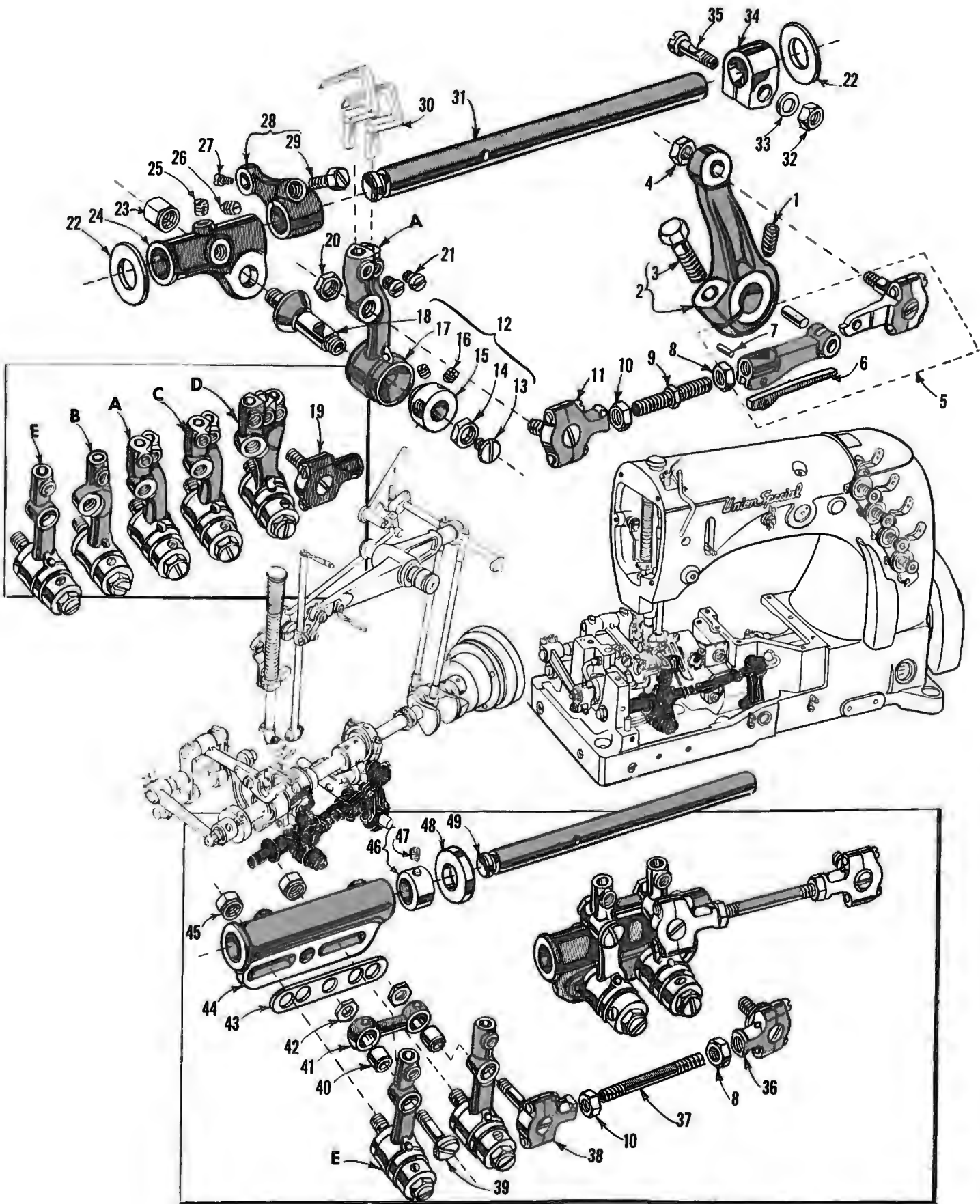
* Two No. 51293 T replaced by one each Nos. 22571 B, 52794 G.



CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1	22729	Screw-----	1
2	51243 C	Ball Stud Guide Fork -----	1
3	29105 AA	Looper Drive Lever Eccentric Assembly, for Styles in Classes 51400, 51700; Styles 51200 BG, BK, BP, BR, BS; 51900 BG-----	1
	29105 Z	Looper Drive Lever Eccentric Assembly, for Styles in Classes 51300, 51500; Styles 51200 BL, BM, BT, BW, BX; 51900 BH, BJ-----	1
4	22559 A	Bearing Cap Screw, lower -----	2
5	22559 B	Bearing Cap Screw, upper -----	2
6	22894 C	Eccentric Set Screw -----	4
7	22894 D	Eccentric Spot Screw -----	1
8	22852 A	Clamp Screw -----	1
9	81	Spot Screw -----	1
10	51242 M	Washer -----	1
11	51242 Y	Looper Drive Lever Rocker -----	1
12	52841 J	Nut -----	1
13	51242 M	Washer -----	1
14	52841 G	Locking Stud -----	1
15	12982	Lock Nut -----	1
16	51242 P	Looper Drive Lever Shaft -----	1
17	22539 H	Plug Screw -----	1
18	51242 L	Thrust Washer-----	2
19	51493 BP	Oil Pump Driving Gear -----	1
20	22560 B	Screw-----	2
21	29476 FF	Crankshaft Assembly, .910 inch throw, for Styles 51200 BL, BM, BT, BW, BX; 51300 BG, BJ -----	1
	29476 GZ	Crankshaft Assembly, .990 inch throw, for Styles in Class 51500; Styles 51300 BH, BL, BM; 51900 BH, BJ -----	1
	29476 HA	Crankshaft Assembly, .770 inch throw, for Styles in Classes 51400, 51700; Styles 51200 BG, BK, BP, BR, BS; 51900 BG-----	1
22	51216 M	Needle Bearings-----	28
23	51247	Counterweight -----	1
24	22894 J	Screw-----	2
25	51147	Thrust Collar -----	1
26	95	Screw-----	2
28	22569 B	Screw-----	3
29	51221 C	Handwheel, for No. 1 "V" or round belt -----	1
30	22894 F	Screw-----	2
31		Needle Holder (See Pages 29, 31) -----	1
32		Needle Bar (See Pages 29, 31)-----	1
33	27-435 Blk.	Eyelet Lock Washer -----	1
34	22768	Screw-----	1
35	56458 A	Needle Bar Thread Eyelet, for two needle machine -----	1
36	56358	Needle Bar Thread Eyelet, for one needle machine -----	1
37	56958 A	Needle Bar Thread Eyelet, for three needle machine-----	1
38	29348 AF	Needle Lever Assembly-----	1
39	51254 K	Needle Bar Connection -----	1
40	22562 A	Screw -----	1
41	56354 D	Needle Bar Connection Link -----	1
42	22564	Screw, for lower link pin-----	1
43	52336 A	Link Pin -----	2
44	660-215	Retaining Ring-----	4
45	77	Screw, for upper link pin -----	1
46	56350 D	Needle Lever Stud -----	1
47	56315 A	Needle Lever -----	1
*48	666-170	Oil Wick, for needle lever stud -----	1
49	719	Screw-----	2
50	22586 R	Screw-----	1
51	51250 F	Gasket -----	1
52	51250 D	Washer -----	1
53	660-212	Oil Seal Ring -----	2
54	51150	Needle Lever Thrust Collar -----	1
55	29066 R	Needle Lever Ball Joint-----	1
56	22559 G	Screw-----	2
57	51216 N	Washer -----	1
58	51216 P	Nut -----	1
59	51216 G	Needle Lever Connecting Rod-----	2
60	22768	Screw-----	1
61	56458	Needle Lever Thread Eyelet, for two needle machine -----	1
62	56358 A	Needle Lever Thread Eyelet, for one needle machine -----	1
63	56958	Needle Lever Thread Eyelet, for three needle machine-----	1

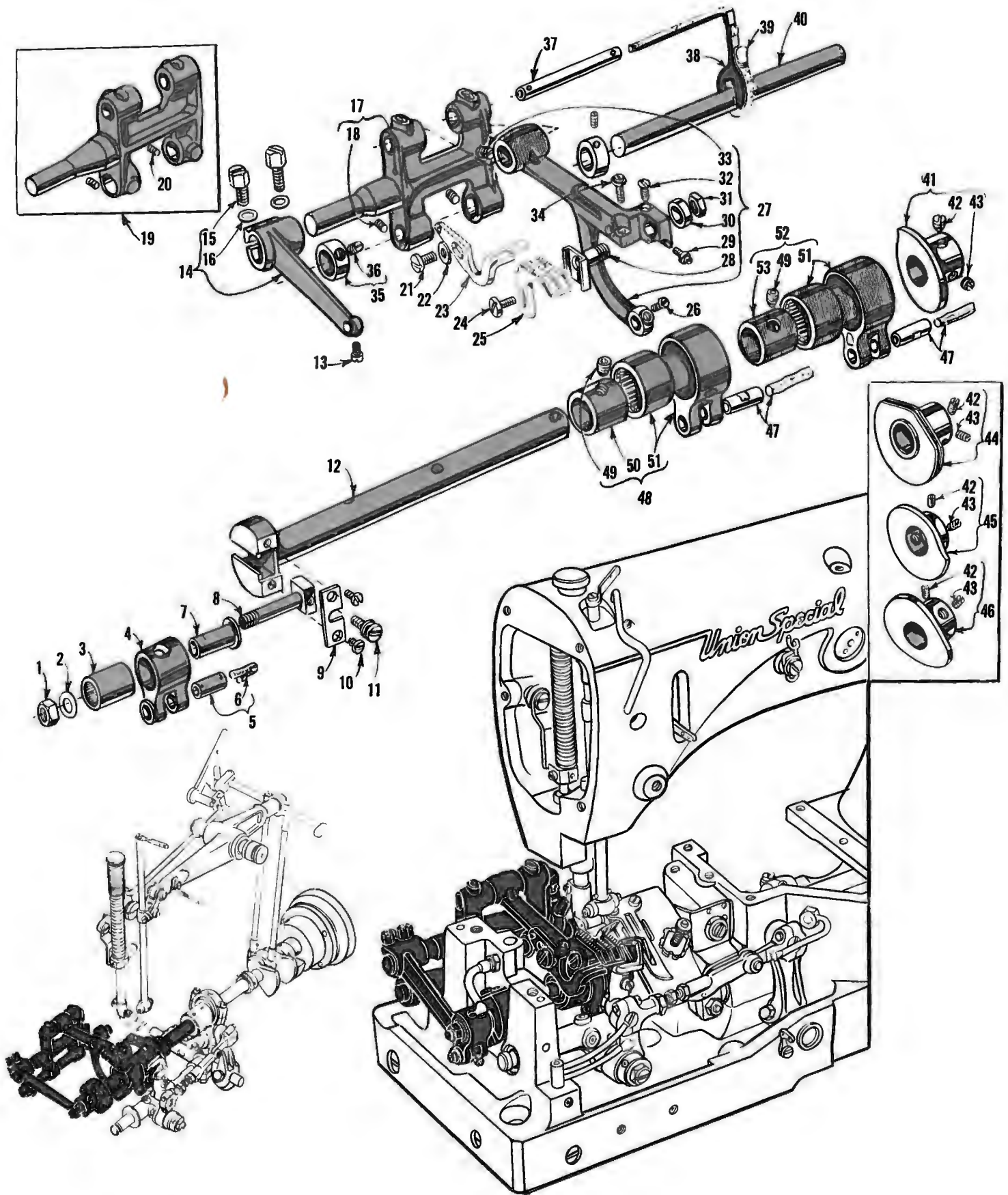
* For use with needle lever stud No. 51250 E in old machines.



LOOPER ROCKER AND CONNECTING ROD PARTS

Ref. No.	Part No.	Description	Amt. Req.
1	22894 H	Spot Screw -----	1
2	51242 W	Looper Drive Lever -----	1
3	22811 B	Screw -----	1
4	12538	Nut -----	1
5	51241 K	Looper Connecting Rod and Ball Joint, right, for Styles in Classes 51200, 51300, 51400, 51500, 51900 -----	1
6	56341 G	Spring -----	1
7	50-458 Blk.	Spring Pin -----	1
8	18	Nut, right thread-----	1
9	51240 D	Looper Connecting Rod, for Styles in Class 51300, 51400, 51500, 51900; Styles 51200 BL, BM, BT, BW, BX -----	1
	57840	Looper Connecting Rod, for Styles 51200 BG, BK, BP, BR, BS -----	1
10	269	Nut, left thread-----	1
11	55241 N	Looper Connecting Rod Ball Joint, left, for Styles in Classes 51200, 51300, 51400, 51500 -----	1
12		Looper Rocker Assembly (See Chart Below)-----	
13	22829	Lock Nut Screw-----	1
14	258 A	Lock Nut-----	1
15	15465 F	Looper Rocker Cone -----	1
16	88	Set Screw -----	2
17		Looper Rocker (See Chart Below)-----	
18	51745	Looper Rocker Cone Stud-----	1
19	51241 D	Looper Connecting Rod Ball Joint, left, for Styles in Class 51900 -----	1
20	18	Nut, for Styles in Classes 51200, 51300, 51400, 51500, 51900 -----	1
21	73	Looper Set Screw -----	1, 2, 3
22	51244 L	Thrust Washer-----	2
23	51246	Looper Rocker Stud Nut, for Styles in Classes 51200, 51300, 51400, 51500, 51900 -----	1
24	51244	Looper Rocker Frame, for Styles in Classes 51200, 51300, 51400, 51500, 51900 -----	1
25	98	Set Screw -----	1
26	96	Spot Screw -----	1
27	77	Screw-----	1
28	51244 B	Looper Rocker Shaft Arm -----	1
29	22519 H	Screw -----	1
30		Looper (See Page 45) -----	
31	51144	Looper Rocker Rock Shaft, for Styles in Classes 51200, 51300, 51400, 51500, 51900-----	1
32	18	Nut -----	1
33	20	Washer -----	1
34	51244 N	Looper Rocker Rock Shaft Collar, for Styles in Classes 51200, 51300, 51400, 51500, 51900 -----	1
35	55244 G	Locking Stud-----	1
36	51741 C	Looper Connecting Rod Ball Joint, right, for Styles in Class 51700 -----	1
37	41047	Looper Connecting Rod, for No. 64 to 96 gauge, Styles in Class 51700 -----	1
	39141	Looper Connecting Rod, for No. 56 gauge, Style 51700 -----	1
	4761	Looper Connecting Rod, for No. 112 and 128 gauges, Style 51700-----	1
38	55641	Looper Connecting Rod Ball Joint, left, for Styles in Class 51700 -----	1
39	22835	Looper Rocker Link Stud, for Styles in Class 51700-----	1
40	51771	Looper Rocker Link Ferrule, for Styles in Class 51700 -----	2
41	51770-56	Looper Rocker Link, for No. 56 gauge, Styles in Class 51700-----	1
	51770-64	Looper Rocker Link, for No. 64 gauge -----	1
	51770-72	Looper Rocker Link, for No. 72 gauge -----	1
	51770-80	Looper Rocker Link, for No. 80 gauge -----	1
	51770-88	Looper Rocker Link, for No. 88 gauge -----	1
	51770-96	Looper Rocker Link, for No. 96 gauge -----	1
	51700-112	Looper Rocker Link, for No. 112 gauge -----	1
	51770-128	Looper Rocker Link, for No. 128 gauge -----	1
42	14077	Nut -----	2
43	51772-56	Looper Rocker Spacing Plate, for No. 56 and 96 gauges, Styles in Class 51700 -----	1
	51772-64	Looper Rocker Spacing Plate, for No. 64 and 104 gauges -----	1
	51772-72	Looper Rocker Spacing Plate, for No. 72 and 112 gauges -----	1
	51772-80	Looper Rocker Spacing Plate, for No. 80 gauge -----	1
	51772-88	Looper Rocker Spacing Plate, for No. 88 and 128 gauges -----	1
44	51744 A	Looper Rocker Frame, for Styles in Class 51700 -----	1
45	1280	Looper Rocker Stud Nut, for Styles in Class 51700-----	2
46	51773	Looper Rocker Frame Spacing Collar, for Styles in Class 51700 -----	1
47	88 B	Screw -----	1
48	54244 L	Thrust Washer, for Styles in Class 51700-----	1
49	51244 A	Looper Rocker Rock Shaft, for Styles in Class 51700-----	1

	Ref. 12 Assembly	Ref. 17 Assembly	Identification Mark	Machine Styles	Amt. Req.
A	29192 A	51413	"C"	51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY	1
B	29192	51213	"B"	51200 BG, BK, BL, BM, BP, BR, BS, BT, BW, BX, 51300 BG, BH, BJ, BL, BM	1
C	29192 D	51513	"D"	51500 BJ, BK, BM, BN, BR	1
D	29192 B	51913	"F"	51500 BP, 51900 BG, BH, BJ	1
E	29192 C	51713	"E"	51700 BJ, BK, BQ, BR	2



MAIN SHAFT AND FEED DRIVING PARTS

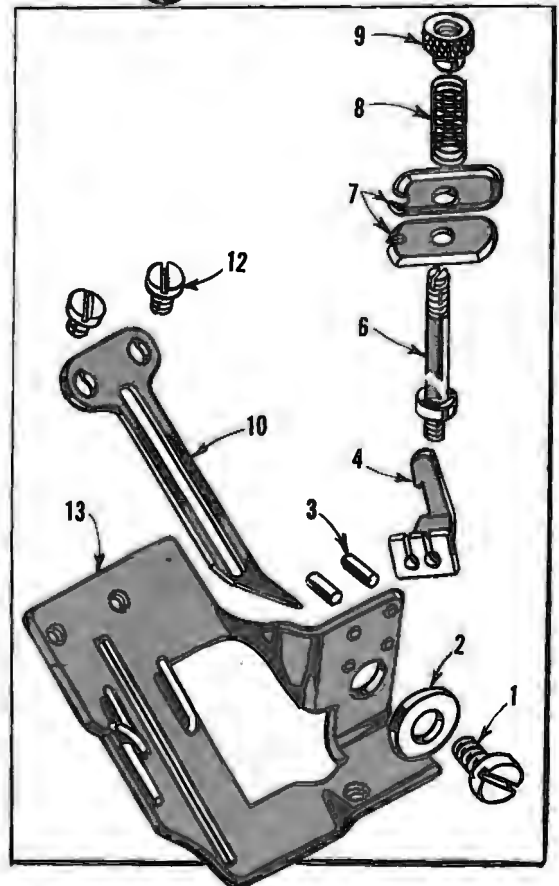
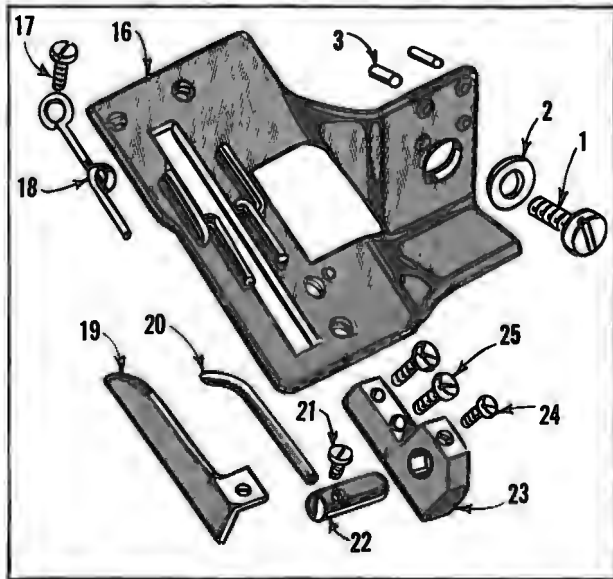
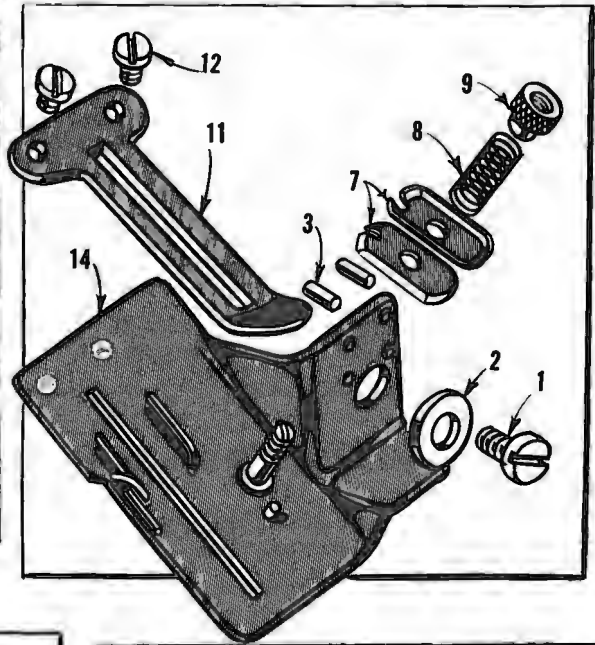
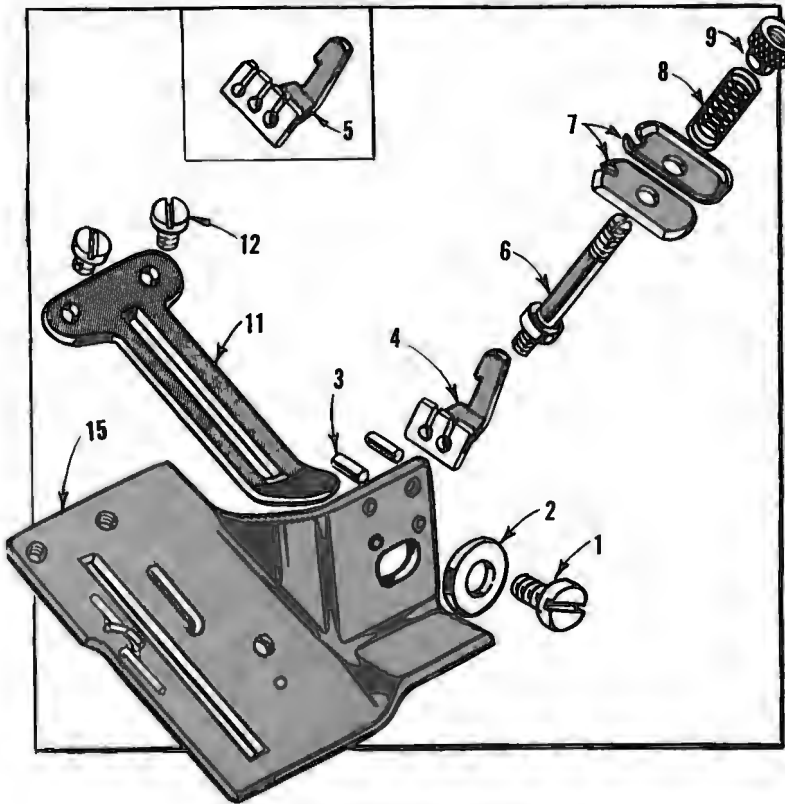
Ref. No.	Part No.	Description	Amt. Req.
1	269	Nut, left thread	1
2	20	Washer	1
3	660-169	Needle Bearing	1
4	51236 D	Feed Crank Link	1
5	51054	Link Pin	1
6	666-149	Oil Wick	1
7	51236 F	Feed Crank Link Ferrule	1
8	51236 G	Feed Crank Stud	1
9	51236 B	Feed Crank Stud Cap	1
10	22768	Screw	2
11	22795	Stitch Regulating Screw	1
12	51222	Main Shaft, for Styles in Classes 51200, 51300, 51400, 51500, 51900	1
	51722	Main Shaft, for Styles in Class 51700	1
13	77	Screw	1
14	51235 A	Feed Rocker Arm	1
15	22519 C	Screw	2
16	51235 G	Washer	2
17	51235	Feed Rocker, for Styles in Classes 51200, 51300, 51400, 51500, 51700; Style 51900 BG	1
18	98	Screw	2
19	51135	Feed Rocker, for Styles 51900 BH, BJ	1
20	98	Screw	2
21	22585 B	Needle Guard Screw	1
22	51225 W	Washer	1
23		Needle Guard (See Pages 29, 31)	1
24	22528	Feed Dog Screw	1
25		Feed Dog (See Pages 33, 35, 37, 39, 41, 43)	1
26	77	Screw	1
27	51134	Feed Bar	1
28	56334 L	Feed Dog Holder	1
29	22863	Feed Dog Holder Adjusting Screw	1
30	51134 J	Feed Dog Holder Washer	1
31	256 A	Nut	1
32	538	Feed Dog Height Adjusting Screw	1
33	22560 B	Screw	1
34	22834	Needle Guard Adjusting Screw	1
35	482	Feed Rocker Shaft Collar	2
36	98	Screw	1
37	51134 C	Feed Bar Shaft	1
38	51134 R	Lubricating Felt Guard	1
39	51134 P	Lubricating Felt	1
40	8	Feed Rocker Shaft	1
41	51423 B	Looper Thread Take-up, for Styles in Class 51400; Styles 51200 BG, BK, BP, BR, BS; 51900 BG	1
42	96	Spot Screw	1
43	22580 D	Set Screw	1
44	51423 C	Looper Thread Take-up, for Styles in Class 51500	1
45	51723 A	Looper Thread Take-up, for Styles in Class 51700	1
46	51523 C	Looper Thread Take-up, for Styles in Class 51300; Styles 51200 BL, BM, BT, BW, BX; 51900 BH, BJ	1
47	51236 A	Link Pin	2
48		Feed Lift Eccentric Assembly (See Chart Below)	1
49	22894 D	Screw	1
50		Feed Lift Eccentric (See Chart Below)	1
51	51145 A	Eccentric Bearing	1
52		Looper Avoid Eccentric Assembly (See Chart Below)	1
53		Looper Avoid Eccentric (See Chart Below)	1

FEED LIFT

MACHINE STYLES	Ref. 46 Assembly	Ref. 50 Eccentric	Throw
51200 BL, BM, BT, BW, BX 51300 BG, BJ 51500 BJ, BK, BM, BN, BR 51900 BH, BJ	29476 DR	51142 C	.080
51300 BH, BM	29476 DS	51142 E	.096
51200 BG, BK, BP, BR, BS 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY 51700 BJ, BK, BQ, BR 51900 BG	29476 DV	51406	.062
51300 BL 51500 BP	29476 DY	51142 F	.112

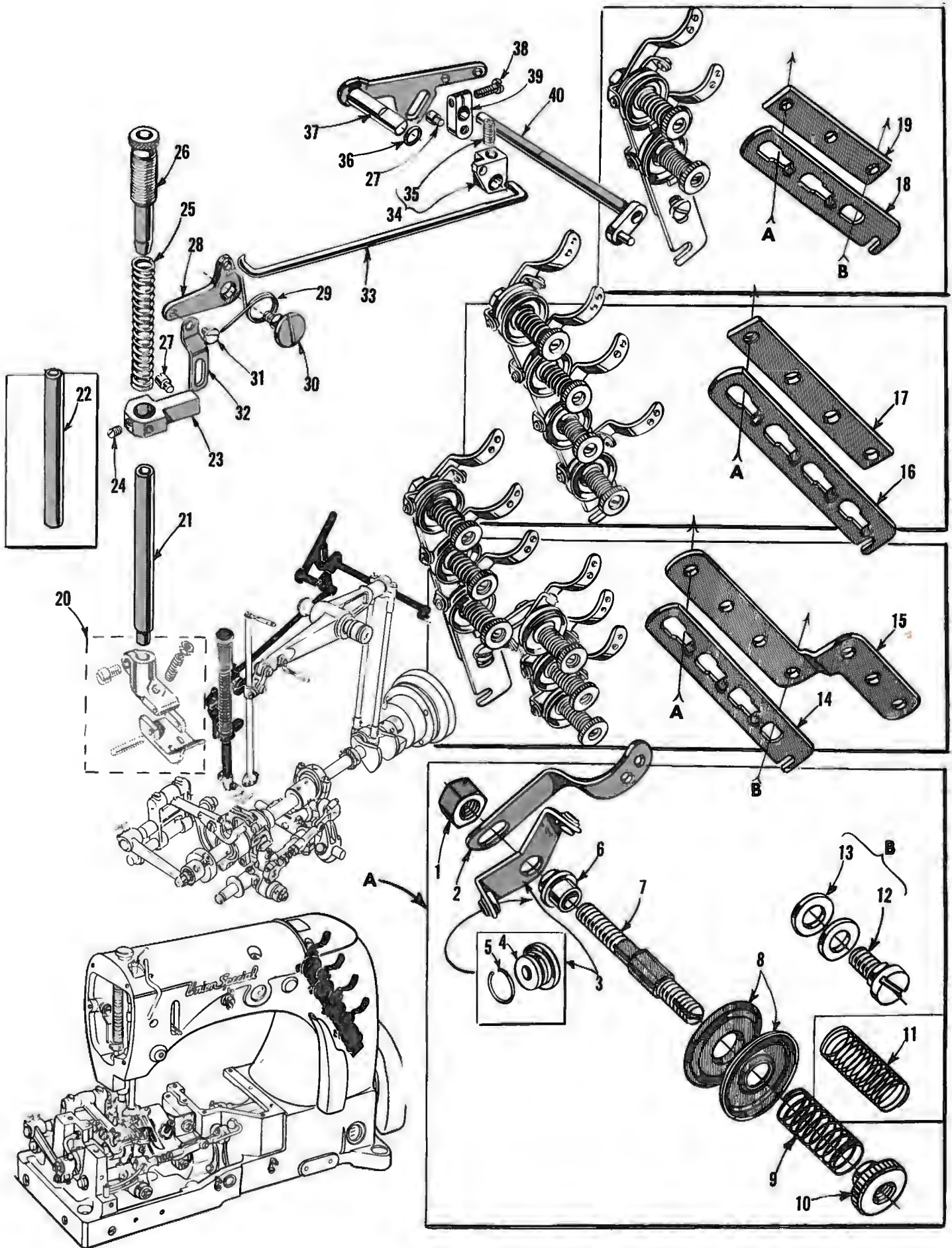
LOOPER AVOID

MACHINE STYLES	Ref. 52 Assembly	Ref. 53 Eccentric	Throw
51200 BL, BM, BW 51300 BH, BL, BM 51500 BJ, BK, BM, BN, BP, BR 51900 BJ	29476 DR	51142 C	.080
51300 BG, BJ 51900 BH	29476 DX	51306	.072
51200 BG, BK, BP, BR, BS, BT, BX 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY 51700 BJ, BK, BQ, BR 51900 BG	29476 DV	51406	.062



LOOPER THREAD TAKE-UP PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	22528	Screw -----	1
2	21657 E	Washer-----	1
3	50-216 Blk.	Dowel Pin -----	2
4	51459 A	Thread Guide, for Styles in Classes 51400, 51700---	1
5	51959 J	Thread Guide, for Styles in Class 51900 -----	1
6	51492	Tension Post, for Styles in Classes 51400, 51700, 51900 -----	1
7	51959 B	Tension Disc, for Styles in Classes 51200, 51300, 51400, 51700, 51900-----	2
8	51959 K	Tension Spring, for Styles in Classes 51400, 51700, 51900 -----	1
	51959 C	Tension Spring, for Styles in Classes 51200, 51300 -----	1
9	51959 D	Tension Nut, for Styles in Classes 51200, 51300, 51400, 51700, 51900-----	1
10	51704	Cast-off Plate, for Styles in Class 51700-----	1
11	52804 A	Cast-off Plate, for Styles in Classes 51200, 51300, 51400, 51900-----	1
12	28	Screw -----	2
13	51757 B	Take-up Shield, for Styles in Class 51700 -----	1
14	51557	Take-up Shield, for Styles in Classes 51200, 51300 -----	1
15	51457 A	Take-up Shield, for Styles in Classes 51400, 51900 -----	1
16	51257 P	Take-up Shield, for Styles in Class 51500 -----	1
17	22768	Screw -----	1
18	52958	Thread Eyelet, for Styles in Class 51500-----	1
19	51204 B	Cast-off, for Styles in Class 51500 -----	1
20	51204	Looper Thread Retaining Finger, for Styles in Class 51500 -----	1
21	22798 A	Screw -----	1
22	51204 A	Looper Thread Retaining Finger Holder, for Styles in Class 51500 -----	1
23	51204 C	Cast-off and Retaining Finger Support Bracket, for Styles in Class 51500-----	1
24	77	Screw -----	1
25	J87 J	Screw -----	2



THREED TENSION AND LIFTER LEVER PARTS

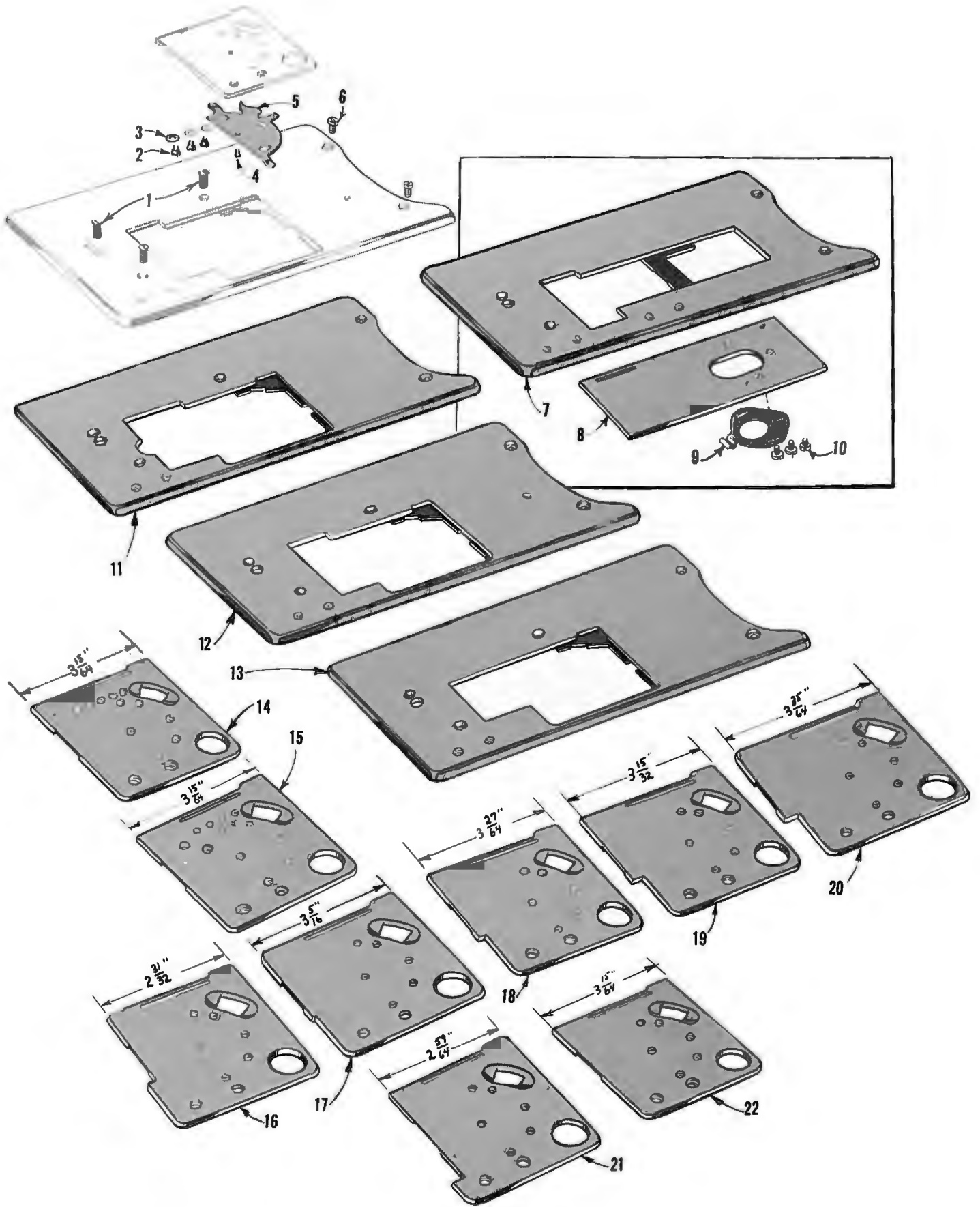
TENSION PARTS

Ref. No.	Part No.	Description	AMOUNT REQUIRED		
			One Needle Machine	Two Needle Machine	Three Needle Machine
1	43266	Nut	1	2	5
2	51491 C	Lead-in Guide	2	4	6
3	51292 D	Tension Thread Eyelet	2	4	6
4	668-25	Eyelet	4	8	12
5	668-28	Locking Ring	4	8	12
6	51292 A	Ferrule	2	4	6
7	51292 G	Tension Post	2	4	6
8	109	Tension Disc	4	8	12
9		Needle Thread Tension Spring		(See Chart Below)	
10	51292 C	Tension Nut	2	4	6
11		Looper Thread Tension Spring		(See Chart Below)	
12	22598 C	Screw	1		1
13	80557	Washer	2		2
14	21657-4	Tension Disc Separator			1
15	51992 A	Tension Post Support			1
16	21657-4	Tension Disc Separator		1	
17	56382 X	Tension Post Support		1	
18	21657-3	Tension Disc Separator	1		
19	52892	Tension Post Support	1		

Ref. No.	Part No.	Description	Amt. Req.
20		Presser Foot (See Pages 33, 35, 37, 39, 41, 43)-----	1
21	51257 K	Presser Bar, for Styles in Classes 51200, 51300, 51400, 51700; Styles 51500 BJ, BK, BM, BN, BR; 51900 BG, BH-----	1
22	51957 E	Presser Bar, for Styles 51500 BP; 51900 BJ-----	1
23	51257 M	Presser Bar Connection and Guide-----	1
24	531	Screw-----	1
25	51256 C	Presser Spring, for Styles in Classes 51200, 51300, 51400, 51500, 51700; Styles 51900 BG, BH-----	1
	53787	Presser Spring, for Style 51900 BH-----	1
26	56356	Presser Spring Regulator-----	1
27	402	Screw-----	2
28	53783 L	Lifter Lever Bell Crank-----	1
29	52883 S	Lifter Lever Bell Crank Spring-----	1
30	22557 B	Screw-----	1
31	22758 C	Screw-----	1
32	53783 A	Lifter Lever Link-----	1
33	53783 M	Lifter Lever Connecting Rod-----	1
34	56383 AB	Lifter Lever, internal-----	1
35	22537	Screw-----	1
36	660-207	Oil Seal Ring-----	1
37	51283 H	Lifter Lever-----	1
38	22596	Screw-----	1
39	21657 Y	Tension Release and Lifter Lever Shaft Connection-----	1
40	21657 W	Tension Release and Lifter Lever Shaft-----	1

TENSION SPRING CHART

Ref. No.	Part No.	Description	Machine Style	Amt. Req.
9	51292 F-5	Needle Thread Tension Spring	51200 BK, BM, BP, BR, BS, BT	1
			51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY;	2
			51700 BJ, BK, BQ, BR	
			51900 BG	3
9	51292 F-8	Needle Thread Tension Spring	51200 BG, BL, BW, BX;	
			51300 BG, BJ, BL, BM	1
			51500 BJ, BK, BM, BN, BP, BR	2
			51900 BH, BJ	3
9	51292 F-14	Needle Thread Tension Spring	51300 BH	1
11	51292 F-1	Looper Thread Tension Spring	51200 BK, BM, BP, BR, BS, BT	1
			51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY;	2
			51700 BJ, BK, BQ, BR	
			51900 BG	3
11	51292 F-2	Looper Thread Tension Spring	51200 BG, BL, BW, BX;	
			51300 BG, BH, BJ, BL, BM	1
			51500 BJ, BK, BM, BN, BP, BR	2
			51900 BH, BJ	3

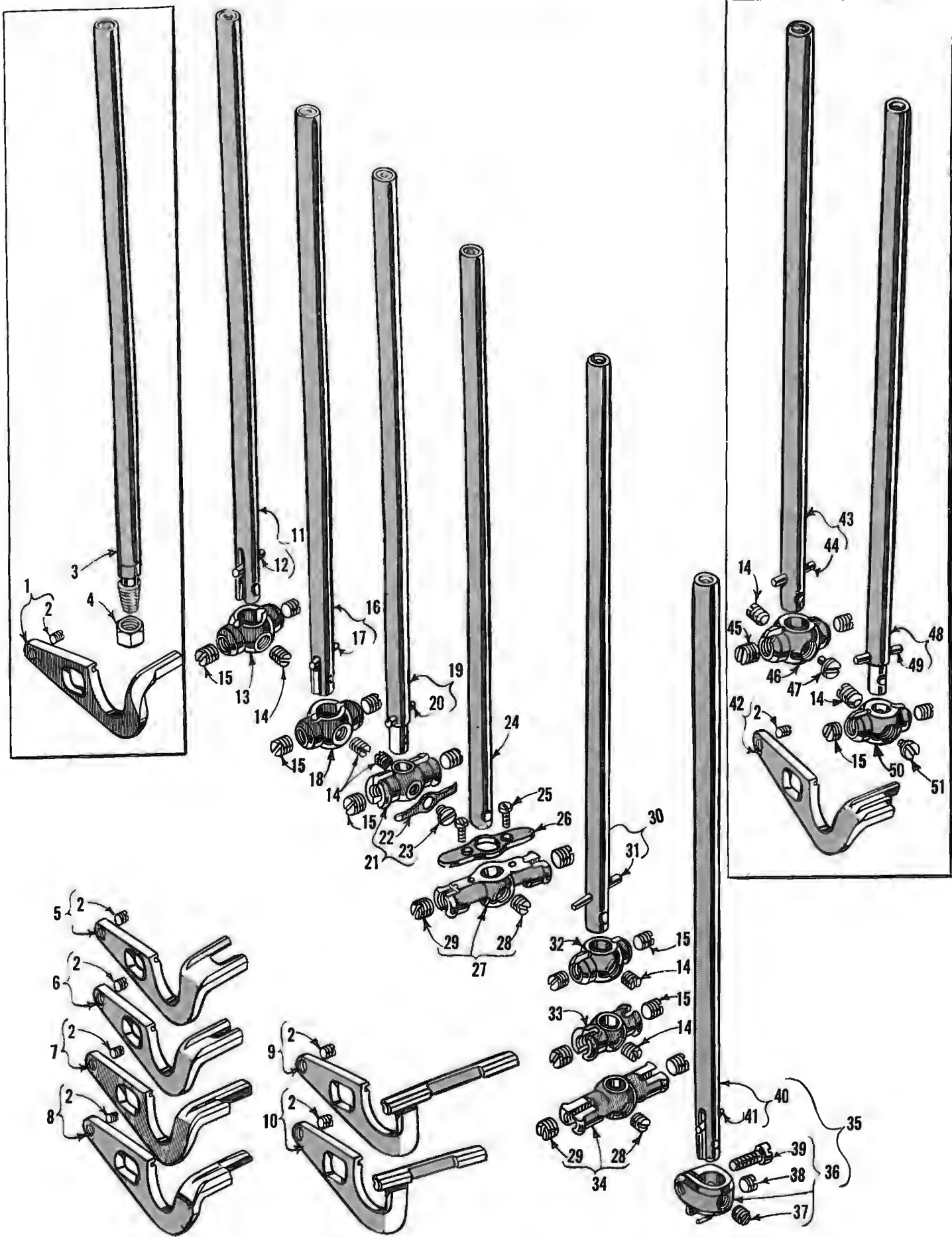


CLOTH PLATES AND CLOTH PLATE COVERS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	80	Screw- - - - -	3
2	22760 A	Screw- - - - -	3
3	35772 H	Washer - - - - -	3
4	22845 B	Screw- - - - -	1
5	51281 AC	Cloth Plate Cover Spring, for Styles in Classes 51200, 51300, 51400, 51700, 51900; Styles 51500 BJ, BK, BN, BP, BR- - - - -	1
6	22839 C	Screw- - - - -	2
7	51501	Cloth Plate, for Style 51500 BM- - - - -	1
8	51281 Y-161	Cloth Plate Cover, for Style 51500 BM- - - - -	1
9	51281 Z	Cloth Plate Cover Spring, for Style 51500 BM - - - - -	1
10	22726 A	Screw- - - - -	3
11	51701 R	Cloth Plate, for Styles in Class 51700; No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS - - - - -	1
12	53701	Cloth Plate, for Styles 51200 BG, BK, BL, BW, BX; 51300 BH, BM; 51400 BD, BP, BT, BU, BW, BX, BY and No. 32 gauge, Style 51400 BS; 51500 BJ, BK, BN, BP, BR; 51900 BG, BH, BJ- - - - -	1
13	51301 D	Cloth Plate, for Styles 51200 BM, BP, BR, BS, BT; 51300 BG, BJ, BL; 51400 BV- - - - -	1
14	51281 AB-207	Cloth Plate Cover, 3 15/64 inches long, for Styles 51200 BK, BL; 51300 BM- - - - -	1
15	51281 U-207	Cloth Plate Cover, 3 15/64 inches long, for Styles 51200 BW, BX- - - - -	1
16	51281 T-190	Cloth Plate Cover, 2 31/32 inches long, for Styles 51200 BT- - - - -	1
17	51281 T-212	Cloth Plate Cover, 3 5/16 inches long, for Styles 51200 BM; 51300 BL; No. 18 gauge, Style 51400 BV- - - - -	1
18	51281 T-219	Cloth Plate Cover, 3 27/64 inches long, for No. 16 gauge, Style 51400 BV- - - - -	1
19	51281 T-222	Cloth Plate Cover, 3 15/32 inches long, for Styles 51200 BR; 51300 BG, BJ- - - - -	1
20	51281 T-227	Cloth Plate Cover, 3 35/64 inches long, for Styles 51200 BP, BS- - - - -	1
21	51281 P-187	Cloth Plate Cover, 2 59/64 inches long, for Styles in Class 51700; No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS- - - - -	1
22	51281 P-207	Cloth Plate Cover, 3 15/64 inches long, for Styles 51200 BG; 51300 BH; 51400 BD, BP, BT, BU, BW, BX, BY; No. 32 gauge, Style 51400 BS; 51500 BJ, BK, BN, BP, BR; 51900 BG, BH, BJ- - - - -	1

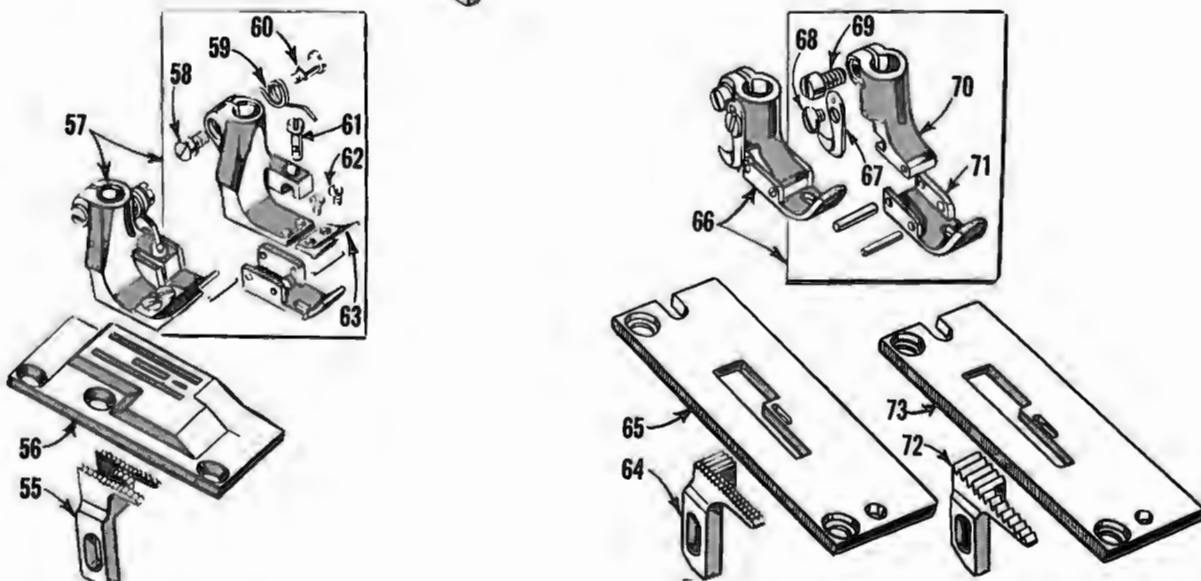
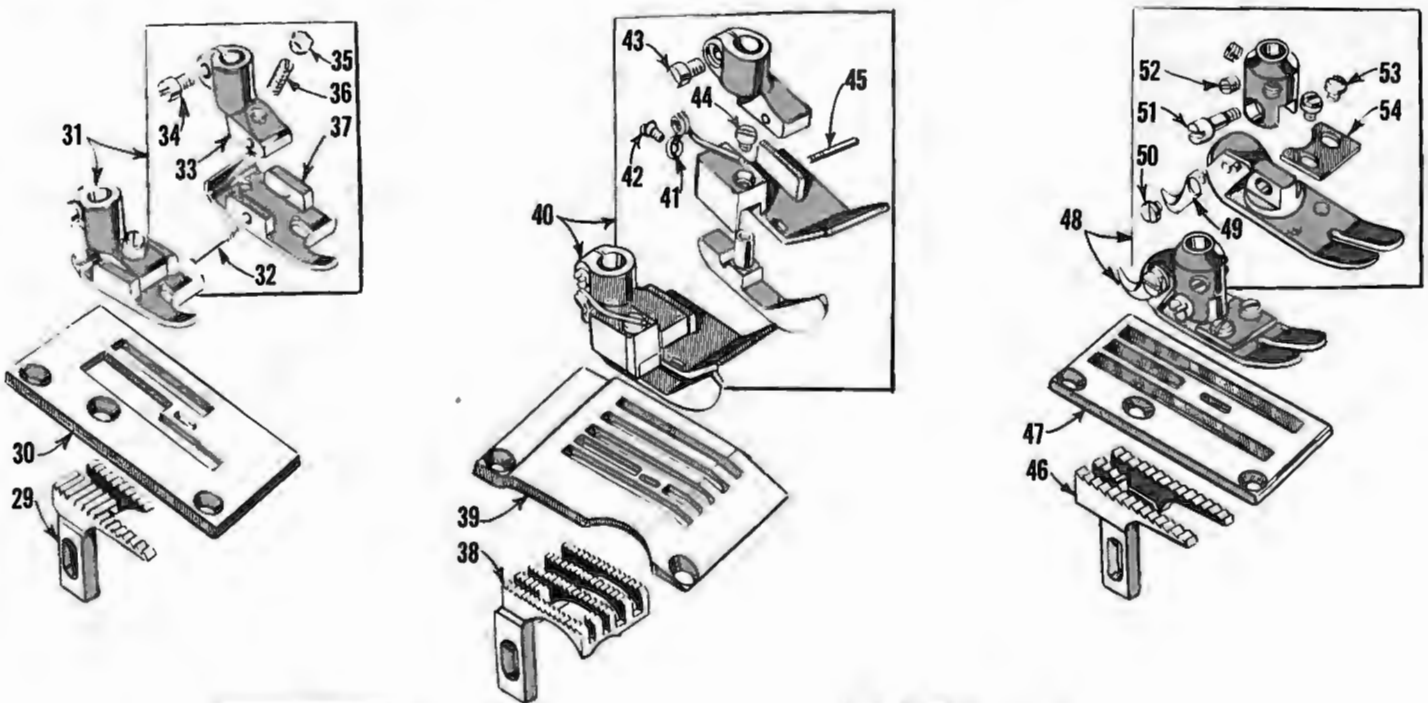
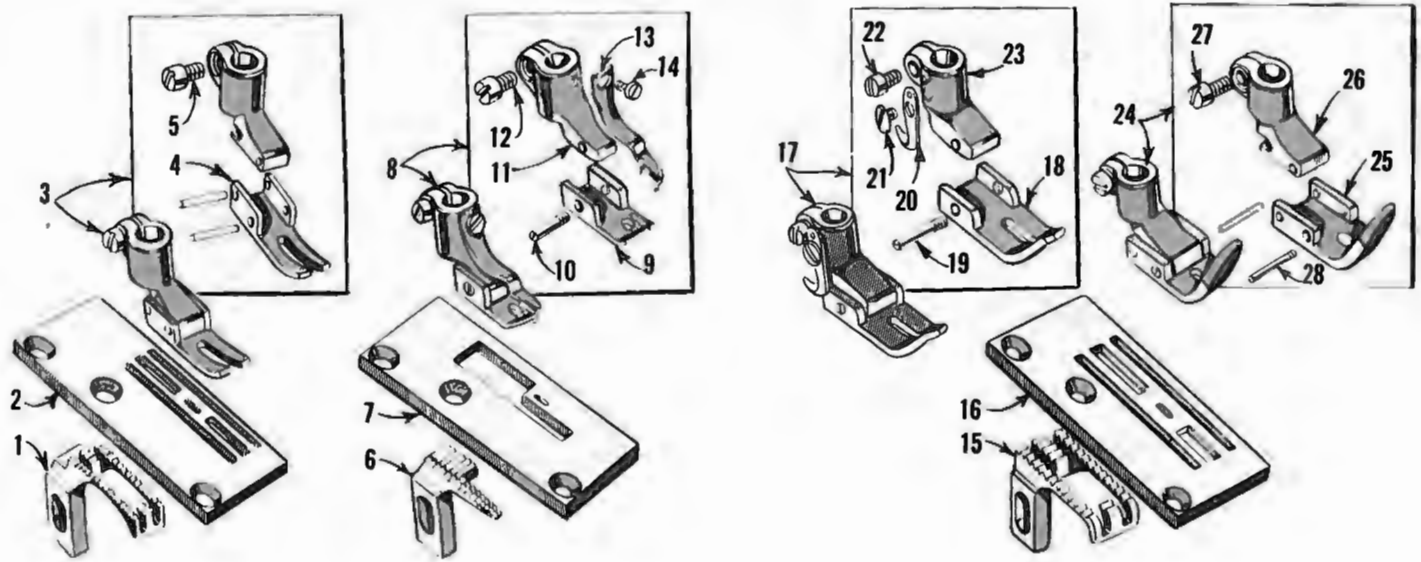
NEEDLE GUARDS, NEEDLE BARS AND NEEDLE HOLDERS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	51225	Needle Guard, for Styles in Classes 51200, 51300 -----	1
2	22801	Pivot Screw-----	1
3	51217 C	Needle Bar, marked "CU", for Styles in Classes 51200, 51300 -----	1
4	56	Needle Clamp Nut, for Styles in Classes 51200, 51300 -----	1
5	51525 C	Needle Guard, for Style 51500 BK -----	1
6	51525 G	Needle Guard, for Style 51500 BN -----	1
7	51425	Needle Guard, for Styles 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BW, BX, BY -----	1
8	51525	Needle Guard, for Styles 51400 BV; 51500 BJ, BM, BR -----	1
9	51725	Needle Guard, for No. 56 to 96 gauges, Styles in Class 51700 -----	1
10	51725 A	Needle Guard, for No. 96 to 112 gauges, Styles in Class 51700 -----	1
11	51417 C-6	Needle Bar, marked "CV-6", for No. 6 gauge, Style 51400 BP -----	1
	51417 C-8	Needle Bar, marked "CV-8", for No. 8 gauge, Styles 51400 BP, BT, BW -----	1
	51417 C-10	Needle Bar, marked "CV-10", for No. 10 gauge, Styles 51400 BP, BT, BW -----	1
	51417 C-12	Needle Bar, marked "CV-12", for No. 12 gauge, Styles 51400B D, BP, BT, BW-----	1
	51417 C-16	Needle Bar, marked "CV-16", for No. 16 gauge, Styles 51400 BD, BP, BT, BW-----	1
	51417 C-18	Needle Bar, marked "CV-18", for No. 18 gauge, Style 51400 BP -----	1
12	50 J-16	Stop Pin-----	1
13	51418-16	Needle Holder, marked "D-16", for all gauges, Styles 51400 BD, BP, BT, BW-----	1
14	89	Spot Screw -----	1
15	98	Set Screw-----	2
16	56517 B-16	Needle Bar, marked " ET ", for No. 16 gauge, Styles 51400 BV; 51500 BJ -----	1
17	50 J-16	Stop Pin-----	1
18	51418-16	Needle Holder, marked "D-16", for No. 16 gauge, Styles 51400 BV; 51500 BJ-----	1
19	56517 B-18	Needle Bar, marked "EU", for No. 18 gauge, Styles 51400 BV; 51500 BJ, BM, BR -----	1
20	50 J-16	Stop Pin-----	1
21	7018 E-5	Needle Holder, for No. 18 gauge, Styles 51400 BV; 51500 BJ, BM, BR -----	1
22	7040-6	Thread Guide -----	1
23	187 B	Screw-----	1
24	51717	Needle Bar, marked "AU", for Styles in Class 51700 -----	1
25	605 A	Screw -----	2
26	7933-48	Needle Stop Plate, for No. 56 and 64 gauges, Styles in Class 51700 --	1
	7933-61	Needle Stop Plate, for No. 72 to 88 gauges, Styles in Class 51700-----	1
	16182 B	Needle Stop Plate, for No. 96 gauge, Styles in Class 51700-----	1
	16182 C	Needle Stop Plate, for No. 128 gauge, Styles in Class 51700-----	1
27	51718 A-56	Needle Holder, marked "AB-56", for No. 56 gauge, Styles in Class 51700-----	1
	51718 A-64	Needle Holder, marked "AB-64", for No. 64 gauge, Styles in Class 51700-----	1
	51718 A-72	Needle Holder, marked "AB-72", for No. 72 gauge, Styles in Class 51700-----	1
	51718 A-80	Needle Holder, marked "AB-80", for No. 80 gauge, Styles in Class 51700-----	1
	51718 A-88	Needle Holder, marked "AB-88", for No. 88 gauge, Styles in Class 51700-----	1
	51718 A-96	Needle Holder, marked "AB-96", for No. 96 gauge, Styles in Class 51700-----	1
	51718 A-112	Needle Holder, marked "AB-112", for No. 112 gauge, Styles in Class 51700-----	1
	51718 A-128	Needle Holder, marked "AB-128", for No. 128 gauge, Styles in Class 51700-----	1
28	22894 P	Spot Screw -----	1
29	98	Needle Set Screw-----	2
30 to 51		See following page	



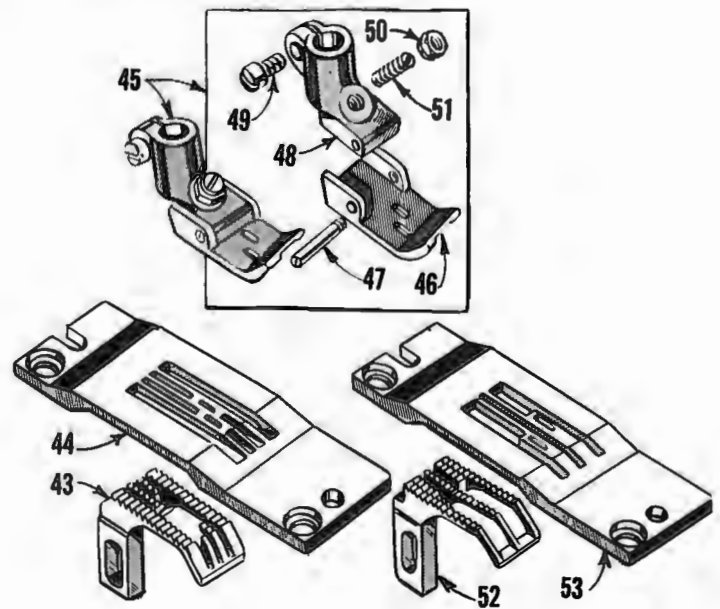
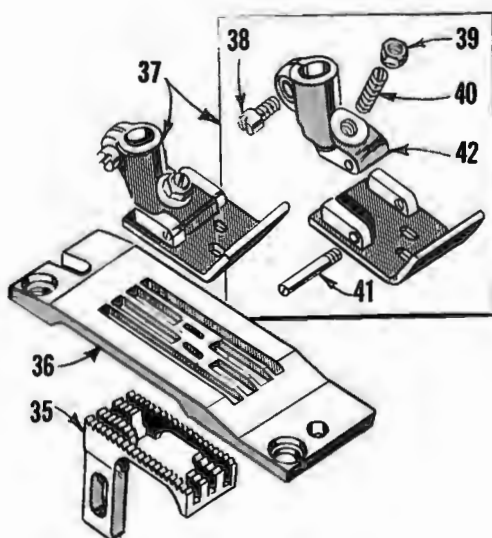
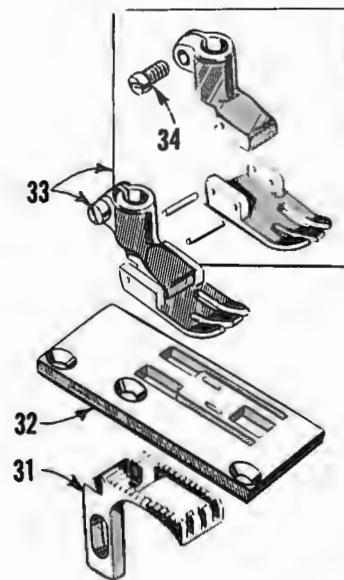
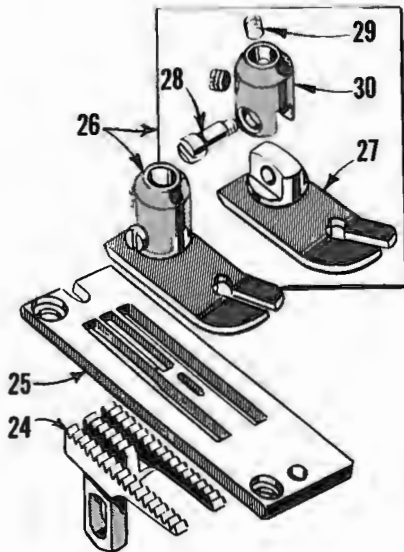
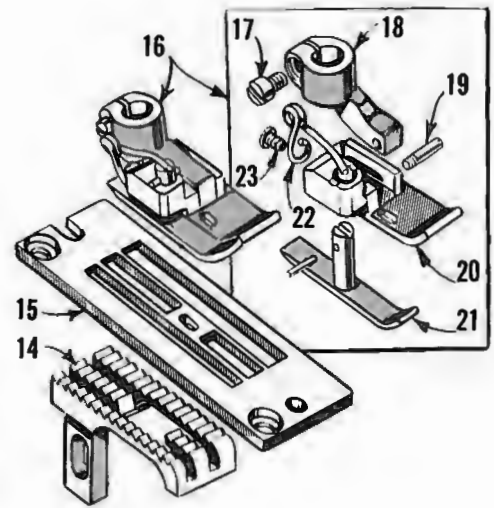
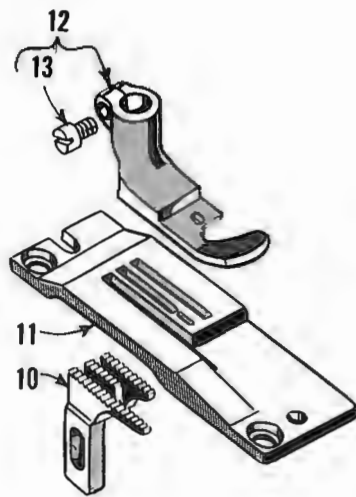
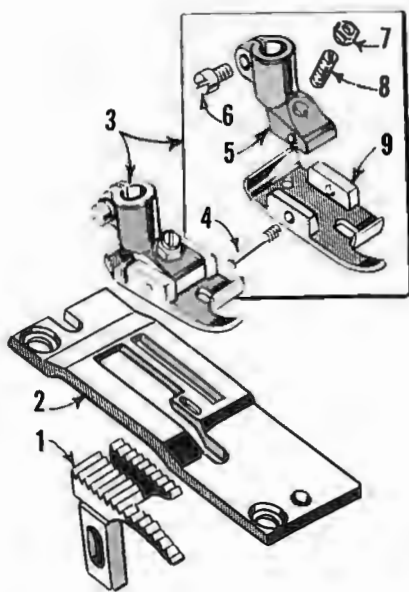
NEEDLE GUARDS, NEEDLE BARS AND NEEDLE HOLDERS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1 to 29		See preceding page	
30	51417 D	Needle Bar, marked "DE", for Nos. 24, 26, 32, 48 gauges, Styles 51400 BA, BB, BQ, BR, BS, BU, BX, BY-----	1
31	50 J-40	Stop Pin-----	1
32	51418 K-24	Needle Holder, marked "L-24", for No. 24 gauge, Style 51400 BX-----	1
	51418 K-26	Needle Holder, marked "L-26", for No. 26 gauge, Style 51400 BX-----	1
33	51418 B-32	Needle Holder, marked "D-32", for No. 32 gauge, Styles 51400 BS, BU, BY-----	1
34	51418 D-48	Needle Holder, marked "AC-48", for No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS-----	1
35	29202 N-1	Needle Bar Assembly, for No. 1 gauge, Style 51500 BK--	1
	29202 M-1	Needle Bar Assembly, for No. 1 gauge, Style 51500 BN--	1
36	51518 C-1	Needle Holder, for No. 1 gauge, Style 51500 BK----	1
	51518 G-1	Needle Holder, for No. 1 gauge, Style 51500 BN----	1
37	89	Spot Screw-----	1
38	88 B	Needle Set Screw-----	1
39	22729	Needle Clamp Screw-----	1
40	56517 E-1	Needle Bar, marked "EL", for No. 1 gauge, Style 51500 BK-----	1
	56517 D-1	Needle Bar, marked "EK", for No. 1 gauge, Style 51500 BN-----	1
41	50 J-16	Stop Pin-----	1
42	51925	Needle Guard, for Styles 51500 BP; 51900 BG, BH, BJ----	1
43	56917	Needle Bar, marked "EP-9", for No. 18 gauge, Style 51500 BP; Nos. 8 and 9 gauges, Styles 51900 BH, BJ---	1
44	50 J-26	Stop Pin-----	1
45	22580	Needle Set Screw, outer-----	2
46	35818 N-8	Needle Holder, marked "C-8", for No. 8 gauge, Style 51900 BH-----	1
	35818 N-9	Needle Holder, marked "C-9", for No. 18 gauge, Style 51500 BP; No. 9 gauge, Styles 51900 BH, BJ-----	1
47	22752	Needle Set Screw, middle-----	1
48	51917 A	Needle Bar, marked "DC", for Nos. 5, 6, 7 gauges, Styles 51900 BG, BH-----	1
49	50 J-26	Stop Pin-----	1
50	51918-5	Needle Holder, marked "E-5", for No. 5 gauge, Style 51900 BG-----	1
	51918-6	Needle Holder, marked "E-6", for No. 6 gauge, Style 51900 BG-----	1
	51918-7	Needle Holder, marked "E-7", for No. 7 gauge, Style 51900 BG-----	1
51	22752 A	Needle Set Screw, middle-----	1



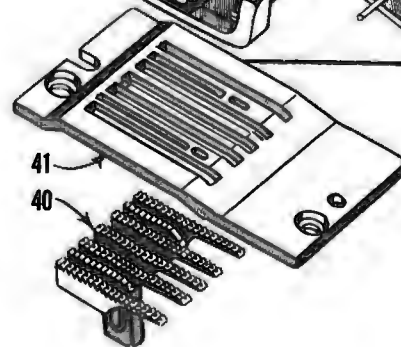
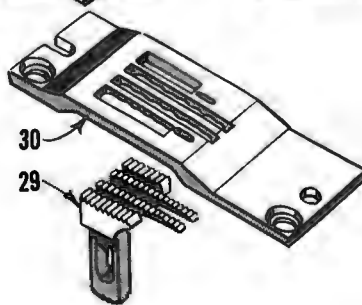
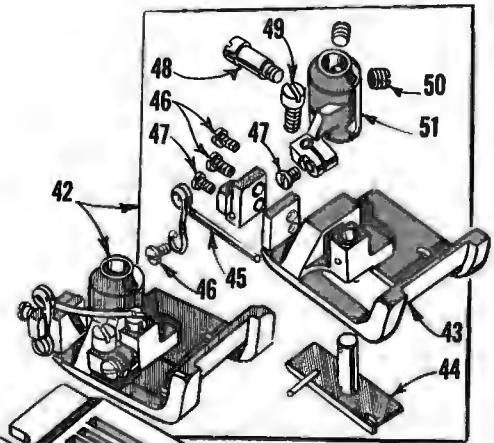
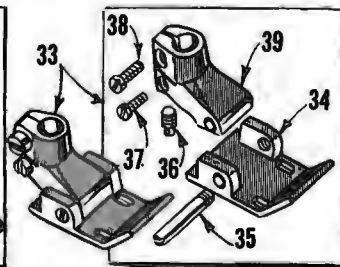
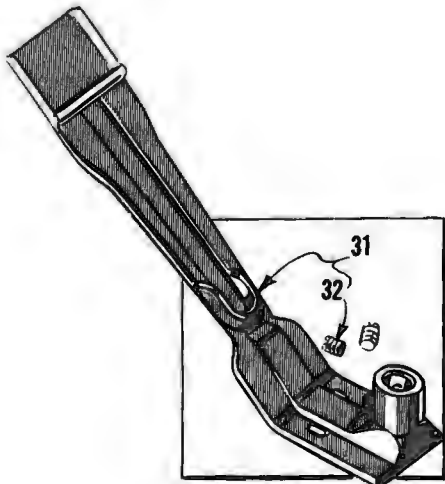
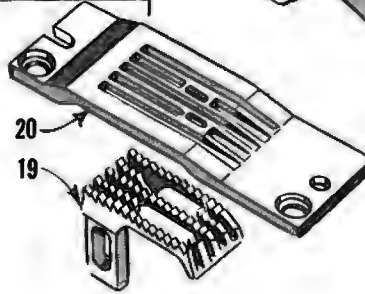
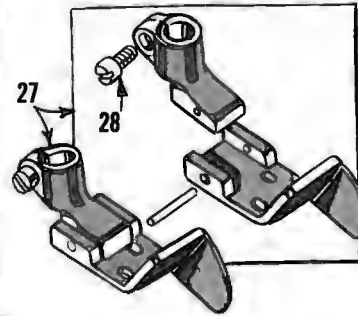
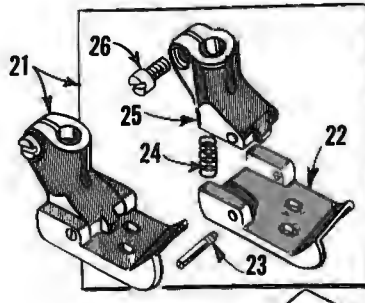
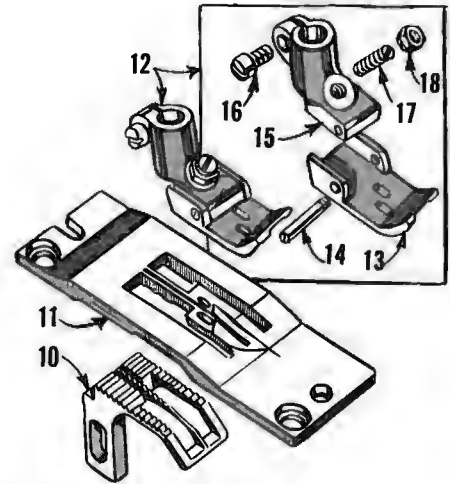
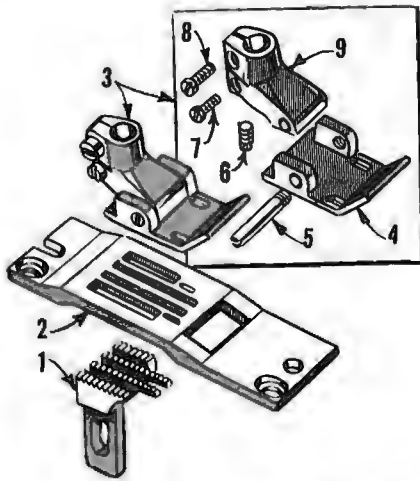
FEED DOGS, THROAT PLATES, PRESSER FEET

Ref. No.	Part No.	Description	Amt. Req.
1	22 I	Feed Dog, for Style 51200 BS-	1
2	195 D	Throat Plate, for Style 51200 BS-	1
3	65 A	Presser Foot, for Style 51200 BS-	1
4	65 AD	Presser Foot Bottom-	1
5	91	Clamp Screw-	1
6	22 D	Feed Dog, for Style 51200 BP-	1
7	1724 F	Throat Plate, for Style 51200 BP-	1
8	51220 E	Presser Foot, for Style 51200 BP-	1
9	51230 E	Presser Foot Bottom-	1
10	22799 G	Hinge Screw-	1
11	51230	Presser Foot Shank	1
12	91	Clamp Screw-	1
13	6235	Spring Toe	1
14	91 A	Screw-	1
15	51305 A	Feed Dog, for Styles 51300 BG, BJ	1
16	9224 E	Throat Plate, for Styles 51300 BG, EJ	1
17	51320 G	Presser Foot, for Style 51300 BG-	1
18	6530 A	Presser Foot Bottom-	1
19	22799 B	Hinge Screw-	1
20	1741 B	Chain Cutting Knife-	1
21	187 A	Screw-	1
22	91	Clamp Screw-	1
23	6530	Presser Foot Shank	1
24	51320 C	Presser Foot, for Style 51300 BJ-	1
25	51330 C	Presser Foot Bottom-	1
26	51530 A	Presser Foot Shank	1
27	91	Clamp Screw-	1
28	22799 B	Hinge Screw-	1
29	6405 W	Feed Dog, for Style 51200 BM-	1
30	6424 W	Throat Plate, for Style 51200 BM-	1
31	6420 W	Presser Foot, for Style 51200 BM-	1
32	22799 E	Hinge Screw-	1
33	6430	Presser Foot Shank	1
34	91	Clamp Screw-	1
35	51430 F	Adjusting Nut-	1
36	22840 A	Adjusting Screw-	1
37	6430 A	Presser Foot Bottom-	1
38	6405 U	Feed Dog, for Style 51200 BT-	1
39	6428 L	Throat Plate, for Style 51200 BT-	1
40	51220 J	Presser Foot, for Style 51200 BT-	1
41	11534	Yielding Section Spring-	1
42	605	Screw-	1
43	91	Clamp Screw-	1
44	187 A	Screw-	1
45	22799 B	Hinge Screw-	1
46	197 X	Feed Dog, for Style 51300 BL-	1
47	6624	Throat Plate, for Style 51300 HL-	1
48	6627 A	Presser Foot, for Style 51300 BL-	1
49	1741 B	Chain Cutting Knife-	1
50	187 A	Screw-	1
51	86 X	Hinge Screw-	1
52	88	Set Screw-	2
53	25 B	Screw-	2
54	199	Needle Guard	1
55	9705	Feed Dog, for Style 51200 BR-	1
56	9724	Throat Plate, for Style 51200 BR-	1
57	9720	Presser Foot, for Style 51200 BR-	1
58	91	Clamp Screw-	1
59	9634	Yielding Section Spring-	1
60	57 WD	Screw-	1
61	9634 A	Spring Pin	1
62	605	Screw-	2
63	9735	Detachable Toe	1
64	22 W	Feed Dog, for Style 51200 BX-	1
65	51224 X	Throat Plate, for Style 51200 EX-	1
66	51220 W	Presser Foot, for Styles 51200 BW, BX	1
67	1741 B	Chain Cutting Knife-	1
68	187 B	Screw-	1
69	91	Clamp Screw-	1
70	51230 F	Presser Foot Shank	1
71	51230 G	Presser Foot Bottom-	1
72	51205 W	Feed Dog, for Style 51200 BW-	1
73	51224 E	Throat Plate, for Style 51200 BW-	1



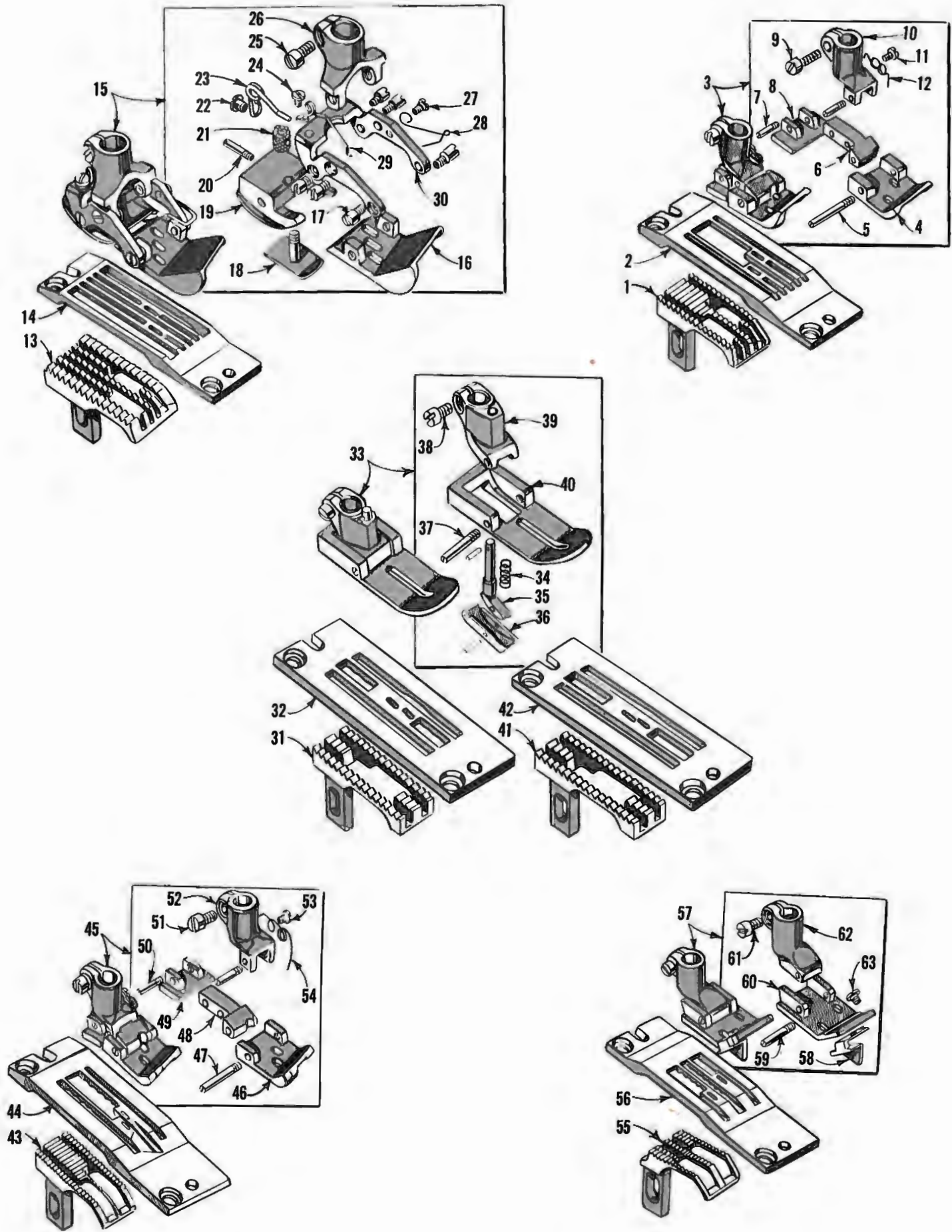
FEED DOGS, THROAT PLATES, PRESSER FEET

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	6405 M	Feed Dog, for Styles 51200 BL; 51300 BM-----	1
2	51224 B	Throat Plate, for Styles 51200 BL; 51300 BM-----	1
3	6420 W	Presser Foot, for Styles 51200 BL; 51300 BM-----	1
4	22799 E	Hinge Screw -----	1
5	6430	Presser Foot Shank -----	1
6	91	Clamp Screw-----	1
7	51430 F	Adjusting Nut -----	1
8	22840 A	Adjusting Screw -----	1
9	6430 A	Presser Foot Bottom -----	1
10	51205 A	Feed Dog, for Style 51200 BK-----	1
11	51224 A	Throat Plate, for Style 51200 BK-----	1
12	51220 A	Presser Foot, for Style 51200 BK-----	1
13	91	Clamp Screw-----	1
14	51205 F	Feed Dog, for Style 51200 BG-----	1
15	51224 F	Throat Plate, for Style 51200 BG-----	1
16	56320 R	Presser Foot, for Style 51200 BG-----	1
17	91	Clamp Screw-----	1
18	56330 D	Presser Foot Shank-----	1
19	22799 G	Hinge Screw -----	1
20	56330 C	Presser Foot Bottom -----	1
21	51230 N	Yielding Section-----	1
22	19146 A	Yielding Section Spring-----	1
23	604	Screw -----	1
24	51305 B	Feed Dog, for Style 51300 BH-----	1
25	51324 B	Throat Plate, for Style 51300 BH-----	1
26	51320 B	Presser Foot, for Style 51300 BH-----	1
27	51330 B	Presser Foot Bottom -----	1
28	86 X	Hinge Screw -----	1
29	88	Set Screw-----	2
30	65 XD	Presser Foot Shank-----	1
31	7005 A-6	Feed Dog, for No. 18 gauge, Style 51400 BV-----	1
32	7024 C-5	Throat Plate, for No. 18 gauge, Style 51400 BV-----	1
33	7020 B-4 1/2	Presser Foot, for No. 16 gauge, Style 51400 BV-----	1
	7020 B-5	Presser Foot, for No. 18 gauge, Style 51400 BV-----	1
34	91	Clamp Screw-----	1
35	51405 AD-12	Feed Dog, for No. 12 gauge, Style 51400 BD-----	1
	51405 AD-16	Feed Dog, for No. 16 gauge, Style 51400 BD-----	1
36	51424 AD-12	Throat Plate, for No. 12 gauge, Style 51400 BD-----	1
	51424 AD-16	Throat Plate, for No. 16 gauge, Style 51400 BD-----	1
37	51420 AD-12	Presser Foot, for No. 12 gauge, Style 51400 BD-----	1
	7420 AG-4 1/2	Presser Foot, for No. 16 gauge, Style 51400 BD-----	1
38	91	Clamp Screw-----	1
39	51430 F	Adjusting Nut -----	1
40	22840 A	Adjusting Screw -----	1
41	22799 E	Hinge Screw -----	1
42	51430 D	Presser Foot Shank-----	1
43	51405 A-8	Feed Dog, for Nos. 6 and 8 gauge, Style 51400 BP-----	1
	51405 A-10	Feed Dog, for Nos. 10 and 12 gauge, Style 51400 BP-----	1
44	51424 A-6	Throat Plate, for No. 6 gauge, Style 51400 BP-----	1
	51424 A-8	Throat Plate, for No. 8 gauge, Style 51400 BP-----	1
	51424 A-10	Throat Plate, for No. 10 gauge, Style 51400 BP-----	1
	51424 A-12	Throat Plate, for No. 12 gauge, Style 51400 BP-----	1
45	51420-6	Presser Foot, for No. 6 gauge, Style 51400 BP-----	1
	51420-8	Presser Foot, for No. 8 gauge, Style 51400 BP-----	1
	51420-10	Presser Foot, for No. 10 gauge, Style 51400 BP-----	1
	51420-12	Presser Foot, for No. 12 gauge, Style 51400 BP-----	1
	51420-16	Presser Foot, for No. 16 gauge, Style 51400 BP-----	1
	51420-18	Presser Foot, for No. 18 gauge, Style 51400 BP-----	1
46	51430-A-6	Presser Foot Bottom, for No. 6 gauge, Style 51400 BP-----	1
	51430 A-8	Presser Foot Bottom, for No. 8 gauge, Style 51400 BP-----	1
	51430 A-10	Presser Foot Bottom, for No. 10 gauge, Style 51400 BP-----	1
	51430 A-12	Presser Foot Bottom, for No. 12 gauge, Style 51400 BP-----	1
	51430 A-16	Presser Foot Bottom, for No. 16 gauge, Style 51400 BP-----	1
	51430 A-18	Presser Foot Bottom, for No. 18 gauge, Style 51400 BP-----	1
47	22799 B	Hinge Screw -----	1
48	51430 D	Presser Foot Shank-----	1
49	91	Clamp Screw-----	1
50	51430 F	Adjusting Nut -----	1
51	22840 A	Adjusting Screw -----	1
52	51405-16	Feed Dog, for Nos. 16 and 18 gauge, Style 51400 BP-----	1
53	51424-16	Throat Plate, for No. 16 gauge, Style 51400 BP-----	1
	51424-18	Throat Plate, for No. 18 gauge, Style 51400 BP-----	1



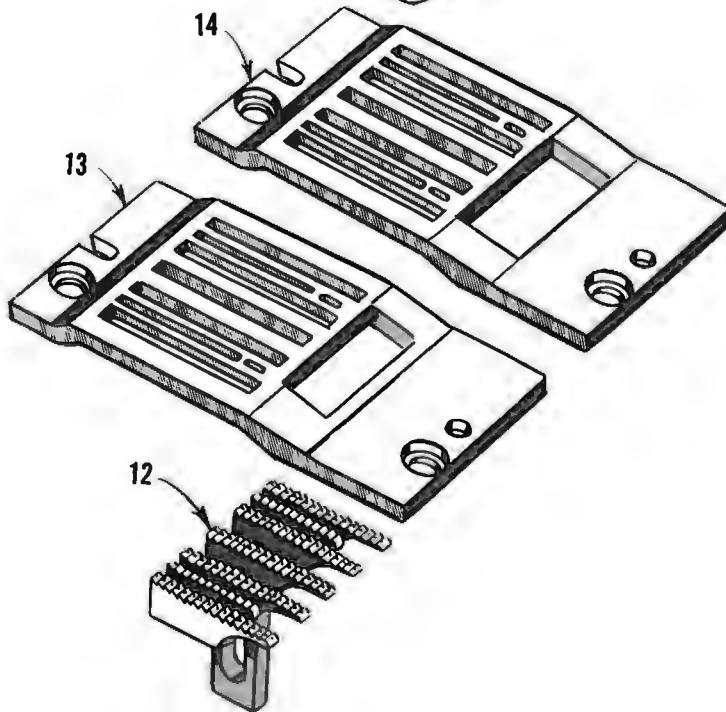
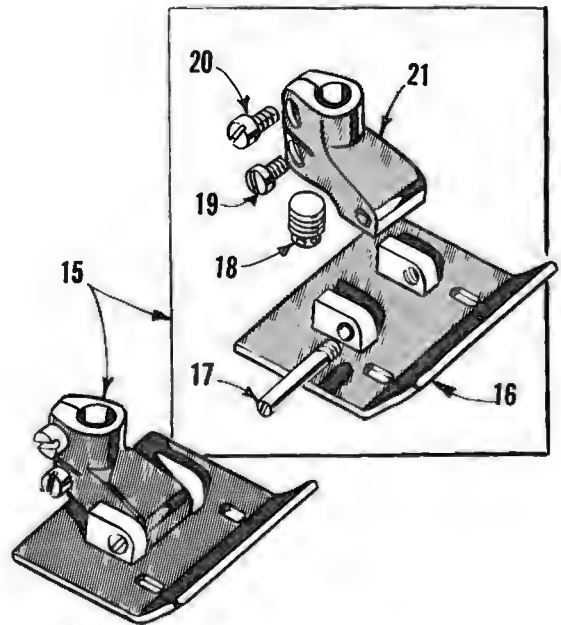
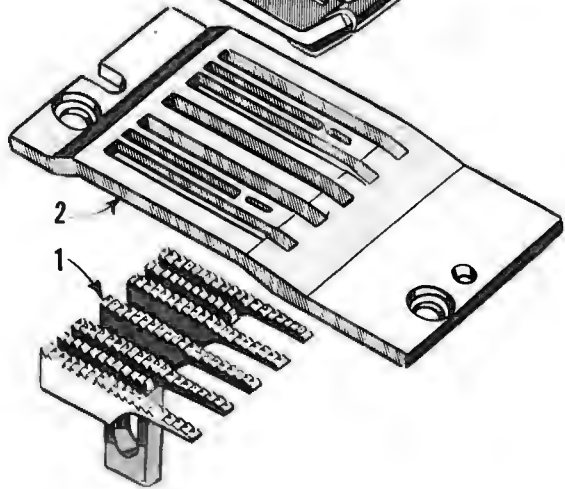
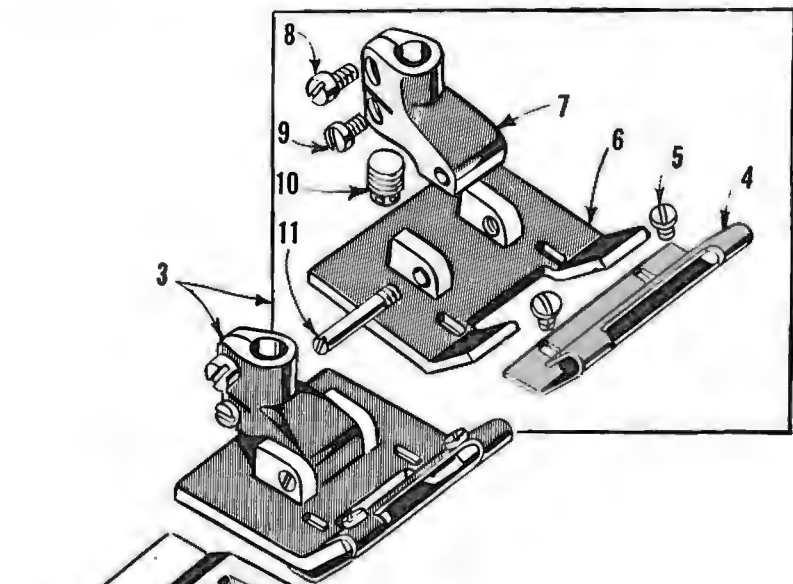
FEED DOGS, THROAT PLATES, PRESSER FEET

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	51405 B-32	Feed Dog, for No. 32 gauge, Style 51400 BS -----	1
	51405 B-48	Feed Dog, for No. 48 gauge, Style 51400 BS -----	1
2	51424 B-32	Throat Plate, for No. 32 gauge, Style 51400 BS -----	1
	51424 B-48	Throat Plate, for No. 48 gauge, Style 51400 BS -----	1
3	51420 C-32	Presser Foot, for No. 32 gauge, Style 51400 BS -----	1
	51420 C-48	Presser Foot, for No. 48 gauge, Style 51400 BS -----	1
4	51430 C-32	Presser Foot Bottom, for No. 32 gauge, Style 51400 BS -----	1
	51430 C-48	Presser Foot Bottom, for No. 48 gauge, Style 51400 BS -----	1
5	22799 D	Hinge Screw -----	1
6	22752 B	Adjusting Screw -----	1
7	77	Clamp Screw, lower -----	1
8	91	Clamp Screw, upper -----	1
9	51430	Presser Foot Shank -----	1
10	51405 G-8	Feed Dog, for Nos. 8, 10 and 12 gauge, Style 51400 BT -----	1
	51405 G-16	Feed Dog, for No. 16 gauge, Style 51400 BT -----	1
11	51424 E-8	Throat Plate, for No. 8 gauge, Style 51400 BT -----	1
	51424 E-10	Throat Plate, for No. 10 gauge, Style 51400 BT -----	1
	51424 E-12	Throat Plate, for No. 12 gauge, Style 51400 BT -----	1
	51424 E-16	Throat Plate, for No. 16 gauge, Style 51400 BT -----	1
12	51420 E-8	Presser Foot, for No. 8 gauge, Style 51400 BT -----	1
	51420 E-10	Presser Foot, for No. 10 gauge, Style 51400 BT -----	1
	51420 E-12	Presser Foot, for No. 12 gauge, Style 51400 BT -----	1
	51420 E-16	Presser Foot, for No. 16 gauge, Style 51400 BT -----	1
13	51430 E-8	Presser Foot Bottom, for No. 8 gauge, Style 51400 BT -----	1
	51430 E-10	Presser Foot Bottom, for No. 10 gauge, Style 51400 BT -----	1
	51430 E-12	Presser Foot Bottom, for No. 12 gauge, Style 51400 BT -----	1
	51430 E-16	Presser Foot Bottom, for No. 16 gauge, Style 51400 BT -----	1
14	22799 B	Hinge Screw -----	1
15	51430 D	Presser Foot Shank -----	1
16	91	Clamp Screw -----	1
17	22840 A	Adjusting Screw -----	1
18	51430 F	Adjusting Nut -----	1
19	51505-18	Feed Dog, for Nos. 16 and 18 gauge, Style 51500 BJ -----	1
20	51524-16	Throat Plate, for No. 16 gauge, Style 51500 BJ -----	1
	51524-18	Throat Plate, for No. 18 gauge, Style 51500 BJ -----	1
21	51520-16	Presser Foot, for No. 16 gauge, Style 51500 BJ -----	1
	51520-18	Presser Foot, for No. 18 gauge, Style 51500 BJ -----	1
22	51530-16	Presser Foot Bottom, for No. 16 gauge, Style 51500 BJ -----	1
	51530-18	Presser Foot Bottom, for No. 18 gauge, Style 51500 BJ -----	1
23	22799 C	Hinge Screw -----	1
24	51930	Spring -----	1
25	35830	Presser Foot Shank -----	1
26	91	Clamp Screw -----	1
27	7527 U-5	Presser Foot, for No. 18 gauge, Style 51500 BM -----	1
28	91	Clamp Screw -----	1
29	51405 F-32	Feed Dog, for No. 32 gauge, Styles 51400 BU, BY -----	1
30	51424 F-32	Throat Plate, for No. 32 gauge, Styles 51400 BU, BY -----	1
31	51420 L-32	Folder Presser Foot, for No. 32 gauge, Style 51400 BY -----	1
32	88	Screw -----	2
33	51420 C-32	Presser Foot, for No. 32 gauge, Style 51400 BU -----	1
	51420 C-48	Presser Foot, for No. 48 gauge, Styles 51400 BB, BR -----	1
34	51430 C-32	Presser Foot Bottom, for No. 32 gauge, Style 51400 BU -----	1
	51430 C-48	Presser Foot Bottom, for No. 48 gauge, Styles 51400 BB, BR -----	1
35	22799 D	Hinge Screw -----	1
36	22752 B	Adjusting Screw -----	1
37	77	Clamp Screw, lower -----	1
38	91	Clamp Screw, upper -----	1
39	51430	Presser Foot Shank -----	1
40	51405 C-48	Feed Dog, for No. 48 gauge, Styles 51400 BA, BB, BR -----	1
41	51424 C-48	Throat Plate, for No. 48 gauge, Styles 51400 BA, BB, BR -----	1
42	51420 M-48	Presser Foot, for No. 48 gauge, Style 51400 BA -----	1
43	51430 M-48	Presser Foot Bottom, for No. 48 gauge, Style 51400 BA -----	1
44	51430 N-48	Yielding Section, for No. 48 gauge, Style 51400 BA -----	1
45	16194	Yielding Section Spring -----	1
46	605	Screw -----	3
47	605 A	Screw -----	2
48	86 X	Hinge Screw -----	1
49	97	Screw -----	1
50	88	Set Screw -----	2
51	51430 G	Presser Foot Shank -----	1



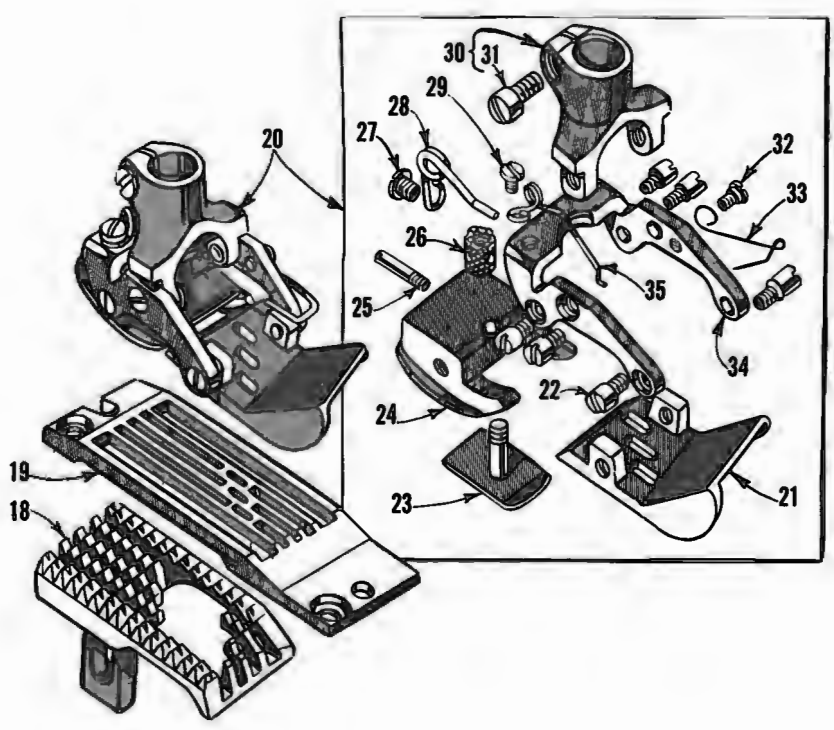
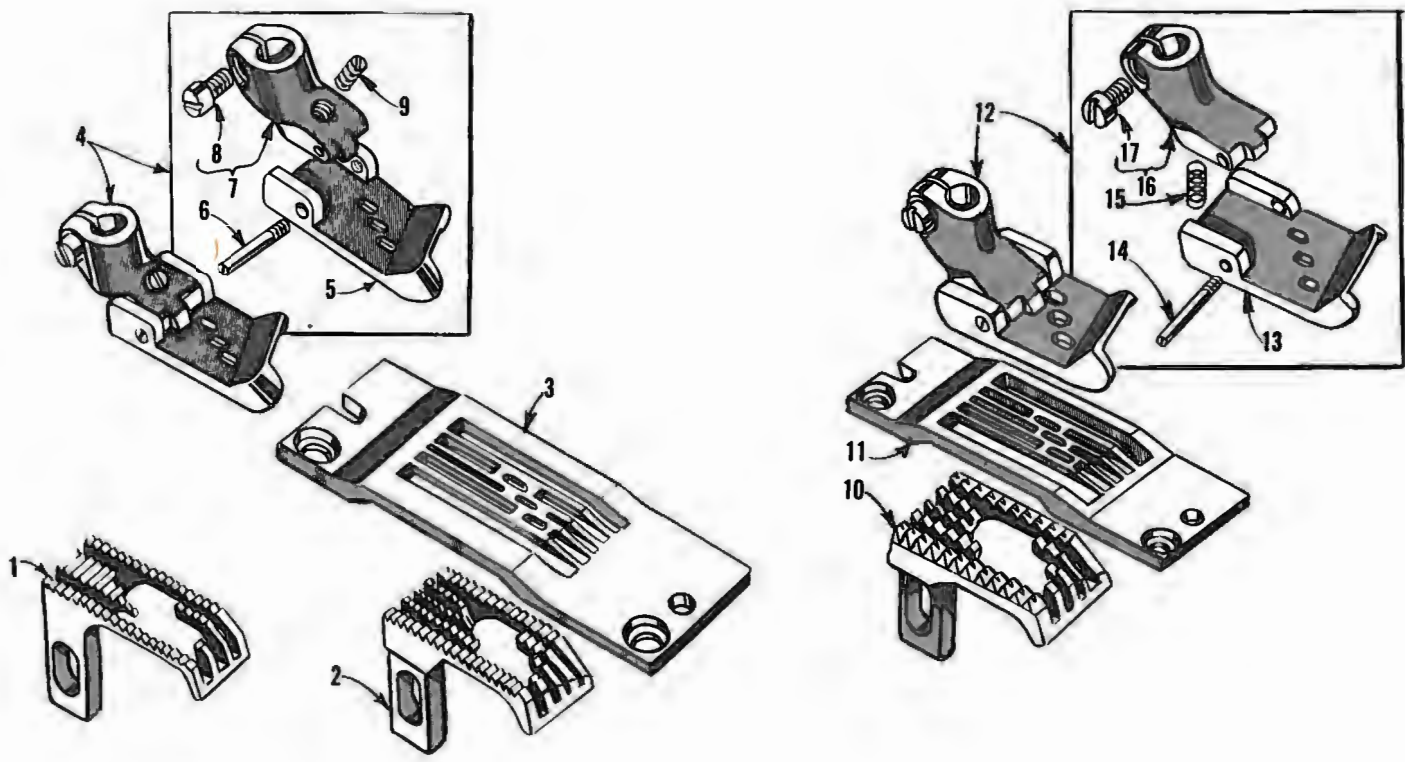
FEED DOGS, THROAT PLATES, PRESSER FEET

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	51505 BR-18	Feed Dog, for No. 18 gauge, Style 51500 BR-----	1
2	51524 BR-18	Throat Plate, for No. 18 gauge, Style 51500 BR-----	1
3	51520 BR-18	Presser Foot, for No. 18 gauge, Style 51500 BR-----	1
4	51530 BR-18	Bottom, front section-----	1
5	22799 C	Hinge Screw-----	1
6	35730 AC	Hinged Section-----	1
7	22799 G	Hinge Screw-----	2
8	51530 J	Bottom, rear section-----	1
9	91	Clamp Screw-----	1
10	35730 AD	Shank-----	1
11	73 A	Screw-----	1
12	35730 AE	Spring-----	1
13	K65184	Feed Dog, for No. 18 gauge, Style 51500 BP-----	1
14	K65183	Throat Plate, for No. 18 gauge, Style 51500 BP-----	1
15	35820 R-9	Presser Foot, for No. 18 gauge, Style 51500 BP-----	1
16	35830 R-9	Bottom, front section-----	1
17	22845 A	Hinge Screw-----	6
18	35830 E	Yielding Section-----	1
19	35830 G	Bottom, rear section-----	1
20	22799 L	Set Screw-----	1
21	35830 F	Adjusting Nut-----	1
22	73 A	Screw-----	1
23	35830 D	Yielding Section Spring-----	1
24	22561	Screw-----	1
25	91 D	Clamp Screw-----	1
26	35830 B	Shank-----	1
27	22599	Screw-----	1
28	35830 K	Equalizing Spring, front-----	1
29	35830 H	Equalizing Spring, rear section-----	1
30	35830 C	Yoke-----	1
31	51505 C-1	Feed Dog, for No. 1 gauge, Style 51500 BK-----	1
32	56528 C-1	Throat Plate, for No. 1 gauge, Style 51500 BK-----	1
33	51520 C-1	Presser Foot, for No. 1 gauge, Style 51500 BK, BN-----	1
34	51530 G	Plunger Spring-----	1
35	51530 F	Plunger-----	1
36	51530 E	Yielding Section-----	1
37	22799 C	Hinge Screw-----	1
38	91	Clamp Screw-----	1
39	51530 D	Shank-----	1
40	51530 C-1	Bottom-----	1
41	51505 G-1	Feed Dog, for No. 1 gauge, Style 51500 BN-----	1
42	51524 G-1	Throat Plate, for No. 1 gauge, Style 51500 BN-----	1
43	51405 R-8	Feed Dog, for Nos. 8 and 10 gauge, Style 51400 BW-----	1
	51405 R-12	Feed Dog, for Nos. 12 and 16 gauge, Style 51400 BW-----	1
44	51424 R-8	Throat Plate, for No. 8 gauge, Style 51400 BW-----	1
	51424 R-10	Throat Plate, for No. 10 gauge, Style 51400 BW-----	1
	51424 R-12	Throat Plate, for No. 12 gauge, Style 51400 BW-----	1
	51424 R-16	Throat Plate, for No. 16 gauge, Style 51400 BW-----	1
45	51420 R-8	Presser Foot, for No. 8 gauge, Style 51400 BW-----	1
	51420 R-10	Presser Foot, for No. 10 gauge, Style 51400 BW-----	1
	51420 R-12	Presser Foot, for No. 12 gauge, Style 51400 BW-----	1
	51420 R-16	Presser Foot, for No. 16 gauge, Style 51400 BW-----	1
46	51430 R-8	Bottom, front section, for No. 8 gauge, Style 51400 BW-----	1
	51430 R-10	Bottom, front section, for No. 10 gauge, Style 51400 BW-----	1
	51430 R-12	Bottom, front section, for No. 12 gauge, Style 51400 BW-----	1
	51430 R-16	Bottom, front section, for No. 16 gauge, Style 51400 BW-----	1
47	22799 E	Hinge Screw-----	1
48	35730 AC	Hinged Section-----	1
49	35730 AB	Bottom, rear section-----	1
50	22799 G	Hinge Screw-----	2
51	91	Clamp Screw-----	1
52	35730 AD	Shank-----	1
53	73 A	Screw-----	1
54	35730 AE	Spring-----	1
55	51405 K-26	Feed Dog, for Nos. 24 and 26 gauge, Style 51400 BX-----	1
56	51424 K-24	Throat Plate, for No. 24 gauge, Style 51400 BX-----	1
	51424 K-26	Throat Plate, for No. 26 gauge, Style 51400 BX-----	1
57	51420 K-24	Presser Foot, for No. 24 gauge, Style 51400 BX-----	1
	51420 K-26	Presser Foot, for No. 26 gauge, Style 51400 BX-----	1
58	53530 E	Guide-----	1
59	22799 B	Hinge Screw-----	1
60	51430 K-26	Bottom, for No. 26 gauge, Style 51400 BX-----	1
61	91	Clamp Screw-----	1
62	51430 B	Shank-----	1
63	187 A	Screw-----	1



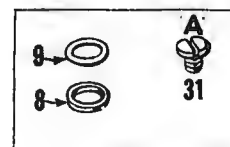
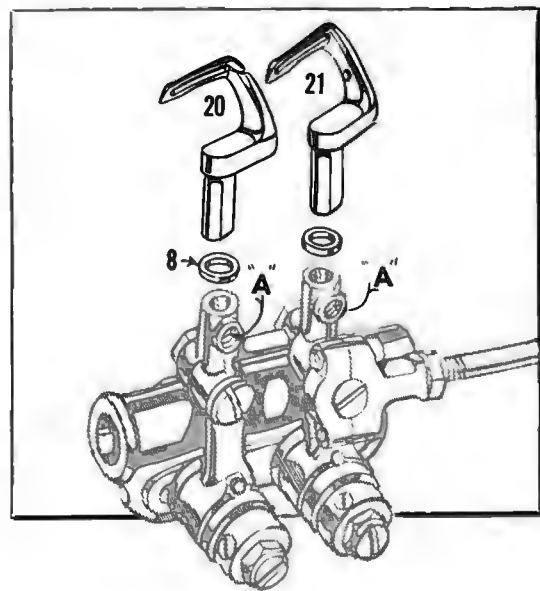
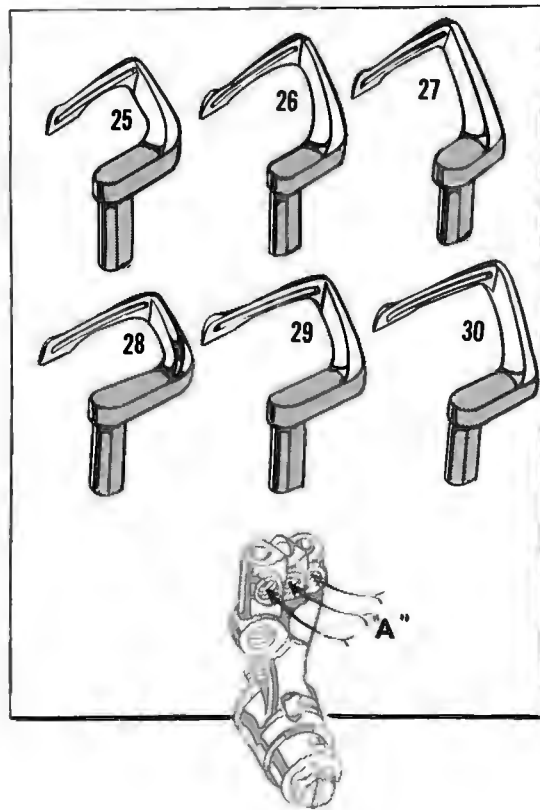
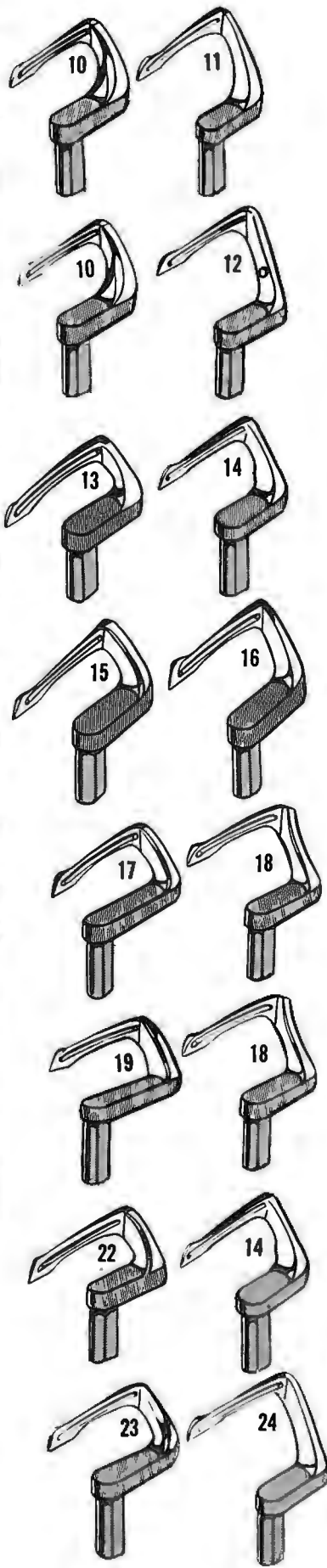
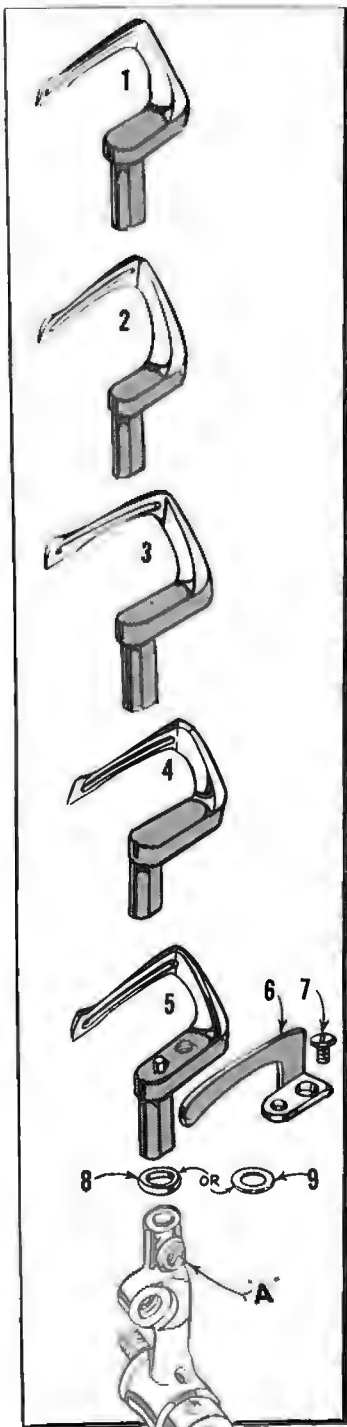
FEED DOGS, THROAT PLATES, PRESSER FEET

Ref. No.	Part No.	Description	Amt. Req.
1	51705-56	Feed Dog, for No. 56 gauge, Styles 51700 BJ, BQ-	1
	51705-64	Feed Dog, for No. 64 gauge, Styles 51700 BJ, BQ-	1
	51705-72	Feed Dog, for No. 72 gauge	1
	51705-80	Feed Dog, for No. 80 gauge	1
	51705-96	Feed Dog, for No. 96 gauge	1
	51705-112	Feed Dog, for No. 112 gauge-	1
2	51724-56	Throat Plate, for No. 56 gauge, Styles 51700 BJ, BQ-	1
	51724-64	Throat Plate, for No. 64 gauge, Styles 51700 BJ, BQ-	1
	51724-72	Throat Plate, for No. 72 gauge	1
	51724-80	Throat Plate, for No. 80 gauge	1
	51724-96	Throat Plate, for No. 96 gauge	1
	51724-112	Throat Plate, for No. 112 gauge-	1
3	51720-56	Presser Foot, for No. 56 gauge, Styles 51700 BJ, BQ-	1
	51720-64	Presser Foot, for No. 64 gauge, Styles 51700 BJ, BQ-	1
	51720-72	Presser Foot, for No. 72 gauge	1
	51720-80	Presser Foot, for No. 80 gauge	1
	51720-96	Presser Foot, for No. 96 gauge	1
	51720-112	Presser Foot, for No. 112 gauge-	1
4	51730 A-56	Flexible Toe, for No. 56 gauge, Styles 51700 BJ, BQ	1
	51730 A-64	Flexible Toe, for No. 64 gauge, Styles 51700 BJ, BQ	1
	51730 A-72	Flexible Toe, for No. 72 gauge-	1
	51730 A-80	Flexible Toe, for No. 80 gauge-	1
	51730 A-96	Flexible Toe, for No. 96 gauge-	1
	51730 A-112	Flexible Toe, for No. 112 gauge	1
5	91 A	Screw	2
6	51730-56	Presser Foot Bottom, for No. 56 gauge, Style 51700 BJ, BQ	1
	51730-64	Presser Foot Bottom, for No. 64 gauge, Styles 51700 BJ, BQ-	1
	51730-72	Presser Foot Bottom, for No. 72 gauge	1
	51730-80	Presser Foot Bottom, for No. 80 gauge	1
	51730-96	Presser Foot Bottom, for No. 96 gauge	1
	51730-112	Presser Foot Bottom, for No. 112 gauge-	1
7	51430	Presser Foot Shank-	1
8	91	Clamp Screw, upper-	1
9	77	Clamp Screw, lower-	1
10	22752 B	Adjusting Screw	1
11	22799 D	Hinge Screw	1
12	51705 D-56	Feed Dog, for No. 56 gauge, Style 51700 BR	1
	51705 D-64	Feed Dog, for No. 64 gauge, Style 51700 BK	1
	51705 D-72	Feed Dog, for No. 72 gauge	1
	51705 D-80	Feed Dog, for No. 80 gauge	1
	51705 D-96	Feed Dog, for No. 96 gauge	1
	51705 D-112	Feed Dog, for No. 112 gauge-	1
13	51724 D-56	Throat Plate, for No. 56 gauge	1
	51724 D-64	Throat Plate, for No. 64 gauge, Style 51700 BK	1
	51724 D-72	Throat Plate, for No. 72 gauge	1
	51724 D-80	Throat Plate, for No. 80 gauge	1
	51724 D-96	Throat Plate, for No. 96 gauge	1
	51724 D-112	Throat Plate, for No. 112 gauge-	1
14	K59843	Throat Plate, for No. 56 gauge, Style 51700 BR	1
15	51720 D-56	Presser Foot, for No. 56 gauge, Style 51700 BR	1
	51720 D-64	Presser Foot, for No. 64 gauge, Style 51700 BK	1
	51720 D-72	Presser Foot, for No. 72 gauge	1
	51720 D-80	Presser Foot, for No. 80 gauge	1
	51720 D-96	Presser Foot, for No. 96 gauge	1
	51720 D-112	Presser Foot, for No. 112 gauge-	1
16	51730 D-56	Presser Foot Bottom, for No. 56 gauge, Style 51700 BK	1
	51730 D-64	Presser Foot Bottom, for No. 64 gauge, Styles 51700 BK, BR-	1
	51730 D-72	Presser Foot Bottom, for No. 72 gauge	1
	51730 D-80	Presser Foot Bottom, for No. 80 gauge	1
	51730 D-96	Presser Foot Bottom, for No. 96 gauge	1
	51730 D-112	Presser Foot Bottom, for No. 112 gauge-	1
17	22799 D	Hinge Screw	1
18	22752 B	Adjusting Screw	1
19	77	Clamp Screw, lower-	1
20	91	Clamp Screw, upper-	1
21	51430	Presser Foot Shank-	1



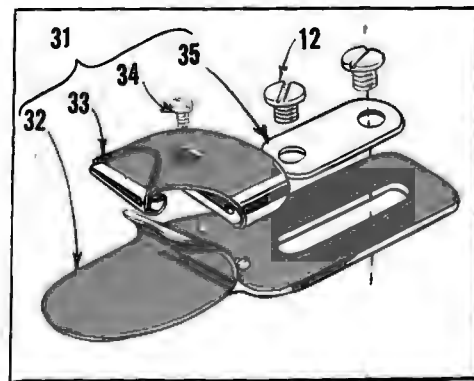
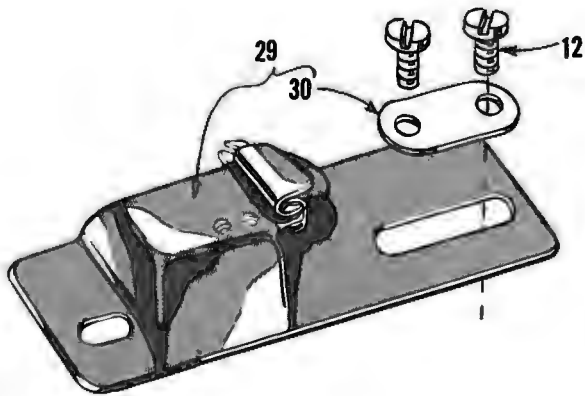
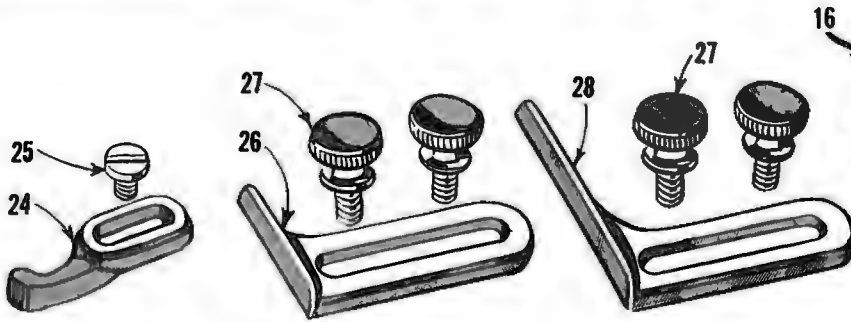
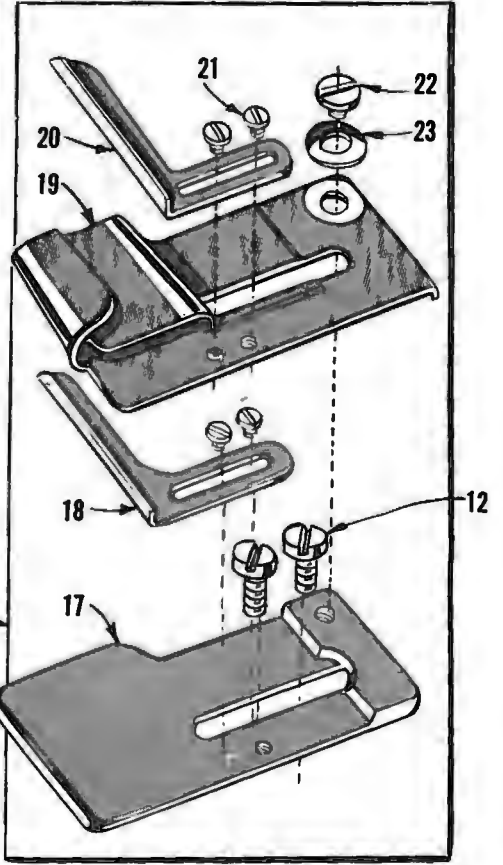
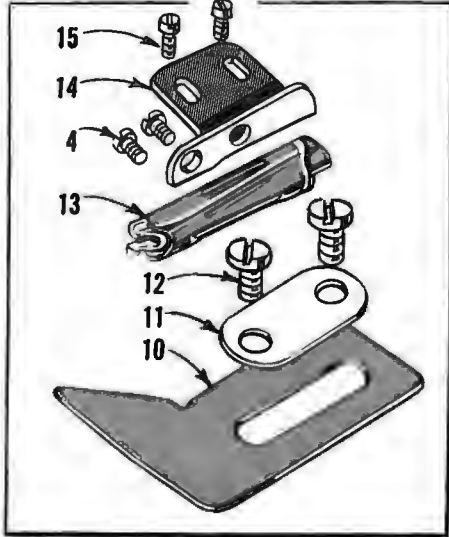
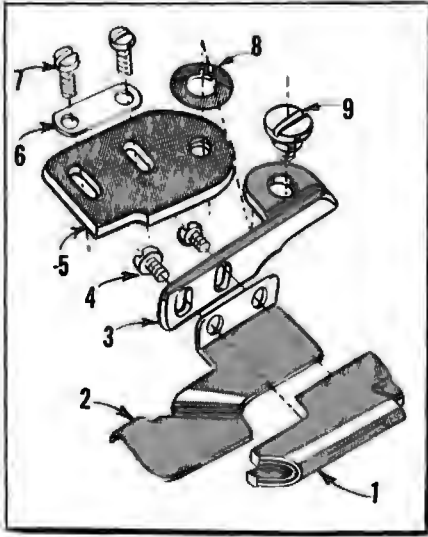
FEED DOGS, THROAT PLATES, PRESSER FEET

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	51905-5	Feed Dog, for No. 5 gauge, Style 51900 BG -----	1
2	51905 A-7	Feed Dog, for Nos. 6 and 7 gauges, Styles 51900 BG, BH-----	1
3	51924 A-6	Throat Plate, for No. 6 gauge, Style 51900 BG -----	1
	51924 A-7	Throat Plate, for No. 7 gauge, Styles 51900 BG, BH-----	1
4	51920-5	Presser Foot, for No. 5 gauge, Style 51900 BG-----	1
	51920-6	Presser Foot, for No. 6 gauge, Style 51900 BG-----	1
	51920-7	Presser Foot, for No. 7 gauge, Styles 51900 BG, BH -----	1
5	51930 B-5	Presser Foot Bottom, for No. 5 gauge, Style 51900 BG---	1
	51930 B-6	Presser Foot Bottom, for No. 6 gauge, Style 51900 BG---	1
	51930 B-7	Presser Foot Bottom, for No. 7 gauge, Styles 51900 BG, BH -----	1
6	22799 B	Hinge Screw -----	1
7	51930 A	Presser Foot Shank-----	1
8	91	Clamp Screw-----	1
9	12935 A	Adjusting Screw -----	1
10	51905 B-9	Feed Dog, for Nos. 8 and 9 gauges, Style 51900 BH-----	1
11	51924 B-8	Throat Plate, for No. 8 gauge, Style 51900 BH -----	1
	51924 B-9	Throat Plate, for No. 9 gauge, Style 51900 BH -----	1
12	35820 P-8	Presser Foot, for No. 8 gauge, Style 51900 BH-----	1
	35820 P-9	Presser Foot, for No. 9 gauge, Style 51900 BH-----	1
13	35830 P-8	Presser Foot Bottom, for No. 8 gauge, Style 51900 BH---	1
	35830 P-9	Presser Foot Bottom, for No. 9 gauge, Style 51900 BH---	1
14	22799 C	Hinge Screw -----	1
15	51930	Spring-----	1
16	35830	Presser Foot Shank-----	1
17	91	Clamp Screw-----	1
18	51905 C-9	Feed Dog, for No. 9 gauge, Style 51900 BJ-----	1
19	51924 C-9	Throat Plate, for No. 9 gauge, Style 51900 BJ-----	1
20	35820 R-9	Presser Foot, for No. 9 gauge, Style 51900 BJ-----	1
21	35830 R-9	Bottom, front section -----	1
22	22845 A	Hinge Screw -----	6
23	35830 E	Yielding Section -----	1
24	35830 G	Bottom, rear section -----	1
25	22799 L	Set Screw-----	1
26	35830 F	Adjusting Nut -----	1
27	73 A	Screw-----	1
28	35830 D	Yielding Section Spring-----	1
29	22561	Screw-----	1
30	35830 B	Presser Foot Shank-----	1
31	91 D	Clamp Screw-----	1
32	22599	Screw-----	1
33	35830 K	Equalizing Spring, front section-----	1
34	35830 C	Yoke -----	1
35	35830 H	Equalizing Spring, rear section -----	1



LOOPERS

Ref. No.	Part No.	Description	Amt. Req.
1	51208 D	Looper, for Styles 51200 BG, BP, BS, BT -----	1
2	51409	Looper, for Styles 51200 BK, BR -----	1
3	51909 C	Looper, for Styles 51200 BL; 51300 BM -----	1
4	51208	Looper, for Styles 51200 BM; 51300 BG, BH, BJ, BL -----	1
5	51208 W	Looper, for Styles 51200 BW, BX -----	1
6	51210	Looper Needle Guard, for Styles 51200 BW, BX -----	1
7	73 A	Screw -----	1
8	21210	Looper Collar, .040 inch thick, for Styles 51200 BL, BM, BT, BW, BX; 51300 BH, BJ, BL, BM; 51700 BJ, BK, BQ, BR --	1
9	21210 A	Looper Collar, .020 inch thick, for Styles 51200 BG, BK, BP, BS; 51300 BG -----	1
10	51408-6	Looper, front, for No. 6 gauge, Style 51400 BP -----	1
	51408-8	Looper, front, for No. 8 gauge, Styles 51400 BP, BT, BW ---	1
	51408-10	Looper, front, for No. 10 gauge, Styles 51400 BP, BT, BW --	1
	51408-12	Looper, front, for No. 12 gauge, Styles 51400 BD, BP, BT, BW -----	1
	51408-16	Looper, front, for No. 16 gauge, Styles 51400 BD, BP, BT, BW -----	1
	51408-18	Looper, front, for No. 18 gauge, Style 51400 BP -----	1
	51408-24	Looper, front, for No. 24 gauge, Style 51400 BX -----	1
	51408-26	Looper, front, for No. 26 gauge, Style 51400 BX -----	1
	51408-32	Looper, front, for No. 32 gauge, Styles 51400 BS, BU, BY ---	1
	51408-48	Looper, front, for No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS -----	1
11	51409	Looper, back, for Styles 51400 BD, BP, BT, BW, BX -----	1
12	51409 B	Looper, back, for Styles 51400 BA, BB, BQ, BR, BS, BU, BY --	1
13	K55001	Looper, front, for No. 18 gauge, Style 51400 BV -----	1
14	51208 D	Looper, back, for Style 51400 BV -----	1
15	51508 M-16	Looper, front, for No. 16 gauge, Style 51500 BJ -----	1
	51508 M-18	Looper, front, for No. 18 gauge, Styles 51500 BJ, BM, BR --	1
16	51909 C	Looper, back, for Styles 51500 BJ, BM, BR -----	1
17	51508 C-1	Looper, front, for No. 1 gauge, Style 51500 BK -----	1
18	51509 C	Looper, back, for Styles 51500 BK, BN -----	1
19	51508 G-1	Looper, front, for No. 1 gauge, Style 51500 BN -----	1
20	51709	Looper, left, for Styles 51700 BJ, BK, BQ, BR -----	1
21	51708	Looper, right, for Styles 51700 BJ, BK, BQ, BR -----	1
22	51408 A-16	Looper, front, for No. 16 gauge, Style 51400 BV -----	1
23	51908 B-9	Looper, front, for No. 18 gauge, Style 51500 BP -----	1
24	51909 D-9	Looper, back, for No. 18 gauge, Style 51500 BP -----	1
25	51908-5	Looper, front, for No. 5 gauge, Style 51900 BG -----	1
	51908-6	Looper, front, for No. 6 gauge, Style 51900 BG -----	1
	51908-7	Looper, front, for No. 7 gauge, Style 51900 BG -----	1
26	51409	Looper, middle, for Style 51900 BG -----	1
27	51909-5	Looper, back, for No. 5 gauge, Style 51900 BG -----	1
	51909-6	Looper, back, for No. 6 gauge, Style 51900 BG -----	1
	51909-7	Looper, back, for No. 7 gauge, Style 51900 BG -----	1
28	51908 B-7	Looper, front, for No. 7 gauge, Style 51900 BH -----	1
	51908 B-8	Looper, front, for No. 8 gauge, Style 51900 BH -----	1
	51908 B-9	Looper, front, for No. 9 gauge, Style 51900 BH, BJ -----	1
29	51909 C	Looper, middle, for Styles 51900 BH, BJ -----	1
30	51909 D-7	Looper, back, for No. 7 gauge, Style 51900 BH -----	1
	51909 D-8	Looper, back, for No. 8 gauge, Style 51900 BH -----	1
	51909 D-9	Looper, back, for No. 9 gauge, Styles 51900 BH, BJ -----	1
31	73	Screw -----	1, 2, 3

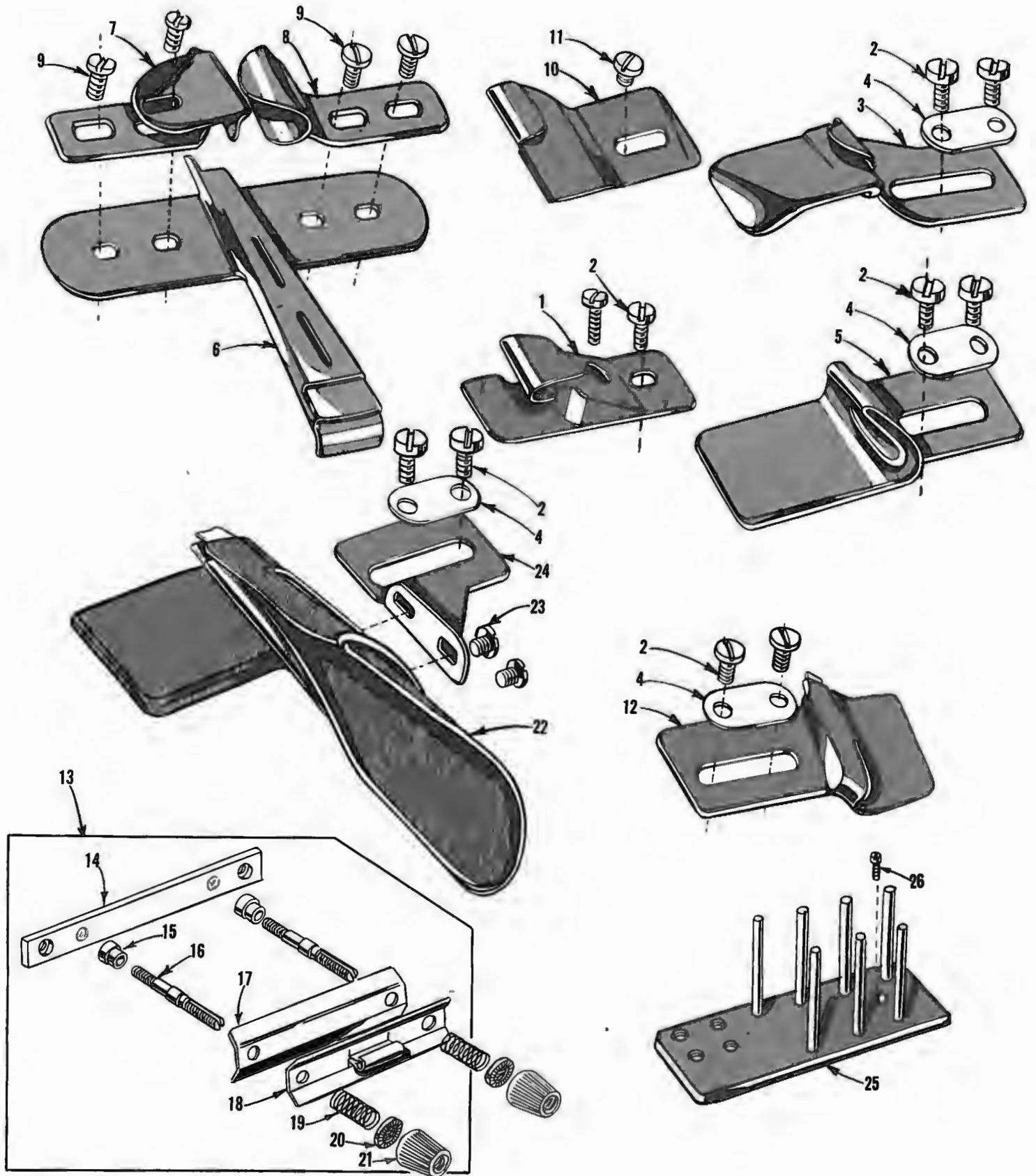


ATTACHMENTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	23215 BC-5/8	English Binder, uses selvage edge binding strip 5/8 inch wide, 5/32 inch capacity for body fabric, finishes 5/16 inch wide, for Styles 51200 BL; 51300 BM -----	1
	23215 BC-3/4	English Binder, uses 3/4 inch strip and finishes 3/8 inch-----	1
	23215 BC-7/8	English Binder, uses 7/8 inch strip and finishes 7/16 inch -----	1
2	23438 B	Body Fabric Lead-in Platform, for Styles 51200 BL; 51300 BM -----	1
3	23437 Y	Binder Swinging Bracket, for Styles 51200 BL; 51300 BM -----	1
4	90	Screw -----	2
5	23437 B	Binder Swinging Bracket Support, for Styles 51200 BL; 51300 BM -----	1
6	23425 T	Washer Plate-----	1
7	22585	Screw -----	2
8	12957 E	Spring Washer-----	1
9	22735	Screw -----	1
10	23438 A	Body Fabric Lead-in Platform, for Style 51200 BK -----	1
11	23425 V	Washer Plate -----	1
12	25 C	Screw -----	2
13	23322 AB-3/4	Cut Edge Binder, uses strip cut 3/4 inch wide, finishes 7/32 inch wide, for Style 51200 BK -----	1
	23322 AB-7/8	Cut Edge Binder, uses strip cut 7/8 inch wide, finishes 1/4 inch wide ----	1
	23322 AB-1	Cut Edge Binder, uses strip cut 1 inch wide, finishes 9/32 inch wide ----	1
	23322 AB-1 1/8	Cut Edge Binder, uses strip cut 1 1/8 inch wide, finishes 11/32 inch wide -----	1
	23322 AB-1 1/4	Cut Edge Binder, uses strip cut 1 1/4 inch wide, finishes 13/32 inch wide -----	1
14	23322 AC	Binder Support, for Style 51200 BK -----	1
15	90	Screw -----	2
16	23184 K	Swinging Folder and Guide, for Style 51300 BJ -----	1
17	23184 E	Lower Portion -----	1
18	23184 G	Adjustable Guide, lower -----	1
19	23184 L	Upper Portion -----	1
20	23184 M	Adjustable Guide, upper -----	1
21	187 A	Screw -----	4
22	22726	Screw -----	1
23	12957 E	Spring Washer -----	1
24	24 S	Edge Guide, for Styles 51200 BQ, BW, BX -----	1
25	25 S	Screw -----	1
26	24 X	Edge Guide, for Style 51200 BM -----	1
27	25	Screw -----	2
28	24	Edge Guide, for Styles 51200 BG, BS; 51300 BG; 51400 BX; 51500 BK, BN-----	1
29	23100	Double Edge Folder and Guide, 3/64 inch capacity, 3/16 inch overlap, for Style 51200 BR -----	1
30	23425 V	Washer Plate-----	1
31		Double Lap Seam Feller Assembly (See Chart Below) -----	1
32		Lower Scroll and Base (See Chart Below)-----	1
33		Upper Scroll (See Chart Below)-----	1
34	28	Screw-----	1
35	23425 V	Washer Plate-----	1

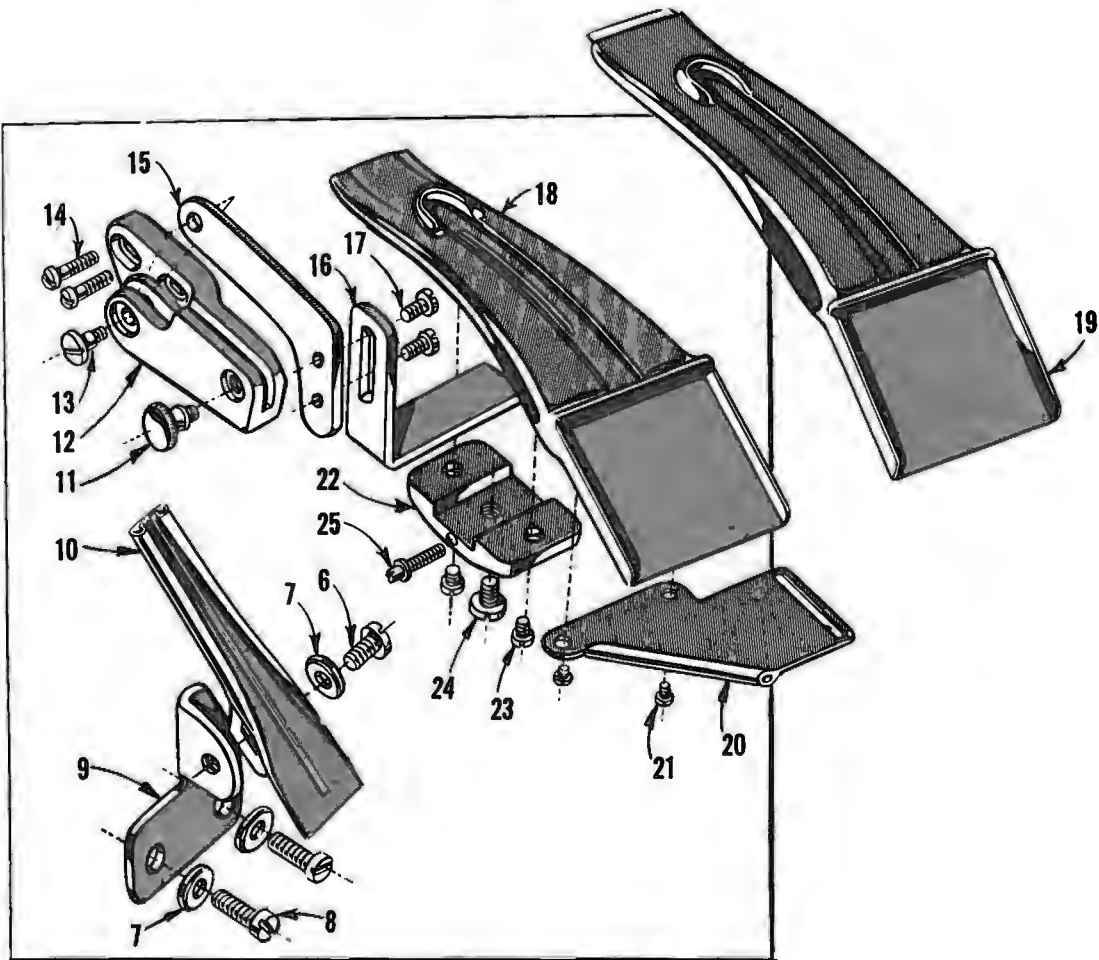
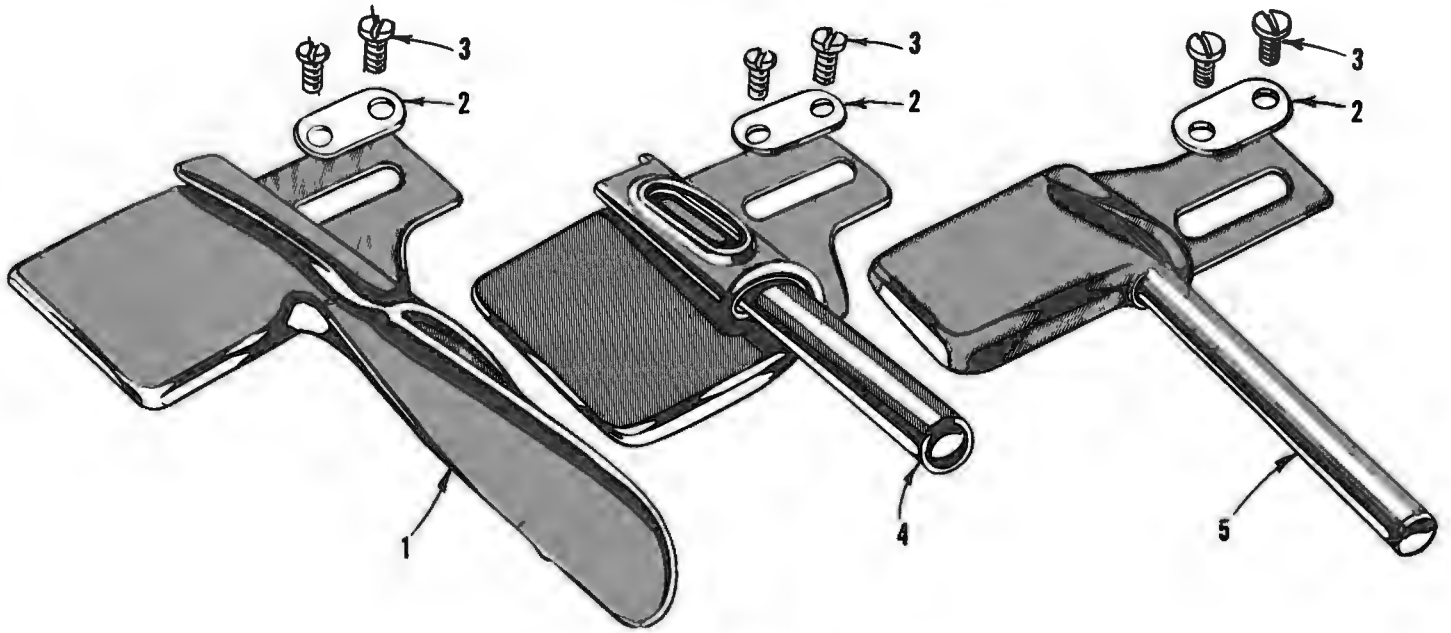
DOUBLE LAP SEAM FELLERS

<u>Assembly No. Ref. 31</u>	<u>Gauge</u>	<u>Capacity</u>	<u>Lower Scroll Ref. 32</u>	<u>Upper Scroll Ref. 33</u>	<u>Machine Style</u>
23420 U-6-1/32	6	1/32	23422 U-1/32	23421 U-6-1/32	51400 BP-6
23420 U-8-1/32	8	1/32	23422 U-1/32	23421 U-8-1/32	51400 BP-8, BW-8
23420 U-10-1/32	10	1/32	23422 U-1/32	23421 U-10-1/32	51400 BP-10, BW-10
23420 U-10-1/16	10	1/16	23422 U-1/16	23421 U-10-1/16	51900 BG-5
23420 U-12-1/16	12	1/16	23422 U-1/16	23421 U-12-1/16	51400 BP-12, BW-12; 51900 BG-6
23420 U-16-1/16	16	1/16	23422 U-1/16	23421 U-16-1/16	51400 BP-16, BW-16; 51900 BG-7
23420 U-16-3/32	16	3/32	23422 U-3/32	23421 U-16-3/32	51500 BJ-16; 51900 BH-7, BH-8
23420 U-18-1/16	18	1/16	23422 U-1/16	23421 U-18-1/16	51400 BP-18
23420 U-18-3/32	18	3/32	23422 U-3/32	23421 U-18-3/32	51500 BJ-18, BR-18; 51900 BH-9
23420 U-26-1/16	26	1/16	23422 U-1/16	23421 U-26-1/16	51400 BX-26
23420 V-8-1/32	8	1/32	23422 V-1/32	23421 V-8-1/32	51400 BT-8
23420 V-10-1/32	10	1/32	23422 V-1/32	23421 V-10-1/32	51400 BT-10
23420 V-12-1/32	12	1/32	23422 V-1/32	23421 V-12-1/32	51400 BT-12
23420 V-16-1/32	16	1/32	23422 V-1/32	23421 V-16-1/32	51400 BT-16



ATTACHMENTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	23151 A	Plate Folder and Guide, for heavy material, 1/4 inch capacity for both plies, top ply folded, lower ply flat, 1/2 inch overlap, for Styles 51500 BP; 51900 BJ-----	1
2	25 C	Screw-----	2
3	23405 J	Folder, for turning body of garment downwardly, 1/32 inch capacity, 5/16 inch fold, for Style 51400 BS -----	1
	K59386	Folder, for turning body of garment downwardly, 1/16 inch capacity, 5/16 inch fold, for Style 51700 BR-----	1
4	23425 V	Washer Plate -----	1
5	23405 F	Folder, for turning body of garment upwardly, 1/32 inch capacity, 5/16 inch fold, for Style 51400 BY -----	1
	K59432	Folder, for turning body of garment upwardly, 1/16 inch capacity, 5/16 inch fold, for Style 51700 BQ -----	1
6	K30773	Strip Folder, for facing overall bibs, strip cut 1 inch wide, finishes 9/16 inch, on Style 51500 BM -----	1
7	K38038	Edge Guide, adjustable, for facing overall bibs, on Style 51500 BM -----	1
8	K38197	Folder, for turning bib of overall downwardly, on Style 51500 BM -----	1
9	22514	Screw-----	4
10	23404 E	Edge Guide, for body of garment, on Styles 51400 BQ; 51700 BK-----	1
11	25 C	Screw-----	1
12	23405 L	Folder, for turning body of garment upwardly, 1/32 inch capacity, 5/16 inch fold, on Styles 51400 BR; 51700 BJ-----	1
13	21182 N	Strip Tension Assembly, for Styles 51400 BS; 51700 BK, BR -----	1
14	21182 P	Strip Tension Base -----	1
15	11261 B	Tension Post Ferrule -----	2
16	56392 E	Tension Post-----	2
17	21182 L	Strip Tension Plate, inner-----	1
18	21182 K	Strip Tension Plate, outer-----	1
19	110-3	Tension Spring-----	2
20	39592 AK	Tension Spring Ferrule -----	2
21	39592 Z	Tension Nut-----	2
22	23406 B-7/8	Folder, for attaching single piece facing to sleeves of shirts, uses strip 2 1/4 inches wide, finishes 7/8 inch, on Style 51400 BA -----	1
23	22730	Screw-----	2
24	23402 D	Folder Support-----	1
25	23439 A	Pin Tension, for Styles 51200 BK, BL; 51300 BM-----	1
26	90	Screw-----	1

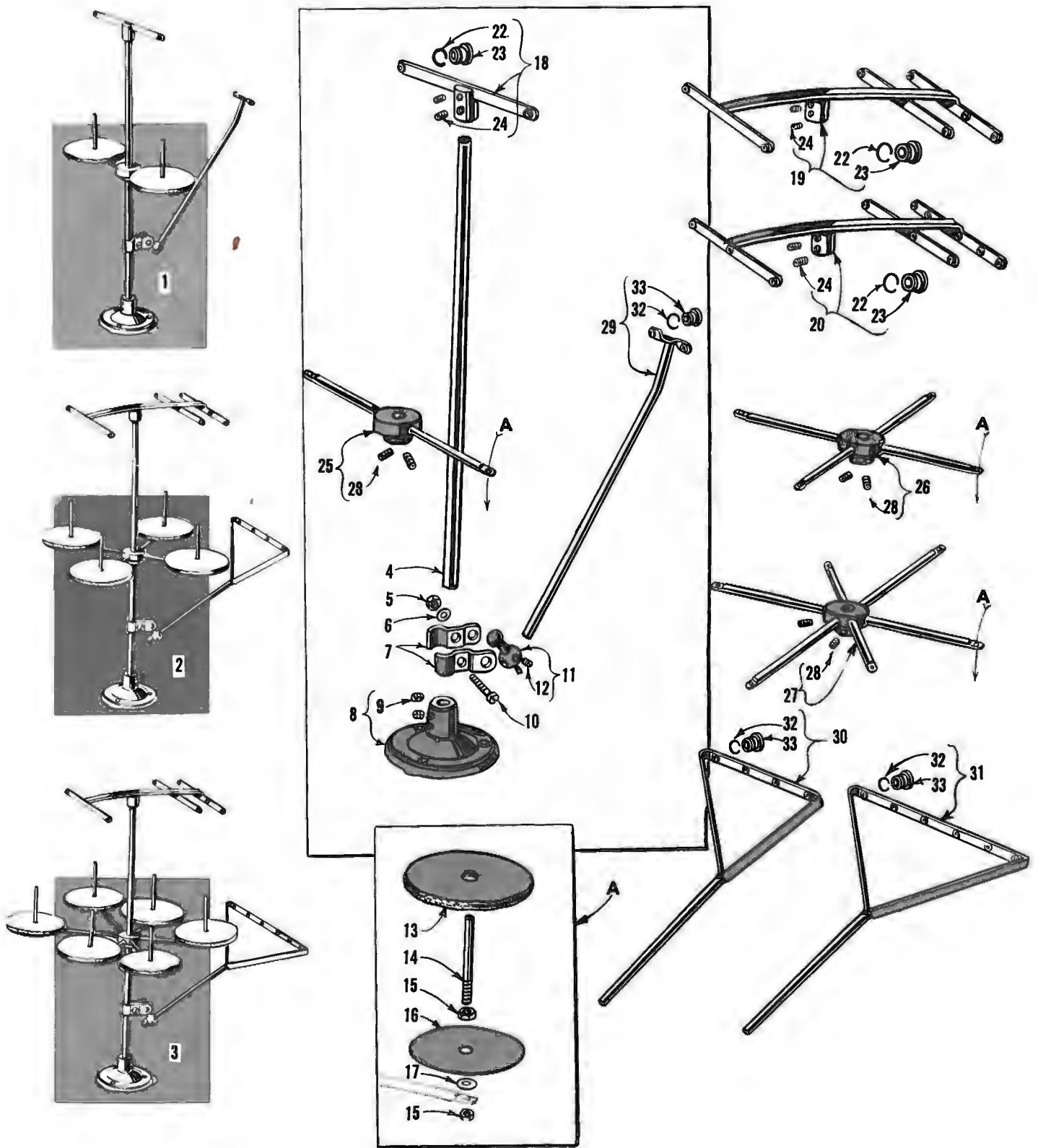


ATTACHMENTS

Ref. No.	Part No.	Description	Amt. Req.
1	23360 F-1/2	Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 1 1/2 inches wide, finishes 1/2 inch, on Style 51200 BT -----	1
	K40881	Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 2 1/8 inches wide, finishes 3/4 inch, on Style 51200 BT -----	1
	K49640	Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 2 3/8 inches wide, finishes 7/8 inch, on Style 51200 BT -----	1
	K49746	Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 2 5/8 inches wide, finishes 1 inch, on Style 51200 BT -----	1
2	23425 V	Washer Plate -----	1
3	25 C	Screw -----	2
4	23168 Q	Folder, for making 7/8 inch "cut-on" button stays on shirts, starts operation at neck, turned up hem, on Style 51400 BB -----	1
5	23168 R	Folder, for making 5/8 inch "cut-on" button stays on shirts, starts operation at neck, turned down hem, on Style 51400 BU -----	1
6	22548	Screw -----	1
7	9255	Washer -----	3
8	136	Screw -----	2
9	23436	Folder Bracket, for Styles 51400 BQ, BS; 51700 BK, BR -----	1
10	23435-32	Facing Strip Folder, for shirt front operations, 1/32 inch capacity, uses strip 1 inch wide, finishes 5/8 inch, on No. 32 gauge, Style 51400 BS -----	1
	23435-48	Facing Strip Folder, for shirt front operations, 1/32 inch capacity, uses strip 1 1/4 inches wide, finishes 7/8 inch, on No. 48 gauge, Styles 51400 BQ, BS -----	1
	K59825	Facing Strip Folder, for shirt front operations, 1/16 inch capacity, uses strip 1 3/8 inches wide, finishes 1 inch, on No. 56 gauge, Style 51700 BR -----	1
	23435-64	Facing Strip Folder, for shirt front operations, 1/32 inch capacity, uses strip 1 1/2 inches wide, finishes 1 1/8 inches, on No. 64 gauge, Style 51700 BK -----	1
*11	25 T	Screw -----	1
*12	23229 W	Folder Swinging Arm Support, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ -----	1
*13	22773	Screw -----	1
14	22541	Screw -----	2
*15	23229 N	Folder Swinging Arm, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ -----	1
*16	23229 P	Folder Bracket, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ -----	1
*17	22528	Screw -----	2
18	23401 K-48	Center Plait Folder, 1/32 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/4 inches wide, finishes 1 1/4 inches, interlining strip cut 1 7/32 inches wide, for No. 48 gauge, Styles 51400 BQ, BR -----	1
	23401 K-56	Center Plait Folder, 1/32 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 3/8 inches wide, finishes 1 3/8 inches, interlining strip, cut 1 11/32 inches wide for No. 56 gauge, Styles 51700 BJ, BK -----	1
	23401 K-64	Center Plait Folder, 1/32 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches, interlining strip cut 1 15/32 inches wide, for No. 64 gauge, Styles 51700 BJ, BK -----	1
19	K58357	Center Plait Folder, 1/16 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches, for No. 64 gauge, Style 51700 BQ, no provision for interlining -----	1
†	K58337	Center Plait Folder, 1/16 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches, interlining strip cut 1 7/16 inches wide, for No. 64 gauge -----	1
20	23403-48	Angular Strip Guide, reversible, for No. 48 gauge, Styles 51400 BQ, BR --	1
	23403-56	Angular Strip Guide, reversible, for No. 56 gauge, Style 51700 BJ -----	1
	23403-64	Angular Strip Guide, reversible, for No. 64 gauge, Style 51700 BJ, BK ---	1
21	25 B	Screw -----	2
*22	23229 Q	Folder Clamp, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ -----	1
*23	25 CC	Screw -----	2
*24	25 S	Screw -----	1
*25	22863 A	Adjusting Screw -----	1

* Available complete as part No. 29481 D (Suspended Folder Arm Assembly).

† Available as an extra send and charge item or on special machine.



THREAD STAND PARTS

Ref. No.	Part No.	Description	Amount Required		
			One Needle	Two Needle	Three Needle
1	21101 H-2	Thread Stand, complete	1		
2	21101 H-4	Thread Stand, complete		1	
3	21101 H-6	Thread Stand, complete			1
4	21104 B-24	Thread Stand Rod	1	1	1
5	21104 H	Nut	1	1	1
6	652-16	Washer	1	1	1
7	21114 U	Lead Eyelet Ball Split Socket	2	2	2
8	21114 A	Base	1	1	1
9	22651 CD-5	Screw	2	2	2
10	22810	Screw	1	1	1
11	21114 T	Lead Eyelet Socket Ball	1	1	1
12	22651 CD-4	Screw	2	2	2
13	21104 V	Felt Pad	2	4	6
14	21114 W	Spool Pin	2	4	6
15	258 A	Nut	4	8	12
16	21114	Spool Seat Disc	2	4	6
17	652-16	Washer	2	4	6
18	21114 H-2	Eyelet Support	1		
19	21114 H-4	Eyelet Support		1	
20	21114 H-6	Eyelet Support			1
22	21114 M	Eyelet Locking Ring	2	8	12
23	21114 L	Eyelet	2	8	12
24	22651 CD-4	Screw	2	2	2
25	21114 D-2	Spool Seat Support	1		
26	21114 D-4	Spool Seat Support		1	
27	21114 D-6	Spool Seat Support			1
28	22651 CD-5	Screw	2	2	2
29	21114 S-2	Lead Eyelet	1		
30	21114 S-4	Lead Eyelet		1	
31	21114 S-6	Lead Eyelet			1
32	21114 M	Eyelet Locking Ring	2	4	6
33	21114 L	Eyelet	2	4	6

*ACCESSORIES AVAILABLE AS EXTRAS

<u>Part No.</u>	<u>Description</u>
WA15 A	Stop Watch
TA55 B	Hand Tachometer
660-240	Thread Tweezers
Y500-257	Expansion Reamer, for needle bar bearings, size .257
Y503-319	Expansion Reamer, for lower presser bar bearings, size .319
Y505-407	Expansion Reamer, for looper rocker and feed rocker shaft bearings, size .407 inch
Y506-530	Expansion Reamer, for main shaft and upper feed drive rock shaft bearings, size .530 inch
Y802	Taper Reamer, for needle lever and feed crank link pins
21201	Screw Driver, 9/64 inch round blade, length overall 7 5/8 inches
21202	Screw Driver, 7/32 inch round blade, length overall 11 1/4 inches
21203	Screw Driver, 13/64 inch round blade, length overall 15 1/2 inches
21204	Screw Driver, 9/32 inch round blade, length overall 15 inches
21205 A	Screw Driver, 3/8 inch round blade, length overall 14 inches
21207	Screw Driver, 7/64 inch round blade, length overall 2 1/2 inches
21208	Screw Driver Set, three detachable blades
21225-1/8	Looper Adjusting Gauge, 1/8 inch measurement
21225-5/32	Looper Adjusting Gauge, 5/32 inch measurement
21236	Belt Plier, for 3/8 and smaller round belting
21260	Emery Cord, 3/64 inch diameter, grade No. 120, 50 yard spool
21260 A	Emery Cord, 3/64 inch diameter, grade No. 150, 50 yard spool
21260 B	Emery Cord, 1/32 inch diameter, grade No. 180, 50 yard spool
21260 C	Emery Cord, .025 inch diameter, grade No. 200, 50 yard spool
21260 D	Emery Tape, 3/32 inch wide, grade No. 180, 50 yard spool
21260 E	Emery Cord, .018 inch diameter, grade No. 200, 50 yard spool
21261	Leather Belt, flat, 1 inch wide, 63 inches long, includes fastener No. 21350
21261 M-340	"V" Belt, No. 1 size, 34 inches outside circumference
21261 M-350	"V" Belt, 35 inches outside circumference
21261 M-360	"V" Belt, 36 inches outside circumference
21261 M-370	"V" Belt, 37 inches outside circumference
21261 M-380	"V" Belt, 38 inches outside circumference
21262	Leather Belt, round 9/32 inch diameter, 44 inches long, includes belt hook No. 21351
21350	Belt Fastener, for 1 inch flat belt
21351	Belt Hook, for 9/32 inch round belt
21388	Wrench, single end, 3/8 inch opening
21388 N	Wrench, double end, 3/16 and 5/16 inch openings
21388 R	Wrench, double end, 3/8 and 1/2 inch openings
21388 W	Wrench, double end, curved, 9/32 inch openings
21388 X	Wrench, for main shaft bearing housing
21388 AE	Socket Wrench Assembly, for 9/32 and 3/8 inch hexagonal nuts
21388 AN	Socket Head Wrench Kit, five wrenches, for socket head set screws from size No. 10 to 7/16 inch inclusive
21394	Utility Grinder, including emery wheel, 5 inches diameter, 1/4 inch face, recommended speed 3000 R. P. M.
21394 G	Emery Wheel, 5 inches diameter, 1/4 inch face, 3/8 inch hole, grade "M" emery 60
21394 H	Emery Wheel, 5 inches diameter, 1/2 inch face, 3/8 inch hole, grade "M" emery 60
21394 K	Utility Grinder, including emery wheel, 5 inches diameter, 1/2 inch face, recommended speed 3000 R. P. M.
21660 H	Knee Press Assembly, machine mounted for lifting presser foot
28606-1/2	Powdered Oil Stone, 1/2 lb. package
28606-1	Powdered Oil Stone, 1 lb. package

* The above tools and accessories are not illustrated but will prove helpful in the successful operation and maintenance of the machine.

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Here are Oil Specifications for Union Special Sewing Machines



Specification 174 specifies a high quality petroleum oil, viscosity 100 seconds at 100°F. Recommended for all oiling applications on high speed machines.

Specification 175 specifies a high quality petroleum oil, viscosity 100 seconds at 100°F., water white or with a maximum A.S.T.M. color number of 1. *For use where freedom from oil staining is paramount.*

Specification 87 specifies a high quality petroleum oil, viscosity 300 seconds at 100°F.

Specification 100 specifies a general purpose high quality grease for use in ball bearings and transmitters. It is similar to commercial N.L.G.I., grease No. 3. Where No. 3 grease is not obtainable, No. 2 may be used.

UNION SPECIAL SPECIFICATION NO.	174	175	87
Viscosity S.S.U. at 100°F	90-125	90-125	300-350
Flash (Min.)	350	350	350
Pour (Max.)	20	20	20
Color A.S.T.M. (Max.)	3	1	3
Neutralization No. (Max.)	0.10	0.10	0.10
Viscosity Index (D & D Min.)	85	85	85
Compounding	None	None	None
Copper Corrosion (Max.)	1A	1A	1A

*Anline No. 175-225 175-225 175-225

*Used with Buna N Rubber "O" Retainers

NOTE 1: The use of non-corrosive additives in oils meeting above classification is desirable but not essential. These may include:

1. Oxidation inhibitors
2. Rust inhibitors
3. Lubricity additives
4. Anti-oxidants
5. Film strength additives

These additives must be completely soluble in the oil and not removable by wick feeding nor shall they separate.

NOTE 2: Oils containing the following type additives shall not be used at any time:

1. Extreme pressure additives—corrosive
2. Tackiness or adhesive additives
3. Lead soap additives
4. Detergents



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Helpful, authoritative information on the most efficient types of equipment for making virtually any machine sewed article is available from Union Special Sales Promotion Department. Among the many interesting, illustrated bulletins that are available without obligation are the following:



- No. 240, "Men's, Women's, Children's Footwear"
- No. 249, "Rainwear"
- No. 250, "Men's Dress Shirts"
- No. 251, "Service Shirts and Pants"
- No. 252, "Men's Shorts and Pajamas"
- No. 253, "Overalls, Coveralls, and Dungarees"
- No. 254, "Men's Knit Underwear"
- No. 256, "Knit Outerwear"
- No. 259, "Men's Sports Shirts"
- No. 260, "Work Gloves"
- No. 262, "Cotton, Burlap, Jute, and Multiwall Paper Bags"
- No. 263, "Men's Clothing"
- No. 264, "Men's Women's, Children's Jackets"
- No. 265, "Women's Wear"
- No. 266, "Women's Wear And High Fashion"
- No. 267, "Corsets, Girdles, Brassieres"
- No. 268, "Children's Wear"
- No. 269, "Mattresses, Slip Covers, Furniture Upholstery"
- No. 271, "Awnings, Canopies, Tents, Tarps"
- No. 273, "Curtains & Drapes"
- No. 610, "Klipp-it"
- No. 710, "MCS ForMation Unit"
- No. 730, "MCS Automatic Dual Underfront Shirt Hemmer"
- No. 740, "MCS Automatic Rib-Knit Cuff Machine"
- No. 750, "Fusing Presses"
- No. 1100, "Lewis Blindstitch, Chainstitch, Lockstitch, Machines"
- No. 1105, "Button Sewers—Ticket Tackers"
"Columbia Blindstitch, Saddle Stitch, and Tie Closing Machines"
- No. 1500, "Alteration Department Machines"



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