

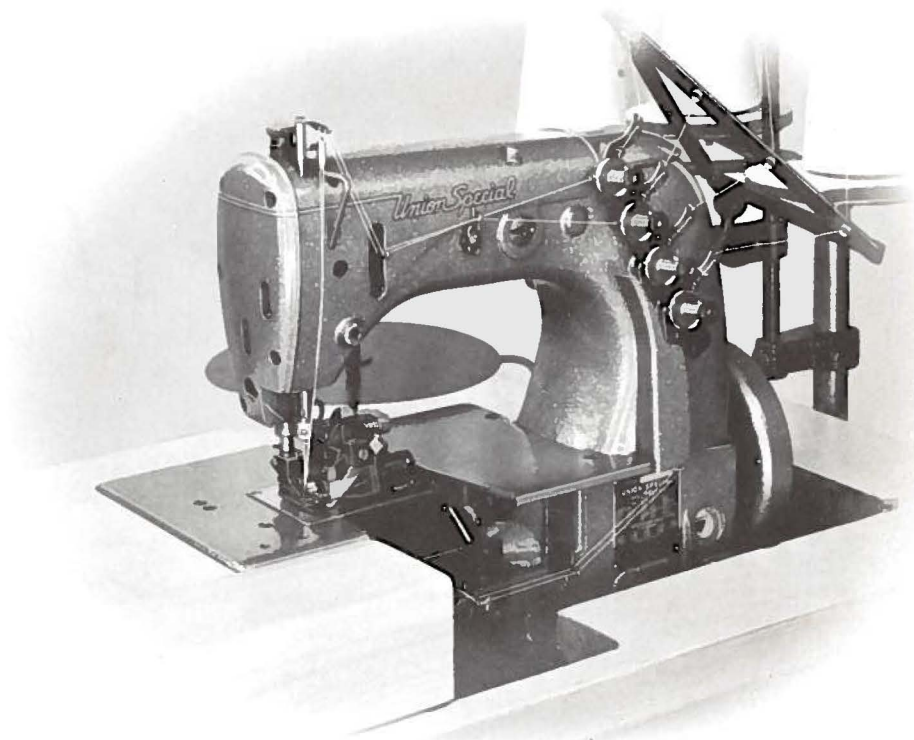
FINEST QUALITY

Union Special[®]
LEWIS • COLUMBIA

**INDUSTRIAL
SEWING
MACHINES**

STYLE

51400 BJ



CATALOG

T107 L

Second
Edition

LIST OF PARTS

FOR

STYLE 51400 BJ

Union Special MACHINE COMPANY

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. T107 L

LIST OF PARTS

Style

51400 BJ

The parts listed in this catalog are
furnished at list prices for repairs only.

Second Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U. S. A.

March, 1965

IDENTIFICATION OF MACHINE

Each Union Special carries a Style number which is stamped in the name plate on the machine. Style numbers are classified as standard and special. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 51400 BJ". Special Style numbers contain the letter "Z". When only minor changes are made in a standard machine, a "Z" is suffixed to the standard Style number. Example: "51400 BJZ".

APPLICATION OF CATALOG

This catalog applies specifically to the standard styles of machines as listed herein.

It can also be applied with discretion to some special machines in Class 51400. All reference to direction, such as left and right, front and back, etc., are taken from the operator's position while seated at the machine. Operating direction of handwheel is toward the operator.

DESCRIPTION OF MACHINE

51400 BJ Streamlined Flat Bed, Two Needle, Two Loopers, Upper and Under Feed, Trimmer, With Front Disposal of Trimmings, Light Weight Presser Bar and Needle Bar, Light Weight Needle Bar Driving Mechanism, Automatically Lubricated. For Seaming and Binding Dresses, Aprons; Also Seaming Trouser Pockets by "Nu-Pocket" Method. Seam Type BSc-2, Stitch Type 401. Standard Gauge No. 10.

NEEDLES

Each Union Special needle has both a type number and a size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number stamped on the needle shank, denotes largest diameter of blade measured in thousandths of an inch across the eye. Collectively, type number and size number represent the complete symbol.

Standard needle for Style 51400 BJ is Type 108 GKS. It is a round shank, round point, extra short, double groove, struck groove, oversize ball eye, spotted, chromium plated, and is available in sizes of 032, 036, 040. Unless otherwise specified, the machine will be equipped with size 036.

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

Selection of proper needle size should be determined by size of thread used. Thread should pass freely through needle eye in order to produce a good stitch formation.

Success in the operation of this machine can be secured only with the genuine Union Special needles. Genuine needles are packaged with labels marked *Union Special*. This is your guarantee of needles of the highest quality in materials and workmanship.

OILING

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 200 to 250 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 twelve 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. Excessive oil in the main reservoir may be drained at the plug screw in main frame, directly under the handwheel.

The following is a numerical list of the parts used in this machine. Quantities, part numbers, and descriptions are given. Following the parts list are photographs of some of the major parts.

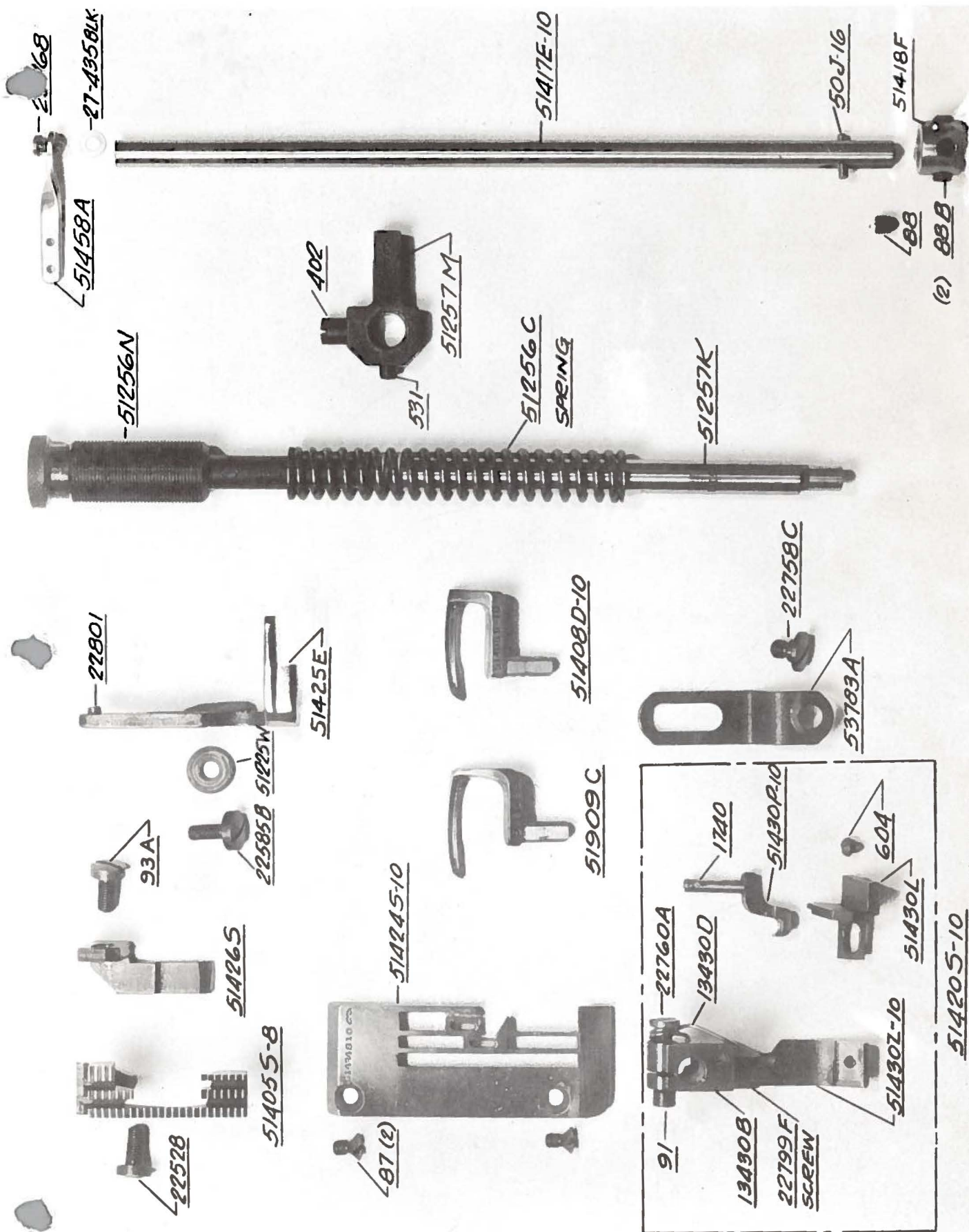
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Feed Rocker Shaft	1	660-202	"O" Ring for pulley	1	22562 A	Screw for 51254 H
3	18	Nut for 51240 E, 55241 N, 55244 G	1	660-207	Oil Seal Ring for foot lifter lever bushing	1	22568	Screw for 51450
2	20	Washer for 51236 G, 51758	2	660-212	Oil Seal Ring (22586 R)	3	22569 B	Screw for bearing housing
1	27-435 Blk.	Needle Bar Eyelet Washer	2	666-65	Oil Wick for 51244 K	5	22569 B	Screw for 51282 Y
2	50-216 Blk.	Pin for 51257 T	2	666-111	Oil Wick for 8	3	22569 B	Screw for 51493 AH
1	50-294 Blk.	Pin for 51493 AH	2	666-114	Oil Wick for right main shaft	1	22570 B	Screw for 51278 D
1	50-648 Blk.	Pin for 51493 AH	2	666-118	Oil Wick for left main shaft	15	22571 A	Plug Screw for bed
1	50-648 Blk.	Pin for 51493 AH	1	666-138	Felt (90)	1	22571 B	Plug Screw for bed
1	50-648 Blk.	Pin for 51493 AH	1	666-121	Oil Felt for 51494 E	1	22580 D	Set Screw for 51223 A
1	50-648 Blk.	Pin for 51493 AH	1	666-123	Felt for 51193 X	2	22585 A	Screw for 51282 AF
1	50 J-16	Stop Pin for 51417 E	1	666-149	Felt for 51054	1	22585 B	Screw for 51425 E
1	54	Needle Bar Link for 29348 P	1	666-170	Felt Wick for 51134 V	1	22586 R	Screw for 660-212
2	73	Screw for looper	1	666-170	Wick for 51250 E	1	22588 A	Screw for 52350 A
1	77	Screw for 51054	2	666-179	Wedge Pin for 666-111	1	22596	Screw for 21657 Y
3	77	Screw for 51236 A	1	666-201	Felt Plug for 51294 U	1	22711	Screw for 52372 A
3	77	Screw for 51054, 51204 C, 51244 B	1	666-208	Felt for 51294 W	2	22729	Screw for 51243 C, 51472 B
1	78	Screw for 51054	1	666-209	Felt Plug for 51294 U	1	22729 A	Screw for 51294 U
2	80	Screw for 52980 A	1	666-214	Felt for 51294 M	1	22729 B	Screw for 51294 U
3	80	Screw for 51401 R	2	667 B-		2	22729 C	Screw for 55241 N
1	81	Screw for 51242 Y (12982)	2	668-25	Dowel Pin for 51273 A	2	22730	Screw for 51278
1	82	Screw for 51236 G	2	668-28	Locking Ring for 51292 D	1	22733 B	Plug Screw for 52882 L (41394 A)
2	87	Screw for 51424 S	2	719	Screw for 51150, 51250 E	1	22758 C	Screw for 53783 A
2	J87 J	Screw for 51204 C	1	1740	Stop Pin for 51420 S	1	22760 A	Screw for 13430 D
2	87 U	Screw for 23322 AG	2	6042 A	Washer for 51135 P	2	22768	Screw for 51458, 51458 A
2	88	Screw for 15465 F	1	6042 A	Washer for 52894 AM	2	22768	Screw for 51236 B
2	88	Screw for 14649	1	7947	Nut for 51294 R	2	22798	Screw for 51472 A
1	88	Screw for 51418 F	1	12538	Nut for 51241 K	1	22798 A	Screw for 51204 A
1	88	Screw for 52894 AK	1	12957 E	Spring Washer for 23437 E	1	22799 F	Screw for 51420 S
2	88 B	Screw for 51034 A	1	12982	Lock Nut for 81	1	22801	Pivot Screw for 51425 E
2	88 B	Screw for 51418 F	1	13430 B	Shank for 51420 S (91)	1	22811 B	Screw for 51242 W
1	90	Screw for 23439 A	1	13430 D	Spring for 51420 S (22760 A)	1	22829	Screw for 51745 (258 A)
2	90	Screw for 52882 AD	3	14649	Collar for 8 (88)	1	22834	Adjusting Screw for needle guard
1	90	Screw for 666-138	1	15465 F	Differential Rocker Cone for 29192 D (88)	2	22839 C	Screw for 51401 R
5	90	Screw for 52882 Y, 52894 AB	2	21212	Oil Siphon Connection Locking Ring	1	22848	Screw for 51758 (20)
2	90	Screw for 23437 K	1	B21375 AH	Belt Guard (93)	9	22848	Screw for 52882 L
1	91	Screw for 13430 B	1	21657 E	Washer for 51257 T	1	22852	Screw for 52934 D (51216 N)
2	93	Screw for B21375 AH	1	21657 W	Tension Release Lever Shaft	1	22852 A	Screw for 51242 Y (51242 M)
1	93 A	Screw for 51426 S	1	21657 X	Release Lever Bushings	1	22863	Tilting Screw for 52934
1	95	Screw for 51270 B	1	21657 Y	Connection (402, 22596)	1	22883 A	Plug Screw for bed
1	95	Plug Screw	1	21657-4	Tension Release Separator	1	22889 A	Plug Screw for 51758
2	95	Screw for 51147	3	22513	Screw for 35731 A	2	22889 C	Plug Screw for bed
1	HA95	Adjusting Screw for 51134 N	2	22517	Screw for 51273 A	1	22889 D	Plug Screw for bed
1	96	Spot Screw for 51223 A	1	22519 H	Screw for 51244 B	4	22894 C	Set Screw for 29105 AA
2	96	Screw for 51244	1	22524	Screw for 51282 AF	1	22894 C	Set Screw for 52372 A
1	97 A	Screw for 51241 K	1	22528	Screw for 51257 T (21657 E)	2	22894 C	Screw for 51273 B
1	98	Screw for 51244	1	22528	Screw for 51405 S	1	22894 D	Spot Screw for 29105 AA
3	98 A	Screw for 158 B	1	22537	Screw for 53783 N	1	22894 D	Screw for 29476 DP
1	98 A	Screw for 51291 A	1	22539 H	Plug Screw for bed	1	22894 D	Screw for 29476 DR
8	109	Tension Disc	1	22539 R	Plug Screw for bed	2	22894 F	Set Screw for 51221 C
3	158 B	Thread Eyelet (98 A)	3	22541 B	Screw for 52882 AD	1	22894 H	Screw for 51242 W
1	258	Nut for 51134 HA	1	22542	Screw for 51282 Y	2	22894 J	Screw for 51247
1	258	Nut for 51280 E	1	22547 C	Screw for 51478 (51250 C)	1	22894 T	Set Screw for 29476 HZ
1	258 A	Nut for 660-136	4	22548	Screw for 52882 AE	1	22894 T	Screw for 29476 JN
1	258 A	Nut for 52894 AM	1	22557 B	Screw for 53783 L	1	23322 M	Washer for 23322 AG
1	258 A	Check Nut for 29192 D	2	22559 A	Lower Cap Screw for 29105 AA	1	23322 AG-	Binder for 3/4 inch binding (87 U, 23322 M)
2	269	Nut for 51236 G, 51240 E	2	22559 B	Upper Cap Screw for 29105 AA	1	23322 AG-	Binder for 7/8 inch binding (87 U, 23322 M)
1	402	Screw for 21657 Y	2	22559 G	Screw for 29066 R	1	23322 AG-	Binder for 1 inch binding (87 U, 23322 M)
1	402	Screw for 53783 A	1	22560 B	Screw for 52934			
1	531	Screw for 51257 M						
2	531	Screw for 51493 BQ						
1	538	Height Adjusting Screw for 52934						
1	604	Screw for 51430 L						
1	643-127 Blk.	Oil Pump Housing Gasket						
1	660-90	Felt Wiper for 29105 AA						
1	660-136	Feed Crank Link Oil Tube (258 A)						
1	660-169	Needle Bearing for 51236 E						

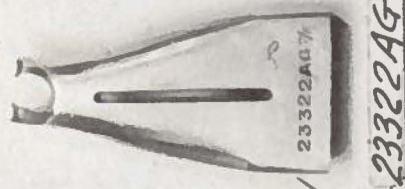
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	23437 E	Screw for 23437 H	1	51204 C	Cast-off Finger	1	51254 C	Upper Needle Bar
1	23437 H	Binder Mounting			Support Bracket			Bushing
		Bracket (12957 E,	1	51215 J	Needle Lever for	1	51254 D	Lower Needle Bar
	23437 J	23437 E)			29348 P (51216 N,	1	51254 H	Bushing
		Binder Holder			51216 P)			Needle Bar Connection
1	23437 K	Bracket for 23437 H	2	51216 G	Needle Lever	1	51256 C	for 29348 P)
		Bracket Base for			Connecting Rod	1	51256 N	Presser Bar Spring
		23437 H (90)	28	51216 M	Needle Bearing			Presser Spring
1	23439 A	Pin Tension (90)			Roller for 29476 HJ	1	51257 K	Regulator
1	29066 R	Upper Needle Lever	3	51216 N	Washer for 22852,	1	51257 M	Presser Bar
		Connecting Rod Ball			51215 J, 55244 G			Presser Bar Connec-
		Joint Assembly	1	51216 P	Nut for 51215 J	1	51257 T	tion and Guide (531)
		(22559 G)	1	51221 C	#1 "V" and Round			Cast-off Plate
1	29105 AA	Looper Drive Eccen-			Belt Pulley (22894 F)	1	51257 AA	Support (22528)
		tric Assembly, .220	1	51223 A	Take-up (96, 22580 D)			Lower Presser Bar
		inch throw	1	51225 W	Washer for 22585 B	1	51270 B	Bushing
1	29192 D	Looper Rocker	1	51236 A	Link Pin for 51273 D			Needle Thread Take-
		Assembly			(77)	1	51272 C	up Wire (95)
1	29348 P	Needle Lever	2	51236 A	Feed Lift Eccentric			Block Guide Collar
		Assembly			Link Pin (77)	1	51272 D	Shaft
1	29476 DP	Upper Feed Lift	1	51236 A	Looper Avoid			Block Guide Collar
		Eccentric Assembly	1	51236 B	Eccentric Link Pin	1	51273 A	Shaft Spring
		.140 inch throw			Feed Crank Stud	1	51273 B	Upper Knife Holder
1	29476 DR	Feed Lift Eccentric	1	51236 D	Cap (22768)			Bracket (22517)
		Assembly, lower,	1	51236 E	Link for 51236 E	1	51273 D	Upper Knife Holder
		.080 inch throw			Feed Crank Link	1	51273 D	Rocker Stud (22894 C)
1	29476 HJ	Crankshaft Assembly	1	51236 F	Assembly			Upper Knife Holder
		.770 inch throw	1	51236 G	Ferrule for 51236 E	1	51278	Rocker Arm
1	29476 HZ	Knife Drive Eccen-			Feed Crank Stud			Chip Guard Assembly
		tric Assembly,	1	51240 E	(20, 82, 269)	1	51278 A	(22730)
		.140 inch throw			Looper Connecting	1	51278 D	Chip Guard for 51278
1	29476 JN	Looper Avoid	1	51241 K	Rod (18, 269)		51278 D	Spring (22570 B)
		Eccentric Assembly,			Looper Connecting	1	51278 G	Hinge Pin for 51278
		.062 inch throw			Rod and Ball Joint,	1	51280 E	Throat Plate Support
2	35178 D	Spring for 666-114			right (12538)			Pin (258)
2	35178 D	Spring for 666-65	2	51242 L	Thrust Washer for	2	51280 J	Dowel Pin for 52980 A
2	35731 A	Presser Bar Connect-			51242 P	1	51282 Y	Head Cover (22569 B)
		ing Guide Plate	2	51242 M	Washer for 22852 A,	1	51282 Z	Head Cover Gasket
		(22513, 51294 R)			52841 G	1	51282 AC	Felt Liner for 51282 Y
1	35766	Screw for 51450	1	51242 P	Looper Drive Lever	1	51282 AE	Needle Lever Bearing
1	39158 G	Hinge for 51278			Shaft (51242 L)			Oiler (90)
1	39158 U	Spring for 51278	1	51242 R	Looper Drive Lever	1	51282 AF	Oil Reservoir Top
1	39582 L	Oil Cap for 52882 AD			Shaft Bushing,			Cover (22524,
2	41394 A	Gasket for 22733 B			middle	1	51283 H	22585 A)
2	43266	Nut for 51292 G	1	51242 S	Looper Drive Lever			Presser Foot Lifter
1	51034 A	Upper Feed Bar Shaft			Shaft Bushing, rear			and Tension Disc
		(88 B)	1	51242 W	Looper Drive Lever	1	51290 R	Release Lever
1	51054	Feed Crank Link Pin			(22811 B, 22894 H)	1	51290 T	Bushing for 52891 B
		(77, 666-149)	1	51242 Y	Looper Drive Lever			Main Shaft Bushing,
2	51054	Link Pin for 29348 P			Rocker (81,	1	51291 A	center
		(77, 78)			22852 A)			Looper Thread Guard
1	51134 C	Feed Bar Shaft	1	51242 Z	Looper Drive Lever	4	51292 A	(98 A)
1	51134 J	Washer for 51134 HA			Shaft Bushing, front	4	51292 A	Tension Post Ferrule
1	51134 N	Spring for 52934 A	1	51243 C	Ball Stud Fork	4	51292 C	Tension Post Nut
		(HA95)			(22729)	2	51292 D	Tension Thread Eyelet
1	51134 V	Taper Pin for 52934 B	1	51244	Looper Rocker		51292 F-	
1	51134 HA	Feed Dog Holder (258)			Frame (96, 98)	2	4	Tension Spring, looper
1	51135 P	Feed Rocker Arm	1	51244 B	Looper Rocker		51292 F-	
		(6042 A, 55235 D,			Shaft Arm (77,	8	8	Tension Spring, needle
		55235 E)	1	51244 K	22519 H)	4	51292 G	Tension Post (43266)
1	51142 B	Eccentric for			Looper Rocker	1	51294 K	Upper Clamp for
		29476 DP, 29476 HZ	1	51244 L	Shaft (51244 L)			51294 U
1	51145 A	Eccentric Link	2	51244 L	Thrust Washer for	1	51294 M	Oil Tube
		Assembly			51244 K	1	51294 N	Oil Tube Connection
1	51147	Main Shaft Collar	1	51244 M	Looper Rocker Shaft			(21212)
		(95)			Bushing, center	1	51294 P	Oil Tube Clamp (7947)
1	51150	Needle Lever Shaft	1	51244 N	Looper Rocker	1	51294 R	Screw for 51294 P
		Stop (719)			Shaft Collar (18,	1	51294 U	Oil Siphon Assembly
1	51193 X	Oil Tube for upper			55244 G)	1	51294 W	Oil Tube for 51273
		feed bar pin	1	51246	Looper Rocker Stud	1	51382 A	Gasket for 51282 AF
		(666-123)			Nut	1	51401 R	Cloth Plate (80,
								22839 C)
	51204	Looper Thread	1	51247	Main Shaft Counter-	1	51405 S-	
		Retaining Finger			weight (22894 J)	8	8	Lower Feed Dog
		(22798 A)	1	51250 C	Nut for 22547 C			(22528)
1	51204 A	Looper Thread	1	51250 D	Washer for 22586 R	1	51406	Eccentric for 29476 JN
		Retaining Finger	1	51250 E	Needle Lever Stud			(22894 T)
		Holder (77, 22798 A)			(719)	1	51408 D-	
1	51204 B	Auxiliary Cast-off	1	51250 F	Gasket for 22586 R	10	10	Looper, front (73)

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51417 E-10	Needle Bar (50 J-16)	1	51493 B	Gear Stud for 51493 AG	1	52882 AD	Chamber Cover (22)
1	51418 F	Needle Clamp Collar (88, 88 B)	1	51493 D	Pump Driving Shaft	1	52882 AE	Crank Chamber Cover (22548)
1	51420 S-10-3/4	Presser Foot for Style 51400 BJ-10-3/4	2	51493 E	Driving Shaft Gear	1	52883 R	Presser Foot Lifter Lever Bushing
1	51420 S-10-7/8	Presser Foot for Style 51400 BJ, 10-7/8	1	51493 AG	Oil Pump Housing	1	52882 S	Presser Foot Lifter Lever Bell Crank
1	51420 S-10-1	Presser Foot for Style 51400 BJ-10-1	1	51493 BK	Lint Filter Screen	2	52890 C	Main Shaft Bushing, left and right
1	51422 E	Main Shaft	1	51493 BP	Pump Driving Gear (22560 B)	1	52891 B	Main Shaft Housing (22569 B)
1	51424 S-10	Throat Plate (87)	1	51493 BQ	Pump Driven Gear (531)	3	52894 AB	Oil Tube Holder (90)
1	51425 E	Needle Guard (22585 B, 51225 W)	1	51494 E	Oil Tube for upper and lower feed lift eccentric	1	52894 AK	Oil Tube for looper rocker and left ball joint (88)
1	51426 S	Upper Feed Dog (93 A)	1	51513	Looper Rocker for 29192 D	1	52894 AM	Oil Tube for right ball joint (258 A, 6042 A)
1	51430 L	Knife Guard for 51420 S (604)	1	51745	Rocker Cone Stud (51246)	1	52934	Feed Bar, tiltable
1	51430 P-10-3/4	Yielding Section for 51420 S-10-3/4	1	51758	Frame Thread Eyelet (20, 22848, 22889 A)	1	52934 A	Upper Feed Bar (HA 95)
1	51430 P-10-7/8	Yielding Section for 51420 S-10-7/8	1	51909 C	Looper, back (73)	1	52934 B	Upper Feed Bar Arm
1	51430 P-10-1	Yielding Section for 51420 S-10-1	1	52350 A	Knife Holder Plate (22588 A)	1	52934 C	Rubber Stop Pad
1	51430 Z-10	Presser Foot Bottom for 51420 S	1	52372	Upper Knife Holder Block (22711)	1	52934 D	Top Feed Holder (22852)
1	51449	Knife, lower	1	52372 A	Upper Knife Holder Block Guide Collar (22711, 22894 C)	1	52934 E	Lubricating Felt
1	51450	Lower Knife Holder Block (22568, 35766)	2	52373 A	Bushing for 51273 D	1	52934 F	Lubricating Felt Guard
1	51458	Needle Lever Thread Eyelet (22768)	1	52470	Stop for looper connecting rod	1	52935	Feed Rocker (92127)
1	51458 A	Needle Bar Thread Eyelet (27-435 Blk, 22768)	2	52836 P	Feed Rocker Shaft Bushing	1	52980 A	Throat Plate Support (80)
1	51470	Knife, upper	2	52836 R	Looper Rocker Shaft Bushing, right and left	1	53592	Tension Post Support
1	51472 A	Upper Knife Shield (22798)	1	52841 G	Locking Stud for 51242 Y (51242 M)	1	53783 A	Lifter Lever Link (402, 22758 C)
1	51472 B	Upper Knife Clamp (22729)	1	52841 J	Nut for 52841 G	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
1	51478	Front Cover and Chip Guard Latch (22547 C, 51250 C)	1	52882 L	Oil Reservoir Back Cover (22733 B, 22848)	1	53783 M	Presser Foot Lifter Lever Connecting Rod
4	51491 C	Lead-in Thread Eyelet	1	52882 M	Gasket for 52882 L	1	53783 N	Presser Foot Lifter Lever, internal (22537)
			1	52882 P	Gasket for 52882 AD	2	55235 D	Screw for 51135 P
			1	52882 U	Gasket for 52882 AE	2	55235 E	Nut for 51135 P
			1	52882 W	Gasket for 51282 Y	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
			1	52882 Y	Baffle Plate (90)	1	55244 G	Looper Shaft Collar Stud (18, 51216 N)
			1	52882 AA	Drip Plate for 52882 AD	1	56341 G	Spring for 51241 K
			1	52882 AC	Oil Cap Torsion Spring	1	56390 E	Gasket for 52891 B
						2	92127	Screw for 52935

NOTE: Numbers in parenthesis following parts' descriptions indicate the screws, nuts, etc. used to attach or hold those parts.

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23322AG

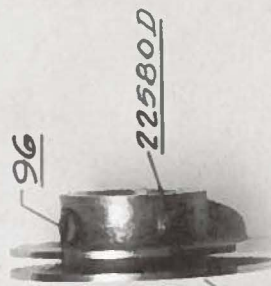
SPECIFY WIDTH OF BINDING



23322M



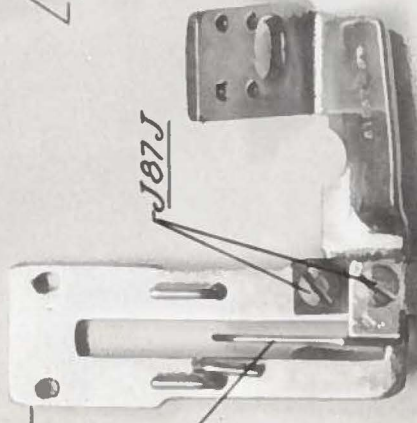
87U



96

22580D

51223A



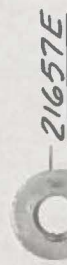
51257T

J87J

51204B

51204

51204



21657E

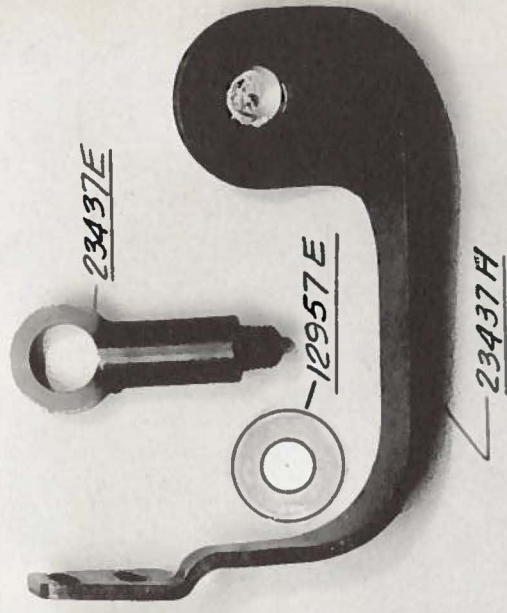


22528

17

51204C

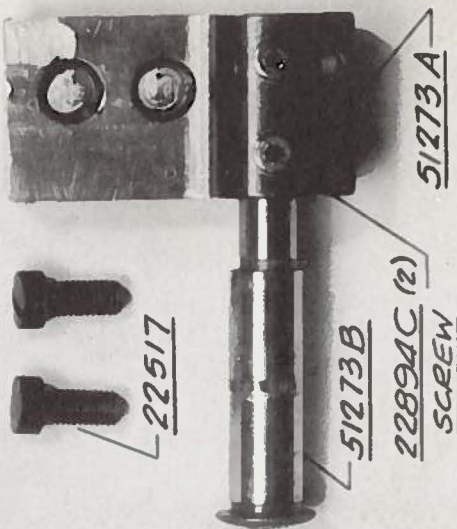
22798A 51204A



23437E

12957E

23437H



51273A

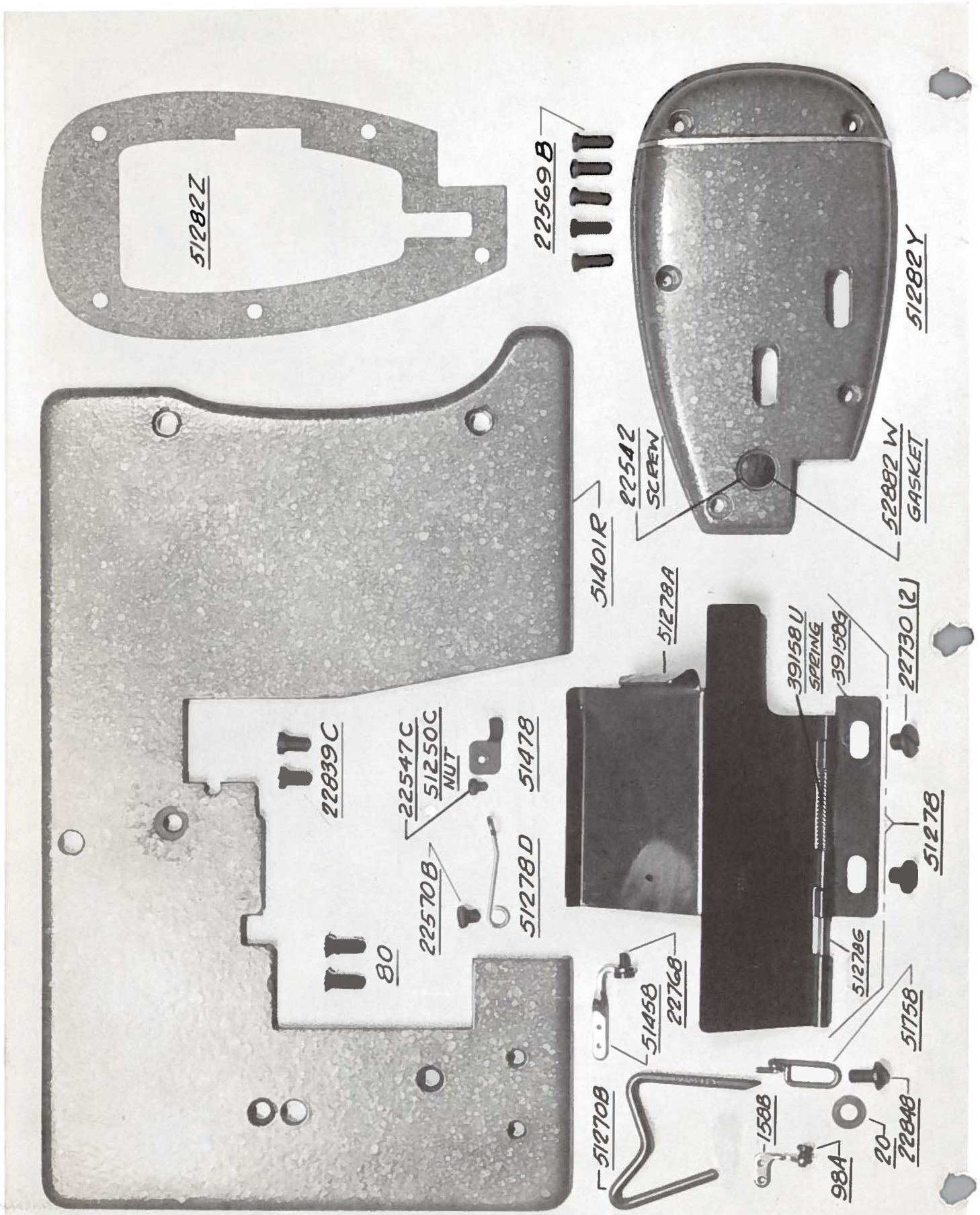
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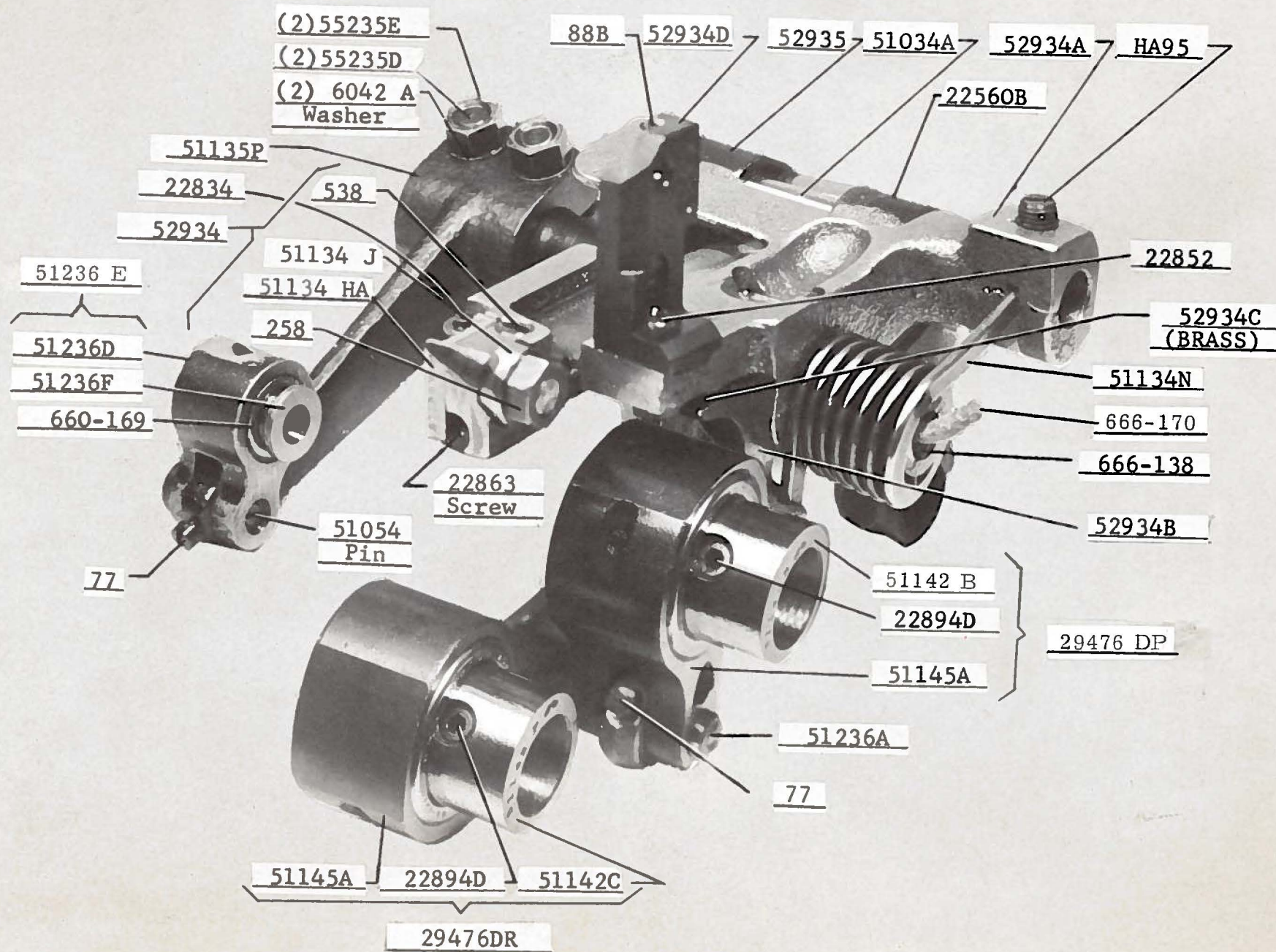
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