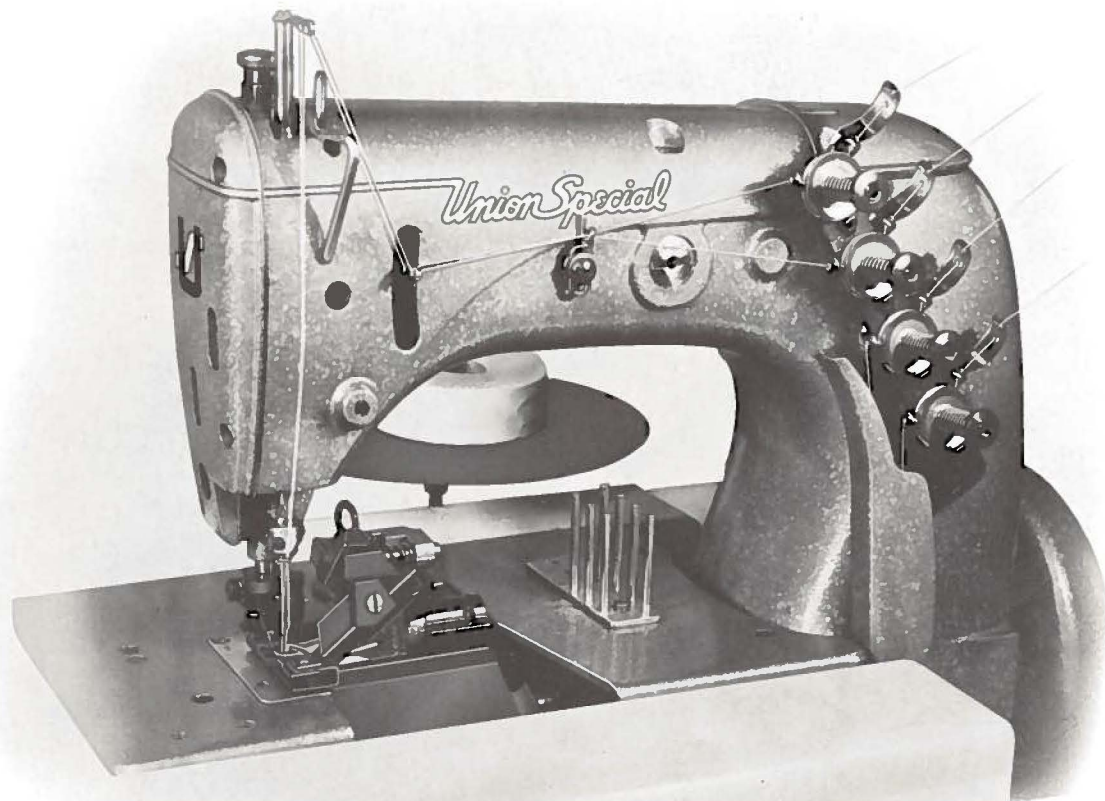


FINEST QUALITY

Union Special®
LEWIS • COLUMBIA

INDUSTRIAL
SEWING
MACHINES

STYLE
51400 BK



Catalog
No.

T109 L
Second
Edition

LIST OF PARTS
FOR
STYLE 51400 BK

Union Special MACHINE COMPANY
CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. T109 L

LIST OF PARTS

Style
51400 BK

Second Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U. S. A.

March, 1971

IDENTIFICATION OF MACHINE

Each Union Special machine is identified by a Style number which is stamped into the name plate on the front of 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 BK". 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: "Style 51400 BKZ".

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".

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 styles of 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 BK Streamlined Flat Bed, Two Needle, Two Loopers, Intermittent Differential Feed, Medium Duty Machine, With Double Disc Take-up, Needle Bearing Needle Drive, Light Weight Presser Bar and Pulley, Automatically Lubricated, Filter Type Oil Return Pump, Front Disposal of Trimmings for Binding Operations on Medium Weight Materials. 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, midway between the shank and the eye. Collectively, type number and size number represent the complete symbol.

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

To have needle orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. 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 genuine Union Special needles, which are put up in packages marked *Union Special*. This trademark 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 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 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 the 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.

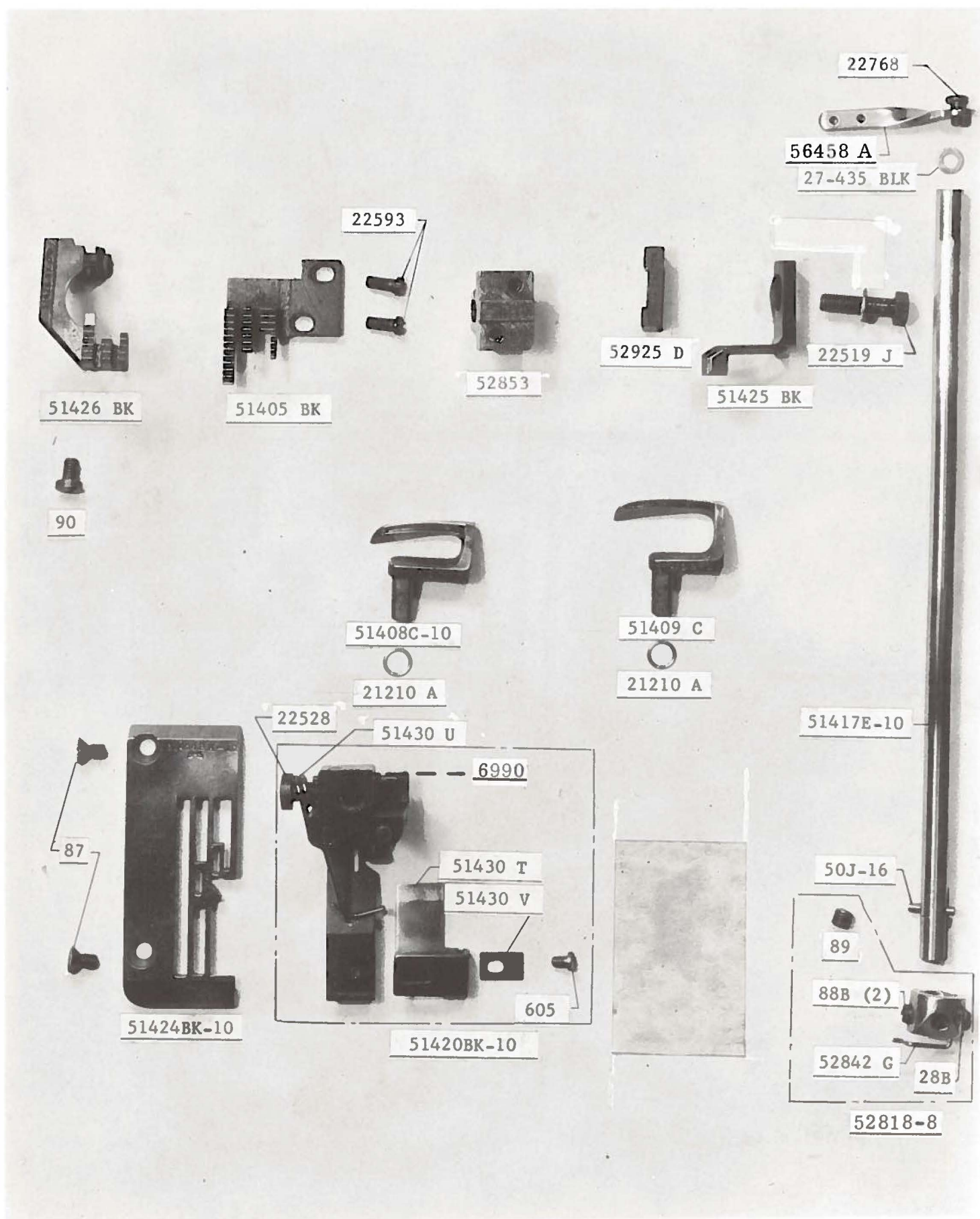
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Feed Rocker Shaft	1	660-169	Feed Crank Link	2	22559 G	Screw for 29066 R
3	18	Nut for 51240 E,	1	660-202	Needle Bearing	2	22560 B	Screw for 51493 BP
		55241 N, 55244 G			Oil Seal Ring for	1	22560 B	Screw for 52834
1	20	Washer for 51435	1	660-207	51221 C	1	22562 A	Screw for 51254 H
2	20	Washer for 51236 G,			Oil Seal Ring for	2	22565 C	Screw for 39237
		51758			foot lifter lever	1	22568	Screw for 51450
2	CL21	Oil Wick for			bushing	5	22569 B	Screw for 51282 Y
		52834 H, 52835 N	2	660-212	Oil Seal Ring for	3	22569 B	Screw for 51493 AG
2	25 C	Screw for 23223 T			51250 E (22586 R)	3	22569 B	Screw for 52891 B
2	25 CC	Screw for 43139 A	2	666-65	Oil Wick for 51144	1	22570 B	Screw for 51278 D
1	27-435		2	666-111	Oil Wick for 8	18	22571 A	Plug Screw
	Blk.	Needle Bar Eyelet	2	666-114	Oil Wick for right	1	22580 D	Screw for 51223 A
		Washer			main shaft bushing	2	22585 A	Screw for 52882 L
1	28 B	Screw for 52842 G	2	666-118	Oil Wick for left	1	22586 R	Screw for 660-212
2	50-216				main shaft bushing	1	22588 A	Screw for 52350 A
	Blk.	Pin for 51257 T	1	666-170	Oil Wick for 51250 E	4	22593	Screw for 39237 D
1	50-648		2	666-179	Wedge Pin for	2	22593	Screw for 51405 BK
	Blk.	Lucite Oil Gauge			666-111	1	22595	Screw for 51472 B
1	50-789		1	666-201	Felt for 51294 U	1	22596	Screw for 21657 Y
	Blk.	Hinge Pin for 39582 L	1	666-209	Felt for 51294 U	2	22597	Screw for 51435 B,
1	50 J-16	Stop Pin for 51417 E-10	1	666-214	Lint Filter for			52835 U
1	54	Needle Lever Con-			51294 M	1	22598 C	Screw for 21657-4
		necting Link	2	667 B-10	Dowel Pin for 51273 A	1	22711	Screw for 52372 A
2	73	Screw for looper	3	719	Screw for 51150,	1	22729	Screw for 51243 C
2	77	Screw for 51054			51250 E, 52835 U	1	22729 A	Screw for 51294 U
1	77	Screw for 51204 A	1	907	Nut for 22868 A	1	22729 B	Screw for 51294 U
2	77	Screw for 51236 A	1	6042 A	Washer for 52894 AM	2	22730	Screw for 51278
1	78	Screw for 51054	2	6990	Spring for 51430 W,	1	22733 B	Screw for 52882 L
2	80	Screw for 51501 A			51430 X			(41394 A)
2	80	Screw for 52980 A	1	7947	Nut for 51294 R	1	22747	Screw for 52834
1	81	Screw for 51242 Y	2	8372 A	Washer for 43139 A	1	22758 B	Screw for 51435
		(12982)	2	9937	Nut for 51435	2	22758 B	Screw for 52835 G
1	82	Stitch Regulating	1	12538	Nut for 51241 K			(12934 A)
		Screw	2	12934 A	Nut for 22758 B	1	22758 C	Screw for 53783 A
2	87	Screw for 51424 BK-	1	12957 E	Spring Washer for	2	22768	Screw for 51236 B
		10			23437 W	3	22768	Screw for 51244 B,
2	J87 J	Screw for 51204 C	1	12982	Lock Nut for 81			56458, 56458 A
2	88	Screw for 15465 F	1	15465 F	Looper Rocker Cone	2	22798	Screw for 51472 A
1	88	Screw for 52894 AK			for 29192 D (88)	1	22798 A	Screw for 51204
2	88 B	Needle Set Screw	2	21210 A	Looper Collar	1	22799 N	Screw Pin for
1	89	Set Screw for	1	21212	Locking Ring for			61130 F
		52818-8			51294 N	2	22799 U	Screw for 51430 W,
2	90	Screw for 23322 AL-	1	B21375 AH	Belt Guard (93)			51430 X
		1	1	21657-4	Tension Release	1	22811 B	Screw for 51242 W
1	90	Screw for 51426 BK			Separator (22598 C)	2	22823 A	Screw for 51493 AY
2	90	Screw for 51282 AE,	1	21657 E	Washer for 51257 T	1	22823 B	Screw for 51493 AY
		52882 Y	1	21657 W	Tension Release	1	22829	Screw for 51745(258 A)
3	90	Screw for 52794 G,			Lever Shaft	2	22839 C	Screw for 51501 A
		52894 AD, 52894 AE	1	21657 X	Tension Release	1	22848	Screw for 51758 (20)
2	90	Screw for 52882 AA			Lever Shaft Bushing	2	22848	Screw for 52835 N
2	93	Screw for B21375 AH	1	21657 Y	Tension Release	9	22848	Screw for 52882 L
2	95	Screw for 51147			Lever Shaft Con-	1	22852 A	Screw for 51242 Y
1	95	Screw for 51270 B			nection (402, 22596)			(51242 M)
1	95	Plug Screw	3	22513	Screw for 35731 A	1	22868 A	Screw for 52835 S
2	96	Screw for 51223 A,	3	22516	Screw for 52836 H			(907, 39236 A)
		51244	2	22517	Screw for 51273 A	1	22883 A	Plug Screw
1	98	Screw for 482	2	22519 C	Screw for 52836 C	1	22889 A	Adaptor Plug Screw
1	98	Screw for 51244			(51235 G)	4	22894 C	Screw for 29105 Z
3	98 A	Screw for 158 B	1	22519 H	Screw for 51244 B	2	22894 C	Screw for 51273 A
1	98 A	Screw for 51291 A	1	22519 J	Screw for 51425 BK,	1	22894 C	Screw for 52372 A
					52925 D	1	22894 D	Screw for 29015 Z
8	109	Tension Disc				1	22894 D	Screw for 51406
3	158 B	Thread Eyelet (98 A)	6	22524	Screw for 51282 AF	1	22894 F	Screw for 51221 C
1	258	Nut for 51280 E	1	22528	Screw for 51257 T	1	22894 H	Screw for 51242 W
1	258 A	Nut for 660-136	1	22537	Screw for 51430 U	2	22894 J	Screw for 51247
1	258 A	Nut for 22829	1	22539 H	Plug Screw	2	22894 P	Screw for 52836
1	258 A	Nut for 52894 AM	3	22541 B	Screw for 52882 AD	1	22894 T	Screw for 51142 B
2	269	Nut for 51236 G,	1	22542	Plug Screw for	1	23223 T	Strip Guide (25 C)
		51240 E			51282 Y (52882 W)	1	23322 M	Washer for 23322 AL-1
2	402	Screw for 21657 Y,	1	22547 C	Screw for 51478	1	23322 AL-	
		53783 A			(51250 C)	1		
2	482	Feed Rocker Shaft	4	22548	Screw for 52882 AE			Binder for 1 inch width
		Collar (98)	2	22548	Screw for 23437 V			binding (90, 23322 M)
1	531	Screw for 51257 M	2	22557 B	Screw for 53783 L	1	23437 U	Binder Mounting
2	531	Screw for 51493 BQ	2	22559 A	Bearing Cap Screw,	1	23437 V	Bracket (23437 E)
1	605	Screw for 51430 T			lower, for 29105 Z			Binder Slide Block
1	643-127		2	22559 B	Bearing Cap Screw,	1	23437 W	(22548)
	Blk.	Gasket for 51493 AG			upper, for 29105 Z			Screw for 23437 U
1	660-136	Feed Crank Oil Tube						(12957 E, 43139 A)

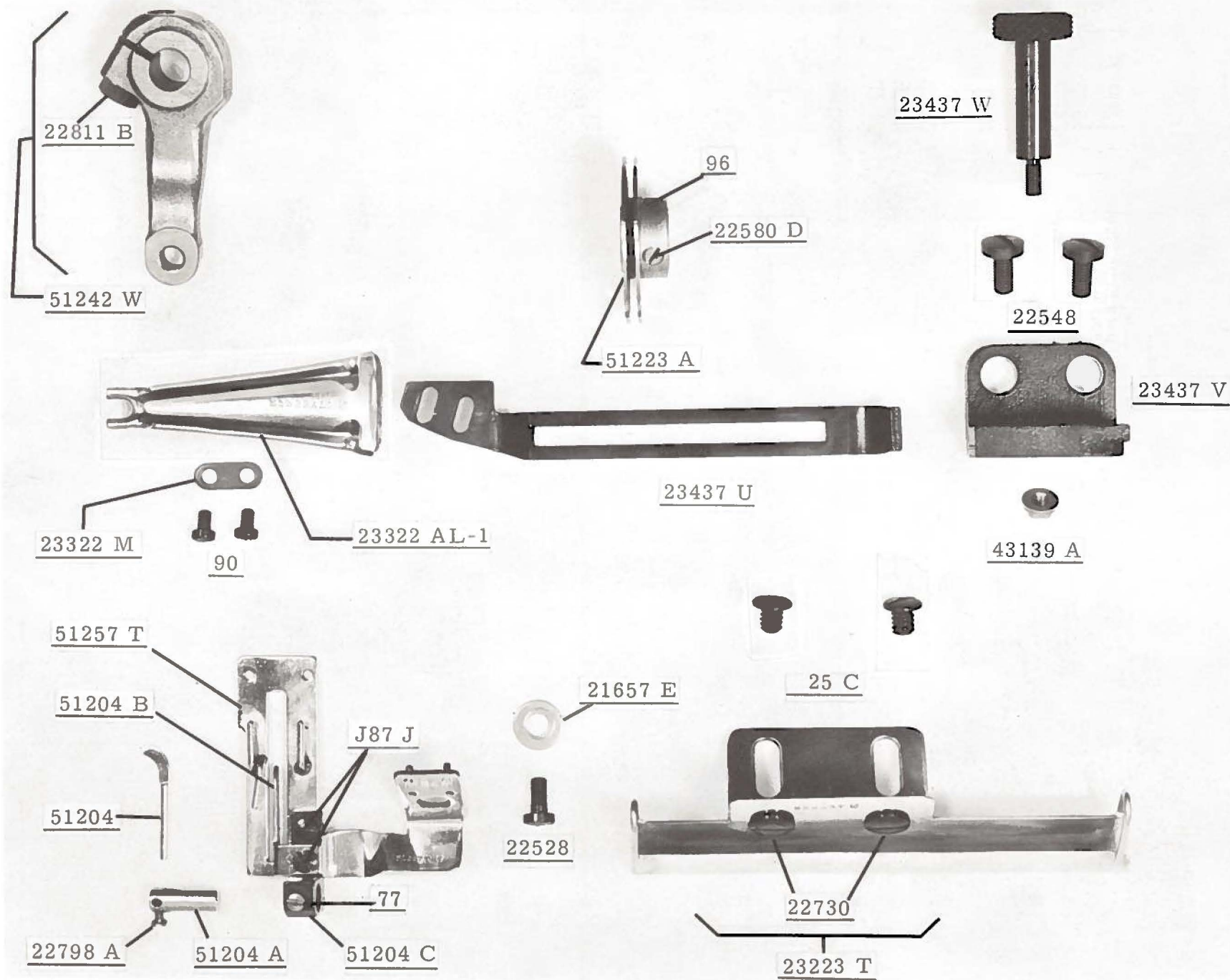
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	29066 R	Needle Lever Connecting Rod Assembly (22559 G)	2	51236 A	Feed Lift and Looper Avoid Eccentric Link Pin (77)	1	51272 D	Block Guide Collar Shaft Spring
1	29105 Z	Looper Drive Eccentric Assembly (22894 C, 22894 D)	1	51236 B	Feed Crank Stud Cap (22768)	1	51273 A	Upper Knife Lever Stud Support Bracket (22517, 22894 C)
1	29192 D	Looper Rocker Assembly	1	51236 D	Feed Crank Link	1	51273 B	Upper Knife Rocker Bearing Stud
1	29348 P	Needle Lever Assembly	1	51236 E	Feed Crank Link Assembly; one each 660-169, 41236 D, 51236 F	1	51273 D	Knife Holder Rocker Arm (77)
2	29476 DV	Feed Lifter and Looper Avoid Eccentric Assembly	1	51236 F	Feed Crank Link Ferrule	1	51278	Front Cover and Chip Guard Assembly (22730)
1	29476 FF	Crankshaft Assembly, 910 inch throw	1	51236 G	Feed Crank Stud (20, 269)	1	51278 A	Chip Guard for 51278
1	29476 HZ	Knife Driving Eccentric Assembly	1	51240 E	Looper Connecting Rod (18, 269)	1	51278 D	Chip Guard Tension Spring (22570 B)
4	35178 D	Spring for 666-65, 666-114	1	51241 K	Looper Connecting Rod and Ball Joint, right (12538)	1	51278 G	Hinge Pin for 51278 A
2	35731 A	Presser Bar Connecting Guide Plate (22513)	2	51242 L	Thrust Washer for 51242 Y	1	51280 E	Throat Plate Support Pin (258)
1	35766	Screw for 51450	2	51242 M	Washer for 22852 A, 52841 G	1	51282 Y	Head Cover (22542, 22569 B)
1	39158 G	Front Cover Hinge	1	51242 P	Looper Drive Lever Shaft	1	51282 Z	Head Cover Gasket
1	39158 U	Front Cover Hinge Spring	1	51242 R	Looper Drive Lever Shaft Bushing, middle	1	51282 AC	Felt Liner for 51282 Y
1	39236	Differential Feed Bar Driving Link Slide Block	1	51242 S	Looper Drive Lever Shaft Bushing, rear	1	51282 AE	Needle Lever Bearing Oiler (90)
2	39236 A	Differential Feed Bar Regulating Stud Washer for 22868 A	1	51242 W	Looper Drive Lever (22811 B, 22894 H)	1	51282 AF	Oiler Reservoir Top Cover (22524)
1	39237	Differential Feed Bar Guide (22565 C)	1	51242 Y	Looper Drive Lever Rocker (81, 22852 A)	1	51283 H	Presser Foot Lifter and Tension Disc Release Lever
2	39237 D	Differential Feed Bar Guide Plate (22593)	1	51242 Z	Looper Drive Lever Shaft Bushing, front	1	51290 T	Main Shaft Bushing, center
2	39237 G	Bushing for 52834	1	51243 C	Ball Stud Fork (22729)	1	51291 A	Looper Thread Guard (98 A)
1	39582 L	Oil Cap for 52882 AD	1	51244	Looper Rocker Frame (96, 98)	4	51292 A	Tension Post Ferrule
2	41394 A	Gasket for 22733 B	1	51244 B	Looper Rocker Shaft Arm (22519 H, 22768)	4	51292 C	Tension Nut
2	43139 A	Differential Feed Index Stop (25 CC, 8372 A)	1	51244 L	Looper Rocker Shaft Thrust Washer	4	51292 D	Tension Thread Eyelet
1	43139 A	Lock Nut for 23437 W	2	51244 M	Looper Rocker Shaft Thrust Washer	2	51292 F-4	Tension Spring (looper)
2	43266	Nut for 51292 G	1	51244 N	Looper Rocker Shaft Bushing, right	2	51292 F-8	Tension Spring (needle)
1	51054	Feed Crank Link Pin (77)	1	51244 N	Looper Rocker Shaft Clamp Collar (18, 51216 N, 55244 G)	4	51292 G	Tension Post (43266)
2	51054	Needle Lever Link Pin (77, 78)	1	51246	Looper Rocker Stud Nut	1	51294 M	Oil Siphon Tube
1	51134 C	Feed Bar Shaft	1	51247	Main Shaft Counterweight (22894 J)	1	51294 N	Oil Siphon Tube Connection (21212)
1	51142 B	Knife Drive Eccentric (22894 T)	1	51250 A	Needle Lever Bushing for 51215 J	1	51294 P	Oil Tube Clamp (51294 R)
1	51144	Looper Rocker Shaft Bearing for 29476 DV	1	51250 C	Nut for 22547 C	1	51294 R	Screw for 51294 P (7947)
1	51145 A	Bearing for 29476 HZ	1	51250 D	Washer for 22586 R	1	51294 U	Oil Siphon Assembly
1	51147	Main Shaft Collar (95)	1	51250 E	Needle Lever Stud for 29348 P (719)	4	51295 A	Isolator for base plate assembly
1	51150	Needle Lever Shaft Stop Collar (719)	1	51250 F	Gasket for 22586 R	1	51382 A	Gasket for 51282 AF
1	51204	Looper Thread Retaining Finger (22798 A)	1	51254 C	Upper Needle Bar Bushing	1	51405 BK	Main Feed Dog (22593)
1	51204 A	Looper Thread Retaining Finger Holder (77)	1	51254 D	Lower Needle Bar Bushing	1	51406	Feed Lift and Looper Avoid Eccentric (22894 D)
1	51204 B	Cast-off	1	51254 H	Needle Bar Connection (22562 A)	1	51408 C-10	Looper, front (73)
1	51204 C	Cast-off Finger Support Bracket (J87 J)	1	51256 C	Presser Spring	1	51409 C	Looper, back (73)
1	51215 J	Needle Lever	1	51256 N	Presser Spring Regulator	1	51417 E-10	Needle Bar
2	51216 G	Needle Lever Connecting Rod	1	51257 K	Presser Bar	1	51420 BK-10	Presser Foot Main Shaft
28	51216 M	Crankshaft Needle Bearing Roller	1	51257 M	Presser Bar Connector and Guide (531)	1	51422 H	Throat Plate (87)
1	51216 N	Washer for 51215 J	1	51257 T	Cast-off Plate Support (21657 E, 22528)	1	51424 BK-10	Needle Guard (22519 J)
1	51216 N	Washer for 55244 G	1	51257 AA	Lower Presser Bar Bushing	1	51425 BK	Differential Feed Dog (90)
1	51216 P	Nut for 51215 J	1	51270 B	Needle Thread Take-up Wire (95)	1	51426 BK	Presser Foot Bottom, front section (605)
1	51221 C	Pulley (22894 F)	1	51272 C	Knife Holder Block Guide Collar Shaft	1	51430 T	Presser Foot Bottom, left (22799 U)
1	51223 A	Take-up (96, 22580 D)				1	51430 U	Presser Foot Bottom, right (22799 U)
1	51230 U	Presser Foot Shank				1	51430 V	Presser Foot Lower Plunger, left
2	51235 G	Washer for 22519 C				1	51430 W	Differential Feed Control Lever
1	51236 A	Link Pin for 51273 D (77)				1	51430 X	rear (20, 9937, 22758 B)

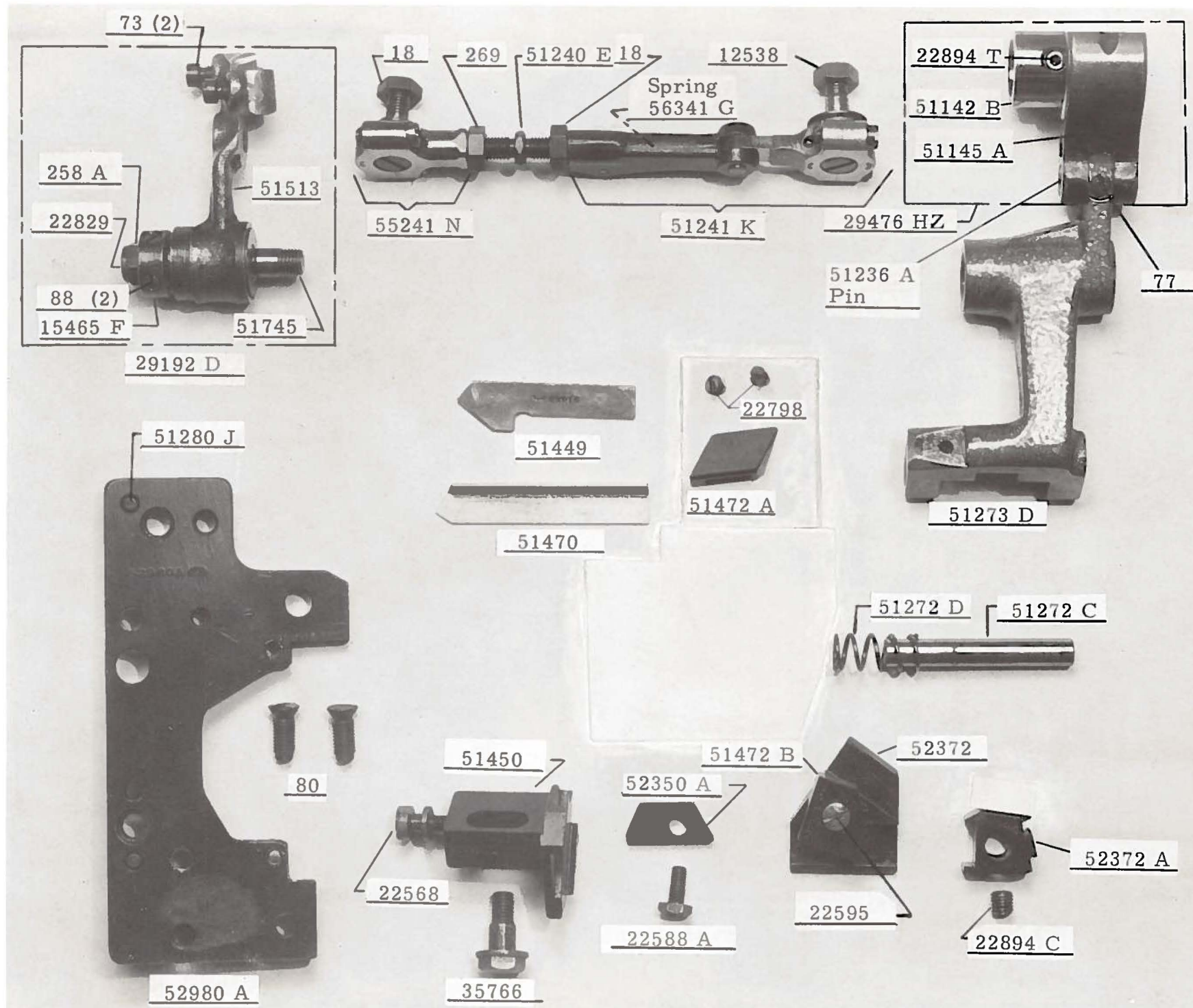
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51435 B	Differential Feed Control Lever Bushing (22597)	1	52470	Stop for looper connecting rod	1	52883 R	Foot Lifter Lever Bushing
1	51449	Lower Knife	1	52794 G	Feed Lifter & Looper Avoid Eccentric Oil Tube (90)	1	52883 S	Presser Foot Lifter Lever Bell Crank Spring
1	51450	Lower Knife Holder Block (22568, 35766)	1	52818-8	Needle Holder (88, 89)	2	52890 C	Main Shaft Bushing, left, and crank shaft bushing, left
			1	52834	Main Feed Bar (22560 B, 22747)	1	52891 B	Main Shaft Housing, including bushing (22569 B)
			1	52834 H	Differential Feed Bar	3	52894 AB	Oil Tube Holder (90)
1	51470	Knife, upper	1	52835	Differential Feed Control Lever (9937)	1	52894 AD	Oil Tube for differential feed bar shaft (90)
1	51472 A	Upper Knife Shield (22798)	1	52835 G	Control Lever Link (22758 B)	1	52894 AE	Oil Tube for differential feed bar guide (90)
1	51472 B	Upper Knife Clamp (22595)	1	52835 K	Control Lever Spring (61267 G)	1	52894 AK	Oil Tube for looper rocker and left ball joint (88)
1	51478	Front Cover and Chip Guard Latch (22547 C, 51250 C)	1	52835 N	Control Lever Stop Plate (22848)	1	52894 AM	Oil Tube for right looper connecting rod ball joint (258 A, 6042 A)
2	51491 C	Lead-in Thread Eyelet	1	52835 Q	Differential Feed Fork	1	52925 D	Needle Guard Holder (22519 J)
1	51493 D	Oil Pump Driving Shaft	1	52835 S	Differential Feed Fork Block (22868 A)	1	52980 A	Throat Plate Support (80)
2	51493 E	Oil Pump Driving Shaft Gear	1	52835 U	Pivot Stud Insert (719, 22597)	1	53592	Tension Post Support
1	51493 AG	Oil Pump Housing (22569 B)	1	52835 V	Differential Feed Bar Driving Link	1	53690 E	Bearing Housing Gasket
1	51493 AH	Oil Pump Housing Cover	1	52836	Feed Rocker (22894 P)	1	53783 A	Presser Foot Lifter Lever Link (402, 22758 C)
1	51493 AY	Base Plate Assembly (22823 A, 22823 B)	1	52836 C	Feed Rocker Arm (22519 C)	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
1	51493 BH	Oil Filter Cap Assembly	1	52836 H	Feed Rocker Segment Plate (22516)	1	53783 M	Presser Foot Lifter Lever Connecting Rod
1	51493 BK	Lint Filter Screen	2	52836 P	Feed Rocker Shaft Bushing	1	53783 N	Presser Foot Lifter Lever, internal (22537)
1	51493 BP	Oil Pump Driving Gear (22560 B)	1	52836 R	Looper Rocker Shaft Bushing, left	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
1	51493 BQ	Oil Pump Driven Gear (531)	1	52841 G	Locking Stud for 51242 Y (51242 M, 52841 J)	1	55244 G	Looper Shaft Collar Stud (18, 51216 N)
1	51494 F	Oil Tube for feed rocker and knife lever	1	52841 J	Nut for 52841 G	*	61130 D	Presser Foot Lower Plunger, right
1	51501 A	Cloth Plate (80, 22839 C)	1	52842 G	Needle Holder Thread Guide (28 B)	1	61130 F	Presser Foot Equalizer (22799 N)
1	51513	Looper Rocker for 29192 D	1	52853	Feed Dog Holder (22519 J, 22519 C)	1	61267 G	Pin for 52835 K
1	51745	Looper Rocker Cone Stud (258 A, 22829)	1	52882 L	Oil Reservoir Back Cover (22585 A, 22733 B, 22848)	1	80557	Spacing Washer for 21657-4, 53592
1	51758	Frame Needle Thread Eyelet (20, 22848, 22889 A)	1	52882 M	Gasket for 52882 L	*1	56458	Needle Lever Thread Eyelet (22768)
			1	52882 P	Gasket for 52882 AD	*1	56458 A	Needle Bar Thread Eyelet (22768)
			1	52882 U	Gasket for 52882 AE			
			1	52882 W	Gasket for 22542			
1	52350 A	Lower Knife Holder Plate (22588 A)	1	52882 Y	Baffle Plate (90)			
1	52372	Upper Knife Holder Block	1	52882 AA	Oil Drip Plate for 52882 AD (90)			
1	52372 A	Knife Holder Block Guide (22711, 22894 C)	1	52882 AC	Torsion Spring for 52882 AD			
1	52373 A	Bushing for 51273 D	1	52882 AD	Crank Chamber Cover, upper (22541 B)			
			1	52882 AF	Crank Chamber Cover, lower (22548)			

NOTE: Numbers in parenthesis following parts' description indicate the screws, nuts, etc., used to attach these parts.

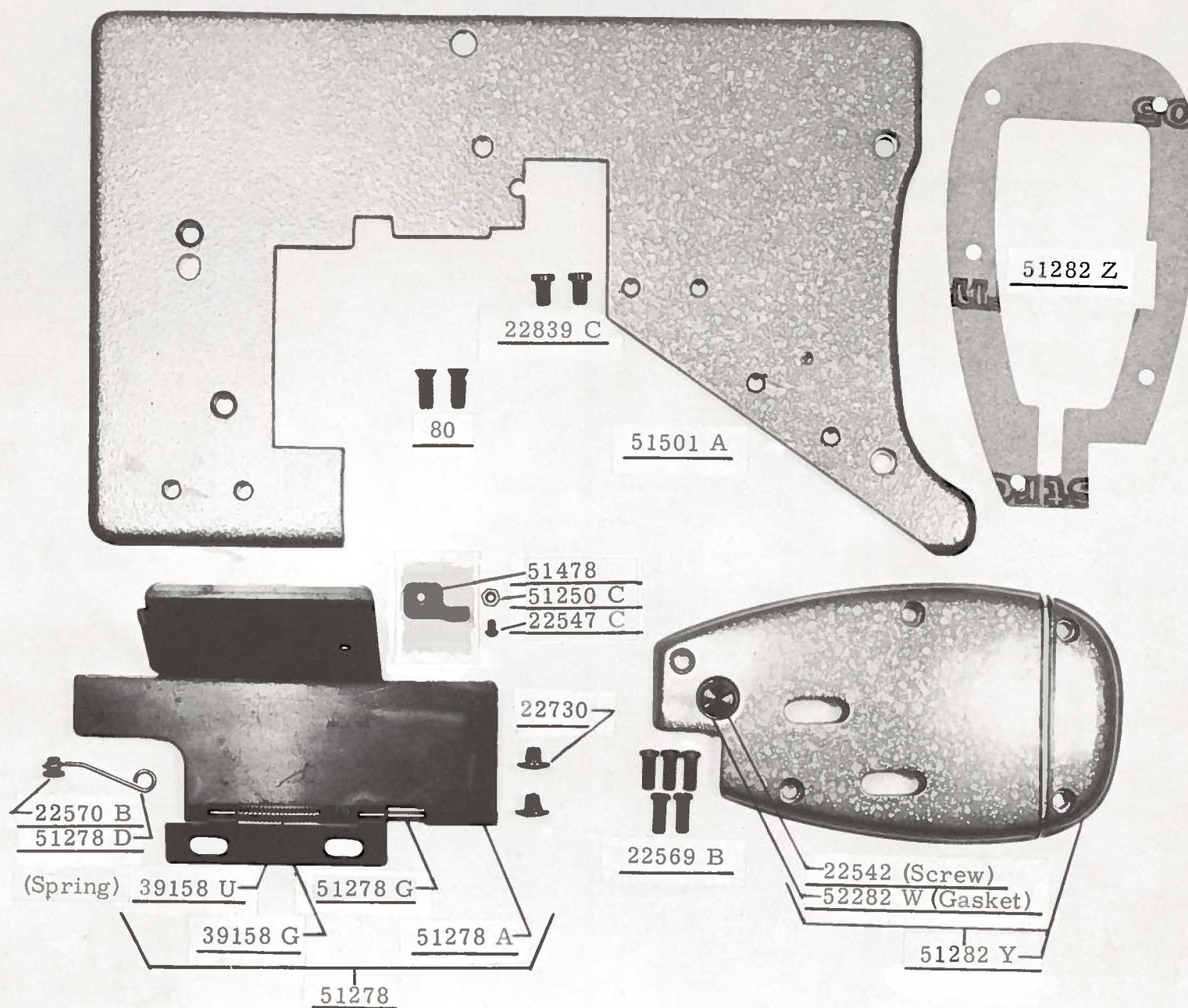
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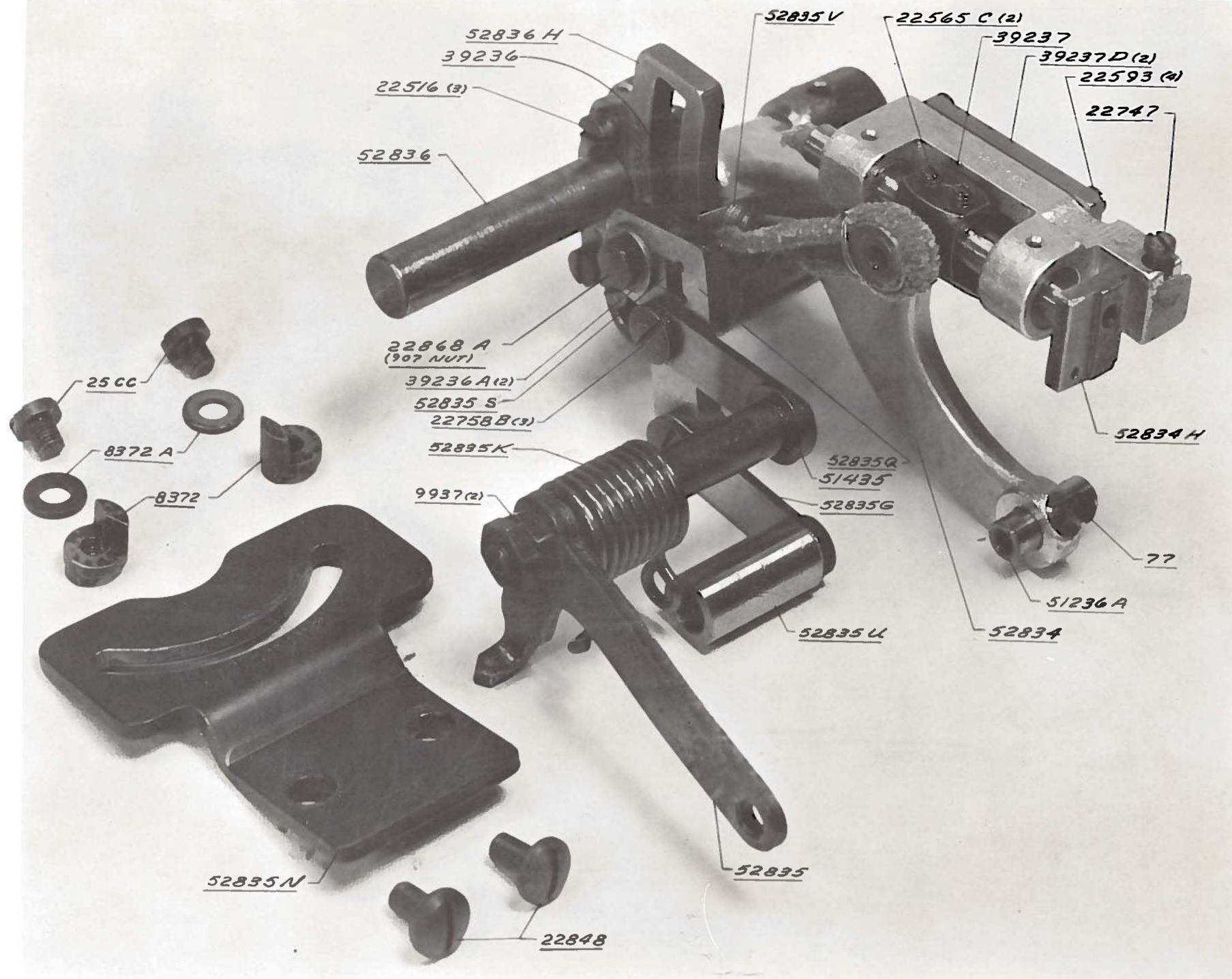






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