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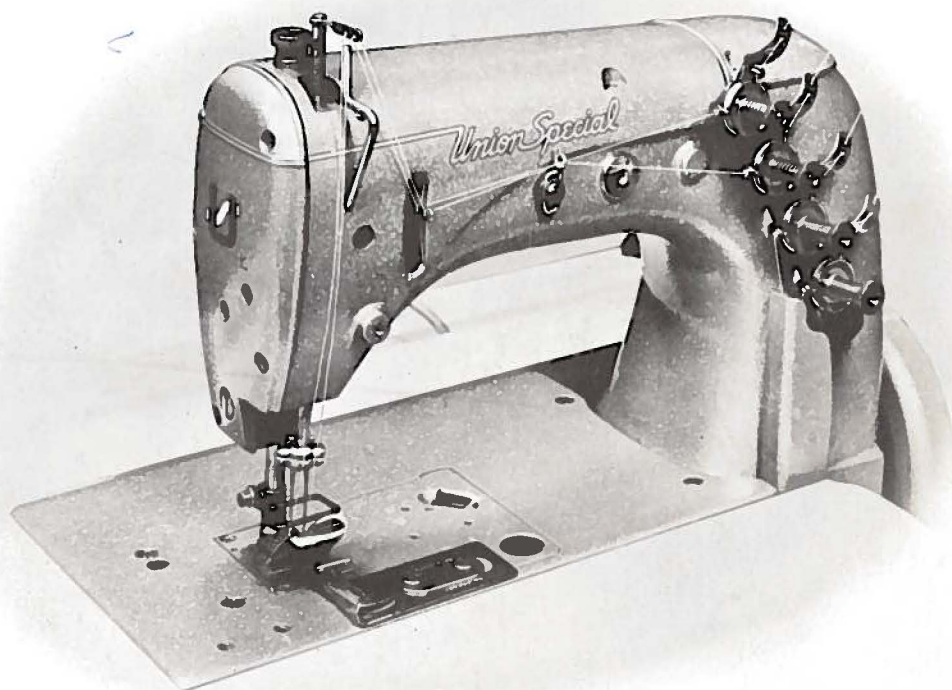
**INDUSTRIAL
SEWING
MACHINES**

**UNITY SEWING SUPPLY CO.
824 E. 8th St.
Los Angeles, CA 90021**

CLASSES

51400

51600



**CATALOG
NO.
T128 L**

STYLE 51600 BA

**LIST OF PARTS FOR STYLES
51400 BC 51600 BA**

Union Special **CORPORATION**
CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. T128 L

LIST OF PARTS

For Styles

51400 BC

51600 BA

First Edition

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Union Special
CORPORATION
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U. S. A.

July, 1973

IDENTIFICATION OF MACHINES

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 51600 BA". 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 51600 BAZ".

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: "51600".

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 Classes 51400 and 51600. Reference to direction, such as right, left, front, back, etc., are given from the operator's position while seated at the machine. Operating direction of the handwheel is toward the operator.

STYLES OF MACHINES

Streamlined Flat Bed Machines, Low Throw, Two Needles, Independent Row, Treadle Controlled Intermittent Differential Feed, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump and Head Oil Siphon Assembly, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 7 3/4 Inches.

51400 BC Left needle in front and 1/8 inch space between needles inline with feed. For setting puff sleeves in house dresses, waists, pajamas, and for similar operations on light to medium weight woven materials, where a large percent of the work calls for intermittently or continuously gathered curved seams and a small percent calls for intermittently or continuously gathered straight seams. Upper ply of fabric passes to the right of needles. Treadle controlled 3 to 1 differential feed gathering mechanism. Seam specification 401-LSc-2 modified. Type 106 GHS needles. Standard gauges Nos. 12 and 16.

51600 BA Same as Style 51400 BC except right needle in front. For gathering and attaching ruffles to body of garments made from light weight woven fabrics and similar operations where a large percent of the work calls for an intermittently or continuously gathered straight seam and a small percent of the work calls for an intermittently or continuously gathered curved seam. Upper ply of fabric passes to the left of needles. Treadle controlled 3 to 1 differential feed gathering mechanism. Seam specification 401-LSc-2 modified. Type 106 GS needles. Standard gauges Nos. 8, 12 and 16.

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 the largest diameter of the blade, measured in thousandths of an inch, midway between the shank and the eye. Collectively, type number and size number represents the complete symbol.

NEEDLES (Continued)

The type numbers of the needles 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 and Sizes</u>
106 GS	Round shank, round point, extra short, double groove, struck groove, ball eye, chromium plated - sizes 027, 029, 032, 036, 040, 044, 049.
106 GHS	Round shank, round point, extra short, ball point, double groove, struck groove, ball eye, chromium plated - sizes 032, 036, 040.

To have 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 106 GS, Size 036".

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

IDENTIFYING PARTS

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

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

IMPORTANT! ON ALL ORDERS, PLEASE INCLUDE PART NAME AND STYLE OF MACHINE FOR WHICH PART IS ORDERED.

USE GENUINE NEEDLES AND REPAIR PARTS

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

Genuine needles are packaged with labels marked *Union Special*. Genuine repair parts are stamped with the Union Special trademark. Each trademark is your guarantee of the highest quality in materials and workmanship.

TERMS

Prices are net cash and subject to change without notice. All shipments are forwarded f.o.b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

OILING AND THREADING

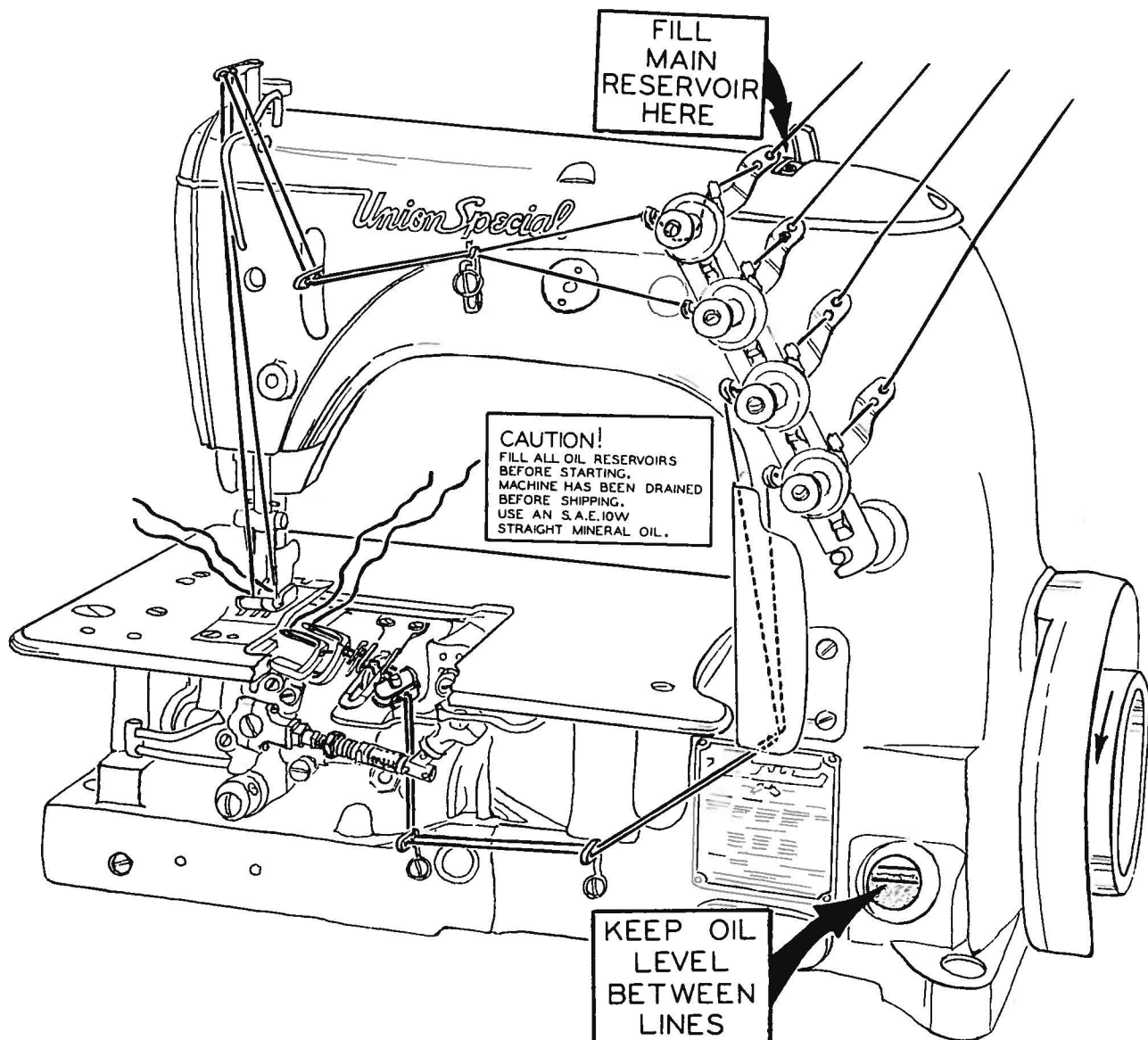
The oil has been drained from the machine before shipping and the reservoir must be filled before beginning to operate. Use a straight mineral oil with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit.

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 reservoir is 12 ounces.

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

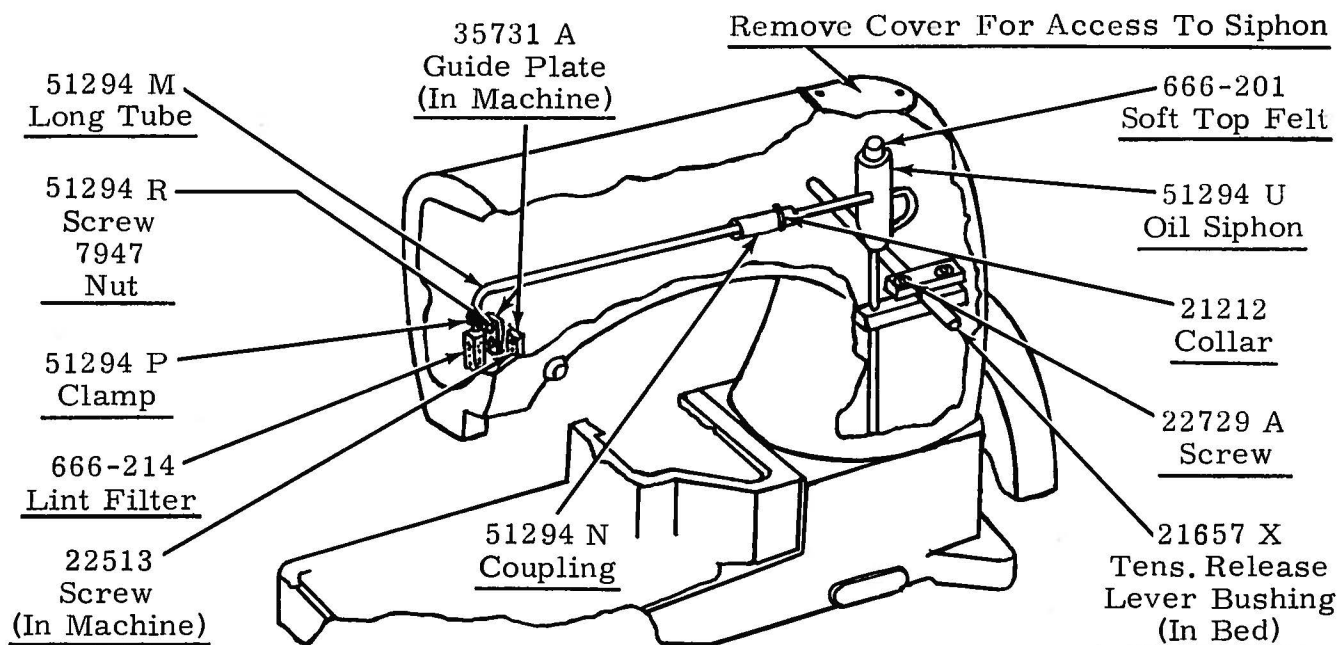
A daily check before the morning start should be made and oil added as required. Oil which has gone through the machine is filtered and pumped back into the main reservoir, making too frequent oilings unnecessary. Excessive oil in the main reservoir may be drained at the plug screw in the main frame directly under the handwheel. After draining oil, wipe the hole and plug screw dry, paint the hole and screw with a little gasket cement and reassemble screw.

The accompanying drawing shows the manner in which Styles 51400 BC and 51600 BA are threaded. The machines can be threaded in a similar manner, left needle in front or right needle in front makes no difference.



SELF-PRIMING HEAD OIL SIPHON

Styles 51400 BC and 51600 BA are equipped with a self-priming head oil siphon. When the machine is started, oil splashes on the priming cup felts, filters through the felts, and trickles down the vertical oil tube, thus, priming the siphon. Once the prime is established, it is maintained, unless the felts are removed. The siphon operates twenty-four hours a day, removing oil at the rate of six to twelve drops per minute, which of course, far exceeds the rate at which oil collects in the head.



INSTALLING AND MAINTENANCE OF OIL SIPHON

A newly installed siphon starts its action within three to five minutes after the machine is operating. However, it may be twenty minutes or so before all the air is removed from the line and the siphon is in full operation. Within an hour, there is a distinct drop in oil level in the head sump.

The felts in the priming cup are designed for a specific purpose. The bottom felt, 666-209, is thin and relatively dense, to meter the flow of priming oil and to prevent the entrance of air. The softer top felt, 666-201, is a filter to prevent the clogging of the metering felt. This felt, at the intake of the siphon, keeps the siphon clear of lint, and prevents the entrance of air at that point. For the best initial self-priming condition, the felts of the siphon should be dry. In this condition, it is difficult for air to be trapped between the felts or in the top soft felt itself.

However, if for some reason the priming cup felts had been oiled before installing, the siphon may fail because air is trapped between the felts or in the soft top felt. As a precaution, remove the soft felt from the cup. Then, while squeezing the felt between the fingers, saturate it well with oil. In other words, squeeze out the air and replace it with oil. Then, completely fill the cup with oil, and push or twist the soft felt down into cup so that it definitely contacts the harder thin felt. This precaution prevents the trapping of air, and no trouble should be experienced when starting the siphon.

If you want to be doubly sure that the siphon is functioning correctly, on a machine in operation, apply a certain amount of oil in the sump around the felt in the head. Before doing this, be certain that this felt has been saturated in the same manner as explained for the soft felt in the top of the siphon cup. When this is done, the siphoning action will begin, and the oil will be removed as explained.

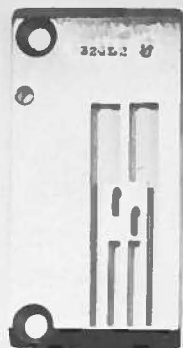
The following is a numerical list of parts used in Styles 51400 BC and 51600 BA. Quantities, part numbers and descriptions are given. Unless otherwise specified, the parts listed are for both machines. Following the parts list are photographs of some of the major parts.

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Feed Rocker Shaft	1	402	Screw for 21657 Y	1	12982	Nut for 81
3	18	Nut for 51240 D, 55241 N, 55244 G (right thread)	1	402	Screw for 53783 A	1	15105 B	Main Feed Dog for 8 gauge 51600 BA (22593)
2	PI18	Pin for 666-82	2	482	Feed Rocker Shaft Collar (98)	1	15226 B	Diff. Feed Dog for 8 gauge 51600BA(90)
3	20	Washer for 51236 G, 51435, 51758	1	531	Screw for 51257 M	1	15465 F	Looper Rocker Cone for 29192 A (88)
2	25 C	Screw for 23233 A	2	531	Screw for 51493 BQ	1	21210 A	Looper Collar for 51609 A
2	25 C	Screw for 23253 F	1	643-127 Blk.	Gasket for 51493 AG	1	21212	Locking Ring for 51294 N
2	25 C	Screw for 23253 Z	1	660-136	Oil Tube for feed crank link (258 A)	1	B21375 AH	Belt Guard (93)
2	25 CC	Screw for 43139 A (8372 A)	1	660-169	Needle Bearing for 51236 E	1	21657-4	Tension Release Separator
1	27-435 Blk.	Needle Bar Eyelet Washer	1	660-202	"O" Ring for pulley	1	21657 E	Washer for 51457 A
2	28	Screw for 52804 A	1	660-207	Oil Seal Ring for pres- ser foot lifter lever	1	21657 W	Tension Release Lever Shaft
1	28 C	Adjusting Screw for 8344	2	660-212	Oil Seal Ring for needle lever stud	1	21657 X	Tension Release Shaft Bushing
1	43	Looper Avoid Eccen- tric for 29476 BJ (22894 D)	2	666-65	Oil Wick for looper rocker shaft (35178D)	1	21657 Y	Tension Release and Lifter Lever Shaft Connection(402, 22596)
1	43 C	Feed Lift Eccentric for 29476 AR (22894 D)	2	666-82	Oil Wick for 51145 (PI18)	2	22513	Screw for 23233 C
2	50-216 Blk.	Pin for 51457 A	2	666-111	Oil Wick for feed rocker shaft	3	22513	Screw for 35731 A
1	50-458 Blk.	Spring Pin for 51241 K	2	666-114	Oil Wick for main shaft bushing, right (35178 D)	3	22516	Screw for 52836 H
1	50-648 Blk.	Lucite Oil Gauge	1	666-170	Oil Wick for main shaft bushing, left	2	22519 C	Screw for 52836 C
1	54	Needle Bar Link on 29348 P	2	666-179	Oil Wick for 51250 E	1	22519 H	Screw for 51244 B
2	73	Screw for looper	1	666-201	Wedge Pin for 666-111	1	22519 J	Screw for needle guard and 52853
1	77	Screw for 51054	1	666-209	Felt Plug, upper, for 51294 U	7	22524	Screw for 53782 B
1	77	Screw for 51054 on 29348 P, upper	1	666-214	Siphon Cup Disc Felt for 51294 U	1	22528	Screw for 51457 A
1	77	Screw for 51236 A	1	719	Felt Lint Filter for 51294 M	1	22539 H	Plug Screw for bed
2	80	Screw for cloth plate	1	719	Screw for 51150	3	22541 B	Screw for 52882 AD
1	81	Screw for 51242 Y (12982)	1	719	Screw for 51250 E	4	22548	Screw for 52882 AE
1	82	Stitch Regulating Screw	1	907	Screw for 52835 U	1	22557 B	Screw for 53783 L
2	87	Screw for throat plate on 51600 BA	1	6042 A	Nut for 22868 A	2	22559 A	Cap Screw for 29105 AA, small end
2	88	Screw for 15465 F	1	7947	Washer for 52894 AM	2	22559 B	Cap Screw for 29105 AA, large end
1	89	Screw for 51418-16	1	8305 L	Nut for 51294 R	2	22559 G	Screw for 29066 R
1	90	Screw for differential feed dog	1	8305 N	Main Feed Dog for 16 gauge 51600 BA (22593)	2	22560 B	Screw for 51493 BP
2	90	Screw for 51282 AE	1	8305 S	Main Feed Dog for 12 gauge 51600 BA (22593)	1	22560 B	Screw for 52834
2	90	Screw for 52882 Y	1	8324 L-2	Main Feed Dog for 10 gauge 51600 BA (22593)	2	22560 B	Screw for 52894 AK
2	90	Screw for 52882 AA	1	8324 L-4	Throat Plate for 8 gauge 51600 BA(87)	2	22561	Screw for 23253 B
3	90	Screw for 52894 AB	1	8324 L-4	Throat Plate for 12 gauge 51600BA(87)	2	22561	Screw for 23253 Y
1	91	Clamp Screw for 51600 BA presser feet	1	8324 L- 4 1/2	Throat Plate for 16 gauge 51600BA(87)	1	22562 A	Screw for 51254 H
2	93	Screw for B21375 AH	1	8326	Diff. Feed Dog for 16 gauge 51600BA(90)	1	22564	Screw for 51054 on 29348 P, lower
1	95	Plug Screw for bed	1	8326 A	Diff. Feed Dog for 12 gauge 51600BA(90)	2	22565 C	Screw for 39237
2	95	Screw for 51147	1	8326 G	Diff. Feed Dog for 10 gauge 51600BA(90)	5	22569 B	Screw for 51282 Y
1	95	Screw for 51270 B	1	8326 C-3	Throat Plate for 10 gauge 51600BA(87)	3	22569 B	Screw for 51493 AH
1	96	Screw for 51244	1	8344	Stripper Blade for 51600BA(28C, 187 A)	3	22569 B	Screw for 52891 B
1	96	Spot Screw for 51423 B	2	8372 A	Washer for 25 CC	2	22570	Screw for throat plate on 51400 BC
2	98	Needle Set Screw	1	9420 C-2	Presser Foot for 8 gauge 51600 BA	18	22571 A	Plug Screw for bed
1	98	Screw for 482	1	9420 C-3	Presser Foot for 10 gauge 51600 BA	1	22580 D	Set Screw for 51423 B
1	98	Screw for 51244	1	9420 C-4	Presser Foot for 12 gauge 51600 BA	2	22585 A	Screw for 53782 B
3	98 A	Screw for 158 B	1	9420 C- 4 1/2	Presser Foot for 16 gauge 51600 BA	1	22586 R	Screw for 660-212 (51250 D, 51250 F)
1	98 A	Screw for 51291 A	2	9937	Nut for 51435	2	22593	Screw for main feed dog
8	109	Tension Disc	1	12538	Nut for 51241 K	4	22593	Screw for 39237 D
3	158 B	Looper Thread Eyelet (98 A)	2	12934 A	Nut for 22758 B	1	22596	Screw for 21657 Y
2	187 A	Screw for 8344				1	22597 A	Screw for 51435 B
1	258 A	Nut for 660-136				1	22597 A	Screw for 52835 U
1	258 A	Lock Nut for 22829 on 29192 A				2	22704	Screw for 51444-12
1	258 A	Nut for 52894 AM				2	22704	Screw for 51444-16
1	269	Nut for 51236 G				1	22729	Screw for 51243 C
1	269	Nut for 51240 D (left thread)				1	22729 A	Screw for 51294 U
1	357	Screw for 380				1	22729 B	Screw for 51294 U
1	380	Latch Spring for 51402 on 51400 BC (357)				2	22729 C	Screw for 55241 N
						1	22733 B	Plug Screw for 52882 L (41394 A)
						1	22747	Feed Dog Height Adjusting Scr. for 52834
						1	22758 B	Screw for 52835 G
						2	22758 B	Screw for 52835 Q (12934 A)

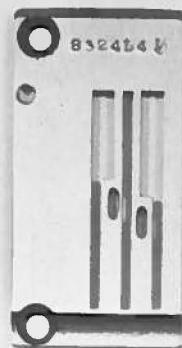
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	22758 C	Screw for 53783 A	2	39237 D	Diff. Feed Bar Guide	1	51250 E	Needle Lever Stud
3	22760 A	Screw for 51281 AC			Plate (22593)			(666-170, 719)
1	22765	Shank Screw for	2	39237 G	Bushing for 52834	1	51250 F	Gasket for 22586 R
		51420 AC-12, -16	1	39582 L	Oil Cap for 52882 AD	1	51254 C	Needle Bar Bushing,
2	22768	Screw for 51236 B	2	41394 A	Gasket for 22733 B			upper
1	22768	Screw for 51244 B	2	43139 A	Segment Stop Nut for	1	51254 D	Needle Bar Bushing,
1	22768	Screw for 56458 A			25 CC			lower
1	22768	Screw for 56458	2	43266	Nut for 51292 G	1	51254 J	Needle Bar Connec-
1	22799 E	Hinge Screw for	1	51054	Feed Crank Link Pin			tion on 29348 P
		presser foot			(77)			(22562 A)
		51420 AC-12, -16	2	51054	Link Pin for 29348 P	1	51256 C	Presser Bar Spring
1	22811 B	Clamp Screw for			(77, 22564)	1	51257 K	Presser Bar
		51242 W	1	51134 C	Feed Bar Shaft	1	51257 M	Presser Bar Connec-
1	22829	Screw for 15465 F	1	51144	Looper Rocker Shaft			tion and Guide (531)
		(258 A)			(51244 L)	1	51257 AA	Presser Bar Bushing,
3	22839	Screw for 51480 A	1	51145	Feed Lift Eccentric			lower
3	22839	Screw for 51480 C			Link for 29476 AR	1	51270 B	Pull-off Wire (95)
2	22839 C	Screw for cloth plate	1	51145	Looper Avoid Eccen-	1	51281 T-219	Cloth Plate Cover
1	22845 B	Screw for 51281 AC			tric Link for			for 51600 BA
1	22848	Screw for 51758			29476 BJ	1	51281 AC	Cloth Plate Cover
2	22848	Screw for 52835 N	1	51147	Main Shaft Collar (95)			Spring for 51600BA
9	22848	Screw for 52882 L	1	51150	Needle Lever Thrust			(22760 A, 22845 B,
1	22852 A	Screw for 51242 Y			Collar (719)			35772 II)
		(51242 M)	1	51215 J	Needle Lever on	1	51282 Y	Head Cover (22569 B)
1	22868 A	Screw for 39236 T			29348 P (51216 N,	1	51282 Z	Gasket for 51282 Y
		(907, 39236 A)			51216 P)	1	51282 AE	Needle Lever Bearing
1	22883 A	Plug Screw	2	51216 G	Needle Lever Con-			Oiler (90)
1	22889 A	Adaptor Plug Screw			necting Rod	1	51283 H	Presser Foot Lifter
		for 51758	28	51216 M	Needle Bearing			and Tension Disc
4	22894 C	Set Scr. for 29105 AA			Roller for 29476 FG			Release Lever (402)
1	22894 D	Screw for 43	1	51216 N	Washer for 51215 J	1	51290 T	Main Shaft Bushing,
1	22894 D	Screw for 43 C	1	51216 N	Washer for 55244 G			middle
1	22894 D	Spot Screw for	1	51216 P	Nut for 51215 J	1	51291 A	Looper Thread Guard
		29105 AA	1	51221 C	#1 Vee Belt Pulley			(98 A)
2	22894 F	Screw for 51221 C			(22894 F)	4	51292 A	Tension Post Ferrule
1	22894 H	Screw for 51242 W	2	51225 W	Diff. Feed Bar	4	51292 C	Tension Nut
2	22894 J	Screw for 51247			Reg. Stud Washer	4	51292 D	Tension Post Eyelet
2	22894 P	Screw for 52836	2	51235 G	Washer for 52836 C	2	51292 F-2	Tension Spr., looper
1	23233 A	Attachment for	2	51236 A	Link Pin for feed lift	2	51292 F-5	Tension Spr., needle
		51400 BC (25 C)			and looper avoid (77)	4	51292 G	Tension Post (43266)
1	23233 B	Lower Scroll and	1	51236 B	Feed Crank Stud Cap	1	51294 K	Clamp, upper, for
		Base for 23233 A			(22768)			51294 U
1	23233 C	Upper Scroll for	1	51236 D	Feed Crank Link for	1	51294 M	Oil Siphon Tube
		23233 A (22513)			51236 E	1	51294 N	Oil Tube Connection
1	23253 B	Attachment, upper,	1	51236 E	Feed Crank Link			(21212)
		for 10, 12, 16 gauge	1	51236 F	Feed Crank Link	1	51294 P	Oil Tube Clamp
		51600 BA (22561)			Ferrule for 51236 E	1	51294 R	Scr. for 51294P(7947)
1	23253 F	Attachment, lower,	1	51236 G	Feed Crank Stud	1	51294 U	Oil Siphon Assembly
		for 10, 12, 16 gauge			(20, 82, 269)			(22729 A, 22729 B)
		51600 BA (25 C)	1	51240 D	Looper Connecting	1	51301 D	Cloth Plate for
1	23253 Y	Attachment, upper,			Rod (18, 269)			51600BA (80, 22839C)
		for 8 gauge 51600 BA	1	51241 K	Looper Connecting	1	51382 A	Gasket for 53782 B
		(22561)			Rod and Ball Joint,	1	51401 M	Cloth Plate for
1	23253 Z	Attachment, lower,			right (12538)			51400 BC (80, 22839C)
		for 8 gauge 51600 BA	2	51242 L	Thrust Washer for	1	51402	Cloth Plate Slide for
		(25 C)			51242 P			51400 BC
1	29066 R	Needle Lever Con-	1	51242 M	Washer for 22852 A	1	51405 AC-12	Main Feed Dog for
		necting Rod Ball	1	51242 M	Washer for 52841 G			51400 BC (22593)
		Joint Assembly,	1	51242 P	Looper Drive Lever	1	51408-12	Looper, front, for
		upper (22559 G)			Shaft (51242 L)			12 gauge 51400 BC
1	29105 AA	Looper Drive Lever	1	51242 R	Looper Drive Lever			(73)
		Eccentric Assembly			Shaft Bushing, middle	1	51408-16	Looper, front, for
1	29192 A	Looper Rocker	1	51242 S	Looper Drive Lever			16 gauge 51400 BC
		Assembly			Shaft Bushing, rear			(73)
1	29348 P	Needle Lever	1	51242 W	Looper Drive Lever	1	51409	Looper, back, for
		Assembly			(22811 B, 22894 H)			51400 BC (73)
1	29476 AR	Feed Lift Assembly,	1	51242 Y	Looper Drive Lever	1	51413	Looper Rocker for
		.080 inch throw			Rocker (81, 22852 A)			29192 A
1	29476 BJ	Looper Avoid	1	51242 Z	Looper Drive Lever	1	51417 C-8	Needle Bar for 10
		Assembly, .062 inch			Shaft Bushing, front			gauge 51600 BA
		throw	1	51243 C	Ball Stud Fork for	1	51417 C-12	Needle Bar for 12
1	29476 FG	Cranksaft Assembly			29105 AA (22729)			gauge 51400 BC
		.770 inch throw	1	51244	Looper Rocker	1	51417 C-16	Needle Bar for 16
4	35178 D	Spring for 666-65,			Frame (96, 98)			gauge 51400 BC
		666-114	1	51244 B	Looper Rocker Shaft	1	51418-16	Needle Holder (89, 98)
2	35731 A	Presser Bar Con-			Arm (22519 H)	1	51420 AC-12	Presser Foot for 12
		nection Guide Plate	2	51244 L	Thrust Washer for			gauge 51400 BC
		(22513)			51144	1	51420 AC-16	Presser Foot for 16
3	35772 H	Washer for 51281 AC	1	51244 N	Looper Rocker Shaft			gauge 51400 BC
1	39236	Regulating Screw			Clamp Collar	1	51422	Main Shaft
		Sliding Block	1	51246	Nut for 51745	1	51423 B	Take-up (96, 22580D)
1	39236 T	Diff. Feed Driving	1	51247	Main Shaft Counter-	1	51424 AC-12	Throat Plate
		Link (22868 A)			weight (22894 J)			for 12 gauge
1	39237	Diff. Feed Bar Guide	1	51250 A	Bushing for 51215 J			51400 BC
		(22565 C)	1	51250 D	Washer for 22586 R			(22570)

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51424 AC-16	Throat Plate for 16 gauge 51400 BC (22570)	1	51617 B-8	Needle Bar for 8 gauge 51600 BA	1	52883 R	Presser Foot Lifter Lever Bushing
1	51425 AC	Needle Guard for 51400 BC (22519 J)	1	51617 B-12	Needle Bar for 12 gauge 51600 BA	1	52883 S	Presser Foot Lifter Lever Bell Crank Spring
1	51426 AC	Diff. Feed Dog for 51400 BC (90)	1	51617 B-16	Needle Bar for 16 gauge 51600 BA	2	52890 C	Main Shaft Bushing, left and inner right
1	51430 AC-12	Bottom, for presser foot 51420 AC-12	1	51625	Needle Guard for 51600 BA (22519 J)	1	52891 B	Crankshaft Bushing Housing, including bushing (22569 B)
1	51430 AD	Plunger Spring for presser foot 51420 AC-12, -16	1	51745	Looper Rocker Cone Stud for 29192 A (51246)	3	52894 AB	Oil Tube Holder (90)
1	51430 AE	Plunger Pin for presser foot 51420 AC-12, -16	1	51758	Frame Needle Thread Eyelet (20, 22848, 22889 A)	1	52894 AC	Oil Tube for feed lift and looper avoid eccentric
1	51435	Diff. Feed Control Lever, rear (20, 9937)	2	51959 B	Looper Thread Nipper Disc	1	52894 AD	Oil Tube for diff. feed bar shaft
1	51435 B	Control Lever Bushing (22597 A)	1	51959 D	Looper Thread Nipper Nut	1	52894 AE	Oil Tube for diff. feed bar guide
1	51444-12	Stripper Blade for 12 gauge 51400 BC (22704)	1	51959 K	Looper Thread Nipper Spring	1	52894 AK	Oil Tube for looper rocker and left ball joint (22560 B)
1	51444-16	Stripper Blade for 16 gauge 51400 BC (22704)	1	52804 A	Cast-off Wire (28)	1	52894 AM	Oil Tube for looper rocker ball joint, right (258A, 6042A)
1	51457 A	Cast-off Wire Support (50-216 Blk., 21657 E, 22528)	1	52834	Main Feed Bar (22560 B, 22747)	1	52925 D	Needle Guard Holder
1	51459 A	Looper Thread Tension Post Thread Guide	1	52835 H	Diff. Feed Bar	2	52936	Feed Rocker Shaft Bushing
1	51480 A	Throat Plate Support for 51400 BC (22839)	1	52835 G	Control Lever Link (22758 B)	1	52944 T	Looper Rocker Shaft Bushing, left
1	51480 C	Throat Plate Support for 51600 BA (22839)	1	52835 K	Diff. Control Lever Spring (61267 G)	1	52944 U	Looper Rocker Shaft Bushing, right
4	51491 C	Lead-in Thread Eyelet	1	52835 N	Control Lever Stop Plate (22848)	1	53782 B	Oil Reservoir Top Cover (22524, 22585 A)
1	51492	Looper Thread Tension Post	1	52835 Q	Intermediate Diff. Feed Fork (22758 B)	1	53783 A	Lifter Lever Link (402, 22758 C)
1	51493 D	Oil Pump Driving Shaft	1	52835 S	Diff. Feed Fork Block	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
2	51493 E	Oil Pump Driving Shaft Gear	1	52835 U	Pivot Stud Insert (719, 22597 A)	1	53783 M	Presser Foot Lifter Lever Connecting Rod
1	51493 AG	Oil Pump Housing	1	52836	Feed Rocker (22894 P)	1	53783 N	Presser Foot Lifter Lever, internal
1	51493 AH	Oil Pump Housing Cover (22569 B)	1	52836 C	Feed Rocker Arm (22519 C, 51235 G)	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
1	51493 BK	Lint Filter Screen	1	52836 H	Feed Rocker Segment Slot Plate (22516)	1	55244 G	Looper Rocker Rock Shaft Collar Stud (18, 51216 N)
1	51493 BP	Oil Pump Driving Gear (22560 B)	1	52841 G	Looper Lever Locking Stud (51242 M, 52841 G)	1	56341 G	Spring for 51241 K
1	51493 BQ	Oil Pump Driven Gear (531)	1	52841 J	Nut for 52841 G	1	56356	Presser Spring Reg.
1	51608 A-8	Looper, front, for 8 gauge 51600 BA (73)	1	52853	Feed Dog Holder (22519 J)	1	56382 X	Tension Post Supp.
1	51608 A-12	Looper, front, for 12 gauge 51600 BA (73)	1	52882 L	Oil Reservoir Back Cover (22733 B, 22848)	1	56390 E	Gasket for 52891 B
1	51608 A-16	Looper, front, for 16 gauge 51600 BA (73)	1	52882 M	Gasket for 52882 L	1	56458	Needle Lever Thread Eyelet (22768)
1	51609 A	Looper, back, for 51600 BA (73, 21210 A)	1	52882 P	Gasket for 52882 AD	1	56458 A	Needle Bar Thread Eyelet (27-435 Blk., 22768)
			1	52882 U	Gasket for 52882 AE	1	61267 G	Spring Pin for 52835 K
			1	52882 Y	Baffle Plate (90)			
			1	52882 AA	Drip Plate for 52882 AD (90)			
			1	52882 AC	Torsion Spring for 52882 AD			
			1	52882 AD	Crank Chamber Cover (22541 B)			
			1	52882 AE	Crank Chamber Cover, lower (22548)			

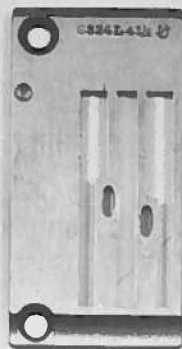
NOTE: Numbers in parenthesis following parts' description indicate the screws, nuts, etc., used to attach these parts.



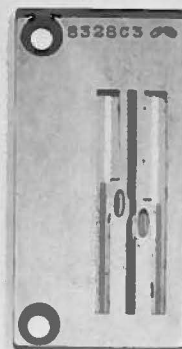
8324 L-2



8324 L-4



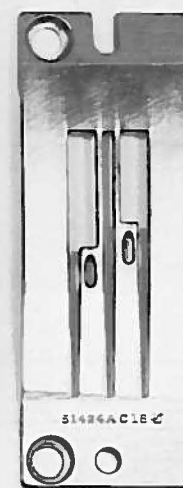
8324 L-4 1/2



8328 C-3



51424 AC-12



51424 AC-16



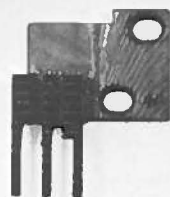
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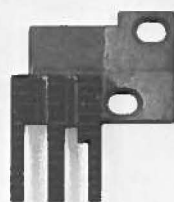
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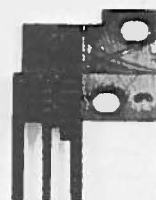
15105 B



8305 N



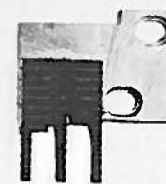
8305 L



8305 S



22593



51405 AC-12



15226 B



8326 A



8326



8326 G



90



51426 AC

23253 B
23253 Y



22561

22765 (Incl.)



51420 AC-12

51420 AC-16

91 (Incl.)

28 C (Adj. Screw for 8344)



8344



51409

9420 C-2

9420 C-3

9420 C-4

9420 C-4 1/2



187 A



51609 A



51408-12



51408-16



21210 A



51608 A-8



51608 A-12



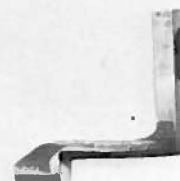
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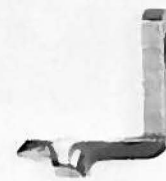
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52925 D



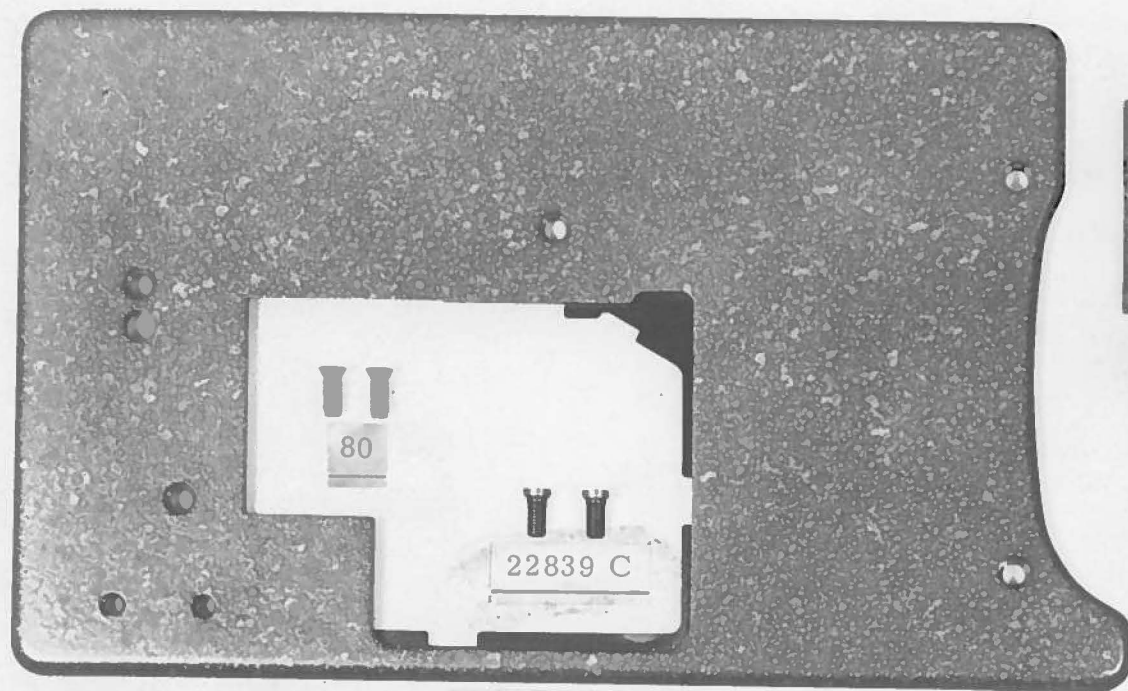
51425 AC



51625



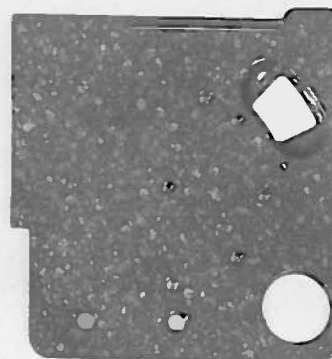
22519 J



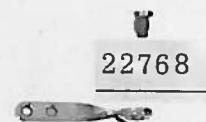
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22839 C

51301 D



51281 T-219



22768

56458 A

27-435 Blk.



51281 AC

22845 B



25 C



23425 V



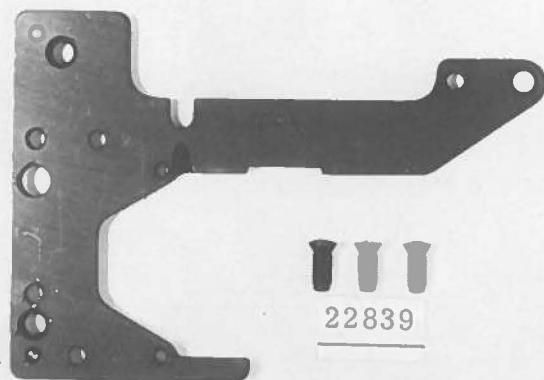
22760 A

35772 H

51417 C-8
51617 B-8
51617 B-12
51617 B-16



50 J-16



51480 C

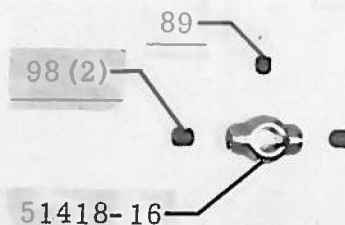


22839



23235 F

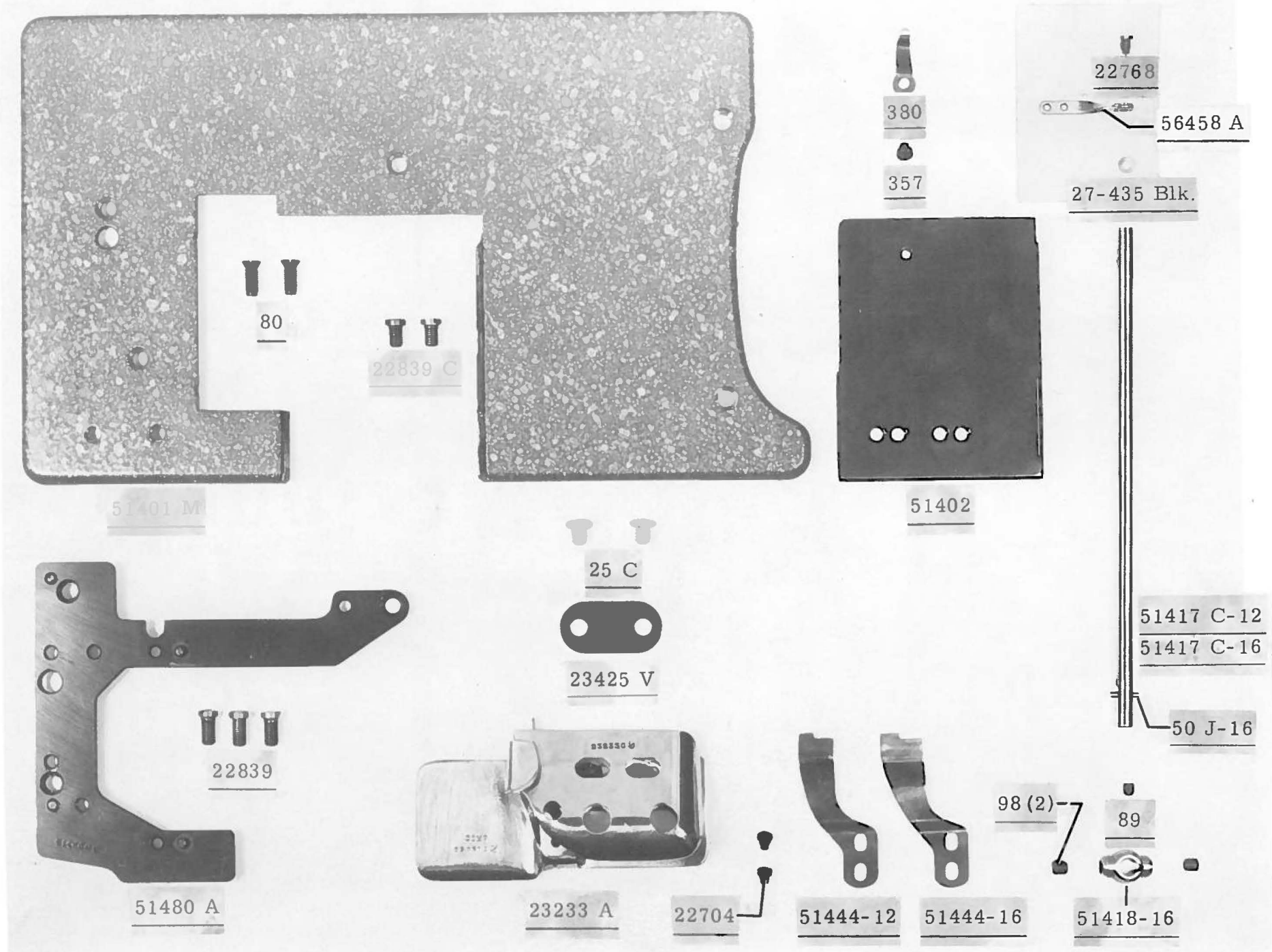
23235 Z

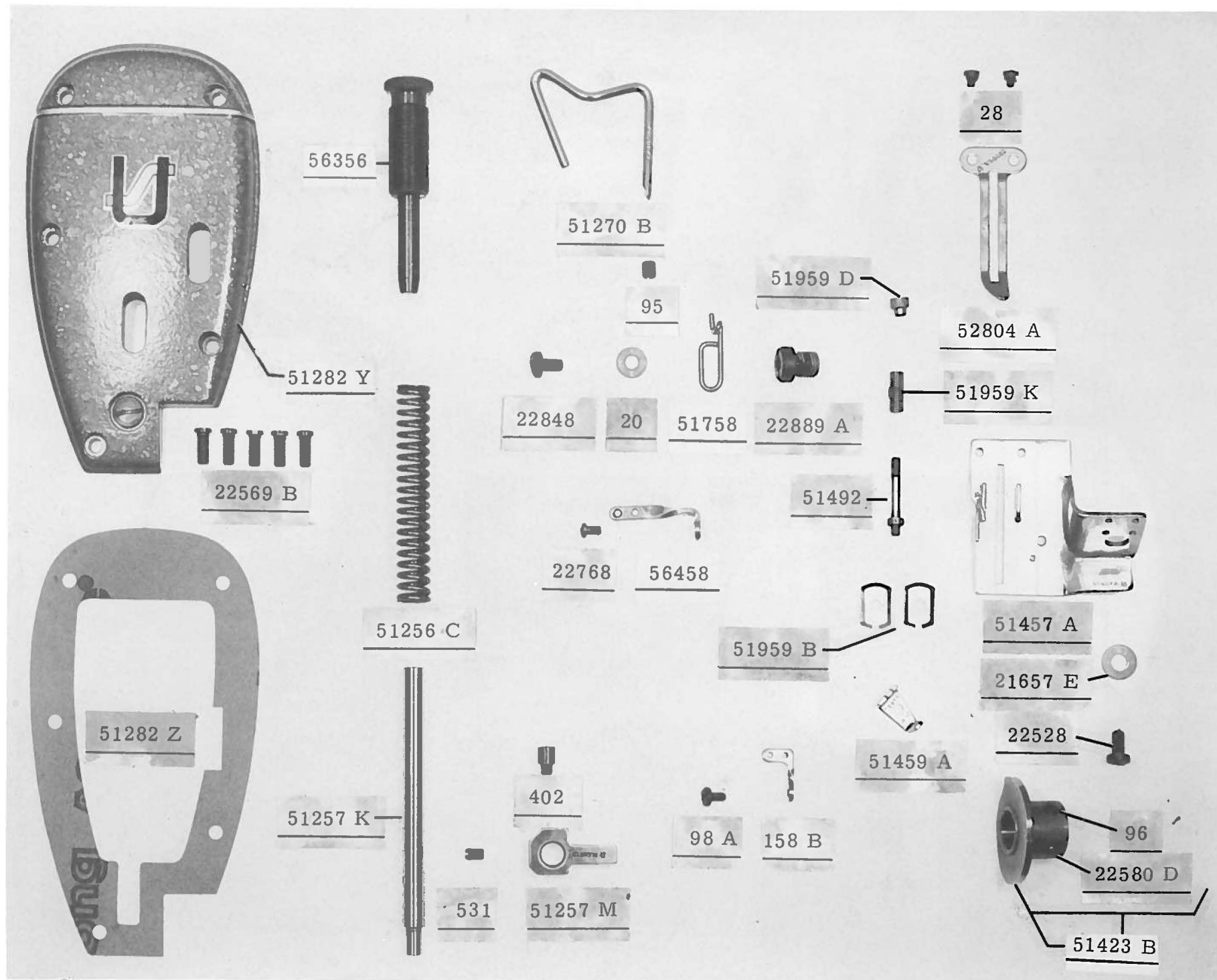


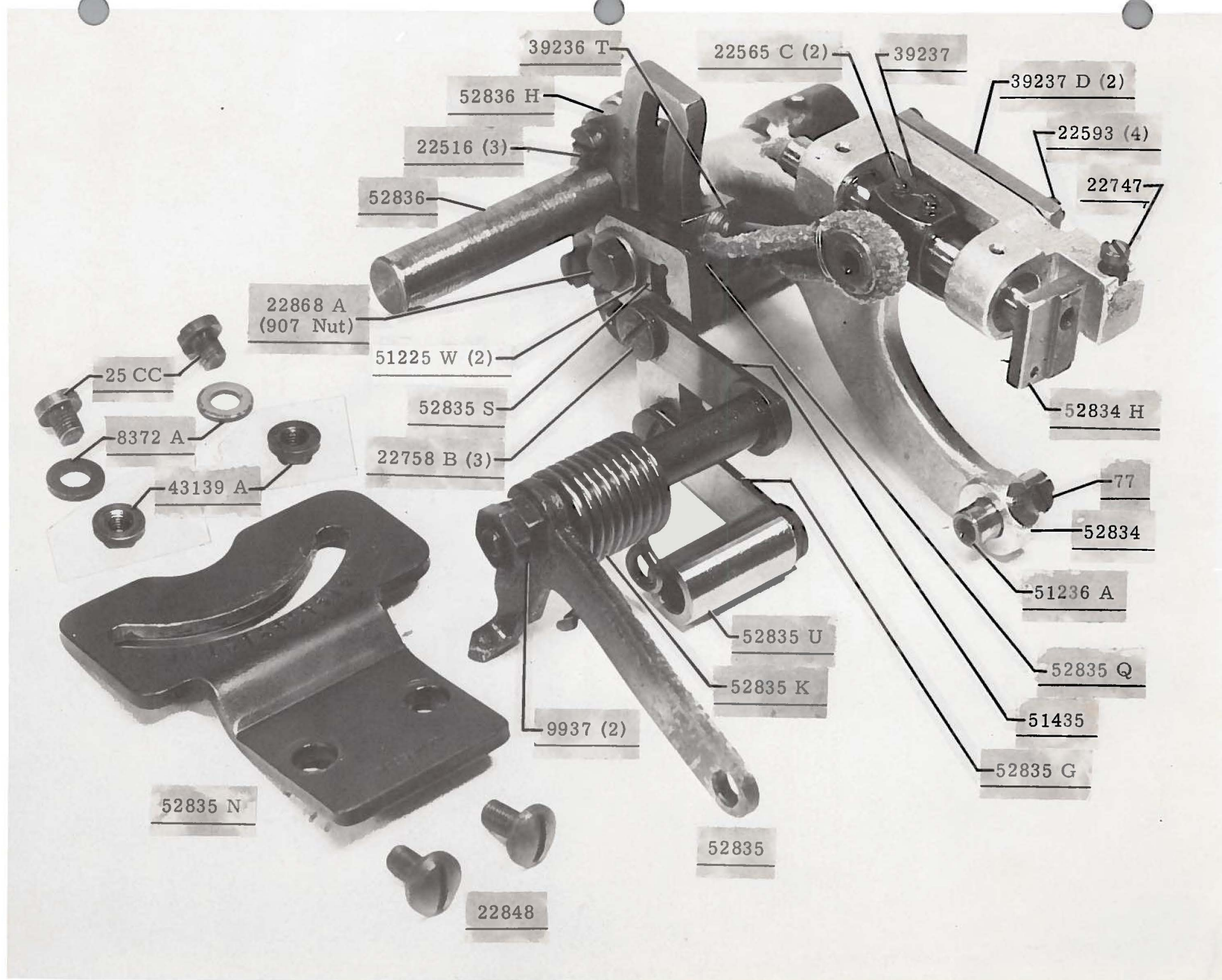
98 (2)

51418-16

89









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