



*Union Special*<sup>®</sup>  
LEWIS<sup>®</sup> • COLUMBIA<sup>®</sup>

INDUSTRIAL  
SEWING  
MACHINES

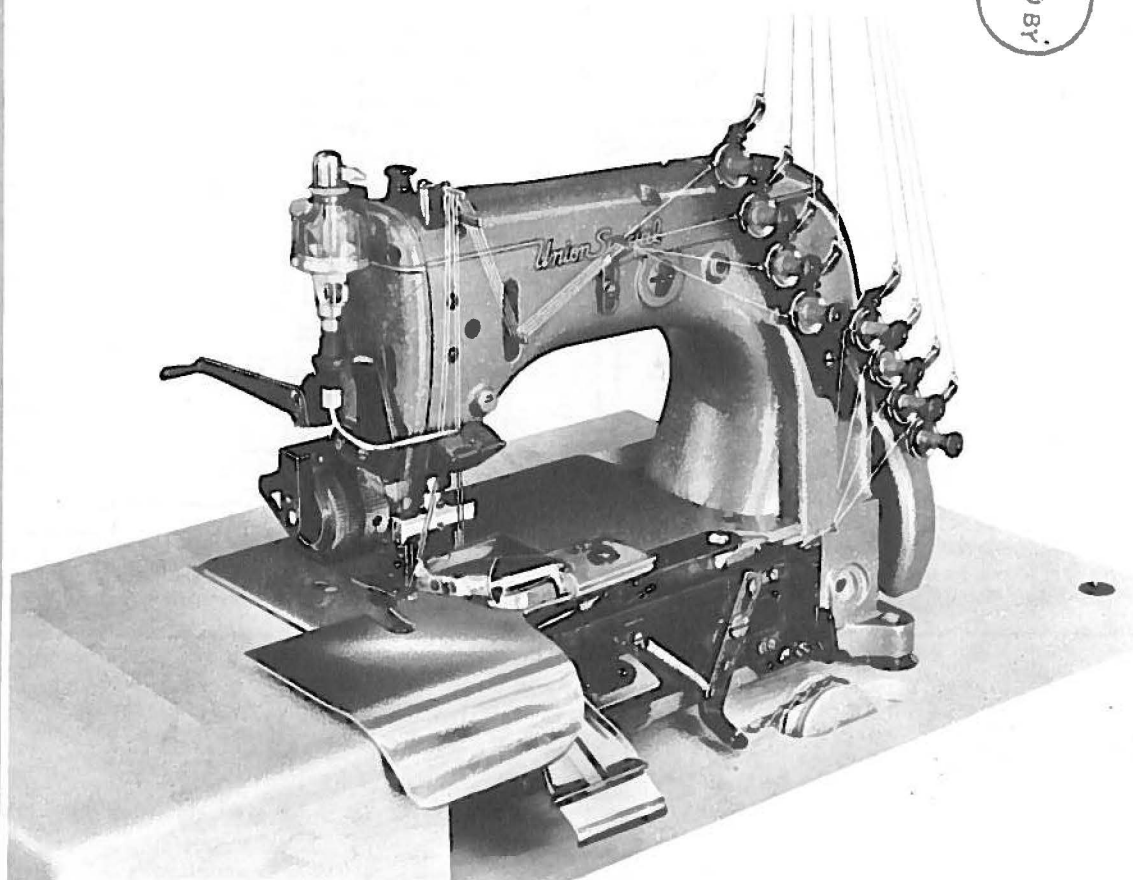


**CLASSES**

51400

51700

51800



STYLE 51800BA

**STREAMLINED**

**FIFTY THOUSAND SERIES**

**CLOSE COUPLED PULLER**

**CATALOG**

No.

104R

***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 refiled.

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.

**Union Special**  
FINEST QUALITY

## Style 51400 BE-16

### Suggested Minimum Spare Parts List\*

| Part Number   | Description                  | Minimum Quantity Per 5 Machines | Part Number | Description                  | Minimum Quantity Per 5 Machines |
|---------------|------------------------------|---------------------------------|-------------|------------------------------|---------------------------------|
| 7420 AG-4-1/2 | Presser foot                 | 1                               | 98          | Needle set screws            | 4                               |
| 22799 E       | Hinge screw for presser foot | 2                               | 51476 A     | Lower feed roller (Bakelite) | 1                               |
| 91            | Clamp screw for presser foot | 2                               | 51475 A     | Upper feed roller (Bakelite) | 1                               |
| 7405 U-4-1/2  | Feed Dog                     | 1                               | 51408-16    | Front looper                 | 1                               |
| 22528         | Screws for feed dog          | 2                               | 51409       | Back looper                  | 1                               |
| 7528 H-4-1/2  | Throat plate                 | 1                               | 73          | Looper set screws            | 4                               |
| 87            | Screws for throat plate      | 4                               | 21225-1/8   | Looper gauge                 | 1                               |
| 106 GS        | Needles (specify size)       | 200                             | 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 R

LIST OF PARTS

Classes

|       |       |       |
|-------|-------|-------|
| 51400 | 51700 | 51800 |
|-------|-------|-------|

Styles

|          |          |
|----------|----------|
| 51400 BE | 51800 BA |
| 51700 BU | 51800 BB |

First Edition

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**UNION SPECIAL CORPORATION**

INDUSTRIAL SEWING MACHINES

**CHICAGO**

Printed in U.S.A.

January, 1979



## FOREWORD

The 50000 series streamlined close-coupled puller machines covered by this catalog represent the latest design of the UNION SPECIAL flat bed line. Light weight needle bars and driving mechanisms and light weight presser bars make it possible to attain the utmost in speed and production. The new light weight parts and needle bearings make them lighter running and smoother operating. The light weight presser bar mechanism reduces pressure required to lift the foot. The clutch mechanism for the close-coupled puller is housed in the upper roller, to insure a uniformly controlled feeding. All parts are made by precision methods insuring complete interchangeability.

Automatic lubrication and a new filter type oil return pump, used in conjunction with isolated mounting oil pan base plate, for returning filtered oil to the main reservoir has made maintenance simple.

It is our constant aim to furnish carefully prepared information which will enable our customers 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 in this catalog.

Union Special representatives will be found in all manufacturing centers, ready to cooperate with you to plan and estimate requirements.

**UNION SPECIAL CORPORATION**

Engineering Department



## 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. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 51800 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 51800 BAZ".

The distance between the rows of stitches or between needles is represented by a gauge number measured in 1/64ths of an inch, going from left to right. Thus, 16-64-16 gauge represents a distance of 16/64 or 1/4 inch between 1st (extreme left) and 2nd needles, a distance of 64/64 or 1 inch between 2nd and 3rd needles, and finally, a distance of 16/64 or 1/4 inch between 3rd and 4th needles. This would also indicate a four needle machine.

## APPLICATION OF CATALOG

This catalog applies specifically to the standard Style of machines as listed herein. It can also be applied with discretion to some Special machines in Classes 51400, 51700, 51800. References to direction such as right, left, front, back, etc., are taken from the operator's position while seated at the machine. Operating direction of handwheel is toward the operator.

### STYLE OF MACHINE IN CLASS 51400

Streamlined Flat Bed, Two Needle, Left Needle in Front, Independent Row, Low Throw, Close-Coupled Puller With Clutch in Upper Feed Roller, Double Disc Take-up, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump and Oil Siphon Assembly, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 7 3/4 Inches.

51400 BE For hemming and simultaneously inserting elastic in tops and legs of knitted undergarments and for similar operations on light to medium weight materials. Seam specification 401-EFg-2. Type 106 GS needle. Standard gauges Nos. 16, 18, 24.

### STYLE OF MACHINE IN CLASS 51700

Streamlined Flat Bed, Two Needle, Needles Abreast, Independent Row, High Throw, Close-Coupled Puller With Clutch in Upper Feed Roller and Tilttable Lower Feed Roller, Single Disc Take-up, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump and Oil Siphon Assembly, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 7 3/4 Inches.

51700 BU For attaching waistband strips to dungarees, service pants, work trousers and for similar operations on medium heavy to heavy weight material. Strips guided next to feed dog. Seam specification 401-LSk-2. Type 128 GAS needle. Standard gauge No. 96 only.

### STYLES OF MACHINES IN CLASS 51800

Streamlined Flat Bed, Four Needles, Left Needle in Front for Each Pair of Needles, Independent Row, High Throw, Close-Coupled Puller With Clutch in Upper Feed Roller, Single Disc Take-up, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump and Oil Siphon Assembly, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 7 3/4 Inches.

## STYLES OF MACHINES IN CLASS 51800 (Continued)

51800 BA For attaching bibs to overalls and for similar operations on medium heavy to heavy weight sanforized and non-sanforized materials. Strips used in long lengths guided next to feed dog. Floor treadle controlled strip collapsing mechanism. Knee press for raising presser foot. Seam specification 401-LS1-4. Type 130 GS needle. Standard gauges Nos. 12-56-12, 12-64-12, 16-64-16, 16-76-16.

51800 BB Same as 51800 BA, except it is not equipped with strip collapsing mechanism and has a floor treadle for raising the presser foot.

### NEEDLES

Each UNION SPECIAL needle has both a type number and 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 blade, measured in thousandths of an inch, midway between the shank and the eye. Collectively, the type number and the size number is the complete symbol.

To have orders promptly and accurately filled, forward the empty package, a sample needle, or the type and size number should be given. See description on packages. A complete order would read as follows: "1000 Needles, Type 106 GHS-080/032".

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 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.                               |
| 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, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060. |

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

### ORDERING REPAIR PARTS

### ILLUSTRATIONS

This catalog has been arranged to simplify ordering repair parts. Exploded views of 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 a listing of the parts with their parts numbers, descriptions and the number of pieces required in the particular view being shown.



## ORDERING REPAIR PARTS (Continued)

Numbers in the first column are reference numbers only, and merely indicate the position of that part in the illustration. Reference numbers should never be used in ordering parts. Always use the part number listed in the second column.

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. Example:

|    |          |                                             |   |
|----|----------|---------------------------------------------|---|
| 49 | 29105 AA | Looper Drive Lever Eccentric Assembly ----- | 1 |
| 50 | 22559 A  | Bearing Cap Screw, lower-----               | 2 |
| 51 | 22559 B  | Bearing Cap Screw, upper-----               | 2 |
| 52 | 22894 C  | Eccentric Set Screw -----                   | 4 |
| 53 | 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 is that replacement of these parts individually is not recommended, so the complete sub-assembly should be ordered.

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 description 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 this book. This 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 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 Corporation, 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, U S Emblem. 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

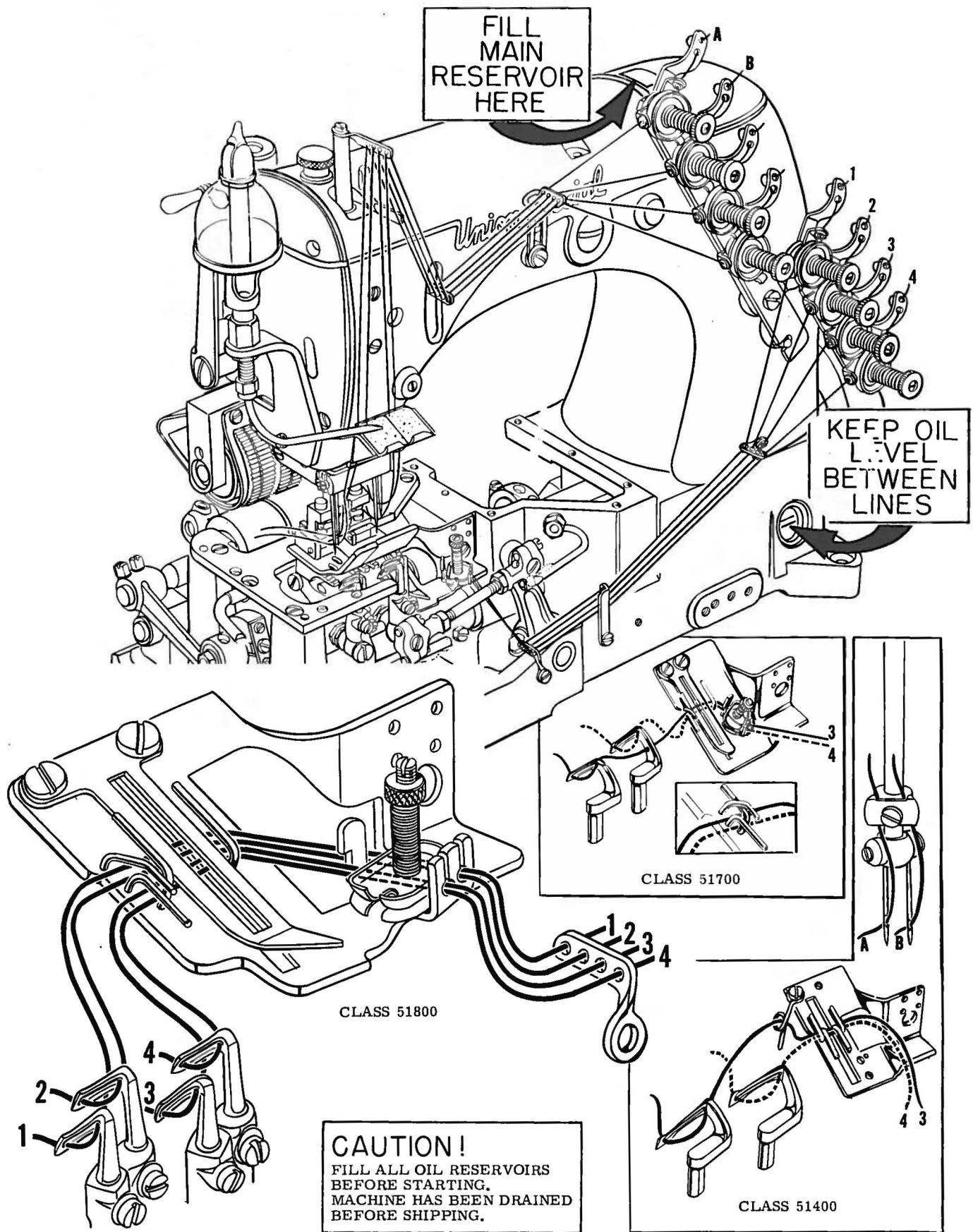
The oil has been drained from the machine before shipping and the reservoir must be filled before beginning to operate. Use a straight mineral oil with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit.

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 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 four needle machine is threaded. Two needle machines are threaded in substantially the same manner. The looper threading of the various classes is indicated in the inserts.



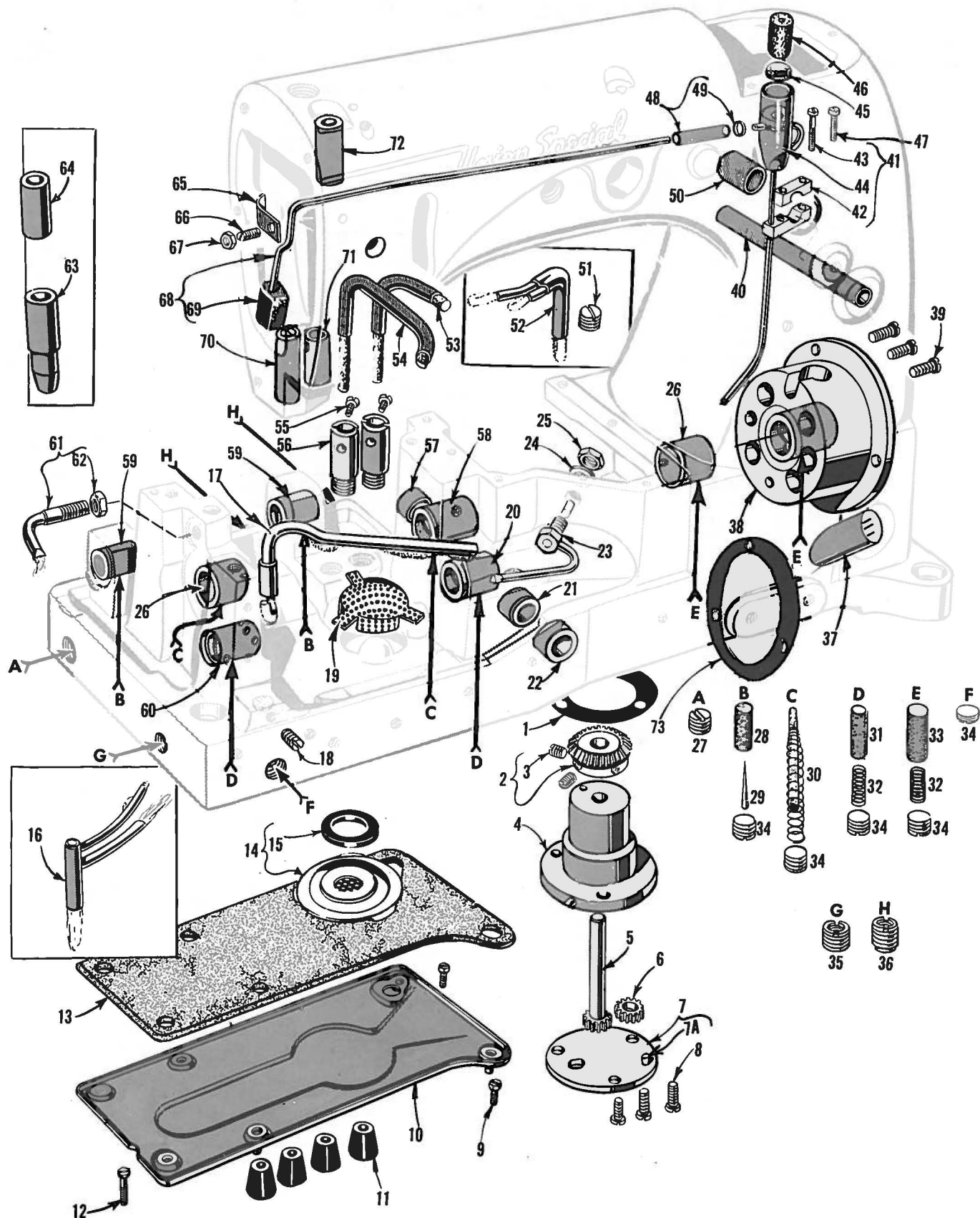




MAIN FRAME, MISCELLANEOUS COVERS AND PLATES

| Ref.<br>No. | Part<br>No. | Description                                                                 | Amt.<br>Req. |
|-------------|-------------|-----------------------------------------------------------------------------|--------------|
| 1           | 93          | Screw -----                                                                 | 2            |
| 2           | BB21375 AH  | Belt Guard -----                                                            | 1            |
| 3           | 98 A        | Screw -----                                                                 | 4            |
| 4           | 1068        | Thread Eyelet, for Style 51800 BA -----                                     | 2            |
|             | 1068        | Thread Eyelet, for Style 51800 BB -----                                     | 3            |
| 5           | 51291 A     | Looper Thread Guard -----                                                   | 1            |
| 6           | 158 B       | Thread Eyelet, for Styles 51400 BE, 51700 BU -----                          | 3            |
| 7           | 51859 B     | Thread Eyelet, for Style 51800 BA -----                                     | 1            |
| 8           | 51482 A     | Cloth Guard, for Style 51400 BE -----                                       | 1            |
| 9           | 25 S        | Screw, for Style 51400 BE -----                                             | 2            |
| 10          | 51282 Y     | Head Cover, for Styles 51400 BE, 51700 BU -----                             | 1            |
| 11          | 22542       | Screw -----                                                                 | 1            |
| 12          | 52882 W     | Washer -----                                                                | 1            |
| 13          | 51282 AC    | Felt Liner -----                                                            | 1            |
| 14          | 22799 M     | Screw, for strip collapsing device mounting bracket on Style 51800 BA ----- | 1            |
| 15          | 22848       | Screw -----                                                                 | 3            |
| 16          | 20          | Washer -----                                                                | 3            |
| 17          | 51282 AH    | Oil Shield -----                                                            | 1            |
| 18          | 22541       | Screw, for Styles 51800 BA, BB -----                                        | 2            |
| 19          | 21396 BP    | Needle Thread Lubricator, for Styles 51800 BA, BB -----                     | 1            |
| 19A         | 21396 AG    | Felt Pad -----                                                              | 2            |
| 20          | 51782 A     | Head Cover, for Styles 51800 BA, BB -----                                   | 1            |
| 21          | 22542       | Screw -----                                                                 | 1            |
| 22          | 52882 W     | Washer -----                                                                | 1            |
| 23          | 51282 AC    | Gasket -----                                                                | 1            |
| 24          | 51282 Z     | Gasket -----                                                                | 1            |
| 25          | 21396 BJ    | Thread Oiler, for Styles 51800 BA, BB -----                                 | 1            |
| 26          | 660-75      | Coupling -----                                                              | 1            |
| 27          | 660-74      | Sleeve -----                                                                | 1            |
| 28          | 11638 M     | Nut -----                                                                   | 1            |
| 29          | 61394 V     | Adapter -----                                                               | 1            |
| 30          | 666-79      | Oiler -----                                                                 | 1            |
| 31          | 21396 BK    | Thread Oiler Bracket, for Styles 51800 BA, BB -----                         | 1            |
| 32          | 22569 B     | Screw -----                                                                 | 5            |
| 33          | 51270       | Take-up Wire, for Styles 51400 BE, 51700 BU -----                           | 1            |
| 34          | 35731 A     | Presser Bar Connection Guide Plate -----                                    | 2            |
| 35          | 22513       | Screw -----                                                                 | 3            |
| 36          | 51454 A     | Needle Bar Guide Block, for Styles 51700 BU, 51800 BA, BB -----             | 1            |
| 37          | 22849       | Screw, for Styles 51700 BU, 51800 BA, BB -----                              | 2            |
| 38          | 95          | Screw -----                                                                 | 2            |
| 39          | 51870       | Take-up Wire, for Style 51800 BA, BB -----                                  | 1            |
| 40          | 51758       | Frame Needle Thread Eyelet, for Styles 51400 BE, 51700 BU -----             | 1            |
| 41          | 22889 A     | Adapter Screw -----                                                         | 1            |
| 42          | 51858       | Frame Needle Thread Eyelet, for Style 51800 BA, BB -----                    | 1            |
| 43          | 20          | Washer -----                                                                | 1            |
| 44          | 22848       | Screw -----                                                                 | 1            |
| 45          | 56382 AC    | Needle Lever Bearing Oiler and Baffle Plate, for Style 51400 BE -----       | 1            |
| 45A         | 52882 Y     | Baffle Plate, for Styles 51700 BU, 51800 BA, BB -----                       | 1            |
| 46          | 51282 AE    | Needle Lever Bearing Oiler, for Styles 51700 BU, 51800 BA, BB -----         | 1            |
| 47          | 90          | Screw -----                                                                 | 2            |
| 48          | 52882 P     | Crank Chamber Cover Gasket -----                                            | 1            |
| 49          | 52882 AD    | Crank Chamber Cover, upper -----                                            | 1            |
| 50          | 90          | Screw -----                                                                 | 2            |
| 51          | 52882 AA    | Oil Drip Plate -----                                                        | 1            |
| 52          | 50-789 Blk  | Pin -----                                                                   | 1            |
| 53          | 52882 AC    | Spring -----                                                                | 1            |
| 54          | 39582 L     | Oil Cap -----                                                               | 1            |
| 55          | 22541 B     | Screw -----                                                                 | 3            |
| 56          |             | Cloth Plate (See Page 27) -----                                             | 1            |
| 57          |             | Cloth Plate Cover (See Page 27) -----                                       | 1            |
| 58          | 52882 AE    | Crank Chamber Cover, lower -----                                            | 1            |
| 59          | 52882 U     | Gasket -----                                                                | 1            |
| 60          | 22548       | Screw -----                                                                 | 4            |
| 61          | 22848       | Screw -----                                                                 | 9            |
| 62          | 52882 M     | Gasket -----                                                                | 1            |
| 63          | 52882 L     | Oil Reservoir Back Cover -----                                              | 1            |
| 64          | 41394 A     | Gasket -----                                                                | 2            |
| 65          | 22733 B     | Plug Screw -----                                                            | 1            |
| 66          | 22839       | Screw -----                                                                 | 1            |
| 67          |             | Throat Plate (See Pages 29, 31) -----                                       | 1            |
| 68          | 87          | Screw, for throat plate -----                                               | 2            |
| 69          | 22585 A     | Screw -----                                                                 | 2            |
| 70          | 22524       | Screw -----                                                                 | 7            |
| 71          | 53782 B     | Oil Reservoir Top Cover -----                                               | 1            |
| 72          | 51382 A     | Gasket -----                                                                | 1            |
| 73          | 80          | Screw, for cloth plate -----                                                | 3            |
| 74          | 22839 C     | Screw, for cloth plate -----                                                | 2            |

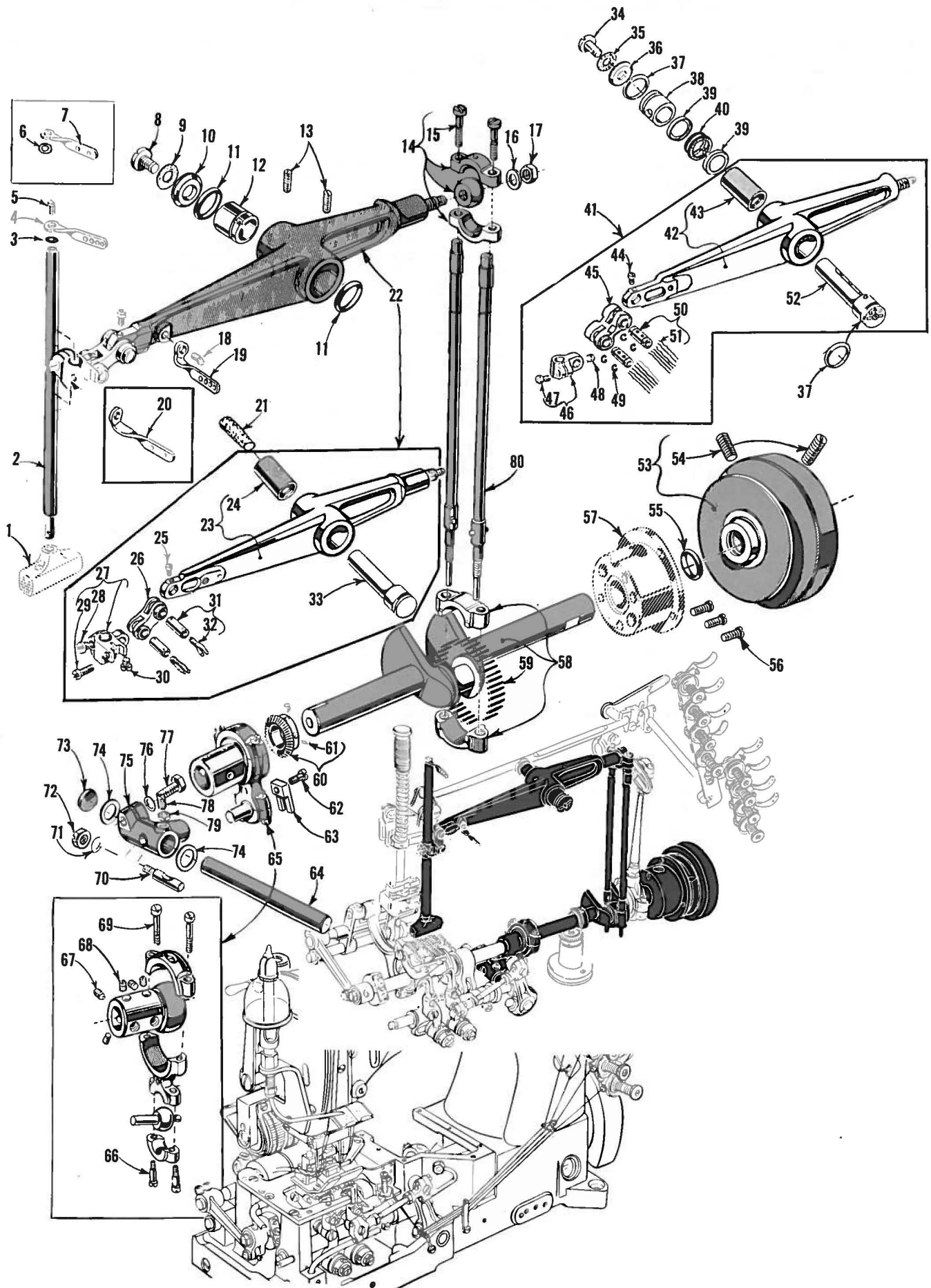




MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                                                   | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|--------------------------------------------------------------------------------------|----------------------|
| 1                   | 643-127             | Gasket -----                                                                         | 1                    |
| 2                   | 51493 BQ            | Oil Pump Driven Gear -----                                                           | 1                    |
| 3                   | 531                 | Screw -----                                                                          | 2                    |
| 4                   | 51493 AG            | Oil Pump Housing -----                                                               | 1                    |
| 5                   | 51493 D             | Oil Pump Driving Shaft -----                                                         | 1                    |
| 6                   | 51493 E             | Oil Pump Driving Shaft Gear -----                                                    | 2                    |
| 7                   | 51493 AH            | Oil Pump Housing Cover -----                                                         | 1                    |
| 7A                  | 50-294 Blk          | Pin -----                                                                            | 1                    |
| 8                   | 22569 B             | Screw -----                                                                          | 3                    |
| 9                   | 22823 A             | Screw -----                                                                          | 2                    |
| 10                  | 51493 AY            | Base Plate, for Style 51800 BB -----                                                 | 1                    |
|                     | 51493 BA            | Base Plate, for Styles 51400 BE, 51700 BU -----                                      | 1                    |
|                     | 51493 BD            | Base Plate, for Style 51800 BA -----                                                 | 1                    |
| 11                  | 51295 A             | Mounting Isolator -----                                                              | 4                    |
| 12                  | 22823 B             | Screw -----                                                                          | 1                    |
| 13                  | 51493 BG            | Base Plate Felt -----                                                                | 1                    |
| 14                  | 51493 BH            | Filter Cap Assembly -----                                                            | 1                    |
| 15                  | 51493 BJ            | Washer, rubber -----                                                                 | 1                    |
| 16                  | 52894 AK            | Oil Tube, for looper rocker ball joint, left, on Style 51400 BE -----                | 1                    |
| 17                  | 51794 C             | Oil Tube, for looper rocker ball joint, left, on Styles 51700 BU, 51800 BA, BB ----- | 1                    |
| 18                  | 22560 B             | Screw -----                                                                          | 1                    |
| 19                  | 51493 BK            | Lint Filter Screen -----                                                             | 1                    |
| 20                  | 52944 U             | Looper Rock Shaft Bushing, right -----                                               | 1                    |
| 21                  | 51242 R             | Looper Drive Lever Shaft Bushing, middle -----                                       | 1                    |
| 22                  | 51242 Z             | Looper Drive Lever Shaft Bushing, front -----                                        | 1                    |
| 23                  | 52894 AM            | Oil Tube, for looper connecting rod ball joint, right -----                          | 1                    |
| 24                  | 6042 A              | Washer -----                                                                         | 1                    |
| 25                  | 258 A               | Nut -----                                                                            | 1                    |
| 26                  | 52890 C             | Main Shaft Bushing, left, inner right -----                                          | 2                    |
| 27                  | 22539 H             | Plug Screw -----                                                                     | 1                    |
| 28                  | 666-111             | Oil Wick -----                                                                       | 2                    |
| 29                  | 666-179             | Wedge Pin -----                                                                      | 2                    |
| 30                  | 666-118             | Oil Wick -----                                                                       | 2                    |
| 31                  | 666-65              | Oil Wick -----                                                                       | 2                    |
| 32                  | 35178 D             | Spring -----                                                                         | 4                    |
| 33                  | 666-114             | Oil Wick -----                                                                       | 2                    |
| 34                  | 22571 A             | Plug Screw -----                                                                     | 15                   |
| 35                  | 22889 D             | Adaptor Plug Screw -----                                                             | 1                    |
| 36                  | 22889 C             | Adaptor Plug Screw -----                                                             | 2                    |
| 37                  | 50-648 Blk          | Lucite Oil Gauge -----                                                               | 1                    |
| 38                  | 52891 B             | Crankshaft Bushing Housing, including bushing -----                                  | 1                    |
| 39                  | 22569 B             | Screw -----                                                                          | 3                    |
| 40                  | 21657 X             | Tension Release Lever Shaft Bushing -----                                            | 1                    |
| 41                  | 51294 U             | Oil Siphon Assembly -----                                                            | 1                    |
| 42                  | 51294 K             | Clamp, upper -----                                                                   | 1                    |
| 43                  | 22729 B             | Screw -----                                                                          | 1                    |
| 44                  | 643-263             | Siphon -----                                                                         | 1                    |
| 45                  | 666-209             | Felt Plug -----                                                                      | 1                    |
| 46                  | 666-201             | Felt Disc -----                                                                      | 1                    |
| 47                  | 22729 A             | Screw -----                                                                          | 1                    |
| 48                  | 51294 Z             | Oil Tube Connection -----                                                            | 1                    |
| 49                  | 21212               | Locking Ring, for oil siphon connection -----                                        | 1                    |
| 50                  | 52883 R             | Foot Lifter Lever Bushing -----                                                      | 1                    |
| 51                  | 22571 B             | Plug Screw, for Style 51400 BE -----                                                 | 1                    |
| 52                  | 52994 AC            | Oil Tube, for feed lift and looper avoid eccentric, on Style 51400 BE -----          | 1                    |
| 53                  | 51794 B             | Oil Tube, for looper avoid eccentric, on Styles 51700 BU, 51800 BA, BB -----         | 1                    |
| 54                  | 54293 A             | Oil Tube, for feed lift eccentric, on Styles 51700 BU, 51800 BA, BB -----            | 1                    |
| 55                  | 90                  | Screw, for Styles 51700 BU, 51800 BA, BB -----                                       | 2                    |
|                     | 90                  | Screw, for Style 51400 BE -----                                                      | 1                    |
| 56                  | 52894 AB            | Oil Tube Holder, for Styles 51700 BU, 51800 BA, BB -----                             | 2                    |
|                     | 52894 AB            | Oil Tube Holder, for Style 51400 BE -----                                            | 1                    |
| 57                  | 51242 S             | Looper Drive Lever Shaft Bushing, rear -----                                         | 1                    |
| 58                  | 51290 T             | Main Shaft Bushing, middle -----                                                     | 1                    |
| 59                  | 52936               | Feed Rocker Shaft Bushing -----                                                      | 2                    |
| 60                  | 52944 T             | Looper Rock Shaft Bushing, left -----                                                | 1                    |
| 61                  | 660-136             | Oil Tube, for feed crank link -----                                                  | 1                    |
| 62                  | 258 A               | Nut -----                                                                            | 1                    |
| 63                  | 51254 C             | Needle Bar Bushing, upper, for Style 51400 BE -----                                  | 1                    |
| 64                  | 51254 D             | Needle Bar Bushing, lower, for Style 51400 BE -----                                  | 1                    |
| 65                  | 51294 P             | Oil Tube Clamp -----                                                                 | 1                    |
| 66                  | 51294 R             | Screw -----                                                                          | 1                    |
| 67                  | 7947                | Nut -----                                                                            | 1                    |
| 68                  | 51294 M             | Oil Siphon Tube -----                                                                | 1                    |
| 69                  | 666-214             | Felt Lint Filter -----                                                               | 1                    |
| 70                  | 51257 AA            | Presser Bar Bushing, lower -----                                                     | 1                    |
| 71                  | 51854 E             | Needle Bar Bushing, lower, for Styles 51700 BU, 51800 BA, BB -----                   | 1                    |
| 72                  | 51854 F             | Needle Bar Bushing, upper, for Styles 51700 BU, 51800 BA, BB -----                   | 1                    |
| 73                  | 56390 E             | Bearing Housing Gasket -----                                                         | 1                    |





CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS

| Ref.<br>No. | Part<br>No. | Description                                                                   | Amt.<br>Req. |
|-------------|-------------|-------------------------------------------------------------------------------|--------------|
| 1           |             | Needle Holder (See Page 27) -----                                             | 1            |
| 2           |             | Needle Bar (See Page 27) -----                                                | 1            |
| 3           | 27-484 Blk  | Eyelet Lock Washer, for Styles 51700 BU, 51800 BA, BB -----                   | 1            |
| 4           | 54158 A     | Needle Bar Thread Eyelet, for Styles 51800 BA, BB -----                       | 1            |
| 5           | 22768       | Screw -----                                                                   | 1            |
| 6           | 27-435 Blk  | Eyelet Lock Washer, for Style 51400 BE -----                                  | 1            |
| 7           | 56458 A     | Needle Bar Thread Eyelet, for Styles 51400 BE, 51700 BU -----                 | 1            |
| 8           | 22586 R     | Screw -----                                                                   | 1            |
| 9           | 51250 F     | Gasket -----                                                                  | 1            |
| 10          | 51250 D     | Washer -----                                                                  | 1            |
| 11          | 660-212     | Oil Seal Ring -----                                                           | 2            |
| 12          | 51150       | Needle Lever Thrust Collar, for Styles 51700 BU, 51800 BA, BB -----           | 1            |
| 13          | 719         | Screw -----                                                                   | 2            |
| 14          | 29066 R     | Needle Lever Connecting Rod Ball Assembly -----                               | 1            |
| 15          | 22559 G     | Screw -----                                                                   | 2            |
| 16          | 51216 N     | Washer -----                                                                  | 1            |
| 17          | 51216 P     | Nut -----                                                                     | 1            |
| 18          | 22768       | Screw -----                                                                   | 1            |
| 19          | 54158       | Needle Lever Thread Eyelet, for Styles 51800 BA, BB -----                     | 1            |
| 20          | 56458       | Needle Lever Thread Eyelet, for Styles 51400 BE, 51700 BU -----               | 1            |
| *21         | 666-170     | Oil Wick, for needle lever stud -----                                         | 1            |
| 22          | 29348 S     | Needle Lever Assembly, for Styles 51700 BU, 51800 BA, BB -----                | 1            |
| 23          | 56315       | Needle Lever -----                                                            | 1            |
| 24          | 56350 B     | Needle Lever Bushing -----                                                    | 1            |
| 25          | 77          | Screw -----                                                                   | 1            |
| 26          | 56354 A     | Needle Bar Connecting Link -----                                              | 1            |
| 27          | 51454 B     | Needle Bar Connection -----                                                   | 1            |
| 28          | 22516 B     | Screw -----                                                                   | 1            |
| 29          | 75 C        | Screw -----                                                                   | 1            |
| 30          | 77          | Screw -----                                                                   | 1            |
| 31          | 51054       | Link Pin -----                                                                | 2            |
| 32          | 666-149     | Lubricating Felt -----                                                        | 1            |
| 33          | 56350 A     | Needle Lever Stud -----                                                       | 1            |
| 34          | 22586 R     | Screw -----                                                                   | 1            |
| 35          | 51250 F     | Gasket -----                                                                  | 1            |
| 36          | 51250 D     | Washer -----                                                                  | 1            |
| 37          | 660-212     | Oil Seal Ring -----                                                           | 2            |
| 38          | 56350 E     | Needle Lever Thrust Collar, for Style 51400 BE -----                          | 1            |
| 39          | 56350 F     | Thrust Washer, for Style 51400 BE -----                                       | 2            |
| 40          | 660-614     | Temper Load Ring, for Style 51400 BE -----                                    | 1            |
| 41          | 29348 AF    | Needle Lever Assembly, for Style 51400 BE -----                               | 1            |
| 42          | 56315 A     | Needle Lever -----                                                            | 1            |
| 43          | 56350 G     | Needle Lever Bushing -----                                                    | 1            |
| 44          | 77          | Screw -----                                                                   | 1            |
| 45          | 56354 D     | Needle Bar Connection Link -----                                              | 1            |
| 46          | 51254 K     | Needle Bar Connection -----                                                   | 1            |
| 47          | 22562 A     | Screw -----                                                                   | 1            |
| 48          | 22564       | Screw -----                                                                   | 1            |
| 49          | 660-215     | Retaining Ring -----                                                          | 4            |
| 50          | 52336 A     | Connecting Pin -----                                                          | 2            |
| 51          | WO-3        | Columbia Yarn (6 stands) -----                                                | -            |
| 52          | 56350 D     | Needle Lever Stud -----                                                       | 1            |
| 53          | 52921 B     | Handwheel, for No. "V" or round belt -----                                    | 1            |
| 54          | 22894 G     | Screw -----                                                                   | 2            |
| 55          | 660-202     | Oil Seal Ring -----                                                           | 1            |
| 56          | 22569 B     | Screw -----                                                                   | 3            |
| 57          | 52891 B     | Crankshaft Bushing Housing, including bushing -----                           | 1            |
| 58          | 29476 HE    | Crankshaft Assembly, .770 inch throw, for Style 51400 BE -----                | 1            |
| -           | 29476 HD    | Crankshaft Assembly, .990 inch throw, for Styles 51700 BU, 51800 BA, BB ----- | 1            |
| 59          | 51216 M     | Needle Bearing -----                                                          | 28           |
| 60          | 51493 BP    | Oil Pump Driving Gear -----                                                   | 1            |
| 61          | 22560 B     | Screw -----                                                                   | 2            |
| 62          | 22729       | Screw -----                                                                   | 1            |
| 63          | 51243 C     | Ball Stud Guide Fork -----                                                    | 1            |
| 64          | 51242 P     | Looper Drive Lever Shaft -----                                                | 1            |
| 65          | 29105 AA    | Looper Drive Lever Eccentric Assembly -----                                   | 1            |
| 66          | 22559 A     | Bearing Cap Screw, lower -----                                                | 2            |
| 67          | 22894 D     | Eccentric Spot Screw -----                                                    | 1            |
| 68          | 22894 C     | Eccentric Set Screw -----                                                     | 4            |
| 69          | 22559 B     | Bearing Cap Screw, upper -----                                                | 2            |
| 70          | 52841 G     | Locking Stud -----                                                            | 1            |
| 71          | 51242 M     | Washer -----                                                                  | 1            |
| 72          | 52841 J     | Nut -----                                                                     | 1            |
| 73          | 22883 A     | Plug Screw -----                                                              | 1            |
| 74          | 51242 L     | Thrust Washer -----                                                           | 2            |
| 75          | 51242 Y     | Looper Drive Lever Rocker -----                                               | 1            |
| 76          | 51242 M     | Washer -----                                                                  | 1            |
| 77          | 22852 A     | Clamp Screw -----                                                             | 1            |
| 78          | 81          | Spot Screw -----                                                              | 1            |
| 79          | 12982       | Lock Nut -----                                                                | 1            |
| 80          | 51216 G     | Needle Lever Connecting Rod -----                                             | 2            |

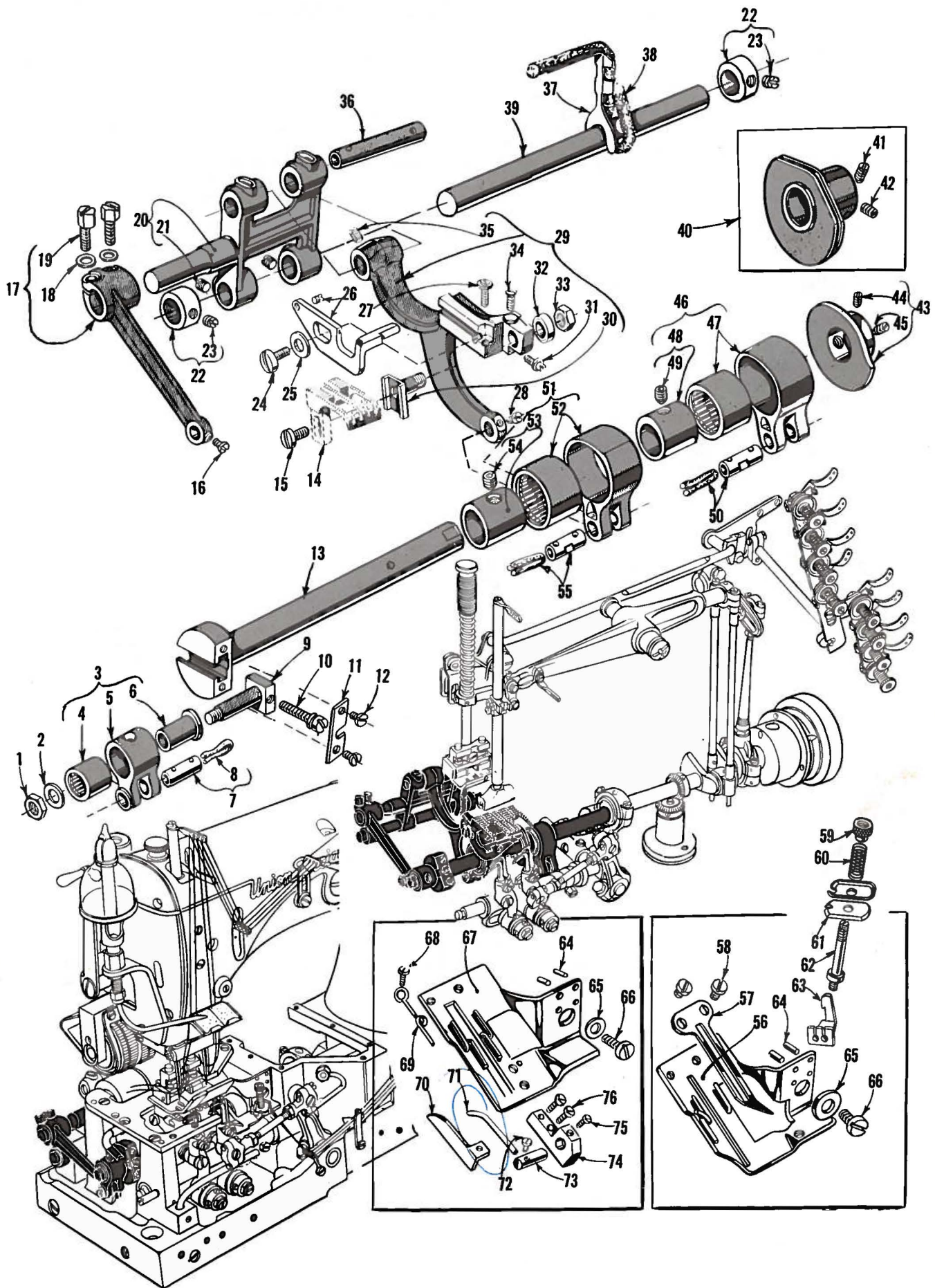




LOOPER ROCKER AND CONNECTING ROD PARTS

| Ref.<br>No. | Part<br>No. | Description                                                                    | Amt.<br>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 Ball Joint, right, for Style 51400 BE -----              | 1            |
| 6           | 56341 G     | Spring -----                                                                   | 1            |
| 7           | 50-458 Blk  | Pin -----                                                                      | 1            |
| 8           | 18          | Nut, right thread -----                                                        | 1            |
| 9           | 51240 E     | Looper Connecting Rod, for Style 51400 BE -----                                | 1            |
| 10          | 269         | Nut, left thread -----                                                         | 1            |
| 11          | 55241 N     | Looper Connecting Rod Ball Joint, left, for Style 51400 BE -----               | 1            |
| 12          | 29192 D     | Looper Rocker Assembly, for Style 51400 BE -----                               | 1            |
| 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          | 51513       | Looper Rocker -----                                                            | 1            |
| 18          | 51745       | Looper Rocker Cone Stud -----                                                  | 1            |
| 19          | 18          | Nut, for Style 51400 BE -----                                                  | 1            |
| 20          | 51244       | Looper Rocker Frame, for Style 51400 BE -----                                  | 1            |
| 21          | 51244 L     | Thrust Washer, for Style 51400 BE -----                                        | 2            |
|             | 51244 L     | Thrust Washer, for Styles 51700 BU, 51800 BA, BB -----                         | 1            |
| 22          | 51246       | Looper Rocker Stud Nut, for Style 51400 BE -----                               | 1            |
| 23          | 98          | Set Screw -----                                                                | 1            |
| 24          | 96          | Spot Screw -----                                                               | 1            |
| 25          | 22768       | Screw -----                                                                    | 1            |
| 26          | 51244 B     | Looper Rocker Shaft Arm -----                                                  | 1            |
| 27          | 22519 H     | Screw -----                                                                    | 1            |
| 28          | 51409       | Looper, back, for Style 51400 BE -----                                         | 1            |
| 29          | 51408-16    | Looper, front, for No. 16 gauge on Style 51400 BE -----                        | 1            |
| 30          | 51408-18    | Looper, front, for No. 18 gauge on Style 51400 BE -----                        | 1            |
| 31          | 51408-24    | Looper, front, for No. 24 gauge on Style 51400 BE -----                        | 1            |
| 32          | 51144       | Looper Rocker Rock Shaft -----                                                 | 1            |
| 33          | 73          | Screw, for No. 29192 K -----                                                   | 4            |
|             | 73          | Screw, for Nos. 29192 C, 29192 D -----                                         | 2            |
| 34          | 55244 G     | Locking Stud, for Style 51400 BE -----                                         | 1            |
| 35          | 51244 N     | Looper Rocker Shaft Clamp Collar, for Style 51400 BE -----                     | 1            |
| 36          | 52470       | Stop for Looper Connecting Rod, for Style 51400 BE -----                       | 1            |
| 37          | 51216 N     | Washer, for Style 51400 BE -----                                               | 1            |
| 38          | 18          | Nut, for Style 51400 BE -----                                                  | 1            |
| 39          | 51741 C     | Looper Connecting Rod Ball Joint, right, for Styles 51700 BU, 51800 BA, BB --- | 1            |
| 40          | 4761        | Looper Connecting Rod, for Style 51700 BU -----                                | 1            |
|             | 41047       | Looper Connecting Rod, for Styles 51800 BA, BB -----                           | 1            |
| 41          | 55641       | Looper Connecting Rod Ball Joint, left, for Styles 51700 BU, 51800 BA, BB ---- | 1            |
| 42          | 22835       | Looper Rocker Link Stud, for Styles 51700 BU, 51800 BA, BB -----               | 1            |
| 43          | 29192 C     | Looper Rocker Assembly, for Style 51700 BU -----                               | 2            |
|             | 29192 K     | Looper Rocker Assembly, for Styles 51800 BA, BB -----                          | 2            |
| 44          | 51813       | Looper Rocker, for No. 29192 K -----                                           | 1            |
| 44A         | 51713       | Looper Rocker, for No. 29192 C -----                                           | 1            |
| 45          | 51709       | Looper, left, for Style 51700 BU -----                                         | 1            |
| 46          | 51708       | Looper, right, for Style 51700 BU -----                                        | 1            |
| 47          | 51808 A     | Looper, front, for Nos. 16-64-16 and 16-76-16 gauge on Styles 51800 BA, BB --  | 2            |
| 48          | 51808       | Looper, front, for Nos. 12-56-12 and 12-64-12 gauge on Styles 51800 BA, BB --  | 2            |
| 49          | 51809       | Looper, back, for all gauges on Styles 51800 BA, BB -----                      | 2            |
| 50          | 54244 L     | Thrust Washer, for Styles 51700 BU, 51800 BA, BB -----                         | 1            |
| 51          | 51773       | Spacing Collar, for Styles 51700 BU, 51800 BA, BB -----                        | 1            |
| 52          | 88 B        | Screw -----                                                                    | 1            |
| 53          | 1280        | Looper Rocker Stud Nut, for Styles 51700 BU, 51800 BA, BB -----                | 2            |
|             | 51772-56    | Looper Rocker Spacing Plate, for No. 96 gauge on Style 51700 BU -----          | 1            |
| 54          | 51772-68    | Looper Rocker Spacing Plate, for No. 12-56-12 gauge on Styles 51800 BA, BB --  | 1            |
|             | 51772-76    | Looper Rocker Spacing Plate, for No. 12-64-12 gauge on Styles 51800 BA, BB --  | 1            |
|             | 51772-80    | Looper Rocker Spacing Plate, for No. 16-64-16 gauge on Styles 51800 BA, BB --  | 1            |
|             | 51772-92    | Looper Rocker Spacing Plate, for No. 16-76-16 gauge on Styles 51800 BA, BB --  | 1            |
| 55          | 51744 A     | Looper Rocker Frame, for Styles 51700 BU, 51800 BA, BB -----                   | 1            |
| 56          | 14077       | Nut, for Style 51700 BU -----                                                  | 2            |
|             | 14077       | Nut, for Styles 51800 BA, BB -----                                             | 4            |
| 57          | 51770-68    | Looper Rocker Link, for No. 12-56-12 gauge on Styles 51800 BA, BB -----        | 1            |
|             | 51770-76    | Looper Rocker Link, for No. 12-64-12 gauge on Styles 51800 BA, BB -----        | 1            |
|             | 51770-80    | Looper Rocker Link, for No. 16-64-16 gauge on Styles 51800 BA, BB -----        | 1            |
|             | 51770-92    | Looper Rocker Link, for No. 16-76-16 gauge on Styles 51800 BA, BB -----        | 1            |
|             | 51770-96    | Looper Rocker Link, for No. 96 gauge on Style 51700 BU -----                   | 1            |
| 58          | 51771       | Looper Rocker Link Bushing, for Styles 51700 BU, 51800 BA, BB -----            | 2            |



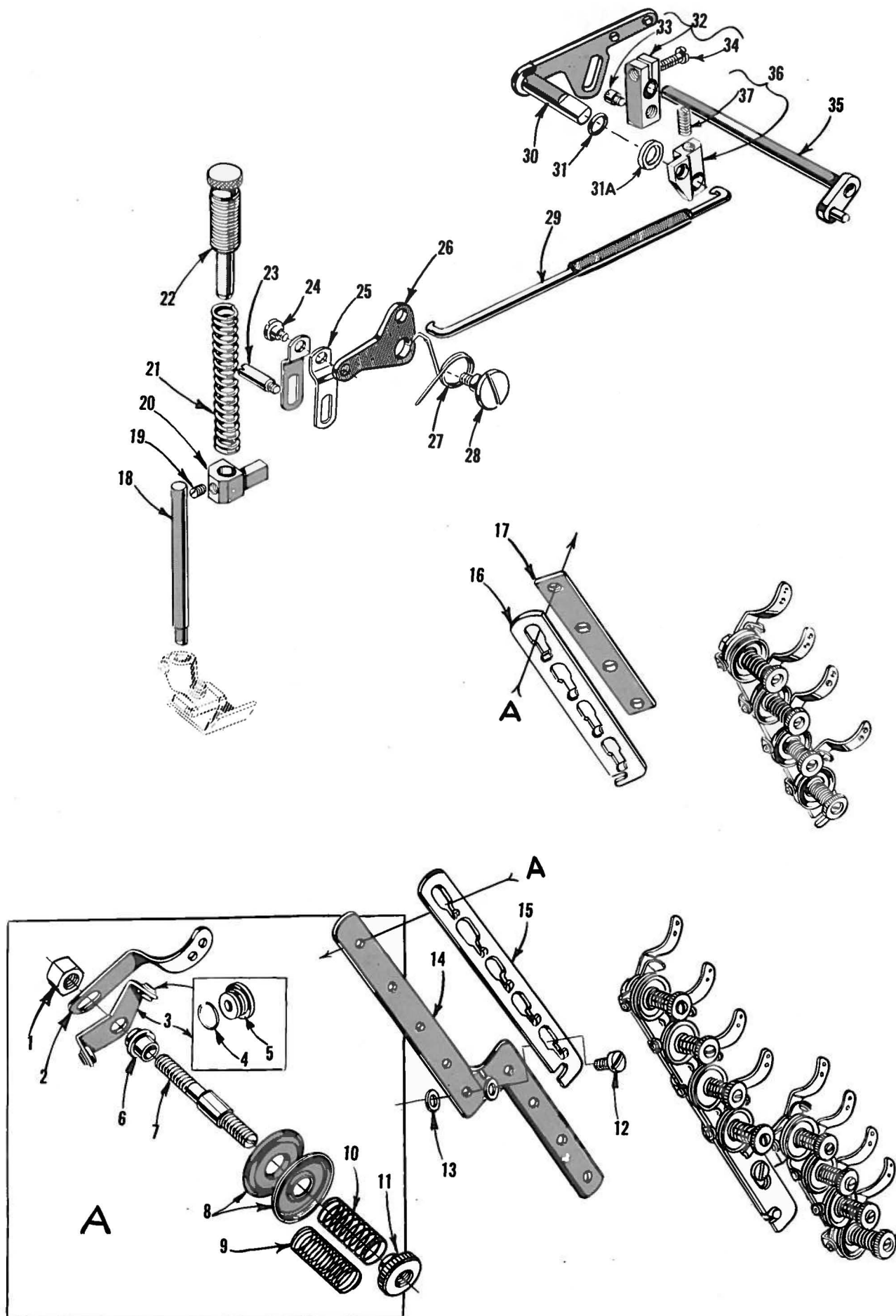




MAIN SHAFT, FEED DRIVING PARTS AND LOOPER THREAD TAKE-UP PARTS

| Ref.<br>No. | Part<br>No. | Description                                                             | Amt.<br>Req. |
|-------------|-------------|-------------------------------------------------------------------------|--------------|
| 1           | 269         | Nut, left thread -----                                                  | 1            |
| 2           | 20          | Washer-----                                                             | 1            |
| 3           | 51236 E     | Feed Crank Link, complete-----                                          | 1            |
| 4           | 660-169     | Needle Bearing -----                                                    | 1            |
| 5           | 51236 D     | Feed Crank Link -----                                                   | 1            |
| 6           | 51236 F     | Feed Crank Link Ferrule -----                                           | 1            |
| 7           | 51054       | Link Pin-----                                                           | 1            |
| 8           | 666-149     | Oil Wick -----                                                          | 1            |
| 9           | 51236 G     | Feed Crank Stud-----                                                    | 1            |
| 10          | 82          | Stitch Regulating Screw -----                                           | 1            |
| 11          | 51236 B     | Feed Crank Stud Cap-----                                                | 1            |
| 12          | 22768       | Screw -----                                                             | 2            |
| 13          | 51222       | Main Shaft, for Style 51400 BE-----                                     | 1            |
|             | 51722       | Main Shaft, for Styles 51700 BU, 51800 BA, BB -----                     | 1            |
| 14          |             | Feed Dog (See Pages 29, 31)-----                                        | 1            |
| 15          | 22528       | Screw -----                                                             | 1            |
| 16          | 77          | Screw -----                                                             | 1            |
| 17          | 51235 A     | Feed Rocker Arm -----                                                   | 1            |
| 18          | 51235 G     | Washer-----                                                             | 2            |
| 19          | 22519 C     | Screw -----                                                             | 2            |
| 20          | 51235       | Feed Rocker -----                                                       | 1            |
| 21          | 98          | Screw-----                                                              | 2            |
| 22          | 482         | Feed Rocker Shaft Collar-----                                           | 2            |
| 23          | 98          | Screw-----                                                              | 1            |
| 24          | 22585 B     | Needle Guard Screw -----                                                | 1            |
| 25          | 51225 W     | Washer-----                                                             | 1            |
| 26          |             | Needle Guard (See Page 27)-----                                         | 1            |
| 27          | 22834       | Needle Guard Adjusting Screw -----                                      | 1            |
| 28          | 77          | Screw -----                                                             | 1            |
| 29          | 51434       | Feed Bar -----                                                          | 1            |
| 30          | 56334 L     | Feed Dog Holder -----                                                   | 1            |
| 31          | 22863       | Feed Dog Holder Adjusting Screw -----                                   | 1            |
| 32          | 51134 J     | Feed Dog Holder Washer-----                                             | 1            |
| 33          | 258         | Nut-----                                                                | 1            |
| 34          | 538         | Feed Dog Height Adjusting Screw -----                                   | 1            |
| 35          | 22560 B     | Screw-----                                                              | 1            |
| 36          | 51134 C     | Feed Bar Shaft-----                                                     | 1            |
| 37          | 51134 R     | Lubricating Felt Guard-----                                             | 1            |
| 38          | 51134 P     | Lubricating Felt-----                                                   | 1            |
| 39          | 8           | Feed Rocker Shaft-----                                                  | 1            |
| 40          | 51423 C     | Looper Thread Take-up, for Style 51400 BE-----                          | 1            |
| 41          | 96          | Spot Screw -----                                                        | 1            |
| 42          | 22580 D     | Set Screw -----                                                         | 1            |
| 43          | 51723 A     | Looper Thread Take-up, for Styles 51700 BU, 51800 BA, BB -----          | 1            |
| 44          | 96          | Spot Screw -----                                                        | 1            |
| 45          | 22580 D     | Set Screw -----                                                         | 1            |
| 46          | 29476 DV    | Looper Avoid Eccentric Assembly-----                                    | 1            |
| 47          | 51145 A     | Eccentric Bearing-----                                                  | 1            |
| 48          | 51406       | Looper Avoid Eccentric, .062 inch throw -----                           | 1            |
| 49          | 22894 D     | Spot Screw -----                                                        | 1            |
| 50          | 51236 A     | Link Pin (includes felt wick) -----                                     | 1            |
| 51          | 29476 DV    | Feed Lift Eccentric Assembly -----                                      | 1            |
| 52          | 51145 A     | Eccentric Bearing-----                                                  | 1            |
| 53          | 51406       | Feed Lift Eccentric, .062 inch throw-----                               | 1            |
| 54          | 22894 D     | Spot Screw -----                                                        | 1            |
| 55          | 51236 A     | Link Pin (includes felt wick) -----                                     | 1            |
| 56          | 51757 B     | Cast-off Plate Support, for Styles 51700 BU, 51800 BA, BB-----          | 1            |
| 57          | 51704       | Cast-off Wire, for Style 51700 BU, 51800 BA, BB -----                   | 1            |
| 58          | 28          | Screw, for cast-off wire -----                                          | 2            |
| 59          | 51959 D     | Tension Nut, for Styles 51700 BU, 51800 BA, BB -----                    | 1            |
| 60          | 51959 K     | Tension Spring, for Styles 51700 BU, 51800 BA, BB -----                 | 1            |
| 61          | 51959 B     | Tension Disc, for Styles 51700 BU, 51800 BA, BB -----                   | 2            |
| 62          | 51492       | Tension Post, for Styles 51700 BU, 51800 BA, BB -----                   | 1            |
| 63          | 51459 A     | Thread Guide, for Styles 51700 BU, 51800 BA, BB-----                    | 1            |
| 64          | 50-216Blk   | Dowel Pin -----                                                         | 2            |
| 65          | 21657 E     | Washer-----                                                             | 1            |
| 66          | 22528       | Screw -----                                                             | 1            |
| 67          | 51257 P     | Cast-off Support, for Style 51400 BE -----                              | 1            |
| 68          | 22768       | Screw, for Style 51400 BE-----                                          | 1            |
| 69          | 52958       | Take-up Thread Eyelet, for Style 51400 BE -----                         | 1            |
| 70          | 51204 B     | Cast-off, for Style 51400 BE-----                                       | 1            |
| 71          | 51204       | Looper Thread Retaining Finger, for Style 51400 BE -----                | 1            |
| 72          | 22798 A     | Screw, for Style 51400 BE-----                                          | 1            |
| 73          | 51204 A     | Looper Thread Retaining Finger Holder, for Style 51400 BE -----         | 1            |
| 74          | 51204 C     | Cast-off and Retaining Finger Support Bracket, for Style 51400 BE ----- | 1            |
| 75          | 77          | Screw, for Style 51400 BE-----                                          | 1            |
| 76          | J87 J       | Screw, for Style 51400 BE-----                                          | 2            |

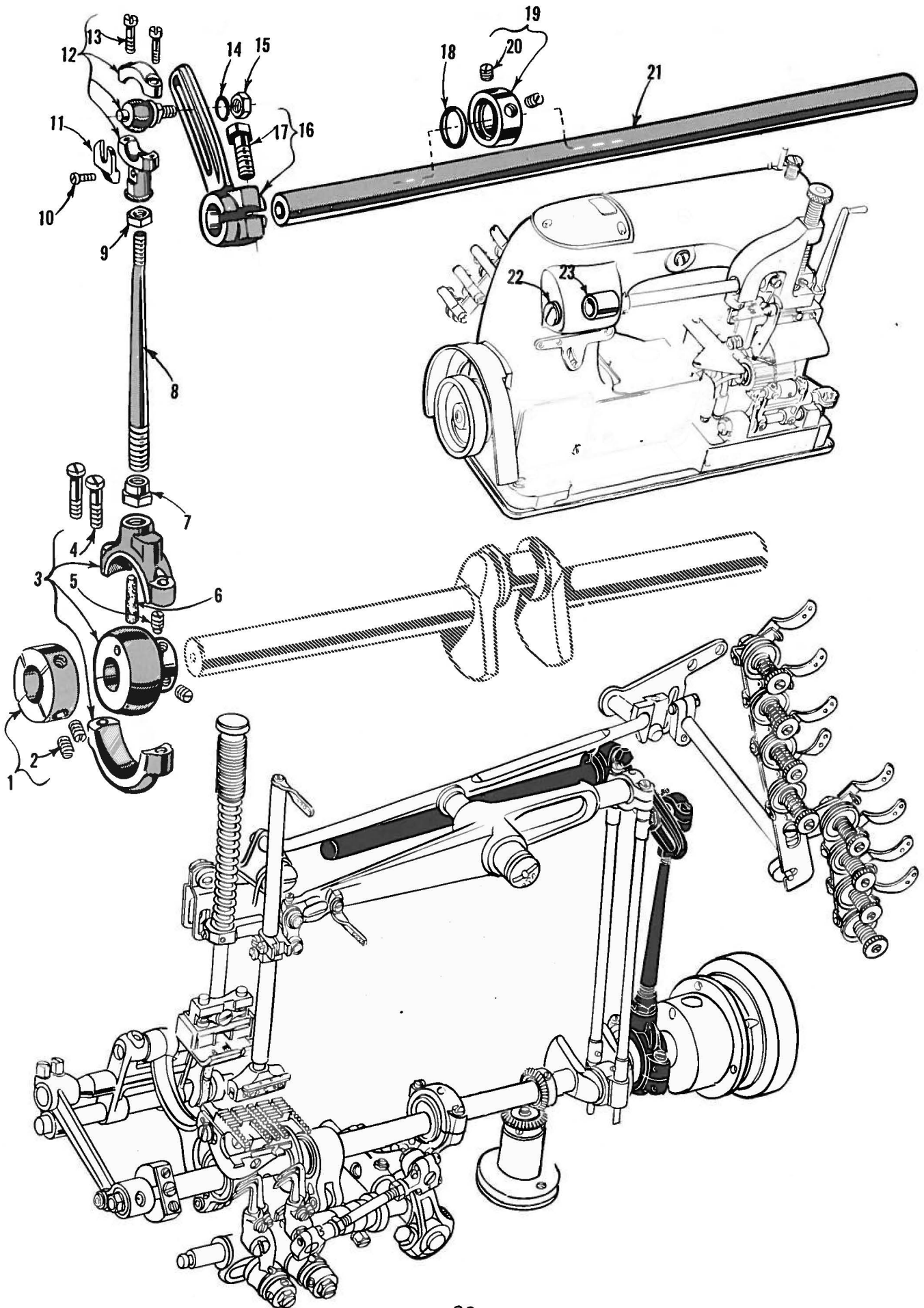




# THREAD TENSION AND LIFTER LEVER PARTS

| Ref.<br>No. | Part<br>No. | Description                                                 | Amt.<br>Req. |
|-------------|-------------|-------------------------------------------------------------|--------------|
| 1           | 43266       | Nut, for Styles 51400 BE, 51700 BU -----                    | 2            |
|             | 43266       | Nut, for Styles 51800 BA, BB -----                          | 7            |
| 2           | 51491 C     | Lead-in Guide, for Styles 51400 BE, 51700 BU -----          | 4            |
|             | 51491 C     | Lead-in Guide, for Styles 51800 BA, BB -----                | 8            |
| 3           | 51292 D     | Tension Thread Eyelet, for Styles 51400 BE, 51700 BU --     | 4            |
|             | 51292 D     | Tension Thread Eyelet, for Styles 51800 BA, BB -----        | 8            |
| 4           | 666-28      | Eyelet Locking Ring, for Styles 51400 BE,<br>51700 BU ----- | 8            |
|             | 668-28      | Eyelet Locking Ring, for Styles 51800 BA, BB -----          | 16           |
| 5           | 668-25      | Eyelet, for Styles 51400 BE, 51700 BU -----                 | 8            |
|             | 668-25      | Eyelet, for Styles 51800 BA, BB -----                       | 16           |
| 6           | 51292 A     | Ferrule, for Styles 51400 BE, 51700 BU -----                | 4            |
|             | 51292 A     | Ferrule, for Styles 51800 BA, BB -----                      | 8            |
| 7           | 51292 G     | Tension Post, for Styles 51400 BE, 51700 BU -----           | 4            |
|             | 51292 G     | Tension Post, for Styles 51800 BA, BB -----                 | 8            |
| 8           | 109         | Tension Disc, for Styles 51400 BE, 51700 BU -----           | 8            |
|             | 109         | Tension Disc, for Styles 51800 BA, BB -----                 | 16           |
| 9           | 51292 F-1   | Tension Spring, loop, for Style 51400 BE -----              | 2            |
|             | 51292 F-2   | Tension Spring, loop, for Style 51700 BU -----              | 2            |
|             | 51292 F-2   | Tension Spring, loop, for Styles 51800 BA, BB -----         | 4            |
| 10          | 51292 F-5   | Tension Spring, needle, for Style 51400 BE -----            | 2            |
|             | 51292 F-8   | Tension Spring, needle, for Style 51700 BU -----            | 2            |
|             | 51292 F-8   | Tension Spring, needle, for Styles 51800 BA, BB -----       | 4            |
| 11          | 51292 C     | Tension Nut, for Styles 51400 BE, 51700 BU -----            | 4            |
|             | 51292 C     | Tension Nut, for Styles 51800 BA, BB -----                  | 8            |
| 12          | 22598 C     | Screw, for Styles 51800 BA, BB -----                        | 1            |
| 13          | 80557       | Washer, for Styles 51800 BA, BB -----                       | 2            |
| 14          | 51892       | Tension Post Support, for Styles 51800 BA, BB -----         | 1            |
| 15          | 21657 AM-5  | Tension Disc Separator, for Styles 51800 BA, BB -----       | 1            |
| 16          | 21657-4     | Tension Disc Separator, for Styles 51400 BE, 51700 BU -     | 1            |
| 17          | 56382 X     | Tension Post Support, for Styles 51400 BE, 51700 BU ---     | 1            |
| 18          | 51257 K     | Presser Bar -----                                           | 1            |
| 19          | 531         | Screw -----                                                 | 1            |
| 20          | 51257 M     | Presser Bar Connection and Guide-----                       | 1            |
| 21          | 51256 C     | Presser Spring, for Style 51400 BE -----                    | 1            |
|             | 53787       | Presser Spring, for Styles 51700 BU, 51800 BA, BB ----      | 1            |
| 22          | 56356       | Presser Spring Regulator -----                              | 1            |
| 23          | 22799 T     | Screw -----                                                 | 1            |
| 24          | 240         | Screw -----                                                 | 1            |
| 25          | 53783 S     | Lifter Lever Link -----                                     | 2            |
| 26          | 53783 L     | Lifter Lever Bell Crank -----                               | 1            |
| 27          | 52883 S     | Lifter Lever Bell Crank Spring -----                        | 1            |
| 28          | 22557 B     | Screw -----                                                 | 1            |
| 29          | 53783 M     | Lifter Lever Connecting Rod -----                           | 1            |
| 30          | 51283 H     | Lifter Lever -----                                          | 1            |
| 31          | 660-207     | Oil Seal Ring -----                                         | 1            |
| 31A         | 39552 C     | Washer -----                                                | 1            |
| 32          | 21657 Y     | Tension Release and Lifter Lever Shaft Connection -----     | 1            |
| 33          | 402         | Screw -----                                                 | 1            |
| 34          | 22596       | Screw -----                                                 | 1            |
| 35          | 21657 W     | Tension Release and Lifter Lever Shaft -----                | 1            |
| 36          | 53783 N     | Lifter Lever, internal -----                                | 1            |
| 37          | 22537       | Screw -----                                                 | 1            |

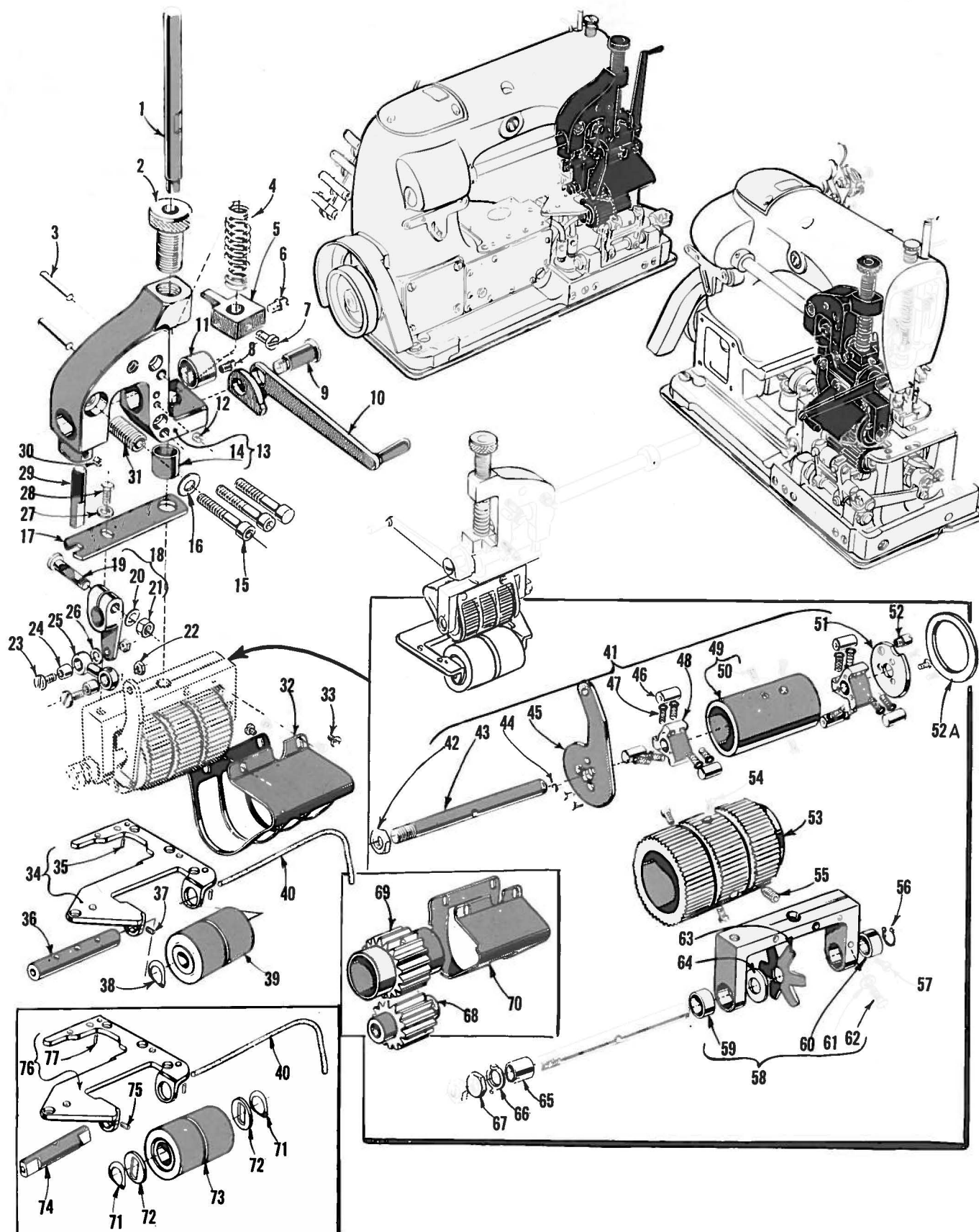




PULLER DRIVING PARTS

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                            | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|-----------------------------------------------|----------------------|
| 1                   | 9660 B              | Thrust Collar -----                           | 1                    |
| 2                   | 98                  | Screw-----                                    | 2                    |
| 3                   | 29126 DE            | Puller Drive Eccentric Assembly -----         | 1                    |
| 4                   | 22587               | Bearing Cap Screw -----                       | 2                    |
| 5                   | 95                  | Screw-----                                    | 2                    |
| 6                   | 666-53              | Lubricating Felt-----                         | 1                    |
| 7                   | 15430 D             | Nut, right thread -----                       | 1                    |
| 8                   | 53716               | Connecting Rod-----                           | 1                    |
| 9                   | 269                 | Nut, left thread -----                        | 1                    |
| 10                  | 22747               | Screw-----                                    | 1                    |
| 11                  | 41255 B             | Ball Stud Guide Fork-----                     | 1                    |
| 12                  | 52854               | Puller Driving Connecting Rod Ball Joint----- | 1                    |
| 13                  | 22729 C             | Bearing Cap Screw -----                       | 2                    |
| 14                  | 454 A               | Washer-----                                   | 1                    |
| 15                  | 258                 | Nut -----                                     | 1                    |
| 16                  | 53752               | Puller Driving Shaft Segment Lever -----      | 1                    |
| 17                  | 22811               | Screw-----                                    | 1                    |
| 18                  | 660-202             | Oil Seal Ring-----                            | 1                    |
| 19                  | 52849 C             | Thrust Collar -----                           | 1                    |
| 20                  | 95                  | Screw-----                                    | 2                    |
| 21                  | 54249               | Puller Driving Shaft -----                    | 1                    |
| 22                  | 22539 D             | Plug Screw -----                              | 1                    |
| 23                  | 53790 A             | Puller Driving Shaft Bushing-----             | 1                    |



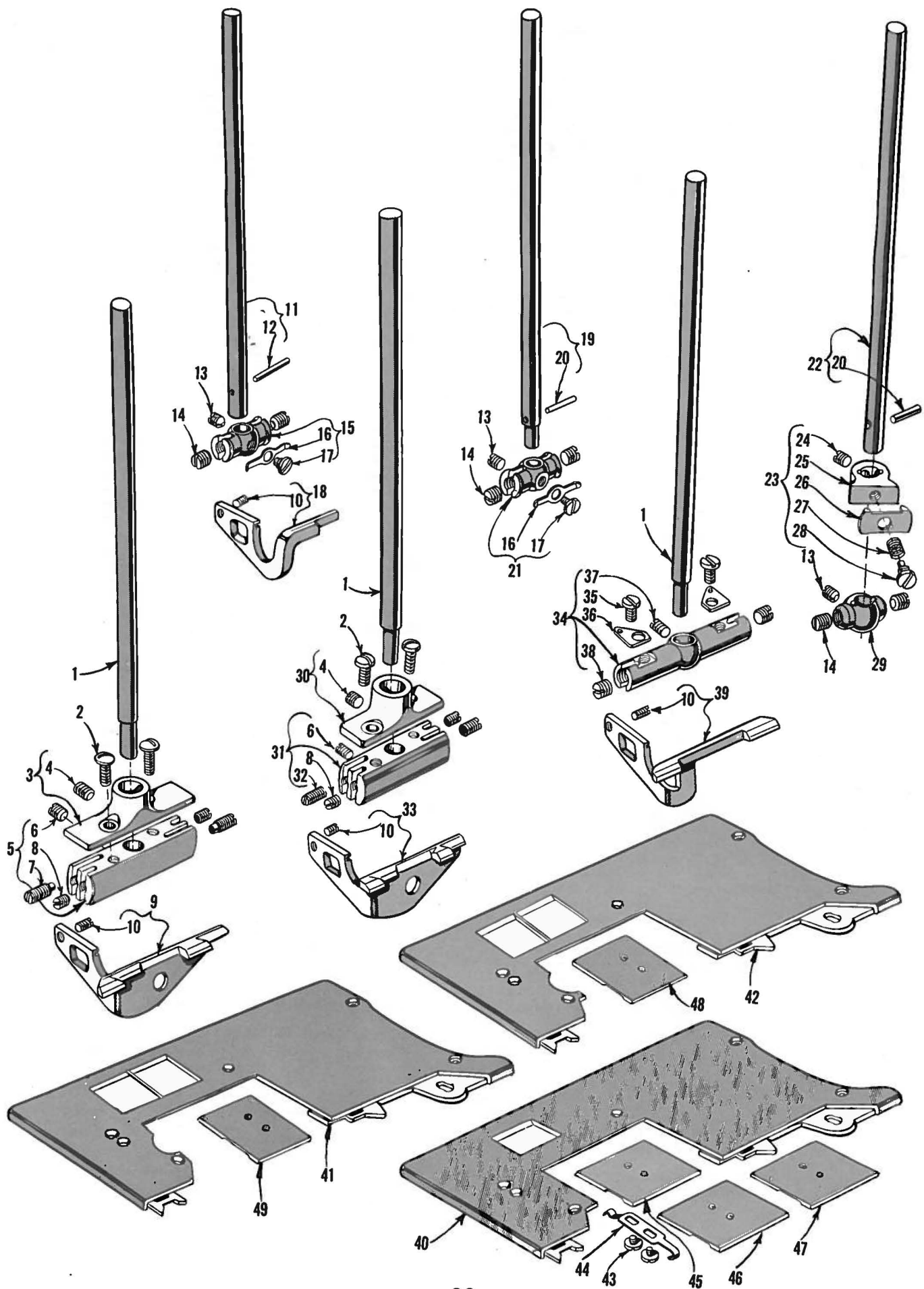


# FEED ROLLER AND PULLER CLUTCH PARTS

| Ref.<br>No. | Part<br>No. | Description                                                                        | Amt.<br>Req. |
|-------------|-------------|------------------------------------------------------------------------------------|--------------|
| 1           | 54277 J     | Feed Roller Presser Bar-----                                                       | 1            |
| 2           | 54277 C     | Feed Roller Presser Spring Regulator-----                                          | 1            |
| 3           | 667 D-24    | Dowel Pin-----                                                                     | 2            |
| 4           | 54277 B     | Feed Roller Presser Spring-----                                                    | 1            |
| * 5         | 54277 G     | Feed Roller Presser Bar Collar-----                                                | 1            |
| * 6         | 22845 C     | Screw-----                                                                         | 1            |
| 7           | 22517       | Screw-----                                                                         | 1            |
| 8           | 33174 B     | Stop Screw-----                                                                    | 1            |
| 9           | 22854 D     | Screw-----                                                                         | 1            |
| 10          | 54277 K     | Feed Roller Lifter Lever-----                                                      | 1            |
| 11          | 54249 B     | Clutch Driving Shaft Bushing, left-----                                            | 1            |
| 12          | 89          | Screw-----                                                                         | 1            |
| 13          | 54277 HA    | Feed Roller Mounting Bracket-----                                                  | 1            |
| 14          | 43245 N     | Bushing-----                                                                       | 1            |
| 15          | 22653 D-24  | Screw-----                                                                         | 3            |
| 16          | 43137 E     | Washer-----                                                                        | 1            |
| 17          | 54278 T     | Feed Roller Yoke Guide-----                                                        | 1            |
| 18          | 54249 C     | Clutch Driving Lever-----                                                          | 1            |
| 19          | 55235 D     | Locking Stud-----                                                                  | 1            |
| 20          | 6042 A      | Washer-----                                                                        | 1            |
| 21          | 55235 E     | Nut-----                                                                           | 1            |
| 22          | 12934 A     | Nut-----                                                                           | 2            |
| 23          | 22757       | Screw-----                                                                         | 2            |
| 24          | 51771       | Ferrule-----                                                                       | 2            |
| 25          | 51770-56    | Connection Link-----                                                               | 1            |
| 26          | 54249 D     | Washer-----                                                                        | 1            |
| 27          | 8372 A      | Washer-----                                                                        | 1            |
| 28          | 22792 A     | Screw-----                                                                         | 1            |
| 29          | 54278 B     | Guide Stud-----                                                                    | 1            |
| 30          | 89          | Screw-----                                                                         | 1            |
| 31          | 22899       | Screw-----                                                                         | 1            |
| 32          | 54278 X     | Feed Roller Guard, for Styles 51700 BU, 51800 BA, BB-----                          | 1            |
| 33          | 22704       | Screw-----                                                                         | 4            |
| 34          | 51480 D     | Throat Plate and Lower Feed Roller Support, for Styles 51400 BE, 51800 BA, BB----- | 1            |
| 35          | 51280 J     | Dowel Pin-----                                                                     | 2            |
| 36          | 54276 L     | Lower Feed Roller Shaft, for Styles 51400 BE, 51800 BA, BB-----                    | 1            |
| 37          | 22733       | Screw, for Styles 51400 BE, 51800 BA, BB-----                                      | 1            |
| 38          | 660-223     | Spring Washer, for Styles 51400 BE, 51800 BA, BB-----                              | 1            |
| 39          | 54276 A     | Lower Feed Roller, rubber, for Styles 51800 BA, BB-----                            | 1            |
| 40          | 666-153     | Oil Wick, for No. 54276 L-----                                                     | 1            |
| 41          | 29476 GG    | Feed Roller Clutch Assembly-----                                                   | 1            |
| 42          | 11638 M     | Nut-----                                                                           | 1            |
| 43          | 54274 G     | Clutch Shaft-----                                                                  | 1            |
| 44          | 605 A       | Screw-----                                                                         | 6            |
| 45          | 54274 K     | Clutch Driving Lever-----                                                          | 1            |
| 46          | 54274 L     | Roller-----                                                                        | 6            |
| 47          | 29480 KP    | Clutch Spring and Cap Assembly-----                                                | 12           |
| 48          | 54274 H     | Clutch Disc-----                                                                   | 2            |
| 49          | 54274 F     | Clutch Barrel-----                                                                 | 1            |
| 50          | 538         | Screw-----                                                                         | 3            |
| 51          | 54274 J     | Clutch Plate-----                                                                  | 1            |
| 52          | 22892 D     | Screw-----                                                                         | 1            |
| 52A         | 54274 R     | Washer, fiber, for Styles 51700 BU, 51800 BA, BB-----                              | 1            |
| 53          | 54275 C     | Upper Feed Roller, steel toothed, for Styles 51700 BU, 51800 BA, BB-----           | 1            |
| 54          | 538         | Screw-----                                                                         | 3            |
| 55          | 22894 H     | Screw-----                                                                         | 1            |
| 56          | 660-208     | Locking Ring-----                                                                  | 1            |
| 57          | 77 B        | Screw-----                                                                         | 1            |
| 58          | 54278 S     | Upper Feed Roller Yoke-----                                                        | 1            |
| 59          | 54278 U     | Bushing, right-----                                                                | 1            |
| 60          | 54278 V     | Bushing, left-----                                                                 | 1            |
| 61          | 51235 G     | Washer-----                                                                        | 1            |
| 62          | T38         | Screw-----                                                                         | 1            |
| 63          | 54274 N     | Clutch Tension Spring-----                                                         | 1            |
| 64          | 54274 P     | Thrust Washer-----                                                                 | 1            |
| 65          | 54278 W     | Feed Roller Yoke Bearing Sleeve-----                                               | 1            |
| 66          | 54278 Y     | Driving Washer-----                                                                | 1            |
| 67          | 11638 M     | Nut-----                                                                           | 1            |
| 68          | 51476 A     | Lower Feed Roller, bakelite, for Style 51400 BE-----                               | 1            |
| 69          | 51475 A     | Upper Feed Roller, bakelite, for Style 51400 BE-----                               | 1            |
| 70          | 54278 AB    | Feed Roller Guard, for Style 51400 BE-----                                         | 1            |
| 71          | 54276 W     | Spring Washer, for Style 51700 BU-----                                             | 2            |
| 72          | 51776 C     | Washer, for Style 51700 BU-----                                                    | 2            |
| 73          | 51776 A     | Lower Feed Roller, rubber, for Style 51700 BU-----                                 | 1            |
| 74          | 51776 B     | Puller Roller Shaft, for Style 51700 BU-----                                       | 1            |
| 75          | 73 C        | Screw, for Style 51700 BU-----                                                     | 1            |
| 76          | 51780 B     | Throat Plate and Lower Feed Roller Support, for Style 51700 BU-----                | 1            |
| 77          | 51280 J     | Dowel Pin-----                                                                     | 2            |

\* Replaced by No. 54277 M, on late model machines.

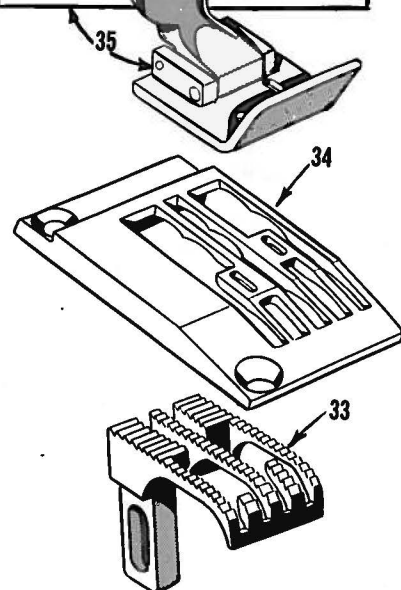
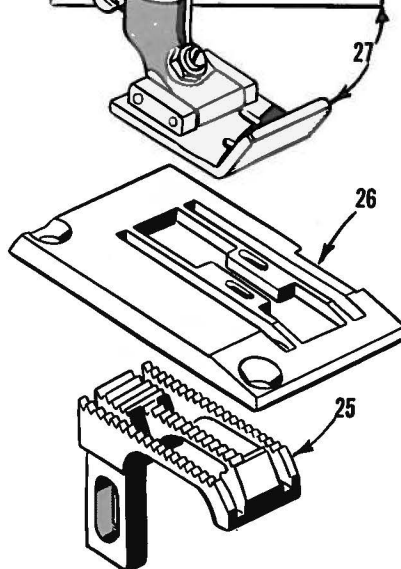
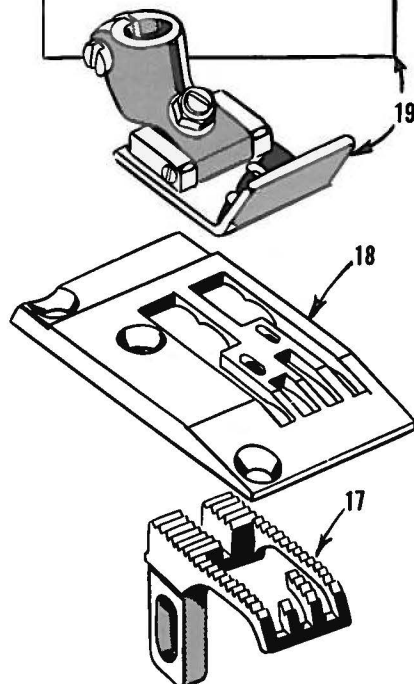
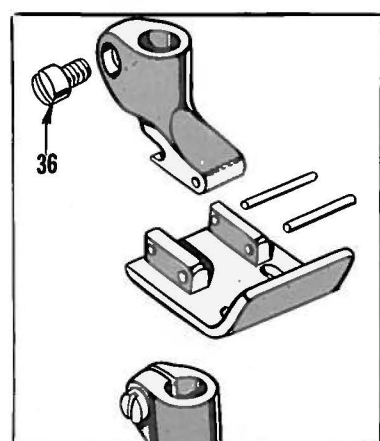
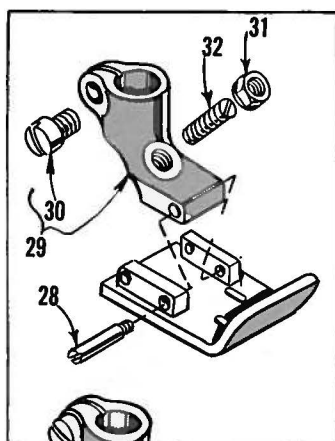
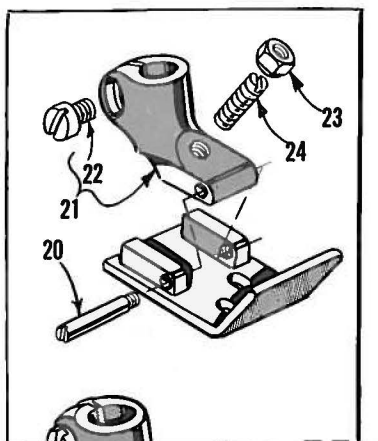
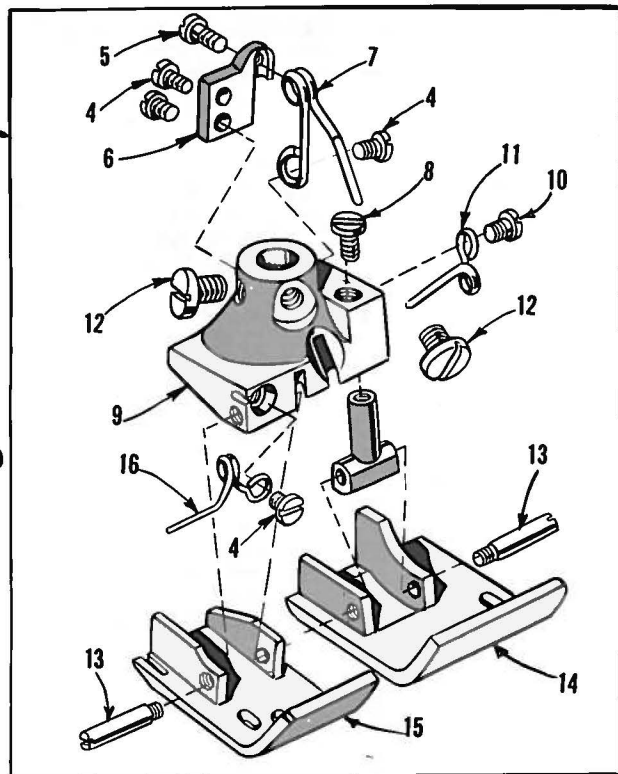
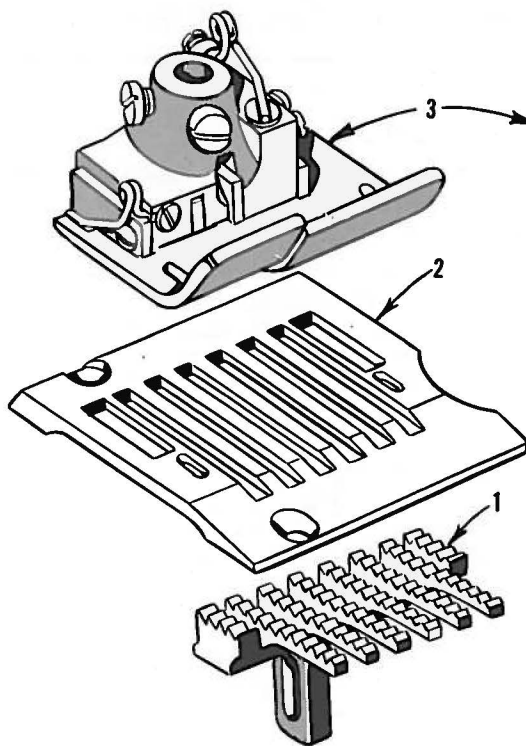




**NEEDLE BARS, NEEDLE HOLDERS, NEEDLE GUARDS, CLOTH PLATES  
AND CLOTH PLATE COVERS**

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                                                   | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|--------------------------------------------------------------------------------------|----------------------|
| 1                   | 51817 A             | Needle Bar, marked "DL", for Styles 51700 BU, 51800 BA, BB-----                      | 1                    |
| 2                   | 22849               | Screw, for Nos. 51833, 51833 A -----                                                 | 2                    |
| 3                   | 51833 A             | Needle Stop Plate, for Nos. 16-64-16, 16-76-16 gauge on<br>Styles 51800 BA, BB ----- | 1                    |
| 4                   | 88                  | Screw, for Nos. 51833, 51833 A -----                                                 | 1                    |
| 5                   | 51818-16-64-16      | Needle Holder, for No. 16-64-16 gauge on Styles 51800 BA, BB-----                    | 1                    |
|                     | 51818-16-76-16      | Needle Holder, for No. 16-76-16 gauge on Styles 51800 BA, BB-----                    | 1                    |
| 6                   | 22894 P             | Screw -----                                                                          | 1                    |
| 7                   | 22575               | Screw, for Nos. 51818-16-64-16, 51818-16-76-16 -----                                 | 2                    |
| 8                   | 22565 C             | Screw -----                                                                          | 2                    |
| 9                   | 51825 C             | Needle Guard, for No. 16-76-16 gauge on Styles 51800 BA, BB -----                    | 1                    |
|                     | 51825 CA            | Needle Guard, for No. 16-64-16 gauge on Styles 51800 BA, BB -----                    | 1                    |
| 10                  | 22801               | Screw, for Nos. 51425 E, 51725 C, 51825 B, 51825 C-----                              | 1                    |
| 11                  | 51417 D             | Needle Bar, marked "DE", for No. 24 gauge on Style 51400 BE -----                    | 1                    |
| 12                  | 50 J-40             | Stop Pin-----                                                                        | 1                    |
| 13                  | 89                  | Screw-----                                                                           | 1                    |
| 14                  | 98                  | Screw-----                                                                           | 2                    |
| 15                  | 7018 E-5 1/2        | Needle Holder, marked "G-5 1/2", for No. 24 gauge on<br>Style 51400 BE -----         | 1                    |
| 16                  | 7040-6              | Thread Guide -----                                                                   | 1                    |
| 17                  | 187 B               | Screw -----                                                                          | 1                    |
| 18                  | 51425 E             | Needle Guard, for Style 51400 BE-----                                                | 1                    |
| 19                  | 56517 B-18          | Needle Bar, marked "EU", for No. 18 gauge on Style 51400 BE -----                    | 1                    |
| 20                  | 50 J-16             | Stop Pin, for Nos. 15417 E-16 and 51417 F-----                                       | 1                    |
| 21                  | 7018 E-5            | Needle Holder, marked "G-5", for No. 18 gauge on Style 51400 BE---                   | 1                    |
| 22                  | 56517 B-16          | Needle Bar, marked "ET", for No. 16 gauge on Style 51400 BE -----                    | 1                    |
| 23                  | 1287                | Needle Bar Thread Nipper, for Style 51400 BE -----                                   | 1                    |
| 24                  | 88                  | Screw -----                                                                          | 1                    |
| 25                  | 1288                | Needle Bar Thread Nipper Collar -----                                                | 1                    |
| 26                  | 57 WB               | Needle Bar Thread Nipper Spring Plate -----                                          | 1                    |
| 27                  | 57 WC               | Needle Bar Thread Nipper Spring -----                                                | 1                    |
| 28                  | 57 WD               | Screw -----                                                                          | 1                    |
| 29                  | 51418-16            | Needle Holder, marked "D-16", for No. 16 gauge on Style 51400 BE--                   | 1                    |
| 30                  | 51833               | Needle Stop Plate, for Nos. 12-56-12, 12-64-12 gauge on<br>Styles 51800 BA, BB ----- | 1                    |
| 31                  | 51818-12-56-12      | Needle Holder, for No. 12-56-12 gauge on Styles 51800 BA, BB-----                    | 1                    |
|                     | 51818-12-64-12      | Needle Holder, for No. 12-64-12 gauge on Styles 51800 BA, BB-----                    | 1                    |
| 32                  | 22565 D             | Screw, for Nos. 51818-12-56-12, 51818-12-64-12 -----                                 | 2                    |
| 33                  | 51825 B             | Needle Guard, for Nos. 12-56-12, 12-64-12 gauge on<br>Styles 51800 BA, BB -----      | 1                    |
| 34                  | 51718 A-96          | Needle Holder, for Style 51700 BU -----                                              | 1                    |
| 35                  | 22513 B             | Screw -----                                                                          | 2                    |
| 36                  | 51718 B-64          | Needle Stop-----                                                                     | 2                    |
| 37                  | 22894 P             | Screw -----                                                                          | 1                    |
| 38                  | 98                  | Screw -----                                                                          | 2                    |
| 39                  | 51725 C             | Needle Guard, for Style 51700 BU-----                                                | 1                    |
| 40                  | 51401 S             | Cloth Plate, for Style 51400 BE-----                                                 | 1                    |
| 41                  | 51801 A             | Cloth Plate, for Styles 51800 BA, BB -----                                           | 1                    |
| 42                  | 51701 V             | Cloth Plate, for Style 51700 BU-----                                                 | 1                    |
| 43                  | 12986 B             | Screw -----                                                                          | 2                    |
| 44                  | 51281 AF            | Cloth Plate Cover Spring-----                                                        | 1                    |
| 45                  | 51281 AG-148        | Cloth Plate Cover, for No. 24 gauge on Style 51400 BE-----                           | 1                    |
| 46                  | 51281 AG-150        | Cloth Plate Cover, for No. 16 gauge on Style 51400 BE-----                           | 1                    |
| 47                  | 51281 AG-144        | Cloth Plate Cover, for No. 18 gauge on Style 51400 BE-----                           | 1                    |
| 48                  | 51281 AG-103        | Cloth Plate Cover, for Style 51700 BU-----                                           | 1                    |
| 49                  | 51281 AG- 99        | Cloth Plate Cover, for Styles 51800 BA, BB-----                                      | 1                    |

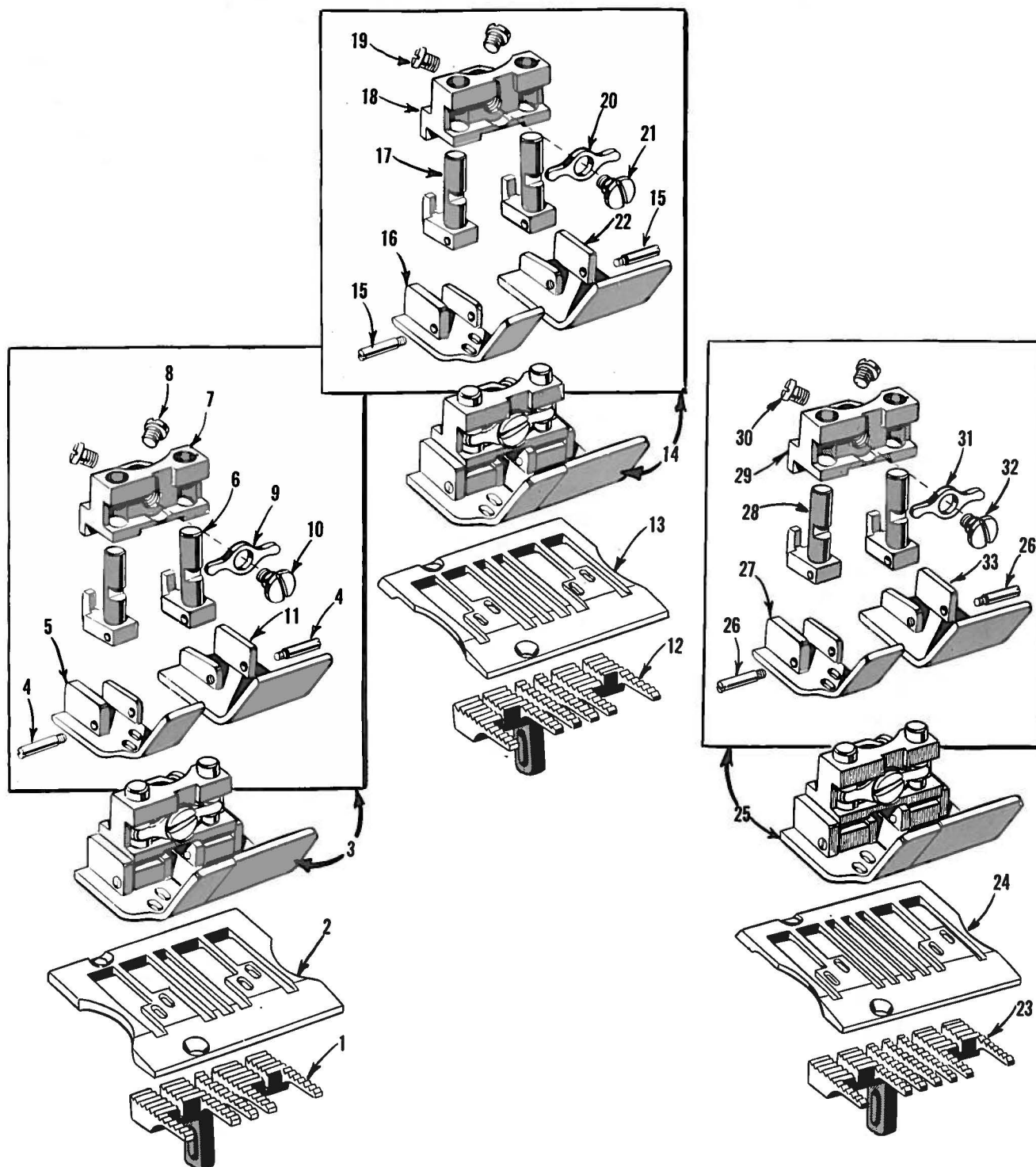




# FEED DOGS, THROAT PLATES, PRESSER FEET

| Ref.<br>No. | Part<br>No.   | Description                                               | Amt.<br>Req. |
|-------------|---------------|-----------------------------------------------------------|--------------|
| 1           | 16505-96      | Feed Dog, for Style 51700 BU-----                         | 1            |
| 2           | 16524 B-96    | Throat Plate, for Style 51700 BU-----                     | 1            |
| 3           | 51720 F-96    | Presser Foot, for Style 51700 BU-----                     | 1            |
| 4           | 605           | Screw-----                                                | 4            |
| 5           | 605 A         | Yielding Section Spring Adjusting Screw -----             | 1            |
| 6           | 65-96         | Spring Holder-----                                        | 1            |
| 7           | 16194         | Yielding Section Spring -----                             | 1            |
| 8           | 87 U          | Yielding Section Screw-----                               | 1            |
| 9           | 51730 G       | Shank -----                                               | 1            |
| 10          | 604           | Screw-----                                                | 1            |
| 11          | 16241         | Hinge Spring, right side -----                            | 1            |
| 12          | 22570         | Clamp Screw -----                                         | 2            |
| 13          | 22799 S       | Hinge Screw -----                                         | 2            |
| 14          | 51730 J       | Presser Foot Bottom, right -----                          | 1            |
| 15          | 51730 H       | Presser Foot Bottom, left -----                           | 1            |
| 16          | 16241 A       | Hinge Spring, left side-----                              | 1            |
| 17          | 7405 U-4 1/2  | Feed Dog, for No. 16 gauge on Style 51400 BE----          | 1            |
| 18          | 7528 H-4 1/2  | Throat Plate, for No. 16 gauge on Style 51400 BE-         | 1            |
| 19          | 7420 AG-4 1/2 | Presser Foot, for No. 16 gauge on<br>Style 51400 BE-----  | 1            |
| 20          | 22799 E       | Hinge Screw -----                                         | 1            |
| 21          | 51430 D       | Shank -----                                               | 1            |
| 22          | 91            | Clamp Screw -----                                         | 1            |
| 23          | 51430 F       | Adjusting Nut -----                                       | 1            |
| 24          | 22840 A       | Adjusting Screw-----                                      | 1            |
| 25          | 7405 AG-5     | Feed Dog, for No. 18 gauge on Style 51400 BE----          | 1            |
| 26          | 7424 AG-5     | Throat Plate, for No. 18 gauge on Style 51400 BE-         | 1            |
| 27          | 7420 AG-5     | Presser Foot, for No. 18 gauge on<br>Style 51400 BE-----  | 1            |
| 28          | 22799 E       | Hinge Screw -----                                         | 1            |
| 29          | 51430 D       | Shank -----                                               | 1            |
| 30          | 91            | Clamp Screw -----                                         | 1            |
| 31          | 51430 F       | Adjusting Nut -----                                       | 1            |
| 32          | 22840 A       | Adjusting Screw-----                                      | 1            |
| 33          | 7405 AF-5 1/2 | Feed Dog, for No. 24 gauge, on Style 51400 BE---          | 1            |
| 34          | 7424 AF-5 1/2 | Throat Plate, for No. 24 gauge, on<br>Style 51400 BE----- | 1            |
| 35          | 7420 AG-5 1/2 | Presser Foot, for No. 24 gauge, on<br>Style 51400 BE----- | 1            |
| 36          | 91            | Clamp Screw -----                                         | 1            |

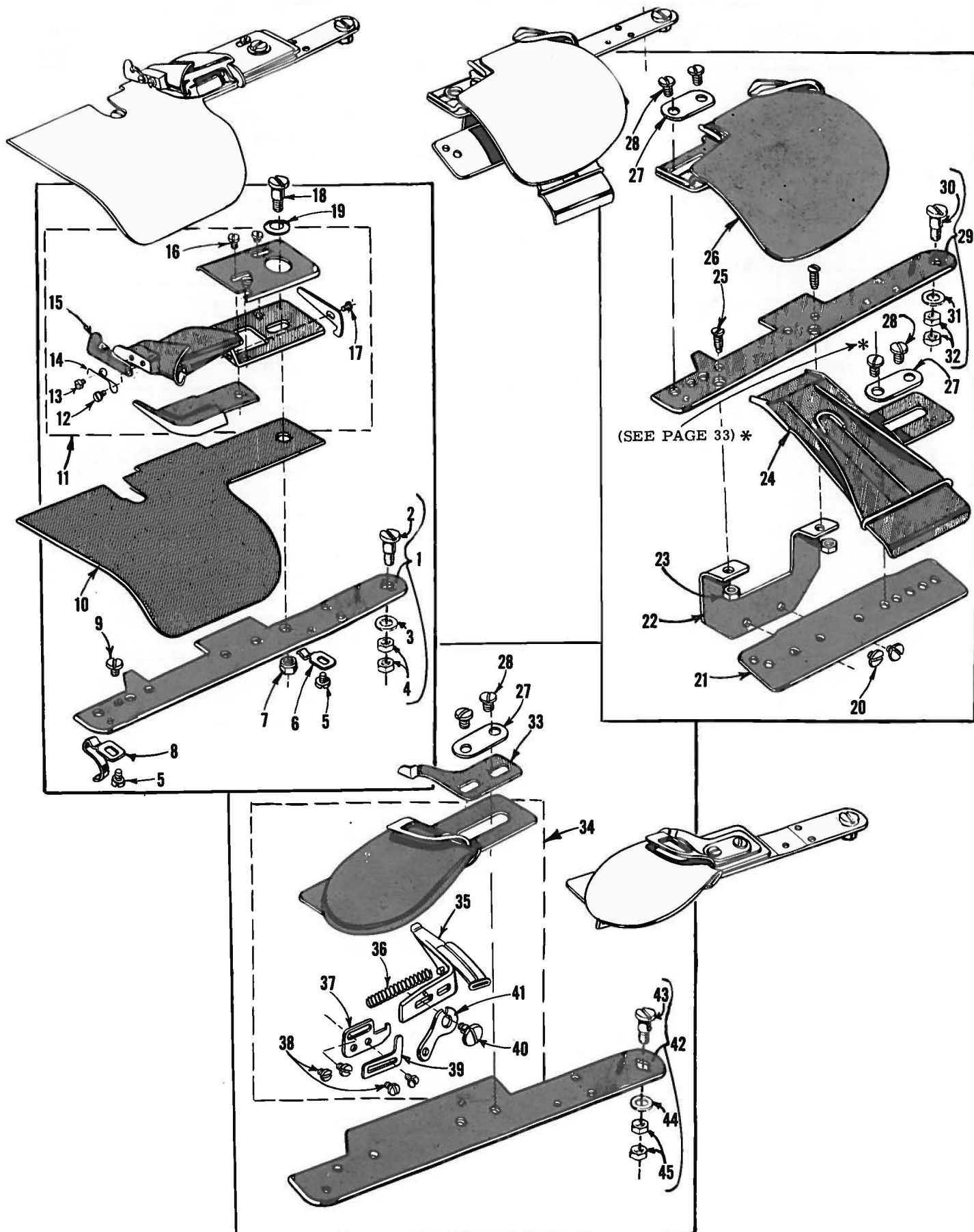




# FEED DOGS, THROAT PLATES, PRESSER FEET

| Ref.<br>No. | Part<br>No.      | Description                                                         | Amt.<br>Req. |
|-------------|------------------|---------------------------------------------------------------------|--------------|
| 1           | 51805-12-56-12   | Feed Dog, for No. 12-56-12 gauge on<br>Styles 51800 BA, BB-----     | 1            |
|             | 51805-12-64-12   | Feed Dog, for No. 12-64-12 gauge on<br>Styles 51800 BA, BB-----     | 1            |
| 2           | 51824-12-56-12   | Throat Plate, for No. 12-56-12 gauge on<br>Styles 51800 BA, BB----- | 1            |
|             | 51824-12-64-12   | Throat Plate, for No. 12-64-12 gauge on<br>Styles 51800 BA, BB----- | 1            |
| 3           | 51820-12-56-12   | Presser Foot, for No. 12-56-12 gauge on<br>Styles 51800 BA, BB----- | 1            |
|             | 51820-12-64-12   | Presser Foot, for No. 12-64-12 gauge on<br>Styles 51800 BA, BB----- | 1            |
| 4           | 22799 S          | Hinge Screw -----                                                   | 2            |
| 5           | 51830 B-12-56-12 | Presser Foot Bottom, left, for No. 12-56-12<br>gauge -----          | 1            |
|             | 51830 B-12-64-12 | Presser Foot Bottom, left, for No. 12-64-12<br>gauge -----          | 1            |
| 6           | 51830 C          | Plunger -----                                                       | 2            |
| 7           | 51830            | Shank -----                                                         | 1            |
| 8           | 22584            | Screw -----                                                         | 2            |
| 9           | 51830 D          | Equalizer-----                                                      | 1            |
| 10          | 22758            | Screw - -----                                                       | 1            |
| 11          | 51830 A-12-56-12 | Presser Foot Bottom, right, for No. 12-56-12<br>gauge -----         | 1            |
|             | 51830 A-12-64-12 | Presser Foot Bottom, right, for No. 12-64-12<br>gauge -----         | 1            |
| 12          | 51805-16-64-16   | Feed Dog, for No. 16-64-16 gauge on<br>Styles 51800 BA, BB-----     | 1            |
| 13          | 51824-16-64-16   | Throat Plate, for No. 16-64-16 gauge on<br>Styles 51800 BA, BB----- | 1            |
| 14          | 51820-16-64-16   | Presser Foot, for No. 16-64-16 gauge on<br>Styles 51800 BA, BB----- | 1            |
| 15          | 22799 S          | Hinge Screw -----                                                   | 2            |
| 16          | 51830 B-16-64-16 | Presser Foot Bottom, left, for No. 16-64-16<br>gauge -----          | 1            |
| 17          | 51830 C          | Plunger -----                                                       | 2            |
| 18          | 51830            | Shank -----                                                         | 1            |
| 19          | 22584            | Screw -----                                                         | 2            |
| 20          | 51830 D          | Equalizer-----                                                      | 1            |
| 21          | 22758            | Screw -----                                                         | 1            |
| 22          | 51830 A-16-64-16 | Presser Foot Bottom, right, for No. 16-64-16<br>gauge -----         | 1            |
| 23          | 51805-16-76-16   | Feed Dog, for No. 16-76-16 gauge on<br>Styles 51800 BA, BB-----     | 1            |
| 24          | 51824-16-76-16   | Throat Plate, for No. 16-76-16 gauge on<br>Styles 51800 BA, BB----- | 1            |
| 25          | 51820-16-76-16   | Presser Foot, for No. 16-76-16 gauge on<br>Styles 51800 BA, BB----- | 1            |
| 26          | 22799 S          | Hinge Screw -----                                                   | 2            |
| 27          | 51830 B-16-76-16 | Presser Foot Bottom, left, for No. 16-76-16<br>gauge -----          | 1            |
| 28          | 51830 C          | Plunger -----                                                       | 2            |
| 29          | 51830            | Shank -----                                                         | 1            |
| 30          | 22584            | Screw -----                                                         | 2            |
| 31          | 51830 D          | Equalizer-----                                                      | 1            |
| 32          | 22758            | Screw -----                                                         | 1            |
| 33          | 51830 A-16-76-16 | Presser Foot Bottom, right, for No. 16-76-16<br>gauge -----         | 1            |





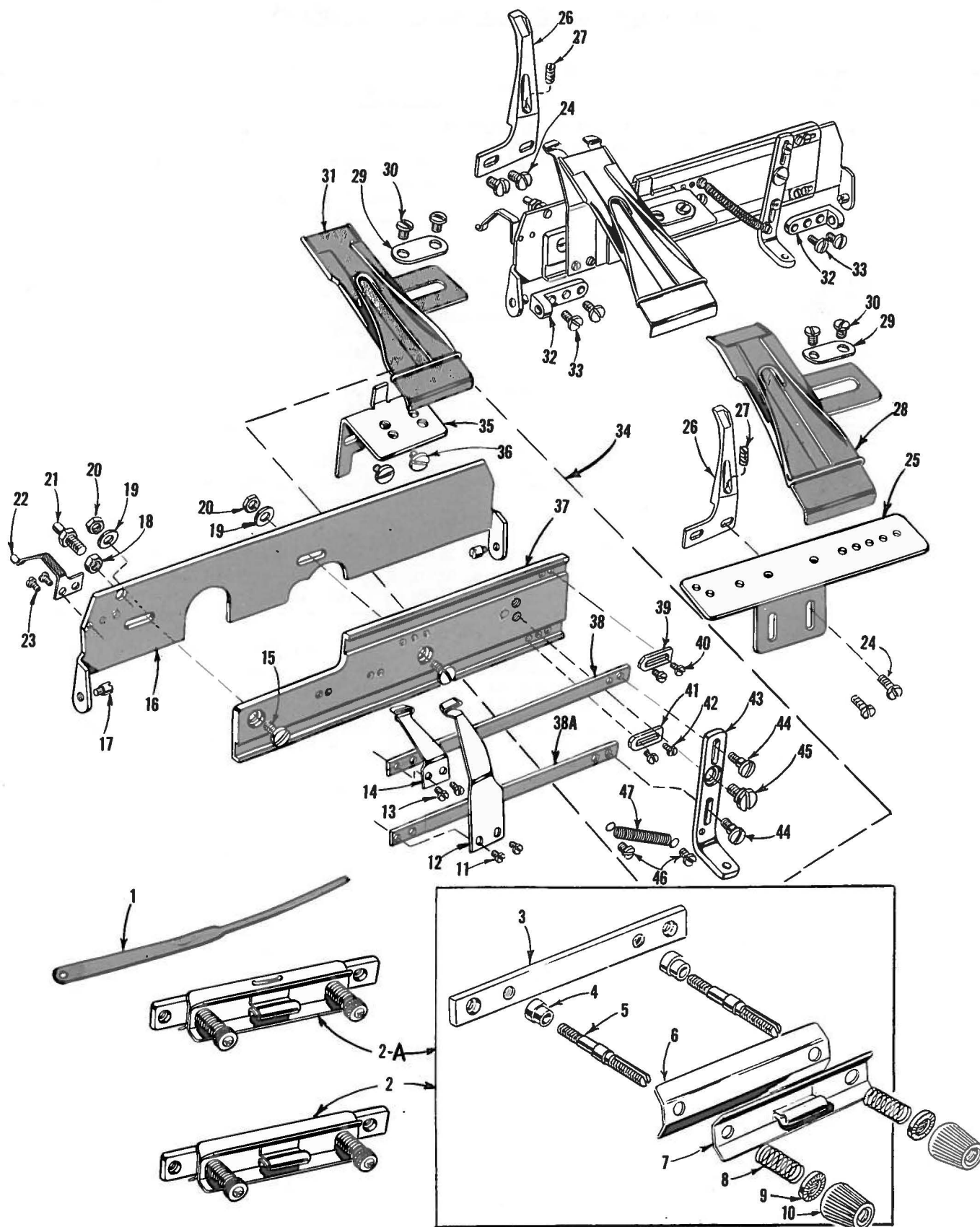
# ATTACHMENTS AND ATTACHING BRACKETS

| Ref.<br>No. | Part<br>No.     | Description                                                                                                                                             | Amt.<br>Req. |
|-------------|-----------------|---------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| 1           | 51864           | Folder Mounting Bracket, for Nos. 12-56-12, 12-64-12, 16-64-16 gauge on Style 51800 BA, BB -----                                                        | 1            |
|             | K72393          | Folder Mounting Bracket, for No. 16-76-16 gauge on Styles 51800 BA, BB -----                                                                            | 1            |
| 2           | 22504 A         | Pivot Screw -----                                                                                                                                       | 1            |
| 3           | 28577           | Washer -----                                                                                                                                            | 1            |
| 4           | 9937            | Nut -----                                                                                                                                               | 2            |
| 5           | 12986 B         | Screw -----                                                                                                                                             | 2            |
| 6           | 54264 B         | Spring -----                                                                                                                                            | 1            |
| 7           | 1280            | Nut, for 22854 on Styles 51800 BA, BB -----                                                                                                             | 1            |
| 8           | 54264 C         | Spring, with finger projection -----                                                                                                                    | 1            |
| 9           | 25 C            | Screw, for 23325 S -----                                                                                                                                | 1            |
| 10          | 23325 S         | Cloth Guard, for Styles 51800 BA, BB -----                                                                                                              | 1            |
| 11          | 23325 R-96-3/16 | Upper Folder, for turning edge of bib downwardly, 3/16 inch capacity, 3/8 inch fold, for Styles 51800 BA, BB -----                                      | 1            |
| 12          | 22561           | Screw -----                                                                                                                                             | 1            |
| 13          | 187 A           | Screw -----                                                                                                                                             | 1            |
| 14          | 23325 D         | Spring -----                                                                                                                                            | 1            |
| 15          | 23325 M         | Yielding Guide -----                                                                                                                                    | 1            |
| 16          | 22570           | Screw -----                                                                                                                                             | 3            |
| 17          | 87 U            | Screw -----                                                                                                                                             | 1            |
| 18          | 22854           | Pivot Screw, for 23325 S on Styles 51800 BA, BB -----                                                                                                   | 1            |
| 19          | HA86 B          | Spring Washer, for 22854 on Styles 51800 BA, BB -----                                                                                                   | 1            |
| 20          | 22730           | Screw, for 23293 R -----                                                                                                                                | 2            |
| 21          | 23293 R         | Folder Support, for Style 51700 BU -----                                                                                                                | 1            |
| 22          | 23293 S         | Folder Support Bracket, for Style 51700 BU -----                                                                                                        | 1            |
| 23          | 18              | Nut, for 80 -----                                                                                                                                       | 2            |
| 24          | 23293 P-96      | Lower Strip Folder, for attaching waistbands to trousers, 3/64 inch capacity, uses 2 1/2 inch strip, finishes 1 3/4 inch wide, for Style 51700 BU ----- | 1            |
| 25          | 80              | Screw, for 23293 S -----                                                                                                                                | 2            |
| 26          | 23325 T-120     | Upper Folder, for turning edge of garment downwardly, 5/32 inch capacity, 3/8 inch fold, for Style 51700 BU -----                                       | 1            |
| 27          | 23425 V         | Washer Plate -----                                                                                                                                      | 1            |
| 28          | 25 C            | Screw -----                                                                                                                                             | 2            |
| 29          | 51764           | Folder Mounting Bracket, for Style 51700 BU -----                                                                                                       | 1            |
| 30          | 22504 A         | Pivot Screw -----                                                                                                                                       | 1            |
| 31          | 28577           | Washer -----                                                                                                                                            | 1            |
| 32          | 9937            | Nut -----                                                                                                                                               | 2            |
| 33          | 7403 P          | Supplemental Edge Guide, for Style 51400 BE -----                                                                                                       | 1            |
| 34          | 23386 E-( )     | Reverse Hemmer, 1/16 inch capacity, 3/8 inch width of elastic, with shiftable elastic guide, for Style 51400 BE (See Chart Below)---                    | 1            |
| 35          | 23386 F         | Shiftable Elastic Guide -----                                                                                                                           | 1            |
| 36          | 75080 C         | Spring -----                                                                                                                                            | 1            |
| 37          | 23386 H         | Shiftable Elastic Guide Stop, right -----                                                                                                               | 1            |
| 38          | 22513           | Screw -----                                                                                                                                             | 4            |
| 39          | 23386 J         | Shiftable Elastic Guide Stop, left -----                                                                                                                | 1            |
| 40          | 22787 B         | Screw -----                                                                                                                                             | 1            |
| 41          | 23386 G         | Shiftable Elastic Guide Lever -----                                                                                                                     | 1            |
| 42          | 51464           | Folder Mounting Bracket, for Style 51400 BE -----                                                                                                       | 1            |
| 43          | 22504 A         | Pivot Screw -----                                                                                                                                       | 1            |
| 44          | 28577           | Washer -----                                                                                                                                            | 1            |
| 45          | 9937            | Nut -----                                                                                                                                               | 2            |

| ATTACHMENT NO. | WIDTH<br>OF HEM | MACHINE<br>GAUGE NUMBER | HEADING |
|----------------|-----------------|-------------------------|---------|
| 23386 E-7/16   | 7/16"           | 16                      | 1/8"    |
| 23386 E-15/32  | 15/32"          | 18                      | 1/8"    |
| 23386 E-1/2    | 1/2"            | 16                      | 3/16"   |
|                | 1/2"            | 18                      | 3/16"   |
| 23386 E-9/16   | 9/16"           | 16                      | 1/4"    |
| 23386 E-19/32  | 19/32"          | 18                      | 1/4"    |
| 23386 E-5/8    | 5/8"            | 24                      | 1/8"    |

\* NOTE: Two No. 28577 washers are required for use with No. 23293 P-96 folder.



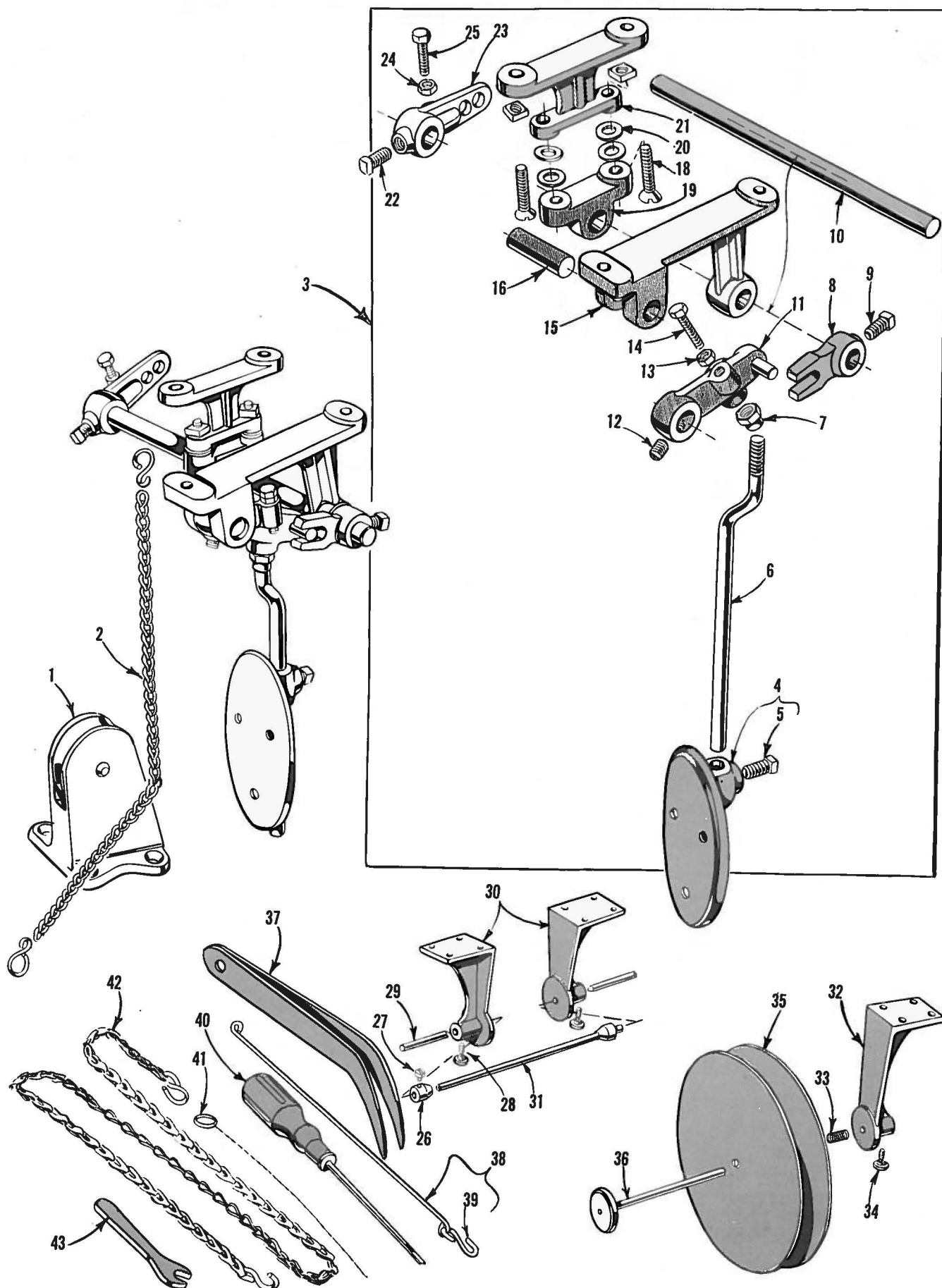


ATTACHMENTS, STRIP TENSIONS AND COLLAPSING MECHANISM

| Ref.<br>No. | Part<br>No. | Description                                                                                                                                                                    | Amt.<br>Req. |
|-------------|-------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| 1           | 23279 D     | Folder Threader, for Style 51700 BU-----                                                                                                                                       | 1            |
| 2           | 21182 N     | Strip Tension Assembly, for Styles 51700 BU, 51800 BA, BB-----                                                                                                                 | 1            |
| 2A          | 21182 T     | Strip Tension Assembly, for Style 51400 BE-----                                                                                                                                | 1            |
| 3           | 21182 P     | Strip Tension Base-----                                                                                                                                                        | 1            |
| 4           | 11261 B     | Tension Post Ferrule-----                                                                                                                                                      | 2            |
| 5           | 56392 E     | Tension Post-----                                                                                                                                                              | 2            |
| *6          | 21182 L     | Strip Tension Plate, inner, for 21182 N-----                                                                                                                                   | 1            |
| 7           | 21182 K     | Strip Tension Plate, outer-----                                                                                                                                                | 1            |
| 8           | 110-3       | Tension Spring-----                                                                                                                                                            | 2            |
| 9           | 39592 AK    | Tension Spring Ferrule-----                                                                                                                                                    | 2            |
| 10          | 39592 Z     | Tension Nut-----                                                                                                                                                               | 2            |
| 11          | 90          | Screw, for No. 23454 H-----                                                                                                                                                    | 2            |
| 12          | 23454 H     | Strip Collapsing Finger, left, for Style 51800 BA-----                                                                                                                         | 1            |
| 13          | 90          | Screw, for No. 23454 G-----                                                                                                                                                    | 2            |
| 14          | 23454 G     | Strip Collapsing Finger, right, for Style 51800 BA-----                                                                                                                        | 1            |
| 15          | 22548       | Screw, for No. 23454 on Style 51800 BA-----                                                                                                                                    | 2            |
| 16          | 23454 J     | Collapsing Device Mounting Bracket, for Style 51800 BA-----                                                                                                                    | 1            |
| 17          | 402         | Hinge Pin, for No. 23454 J-----                                                                                                                                                | 2            |
| 18          | 258         | Nut, for No. 4952 C-----                                                                                                                                                       | 1            |
| 19          | 21657 E     | Washer, for No. 22548-----                                                                                                                                                     | 2            |
| 20          | 12538       | Nut, for No. 22548-----                                                                                                                                                        | 2            |
| 21          | 4952 C      | Stud Stop for Collapsing Mechanism, for Style 51800 BA-----                                                                                                                    | 1            |
| 22          | 23454 L     | Strip Collapsing Device Mounting Bracket Latch Spring, for Style 51800 BA-----                                                                                                 | 1            |
| 23          | 90          | Screw, for No. 23454 L-----                                                                                                                                                    | 2            |
| 24          | 22548       | Screw, for No. 51880 on Styles 51800 BA, BB-----                                                                                                                               | 2            |
| 25          | 23293 N     | Folder Support, for Style 51800 BB-----                                                                                                                                        | 1            |
| 26          | 51880       | Supplementary Throat Plate Support, for Styles 51800 BA, BB-----                                                                                                               | 1            |
| 27          | 12935 A     | Adjusting Screw, for No. 51880-----                                                                                                                                            | 1            |
| 28          | 23293 D-80  | Lower Strip Folder, for attaching bibs to overalls, 1/16 inch capacity,<br>uses 2 inch strip, finishes 1 3/8 inch wide, for No. 12-56-12 gauge on<br>Style 51800 BB-----       | 1            |
|             | 23293 D-88  | Lower Strip Folder, for attaching bibs to overalls, 1/16 inch capacity,<br>uses 2 1/8 inch strip, finishes 1 1/2 inch wide, for No. 12-64-12 gauge<br>on Style 51800 BB-----   | 1            |
|             | 23293 D-96  | Lower Strip Folder, for attaching bibs to overalls, 1/16 inch capacity,<br>uses 2 1/4 inch strip, finishes 1 5/8 inch wide, for No. 16-64-16 gauge<br>on Style 51800 BB-----   | 1            |
|             | 23293 D-108 | Lower Strip Folder, for attaching bibs to overalls, 1/16 inch capacity,<br>uses 2 1/2 inch strip, finishes 1 13/16 inch wide, for No. 16-76-16 gauge<br>on Style 51800 BB----- | 1            |
| 29          | 23425 V     | Washer Plate-----                                                                                                                                                              | 1            |
| 30          | 25 C        | Screw-----                                                                                                                                                                     | 2            |
| 31          | 23293 M-80  | Lower Strip Folder, for attaching bibs to overalls, 3/64 inch capacity,<br>uses 2 1/8 inch strip, finishes 1 7/16 inch wide, for No. 12-56-12 gauge<br>on Style 51800 BA-----  | 1            |
|             | 23293 M-88  | Lower Strip Folder, for attaching bibs to overalls, 3/64 inch capacity,<br>uses 2 1/16 inch strip, finishes 1 9/16 inch wide, for No. 12-64-12 gauge<br>on Style 51800 BA----- | 1            |
|             | 23293 M-96  | Lower Strip Folder, for attaching bibs to overalls, 3/64 inch capacity,<br>uses 2 1/4 inch strip, finishes 1 11/16 inch wide, for No. 16-64-16 gauge<br>on Style 51800 BA----- | 1            |
|             | 23293 M-108 | Lower Strip Folder, for attaching bibs to overalls, 3/64 inch capacity,<br>uses 2 1/2 inch strip, finishes 1 7/8 inch wide, for No. 16-76-16 gauge<br>on Style 51800 BA-----   | 1            |
| 32          | 23454 M     | Strip Collapsing Device Mounting Bracket Hinge Block, for Style 51800 BA-----                                                                                                  | 2            |
| 33          | 22548       | Screw, for No. 23454 M-----                                                                                                                                                    | 4            |
| 34          | 23454       | Strip Collapsing Device, for Style 51800 BA-----                                                                                                                               | 1            |
| 35          | 23454 B     | Strip Collapsing Device Folder Support-----                                                                                                                                    | 1            |
| 36          | 255         | Screw-----                                                                                                                                                                     | 2            |
| 37          | 23454 A     | Strip Collapsing Device Frame-----                                                                                                                                             | 1            |
| 38          | 23454 E     | Strip Collapsing Device Finger Operating Arm, lower-----                                                                                                                       | 1            |
| 38A         | 23454 D     | Strip Collapsing Device Finger Operating Arm, upper-----                                                                                                                       | 1            |
| 39          | 23454 F     | Strip Collapsing Device Finger Operating Arm Stop, adjustable-----                                                                                                             | 1            |
| 40          | 90          | Screw-----                                                                                                                                                                     | 2            |
| 41          | 23454 F     | Strip Collapsing Device Finger Operating Arm Stop, adjustable-----                                                                                                             | 1            |
| 42          | 90          | Screw-----                                                                                                                                                                     | 2            |
| 43          | 23454 C     | Strip Collapsing Device Operating Lever-----                                                                                                                                   | 1            |
| 44          | HA65 L      | Screw-----                                                                                                                                                                     | 2            |
| 45          | 22715       | Screw-----                                                                                                                                                                     | 1            |
| 46          | 90          | Screw-----                                                                                                                                                                     | 2            |
| 47          | 9471        | Spring-----                                                                                                                                                                    | 1            |

\* No part number available for Assembly No. 21182 T

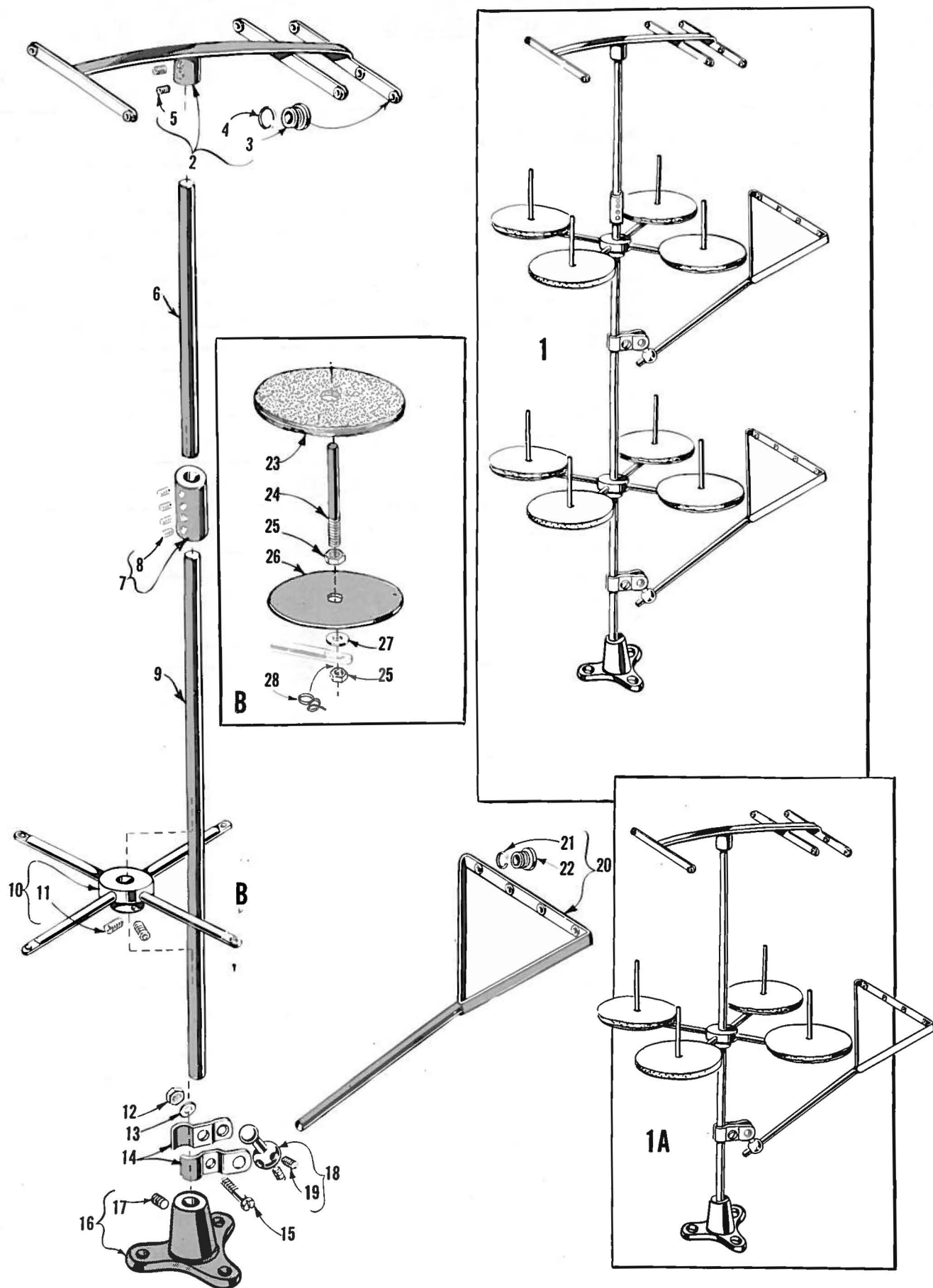




# ACCESSORIES

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                                        | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|---------------------------------------------------------------------------|----------------------|
| 1                   | 660-167             | Idler Pulley, for Style 51800 BA-----                                     | 1                    |
| 2                   | 21693 L             | Knee Press Chain, for Style 51800 BA -----                                | 1                    |
| 3                   | 21693 A             | Knee Press Assembly, for collapsing mechanism<br>on Style 51800 BA -----  | 1                    |
| 4                   | 21685               | Knee Press Plate-----                                                     | 1                    |
| 5                   | 69 FD               | Set Screw -----                                                           | 1                    |
| 6                   | 21693 J             | Knee Press Plate Rod-----                                                 | 1                    |
| 7                   | 15430 D             | Nut -----                                                                 | 1                    |
| 8                   | 21693 F             | Knee Press Interlocking Lever, left -----                                 | 1                    |
| 9                   | 69 FD               | Set Screw-----                                                            | 1                    |
| 10                  | 21693 B             | Knee Press Shaft -----                                                    | 1                    |
| 11                  | 21693 G             | Knee Press Interlocking Lever, right-----                                 | 1                    |
| 12                  | 22622               | Set Screw-----                                                            | 1                    |
| 13                  | 34                  | Nut -----                                                                 | 1                    |
| 14                  | 12993 A             | Stop Screw-----                                                           | 1                    |
| 15                  | 21693 C             | Knee Press Shaft Bracket, front -----                                     | 1                    |
| 16                  | 21693 H             | Knee Press Interlocking Lever Shaft-----                                  | 1                    |
| 18                  | 650-10              | Stove Bolt -----                                                          | 2                    |
| 19                  | 21693 D             | Knee Press Shaft Bracket, rear-----                                       | 1                    |
| 20                  | 28577               | Washer-----                                                               | 4                    |
| 21                  | 21693 T             | Knee Press Shaft Hanger Spacing Block -----                               | 1                    |
| 22                  | 69 FD               | Set Screw-----                                                            | 1                    |
| 23                  | 21693 K             | Knee Press Chain Lever -----                                              | 1                    |
| 24                  | 34                  | Nut -----                                                                 | 1                    |
| 25                  | 12993 A             | Stop Screw-----                                                           | 1                    |
| 26                  | 753                 | Spool Support Cone, adjustable, for Style 51400 BE----                    | 1                    |
| 27                  | 188 D               | Screw, for No. 753 -----                                                  | 1                    |
| 28                  | 201 C               | Screw, for No. 201 A -----                                                | 2                    |
| 29                  | 751                 | Center Pin, for Style 51400 BE-----                                       | 2                    |
| 30                  | 201 A               | Spool Axle Support, for Style 51400 BE-----                               | 2                    |
| 31                  | 21218               | Spool Axle, for Style 51400 BE -----                                      | 1                    |
| 32                  | 21179               | Lower Tape Holder Frame, for Styles 51700 BU,<br>51800 BA, BB-----        | 1                    |
| 33                  | 110-4               | Tension Spring, for Style 51800 BA, BB-----                               | 1                    |
|                     | 110-3               | Tension Spring, for Style 51700 BU -----                                  | 1                    |
| 34                  | 201 C               | Thumbscrew, for Styles 51700 BU, 51800 BA, BB-----                        | 1                    |
| 35                  | 21178 A             | Tape Holder Disc, for Styles 51700 BU,<br>51800 BA, BB-----               | 2                    |
| 36                  | 21385 B             | Lower Tape Holder Axle, for Styles 51700 BU,<br>51800 BA, BB-----         | 1                    |
| 37                  | 660-240             | Thread Tweezers -----                                                     | 1                    |
| 38                  | 51493 BC            | Lifter Link-----                                                          | 1                    |
| 39                  | 660-264             | Hook -----                                                                | 1                    |
| 40                  | 21201               | Screwdriver, 9/64 inch round blade, length over-all<br>7 5/8 inches ----- | 1                    |
| 41                  | 51899               | Thread Wire, for Styles 51800 BA, BB-----                                 | 1                    |
| 42                  | 421 D-28            | Treadle Chain -----                                                       | 1                    |
| 43                  | 21388               | Wrench, single end, 3/8 inch opening -----                                | 1                    |





# THREAD STANDS

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                             | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|----------------------------------------------------------------|----------------------|
| 1                   | 21101 P-8           | Thread Stand, complete, for Styles 51800 BA, BB ----           | 1                    |
| 1A                  | 21101 H-4           | Thread Stand, complete, for Styles 51400 BE,<br>51700 BU ----- | 1                    |
| 2                   | 21114 H-4           | Eyelet Support-----                                            | 1                    |
| 3                   | 21114 L             | Eyelet-----                                                    | 8                    |
| 4                   | 21114 M             | Eyelet Locking Ring -----                                      | 8                    |
| 5                   | 22651 CD-4          | Screw -----                                                    | 2                    |
| 6                   | 21104 B-11          | Thread Stand Rod, upper, for No. 21101 P-8 ----                | 1                    |
| 7                   | 21127               | Coupling, for No. 21101 P-8 -----                              | 1                    |
| 8                   | 22651 CD-3          | Screw -----                                                    | 4                    |
| 9                   | 21104 B-24          | Thread Stand Rod, lower, for No. 21101 P-8 ----                | 1                    |
|                     |                     | Thread Stand Rod, for No. 21101 H-4 -----                      | 1                    |
| 10                  | 21114 D-4           | Spool Seat Support, for No. 21101 P-8 -----                    | 2                    |
|                     |                     | Spool Seat Support, for No. 21101 H-4 -----                    | 1                    |
| 11                  | 22651 CD-5          | Screw, for No. 21101 P-8 -----                                 | 4                    |
|                     |                     | Screw, for 21101 H-4 -----                                     | 2                    |
| 12                  | 21104 H             | Nut, for No. 21101 P-8-----                                    | 2                    |
|                     |                     | Nut, for No. 21101 H-4-----                                    | 1                    |
| 13                  | 652-16              | Washer, for No. 21101 P-8 -----                                | 2                    |
|                     |                     | Washer, for No. 21101 H-4 -----                                | 1                    |
| 14                  | 21114 U             | Lead Eyelet Ball Split Socket, for No. 21101 P-8--             | 4                    |
|                     |                     | Lead Eyelet Ball Split Socket, for No. 21101 H-4--             | 2                    |
| 15                  | 22810               | Screw, for No. 21101 P-8 -----                                 | 2                    |
|                     |                     | Screw, for No. 21101 H-4 -----                                 | 1                    |
| 16                  | 21114 A             | Thread Stand Base -----                                        | 1                    |
| 17                  | 22651 CD-3          | Screw -----                                                    | 1                    |
| 18                  | 21114 T             | Lead Eyelet Socket Ball, for No. 21101 P-8 -----               | 2                    |
|                     |                     | Lead Eyelet Socket Ball, for No. 21101 H-4 -----               | 1                    |
| 19                  | 22651 CD-4          | Screw, for No. 21101 P-8 -----                                 | 4                    |
|                     |                     | Screw, for No. 21101 H-4 -----                                 | 2                    |
| 20                  | 21114 S-4           | Lead Eyelet, for No. 21101 P-8 -----                           | 2                    |
|                     |                     | Lead Eyelet, for No. 21101 H-4 -----                           | 1                    |
| 21                  | 21114 M             | Eyelet Locking Ring, for No. 21101 P-8 -----                   | 8                    |
|                     |                     | Eyelet Locking Ring, for No. 21101 H-4 -----                   | 4                    |
| 22                  | 21114 L             | Eyelet, for No. 21101 P-8-----                                 | 8                    |
|                     |                     | Eyelet, for No. 21101 H-4-----                                 | 4                    |
| 23                  | 21104 V             | Felt Pad, for No. 21101 P-8 -----                              | 8                    |
|                     |                     | Felt Pad, for No. 21104 H-4 -----                              | 4                    |
| 24                  | 21114 W             | Spool Pin, for No. 21101 P-8 - -----                           | 8                    |
|                     |                     | Spool Pin, for No. 21104 H-4 -----                             | 4                    |
| 25                  | 258 A               | Nut, for No. 21101 P-8-----                                    | 16                   |
|                     |                     | Nut, for No. 21104 H-4-----                                    | 8                    |
| 26                  | 21114               | Spool Seat Disc, for No. 21101 P-8 -----                       | 8                    |
|                     |                     | Spool Seat Disc, for No. 21104 H-4-----                        | 4                    |
| 27                  | 652-16              | Washer, for No. 21101 P-8 -----                                | 8                    |
|                     |                     | Washer, for No. 21104 H-4 -----                                | 4                    |
| 28                  | 21114 AF            | Eyelet, for No. 21101 P-8 -----                                | 8                    |



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| 27-484 Blk | 15          | 660-614  | 15       | 21182 L  | 35         | 22729 A  | 13         |
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| 50-648 Blk | 13          | 666-149  | 15, 19   | 21375 AH | 11         | 22757    | 25         |
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| 27         |             | 7947     | 13       | 22519 C  | 19         | 22889 A  | 11         |
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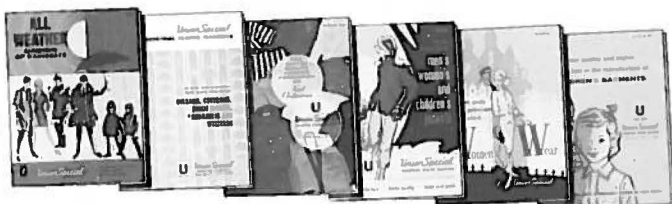
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Helpful, authoritative information on the most efficient types of equipment for making virtually any machine sewed article is available from Union Special Sales Promotion Department. Among the many interesting, illustrated bulletins that are available without obligation are the following:

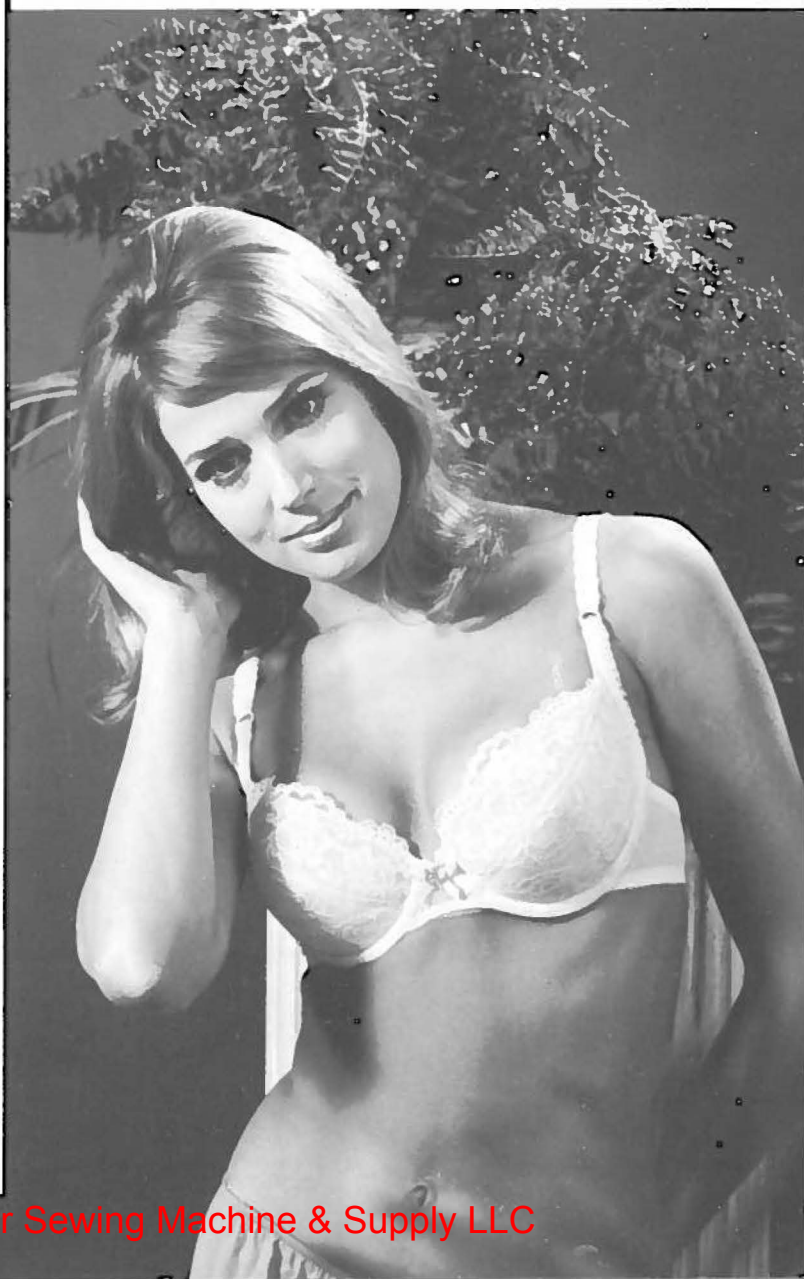


- No. 240, "Men's, Women's, Children's Footwear"
- No. 249, "Rainwear"
- No. 250, "Men's Dress Shirts"
- No. 251, "Service Shirts and Pants"
- No. 252, "Men's Shorts and Pajamas"
- No. 253, "Overalls, Coveralls, and Dungarees"
- No. 254, "Men's Knit Underwear"
- No. 256, "Knit Outerwear"
- No. 259, "Men's 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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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<br>(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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