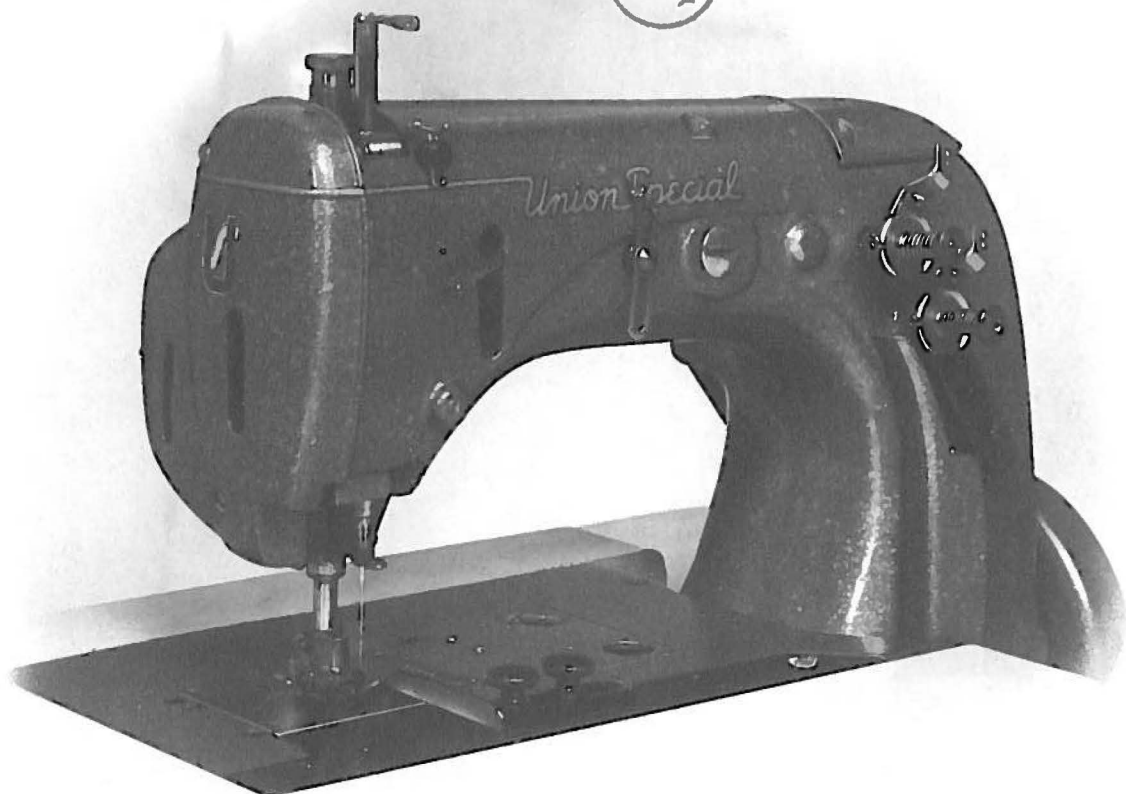


BEST QUALITY

Union Special[®]
LEWIS • COLUMBIA

INDUSTRIAL
SEWING
MACHINES



STYLES

4600AA

4600AB

4600AD

CLASS 54600

STREAMLINED

HIGH SPEED

SINGLE NEEDLE

NEEDLE FEED MACHINES

Union Special MACHINE COMPANY

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

CATALOG

No.

120 A M

Catalog No. 120 AM

INSTRUCTIONS

FOR

ADJUSTING AND OPERATING

AND

LIST OF PARTS

FOR

CLASS 54600

Styles

54600 AA 54600 AB
 54600 AD

First Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U.S.A.

May, 1972

IDENTIFICATION OF MACHINES

Each Union Special machine is identified by a Style number which is stamped into 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 54600 AB". 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 54600 ABZ".

Styles of machines similar in construction are grouped under a class number which differs from the style number, in that it contains no letters. Example: "Class 54600".

APPLICATION OF CATALOG

This catalog applies specifically to the Standard Styles of machines as listed herein. It can also be applied with discretion to some Special Styles of machines in this Class. Reference to direction, such as right, left, front, back, etc., are given from the operator's position while seated at the machine. Operating direction of handwheel is toward the operator.

STYLES OF MACHINES

Streamlined Flat Bed, Single Needle, Independent Row, Needle Feed, High Throw, Double Disc Take-up, Needle Bearing Crankshaft, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump and Oil Siphon Assembly, Loopers in Line With Feed and Looper Throw-out for Simplified Threading, Maximum Work Space to Right of Needle Bar 7 3/4 Inches.

54600 AA For binding on mattresses and general purpose seaming on light to medium weight work. Machine has throw-out binder. Seam specification 401-BSa-1. Type 130 GHS needle. Uses selvage edge binding 5/8, 3/4 and 7/8 inch wide and produces 5/16, 3/8 and 7/16 inch finish respectively. Maximum recommended speed 5000 R. P. M.

54600 AB For miscellaneous seaming operations on light to medium weight materials. Edge guide, hinged presser foot with a yielding section behind the needle and a "U" type feed dog with no feed directly in front of the needle. Seam specification 401-SSa-1. Type 130 GHS needle. Maximum recommended speed 5000 R. P. M.

54600 AD For miscellaneous seaming operations on light to medium weight materials. Edge guide, hinged presser foot with a yielding section behind the needle and a box type feed dog. Seam specification 401-SSa-1. Type 130 GHS needle. Maximum recommended speed 5000 R. P. M.

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.

The standard recommended needle for machines in Class 54600 is Type 130 GHS. It has a round shank, round point, short length, short blade 1/8 inch less than standard, ball eye, width of eye and groove undersize with a one step reduction, double groove, struck groove, spotted, ball point, government point, chromium plated and is available in sizes 032, 036, 040, 044, 049, 054.

NEEDLES (Continued)

To have needle orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. Use description on label. A complete order would read: "1000 Needles, Type 130 GHS, Size 036".

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

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 Union Special Machine Company, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles and are made with the utmost precision. Maximum efficiency and durability are assured.

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

TERMS

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

OILING AND THREADING

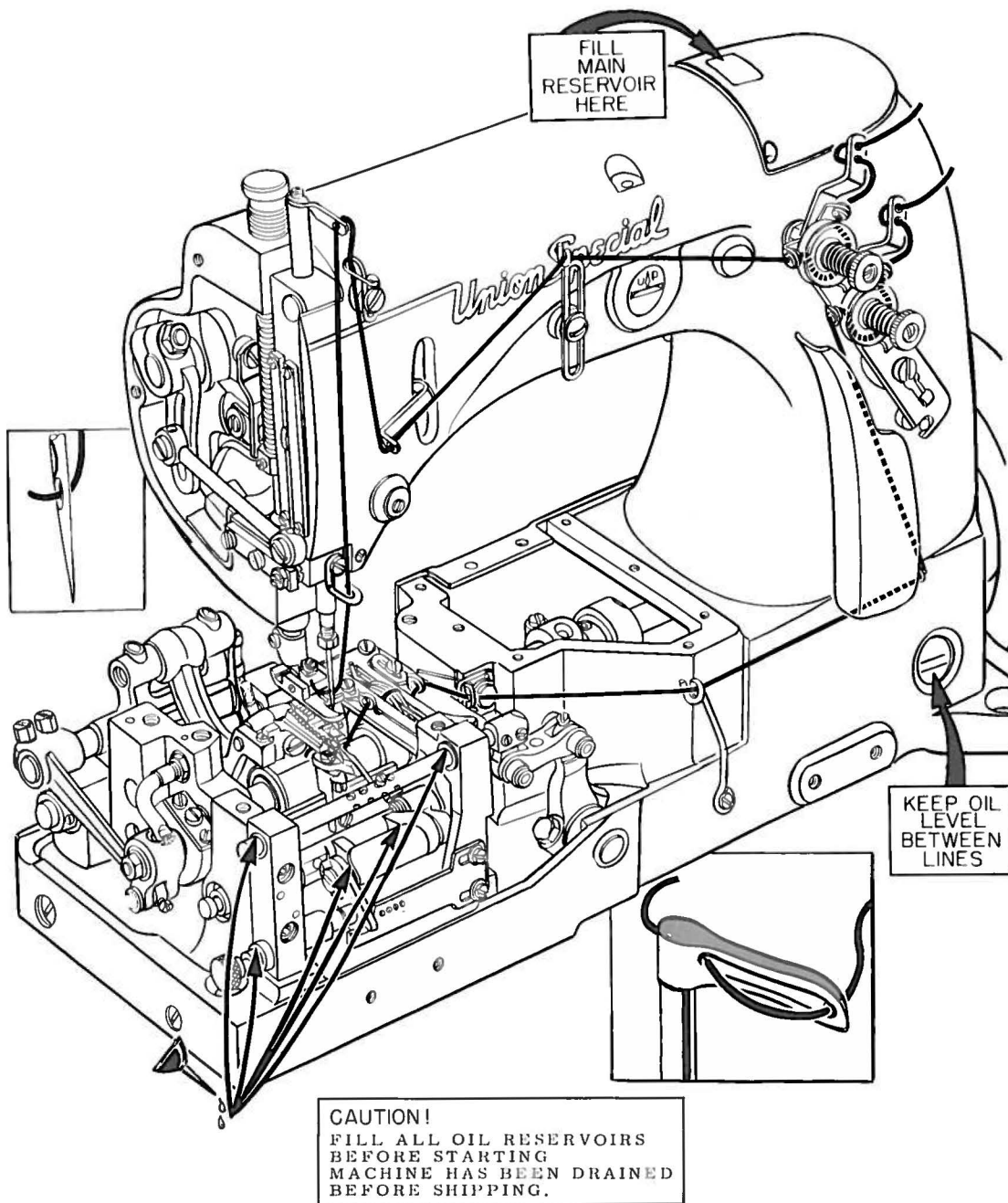
The oil has been drained from the machine before shipping and the reservoir must be filled before beginning to operate. Use a straight mineral oil with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit.

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

The machine is almost entirely automatically lubricated, and no oiling, other than an occasional drop of oil at both bearings of the retainer holder, the looper throw-out pin and looper holder frame locking pin, as indicated in oiling diagram, is required.

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 shows the manner in which these machines are threaded. Please note that the needle is inserted in the needle holder with the eye in a plane at right angles to the direction of line of feed and is threaded from right to left.



THREADING AND OILING DIAGRAM

Thread as indicated. The needle and looper threading have been enlarged for clarity. Please note that the needle is inserted in the needle holder with the eye in a plane at right angles to the direction of line of feed, (spot or scarf to the left) and is threaded from right to left.

Use a straight mineral oil of a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit. This is equivalent to Union Special Specification No. 174. Fill reservoir where indicated and keep oil level between lines on gauge. Add an occasional drop of oil at both bearings of the retainer holder, the looper throw-out pin and the looper holder frame locking pin, as indicated by the oil can. Excessive oil in the main reservoir may be drained at the plug screw in the main frame directly under the hand-wheel.

INSTRUCTIONS FOR MECHANICS

NEEDLE LEVER STUD SETTING

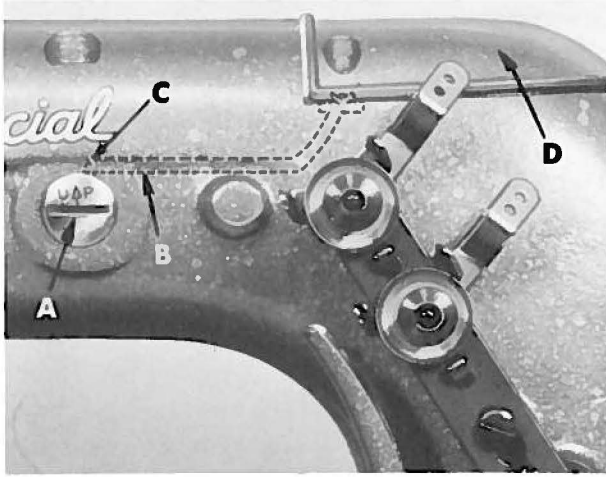


Fig. 1

Observe location of needle lever stud (A, Fig. 1). The head of the needle lever stud is marked with an arrow and the word "UP". These studs are set correctly when arrow points vertically up. Also check the position of the needle lever bearing oiler (B) inside the arm casting, which lubricates the needle lever stud. Make sure it is tilted downwardly and that its delivery end (C) contacts the inside wall of the bed casting at the back, just above the notch of the needle lever shaft stop collar.

OILING SYSTEM

Clean machine thoroughly. Fill oiling system and run machine slowly for a minute to allow oil wicks to carry oil to the bearings. Then recheck the oil in the oil-

ing system and run machine for five minutes at 4500 R.P.M. Inspect oiling system for leaks.

SETTING THE NEEDLE LOCATION, HEIGHT AND TRAVEL

Before making any adjustment, remove top crank chamber cover (D, Fig. 1) and check to see that both ends of spacing washer (C, Fig. 2) are seated in the slot of rocker shaft lever (D). If the spacing washer is seated properly, this will locate the centerline of the upper needle feed connecting rod ball joint (A, Fig. 2), $\frac{7}{32}$ to $\frac{1}{4}$ inch in back of the centerline of the needle lever connecting rod assembly (B).

NOTE: When spacing washer (C, Fig. 2) is properly seated, this will prevent the upper needle feed connecting rod ball joint from moving and also set it properly.

To establish the correct location of the needle bar when the needle bar is at the bottom of its travel, use gauge No. 21227 BT (A, Fig. 3). Loosen nut on needle feed

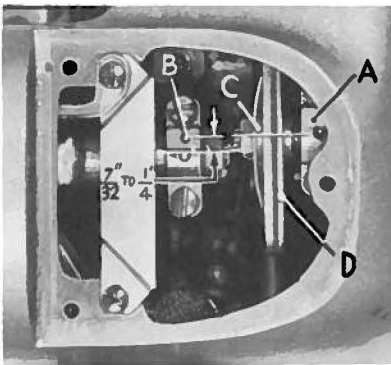


Fig. 2

drive lever (D, Fig. 4). Place gauge 21227 BT on presser bar (B, Fig. 3) with part number up. Rotate gauge in a counterclockwise direction so the shortest surface slips between the presser bar (B) and the needle bar (C) and the longest surface stops against the needle bar. With the needle bar at the bottom of its travel, hold needle bar firmly against the gauge and retighten nut (D, Fig. 4)

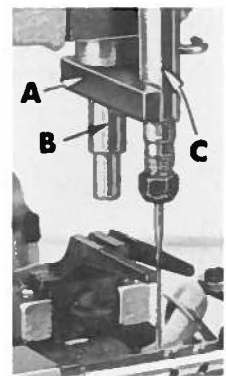


Fig. 3

Using type 130 GHS needle, set the height of the needle bar so that the top of the eye is $\frac{1}{64}$ inch below the underside of the looper, with the looper point

flush with the front of the needle (Fig. 5). Loosen screw (E, Fig. 4) and move needle bar up or down as required and then retighten screw.

SETTING THE NEEDLE LOCATION, HEIGHT AND TRAVEL (Continued)

Set the needle travel at $9/64$ inch, which is approximately $7\frac{1}{2}$ stitches per inch. To set the needle travel, loosen screw (A, Fig. 4) and slide link (B) up or down, so the centerline of screw (A) is located $5/8$ inch above the bottom of slot in needle feed drive lever (C, Fig. 4). Retighten screw (A).

SETTING LOOPER AND LOOPER HOLDER

Insert a new needle, Type 130 GHS, size as specified. Spot or scarf of needle must be to the left.

Assemble looper holder with stationary needle guard (A, Fig. 6) onto looper holder frame (B) and adjust the stationary needle guard so it is just brought up to the needle. Assemble the adjustable needle guard (C) and looper (D) onto looper holder and set so that the right edge of the looper is in line with the stationary needle guard. The distance between the stationary needle guard and the adjustable needle guard to be the same as the large shank section of a needle. Adjust proportionally smaller for smaller than size .049 or .054 needles.

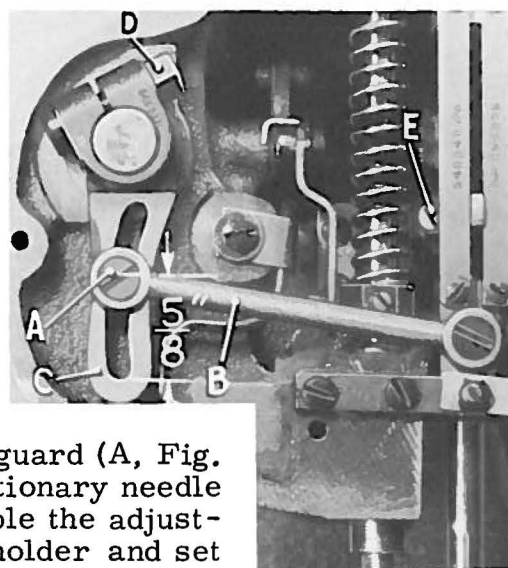


Fig. 4

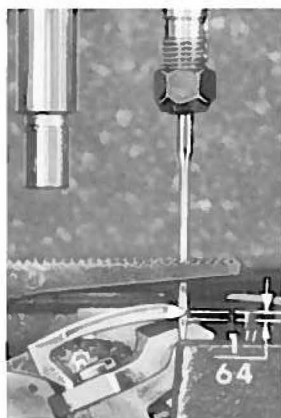


Fig. 5

Set looper holder frame (B, Fig. 6) so the distance between the centerline of the needle (A, Fig. 7) and point of looper (B) is $5/32$ inch when looper is at its extreme rear position and the needle is at bottom of its travel. Accomplish this by loosening the hexagonal head clamp screw (E, Fig. 6) and moving the holder forward or backward as required and tighten screw. Looper gauge No. 21225- $5/32$ (C, Fig. 7) can be used advantageously in making this adjustment. When the looper moves forward its point should pass the left side of the needle and set so the looper brushes but does not pick at the needle.

With the looper point toward the operator, the looper should be seated in looper holder as far down as it will go. The looper may be released to the threading position by pulling the looper holder frame locking pin (A, Fig. 8) to the left when the needle is at the high point of travel. It is returned to the operating position by merely pushing it back until it snaps into the locking position. The right side of the looper (D, Fig. 6) should be at right angles to the centerline of the retainer holder shaft (F). Adjust looper thread eyelet (G, Fig. 6) by loosening two screws (H) and move stop from left to right to prevent the looper from being released to the threading position unless needle point is above the throat plate.

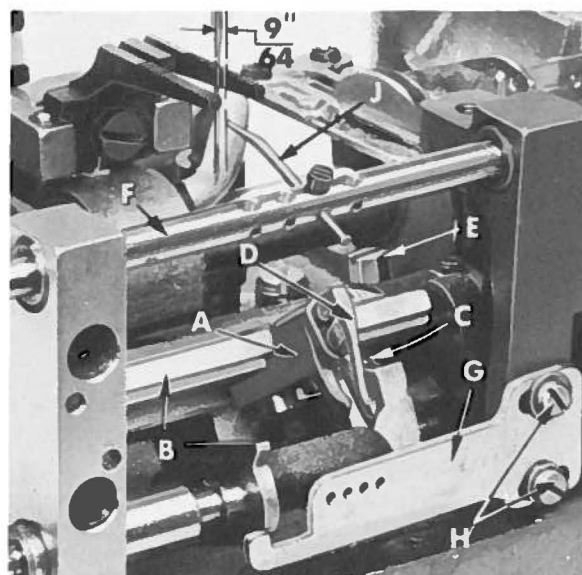


Fig. 6

CHECKING THE NEEDLE-LOOPER TIMING

The mechanical construction and the time flats, together with the adjustments under "Setting The Needle Location, Height and Travel" and "Setting Looper and Looper Holder", produces the needle-looper timing.

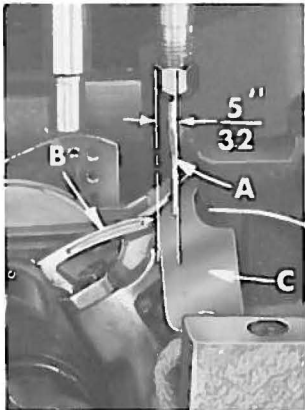


Fig. 7

The needle-looper timing may be checked only at $9/64$ inch needle travel. To check the timing, turn the handwheel in the operating direction until the centerline of the needle is at the centerline of the looper eye. On both the upstroke and the downstroke of the needle, the bottom of the needle eye should be equal distance above the top of the looper blade, as in Fig. 9.

If for any reason the machine has been disassembled or retiming is necessary follow the instructions under, "Setting The Needle Location, Height and Travel" and "Setting Looper and Looper Holder".

SETTING THE RETAINER

Insert the retainer (J, Fig. 6) in the retainer holder bar (F) with the tip of the notched end $9/64$ inch from the needle when the needle bar is at the bottom of its stroke, the notch should be to the right and in a vertical position. Loosen screws in the retainer holder bar connection (A, Fig. 10) and rock the retainer bar so the underside of the retainer is as close as possible to the top of the looper, without contact. Turn the handwheel in the operating direction until the eye of the looper is directly below the point of the retainer. Then, move the retainer holder bar (F, Fig. 6) to the right or left so that the right tip of the retainer lines up with the left side of the looper eye.

NOTE: When using needles larger than size .040 it may be necessary to set the retainer further to the right, but do not set the right side of the retainer beyond the right side of the looper.

SETTING THE FEED DOG

Set the feed dog (A, Fig. 11) with tips of teeth parallel with and project their full depth above the throat plate (B) at high point of travel. Adjust feed dog support screws (C) under back of feed dog to maintain this setting. These screws are also used to level the feed dog across the line of feed.

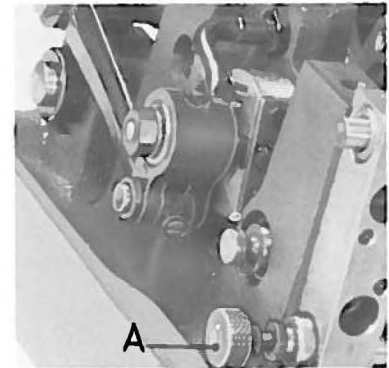


Fig. 8

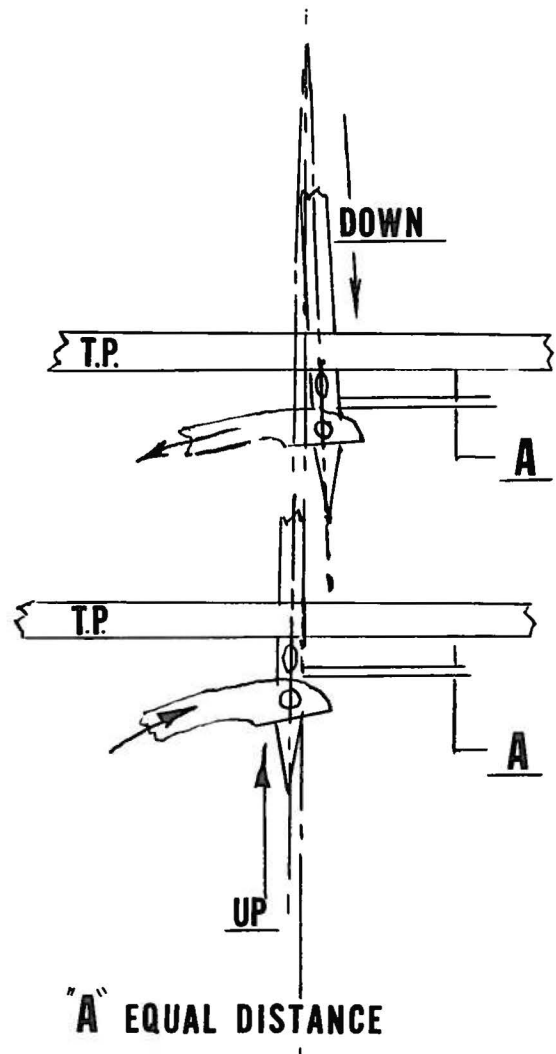


Fig. 9

SETTING THE FEED DOG (Continued)

To tilt feed dog in line of feed and move front tooth (D, Fig. 11) down, turn screw (A, Fig. 12) clockwise and screw (B) counterclockwise. Reverse direction of two screws to raise front tooth. Normal setting is all teeth level with throat plate when feed is at high point of lift.

Space the feed dog so there is a clearance of about $\frac{1}{64}$ inch on the sides and between front of needle hole and needle. This is accomplished by loosening the screws (C, Fig. 13) which clamp the feed rocker arm to the feed rocker (D) and moving the feed rocker forward or backward as needed. Tighten screws securely after proper setting has been attained. Should it be necessary to move the feed dog to the left or right, loosen screws (B, Fig. 10) which hold the feed rocker to the feed rocker shaft and move feed rocker to desired position and retighten screws. Make sure that the feed rocker arm does not bind after making this adjustment.

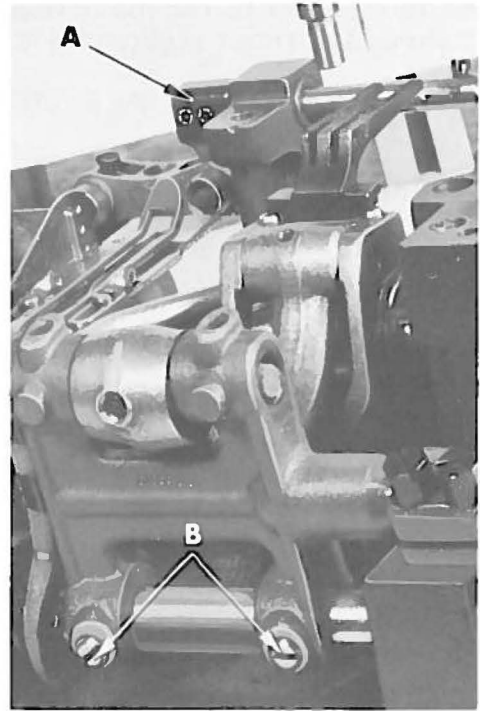


Fig. 10

To set feed dog travel to correspond with needle travel, loosen nut (A, Fig. 13) (it has a left hand thread) and adjust screw (B) until movement of needle and feed dog are synchronized. Turning screw in a clockwise direction shortens the travel of the feed dog and turning screw counterclockwise will lengthen the travel. Retighten nut.

THREAD TENSION RELEASE

The thread tension release is set correctly when it begins to function as the presser foot is raised to within $\frac{1}{8}$ inch of the end of its travel and is entirely released when the presser foot reaches its highest position.

Draw looper and needle thread into the machine. When there are no threads in the machine, the looper may be released into the threading position by turning the handwheel until the needle bar is at high position and pulling the looper holder frame locking pin (A, Fig. 8) to the left. With threads in the machine, proceed in the same manner except hold the needle thread taut to prevent stitch formation while turning handwheel. Return looper to operating position by pushing against looper holder frame; the needle bar being at its highest position.

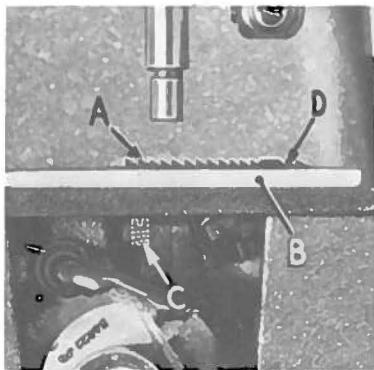


Fig. 11

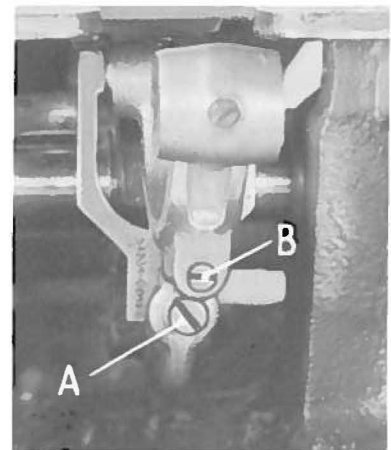


Fig. 12

THREAD TENSION RELEASE (Continued)

The thread for the looper enters from the back of the looper and is threaded from back to front. The needle is threaded from right to left.

SETTING LOOPER THREAD TAKE-UP

The looper thread take-up (A, Fig. 14) is not spotted on mainshaft and consequently is set correctly when the looper thread is just cast-off the highest lobe of the take-up, when the point of the needle is approximately $\frac{1}{32}$ inch below the underside of the looper. The looper thread eyelets (B) located on the cast-off plate (C) are adjustable and should be set all the way forward in their slots (Fig. 14).

NOTE: The position of the looper thread eyelets determine the amount of thread pulled off by the looper thread take-up.

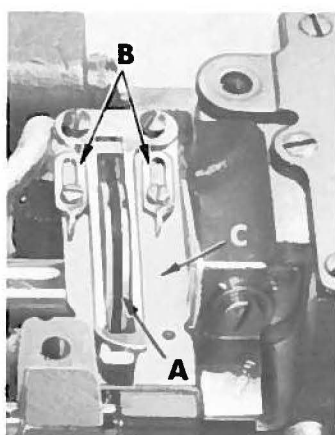


Fig. 14

a good stitch and to avoid puckering the fabric. For pulling up a better stitch, see paragraph on looper thread take-up eyelet.

CHAINING STITCH LENGTH

Start operating on a piece of fabric. Set stitch to required length. To alter stitch length, loosen nut (A, Fig. 13) (it has a left hand thread) and turn screw (B) in head of main shaft until desired stitch length has been attained and tighten nut. Turning screw in a clockwise direction shortens the stitch and turning screw in a counterclockwise direction lengthens the stitch. The travel of the needle bar should be changed to correspond to the travel of the feed dog and this is accomplished by loosening screw (A, Fig. 4) and sliding link (B) up or down until the movement of the feed dog and needle bar are synchronized. Sliding the link upward shortens the travel of the needle bar and sliding it downward lengthens the travel of the needle bar.

PRESSER FOOT PRESSURE

Regulate the presser spring so that it exerts only enough pressure on the presser foot to feed the work uniformly.

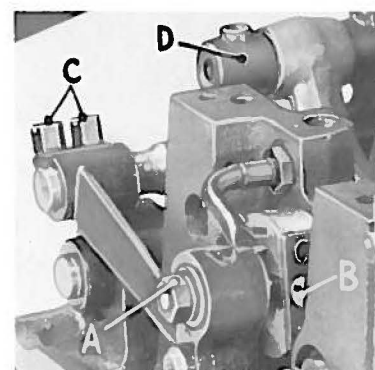


Fig. 13

SETTING THE NEEDLE LEVER EYELET

With the needle lever at the bottom of its stroke, the needle lever eyelet (A, Fig. 15) is set correctly when the underside of the eyelet is $4 \frac{7}{16}$ inches above the top of the retainer drive shaft (B).

SETTING FRAME NEEDLE THREAD EYELET

The frame needle thread eyelet should be set as low as possible. High settings pull thread through the tension on the downstroke of the needle bar and this is not desirable.

THREAD TENSIONS

The tension on the needle thread should be as light as possible to pull up

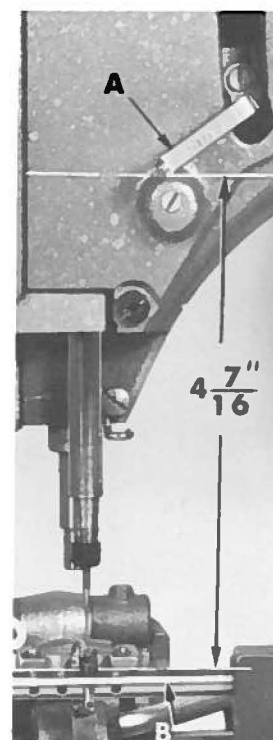


Fig. 15

IDENTIFYING PARTS

Where the construction permits, each part is stamped with its part number. On some of the smaller parts and on those where the 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.

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 part numbers, descriptions and the number of pieces required in the particular view being shown.

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

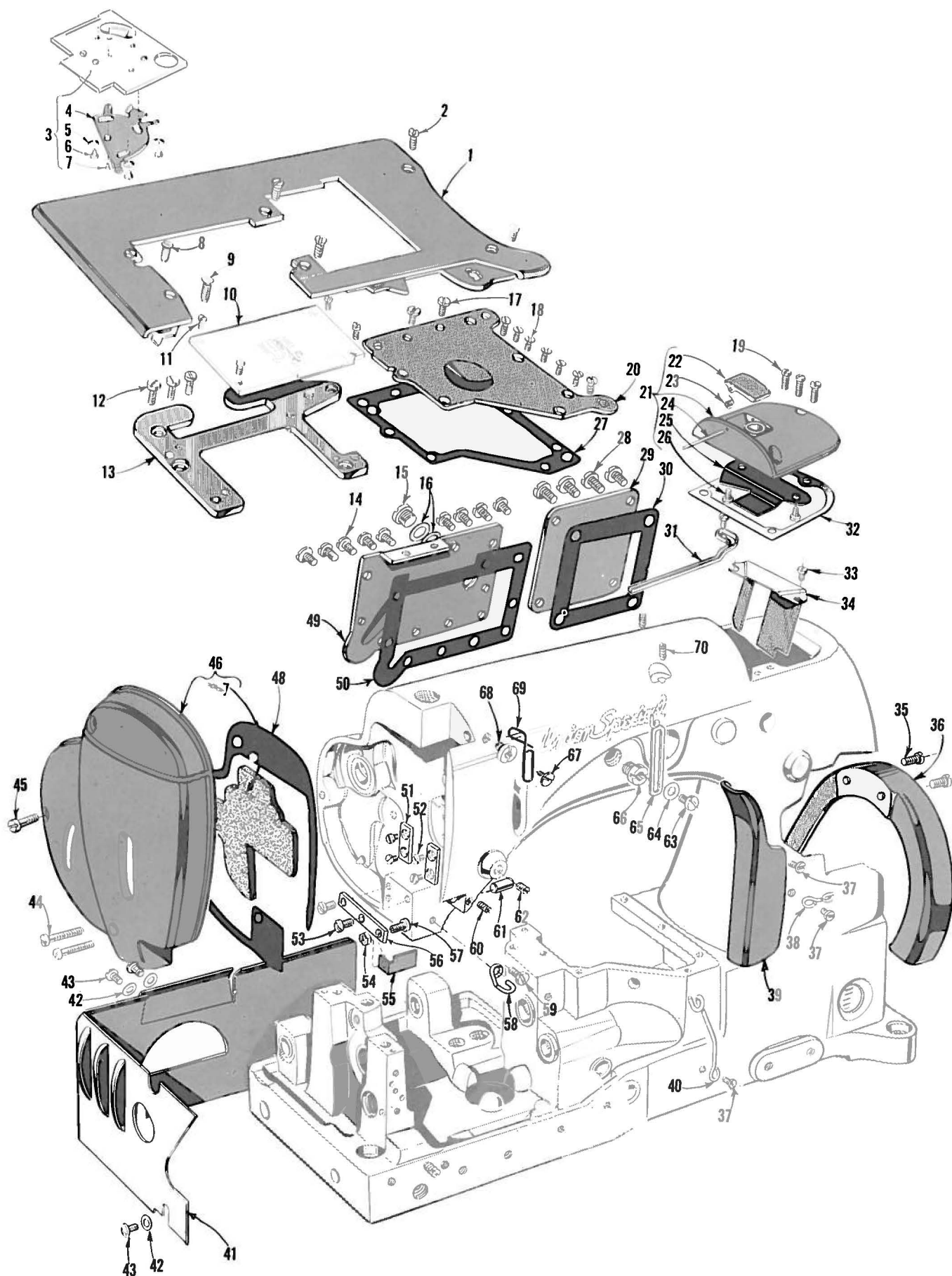
Component parts of sub-assemblies, which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. Example:

46	29105 AD	Retainer Drive Eccentric Assembly-----	1
47	22559 B	Bearing Screw, upper -----	2
48	22894 C	Set Screw -----	5
49	22559 A	Bearing Screw, lower -----	2

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.

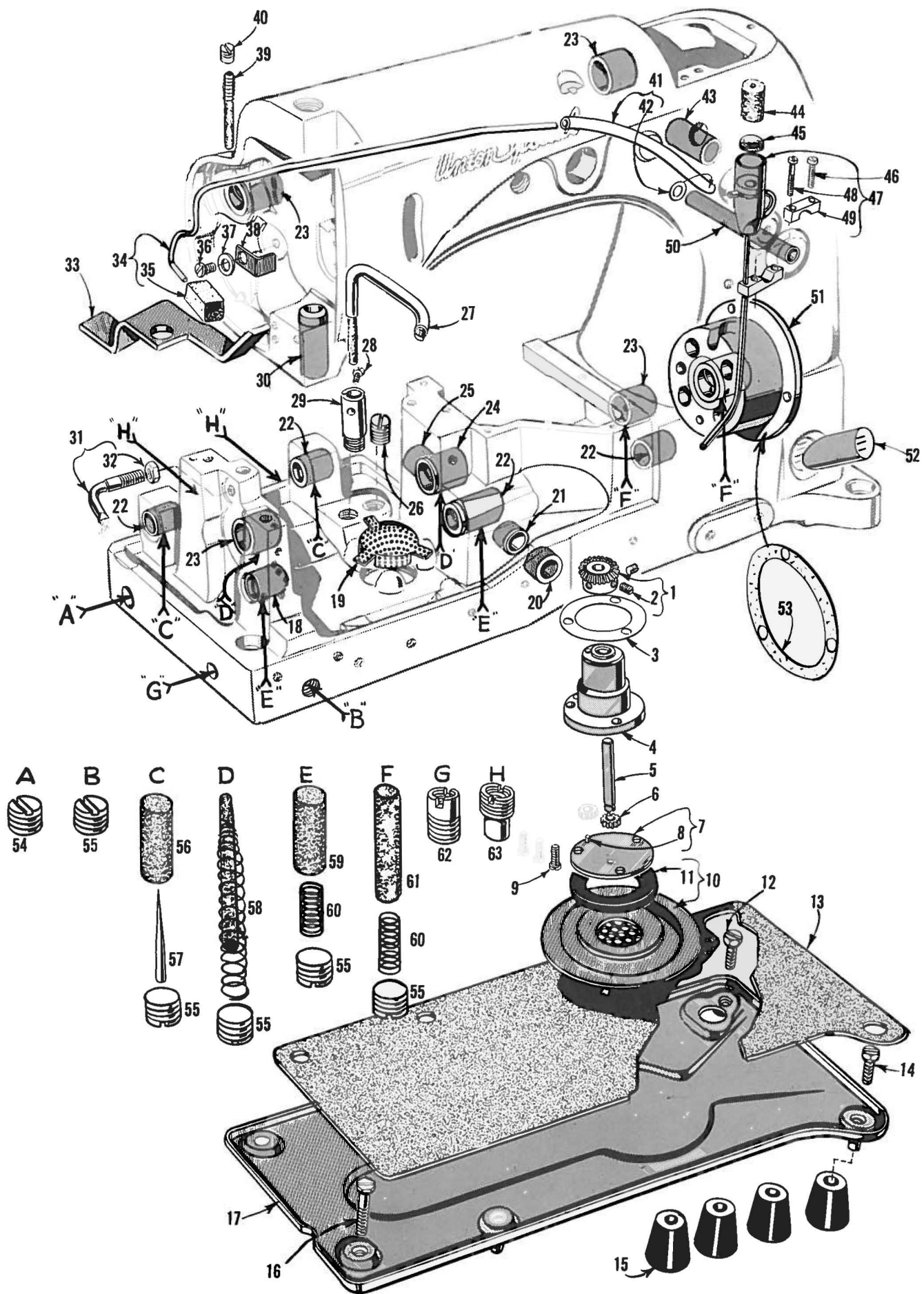
In those cases where a part is common to all of the machines covered by this catalog, no specific usage will be mentioned in the description, however, when the parts for the various machines are not the same, the specific usage will be mentioned in the description, and if necessary, the difference will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



MAIN FRAME, MISCELLANEOUS COVERS AND PLATES

Ref. No.	Part No.	Description	Amt. Req.
1	54601 A	Cloth Plate -----	1
2	22839 C	Screw, for cloth plate -----	2
3	54681	Cloth Plate Cover Assembly -----	1
4	54681 A	Spring -----	1
5	35772 H	Washer -----	3
6	22560 A	Screw -----	3
7	22845 B	Screw -----	1
8	80	Screw, for cloth plate -----	3
9	22574	Screw, for cloth plate -----	1
10		Throat Plate (See Page 25) -----	1
11	22562	Screw, for throat plate, Styles 54600 AB, AD -----	4
	22562 A	Screw, for throat plate, Style 54600 AA -----	4
12	22839	Screw, for throat plate support -----	3
13	54680	Throat Plate Support -----	1
14	22848	Screw, for oil reservoir back cover -----	9
15	22733 B	Plug Screw -----	1
16	41394 A	Gasket, for plug screw -----	2
17	22585 A	Screw, for oil reservoir top cover -----	2
18	22524	Screw, for oil reservoir top cover -----	7
19	22541 B	Screw, for upper crank chamber cover -----	3
20	53782 B	Oil Reservoir Top Cover -----	1
21	52882 AD	Crank Chamber Cover, upper -----	1
22	39582 L	Oil Cap -----	1
23	52882 AC	Oil Cap Torsion Spring -----	1
24	50-789 Blk.	Oil Cap Hinge Pin -----	1
25	52882 AA	Oil Drip Plate -----	1
26	90	Screw -----	2
27	51382 A	Gasket, for oil reservoir top cover -----	1
28	22548	Screw, lower crank chamber cover -----	4
29	52882 AE	Crank Chamber Cover, lower -----	1
30	52882 U	Gasket, for lower crank chamber cover -----	1
31	51282 AE	Needle Lever Bearing Oiler -----	1
32	52882 P	Gasket, for upper crank chamber cover -----	1
33	90	Screw, for baffle plate -----	2
34	52882 Y	Baffle Plate -----	1
35	93	Screw, for belt guard -----	2
36	B21375 AH	Belt Guard -----	1
37	98 A	Screw, for thread eyelet and looper thread guard -----	3
38	52 A	Looper Thread Eyelet -----	1
39	51291 A	Looper Thread Guard -----	1
40	52958 B	Frame Looper Thread Eyelet -----	1
41	54282	Oil Shield -----	1
42	20	Washer, for oil shield -----	3
43	22848	Screw, for oil shield -----	3
44	294	Screw, for head cover -----	2
45	22572 A	Screw, for head cover -----	1
46	54682	Head Cover -----	1
47	54682 B	Felt Liner -----	1
48	54682 A	Head Cover Gasket -----	1
49	52882 L	Oil Reservoir Back Cover -----	1
50	52882 M	Gasket, for oil reservoir back cover -----	1
51	35731 A	Presser Bar Connection Guide Plate -----	2
52	22513	Screw, for presser bar connection guide plate -----	4
53	22569 C	Screw, guide stud support -----	2
54	12934 A	Nut, for stud No. 22528 C -----	1
55	54682 C	Needle Bar Frame Guard -----	1
56	54637 B	Guide Stud Support -----	1
57	22528 C	Needle Bar Frame Guide Stud -----	1
58	54658 A	Needle Thread Eyelet, lower -----	1
59	98 A	Screw, for lower needle thread eyelet -----	1
60	22517 F	Screw, for needle bar frame pin -----	1
61	53137 A	Pin, for needle bar frame -----	1
62	95	Plug Screw, for bed -----	1
63	22848	Screw, for frame needle thread eyelet -----	1
64	20	Washer, for frame needle thread eyelet -----	1
65	539	Frame Needle Thread Eyelet -----	1
66	22889 A	Adaptor Screw, for frame needle thread eyelet -----	1
67	22784 F	Screw, for needle thread take-up wire -----	1
68	22891 A	Screw, for needle bar frame pivot pin -----	1
69	54670	Needle Thread Take-up Wire -----	1
70	719	Screw, for needle lever stud -----	2

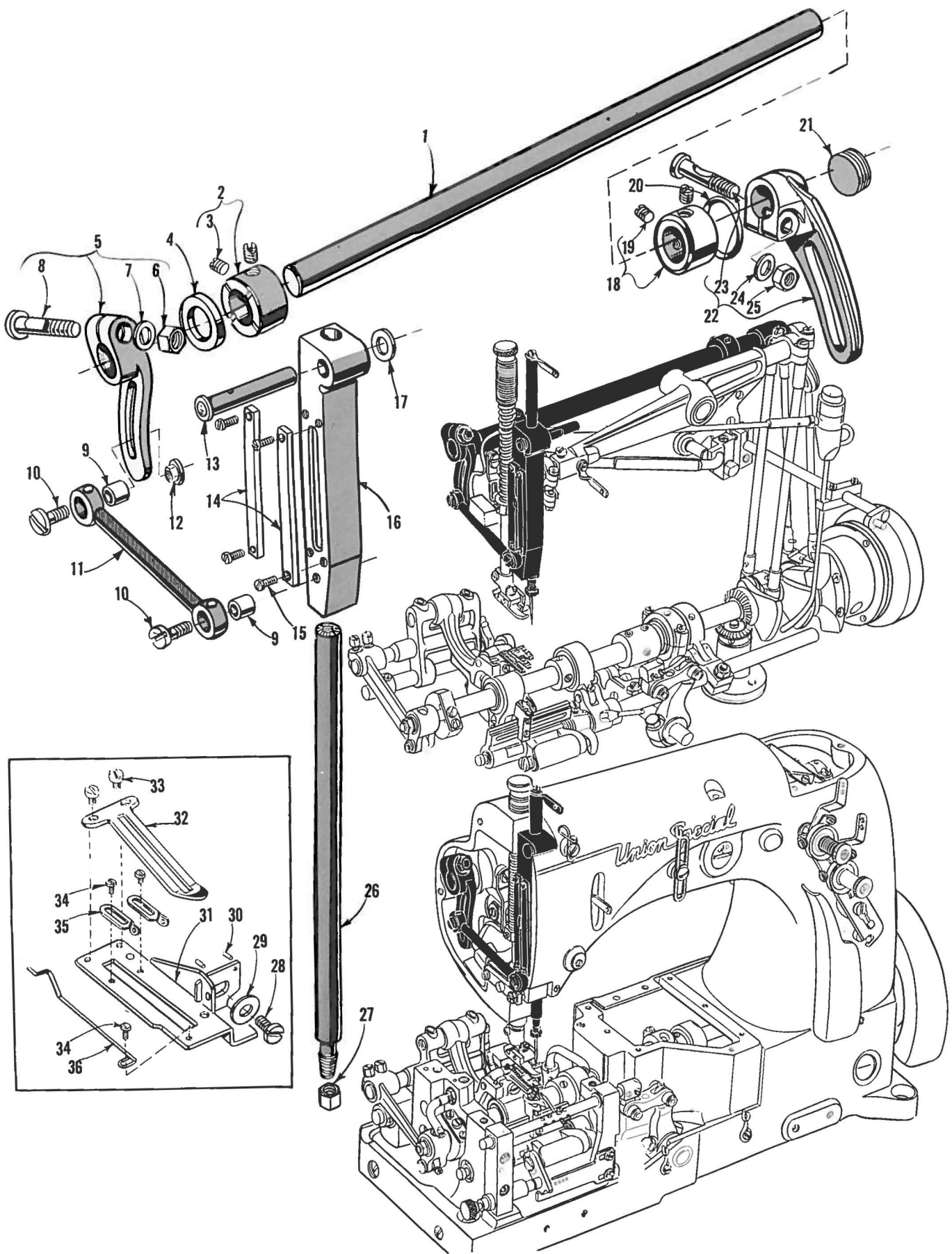


MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	51493 BQ	Oil Pump Driven Gear-----	1
2	531	Screw -----	2
3	643-127 Blk.	Gasket, for oil pump housing-----	1
4	51493 AG	Oil Pump Housing-----	1
5	51493 D	Oil Pump Driving Shaft -----	1
6	51493 E	Oil Driving Shaft Gear-----	2
7	51493 AH	Oil Pump Housing Cover -----	1
8	50-294 Blk.	Pin -----	1
9	22569 B	Screw, for oil pump housing cover -----	3
10	51493 BH	Filter Cap Assembly -----	1
11	51493 BJ	Washer, rubber -----	1
12	22645 H-64	Screw, oil pan assembly -----	1
13	51493 BG	Base Plate Felt-----	1
14	22823 A	Screw, oil pan assembly -----	1
15	51295 A	Mounting Isolator -----	4
16	22823 B	Screw, oil pan assembly-----	1
17	51493 AY	Oil Pan Assembly-----	1
18	52944 T	Looper Rocker Shaft Bushing, left -----	1
19	51493 BK	Lint Filter Screen -----	1
20	51242 Z	Looper Drive Lever Shaft Bushing, front -----	1
21	51242 R	Looper Drive Lever Shaft Bushing, middle -----	1
22	52936	Feed Rocker Shaft Bushing and Looper Rocker Shaft Bushing, middle and right -----	4
23	52890 C	Main Shaft Bushing, left, inner right and Rocker Shaft Bushing, upper left and right -----	4
24	51290 T	Main Shaft Bushing, middle -----	1
25	51242 S	Looper Drive Lever Shaft Bushing, rear -----	1
26	22571 B	Plug Screw, for bed -----	1
27	54293 A	Feed Lift Eccentric Oil Tube-----	1
28	90	Screw, for oil tube-----	1
29	52894 AB	Oil Tube Holder -----	1
30	51257 AA	Presser Bar Bushing, lower -----	1
31	660-136	Oil Tube, for feed crank link assembly -----	1
32	258 A	Nut-----	1
33	666-217	Head Oil Attraction Felt -----	1
34	54694	Horizontal Siphon Oil Tube-----	1
35	666-218	Siphon Priming Block, felt -----	1
36	22569 C	Screw, for oil tube clamp-----	1
37	20	Washer, for oil tube clamp -----	1
38	54694 A	Oil Tube Clamp-----	1
39	666-99	Oil Wick, for upper rocker shaft bushing, left -----	1
40	22706 A	Plug Screw-----	1
41	51294 N	Oil Tube Connection-----	1
42	21212	Locking Ring -----	1
43	52883 R	Presser Foot Lifter Lever Bushing -----	1
44	666-201	Felt Plug -----	1
45	666-209	Felt Disc -----	1
46	22729 A	Screw, for oil siphon assembly-----	1
47	51294 U	Oil Siphon Assembly -----	1
48	22729 B	Screw -----	1
49	51294 K	Clamp, upper -----	1
50	21657 X	Tension Release Lever Bushing -----	1
51	52891 B	Crankshaft Bushing Housing, including bushing-----	1
52	50-648 Blk.	Lucite Oil Gauge -----	1
53	56390 E	Crankshaft Bearing Housing Gasket -----	1
54	22539 H	Plug Screw, for bed-----	1
55	22571 A	Plug Screw, for bed-----	13
56	666-111	Oil Wick, for feed rocker shaft-----	2
57	666-179	Wedge Pin -----	2
58	666-118	Oil Wick, for main shaft bushing left and middle -----	2
59	666-65	Oil Wick, for looper rocker shaft bushing -----	2
60	35178 D	Spring, for oil wick -----	4
61	666-114	Oil Wick, for main shaft bushing right and inner right-----	2
62	22889 D	Adaptor Plug Screw -----	1
63	22889 C	Adaptor Plug Screw -----	2

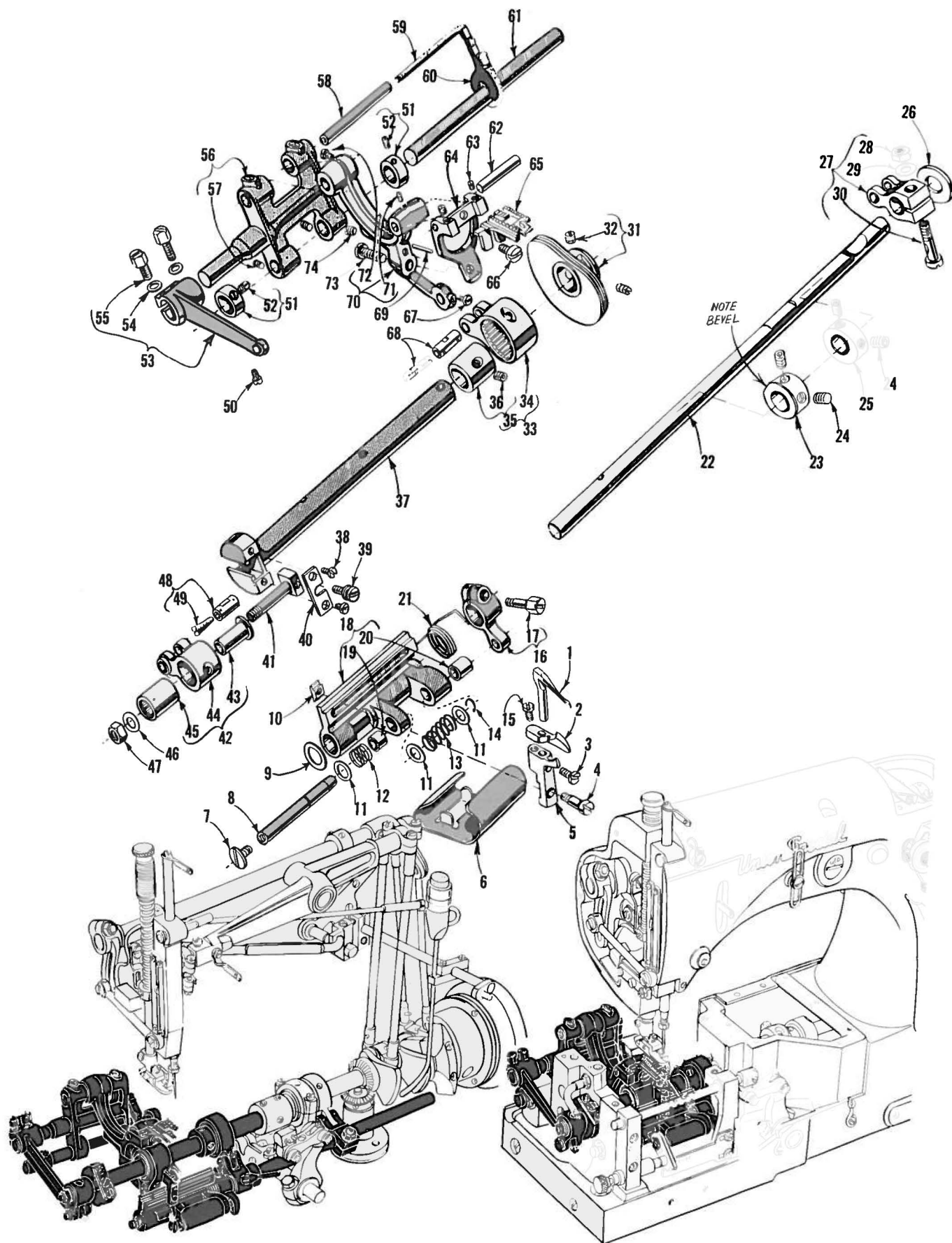
CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	56	Needle Clamp Nut -----	1
2	54617	Needle Bar, marked "EE" -----	1
3	27-484 Blk.	Washer, for needle bar eyelet -----	1
4	56358	Needle Bar Eyelet -----	1
5	22768	Screw, for needle bar eyelet -----	1
6	CL21	Oil Wick, for ball joint assembly -----	1
7	22586 R	Plug Screw, for needle lever stud -----	1
8	51250 F	Gasket, for needle lever stud -----	1
9	51250 D	Washer, for needle lever stud -----	1
10	660-212	Oil Seal Ring, for needle lever stud -----	2
11	51150	Needle Lever Stop Collar -----	1
12	29066 R	Needle Lever Connecting Rod Assembly -----	1
13	22559 G	Screw -----	2
14	51216 N	Washer, for needle lever -----	1
15	51216 P	Nut, for needle lever -----	1
16	51216 G	Needle Lever Connecting Rod -----	2
17	18	Nut, for ball joint assembly -----	1
18	54652	Spacer Washer, for ball joint assembly -----	1
19	52952 B	Needle Feed Connecting Rod Ball Joint, upper -----	1
20	22559 G	Screw -----	2
21	52916	Needle Feed Drive Connecting Rod -----	2
22	52951 C	Thrust Washer, for crankshaft -----	1
23	29126 DH	Needle Feed Drive Eccentric Assembly -----	1
24	660-246	Tru-Arc Ring -----	1
25	52951 B	Retaining Washer -----	1
26	52951 A	Connecting Rod Bearing -----	1
27	54638	Eccentric, .100 inch throw -----	1
28	95	Screw -----	2
29	29476 MZ	Crankshaft Assembly, .990 inch throw -----	1
30	51216 M	Needle Bearing -----	28
31	54647	Counterweight -----	1
32	88 F	Screw -----	2
33	52921 B	Pulley -----	1
34	22894 G	Screw -----	2
35	22569 B	Screw, for crankshaft bushing housing -----	3
36	660-202	Oil Seal Ring, for pulley -----	1
37	52891 B	Crankshaft Bushing Housing, including bushing -----	1
38	51236 A	Link Pin, for looper drive eccentric assembly -----	1
39	51493 BP	Oil Pump Driving Gear -----	1
40	22560 B	Screw -----	2
41	29133 N	Looper Drive Eccentric Assembly, .312 inch throw -----	1
42	22894 C	Screw -----	2
43	22768	Screw -----	1
44	22729	Screw, for ball stud guide fork -----	1
45	51243 C	Ball Stud Guide Fork -----	1
46	29105 AD	Retainer Drive Eccentric Assembly -----	1
47	22559 B	Bearing Screw, upper -----	2
48	22894 C	Set Screw -----	5
49	22559 A	Bearing Screw, lower -----	2
50	12982	Lock Nut, for screw No. 81 -----	1
51	51242 P	Looper Drive Lever Shaft -----	1
52	51242 L	Thrust Washer -----	1
53	52841 G	Locking Stud -----	1
54	51242 M	Washer -----	1
55	52841 J	Nut, for locking stud -----	1
56	51242 Y	Looper Drive Lever Rocker -----	1
57	51242 L	Thrust Washer -----	1
58	22883 A	Plug Screw -----	1
59	51242 M	Washer, for looper drive lever rocker -----	1
60	81	Spot Screw, for looper drive lever rocker -----	1
61	22852 A	Clamp Screw, for looper drive lever rocker -----	1
62	29348 X	Needle Lever Assembly -----	1
63	54654	Ball Joint Assembly -----	1
64	97	Screw -----	1
65	97 A	Screw -----	4
66	54654 C	Guide Washer -----	1
67	28	Screw -----	1
68	22839 A	Screw -----	1
69	54615	Needle Lever, including bushing -----	1
70	51250 E	Needle Lever Stud -----	1
71	54658	Needle Lever Thread Eyelet -----	1
72	22768	Screw, for needle lever thread eyelet -----	1



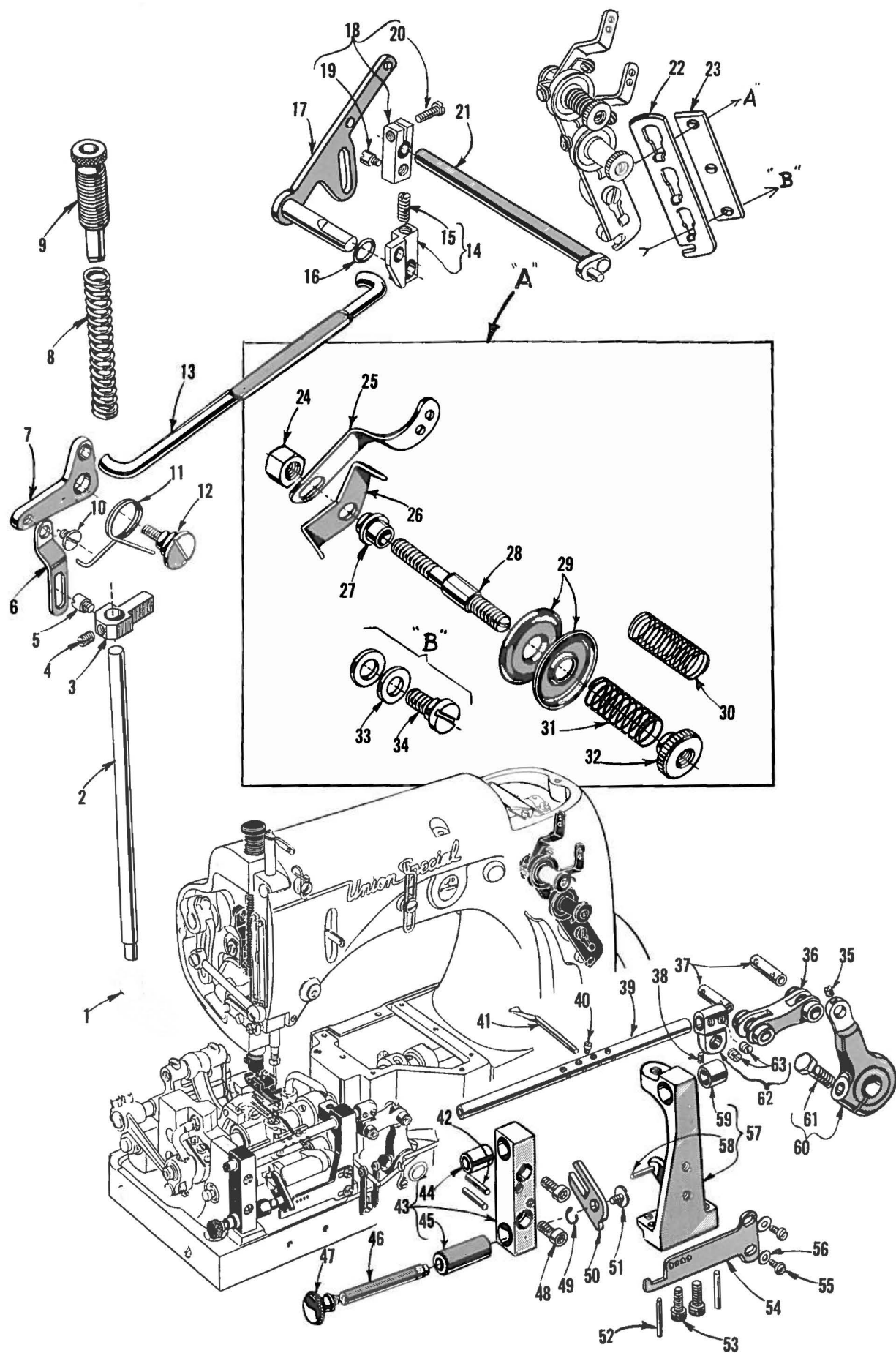
NEEDLE FEED PARTS, CAST-OFF PLATE, NEEDLE BAR AND NEEDLE HEAD

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	52849	Needle Feed Rocker Shaft -----	1
2	51147	Rocker Shaft Collar -----	1
3	95	Screw -----	2
4	52951 C	Thrust Washer, for needle feed rocker shaft -----	1
5	54637 D	Needle Feed Drive Lever, left -----	1
6	55235 E	Nut -----	1
7	6042 A	Washer -----	1
8	55235 D	Locking Stud -----	1
9	51771	Ferrule, for link -----	2
10	22758 H	Screw, for link -----	2
11	54637 C	Link -----	1
12	43139 A	Nut, for link -----	1
13	61985 A	Needle Bar Frame Pivot Pin -----	1
14	54654 D	Ball Stud Guide -----	2
15	22593	Screw, for ball stud guide -----	4
16	54637	Needle Bar Frame -----	1
17	61341 F	Washer, for needle bar frame -----	1
18	52849 C	Rocker Shaft Oil Seal Collar -----	1
19	95	Screw -----	2
20	660-202	Oil Seal Ring, for rocker shaft -----	1
21	22539 D	Plug Screw, for bed -----	1
22	52952 C	Needle Feed Rocker Shaft Lever, right -----	1
23	55235 D	Locking Stud -----	1
24	6042 A	Washer -----	1
25	55235 E	Nut -----	1
26	54617	Needle Bar, marked "EE" -----	1
27	56	Needle Clamp Nut -----	1
28	22528	Screw, for cast-off support plate -----	1
29	21657 E	Washer, for cast-off support plate -----	1
30	50-216 Blk.	Dowel Pin, for cast-off support plate -----	2
31	54657	Cast-off Support Plate -----	1
32	54604	Cast-off Plate -----	1
33	28	Screw, for cast-off plate -----	2
34	73 A	Screw, for eyelet and cast-off wire -----	3
35	52958 D	Looper Thread Take-up Eyelet -----	2
36	52904 G	Cast-off Wire -----	1



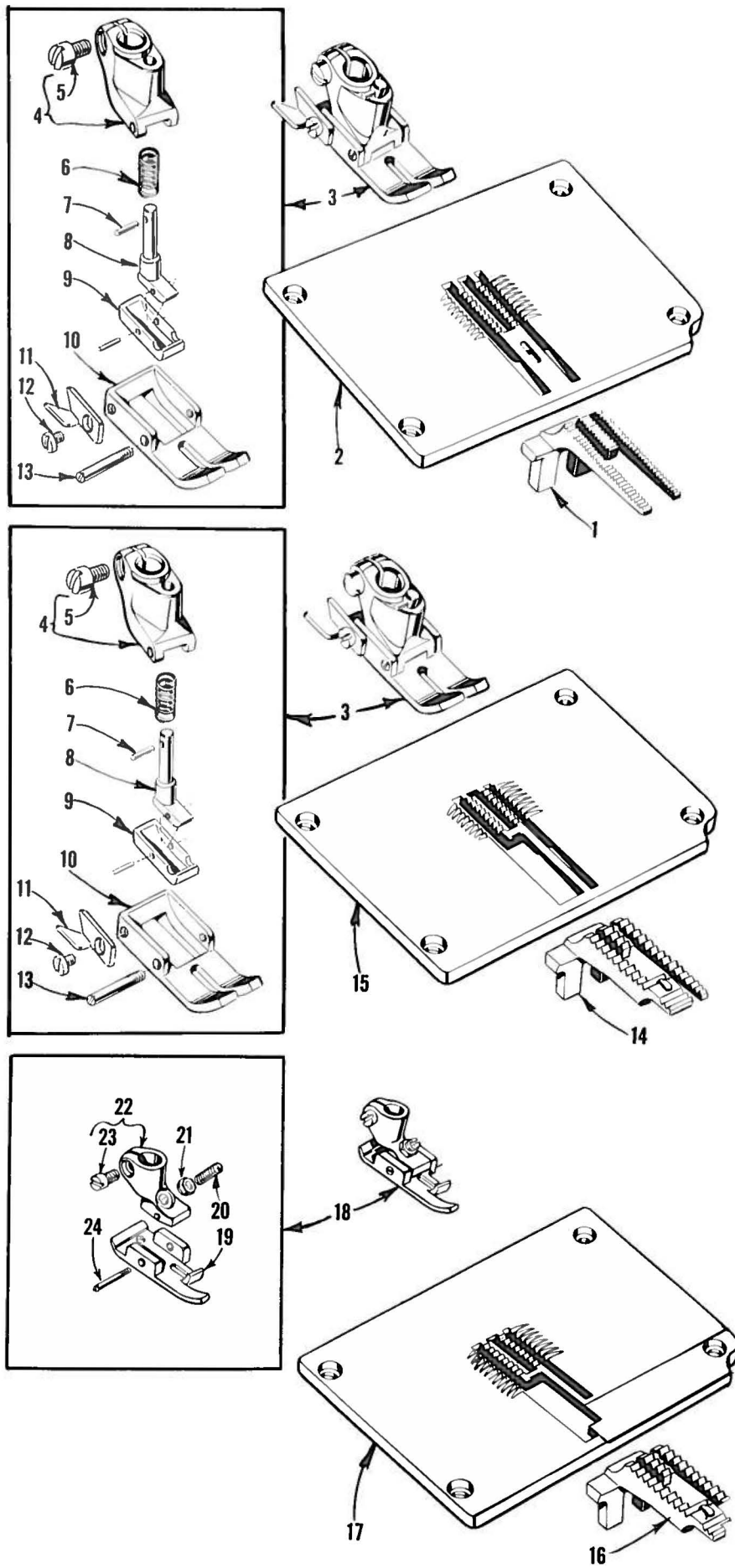
TAKE-UP, MAIN SHAFT, FEED DRIVING AND LOOPER DRIVING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1	54608	Looper, marked "CW"-----	1
2	54625	Looper Holder Needle Guard -----	1
3	J87 J	Screw, for looper -----	1
4	22559 D	Screw, for looper holder -----	1
5	54685	Looper Holder and Needle Guard -----	1
6	54244 M	Looper Holder Frame Thread Shield -----	1
7	22542 A	Screw, for locking pin -----	1
8	54244 D	Looper Holder Frame Locking Pin -----	1
9	51242 L	Thrust Washer, for looper holder frame -----	1
10	54285 C	Nut, for looper holder -----	1
11	6042 A	Washer, for looper holder frame -----	3
12	54244 H	Throw-out Fork Pressure Spring -----	1
13	39173 A	Looper Holder Frame Locking Pin Spring -----	1
14	660-215	Retaining Ring -----	1
15	22768	Screw, for needle guard -----	1
16	54244 B	Looper Holder Frame Driving Arm -----	1
17	22519 C	Screw -----	1
18	54244 R	Looper Holder Frame -----	1
19	54244 E	Bushing, left -----	1
20	54244 F	Bushing, right -----	1
21	54244 C	Looper Throw-out Spring -----	1
22	51244 K	Looper Rocker Shaft -----	1
23	54644 A	Thrust Collar, left -----	1
24	22894 W	Screw, for thrust collars -----	4
25	43245 D	Thrust Collar, right -----	1
26	51244 L	Thrust Washer, right, for looper rocker shaft -----	1
27	54644	Looper Holder Frame Rocker Shaft Connection -----	1
28	18	Nut -----	1
29	20	Washer -----	1
30	55244 G	Locking Stud -----	1
31	51223 A	Double Disc Take-up -----	1
32	22580 D	Screw -----	2
33	29476 KR-072	Feed Lift Eccentric Assembly -----	1
34	54245 C	Eccentric Bearing -----	1
35	51306	Eccentric, .072 inch throw -----	1
36	22894 D	Screw -----	1
37	54622	Main Shaft -----	1
38	22768	Screw, for feed crank stud cap -----	2
39	82	Stitch Regulating Screw -----	1
40	51236 B	Feed Crank Stud Cap -----	1
41	51236 G	Feed Crank Stud -----	1
42	51236 E	Feed Crank Link Assembly -----	1
43	51236 F	Feed Crank Link Ferrule -----	1
44	51236 D	Feed Crank Link -----	1
45	660-169	Needle Bearing -----	1
46	20	Washer -----	1
47	269	Nut, left thread -----	1
48	51054	Feed Crank Link Pin -----	1
49	666-149	Lubricating Felt -----	1
50	77	Screw -----	1
51	482	Feed Rocker Shaft Collar -----	2
52	98	Screw -----	1
53	51235 A	Feed Rocker Arm -----	1
54	51235 G	Washer -----	2
55	22519 C	Screw -----	2
56	51235	Feed Rocker -----	1
57	98	Screw -----	2
58	51134 C	Feed Bar Shaft -----	1
59	51134 P	Lubricating Felt -----	1
60	51134 R	Lubricating Felt Guard -----	1
61	8	Rocker Shaft -----	1
62	54134 N	Pin, for feed bar tilting extension -----	1
63	22560 B	Screw, for feed bar tilting extension -----	2
64	54234 C	Feed Bar Tilting Extension -----	1
65		Feed Dog (See Page 25) -----	1
66	HA61 D	Screw, for feed dog -----	1
67	77	Screw, for link pin -----	1
68	51236 A	Link Pin, for feed bar -----	1
69	667 B-20	Dowel Pin, for feed bar -----	1
70	54234 B	Feed Bar -----	1
71	22733	Screw -----	1
72	22560 B	Screw -----	1
73	88 F	Screw, for feed bar tilting extension -----	1
74	531	Screw, for feed bar -----	1



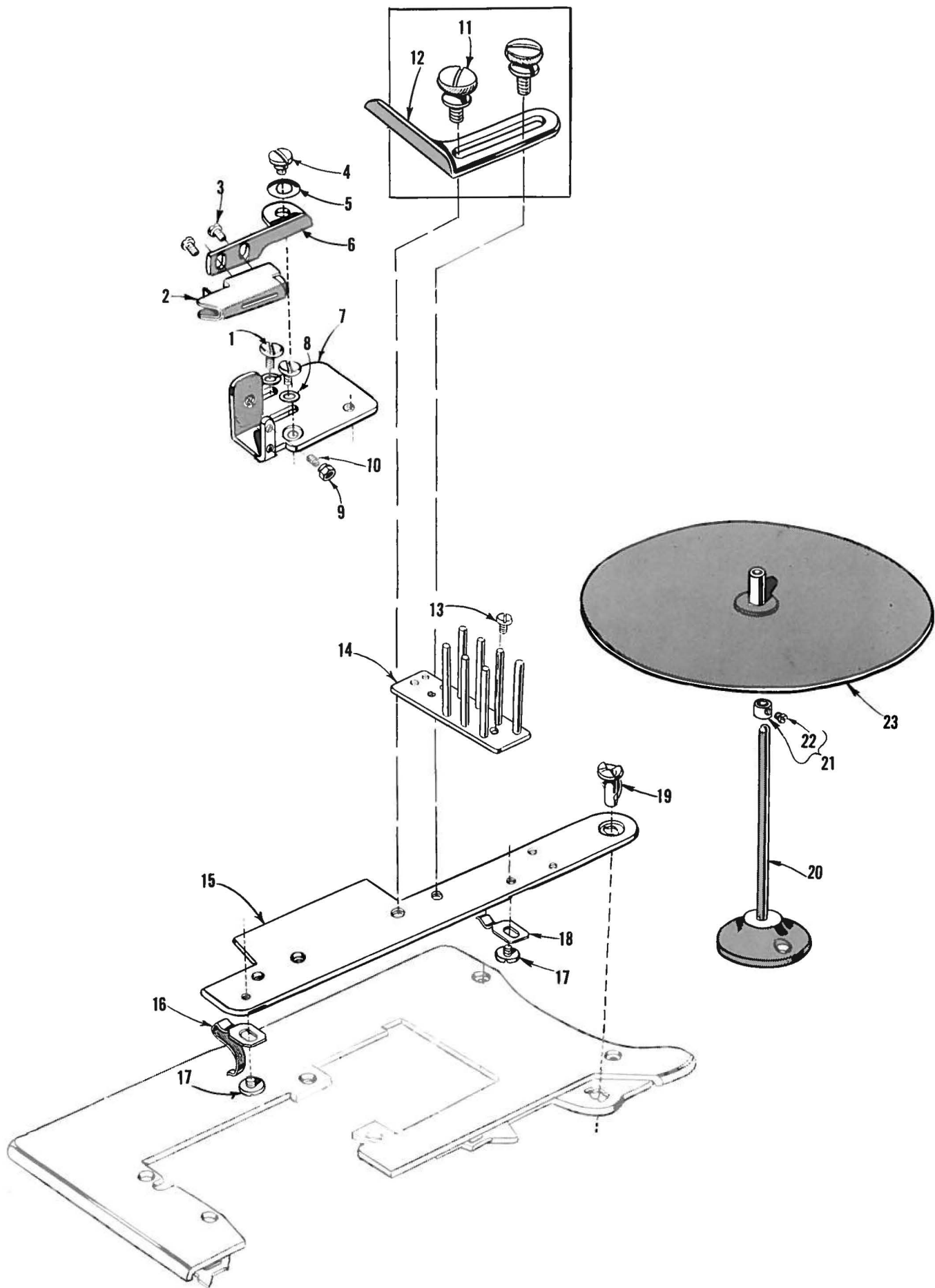
PRESSER FOOT, PRESSER FOOT LIFTER, THREAD TENSION
AND RETAINER DRIVING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1		Presser Foot (See Page 25)-----	1
2	51257 K	Presser Bar, marked "A"-----	1
3	51257 M	Presser Bar Connection and Guide -----	1
4	531	Screw, for presser bar connection and guide -----	1
5	402	Stop Screw, for lifter lever link-----	1
6	53783 A	Lifter Lever Link -----	1
7	53783 L	Presser Foot Lifter Lever Bell Crank -----	1
8	53787	Presser Bar Spring-----	1
9	56356	Presser Spring Regulator -----	1
10	22758 C	Screw, for lifter lever link -----	1
11	52883 S	Presser Foot Lifter Lever Bell Crank Spring-----	1
12	22557 B	Screw, for lifter lever bell crank spring -----	1
13	53783 M	Presser Foot Lifter Lever Connecting Rod -----	1
14	53783 N	Presser Foot Lifter Lever, internal-----	1
15	22537	Screw -----	1
16	660-207	Oil Seal Ring, for presser foot lifter lever -----	1
17	51283 H	Presser Foot Lifter Lever -----	1
18	21657 Y	Tension Release and Foot Lifter Lever Connection -----	1
19	402	Stop Screw-----	1
20	22596	Clamp Screw-----	1
21	21657 W	Tension Release Lever Shaft-----	1
22	21657-3	Tension Disc Separator -----	1
23	52892	Tension Post Support -----	1
24	43266	Tension Post Nut -----	1
25	51491 C	Thread Lead-in Guide-----	2
26	51292 D	Tension Thread Eyelet -----	2
27	51292 A	Tension Post Ferrule -----	2
28	51292 G	Tension Post-----	2
29	109	Tension Disc-----	4
30	51292 F-2	Tension Spring, loop-----	1
31	51292 F-5	Tension Spring, needle-----	1
32	51292 C	Tension Post Nut -----	2
33	80557	Washer, for tension disc separator-----	2
34	22598 C	Screw, for tension disc separator -----	1
35	22564	Screw, for taper link pin -----	1
36	HA54 A	Retainer Drive Lever Link -----	1
37	51134 V	Taper Link Pin -----	2
38	78	Screw, for taper link pin -----	1
39	54242 B-4-16	Retainer Holder -----	1
40	22845 B	Screw, for retainer -----	1
41	54611 A	Retainer, marked "BX" -----	1
42	667 B-12	Dowel Pin, for retainer holder bearing -----	2
43	54242 C	Retainer Holder Bearing, left-----	1
44	61354 A	Bushing, upper-----	1
45	51254 A	Bushing, lower-----	1
46	54244 J	Looper Throw-out Actuating Plunger -----	1
47	15489 B	Screw, for actuating plunger-----	1
48	22652 B-8	Screw, for retainer holder bearing -----	2
49	660-215	Retaining Ring, for actuating plunger -----	1
50	54244 G	Looper Holder Frame Throw-out Fork-----	1
51	22542 A	Screw, for looper throw-out fork-----	1
52	667 B-12	Dowel Pin, for retainer holder bearing -----	2
53	22652 B-8	Screw, for retainer holder bearing -----	2
54	54259	Looper Thread Eyelet-----	1
55	J87 J	Screw, for looper thread eyelet -----	2
56	41358	Washer, for looper thread eyelet-----	2
57	54242 D	Retainer Bearing Holder, right -----	1
58	667 B-12	Dowel Pin -----	1
59	61354 A	Bushing -----	1
60	54242 E	Retainer Drive Lever -----	1
61	22811 B	Screw -----	1
62	9650	Retainer Holder Connection-----	1
63	88	Screw -----	2



FEED DOGS, THROAT PLATES AND PRESSER FEET

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	54605 L	Feed Dog, marked "CC", for Style 54600 AB -----	1
2	54624 L	Throat Plate, for Style 54600 AB -----	1
3	54620 P	Presser Foot, for Styles 54600 AB, AD -----	1
4	51530 D	Shank-----	1
5	91	Clamp Screw -----	1
6	51530 G	Spring -----	1
7	1740	Pin-----	1
8	54630 U	Yielding Section Plunger-----	1
9	54630 T	Yielding Section -----	1
10	54630 V	Presser Foot Bottom -----	1
11	52930 AC	Chain Cutting Knife, marked "D" -----	1
12	91 A	Screw, for chain cutting knife -----	1
13	22799 E	Hinge Screw-----	1
14	54605 M	Feed Dog, marked "CD", for Style 54600 AD -----	1
15	54624 M	Throat Plate, for Style 54600 AD -----	1
16	54605 N	Feed Dog, marked "CG", for Style 54600 AA -----	1
17	54624 N	Throat Plate, for Style 54600 AA -----	1
18	54620 N-5/8	Presser Foot, for Style 54600 AA-5/8 -----	1
-	54620 N-3/4	Presser Foot, for Style 54600 AA-3/4 -----	1
-	54620 N-7/8	Presser Foot, for Style 54600 AA-7/8 -----	1
19	54630 S-5/8	Presser Foot Bottom, marked "AP-5/8", for presser foot No. 54620 N-5/8-----	1
-	54630 S-3/4	Presser Foot Bottom, marked "AP-3/4", for presser foot No. 54620 N-3/4-----	1
-	54630 S-7/8	Presser Foot Bottom, marked "AP-7/8", for presser foot No. 54620 N-7/8-----	1
20	22840 A	Adjusting Screw-----	1
21	51430 F	Adjusting Nut-----	1
22	6430	Shank-----	1
23	91	Clamp Screw -----	1
24	22799 E	Hinge Screw-----	1



ATTACHMENTS AND TAPE REEL

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	25 C	Screw, for folder mounting base-----	2
2	23215 BJ-5/8	Binder, uses 5/8 inch selvage edge binding and finishes 5/16 inch wide, for Style 54600 AA-5/8-----	1
-	23215 BJ-3/4	Binder, uses 3/4 inch selvage edge binding and finishes 3/8 inch wide, for Style 54600 AA-3/4-----	1
-	23215 BJ-7/8	Binder, uses 7/8 inch selvage edge binding and finishes 7/16 inch wide, for Style 54600 AA-7/8-----	1
3	90	Screw, for binder-----	2
4	22735	Screw, for binder bracket -----	1
5	12957 E	Spring Washer, for binder bracket-----	1
6	23437 Y	Binder Bracket, for Style 54600 AA-----	1
7	23437 M	Folder Mounting Base, for Style 54600 AA-----	1
8	6042 A	Washer, for folder mounting base -----	2
9	51430 F	Lock Nut, for binder stop screw-----	1
10	22840 A	Stop Screw, for binder -----	1
11	25	Screw, for edge guide -----	2
12	24	Edge Guide, for Styles 54600 AB, AD -----	1
13	22585 C	Screw, for tape tension -----	1
14	23439 A	Tape Tension, for Style 54600 AA -----	1
15	54464	Folder Mounting Swinging Bracket -----	1
16	54264 C	Spring, with finger projection -----	1
17	12986 B	Screw, for springs-----	2
18	54264 B	Spring -----	1
19	660-237	Spring Lock Fastener -----	1
20	21169 F	Binding Holder Base, for Style 54600 AA -----	1
21	161	Binding Holder Stop Collar, for Style 54600 AA-----	1
22	88	Screw -----	1
23	21169 E	Binding Holder Disc, for Style 54600 AA-----	1

THREAD STAND AND ACCESSORIES

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	21101 H-2	Thread Stand, complete -----	1
2	21114 A	Thread Stand Base -----	1
3	22651 CD-4	Screw -----	1
4	22810	Screw -----	1
5	21114 T	Lead Eyelet Socket Ball-----	1
6	22651 CD-4	Screw -----	1
7	21114 U	Lead Eyelet Ball Split Socket-----	2
8	652-16	Washer -----	1
9	21104 H	Nut-----	1
10	21104 B-24	Thread Stand Rod -----	1
11	21114 D-2	Spool Seat Support -----	1
12	22651 CD-5	Screw -----	2
13	21114 H-2	Eyelet Support-----	1
14	22651 CD-4	Screw -----	1
15	21104 V	Pad-----	2
16	21114 W	Spool Pin -----	2
17	258 A	Nut-----	4
18	21114	Spool Seat Disc -----	2
19	652-16	Washer -----	2
20	21114 S-2	Lead Eyelet -----	1
21	660-264	"S" Hook -----	2
22	421 D-28	Treadle Chain, 28 inches long-----	1
23	660-240	Thread Tweezers -----	1
24	21388	Wrench, single end, 3/8 inch opening -----	1
25	51493 BC	Lifter Link-----	1
26	116	Wrench, single end, 9/32 inch opening -----	1
27	21227 BT	Needle Gauge -----	1

NUMERICAL INDEX OF PARTS

Part No.	Page No.	Part No.	Page No.	Part No.	Page No.
8	21	666-201	15	22572 A	13
18	17, 21	666-209	15	22574	13
20	13, 15, 21	666-217	15	22580 D	21
CL21	17	666-218	15	22585 A	13
24	27	667 B-12	23	22585 C	27
25	27	667 B-20	21	22586 R	17
25 C	27	719	13	22593	19
27-484 Blk	17	1740	25	22596	23
28	17, 19	6042 A	19, 21, 27	22598 C	23
50-216 Blk	19	6430	25	22645 H-64	15
50-294 Blk	15	9650	23	22651 CD-4	29
50-648 Blk	15	12934 A	13	22651 CD-5	29
50-789 Blk	13	12957 E	27	22652 B-8	23
52 A	13	12982	17	22706 A	15
HA54 A	23	12986 B	27	22729	17
56	17, 19	15489 B	23	22729 A	15
HA61 D	21	21101 H-2	29	22729 B	15
73 A	19	21104 B-24	29	22733	21
77	21	21104 H	29	22733 B	13
78	23	21104 V	29	22735	27
80	13	21114	29	22758 C	23
81	17	21114 A	29	22758 H	19
82	21	21114 D-2	29	22768	17, 21
J87 J	21, 23	21114 H-2	29	22784 F	13
88	23, 27	21114 S-2	29	22799 E	25
88 F	17, 21	21114 T	29	22810	29
90	13, 15, 27	21114 U	29	22811 B	23
91	25	21114 W	29	22823 A	15
91 A	25	21169 E	27	22823 B	15
93	13	21169 F	27	22839	13
95	13, 17, 19	21212	15	22839 A	17
97	17	21227 BT	29	22839 C	13
97 A	17	B21375 AH	13	22840 A	25, 27
98	21	21388	29	22845 B	13, 23
98 A	13	21657-3	23	22848	13
109	23	21657 E	19	22852 A	17
116	29	21657 W	23	22883 A	17
161	27	21657 X	15	22889 A	13
258 A	15, 29	21657 Y	23	22889 C	15
269	21	22513	13	22889 D	15
294	13	22517 F	13	22891 A	13
402	23	22519 C	21	22894 C	17
421 D-28	29	22524	13	22894 D	21
482	21	22528	19	22894 G	17
531	15, 21, 23	22528 C	13	22894 W	21
539	13	22537	23	23215 BJ	27
643-127 Blk	15	22539 D	19	23437 M	27
652-16	29	22539 H	15	23437 Y	27
660-136	15	22541 B	13	23439 A	27
660-169	21	22542 A	21, 23	29066 R	17
660-202	17, 19	22548	13	29105 AD	17
660-207	23	22557 B	23	29126 DH	17
660-212	17	22559 A	17	29133 N	17
660-215	21, 23	22559 B	17	29348 X	17
660-237	27	22559 D	21	29476 KR-072	21
660-240	29	22559 G	17	29476 MZ	17
660-246	17	22560 A	13	35178 D	15
660-264	29	22560 B	17, 21	35731 A	13
666-65	15	22562	13	35772 H	13
666-99	15	22562 A	13	39173 A	21
666-111	15	22564	23	39582 L	13
666-114	15	22569 B	15, 17	41358	23
666-118	15	22569 C	13, 15	41394 A	13
666-149	21	22571 A	15	43139 A	19
666-179	15	22571 B	15	43245 D	21

NOTE: Only the basic part numbers are shown in the index. For various gauges, capacities, etc. available, refer to the listings on pages indicated.

NUMERICAL INDEX OF PARTS

Part No.	Page No.	Part No.	Page No.	Part No.	Page No.
43266	23	51493 BJ	15	54264 B	27
51054	21	51493 BK	15	54264 C	27
51134 C	21	51493 BP	17	54282	13
51134 P	21	51493 BQ	15	54285 C	21
51134 R	21	51530 D	25	54293 A	15
51134 V	23	51530 G	25	54464	27
51147	19	51771	19	54601 A	13
51150	17	52841 G	17	54604	19
51216 G	17	52841 J	17	54605 L	25
51216 M	17	52849	19	54605 M	25
51216 N	17	52849 C	19	54605 N	25
51216 P	17	52882 L	13	54608	21
51223 A	21	52882 M	13	54611 A	23
51235	21	52882 P	13	54615	17
51235 A	21	52882 U	13	54617	17, 19
51235 G	21	52882 Y	13	54620 N	25
51236 A	17, 21	52882 AA	13	54620 P	25
51236 B	21	52882 AC	13	54622	21
51236 D	21	52882 AD	13	54624 L	25
51236 E	21	52882 AE	13	54624 M	25
51236 F	21	52883 R	15	54624 N	25
51236 G	21	52883 S	23	54625	21
51242 L	17, 21	52890 C	15	54630 S	25
51242 M	17	52891 B	15, 17	54630 T	25
51242 P	17	52892	23	54630 U	25
51242 R	15	52894 AB	15	54630 V	25
51242 S	15	52904 G	19	54637	19
51242 Y	17	52916	17	54637 B	13
51242 Z	15	52921 B	17	54637 C	19
51243 C	17	52930 AC	25	54637 D	19
51244 K	21	52936	15	54638	17
51244 L	21	52944 T	15	54644	21
51250 D	17	52951 A	17	54644 A	21
51250 E	17	52951 B	17	54647	17
51250 F	17	52951 C	17, 19	54652	17
51254 A	23	52952 B	17	54654	17
51257 K	23	52952 C	19	54654 C	17
51257 M	23	52958 B	13	54654 D	19
51257 AA	15	52958 D	19	54657	19
51282 AE	13	53137 A	13	54658	17
51283 H	23	53782 B	13	54658 A	13
51290 T	15	53783 A	23	54670	13
51291 A	13	53783 L	23	54680	13
51292 A	23	53783 M	23	54681	13
51292 C	23	53783 N	23	54681 A	13
51292 D	23	53787	23	54682	13
51292 F-2	23	54134 N	21	54682 A	13
51292 F-5	23	54234 B	21	54682 B	13
51292 G	23	54234 C	21	54682 C	13
51294 K	15	54242 B-4-16	23	54685	21
51294 N	15	54242 C	23	54694	15
51294 U	15	54242 D	23	54694 A	15
51295 A	15	54242 E	23	55235 D	19
51306	21	54244 B	21	55235 E	19
51382 A	13	54244 C	21	55244 G	21
51430 F	25, 27	54244 D	21	56356	23
51491 C	23	54244 E	21	56358	17
51493 D	15	54244 F	21	56390 E	15
51493 E	15	54244 G	23	61341 F	19
51493 AG	15	54244 H	21	61354 A	23
51493 AH	15	54244 J	23	61985 A	19
51493 AY	15	54244 M	21	80557	23
51493 BC	29	54244 R	21		
51493 BG	15	54245 C	21		
51493 BH	15	54259	23		

NOTE: Only the basic part numbers are shown in the index. For various gauges, capacities, etc. available, refer to the listings on pages indicated.



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