

FINEST QUALITY

Union Special[®]
LEWIS • COLUMBIA

**INDUSTRIAL
SEWING
MACHINES**

STYLES

56300G

56300R

56300U

56300X

56400P

56500J

56500N

56700J

56900J



STYLE 56300U

CATALOG

No.

129M

**SECOND
EDITION**

**ADVANCED HIGH SPEED
FIFTY THOUSAND SERIES
FLAT BED MACHINES**

Union Special **MACHINE COMPANY**

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. 129 M

INSTRUCTIONS
FOR
ADJUSTING AND OPERATING

LIST OF PARTS

For Styles

56300 G	56400 P
56300 R	56500 J
56300 U	56500 N
56300 X	56700 J
56900 J	

Second Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U. S. A.

FOREWORD

The new Advanced high speed 50000 series machines covered by this catalog represent the latest design of Union Special's flat bed line. These machines offer many advantages on various operations on a variety of garments such as shirts, trousers, slacks, dress pants, overalls, combination suits, jackets, coats, wind-breakers, mackinaws and lumber jackets.

New light weight parts combined with the use of needle bearings results in a lighter running and smoother operating machine. The light weight presser bar mechanism requires less pressure for good feeding and makes lifting the presser foot easier.

Automatic lubrication, with head and base oil pumps for returning filtered oil to the main reservoir reduces wear to all moving parts at high speed. All parts are made by precision methods, insuring complete interchangeability.

It is the constant aim of Union Special to furnish concisely prepared information which enables customers to procure all possible advantages from the use of Union Special machines. The following pages discuss valuable Adjusting and Operating Data. Illustrations are used to pinpoint the areas under discussion. Exploded views, together with explanations as to the part number, name and quantity, follow the Instructions.

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

Union Special MACHINE COMPANY

Engineering Department

IDENTIFICATION OF MACHINES

Each Union Special machine is identified by a Style number on a 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 56300 G". 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 56300 GZ".

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 56300".

APPLICATION OF CATALOG

This catalog applies specifically to the Standard Styles of machines as listed herein. It can also be applied with discretion to some Special Styles of machines in Classes 56300, 56400, 56500, 56700 and 56900. 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 IN CLASS 56300

Advanced High Speed Single Needle Flat Bed Machines, Medium Throw, Needle Bearing Needle Bar Drive, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Positive Automatic Lubricating System, Filtered Oil Return Pumps for Head and Base, Needle Bearings and Bronze Bearings for Feed Bar and Feed Rocker Shafts Greased and Sealed, Lateral Looper Travel, Larger Handwheel and Improved Belt Guard, Prepared for Use with Knee Press for Presser Foot Lifter, Equipped with Rotary Thread Tensions, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

56300 G For seaming trousers, coats and similar garments, made of medium to medium heavy weight materials. Seam Spec. 401-SSa-1. Type 128 GAS needle. Maximum recommended speed 6500 R. P. M.

56300 R For seaming side and inseams on trousers, back and side seams on coats, sleeve seams on jackets, coats, and for similar operations on medium to medium heavy weight materials. Seam Spec. 401-SSa-1. Type 128 GAS needle. Maximum recommended speed 6500 R. P. M.

56300 U For edge seaming operations on trousers, slacks, dress pants, jackets and similar garments made of light to medium weight material. Equipped with top grip feed presser foot. Seam Spec. 401-SSa-1. Type 128 GAS needle. Maximum recommended speed 6500 R. P. M.

56300 X For edge seaming operations on trousers, slacks, dress pants, jackets and similar garments made of light to medium weight material. Equipped with top grip feed presser foot which has a yielding section to the left of needle. Seam Spec. 401-SSa-1. Type 128 GAS needle. Maximum recommended speed 6500 R. P. M.

STYLES OF MACHINES IN CLASS 56400

Advanced High Speed Two Needle Flat Bed Machines, Left Needle in Front, Independent Row, Low Throw, Needle Bearing Needle Bar Drive, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Positive Automatic Lubricating System, Filtered Oil Return Pumps for Head and Base, Needle Bearings and Bronze Bearings for Feed Bar and Feed Rocker Shafts Greased and Sealed, Lateral Looper Travel, Larger Handwheel and Improved Belt Guard, Prepared for use with Knee Press for Foot Lifter, Equipped with Rotary Thread Tensions, Work Space to Right of Needle Bar 8 1/4 Inches.

STYLES OF MACHINES IN CLASS 56400 (Continued)

56400 P For piecing sleeves, joining shoulders, and setting sleeves of ordinary quality shirts and for similar operations on light to medium weight material. Seam Spec. 401-LSc-2, Type 106 GHS needle. Standard gauges Nos. 6, 8, 10, 12, 16, 18. Maximum recommended speed 6500 R. P. M.

STYLES OF MACHINES IN CLASS 56500

Advanced High Speed Two Needle Flat Bed Machines, Independent Row, High Throw, Needle Bearing Needle Bar Drive, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Positive Automatic Lubricating System, Filtered Oil Return Pumps for Head and Base, Needle Bearings and Bronze Bearings for Feed Bar and Feed Rocker Shafts Greased and Sealed, Lateral Looper Travel, Larger Handwheel and Improved Belt Guard, Prepared for use with Knee Press for Foot Lifter, Equipped with Rotary Thread Tensions, Work Space to Right of Needle Bar 8 1/4 Inches.

56500 J For felling overalls, coats, combination suits, and similar garments made of medium heavy weight material. Left needle in front. Seam Spec. 401-LSc-2, Type 128 GS needle. Standard gauges Nos. 16, 18. Maximum recommended speed 6500 R. P. M., depending on material or operation.

56500 N For seaming trousers and similar garments made of medium heavy to heavy weight material. Right needle in front. Seam Spec. 401-SSa-1. Type 130 GS needle. Available in 5, 7 and 10 stitches per inch only. Standard gauge No. 1. Maximum recommended speed 6500 R. P. M.

STYLES OF MACHINES IN CLASS 56700

Advanced High Speed Two Needle Flat Bed Machines, Needles Abreast, Independent Row, Low Throw, Needle Bearing Needle Bar Drive, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Positive Automatic Lubricating System, Filtered Oil Return Pumps for Head and Base, Needle Bearings and Bronze Bearings for Feed Bar and Feed Rocker Shafts Greased and Sealed, Lateral Looper Travel, Larger Handwheel and Improved Belt Guard, Prepared for use with Knee Press for Foot Lifter, Equipped with Rotary Thread Tensions, Work Space to Right of Needle Bar 8 1/4 Inches.

56700 J For one operation of folding and attaching "set-on" center plait and interlining strips to fronts of shirts and similar garments made of light to medium weight material. Starts operation at neck. Equipped with "Tru-Front" folder. Plaits used in garment lengths and extend 1/4 inch beyond the rows of stitching. Seam Spec. 401-LSm-2. Type 106 GKS needle. Standard gauge No. 64. Maximum recommended speed 6500 R. P. M.

STYLES OF MACHINES IN CLASS 56900

Advanced High Speed Three Needle Flat Bed Machines, Left Needle in Front, Independent Row, High Throw, Needle Bearing Needle Bar Drive Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Positive Automatic Lubricating System, Filtered Oil Return Pumps for Head and Base, Needle Bearings and Bronze Bearings for Feed Bar and Feed Rocker Shafts Greased and Sealed, Lateral Looper Travel, Larger Handwheel and Improved Belt Guard, Prepared for use with Knee Press for Foot Lifter, Equipped with Rotary Thread Tensions, Work Space to Right of Needle Bar 8 1/4 Inches.

56900 J For seaming windbreakers, mackinaws, lumberjacks and similar garments made of medium heavy to heavy weight material. Seam Spec. 401-LSb-3, Type 147 GS needle. Standard guage No. 9. Maximum recommended speed 6500 R. P. M.

NEEDLES

Each Union Special needle has both a type 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 largest diameter of blade, measured in thousandths of an inch, midway between shank and eye. Collectively, type and size number represent the complete symbol, which is given on the label of all needles packaged and sold by Union Special.

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 106 GHS, Size 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 032, 036, 040, 044.
106 GKS	Round shank, round point, extra short, double groove, struck groove, oversize ball eye, chromium plated - sizes 032, 036, 040, 044.
128 GS	Round shank, round point, short, double groove, struck groove, ball eye, spotted, undersize eye and grooves 27% of size of needle, chromium plated - sizes 036, 040, 044, 049, 054.
128 GAS	Round shank, round point, short, double groove, struck groove, ball eye, spotted, chromium plated - sizes 032, 036, 040, 044, 049, 054, 060, 067.
130 GS	Round shank, round point, short, double groove, struck groove, ball eye, spotted, government, chromium plated - sizes 032, 036, 040, 044, 049, 054, 060.
147 GS	Round shank, roundpoint, long, double groove, struck groove, ball eye, spotted, short point, undersize eye and grooves, one step reduction, chromium plated - sizes 032, 036, 040, 044, 049, 054, 060, 067.

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

Success in the operation of Union Special machines can be secured only by use of needles packaged under our brand name, *Union Special*, which is backed by a reputation for producing highest quality needles in materials and workmanship for more than three-quarters of a century.

THREAD WRAPPED AROUND $2\frac{1}{4}$ TURNS
CLOCKWISE

FILL MAIN
RESERVOIR
HERE

Union Special

OPERATE
LOW
FULL

STYLE 56600

FOR CORRECT
OIL LEVEL
NEEDLE OF GAUGE
SHOULD BE IN
OPERATE POSITION.

CAUTION!
FILL OIL RESERVOIR
BEFORE STARTING.
MACHINE HAS BEEN DRAINED
BEFORE SHIPPING.

CLASSES
56200
56300

ADJUST. LOOPER TENSION

CLASS 56900

CLASSES 56400 56700

FIG. 1

THREADING AND OILING DIAGRAM

While machine is in operation the needle of the oil gauge should be in the band marked "OPERATE". For further lubricating instructions refer to paragraph on "Lubrication", on page 8. Thread machine in accordance with the threading diagram above.

INSTRUCTIONS FOR MECHANICS

NOTE: The instructions that follow are based on single needle machines, Class 56300. Any instructions peculiar to two and three needle machines will be noted.

LUBRICATION

CAUTION! Oil has been drained from the main reservoir before shipment, so the reservoir must be filled to the proper level as indicated on oil gauge (A, Fig. 1) before beginning to operate. Run machine slowly for several minutes to distribute the oil to the various parts. Full speed operation can then be expected without damage.

RECOMMENDED OIL

Use a straight mineral oil of a Saybolt viscosity of 200 to 250 seconds at 100° Fahrenheit in the main reservoir. This is equivalent to Union Special specification No. 83. Fill main reservoir at plug screw in upper crank chamber cover (A, Fig. 2) and check oil level at gauge (B). Oil is at maximum level when needle is in yellow band marked "Full". Oil should be added when needle is in yellow band marked "Low".

CAUTION! It is important that these machines not be over filled.

It is recommended that a new machine, or one that has been out of service for an extended period be lubricated as follows: Remove the head cover, clean out lint and directly oil the needle bar link and the needle bar. Replace head cover as no further hand oiling will be required.

Run machine slowly for several minutes to distribute oil to the various parts. Oil may be drained from main reservoir by removing plug screw (C) located below the cloth plate at front of the machine.

NOTE: Looper avoid and feed lift eccentrics receive oil thru the mainshaft, so when assembling be sure oil holes in the eccentric lines up with oil holes in mainshaft when spot screw is in time spot. See paragraph on "Changing Stitch Length" for repacking feed bar and feed rocker sealed greased bearings.

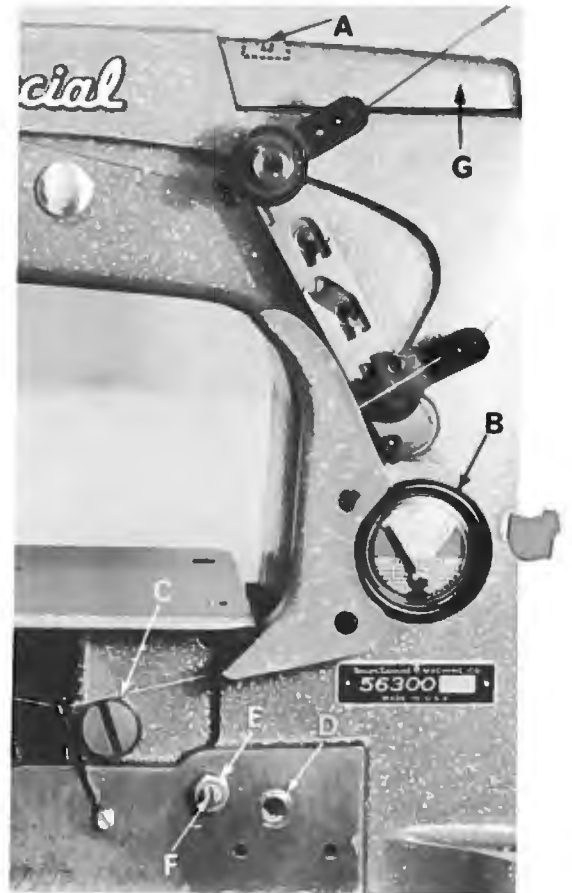


Fig. 2

OIL GAUGE

The oil gauge is set at the factory to show the proper oil level in the reservoir. Should an adjustment become necessary, however, the following steps should be followed:

1. Place the machine upright on a level table or bench.
2. Remove the oil reservoir plug screw (C, Fig. 1) and tip machine forward to drain oil from the reservoir.
3. Make sure all oil is drained from main reservoir.

OIL GAUGE (Continued)

4. Remove lower crank chamber cover, located at the back of the machine.
5. Fill main reservoir to a level even with the bottom contour of the knee press shaft bushing (D, Fig. 2).
6. Loosen lock nut (E) on the calibrating screw (F), and turn the screw to the left or right until the gauge needle rests in the middle of the yellow band marked "LOW".
7. Tighten lock nut (E) and replace plug screw (C).
8. Add oil so that gauge needle rests in the middle of the yellow band marked "FULL".

NEEDLE LEVER BEARING OILER

Remove the head cover and upper crank chamber cover (G, Fig. 2). Check position of needle lever bearing oiler (A, Fig. 3) located inside the arm casting, below the upper crank chamber cover, which lubricates the needle lever stud (B). 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. (Do not allow the oiler to rest on the needle lever.) Allow 1/64 inch clearance as in Figure 3.

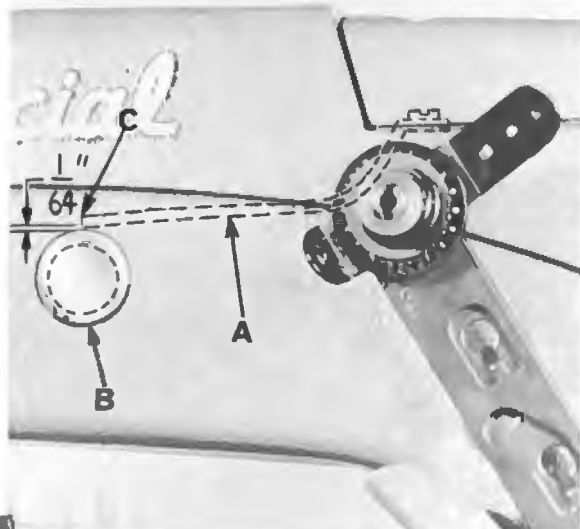


Fig. 3

ALIGNING THE NEEDLE BAR (TWO AND THREE NEEDLE MACHINES)

Align the needle bar (A, Fig. 4) with the proper test plate, using test pins No. PI40 A. See chart below. If test plate and test pins are not available, insert a new set of needles (Type and Size as required) and align the needle bar so that needles correspond with the vertical faces of the needle guard. To turn needle bar, loosen needle bar clamp screw (B, Fig. 4) and turn bar as required. Tighten screw.

<u>Machine Style</u>	<u>Test Plate No.</u>	<u>Test Pin No.</u>
56400 P-6	None	None
56400 P-8	698 AP-8	PI40 A
56400 P-10	698 AP-10	PI40 A
56400 P-12	698 AP-12	PI40 A
56400 P-16	698 AP-16	PI40 A
56400 P-18	698 AP-18	PI40 A
56500 N-5	698 BV-1	PI40 A
56500 N-7	698 BE-1	PI40 A
56500 N-10	698 AZ-1	PI40 A
56500 J-16	698 AT-16	PI40 A
56500 J-18	698 AT-18	PI40 A
56700 J-64	698 AQ-64	PI40 A
56900 J-9	698 AR-9	PI40 A

SYNCHRONIZING LOOPER AND NEEDLE MOTIONS

Turn handwheel in operating direction until the point of the looper (A, Fig. 5), moving to the left is even with the left side of the needle (B). Note the height of the eye of the needle with respect to the looper point, then turn handwheel in the reverse

SYNCHRONIZING LOOPER AND NEEDLE MOTIONS (Continued)

direction until the looper point again moves to the left, and is even with the left side of the needle. If the motions synchronize, the height of the eye of the needle with respect to the looper point will be the same. A variation of .005 inch is allowable. If the distance from the eye of the needle to the point of the looper is greatest when the pulley is turned in the operating direction, move the looper drive shaft synchronizing stud (C) to the rear. Moving it in the opposite direction acts the reverse.

Moving of the looper drive lever shaft synchronizing stud is accomplished as follows: Loosen the clamp screw (D) of the looper drive lever. To move stud to rear (away from operator), a light tap with a small hammer, directly on the stud, is all that is required. To move stud forward (toward operator), remove the cloth plate, throat plate support, oil reservoir top cover and oil reservoir back cover, then, a light tap on the looper drive lever rocker shaft, toward the operator, is all that is required. Then, using the looper drive lever to take up the end play between the looper drive lever rocker shaft and its synchronizing stud, tighten the looper drive lever on the shaft, using screw (D, Fig. 5).

With the looper at the extreme right end of its travel, check the location of the center line of the right looper connecting rod bearing, using gauge No. 21227 CX. Remove nut (E, Fig. 5) and place hole in gauge over threaded stud. The left end of the gauge should locate against the right side of the looper rocker cone (F). If adjustment is necessary, loosen the clamp screw (D) and reposition the looper drive lever (G) as required. Tighten clamp screw. If gauge is not available setting can be checked with a scale. The distance between the center line of the looper rocker cone and the center line of the looper lever stud should be $4 \frac{1}{16}$ inch (Fig. 5).

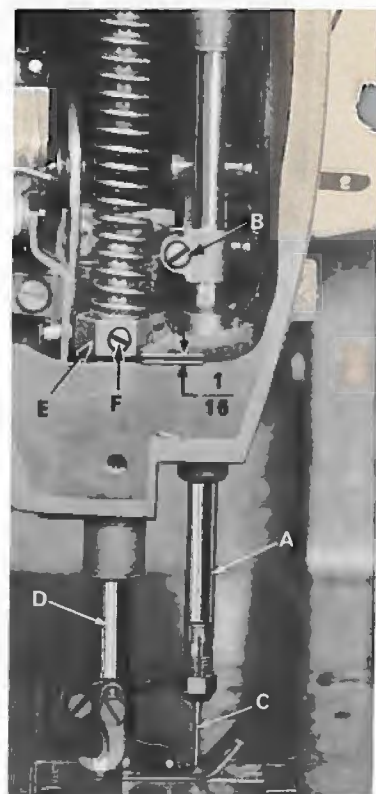


Fig. 4

SETTING THE LOOPER

Insert a new needle, type and size as specified. If the looper gauge is $\frac{5}{32}$ inch, for example, set the looper (A, Fig. 6) so the distance from the center of the needle (B) to the point of the looper is $\frac{5}{32}$ inch, when the looper is at its farthest position to the right. Looper gauge No. 21225- $\frac{5}{32}$ (C) can be used advantageously in making this adjustment. On two needle machines set the back looper to the right needle and on three needle machines set the middle looper to the middle needle, when setting the looper gauge. Refer to chart on the following page for needle Type, looper gauge setting and looper gauge number. If adjustment is required, loosen nut (D) (it has a left hand thread) and nut (E) on connecting

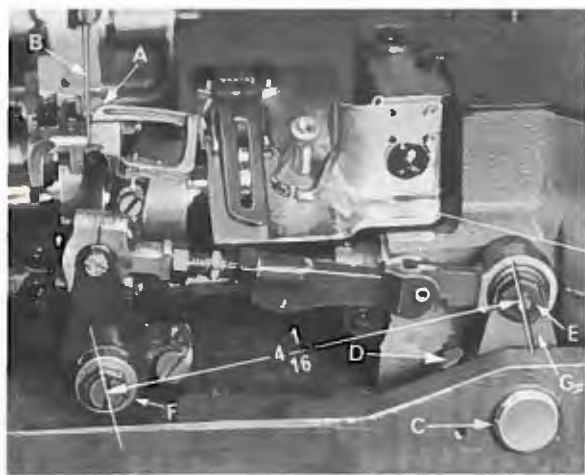


Fig. 5

rod (F), turn the connecting rod forward or backward to obtain the $\frac{5}{32}$ inch dimension. Retighten both nuts, first nut (E), then nut (D). Make sure the left ball joint is in vertical position and does not bind after adjustment.

SETTING THE LOOPER (Continued)

Machine Styles	Needle Type	Looper Gauge Setting	Looper Gauge Number
56400 P	106 GHS	1/8"	21225-1/8
56500 J	128 GS	5/32"	21225-5/32
56500 N	130 GS	5/32"	21225-5/32
56700 J	106 GKS	1/8"	21225-1/8
56900 J	147 GS	7/32"	21225-7/32

The looper is set correctly in line-of-feed, if, as it moves to the left, behind the needle, its point (A, Fig. 7) brushes, but does not pick at the rear of the needle (B).

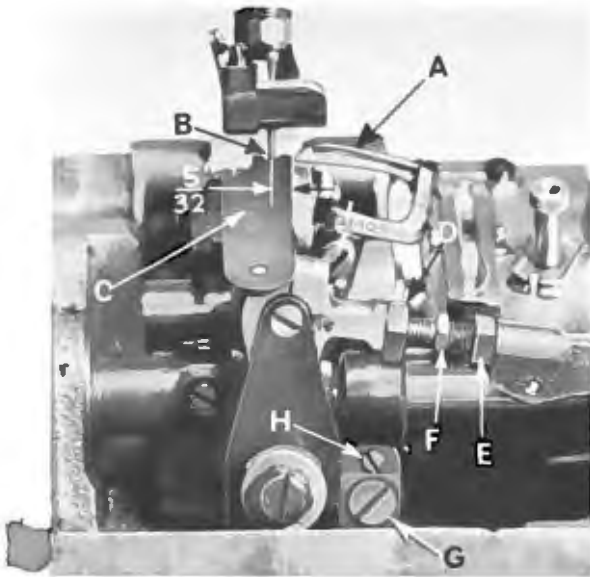


Fig. 6

If adjustment is necessary, loosen lock screw (G, Fig. 6) and turn stop screw (H) as required. Turning stop screw clockwise sets the looper to the rear and turning it counterclockwise acts the reverse. Holding looper to the front while making this adjustment may prove helpful. Tighten lock screw when setting is obtained and recheck the adjustment.

On the two and three needle machines, now insert the other needles and loopers. The same looper - needle relation should exist without any adjustment, other than applying pressure on the looper at front or back of blade, while clamping looper in looper rocker, so as to get the proper in-line-of-feed setting.

SETTING HEIGHT OF NEEDLE BAR

The height of the needle (C, Fig. 4) is correct when the top of its eye is 1/64 inch below the underside of the looper, with the looper point flush with the left side of the needle. On Style 56500 N, the top of the needle eyes should be even with the underside of the looper when the looper point is flush with the left side of the needle. If adjustment is necessary, loosen screw (B) and move needle bar (A) up or down as required and retighten screw. On the two and three needle machines, care should be taken not to disturb the alignment of the needle bar when moving the needle bar either up or down.

All needles are to have equal clearance on the right and left sides of needle slots in throat plate. The descending needles must be deflected alike on the back of the loopers.

SETTING THE FEED DOG

Set the feed dog (A, Fig. 8) in the throat plate (B) so there is equal clearance on all sides. See that the tips of the teeth extend the depth of a tooth or approximately 3/64 inch above the throat plate and are parallel with the throat plate at high point of travel. Adjust the supporting screw (C), under the feed dog, to maintain this setting. Screw (D) is used to hold feed dog in position.

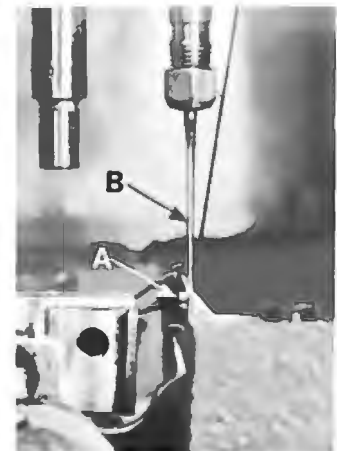


Fig. 7

On Styles 56300 U and 56300 X the tips of the teeth must extend 1/32 inch above the throat plate and the "Grip Feed"

SETTING THE FEED DOG (Continued)

presser foot feed dog must line up with the lower feed dog left to right, and in-line-of-feed the last teeth of the top and bottom feeds should match tooth point to point.

If feed dog teeth are not parallel with the throat plate, loosen nut (A, Fig. 9) and turn screw (B) clockwise to lower the front teeth, and counterclockwise to raise the front teeth. Retighten nut when feed dog is set properly.

Should it be necessary to move the feed dog to the left or right, loosen screws (A, Fig. 10) which hold the feed rocker (B) onto the feed rocker shaft (C), and move feed rocker to desired position and retighten screws. Make sure the feed rocker arm (D) does not bind after making this adjustment.

When the handwheel is turned in the operating direction the feed dog should have equal clearance on both ends of the throat plate slots with feed travel set to desired stitch length.

Should it be necessary to move the feed dog forward or backward, loosen nut (E) which clamps the feed rocker arm to the feed rocker and move the feed rocker forward or backward as needed and retighten nut.

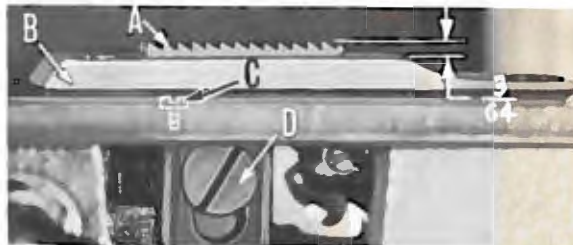


Fig. 8

CHANGING STITCH LENGTH

Set the stitch to required length. This is accomplished by loosening the locknut (F, Fig. 10) (it has a left hand thread) on the end of the stitch regulating stud and turning the stitch adjusting screw (G) located under the left end of the cloth plate, in the head of the main shaft (H), which is marked with "L" and "S". Turning the screw clockwise shortens the stitch (moves stitch regulating stud toward the "S") and turning it in a counterclockwise direction lengthens the stitch (moves stitch regulating stud toward the "L"). Retighten the locknut securely.

Any change in stitch length will necessitate a corresponding change in the rear needle guard setting.

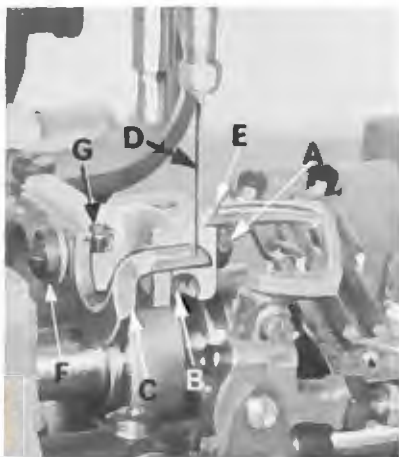


Fig. 9

The feed rocker assembly may require lubrication or repair after years of operation. This can be accomplished as follows: Loosen nut (E, Fig. 10) and remove nut (F). Remove feed rocker arm (D) from machine by rocking slightly. Loosen screws (A) and remove stop collar on right end of shaft (C). The shaft can now be withdrawn. Loosen Allen screw (J) and remove shaft (K). Now, repack bearings.

When packing bearing the parts must be clean and grease should be applied directly from the tube to avoid contamination. Tube of grease can be supplied under the part number 28604 P. If grease seals are replaced they should be pressed in flush with the casting. To assemble, reverse the above procedure. Start tapered end of shafts first, twisting slightly when entering the grease seals to prevent damage. Check for proper adjustment of feed dog as described under "Setting the Feed Dog". Also check to see

there is no binding at any point.

SETTING THE REAR NEEDLE GUARD

Set the rear needle guard (C, Fig. 9) horizontally so that it does not quite contact the rear of the needle (C) when at its most forward point of travel. A clearance of .005 inch is permissible. It should be set as low as possible, yet have its

SETTING THE REAR NEEDLE GUARD (Continued)

vertical face approach within about $3/64$ inch of the needle, until the point of the looper (E), moving to the left, is even with the needle. To move needle guard forward or backward, merely loosen screw (F), move needle guard as required, and retighten screw. To raise or lower needle guard, loosen screw (F), and turn screw (G) clockwise to lower needle guard and counterclockwise to raise it. Retighten screw (F) after guard is properly set.

NOTE: Any change in stitch length will require a change in rear needle guard setting.

THREADING

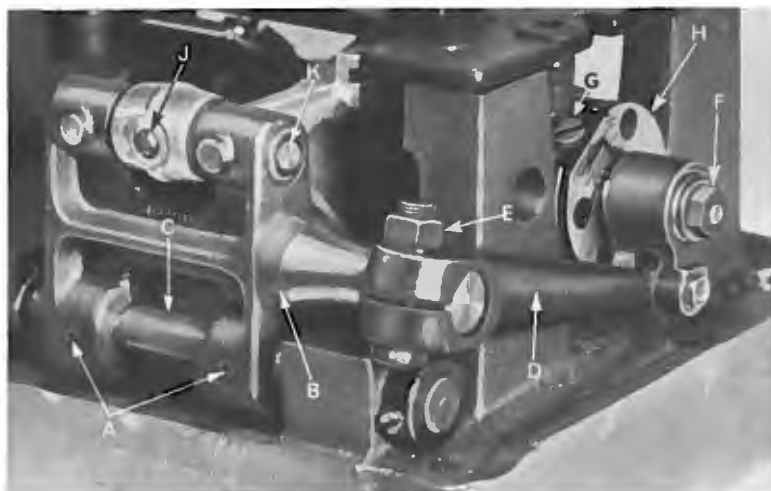


Fig. 10

Draw the looper and needle threads into the machine and start operating on a piece of fabric. Refer to threading diagram (Fig. 1) on page 7, for manner of threading these machines.

THREAD TENSIONS

All threads use the uncurler and nipper tension. The needle thread is to be wrapped around the rotary tension $2\frac{1}{4}$ times, clockwise. The tension on the needle thread should be only sufficient to produce uniform stitches on the under surface of the fabric.

Pull the needle thread through the eyelets and set the needle tension at 3 ounces for all Styles except Styles 56500 J and 56900 J, which should have 5 ounces, and Style 56500 N, which should have 4 ounces. This will feel light.

The looper thread tension is applied at the cast-off support tension disc assembly, and the adjusting nut should be set so that the tension on the looper thread is just sufficient to steady the thread.

THREAD TENSION RELEASE

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

If adjustment is needed, loosen tension release lever screw (A, Fig. 11), located at the back of the machine and move tension disc separator as required. Retighten screw. After adjustment there should be no binding at any point.

SETTING HEIGHT OF PRESSER BAR

The height of the presser bar (D, Fig. 4) is set correctly if it is possible to remove the presser foot when the foot lifter lever (B, Fig. 11) is fully depressed. Also there should be approximately $1/16$ inch clearance between lower surface of the presser bar connection and guide (E, Fig. 4) and the bottom surface of head opening in the bed when the foot lifter lever is

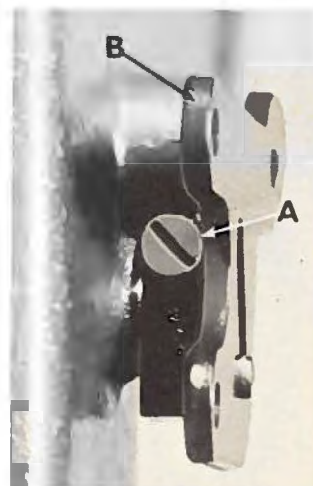


Fig. 11

SETTING HEIGHT OF PRESSER BAR (Continued)

released and the presser foot resting on the throat plate, with the feed dog down below the throat plate.

If adjustment is needed, turn handwheel in operating direction until the needle bar is in the low position. Loosen screw (F). Then, while holding presser foot down on the throat plate surface, pry up presser bar connection and guide with a screwdriver to obtain the $\frac{1}{16}$ inch setting and tighten screw. Check setting by turning handwheel so that needle bar is in its high position and see if presser foot can be removed as mentioned in previous paragraph.

PRESSER FOOT PRESSURE

Regulate the presser spring regulating screw (A, Fig. 12) so that it exerts only enough pressure on the presser foot to feed the work uniformly when a slight tension is placed on the fabric. This is the knurled screw, located directly behind the needle bar in the head of the machine. Turning it clockwise increases the pressure, counterclockwise acts the reverse.

SETTING NEEDLE THREAD TAKE-UP WIRE AND FRAME EYELET

Set the needle thread take-up wire (B, Fig. 12), located adjacent to the needle bar thread eyelet (C), so that its upper surface is even with the top of the holes in the needlebar thread eyelet when the needle bar has completed its downward stroke. Lower this setting for a smaller needle thread loop, and raise it for a larger loop. Set the needle thread frame eyelet (D) so that the eyelet hole is $\frac{3}{4}$ inch above the attaching screw. On Styles 56500 J and 56900 J the eyelet is to be set $\frac{5}{8}$ inch above the attaching screw.

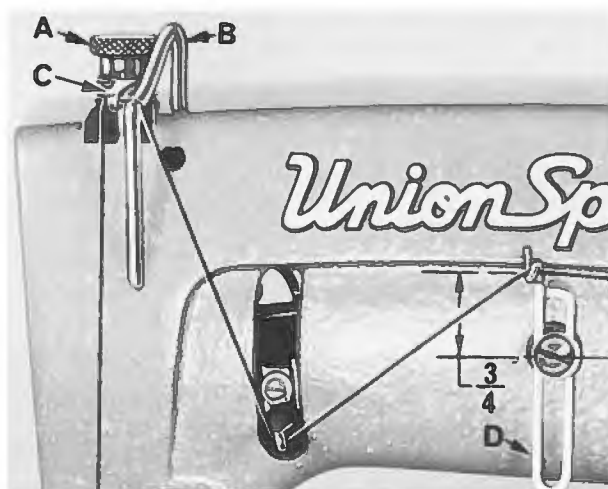


Fig. 12

Before this machine left the factory it was adjusted and inspected to give you the utmost satisfaction and durability at all times. If, however, the machine has been readjusted and is not sewing properly, see the chart below for suggestions which may prove beneficial to you.

SKIPPED STITCHES

Condition	Causes	Cures
Needle loop too small	Take-up wire set too low	Raise take-up wire slightly
	Needle thread stretched at bottom of stroke, loop not formed till stretch relieved.	Lower frame thread eyelet and/or reduce needle tension
	Needle thread creased because it is too tight and needle is hot	Use oversize ball eye needle, lower frame needle eyelet, reduce tension
	Needle thread pinched by needle guard, collapsing needle loop	Drop needle guard slightly
	Thread twisting around needle	Keep needle loop as small as possible, keep needle thread tension to a minimum. Use a left twist thread.
	Needle thread sticking in needle grooves, due to heat	Use oversize ball eye needle, to reduce friction.
	Length of needle eye too long, causing delay in needle loop formation	Use needle with shorter eye, drop needle bar slightly or increase looper gauge 1/64 to 1/32 inch
	Needle does not rise enough to form needle loop properly	Increase looper gauge 1/64 to 1/32 inch
Looper misses needle loop as presser foot is coming off a seam	Material is not held down in front of seam and is flagging	Use tractor type presser foot, if available, or see if presser bar is sticking
	Needle deflecting toward operator	Use sharp point needle
Needle loop formed properly but brushed out of the way by looper	Needle bar set too high	Lower needle bar slightly
Looper misses needle loop when operator is trying to match seams or ends of garments	Needle deflecting toward operator who may be holding back on material while matching seams or ends of garment	Do not hold back excessively on material. Properly adjust feed and maintain a light presser foot pressure so operator does not hold back
Machine misses needle loop when stitch length is increased	Needle deflecting toward the operator because the needle guard is set too far forward	Move needle guard to the rear
Needle misses triangle on looper thread side	Looper thread too loose, not making a good triangle	Increase looper thread tension
	Needle being deflected to the rear by burr on needle point or due to operator pulling on material, or needle glancing off when coming on a seam	Do not pull material at the back. Use a sharp needle to stop needle from glancing off seam. Check needle for burr

NOTE: More detailed information concerning the double locked stitch (stitch type 401) is available under "Stitch Formation, Type 401".

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 numbers of pieces required in the particular view being shown.

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:

21	29105 AG	Looper Drive Lever Crank Assembly, for Styles 56300 G, R, U, X; 56500 J, N; 56900 J -----	1
22	22559 A	Bearing Cap Screw, lower -----	2
23	56343 E	Oil Splasher -----	1
24	22587 K	Bearing Cap Screw, upper -----	2
25	56343 C	Ball Joint Guide Fork -----	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 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

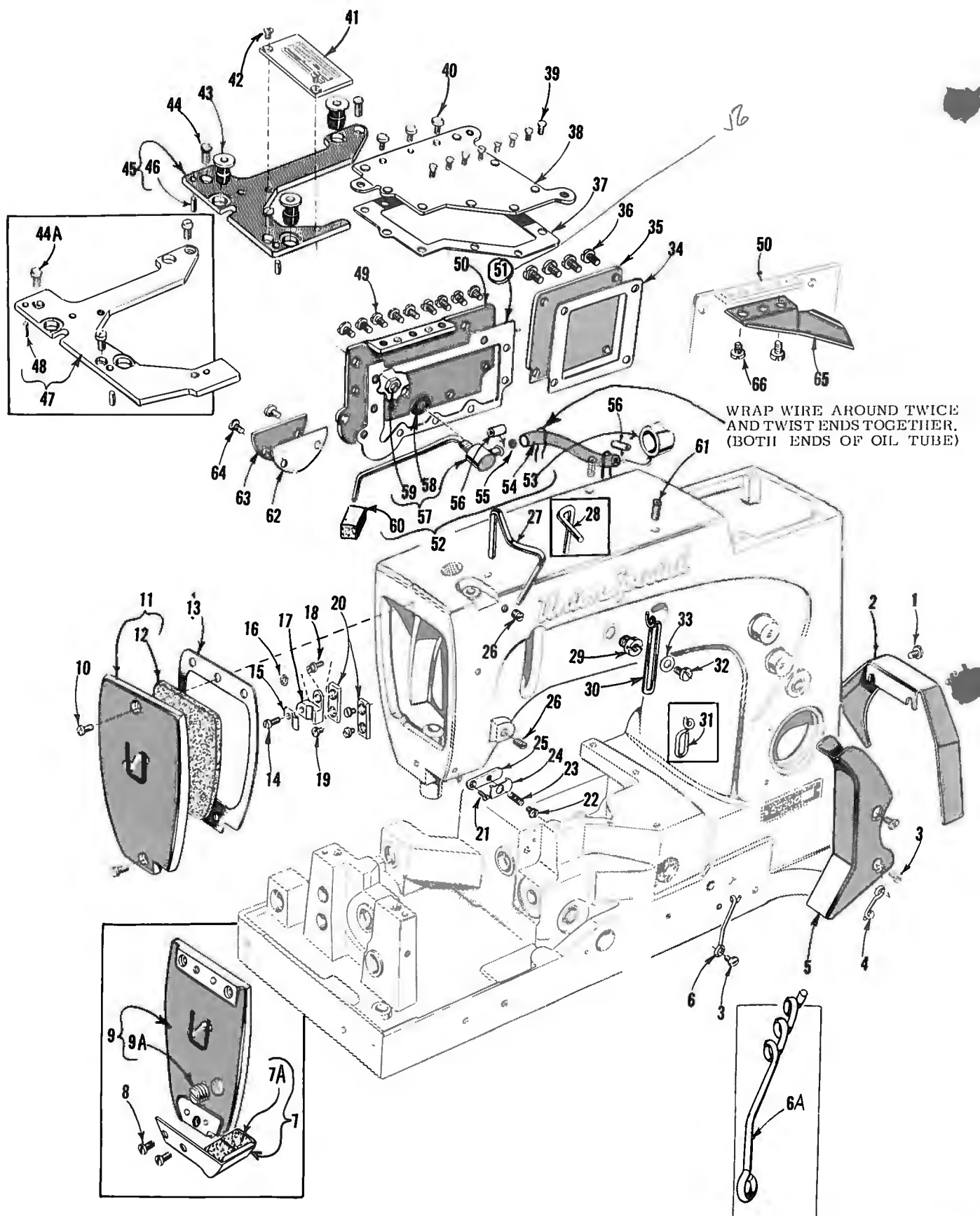
Success in the operation of these machines can be secured only with genuine Union Special Needles and Repair Parts as furnished by the Union Special Machine Company, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles, and are made with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

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

TERMS

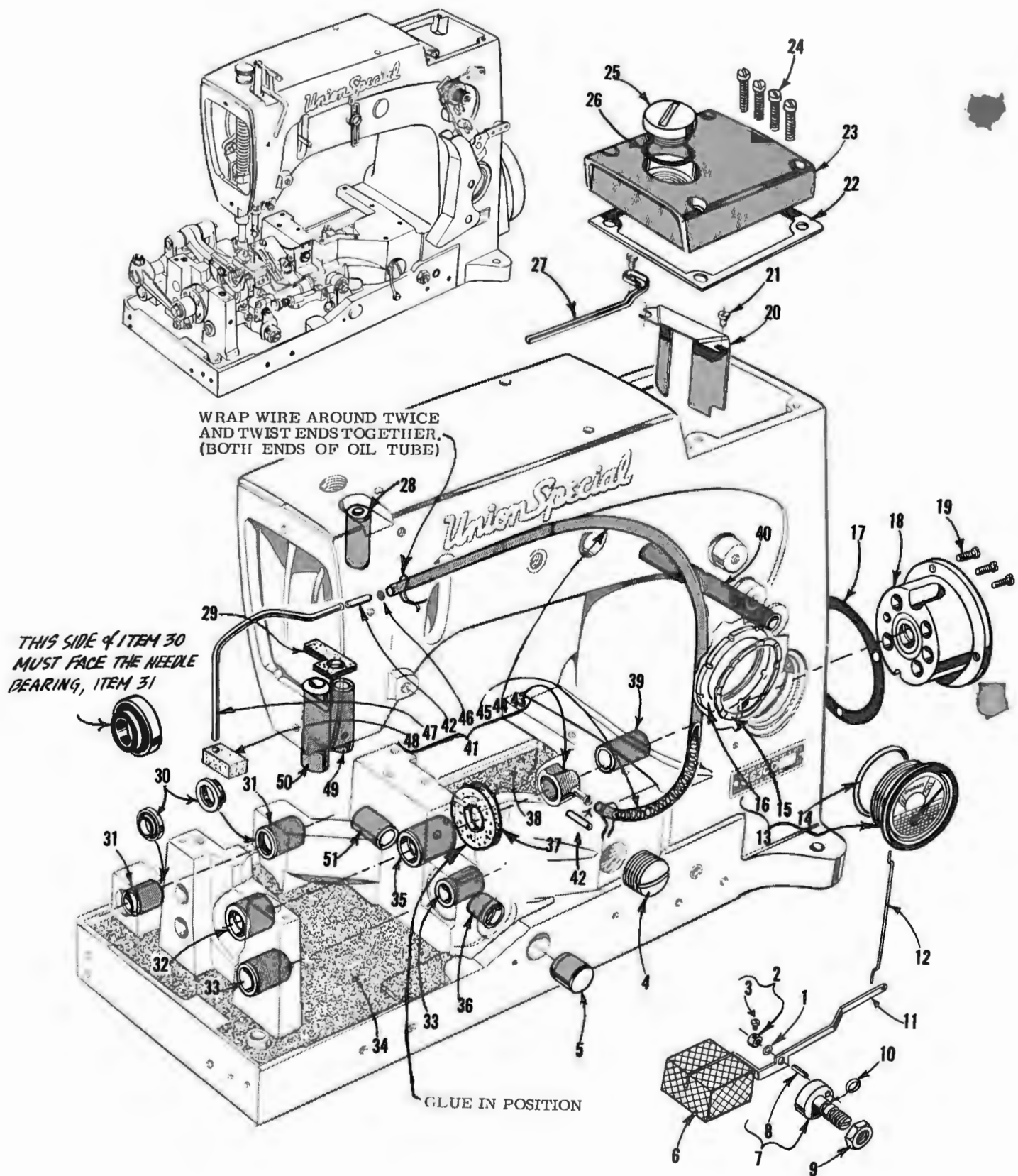
Prices are net cash and subject to change without notice. All shipments are forwarded f. o. b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

EXPLODED VIEWS
AND
DESCRIPTION OF PARTS
FOR
ADVANCED FLAT BED MACHINES



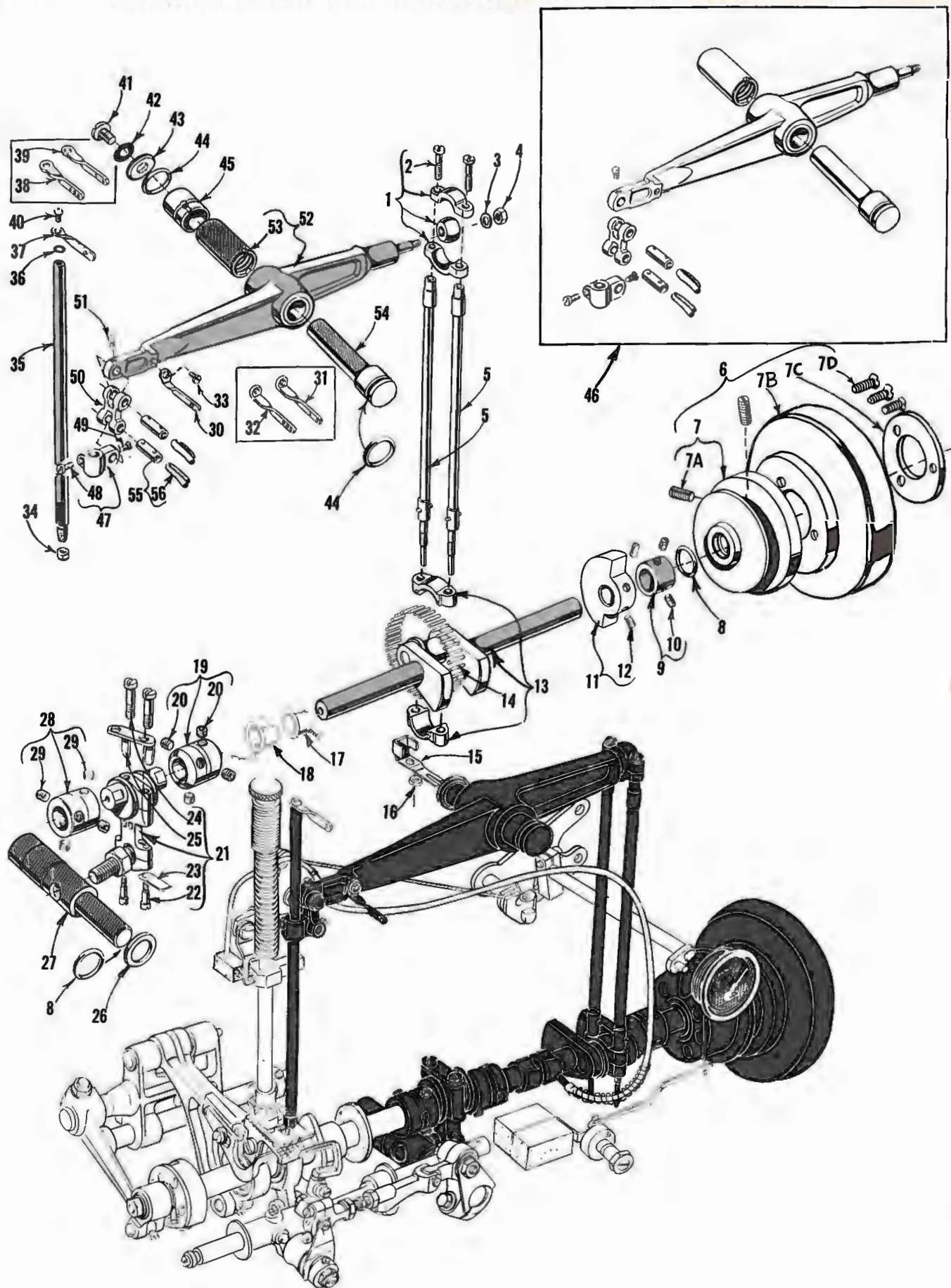
MAIN FRAME, THROAT PLATE SUPPORTS, MISCELLANEOUS COVERS
AND OILING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1	22829	Screw -----	2
2	21375 AV	Belt Guard -----	1
3	98 A	Screw -----	3
4	52 A	Looper Thread Eyelet -----	1
5	56391	Looper Thread Guard -----	1
6	52958 B	Looper Thread Eyelet, for single needle machines -----	1
6A	52958 G	Looper Thread Eyelet, for two and three needle machines -----	1
7	21396 BP	Needle Thread Lubricator, for Style 56900 J -----	1
7A	21396 AG	Felt Pad -----	2
8	22569 C	Screw -----	2
9	56782	Head Cover, for Styles 56700 J, 56900 J -----	1
9A	22733 C	Plug Screw -----	1
10	22569 C	Screw -----	2, 3
11	56382	Head Cover, for all Styles except 56700 J, 56900 J -----	1
12	56382 A	Felt Liner -----	1
13	56382 N	Gasket -----	1
14	22585	Screw -----	1
15	56393 D	Head Oil Tube Clamp -----	1
16	7947	Nut -----	1
17	56393 C	Head Oil Tube Mounting Block -----	1
18	51294 R	Screw -----	1
19	22513	Screw -----	3
20	35731 A	Presser Bar Connection Guide Plate -----	2
21	605 A	Screw -----	1
22	57 WD	Nipper Spring Screw, for Styles 56300 G, R, U, X -----	1
23	15438 C	Nipper Spring, for Styles 56300 G, R, U, X -----	1
24	57 WB	Nipper Spring Plate, for Styles 56300 G, R, U, X -----	1
25	43296	Nipper Spring Base, for Styles 56300 G, R, U, X -----	1
26	95	Plug Screw and Screw for take-up Wire -----	2
27	51270 B	Needle Thread Take-up Wire, for Styles 56300 G, R, U, X -----	1
28	56470	Needle Thread Take-up Wire, for Styles 56400 P; 56500 J, N; 56700 J, 56900 J --	1
29	22889 A	Adaptor Plug Screw -----	1
30	539	Needle Thread Frame Eyelet, for all Styles except 56400 P, 56700 J -----	1
31	51758	Needle Thread Frame Eyelet, for Styles 56400 P, 56700 J -----	1
32	22848	Screw -----	1
33	20	Washer -----	1
34	56382 E	Gasket -----	1
35	56382 D	Crank Chamber Cover, lower -----	1
36	22548	Screw -----	4
37	56382 H	Gasket -----	1
38	56382 G	Oil Reservoir Top Cover -----	1
39	22524	Screw -----	8
40	22585 A	Screw -----	3
41		Throat Plate (See Pages 39, 41, 43) -----	1
42	87	Screw, for throat plate, countersunk head, for Styles 56300 G, R, U, X -----	2
	22570	Screw, for throat plate, fillister head, for all Styles except 56300 G, R, U, X --	2
43	660-313	Well Nut -----	3
44	80	Screw, for Styles 56300 G, R, U, X -----	3
44A	22839	Screw, for all Styles except 56300 G, R, U, X -----	3
45	56380	Throat Plate Support, for Styles 56300 G, R, U, X -----	1
46	51280 J	Dowel Pin -----	2
47	56480	Throat Plate Support, for all Styles except 56300 G, R, U, X -----	1
48	51280 J	Dowel Pin -----	2
49	22848	Screw -----	9
50	56382 F	Oil Reservoir Back Cover -----	1
51	56382 L	Gasket -----	1
52	56393 S	Base Oil Pump Assembly -----	1
53	56393 A	Base Oil Pump -----	1
54	56393 F	Plastic Oil Tube -----	1
55	56393 G	Porex Filter -----	1
56	56393 U	Oil Tube Insert -----	2
57	56393 B	Base Oil Tube Fitting -----	1
58	666-230	Gasket -----	1
59	258 A	Nut -----	1
60	666-214	Intake Felt -----	1
61	22894 E	Screw -----	2
62	56382 K	Gasket -----	1
63	56382 J	Looper Drive Shaft Reservoir Cover -----	1
64	22829	Screw -----	2
65	56382 P	Oil Drip Plate -----	1
66	357	Screw -----	2



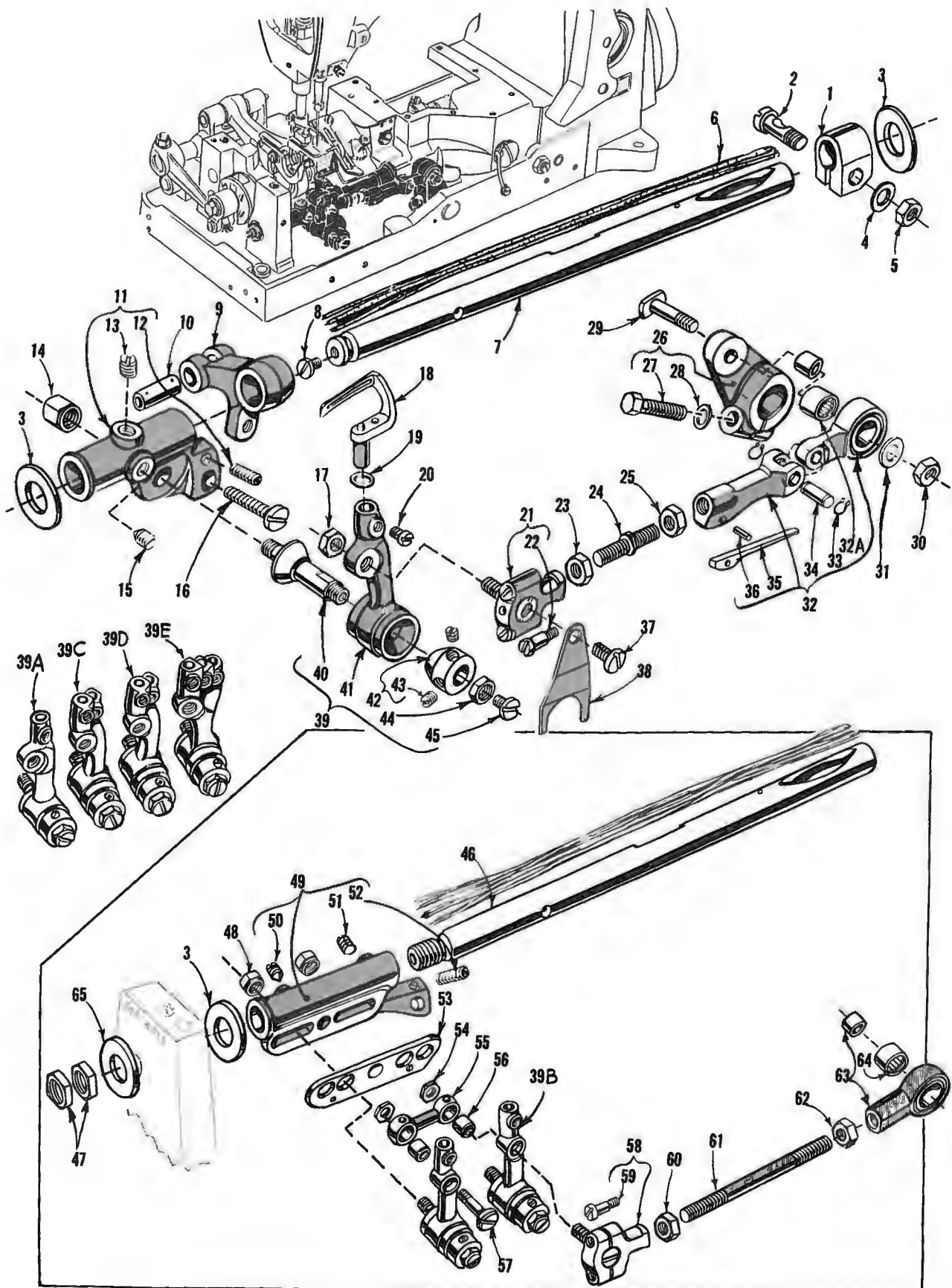
MAIN FRAME, BUSHINGS, OIL GAUGE AND MISCELLANEOUS
OILING PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	27-527 Blk.	Washer -----	1
2	61494 G	Collar-----	1
3	604	Screw -----	1
4	22539 R	Plug Screw -----	1
5	52942 Y	Synchronizing Stud-----	1
6	61494 D	Cork Float-----	1
7	56394 A	Oil Gauge Adjusting Shaft-----	1
8	660-219 A	Pin -----	1
9	11635 B	Nut -----	1
10	660-221	Oil Retaining Ring -----	1
11	56394	Oil Gauge Float Lever -----	1
12	56394 B	Oil Gauge Connecting Rod -----	1
13	63494 E	Oil Gauge-----	1
14	660-316	"O" Ring -----	1
15	63494 G	Spring Washer -----	1
16	63494 F	Nut -----	1
17	56390 E	Bushing Housing Gasket -----	1
18	56390 B	Crankshaft Bushing Housing -----	1
19	22569 B	Screw -----	3
20	52882 Y	Baffle Plate-----	1
21	90	Screw -----	2
22	56382 C	Gasket -----	1
23	56382 B	Upper Crank Chamber Cover -----	1
24	22541 C	Screw -----	4
25	22733 E	Oil Filler Plug Screw -----	1
26	56382 M	Gasket -----	1
27	51282 AE	Needle Lever Bearing Oiler -----	1
28	51154 E	Needle Bar Bushing, upper -----	1
29	56393 R	Oil Attraction Felt-----	1
30	56335 F	Feed Rocker Shaft Oil Seal -----	2
31	56335 A	Feed Rocker Shaft Bushing -----	2
32	56390	Main Shaft Bushing, left-----	1
33	50-895 Blk.	Looper Rocker Shaft Bushing -----	2
34	56393 P	Base Felt, front-----	1
35	56390 D	Main Shaft Bushing, middle-----	1
36	52942 W	Looper Drive Lever Shaft Bushing, front-----	1
37	666-232	Felt Washer -----	1
38	56393 Q	Base Felt, rear -----	1
39	56390 A	Main Shaft Bushing, right -----	1
40	21657 X	Tension Release Lever Shaft Bushing -----	1
41	56393 T	Head Oil Pump Assembly-----	1
42	56393 U	Oil Tube Insert -----	2
43	56393	Head Oil Pump -----	1
44	56393 E	Plastic Oil Tube Connection -----	1
45	56393 N	Oil Tube Support Spring -----	1
46	56393 G	Porex Filter -----	1
47	56393 M	Sewing Head Oil Tube -----	1
48	56393 L	Intake Felt-----	1
49	56354 B	Needle Bar Bushing, lower -----	1
50	51257 AA	Presser Bar Bushing, lower-----	1
51	52942 X	Looper Drive Lever Shaft Bushing, rear -----	1



CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS

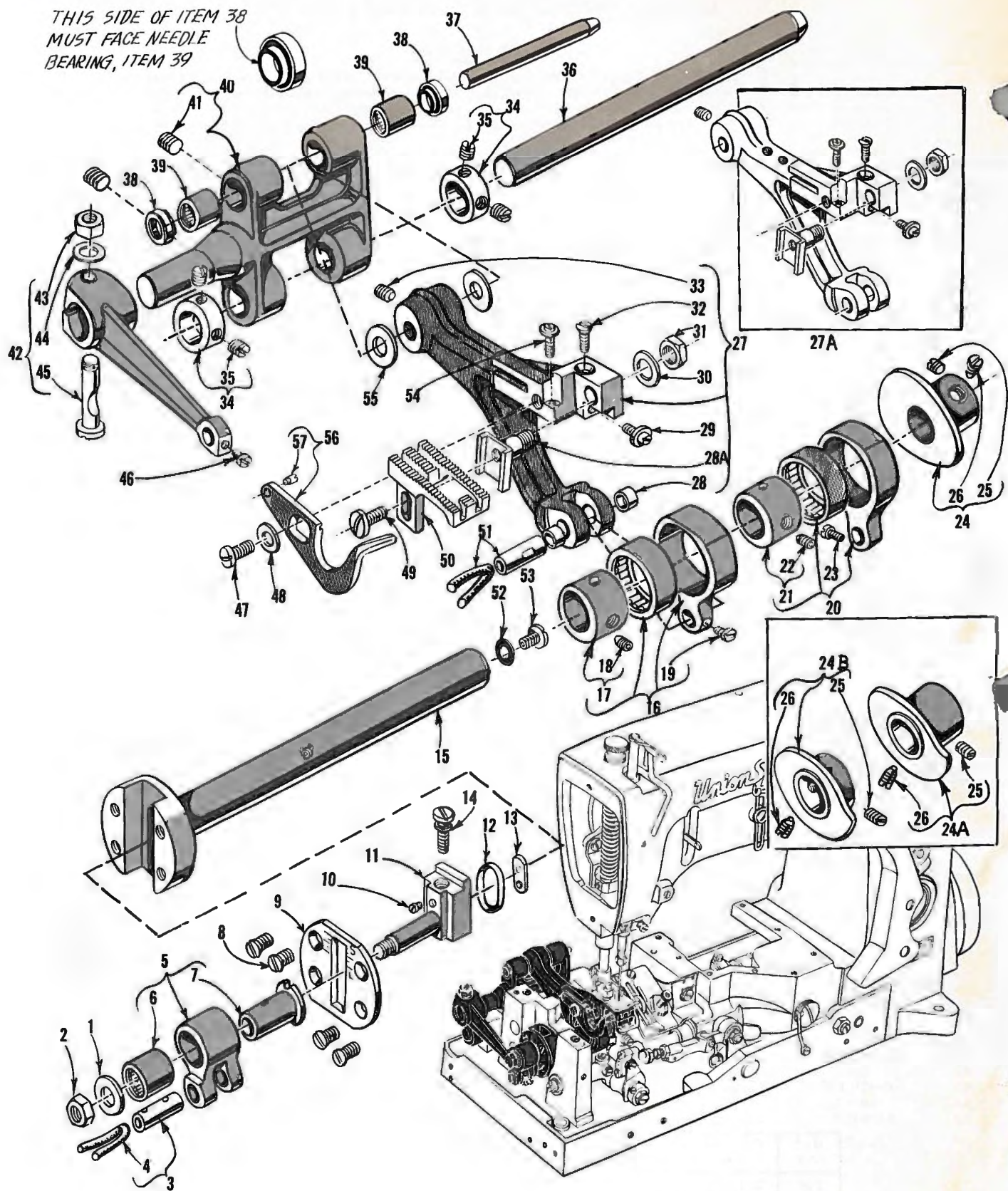
Ref. No.	Part No.	Description	Amt. Req.
1	29066 R	Needle Lever Connecting Rod Upper Ball Joint Assembly -----	1
2	22559 G	Screw -----	2
3	51216 N	Washer -----	1
4	51216 P	Nut -----	1
5	56316	Needle Lever Connecting Rod -----	2
6	56321	Handwheel Assembly -----	1
7	56321 A	Pulley -----	1
7A	22894 AB	Screw -----	2
7B	56321 D	Handwheel -----	1
7C	61321 L	Retainer Plate -----	1
7D	22574	Screw -----	3
8	660-202	"O" Ring, for pulley and looper drive lever rocker shaft -----	2
9	51147	Thrust Collar -----	1
10	95	Screw -----	2
11	51247	Counterweight -----	1
12	22894 J	Screw -----	2
13	29476 LL	Crankshaft Assembly, .910 inch throw, for Styles 56300 G, R, U, X -----	1
	29476 LM	Crankshaft Assembly, .770 inch throw, for Styles 56400 P, 56700 J -----	1
	29476 LN	Crankshaft Assembly, .990 inch throw, for Styles 56500 J, N; 56900 J -----	1
14	51216 M	Needle Bearing -----	28
15	56316 C	Connecting Rod Guide -----	1
16	12934 A	Nut -----	1
17	56393	Head Oil Pump -----	1
18	56393 A	Base Oil Pump -----	1
19	52943 L	Looper Drive Lever and Crankshaft Connection, right -----	1
20	22894 X	Screw -----	4
21	29105 AG	Looper Drive Lever Crank Assembly, for Styles 56300 G, R, U, X; 56500 J, N; 56900 J -----	1
	29105 AH	Looper Drive Lever Crank Assembly, for Styles 56400 P, 56700 J -----	1
22	22559 A	Bearing Cap Screw, lower -----	2
23	56343 E	Oil Splasher -----	1
24	22587 K	Bearing Cap Screw, upper -----	2
25	56343 C	Ball Joint Guide Fork -----	1
26	56342 B	Spacing Washer -----	1
27	52942 A	Looper Drive Lever Rocker Shaft -----	1
28	56343 D	Looper Drive Lever Crank Connection, left -----	1
29	22894 X	Screw -----	4
30	56358 A	Needle Lever Thread Eyelet, for single needle machines, Styles 56300 G, R, U, X -----	1
31	56458	Needle Lever Thread Eyelet, for two needle machines, Styles 56400 P; 56500 J, N; 56700 J -----	1
32	56958	Needle Lever Thread Eyelet, for three needle machines, Style 56900 J -----	1
33	22768	Screw -----	1
34	56	Needle Clamp Nut, for Styles 56300 G, R, U, X -----	1
35		Needle Bar (See Page 35) -----	1
36	27-435 Blk.	Needle Bar Eyelet Washer -----	1
37	56358	Needle Bar Thread Eyelet, for single needle machines, Styles 56300 G, R, U, X -----	1
38	56958 A	Needle Bar Thread Eyelet, for three needle machines, Style 56900 J -----	1
39	56458 A	Needle Bar Thread Eyelet, for two needle machines, Styles 56400 P; 56500 J, N; 56700 J -----	1
40	22768	Screw -----	1
41	22586 R	Screw -----	1
42	51250 F	Gasket -----	1
43	51250 D	Washer -----	1
44	660-212	Oil Seal Ring -----	2
45	51150	Needle Lever Thrust Collar -----	1
46	29348 Y	Needle Lever Assembly -----	1
47	56354	Needle Bar Connection -----	1
48	22562 A	Screw -----	1
49	22564	Screw -----	1
50	56354 A	Needle Bar Link -----	1
51	77	Screw -----	1
52	56315	Needle Lever -----	1
53	56350	Bushing -----	1
54	56350 A	Needle Lever Stud -----	1
55	51054	Link Pin -----	2
56	666-149	Felt Wick -----	1



LOOPER ROCKER AND CONNECTING ROD PARTS

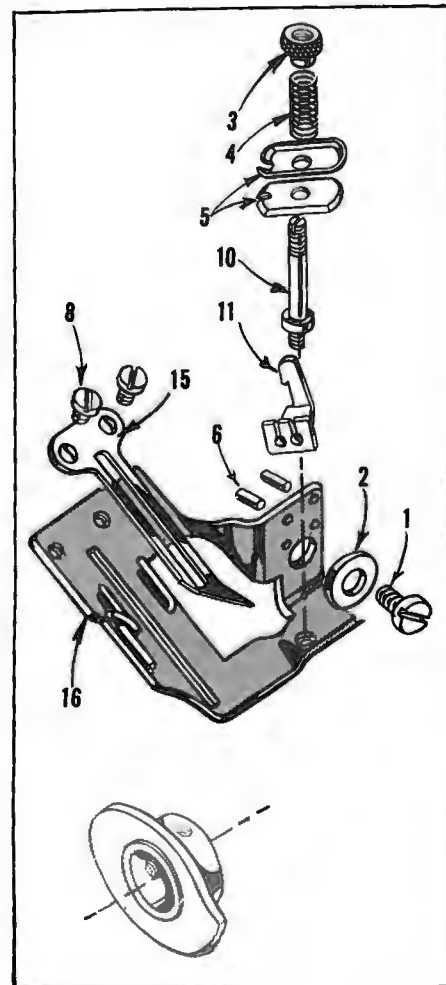
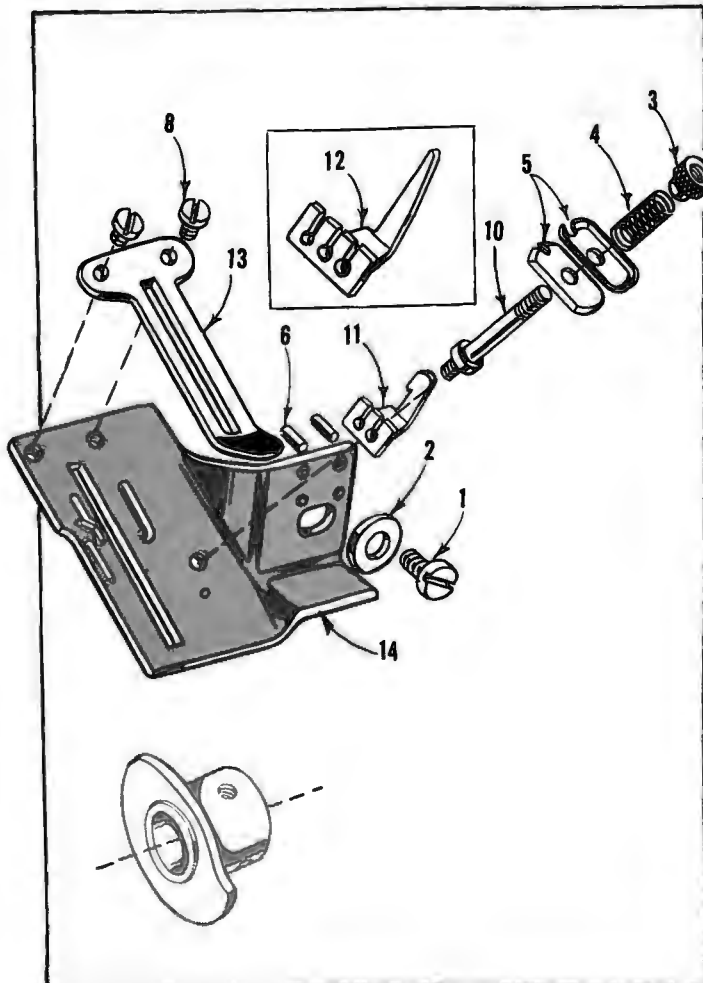
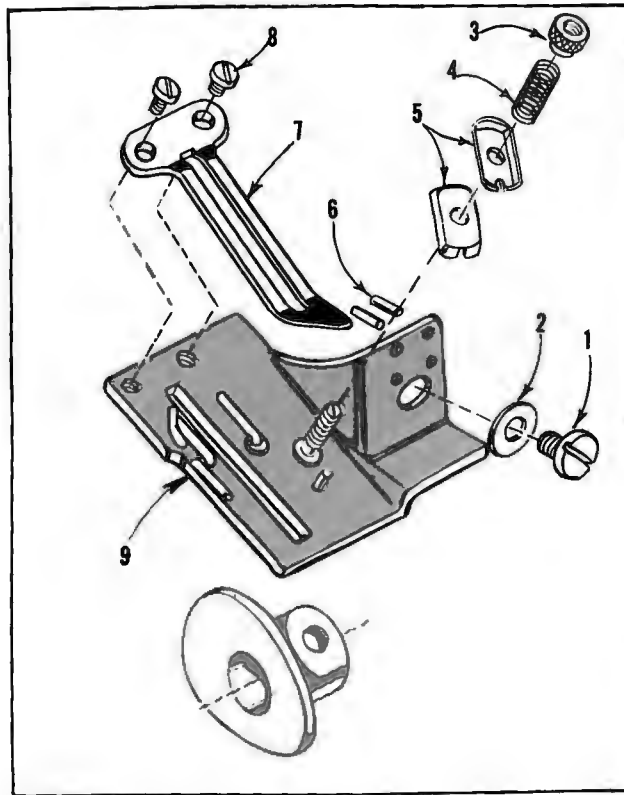
Ref. No.	Part No.	Description	Amt. Req.
1	51244 N	Looper Rocker Shaft Clamp, for all Styles except 56700 J -----	1
2	55244 G	Looper Rocker Shaft Collar Stud, for all Styles except 56700 J -----	1
3	51244 L	Thrust Washer -----	2
4	51216 N	Washer, for all Styles except 56700 J -----	1
5	18	Nut -----	1
6	WO 2	Columbia Wool Yarn (4 strands - 8 inches long) -----	-
7	56344	Looper Rocker Shaft, for all Styles except 56700 J -----	1
8	22513	Screw -----	1
9	56344 B	Looper Rocker Shaft Arm -----	1
10	51236 A	Looper Avoid Link Pin -----	1
11	56344 C	Looper Rocker Frame, for all Styles except 56700 J -----	1
12	719	Stop Screw -----	1
13	98	Screw -----	1
14	51246	Looper Rocker Stud Nut, for all Styles except 56700 J -----	1
15	96	Screw -----	1
16	22874	Looper Rocker Frame Lock Screw -----	1
17	18	Nut, for all Styles except 56700 J -----	1
18	-	Looper (See Page 37) -----	-
19	-	Looper Collar (See Page 37) -----	1
20	73	Screw -----	1, 2, 3
21	56341	Looper Connecting Rod Ball Joint, left, for all Styles except 56700 J -----	1
22	22729 C	Screw -----	2
23	269	Nut, left hand thread -----	1
24	51240 D	Looper Connecting Rod, for all Styles except 56700 J -----	1
25	18	Nut, right hand thread -----	1
26	56342	Looper Drive Lever, marked "A" -----	1
27	22882 C	Screw -----	1
28	51242 M	Washer -----	1
29	52942 R	Looper Lever Stud -----	1
30	18	Nut -----	1
31	20	Washer -----	1
32	56341 B	Looper Connecting Rod Jointed Section Assembly, right, for all Styles except 56700 J --	1
32A	660-311	Needle Bearing -----	1
33	660-310	Truarc Ring -----	2
34	56341 E	Hinge Pin -----	1
35	56341 G	Spring -----	1
36	50-458 Blk.	Spring Pin -----	1
37	87 U	Screw -----	1
38	56393 J	Looper Connecting Rod Ball Joint Oilier, left -----	1
39	-	Looper Rocker Assembly (See Chart Below) -----	-
40	51745	Looper Rocker Cone Stud -----	1
41	-	Looper Rocker (See Chart Below) -----	1
42	15465 F	Looper Rocker Cone -----	1
43	88	Screw -----	2
44	258 A	Lock Nut -----	1
45	22829	Lock Nut Screw -----	1
46	56744 A	Looper Rocker Shaft, for Style 56700 J -----	1
47	51170 D	Nut, for Style 56700 J -----	2
48	1280	Looper Rocker Stud Nut, for Style 56700 J -----	2
49	56744	Looper Rocker Frame, for Style 56700 J -----	1
50	96	Spot Screw -----	1
51	98	Set Screw -----	1
52	719	Stop Screw -----	1
53	56772-64	Looper Rocker Spacing Plate, for Style 56700 J -----	1
54	14077	Nut, for Style 56700 J -----	2
55	51770-64	Looper Rocker Link, for Style 56700 J -----	1
56	51771	Looper Rocker Link Ferrule, for Style 56700 J -----	2
57	22835	Screw, for Style 56700 J -----	1
58	56741	Looper Connecting Rod Ball Joint, left, for Style 56700 J -----	1
59	22729 C	Screw -----	2
60	269	Nut, left hand thread -----	1
61	41047	Looper Connecting Rod, for Style 56700 J -----	1
62	18	Nut, right hand thread -----	1
63	29476 LV	Looper Connecting Rod Assembly, right, for Style 56700 J -----	1
64	660-311	Needle Bearing -----	1
65	56751	Looper Rocker Shaft Thrust Collar, right, for Style 56700 J -----	1

Ref. No.	Ref. No. 39 Assembly	Ref. No. 41 Rocker	I. D. Mark	For Machine Styles	Amt. Req.
39A	29192 V	56313	S	56300 G, R, U, X	1
39B	29192 X	56713	V	56700 J	2
39C	29192 W	56413	U	56400 P	1
39D	29192 AA	56513	X	56500 J, N	1
39E	29192 Y	51913	F	56900 J	1



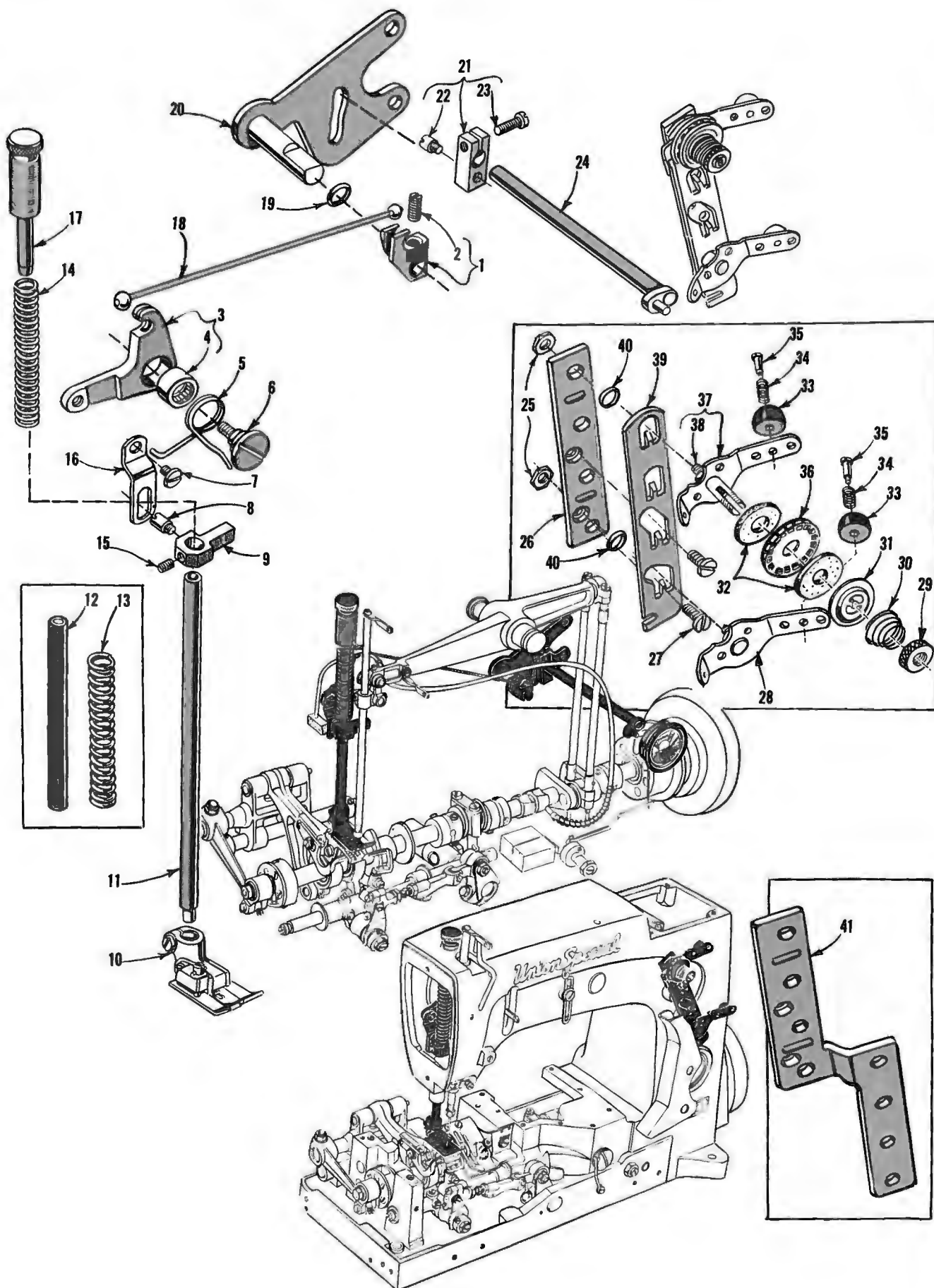
MAIN SHAFT, TAKE-UPS AND FEED DRIVING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1	20	Washer -----	1
2	269	Nut, left thread -----	1
3	51054	Feed Crank Link Pin -----	1
4	666-149	Oil Wick -----	1
5	56336 B	Feed Crank Link -----	1
6	660-169	Needle Bearing -----	1
7	56336 C	Feed Crank Link Ferrule -----	1
8	22525 A	Screw -----	4
9	56322 C	Main Shaft Head Plate -----	1
10	22798 C	Screw -----	1
11	56336	Feed Crank Stud, marked "A" -----	1
12	660-269 B	Quad Ring -----	1
13	56336 D	Feed Crank Stud Insert -----	1
14	22543 A	Stitch Regulating Screw -----	1
15	56322	Main Shaft, for all Styles except 56700 J -----	1
	56722 D	Main Shaft, for Style 56700 J -----	1
16	29476 LK-062	Feed Lift Eccentric Assembly, for Styles 56300 U, X; 56400 P; 56700 J-----	1
	29476 LK-080	Feed Lift Eccentric Assembly, for Styles 56300 G, R; 56500 J, N; 56900 J--	1
17	56306-062	Feed Lift Eccentric, .062 inch throw, for Styles 56300 U, X; 56400 P; 56700 J -----	1
	56306-080	Feed Lift Eccentric, .080 inch throw, for Styles 56300 G, R; 56500 J, N; 56900 J -----	1
18	22894 AA	Screw-----	1
19	77	Screw, for link pin -----	1
20	29476 LK-072	Looper Avoid Eccentric Assembly, for Styles 56300 G, R, U, X; 56500 J, N; 56900 J -----	1
	29476 LK-062	Looper Avoid Eccentric Assembly, for Styles 56400 P; 56700 J -----	1
21	56306-072	Looper Avoid Eccentric, .072 inch throw, for Styles 56300 G, R, U, X; 56500 J, N; 56900 J -----	1
	56306-062	Looper Avoid Eccentric, .062 inch throw, for Styles 56400 P; 56700 J -	1
22	22894 AA	Screw -----	1
23	77	Screw, for link pin -----	1
24	56323	Looper Thread Take-up, for Styles 56300 G, R, U, X; 56500 J, N; 56900 J ----	1
24A	56423	Looper Thread Take-up, for Style 56400 P-----	1
24B	56723	Looper Thread Take-up, for Style 56700 J -----	1
25	22580 D	Set Screw -----	1
26	22764 C	Spot Screw -----	1
27	56334	Feed Bar, for all Styles except 56300 U, X -----	1
27A	56334 C	Feed Bar, for Styles 56300 U, X -----	1
28	56334 A	Bushing -----	2
28A	56334 E	Feed Dog Holder -----	1
29	22863 C	Feed Dog Holder Adjusting Screw -----	1
30	6042 A	Feed Dog Holder Washer -----	1
31	258 A	Nut -----	1
32	22637 P-24	Feed Dog Height Adjusting Screw -----	1
33	22651 CB-4	Screw -----	1
34	56335 D	Feed Rocker Shaft Collar -----	2
35	22894 T	Screw -----	2
36	56335	Feed Rocker Shaft -----	1
37	56334 B	Feed Bar Shaft -----	1
38	56335 E	Feed Rocker Oil Seal -----	2
39	660-249	Feed Rocker Needle Bearing -----	2
40	56335 B	Feed Rocker-----	1
41	22651 CD-4	Screw-----	2
42	56335 C	Feed Rocker Arm -----	1
43	55235 E	Nut -----	1
44	6042 A	Washer -----	1
45	55235 D	Locking Stud -----	1
46	77	Screw, for link pin -----	1
47	22875 H	Screw, for needle guard -----	1
48	61434 G	Washer -----	1
49	22528	Screw, for feed dog -----	1
50		Feed Dog (See Pages 39, 41, 43)-----	1
51	51236 A	Link Pin -----	1
52	56322 B	Gasket -----	1
53	22891 B	Oil Flow Regulating Screw -----	1
54	22834 A	Needle Guard Adjusting Screw -----	1
55	61341 J	Feed Bar Washer -----	2
56		Needle Guard (See Page 35) -----	1
57	22801	Screw -----	1



LOOPER THREAD TAKE-UP PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	22528	Screw -----	1
2	21657 E	Washer-----	1
3	51959 D	Tension Nut-----	1
4	51959 K	Tension Spring -----	1
5	51959 B	Tension Disc-----	2
6	50-216 Blk.	Dowel Pin -----	2
7	52804 A	Cast-off Plate, for Styles 56300 G, R, U, X; 56400 P; 56500 J, N; 56900 J-----	1
8	28	Screw -----	2
9	51557	Take-up Shield, for Styles 56300 G, R, U, X-----	1
10	51492	Tension Post, for Styles 56400 P; 56500 J, N; 56700 J; 56900 J-----	1
11	51459 A	Looper Thread Guide, for Styles 56400 P; 56500 J, N; 56700 J -----	1
12	51959 J	Looper Thread Guide, for Style 56900 J-----	1
13	52804 A	Cast-off Plate, for Styles 56300 G, R, U, X; 56400 P; 56500 J, N; 56900 J-----	1
14	51457 A	Take-up Shield, for Styles 56400 P; 56500 J, N; 56900 J-----	1
15	51704	Cast-off Plate, for Style 56700 J-----	1
16	51757 B	Take-up Shield, for Style 56700 J -----	1

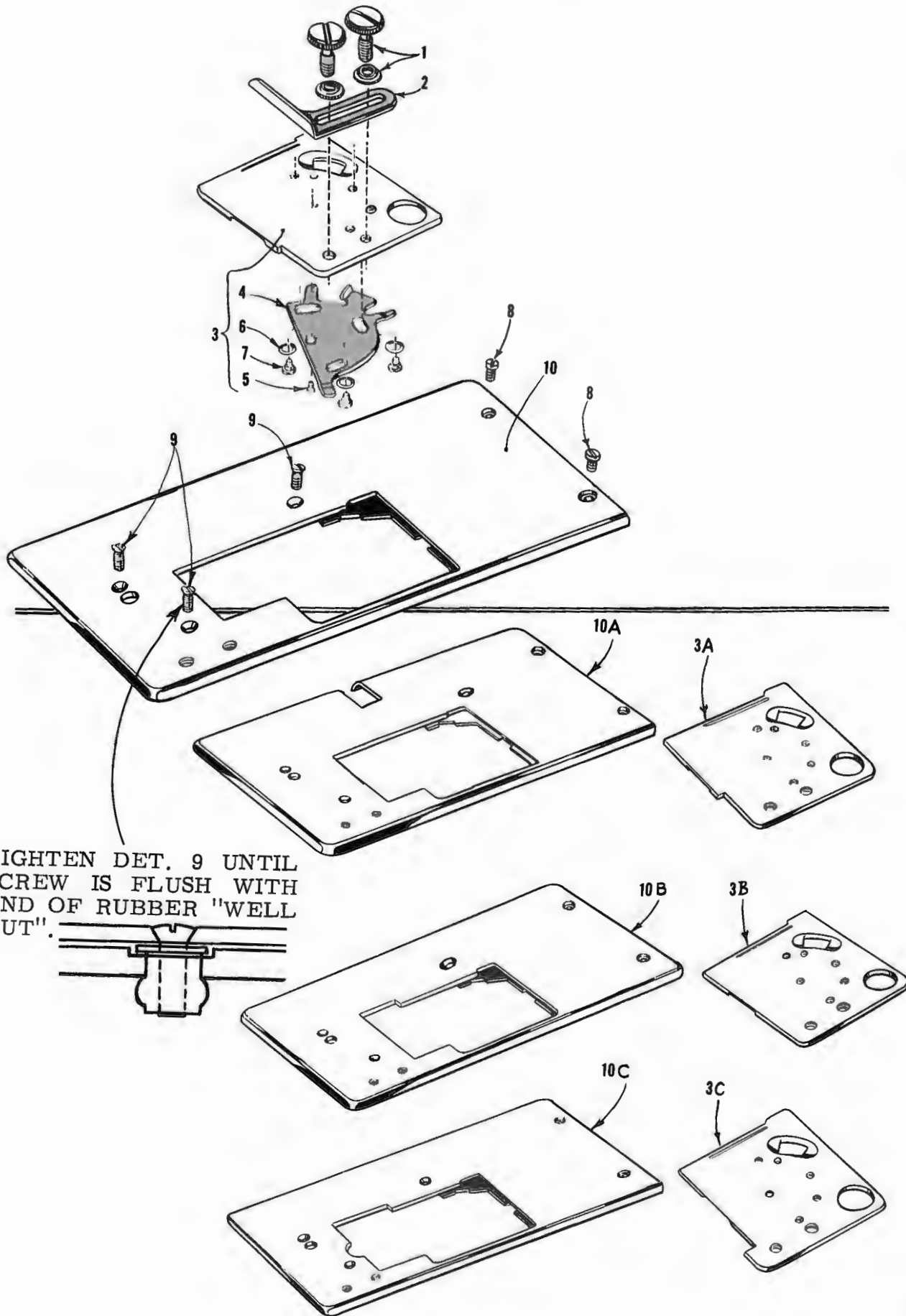


THREAD TENSION AND LIFTER LEVER PARTS

<u>Ref. No.</u>	<u>Part. No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	56383 C	Lifter Lever Connection -----	1
2	74 E	Screw -----	1
3	56383 B	Lifter Lever Bell Crank -----	1
4	660-308	Bell Crank Needle Bearing -----	1
5	56383 D	Lifter Lever Bell Crank Spring -----	1
6	22557 G	Screw -----	1
7	22758 C	Screw -----	1
8	402	Screw -----	1
9	51257 M	Presser Bar Connection and Guide -----	1
10		Presser Foot (See Pages 39, 41, 43) -----	1
11	51257 K	Presser Bar, for all Styles except 56900 J -----	1
12	51957 E	Presser Bar, for Style 56900 J -----	1
13	53787	Presser Spring, for Styles 56300 G, R, 56900 J -----	1
14	51256 C	Presser Spring, for all Styles except 56300 G, R, 56900 J ---	1
15	531	Screw -----	1
16	56383 A	Lifter Lever Link -----	1
17	51256 N	Presser Spring Regulator -----	1
18	56383	Lifter Lever Connecting Cable -----	1
19	660-207	Oil Seal Ring -----	1
20	51283 H	Lifter Lever -----	1
21	21657 Y	Tension Release and Lifter Lever Shaft Connection -----	1
22	402	Screw -----	1
23	22596	Screw -----	1
24	21657 W	Tension Release and Lifter Lever Shaft -----	1

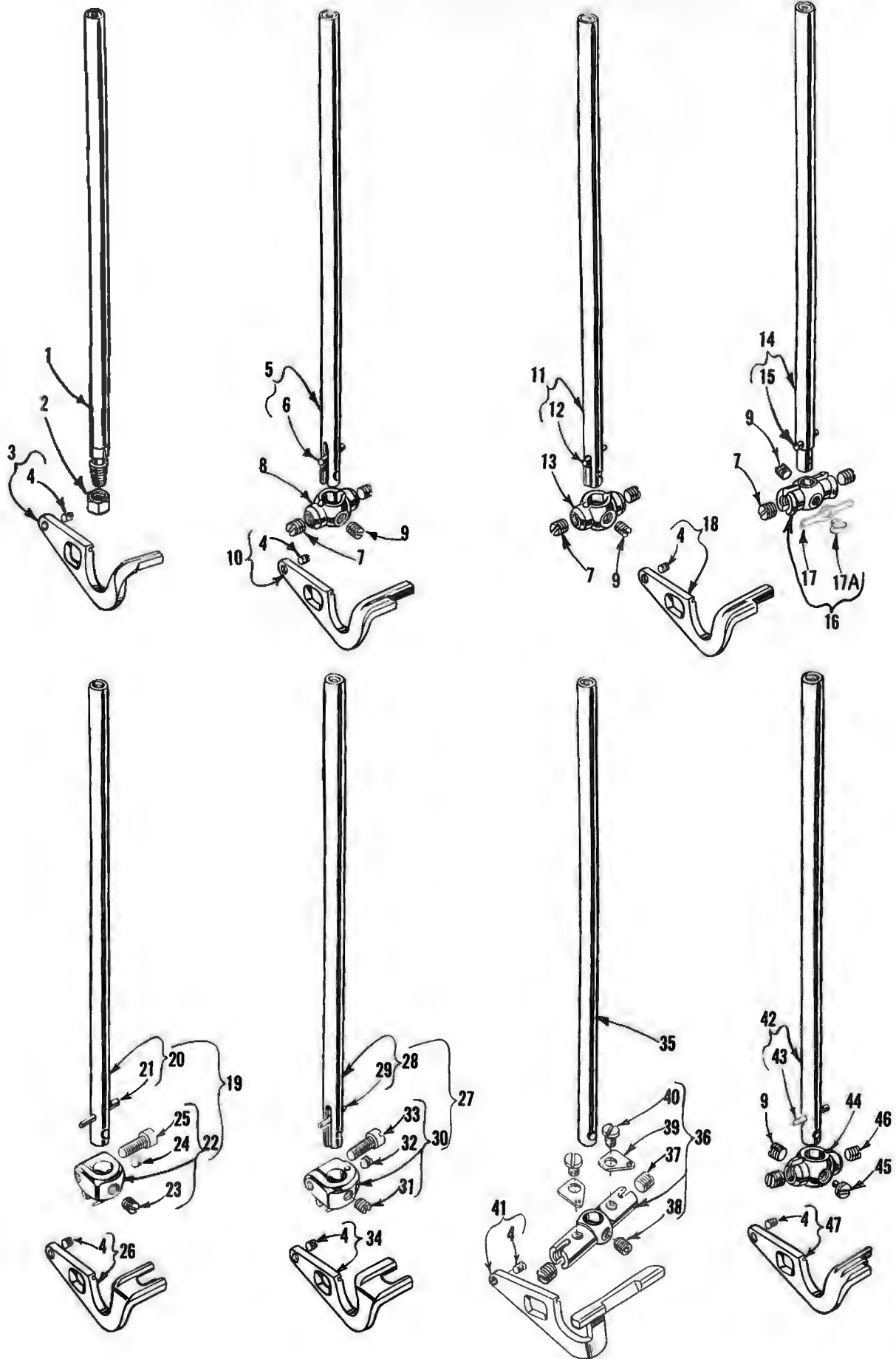
TENSION PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>AMOUNT REQUIRED</u>		
			<u>One Needle Machines</u>	<u>Two Needle Machines</u>	<u>Three Needle Machines</u>
25	14077	Nut	2	4	6
26	56392	Tension Post Support	1	1	-
27	22872 A	Screw	2	2	2
28	56392 C	Looper Thread Tension Eyelet	1	2	3
29	61292 C	Tension Nut	1	2	3
30	61492 M-5	Needle Thread Tension Spring	1	2	3
31	21657 AE	Needle Thread Tension Release Pin	1	2	3
32	61492 T	Felt Washer	2	4	6
33	56359	Thread Nipper Plate	2	4	6
34	56359 A	Thread Nipper Plate Spring	2	4	6
35	22856	Thread Nipper Screw	2	4	6
36	61492 S	Rotary Needle Thread Tension Disc	1	2	3
37	56392 B	Ndl. Thread Tension Post and Eyelet	1	2	3
38	56392 A	Needle Thread Tension Post	1	2	3
39	21657 AD-4	Tension Release	1	1	1
40	660-220	"O" Ring	2	2	2
41	56992	Tension Post Support	-	-	1



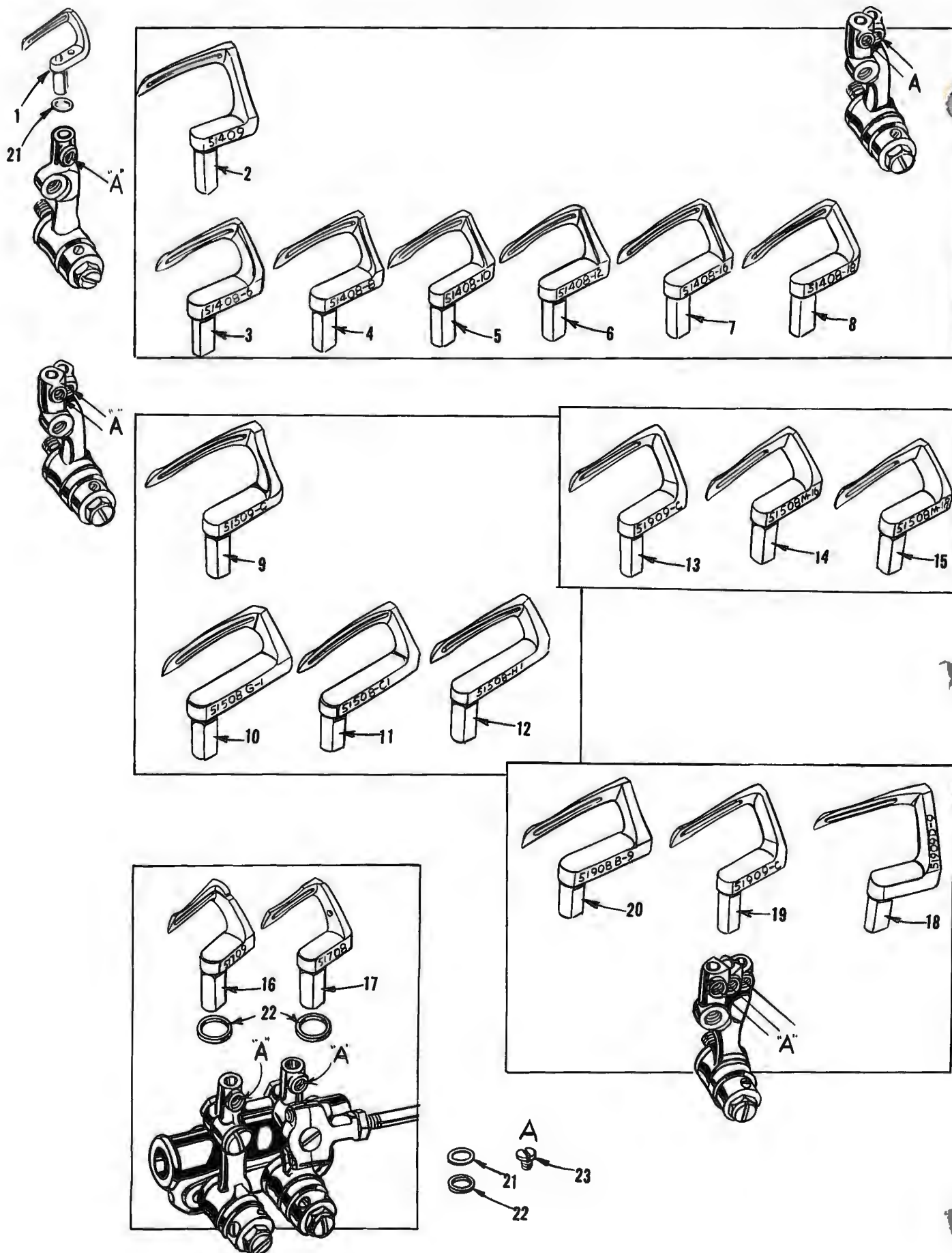
CLOTH PLATES AND CLOTH PLATE COVERS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	25	Screw-----	2
2	24	Edge Guide, for Styles 56300 G, R, U, X; 56500 N-----	1
3	56381-212	Cloth Plate Cover, 3 5/16 inches wide, for Styles 56300 R, X-----	1
3A	56381-222	Cloth Plate Cover, 3 15/32 inches wide, for Styles 56300 G, U-----	1
3B	56381-207	Cloth Plate Cover, 3 15/64 inches wide, for Styles 56400 P; 56500 N, J; 56900 J-----	1
3C	56381-187	Cloth Plate Cover, 2 59/64 inches wide, for Style 56700 J-----	1
4	51281 AC	Cloth Plate Cover Spring-----	1
5	22845 B	Screw-----	1
6	35772 H	Spring Washer-----	3
7	22760 A	Screw-----	3
8	22839 C	Screw-----	2
9	22526 C	Screw-----	3
10	56301	Cloth Plate, for Styles 56300 G, R-----	1
10A	56301 A	Cloth Plate, for Styles 56300 U, X-----	1
10B	56401	Cloth Plate, for Styles 56400 P; 56500 J, N; 56900 J-----	1
10C	56701	Cloth Plate, for Style 56700 J-----	1



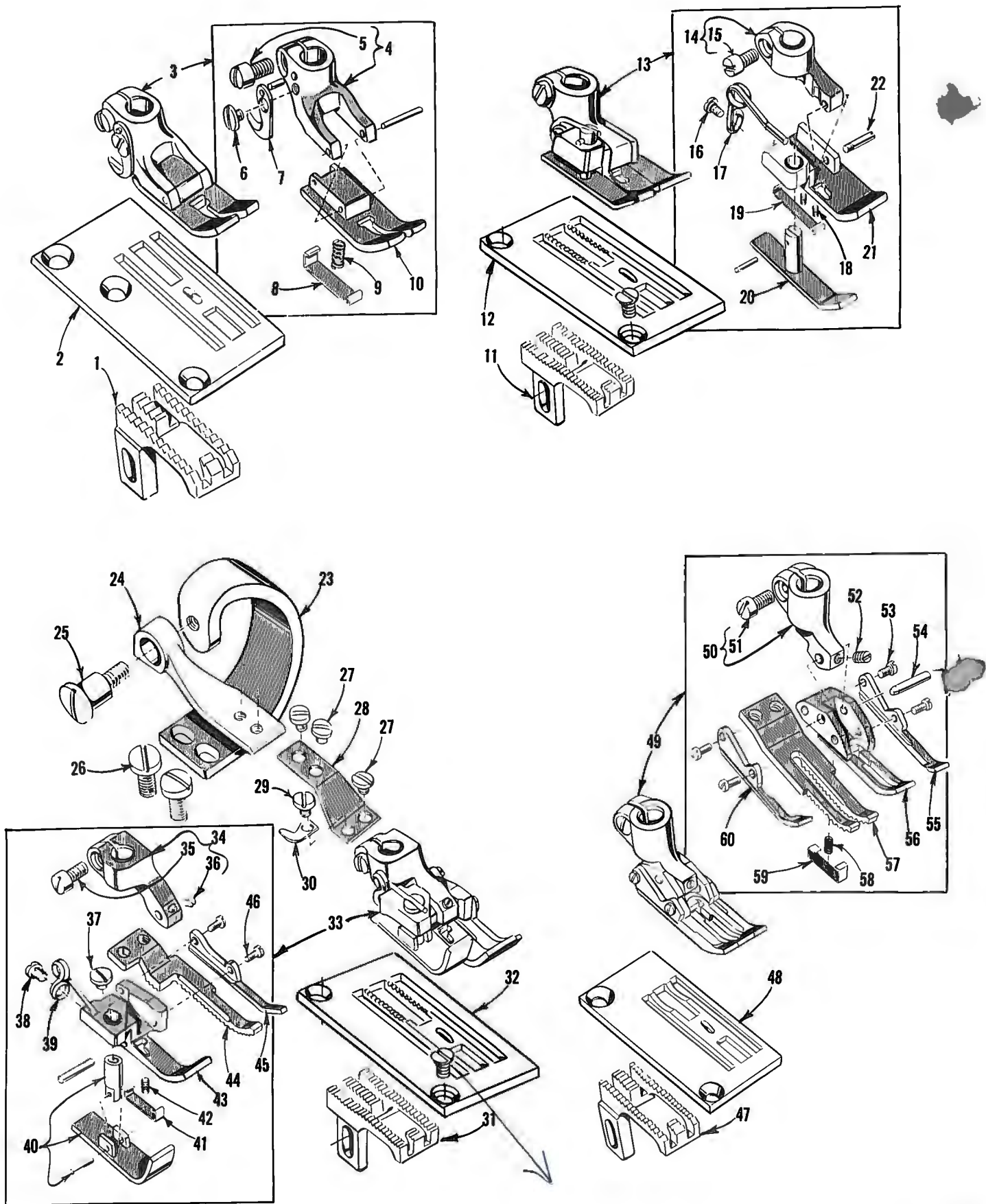
NEEDLE BARS, NEEDLE HOLDERS AND NEEDLE GUARDS

Ref. No.	Part No.	Description	Amt. Req.
1	51217 C	Needle Bar, marked "CU", for Styles 56300 G, R, U, X -----	1
2	56	Needle Clamp Nut, for Styles 56300 G, R, U, X -----	1
3	56325	Needle Guard, for Styles 56300 G, R, U, X -----	1
4	22801	Screw -----	1
5	51417 C-6	Needle Bar, marked "CV-6", for No. 6 gauge, Style 56400 P -----	1
	51417 C-8	Needle Bar, marked "CV-8", for No. 8 gauge, Style 56400 P -----	1
	51417 C-10	Needle Bar, marked "CV-10", for No. 10 gauge, Style 56400 P -----	1
	51417 C-12	Needle Bar, marked "CV-12", for No. 12 gauge, Style 56400 P -----	1
	51417 C-16	Needle Bar, marked "CV-16", for No. 16 gauge, Style 56400 P -----	1
	51417 C-18	Needle Bar, marked "CV-18", for No. 18 gauge, Style 56400 P -----	1
6	50 J-16	Stop Pin -----	1
7	98	Screw, for needle -----	2
8	51418-16	Needle Holder, marked "D-16", for Style 56400 P and No. 16 gauge, Style 56500 J -----	1
9	89	Spot Screw -----	1
10	56425	Needle Guard, for Style 56400 P -----	1
11	56517 B-16	Needle Bar, marked "ET", for No. 16 gauge, Style 56500 J -----	1
12	50 J-16	Stop Pin -----	1
13	51418-16	Needle Holder, for No. 16 gauge, Styles 56500 J, 56400 P -----	1
14	56517 B-18	Needle Bar, marked "EU", for No. 18 gauge, Style 56500 J -----	1
15	50 J-16	Stop Pin -----	1
16	7018 E-5	Needle Holder, marked "G-5", for No. 18 gauge, Style 56500 J -----	1
17	7040-6	Thread Guide -----	1
17A	187 B	Screw -----	1
18	56525	Needle Guard, for Style 56500 J -----	1
19	29202 F-1	Needle Bar Assembly, for 7 S.P.I., Style 56500 N -----	1
	29202 E-1	Needle Bar Assembly, for 10 S.P.I., Style 56500 N -----	1
20	51517 F-1	Needle Bar, marked "DG-1", for 7 S.P.I., Style 56500 N -----	1
	51517 E-1	Needle Bar, marked "DF-1", for 10 S.P.I., Style 56500 N -----	1
21	50 J-16	Stop Pin -----	1
22	51518 G-1	Needle Holder, marked "P-1", for 7 S.P.I., Style 56500 N -----	1
	51518 C-1	Needle Holder, marked "C-1", for 10 S.P.I., Style 56500 N -----	1
23	89	Spot Screw -----	1
24	88 B	Screw, for needle -----	1
25	22729	Screw, for needle -----	1
26	56525 B	Needle Guard, for 7 S.P.I., Style 56500 N -----	1
	56525 C	Needle Guard, for 10 S.P.I., Style 56500 N -----	1
27	29265-5	Needle Bar Assembly, for 5 S.P.I., Style 56500 N -----	1
28	56517 A-5	Needle Bar, marked "ES", for 5 S.P.I., Style 56500 N -----	1
29	50 J-16	Stop Pin -----	1
30	56518 A-5	Needle Holder, marked "AS", for 5 S.P.I., Style 56500 N -----	1
31	89	Spot Screw -----	1
32	22743	Screw, for needle -----	1
33	22729	Screw, for needle -----	1
34	56525 A	Needle Guard, for 5 S.P.I., Style 56500 N -----	1
35	51717	Needle Bar, marked "AU", for Style 56700 J -----	1
36	51718 A-64	Needle Holder, marked "AB-64", for 64 gauge, Style 56700 J -----	1
37	98	Screw, for needle -----	2
38	22894 P	Spot Screw -----	1
39	51718 B-64	Needle Stop and Thread Eyelet -----	2
40	22513 B	Screw -----	2
41	56725	Needle Guard, for Style 56700 J -----	1
42	56917	Needle Bar, marked "EP-9", for Style 56900 J -----	1
43	50 J-26	Stop Pin -----	1
44	35818 N-9	Needle Holder, marked "C-9", for Style 56900 J -----	1
45	22752	Screw, for center needle -----	1
46	22580	Screw, for needle -----	2
47	56925	Needle Guard, for Style 56900 J -----	1



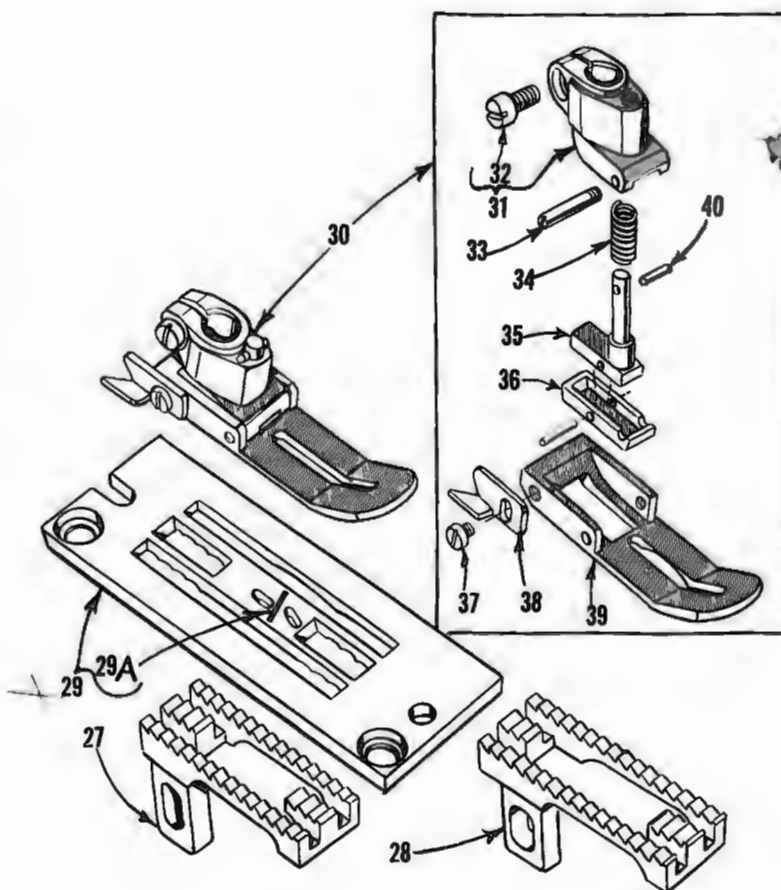
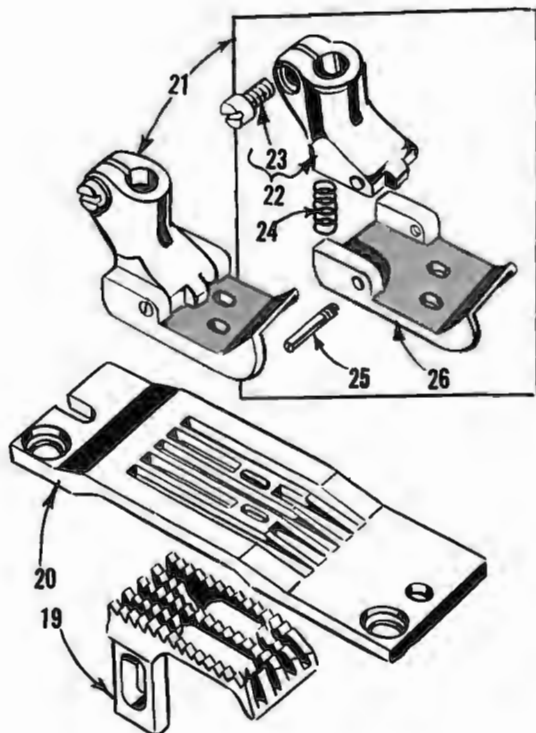
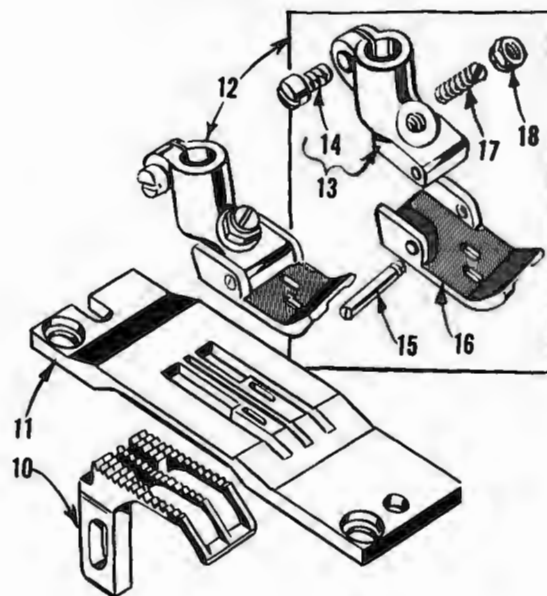
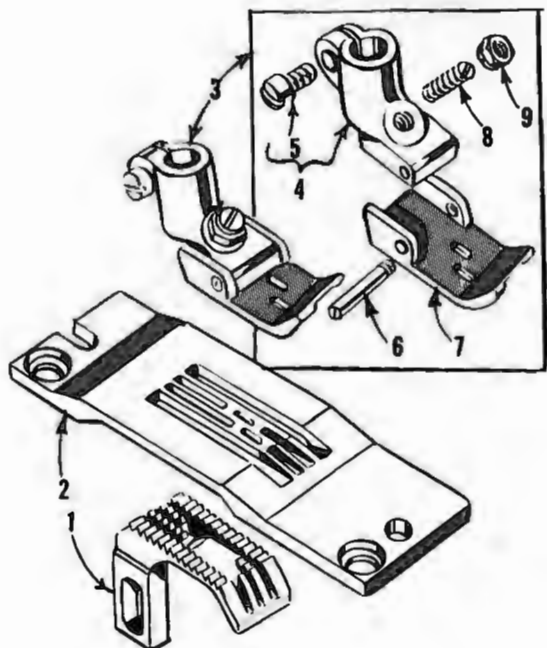
LOOPERS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	51409 C	Looper, for Styles 56300 G, R, U, X-----	1
2	51409	Looper, back, for Style 56400 P-----	1
3	51408-6	Looper, front, for No. 6 gauge, Style 56400 P-----	1
4	51408-8	Looper, front, for No. 8 gauge, Style 56400 P-----	1
5	51408-10	Looper, front, for No. 10 gauge, Style 56400 P-----	1
6	51408-12	Looper, front, for No. 12 gauge, Style 56400 P-----	1
7	51408-16	Looper, front, for No. 16 gauge, Style 56400 P-----	1
8	51408-18	Looper, front, for No. 18 gauge, Style 56400 P-----	1
9	51509 C	Looper, back, for Style 56500 N-----	1
10	51508 G-1	Looper, front, for 7 S.P.I., Style 56500 N-----	1
11	51508 C-1	Looper, front, for 10 S.P.I., Style 56500 N-----	1
12	51508 H-1	Looper, front, for 5 S.P.I., Style 56500 N-----	1
13	51909 C	Looper, back, for Style 56500 J and middle looper for Style 56900 J-----	1
14	51508 M-16	Looper, front, for No. 16 gauge, Style 56500 J-----	1
15	51508 M-18	Looper, front, for No. 18 gauge, Style 56500 J-----	1
16	51709	Looper, left, for Style 56700 J-----	1
17	51708	Looper, right, for Style 56700 J-----	1
18	51909 D-9	Looper, back, for Style 56900 J-----	1
19	51909 C	Looper, middle, for Style 56900 J and back looper for Style 56500 J-----	1
20	51908 B-9	Looper, front, for Style 56900 J-----	1
21	21210 A	Looper Collar, for Styles 56300 G, R, U, X-----	1
22	21210	Looper Collar, for Style 56700 J-----	2
23	73	Screw, for looper-----	1, 2, 3



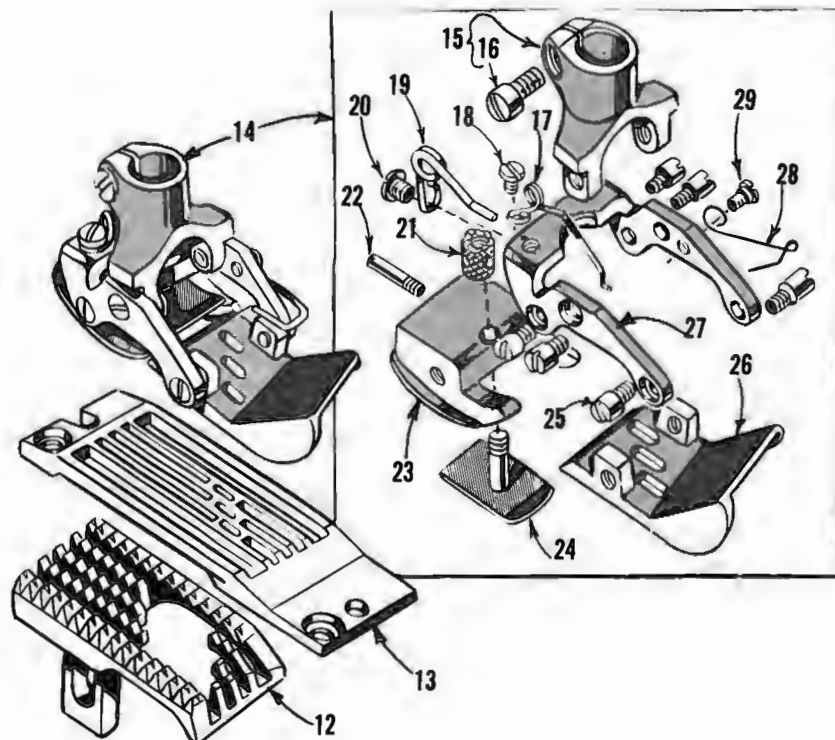
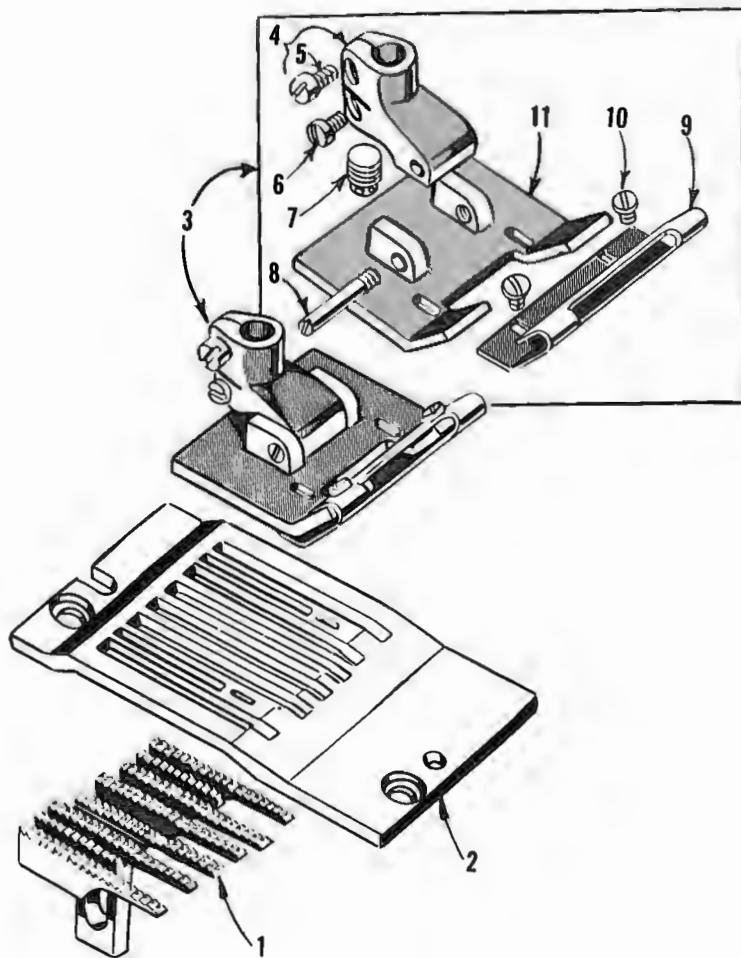
FEED DOGS, THROAT PLATES, PRESSER FEET

Ref. No.	Part No.	Description	Amt. Req.
1	51305 A	Feed Dog, 12 teeth per inch, for Style 56300 G-----	1
2	9224 E	Throat Plate, for Style 56300 G-----	1
3	51320 M	Presser Foot, for Style 56300 G-----	1
4	51330 AJ	Presser Foot Shank-----	1
5	91	Screw-----	1
6	187 B	Screw-----	1
7	1741 B	Chain Cutting Knife-----	1
8	51330 AH	Yielding Section-----	1
9	51330 W	Spring-----	1
10	51330 AG	Presser Foot Bottom-----	1
11	56305	Feed Dog, 16 teeth per inch, for Styles 56300 R, X-----	1
12	51324 K	Throat Plate, for Styles 56300 R, X-----	1
13	56320 R	Presser Foot, for Style 56300 R-----	1
14	56330 D	Presser Foot Shank-----	1
15	91	Screw-----	1
16	604	Screw-----	1
17	19146 A	Spring-----	1
18	61430 BT	Spring-----	2
19	56330 B	Yielding Section-----	1
20	51230 N	Yielding Section-----	1
21	56330 C	Presser Foot Bottom-----	1
22	22799 G	Hinge Screw-----	1
23	51334 A	Top Grip Feed Presser Foot Driving Arm, for Styles 56300 U, X-----	1
24	51334 D	Presser Foot Connecting Rod, for Styles 56300 U, X-----	1
25	22758 G	Screw-----	1
26	22875 J	Screw-----	2
27	28	Screw-----	3
28	51334 C	Connecting Rod Flat Spring, for Styles 56300 U, X-----	1
29	22561	Screw-----	1
30	51330 S	Chain Cutting Knife, for Styles 56300 U, X-----	1
31	56305	Feed Dog, 16 teeth per inch, for Styles 56300 R, X-----	1
32	51324 K	Throat Plate, for Styles 56300 R, X-----	1
33	56320	Presser Foot, for Style 56300 X-----	1
34	51330 Z	Presser Foot Shank-----	1
35	91	Screw-----	1
36	1096	Screw-----	1
37	22561	Screw-----	1
38	604	Screw-----	1
39	19146 A	Spring-----	1
40	51330 AB	Presser Foot Yielding Section-----	1
41	56330 F	Yielding Section-----	1
42	61430 BT	Spring-----	1
43	56330	Presser Foot Bottom, marked "AG"-----	1
44	51330 AD	Presser Foot Feeding Section-----	1
45	51330 AE	Feed Section Guide-----	1
46	22738	Screw-----	2
47	9205 E	Feed Dog, 16 teeth per inch, for Style 56300 U-----	1
48	51324 F	Throat Plate, for Style 56300 U-----	1
49	56320 U	Presser Foot, for Style 56300 U-----	1
50	51330 M	Presser Foot Shank-----	1
51	91	Screw-----	1
52	1096	Screw-----	1
53	22738	Screw-----	4
54	1594 A	Hinge Pin-----	1
55	51330 R	Feed Section Guide, right-----	1
56	56330 E	Presser Foot Bottom-----	1
57	51330 N	Presser Foot Feeding Section-----	1
58	61430 BT	Spring-----	1
59	56330 F	Yielding Section-----	1
60	51330 P	Feed Section Guide, left-----	1



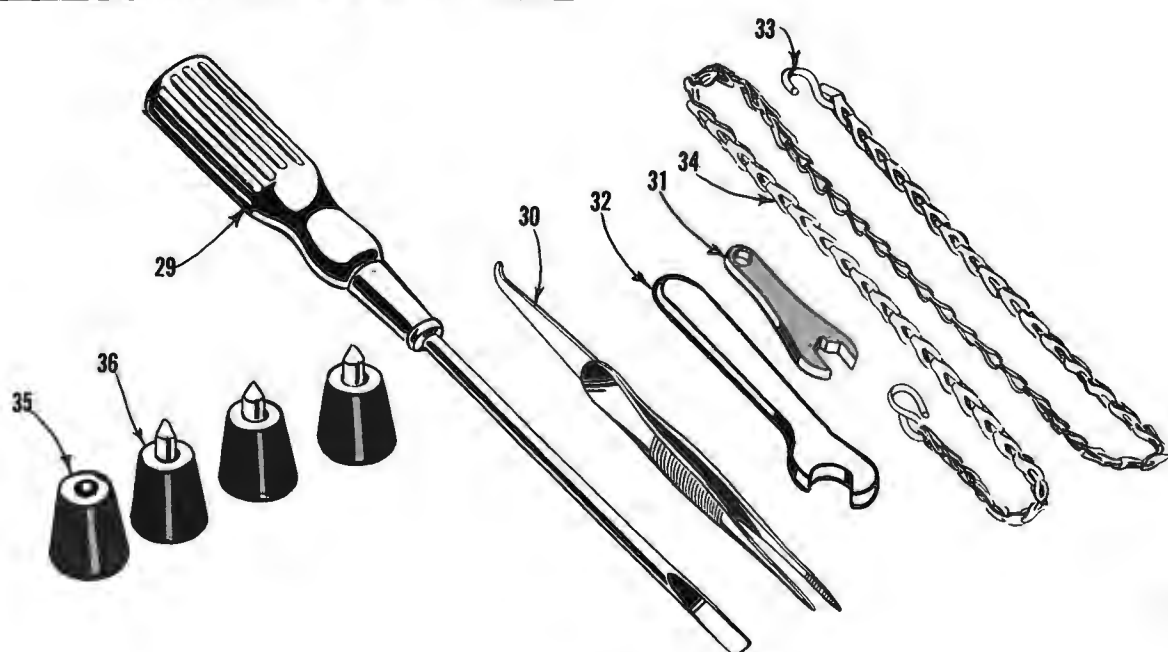
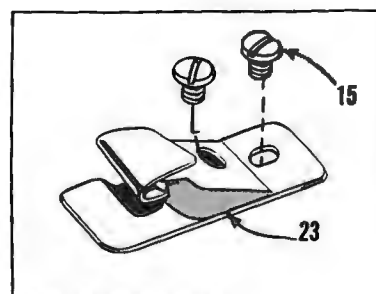
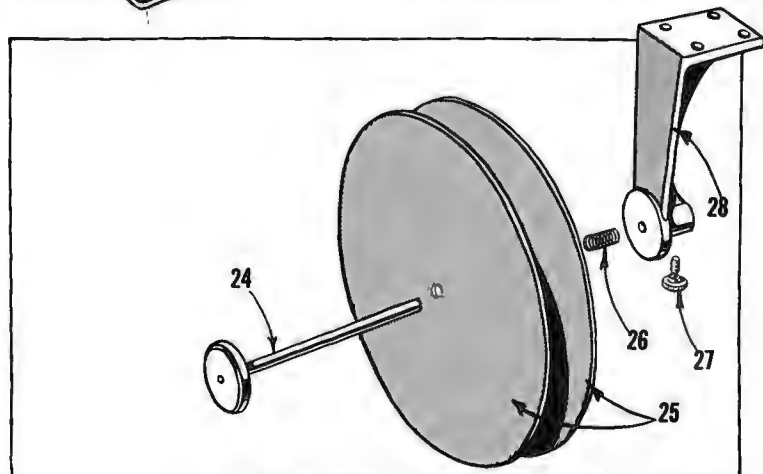
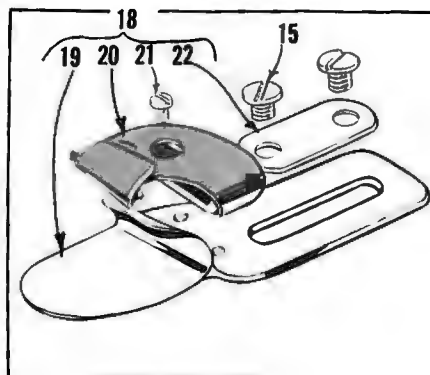
FEED DOGS, THROAT PLATES, PRESSER FEET

Ref. No.	Part No.	Description	Amt. Req.
1	51405 A-8	Feed Dog, 16 teeth per inch, for Nos. 6 and 8 gauges, Style 56400 P-----	1
	51405 A-10	Feed Dog, 16 teeth per inch, for Nos. 10 and 12 gauges, Style 56400 P-----	1
2	51424 A-6	Throat Plate, for No. 6 gauge, Style 56400 P-----	1
	51424 A-8	Throat Plate, for No. 8 gauge, Style 56400 P-----	1
	51424 A-10	Throat Plate, for No. 10 gauge, Style 56400 P-----	1
	51424 A-12	Throat Plate, for No. 12 gauge, Style 56400 P-----	1
3	51420-6	Presser Foot, for No. 6 gauge, Style 56400 P-----	1
	51420-8	Presser Foot, for No. 8 gauge, Style 56400 P-----	1
	51420-10	Presser Foot, for No. 10 gauge, Style 56400 P-----	1
	51420-12	Presser Foot, for No. 12 gauge, Style 56400 P-----	1
4	51430 D	Presser Foot Shank-----	1
5	91	Screw-----	1
6	22799 B	Hinge Screw-----	1
7	51430 A-6	Presser Foot Bottom, for No. 51420-6 presser foot-----	1
	51430 A-8	Presser Foot Bottom, for No. 51420-8 presser foot-----	1
	51430 A-10	Presser Foot Bottom, for No. 51420-10 presser foot-----	1
	51430 A-12	Presser Foot Bottom, for No. 51420-12 presser foot-----	1
8	22840 A	Adjusting Screw-----	1
9	51430 F	Adjusting Nut-----	1
10	51405-16	Feed Dog, 16 teeth per inch, for Nos. 16 and 18 gauges, Style 56400 P-----	1
11	51424-16	Throat Plate, for No. 16 gauge, Style 56400 P-----	1
	51424-18	Throat Plate, for No. 18 gauge, Style 56400 P-----	1
12	51420-16	Presser Foot, for No. 16 gauge, Style 56400 P-----	1
	51420-18	Presser Foot, for No. 18 gauge, Style 56400 P-----	1
13	51430 D	Presser Foot Shank-----	1
14	91	Screw-----	1
15	22799 B	Hinge Screw-----	1
16	51430 A-16	Presser Foot Bottom, for No. 51420-16 presser foot-----	1
	51430 A-18	Presser Foot Bottom, for No. 51420-18 presser foot-----	1
17	22840 A	Adjusting Screw-----	1
18	51430 F	Adjusting Nut-----	1
19	51505-18	Feed Dog, 12 teeth per inch, for Nos. 16 and 18 gauges, Style 56500 J-----	1
20	51524-16	Throat Plate, for No. 16 gauge, Style 56500 J-----	1
	51524-18	Throat Plate, for No. 18 gauge, Style 56500 J-----	1
21	51520-16	Presser Foot, for No. 16 gauge, Style 56500 J-----	1
	51520-18	Presser Foot, for No. 18 gauge, Style 56500 J-----	1
22	35830	Presser Foot Shank-----	1
23	91	Screw-----	1
24	51930	Spring-----	1
25	22799 C	Hinge Pin-----	1
26	51530-16	Presser Foot Bottom, for No. 51520-16 presser foot-----	1
	51530-18	Presser Foot Bottom, for No. 51520-18 presser foot-----	1
27	56505	Feed Dog, 10 teeth per inch, for 7 and 10 S.P.I., Style 56500 N-----	1
28	56505 B	Feed Dog, 10 teeth per inch, for 5 S.P.I., Style 56500 N-----	1
29	56524 A-1	Throat Plate, for 5 S.P.I., Style 56500 N-----	1
	56524 B-1	Throat Plate, for 7 S.P.I., Style 56500 N-----	1
	56524 C-1	Throat Plate, for 10 S.P.I., Style 56500 N-----	1
29A	56528	Insert-----	1
30	56520	Presser Foot, all stitches per inch, Style 56500 N-----	1
31	51530 D	Presser Foot Shank-----	1
32	91	Screw-----	1
33	22799 B	Hinge Screw-----	1
34	51530 G	Spring-----	1
35	51530 F	Plunger-----	1
36	56530 A	Yielding Section-----	1
37	91 A	Screw-----	1
38	52930 AC	Chain Cutting Knife-----	1
39	56530	Presser Foot Bottom-----	1
40	1740	Pin-----	1



FEED DOGS, THROAT PLATES, PRESSER FEET

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	51705-64	Feed Dog, 16 teeth per inch, for No. 64 gauge, Style 56700 J -----	1
2	51724-64	Throat Plate, for No. 64 gauge, Style 56700 J-----	1
3	51720-64	Presser Foot, for No. 64 gauge, Style 56700 J-----	1
4	51430	Presser Foot Shank-----	1
5	91	Screw-----	1
6	77	Clamp Screw Lower-----	1
7	22752 B	Adjusting Screw-----	1
8	22799 D	Hinge Screw-----	1
9	51730 A-64	Flexible Toe-----	1
10	91 A	Screw-----	2
11	51730-64	Presser Foot Bottom-----	1
12	51905 C-9	Feed Dog, 10 teeth per inch, for No. 9 gauge, Style 56900 J -----	1
13	51924 C-9	Throat Plate, for No. 9 gauge, Style 56900 J-----	1
14	35820 R-9	Presser Foot, for No. 9 gauge, Style 56900 J-----	1
15	35830 B	Presser Foot Shank-----	1
16	91 D	Screw-----	1
17	35830 H	Spring-----	1
18	73 A	Screw-----	1
19	35830 D	Spring-----	1
20	22561	Screw-----	1
21	35830 F	Adjusting Nut-----	1
22	22799 L	Hinge Screw-----	1
23	35830 G	Presser Foot Bottom, rear section, marked "G"--	1
24	35830 E	Yielding Section-----	1
25	22845 A	Screw-----	6
26	35830 R-9	Presser Foot Bottom, front section-----	1
27	35830 C	Yoke-----	1
28	35830 K	Spring-----	1
29	22599	Screw-----	1



ATTACHMENTS, TAPE REEL AND MISCELLANEOUS ACCESSORIES

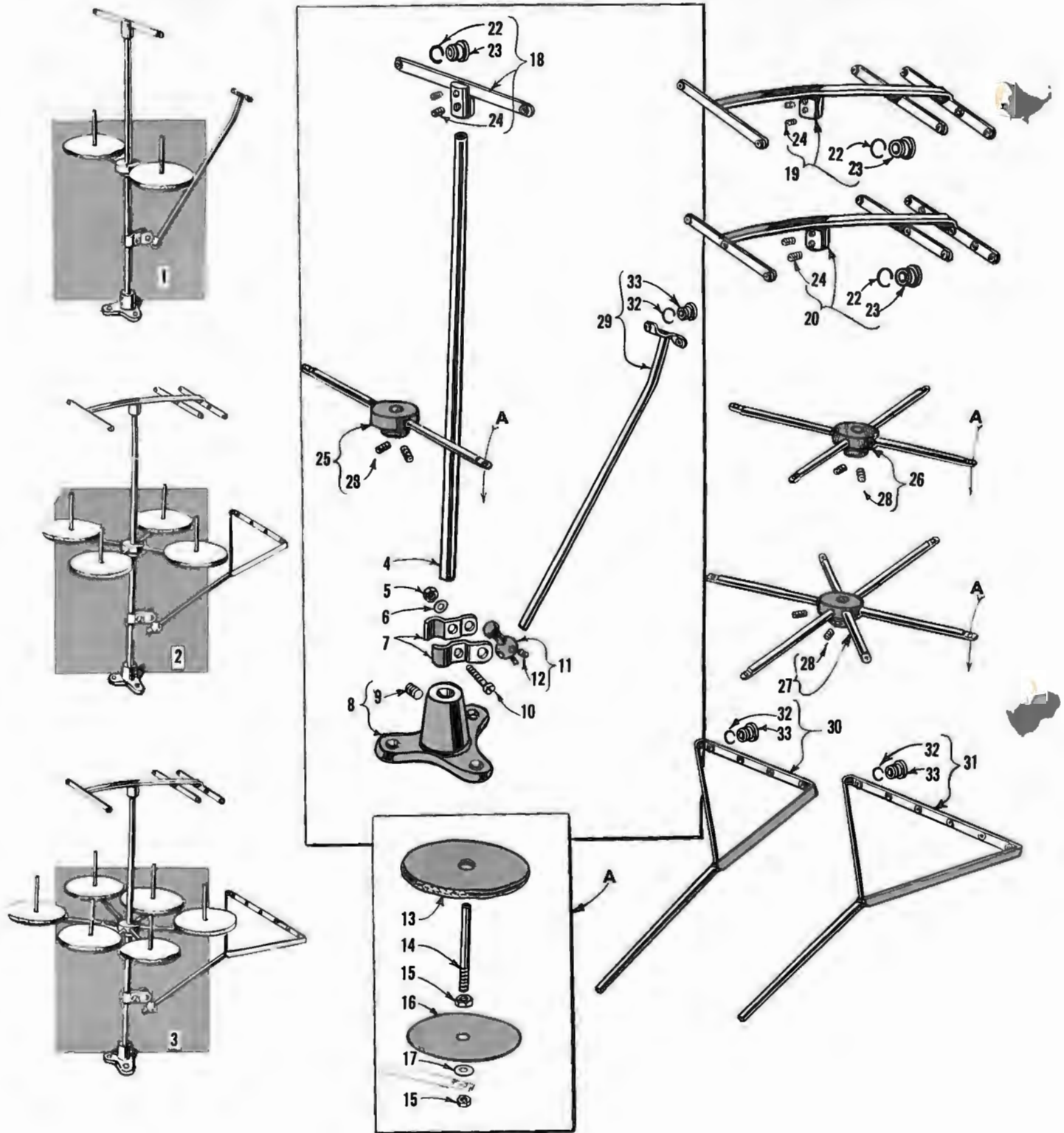
Ref. No.	Part No.	Description	Amt. Req.
1	23401 K-64	Center Plait Folder, 1/32 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches; interlining strip cut 1 15/32 inches wide, for No. 64 gauge, for Style 56700 J-----	1
† -	K58337	Center Plait Folder, 1/16 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches; interlining strip cut 1 7/16 inches wide, for No. 64 gauge-----	1
* 2	22528	Screw-----	2
* 3	23229 P	Folder Bracket, for Style 56700 J-----	1
* 4	23229 N	Folder Swinging Arm, for Style 56700 J-----	1
5	22541	Screw-----	2
* 6	22773	Screw-----	1
* 7	23229 W	Folder Swinging Arm Support, for Style 56700 J-----	1
* 8	25 T	Screw-----	1
* 9	23229 Q	Folder Clamp, for Style 56700 J-----	1
*10	22863 A	Adjusting Screw-----	1
*11	25 CC	Screw-----	2
*12	25 S	Screw-----	1
13	25 B	Screw-----	2
14	23403-64	Angular Interlining Guide, reversible, for Style 56700 J-----	1
15	25 C	Screw-----	2
16	23405 L	Body Folder, for turning body of garment upwardly, 1/32 inch capacity, 5/16 inch fold, for Style 56700 J-----	1
17	23425 V	Washer Plate-----	1
18		Double Lap Seam Feller Assembly (See Chart Below)-----	1
19		Lower Scroll and Base (See Chart Below)-----	1
20		Upper Scroll (See Chart Below)-----	1
21	28	Screw-----	1
22	23425 V	Washer Plate-----	1
23	23151 A	Plate Folder and Guide, for heavy materials, 1/4 inch capacity for bothplies, top ply folded, lower ply flat, 1/2 inch overlap, for Style 56900 J-----	1
24	21385 B	Tape Reel Axle, for Style 56700 J-----	1
25	21178	Tape Reel Disc, for Style 56700 J-----	2
26	110-3	Tape Reel Spring, for Style 56700 J-----	1
27	201 C	Tape Reel Axle Screw, for Style 56700 J-----	1
28	201 A	Tape Reel Frame, for Style 56700 J-----	1
29	21201	Screwdriver, 9/64 inch round blade, length overall 7 5/8 inches, for Styles 56400, 56500, 56700, 56900-----	1
30	660-240	Thread Tweezers, for all Styles-----	1
31	116	Wrench, 9/32 inch open end, for Style 56300-----	1
32	21388	Wrench, 3/8 inch open end, for all Styles-----	1
33	660-264	"S" Hook, for all Styles-----	2
34	421 D-34	Treadle Chain, 34 inches long, for all Styles-----	1
35	51295 A	Isolator-----	1
36	51295 B	Isolator-----	3

DOUBLE LAP SEAM FELLER

Assembly No. Ref. No. 18	Lower Scroll Ref. No. 19	Upper Scroll Ref. No. 20	Gauge	Capacity	For Machine Style
23420 U-6-1/32	23422 U-1/32	23421 U-6-1/32	6	1/32"	56400 P-6
23420 U-8-1/32	23422 U-1/32	23421 U-8-1/32	8	1/32"	56400 P-8
23420 U-10-1/32	23422 U-1/32	23421 U-10-1/32	10	1/32"	56400 P-10
23420 U-12-1/16	23422 U-1/16	23421 U-12-1/16	12	1/16"	56400 P-12
23420 U-16-1/16	23422 U-1/16	23421 U-16-1/16	16	1/16"	56400 P-16
23420 U-16-3/32	23422 U-3/32	23421 U-16-3/32	16	3/32"	56500 J-16
23420 U-18-1/16	23422 U-1/16	23421 U-18-1/16	18	1/16"	56400 P-18
23420 U-18-3/32	23422 U-3/32	23421 U-18-3/32	18	3/32"	56500 J-18

† Available as an extra send and charge item or on special machines.

* Available complete as part No. 29481 D (Suspended Folder Arm Assembly).



THREAD STAND PARTS

Ref. No.	Part No.	Description	Amount Required		
			One Needle	Two Needle	Three Needle
1	21101 H-2	Thread Stand, complete, for Styles 56300 G, R, U, X -----	1		
2	21101 H-4	Thread Stand, complete, for Styles 56400 P; 56500 J, N; 56700 J -----		1	
3	21101 H-6	Thread Stand, complete, for Style 56900 J-----			1
4	21104 B-24	Thread Stand Rod-----	1	1	1
5	21104 H	Nut -----	1	1	1
6	652-16	Washer-----	1	1	1
7	21114 U	Lead Eyelet Ball Split Socket ----	2	2	2
8	21114 A	Thread Stand Base-----	1	1	1
9	22651 CD-3	Screw -----	1	1	1
10	22810	Screw -----	1	1	1
11	21114 T	Lead Eyelet Socket Ball-----	1	1	1
12	22651 CD-4	Screw -----	2	2	2
13	21104 V	Pad, for thread cone-----	2	4	6
14	21114 W.	Spool Pin-----	2	4	6
15	258 A	Nut -----	4	8	12
16	21114	Spool Seat Disc-----	2	4	6
17	652-16	Washer-----	2	4	6
18	21114 H-2	Eyelet Support -----	1		
19	21114 H-4	Eyelet Support -----		1	
20	21114 H-6	Eyelet Support -----			1
22	21114 M	Eyelet Locking Ring -----	2	8	12
23	21114 L	Eyelet-----	2	8	12
24	22651 CD-4	Screw -----	2	2	2
25	21114 D-2	Spool Seat Support -----	1		
26	21114 D-4	Spool Seat Support -----		1	
27	21114 D-6	Spool Seat Support -----			1
28	22651 CD-5	Screw -----	2	2	2
29	21114 S-2	Lead Eyelet-----	1		
30	21114 S-4	Lead Eyelet-----		1	
31	21114 S-6	Lead Eyelet-----			1
32	21114 M	Eyelet Locking Ring -----	2	4	6
33	21114 L	Eyelet-----	2	4	6

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