

FINEST QUALITY

Union Special®

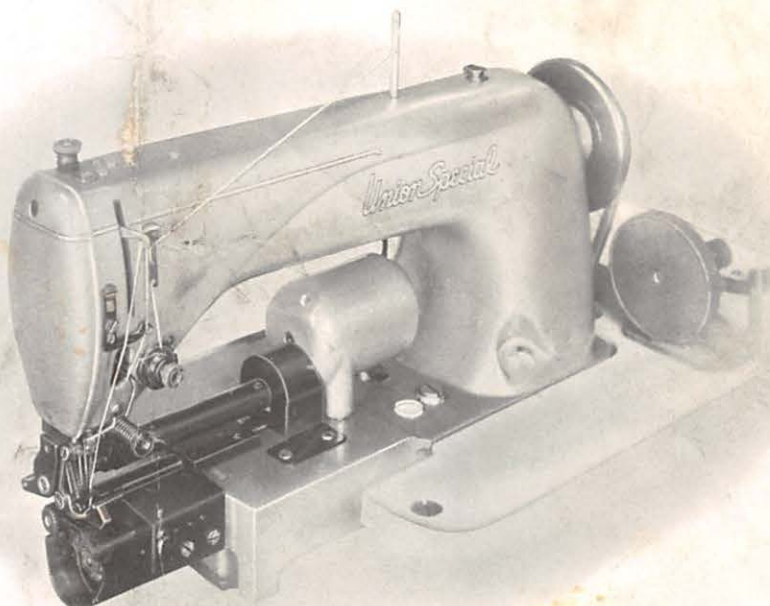
LEWIS • COLUMBIA

INDUSTRIAL
SEWING
MACHINES



STYLES

61400 M
61400 T
61400 W



Style 61400 T

LIST OF PARTS
FOR

61400 M 61400 T
61400 W

CATALOG
NO.

T83 T

Third Edition

Union Special CORPORATION

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. T83 T

LIST OF PARTS

Styles

61400 M 61400 T
 61400 W

Top and Bottom Roller Feed Machines

Third Edition

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Union Special
CORPORATION
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U.S.A.

April, 1974

IDENTIFICATION OF MACHINES

Each Union Special machine is identified by a Style number which is stamped into the name plate on the front of the machine. Style numbers are classified as standard and special. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 61400 M". 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 61400 MZ".

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: "61400".

APPLICATION OF CATALOG

This catalog applies specifically to the Standard Styles of machines as listed herein. It can also be applied with discretion to some Special Styles of machines in Class 61400. Catalog No. 83 R may prove helpful for illustrations not shown in this catalog. Reference to direction, such as right, left, front, back, etc., are given from the operator's position while seated at the machine. Operating direction of the handwheel is toward the operator.

STYLES OF MACHINES

61400 M Streamlined, modified lockstitch machine, for circular work, automatically synchronized power driven, top and bottom roller feed, 1 13/64 inch needle bar travel, automatic lubrication for lower mechanism, visible oil supply, equipped with hemmer for making 3/8 to 1/2 inch turned down hem on overalls, dungarees and similar garments. Seam specification 301-EFb-1, inverted. Type 180 GYS needle.

61400 T Streamlined, modified lockstitch machine, for circular work, automatically synchronized power driven top and bottom roller feed, 1 13/64 inch needle bar travel, automatic lubrication for lower mechanism, visible oil supply, for making a hand turned hem from 1/2 to 2 1/2 inches wide on children's wear, men's dress pants, semi-work pants and work pants. Seam specification 301-EFb-1 or EFa-1. Type 180 GXS needle.

61400 W Streamlined, modified lockstitch machine, automatically synchronized power driven top and bottom roller feed, 1 13/64 inch needle bar travel, automatic lubrication for lower mechanism, visible oil supply, for topstitching waistbands on twill and woolen pants. Seam specification 301-SSa-1. Type 180 GYS needle.

NEEDLES

Each Union Special needle has both a type number and a size number. The type number denotes the kind of shank, point, length, groove, finish, and other details. The size number, stamped on the needle shank, denotes the largest diameter of the blade, measured in thousandths of an inch, across the eye. Collectively, type and size number represents the complete symbol.

NEEDLES (Continued)

The type numbers of the needles recommended for each style of machine covered by this catalog are given in the machine style description. Other needles are available, but the ones indicated are those recommended to produce the most satisfactory results. The type numbers of the recommended needles together with their descriptions, and the sizes available are listed below:

<u>Type No.</u>	<u>Description and Sizes</u>
180 GXS	Round shank, round point, lockstitch, short length, ball eye, single groove, wide angle groove, struck groove, deep spot, ball point, chromium plated - sizes 028, 032, 036, 040, 044, 048, 054, 060
180 GYS	Round shank, round point, lockstitch, short length, ball eye, single groove, wide angle groove, struck groove, deep spot, chromium plated - sizes 028, 032, 036, 040, 044, 048, 054, 060

To have orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. Use description on label. A complete order would read: "1000 Needles, Type 180 GXS, Size 054".

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

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

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

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

USE GENUINE NEEDLES AND REPAIR PARTS

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

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

TERMS

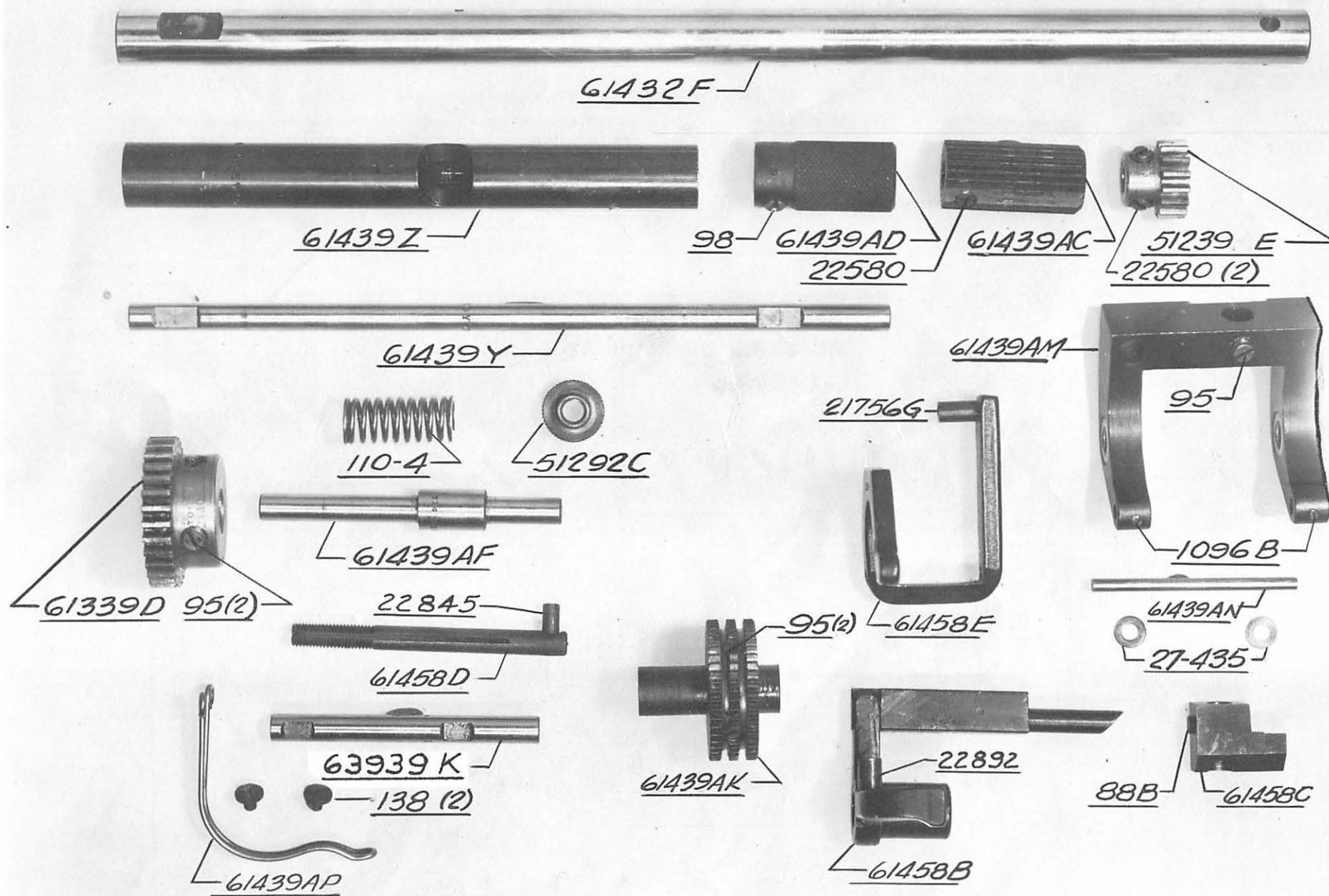
Prices are net cash and subject to change without notice. All shipments are forward f. o. b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

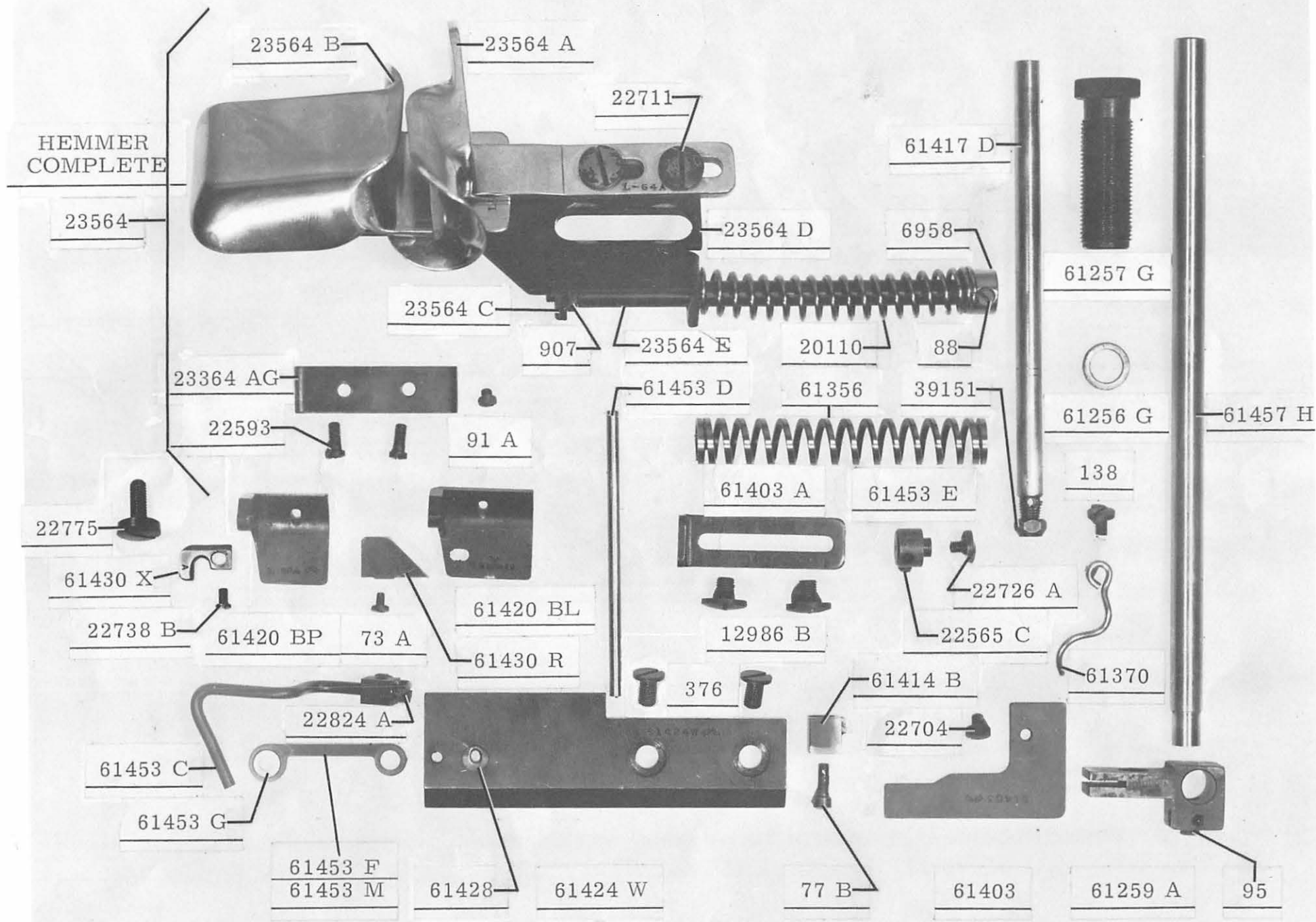
The following is a numerical list of the parts used in this machine. Quantities, part numbers, and descriptions are given. Following the parts list are photographs of some of the major parts.

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	18	Nut for 22832 G	2	22565 C	Screw for 51239 T	1	29126 CV	Top Roller Feed Drive Eccentric Assembly (22832 G)
4	27-435	Blk. Washer for 61439 AN	2	22565 C	Screw for 61453 E			
3	28-95	Blk. Spring Stop on 61339 R	2	22569 B	Screw for head cover	1	29474 G	Rotating Hook Assembly
1	28 C	Needle Clamp Screw for 61417 C	3	22569 C	Screw for 61494 A	1	29475 AA	Tension Assembly (22597 E, 22863 B)
1	50-223	Blk. Rivet for 61351 L	6	22569 H	Hook Set Screw	1	39151	Needle Clamp Nut for 61417 D
1	50-567	Blk. Oil Sight Gauge on 61494	4	22570 A	Screw for 61271	6	41258	Feed Clutch Roller
1	50-568	Blk. Oil Gauge	4	22570 A	Screw for 61382 L	1	41358 M	Clutch Barrel (22597 B)
4	HA61 D	Screw for 61264, 61264 A	4	22570 A	Screw for 61382 M	1	41358 N	Clutch Block, right (22747)
1	73 A	Screw for 61430 R	1	22570 A	Screw for 61439 AB	1	41358 P	Clutch Block, left (22747)
1	77 B	Screw for 61414 B	1	22570 B	Screw for 61482 B	6	41358 Q	Feed Clutch Roller Spring
1	88	Screw for 6958	2	22574	Screw for 61391 D	6	41358 S	Clutch Spring Support Pin
2	88	Screw for 61242	1	22580	Screw for 61251 D	6	41358 T	Support Pin Washer
1	88 B	Screw for 61458 C	1	22580	Screw for 62262	1	41390 E	Bushing for 61439 G
2	89	Screw for 61244	3	22597 B	Screw for 41358 M	1	51239 B	Feed Clutch Check Plate Pin (22729)
1	89	Screw for 61449 AA	1	22597 E	Set Screw for tension assembly	1	51239 E	15 tooth Gear (22580)
1	89	Screw for 61492	1	22704	Screw for 61403	2	51239 G	Universal Joint (22894 T)
1	91 A	Screw for 23564 D	2	22711	Screw for 23564 A	1	51239 S	Roller Feed Clutch Shaft
2	93	Screw for 23564 G	2	22711	Screw for 61210 B	1	51239 T	Roller Feed Clutch Brake (22565 C)
2	93	Screw for 61482	1	22712 F	Screw for 61414 C	1	51239 U	Roller Feed Clutch Brake Washer
2	93	Screw for 61482 L	4	22716 A	Screw for 61411 A	1	51292 C	Presser Foot Tension Regulating Nut
1	95	Screw for 61259 A	1	22716 B	Screw for 61437 A	1	61149 G	Stitch Eccen., .078 inch throw, for 29126 CV
4	95	Screw for 61339 D	3	22716 H	Screw for 61255	1	61149 H	Friction Disc for 61149 G
2	95	Screw for 61439 AK	2	22560 A	Screw for 61437 C	1	61208 B	Rotating Hook for 29474 G
2	95	Screw for 61439 AM	1	22562 B	Screw for 61453 F, M	1	61210 B	Hook Thread Guard for 29474 G (22716 A)
1	96	Screw for 61454 D	3	22564 B	Screw for 51239 B	1	61212	Bobbin for 29474 G
1	96 A	Screw for 61341 C	1	22726 A	Screw for 61482 B	1	61216	Hinge Pin for 61415
2	98	Screw for 2339 F	1	22729	Screw for 61430 X	1	61216 N	Bobbin Case Spring
1	98	Screw for 61439 AD	1	22730	Screw for 61430 BX	1	61236	Bushing for 61261 A
2	109	Tension Disc for 29475 AA	1	22738 B	Screw for 61267	1	61242	Hook Shaft Collar (88)
1	110-4	Presser Foot Tension Regulating Spring	2	22738 F	Screw for 61466 A	1	61244	Hook Shaft Pinion Gear (89)
1	138	Screw for 61370	6	22747	Screw for 61439 G	1	61251 D	Take-up Lever Pin (660-205, 22597 A)
2	138	Screw for 61439 AP	1	22757 C	foot on 61400 M, T	1	61252	Take-up Lever Link
2	376	Screw for 61424 W	1	22758 B	Screw for 61430 U	1	61252 J	Take-up Lever Crank Pin
2	454 A	Washer for 22891	1	22775	Screw for 61430 V	1	61255	Needle Bar Connecting Stud (22562 B)
1	652 B-20	Lock Washer for lifter lever stud	1	22775	Stud for 61468	1	61255 H	Needle Bar Link (22757 C)
1	660-142	Spring Cotter Pin for 61368 A	1	22798 A	Screw for 61453 C	1	61256 G	Presser Spring Washer
1	660-205	Retaining Ring for 61251 D	1	22817 A	Screw for 61482 A	1	61257 G	Presser Bar Bushing, upper
1	660-226	Needle Bearing for 61439 AJ	2	22824 A	Screw for 29126 CV (18, 61434 G)	1	61259 A	Presser Bar Guide (95)
2	660-249	Needle Bearing for 61439 AM	1	22829	Screw for 61458 B	1	61260 A	Feed Driving Shaft Gear (22884)
1	660-257	Washer for 22730	1	22832 G	Screw for 61443	1	61261 A	Feed Driving Shaft Intermediate Gear
2	666-20	Oil Wick	1	22845	Screw for 51239 G	1	61264	Intermediate Gear Shaft Collar, right (HA61 D)
1	666-104	Oil Wick for main shaft housing	1	22863 B	Screw for 61391 D	1	61264 A	Intermediate Gear Shaft Collar, left (HA61 D)
2	666-126	Oil Wick for 61293	1	22874	Hemmer Scroll Slide Spring	1	61267	Lifter Lever Link (22758 B)
1	666-127	Felt Oil Wick for 61393 C	1	22874 F	Hemmer, comp., for 61400 M (907, 22711)	1	61267 G	Spring Pin for release lever
1	907	Adjusting Screw Nut for 23564	2	22880	Hemmer Scroll, right (22711)	1	61271	Frame Needle Thread Eyelet (22570 A)
2	1096 B	Screw for 61439 AN	1	22882	Hemmer Scroll, left (22593)	1	61282 D	Gasket for 61382 L
1	2339 F	Thrust Collar for lower main shaft	2	22884	Hemmer Scroll Slide Hemmer Base (91 A)	2	61282 E	Gasket for 61382 M
1	6958	Collar for 23564 E (88)	2	22884	Operating Rod (20110)	1	61292 C	Nut for 61492
2	8372 A	Washer for 61391 D	1	22884	Hemmer Mounting Bracket for 61400 M (93)	1	61292 G	Tension Release Pin
2	9937	Nut for 22874	1	22890				
1	9937	Nut for 22874 F	1	22891				
2	12986 B	Screw for 61403 A	1	22892				
1	15872 F	Spring for release lever	1	22894 J				
1	20110	Spring for 23564 E	1	22894 T				
1	21629	Stud for 61430 BW	2	22894 V				
1	21756 G	Stud for 61458 E	1	23364 AG				
1	21756 G	Stud for 61458 H	1	23564				
2	22539 D	Plug Screw for base	1	23564 A				
2	22564 E	Screw for 61414 C, 61415 A	1	23564 B				
1	22564 F	Screw for 61413 G	1	23564 C				

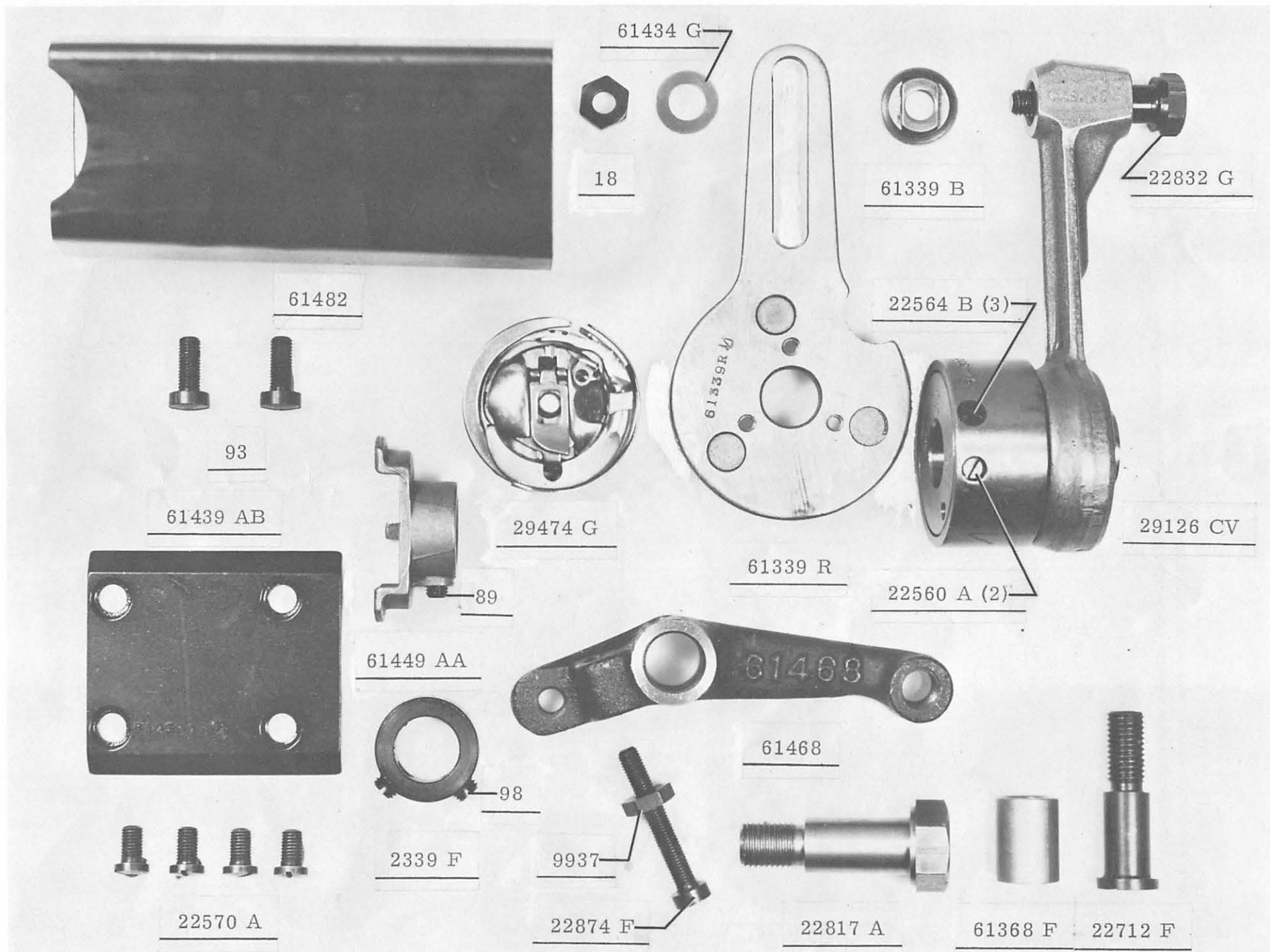
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	61292 H	Release Washer for 29475 AA	1	61403 A	Edge Guide Mounting Bracket for 61400 T (12986 B)	1	61439 AJ	Connecting Rod for 29126 CV (660-226)
2	61293	Oil Tube (666-126)				1	61439 AK	Top Feed Roller (95)
2	61293 N	Plug for inside of arm	1	61411 A	Thread Retainer for 29474 G (22716 H)	1	61439 AM	Presser Bar Roller Bracket (95, 660-249)
1	61321 J	Handwheel for 61421 (22574)	1	61413 E	Bobbin Case Assembly for 29474 G	1	61439 AN	Presser Foot Shank Pin (1096 B)
1	61321 L	Washer for 61421	1	61413 F	Bobbin Case	1	61439 AP	Upper Roller Cloth Stripper (138)
1	61322 B	Main Shaft	1	61413 G	Bobbin Case Eyelet	1	61439 AT	Bushing for 61439 Z
1	61339 B	Ball Washer for 29126 CV	1	61414	Bobbin Case Holder for 29474 G	1	61443	Hook Shaft Driving Gear (22894 J)
2	61339 D	Top and Bottom Roller Feed Driving Gear (95)	1	61414 B	Bobbin Case Holder Position Finger (77 B)	1	61449 B	Spring for 29126 CV
1	61339 E	Feed Driving Shaft, right	1	61414 C	Bobbin Case Tension Spring (22564 E, 22716 B)	1	61449 AA	Stitch Regulating Collar (98)
1	61339 R	Feed Driving Clutch Lever	1	61415	Bobbin Case Latch (61216)	1	61451 C	Thrust Washer for 61351 L
1	61339 S	Feed Clutch Check Plate	1	61415 A	Bobbin Case Latch Lever (22564 E)	1	61453	Spring for 29475 AA
1	61340 C	Hook Shaft	1	61417 C	Needle Bar for 61400 W (28 C)	1	61453 C	Take-up Spring Thread Wire (22824 A)
1	61341 C	Hook Shaft Bushing, left (96 A)	1	61417 D	Needle Bar for 61400 M, T (39151)	1	61453 D	Thread Control Shaft
1	61341 D	Hook Shaft Bushing, right	1	61420 BL	Presser Foot for 61400 T (22775)	1	61453 E	Thread Control Shaft Block (22565 C)
1	61341 G	Oil Seal Washer	1	61420 BP	Presser Foot for 61400 M (22775)	1	61453 F	Thread Control Link, for 61400 M, T (22726 A)
2	61341 J	Thrust Washer for hook shaft	1	61420 CF	Presser Foot for 61400 W	1	61453 G	Thread Control Link Spacer
1	61351 C	Thrust Washer	1	61421	"V" Belt Pulley Assembly	1	61453 L	Thread Controller Shaft Bushing
1	61351 J	Frame Take-up Thread Eyelet (22585 A)	1	61421 A	Pulley Hub for 61421	1	61453 M	Thread Controller Link for 61400 W (22726 A)
38	61351 K	Needle Bearing Roller	1	61424 W	Throat Plate (376)	1	61454	Needle Bar Bushing, lower
1	61351 L	Take-up Lever (61451 C)	1	61428	Needle Hole Insert for 61424 W	1	61454 D	Needle Bar Bushing, upper
1	61351 M	Eyelet for 61351 L	1	61430 R	Guide for 61420 BL (73 A)	1	61457 D	Presser Bar Bushing, lower
1	61351 Q	Take-up Lever Assembly	1	61430 U	Presser Foot Bottom for 61420 CF (22775)	1	61457 H	Presser Bar
1	61356	Presser Spring	1	61430 V	Yielding Spring for 61420 CF (22798 A)	1	61458 B	Presser Bar Connection (22892)
1	61360	Main Shaft Driving Gear (22884)	1	61430 X	Needle Guard for 61420 BP (22738 B)	1	61458 C	Presser Foot Lifter Block (88 B)
1	61360 G	Feed Driving Shaft Collar (22884)	1	61430 BW	Edge Guide for 61420 CF (21629)	1	61458 D	Presser Foot Tension Bar (22845)
1	61366 C	Lifter Lever Extension Stud for 61368 A	1	61430 BX	Edge Guide Block for 61420 CF (22738 F)	1	61458 E	Presser Foot Shank for 61400 M, T (21756 G)
1	61368	Lifter Lever Connecting Rod for 61368 A	1	61432 B	Feed Driving Shaft Bushing, right	1	61458 H	Presser Foot Shank for 61420 CF (21756 G)
1	61368 A	Lifter Lever Extension Stud and Lifter Lever Connecting Rod, complete (660-142)	1	61432 C	Feed Driving Shaft Bushing, left	1	61466 A	Lifter Lever (22890)
1	61368 F	Bell Crank Roller (22712 F)	1	61432 F	Lower Main Shaft Washer for 29126 CV	1	61468	Lifter Lever Bell Crank (22817 A, 22874 F)
1	61370	Needle Thread Guide (138)	1	61434 G	Eccentric Timing Collar for 29126 CV (22560 A)	1	61482	Hook Guard for 61400 M, T (93)
1	B61382 H	Head Cover for 61400 M, T (22569 B)	1	61437 A	Pivot Pin for 29126 CV	1	61482 A	Cloth Guard (22829)
1	61382 L	Housing Cover, right (22570 A)	1	61437 B	Eccentric Housing for 29126 CV (22564 B)	1	61482 B	Hook Shaft Gear Case Cover (660-257, 22570 A, 22730)
1	61382 M	Housing Cover, left (22570 A)	1	61437 C	Top Roller Feed Clutch Housing Support Bracket (22882)	1	61482 L	Cloth Plate Extension for 61400 W (93)
1	61391 D	Main Shaft Counterweight (22570 B, 22596 D, 22880, 22894 V)	1	61439 F	Feed Clutch Housing (22874, 22891)	1	61482 N	Head Cover for 61400 W
1	61392 F-14	Tension Spring for 29475 AA	1	61439 G	Lower Feed Drive Shaft	1	61490	Main Shaft Bearing Housing and Bushing, right
1	61393 B	Oil Tube for upper main shaft (666-20)	1	61439 Y	Lower Feed Driving Shaft Housing	1	61490 A	Main Shaft Bushing, left
1	61393 C	Oil Tube (666-127)	1	61439 Z	Bushing for 61439 Z	1	61492	Tension Post for 29475 AA (89, 61292 C)
1	61394 L	Oil Reservoir Securing Screw (61494 U)	1	61439 AA	Shaft Housing Clamp Plate (22570 A)	1	61492 A	Tension Post Socket for 29475 AA
1	61394 M	Gasket for 61394 AC	1	61439 AB	Feed Roller, lower, for 61400 M (22580)	1	61494	Hook Oil Reservoir
1	61394 AC	Filler Hole Plug Screw	1	61439 AC	Feed Roller, lower, for 61400 T, W (98)	1	61494 A	Reservoir End Cover (22569 C)
1	61394 AE	Oil Cup	1	61439 AD	Top Roller Feed Shaft Guard	1	61494 B	End Cover Gasket
2	61394 AF	Reservoir Gasket, left	1	61439 AE	Top Roller Feed Drive Shaft, right	1	61494 U	Washer for 61394 L
1	61396 F	Hook Shaft Oil Metering Insert	1	61439 AF		1	62262	Intermediate Gear Shaft (22597 A)
1	61403	Edge Guide for 61400 T (22704)	1			1	63939 K	Top Feed Roller Shaft
						1	80557	Washer for 22874

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

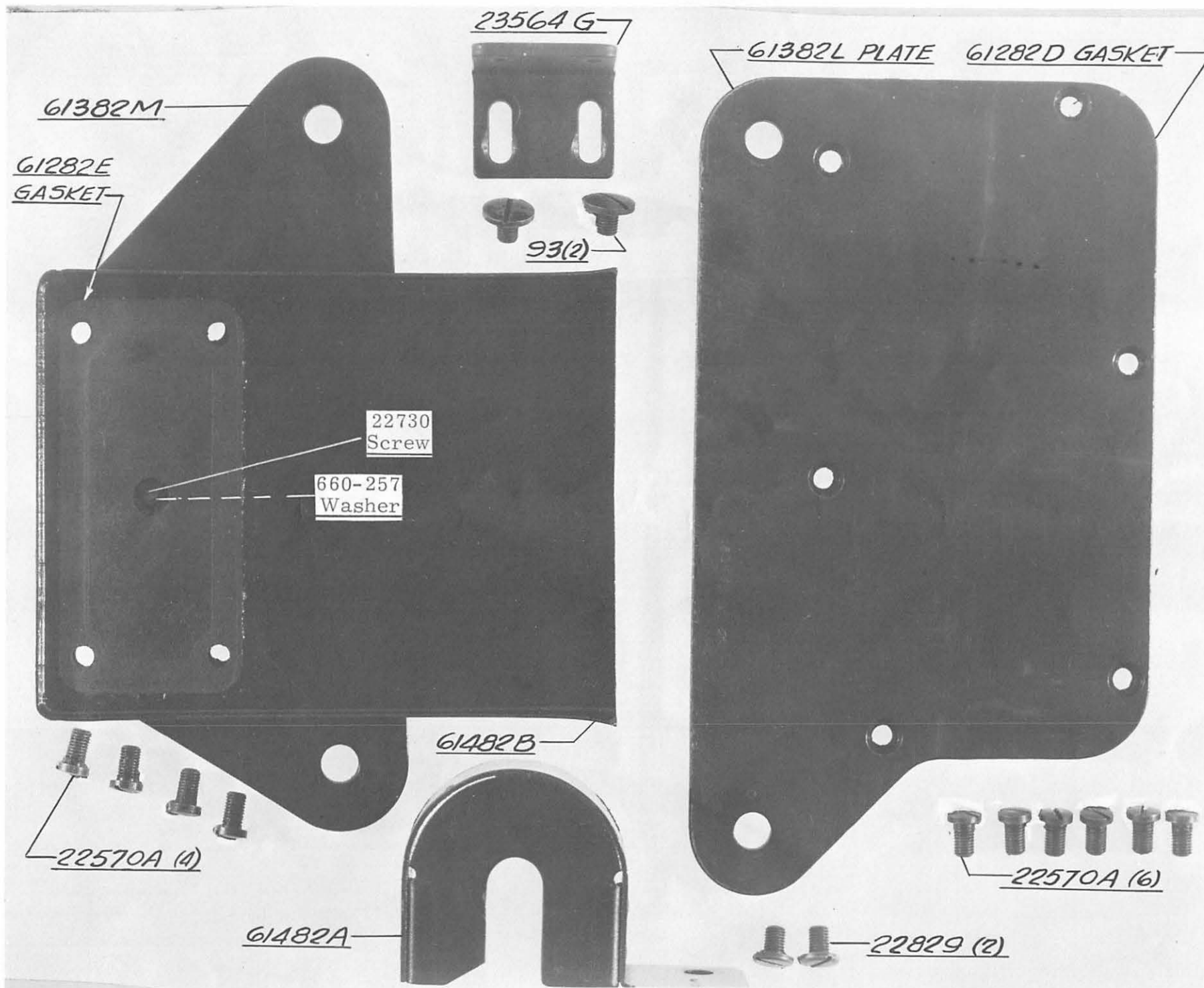




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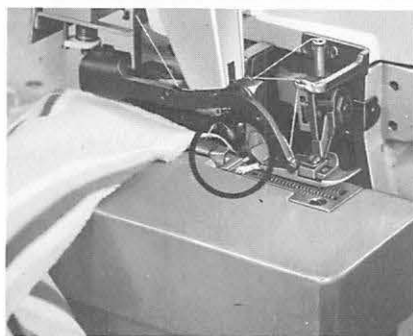


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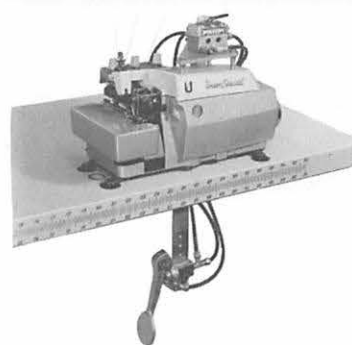


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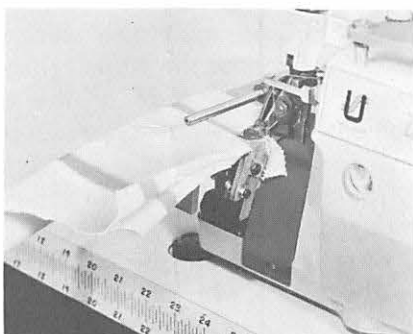
BOOST PRODUCTION WITH THESE WORK AIDS FROM UNION SPECIAL



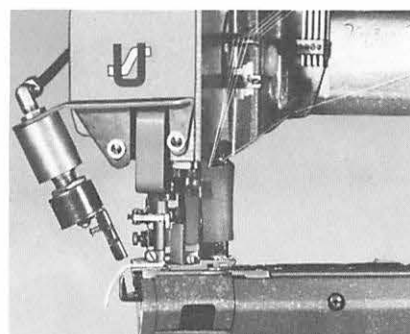
PNEUMATIC CHAIN-CUTTER—for use on conventional Class 39500 and 39600 is a durable scissor-action mechanism that makes a clean positive cut. Style 2899 A-1



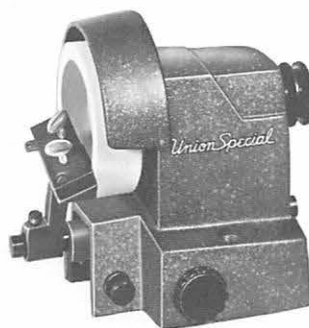
PNEUMATIC FOOT LIFTER—The air-operated foot lifter for use on Class 39500 machines allows the operator to raise the foot simply by knee-touching an actuating switch.



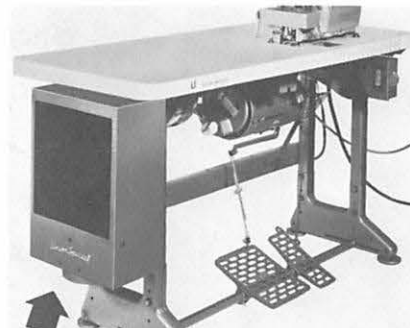
AIR FABRIC UNCURLER—This unit, designed for Class 39500 machines, uses air jets to remove curls from top and bottom plies of flat knit materials as fabric passes through sewing area. Style 2899 B-1



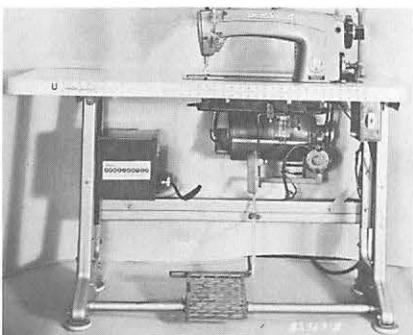
CHAIN CUTTER—The above photo shows the small pneumatic chain cutter that is available for installation as an accessory unit on Class 36200 Flatseamers. Style 2899A-6



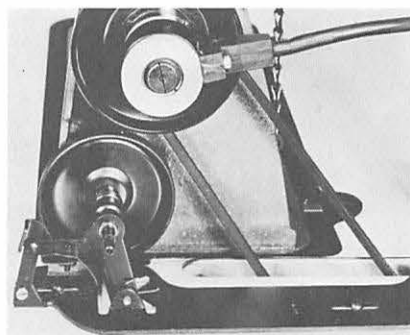
KNIFE GRINDER sharpens straight or angle type knives, is simple and easy to operate, eliminates defective garments caused by dull knives.



HEAT DISPELLER—Union Special's auxiliary unit (arrow) is an effective means for reducing oil temperature where heavy duty service requires it. Style 2899 E-1



AMCO ELECTRONIC NEEDLE POSITIONERS eliminate the necessity of reaching for the hand-wheel to move the needle up or down . . . this allows the operator to keep both hands on the work, insuring better control, uniform quality and increased production.



Union Special[®]
FINEST QUALITY CORPORATION



Union Special[®]
INDUSTRIAL SEWING MACHINES

UNION SPECIAL maintains sales and service facilities throughout the world. These offices will aid you in the selection of the right sewing equipment for your particular operation. Union Special representatives and service men are factory trained and are able to serve your needs promptly and efficiently. Whatever your location, there is a Union Special Representative to serve you. Check with him today.

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Union Special

CORPORATION

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