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Union Special[®]
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**INDUSTRIAL
SEWING
MACHINES**

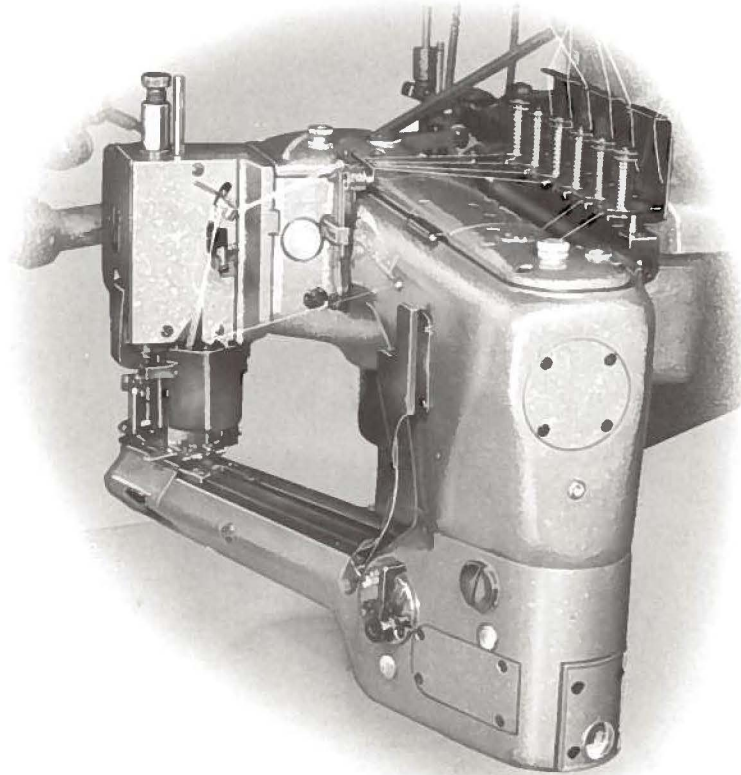
STYLES

36200C

36200E

36200AC

36200AE



CLASS 36200

HIGH SPEED

CYLINDER FLATSEAMER

MACHINES

FOR LAP SEAMING

Union Special **MACHINE COMPANY**

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. T118 C
(Supplement to Catalog No. 118 L)

INSTRUCTIONS
FOR
ADJUSTING AND OPERATING
LIST OF PARTS

STYLES

36200 C	36200 E
36200 AC	36200 AE

First Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U. S. A.

April, 1970

IDENTIFICATION OF MACHINES

Each Union Special machine is identified by a Style number which is stamped into the name plate on the machine. Style numbers are classified as standard and special. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 36200 C". 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 36200 CZ".

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 36200".

APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 118 L and should be used in conjunction therewith. Only the parts found on Styles 36200 C, E, AC and AE, but not on Styles 36200 A, B, AA or AB are illustrated and listed at the back of this catalog. At the back are illustrations identifying the parts by reference numbers and on the opposite pages will be found a listing of the parts, with their part numbers, descriptions and the number of pieces required. Any part that is a component of another part is indicated on the picture plate by having the reference numbers in a box or inside a bracket. On the copy page, a component of another part is indicated by indenting its description under the description of the assembly or complete part. Always use the part number in the second column, never use the reference number in the first column when ordering repair parts.

STYLES OF MACHINES

Cylinder Lap Seamer, High Speed, Medium Throw, Four Needles, One Looper, Six Thread, Manually Operated Differential Feed, Automatic Enclosed Type Oiling System and Filter Type Oil Return Pump, Visual Sight Oil Action and Supply Gauges, Space in Front of Needle 8 Inches.

36200 C For simultaneously trimming and lap seaming infant's panties, men's briefs and shorts, corsets, girdles and similar knitted light to medium weight garments where seaming and closing elastic is necessary. Seam Specification 607-LSa-1. Maximum recommended speed 4200 R. P. M.

36200 E For simultaneously trimming and lap seaming men's briefs and shorts, girdles and similar light to medium weight garments where crossing elastic and heavy seams, such as leg bindings is necessary. Seam Specification 607-LSa-1. Maximum recommended speed 4200 R. P. M.

36200 AC Same as Style 36200 C, except prepared for Pedestal Installation.

36200 AE Same as Style 36200 E, except prepared for Pedestal Installation.

NEEDLES

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

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

For best results, use only genuine Union Special needles in the operation of these machines. They are packaged under our brandname, *Union Special*, which is backed by a reputation for producing highest quality needles for more than three-quarters of a century.

Standard needle for Styles 36200 C, E, AC and AE is Type 118 GAS-029. It has a round shank, round point, extra short, double groove, struck groove, .060 inch diameter shank, chromium plated, and is available in sizes 025, 027, 029, 032, 036.

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 118 GAS, Size 029".

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 trade mark. Each trade mark is your guarantee of the highest quality in materials and workmanship.

TERMS

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

THREADING AND OILING INFORMATION

VIEWS AA and BB:

Thread as indicated in illustration on opposite page, starting with #4, progressing to 3, 2, 1, 5 and 6 in order and passing needle threads UNDER the stitch unlocking spring at needle thread frame eyelet "G".

VIEW CC:

Close-up of tension post assembly. A, Tension Nut; B, Spring; C, Post; D, Disc, upper; E, Disc, lower; F, Post Slot.

Pass threads thru slots "F" in tension post "C", and between tension discs "D" and "E".

VIEW DD:

Close-up of looper thread and cover thread take-ups.

VIEW EE:

Close-up of needle thread sequence.

OILING

Referring to illustration on opposite page, machine is filled at the caps "H" and "J". Use a straight mineral oil, with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit. The level is checked at the two sight gauges "K" and "L", located on the right side of the main frame under the foot lifter lever and at the front of the cylinder, respectively. Maintain oil level between red lines of these gauges.

Automatic lubrication is featured with a continuously driven rotary pump. Flow of oil can be observed thru windows "M" and "N" in crank chamber cover and front top cover. When installing a new machine or starting one that has been idle for some time, priming may be necessary. To do so, remove the two plug screws "P", fill holes with recommended oil and replace screws BEFORE operating. If oil does not flow while machine is running, pump is inoperative.

Oil is drained from machine at two places, "Q" and "R". "R" is located below and back of drive pulley. Belt cover must first be removed. When replacing the screw at "Q" be sure the hole in the filter box, that the screw goes into, lines up with the hole in the bottom of the cylinder.

Occasionally, it is necessary to oil the linkage of the presser foot, the knife holder shank No. 36273 A, guide collar No. 36273 K and the various links and bearings of the presser foot lifting mechanism and thread tension release.

INSTRUCTIONS FOR SEWING ADJUSTMENTS

In addition to the "INSTRUCTIONS FOR SEWING ADJUSTMENTS" covered in Catalog No. 118 L, the following instructions will apply to the machine Styles covered in this supplement catalog.

The lap former (A, Fig. S) must be centered in the presser foot slot. This can be accomplished by loosening screws (B) which will allow the positioning of the lap former within its elongated holes. The gibs (C) must be set so the lap former slide block (located under the lap former) will have a snug (not tight) fit, the entire length of the gibs. This can be accomplished by loosening screws (D), reposition gibs as required and retightening the screws.

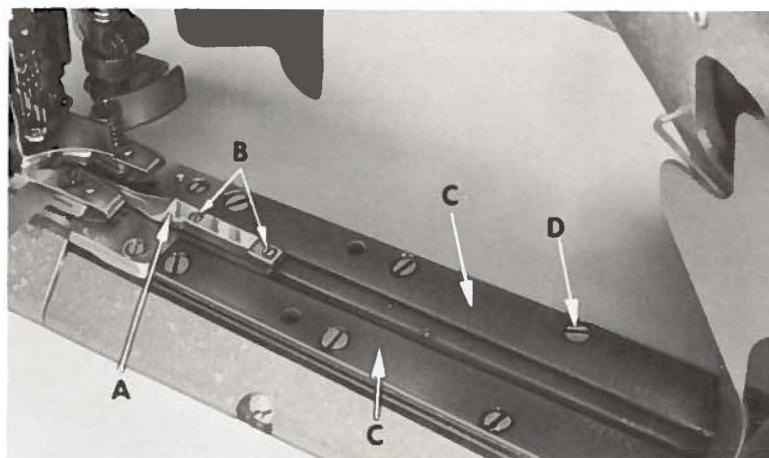
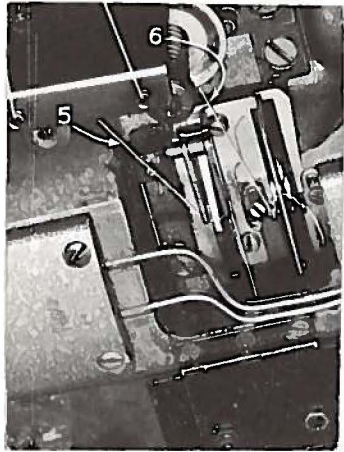


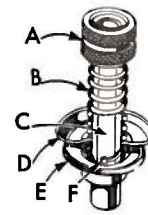
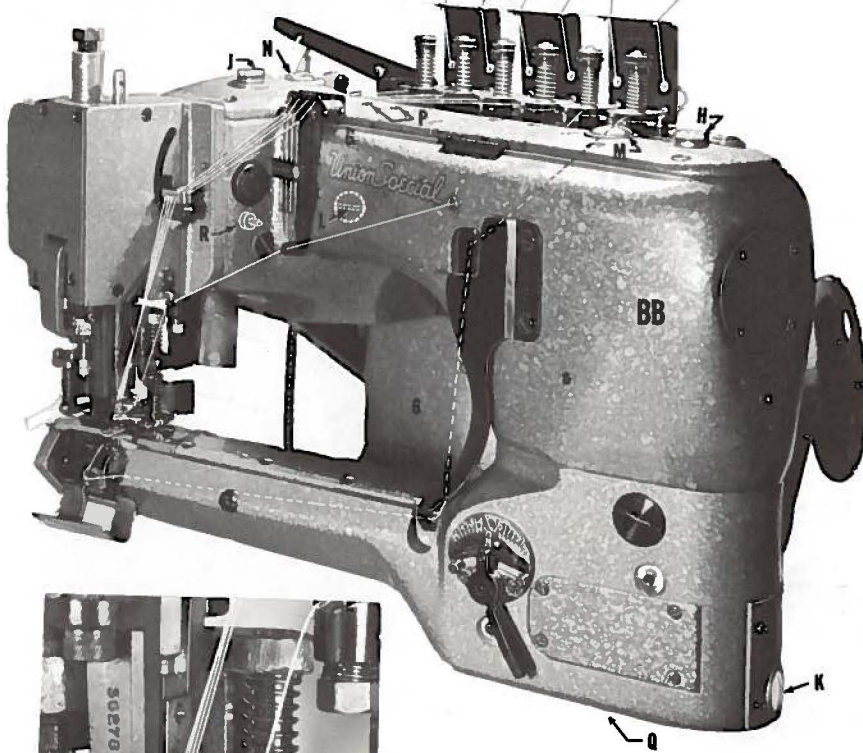
Fig. S



DD



AA

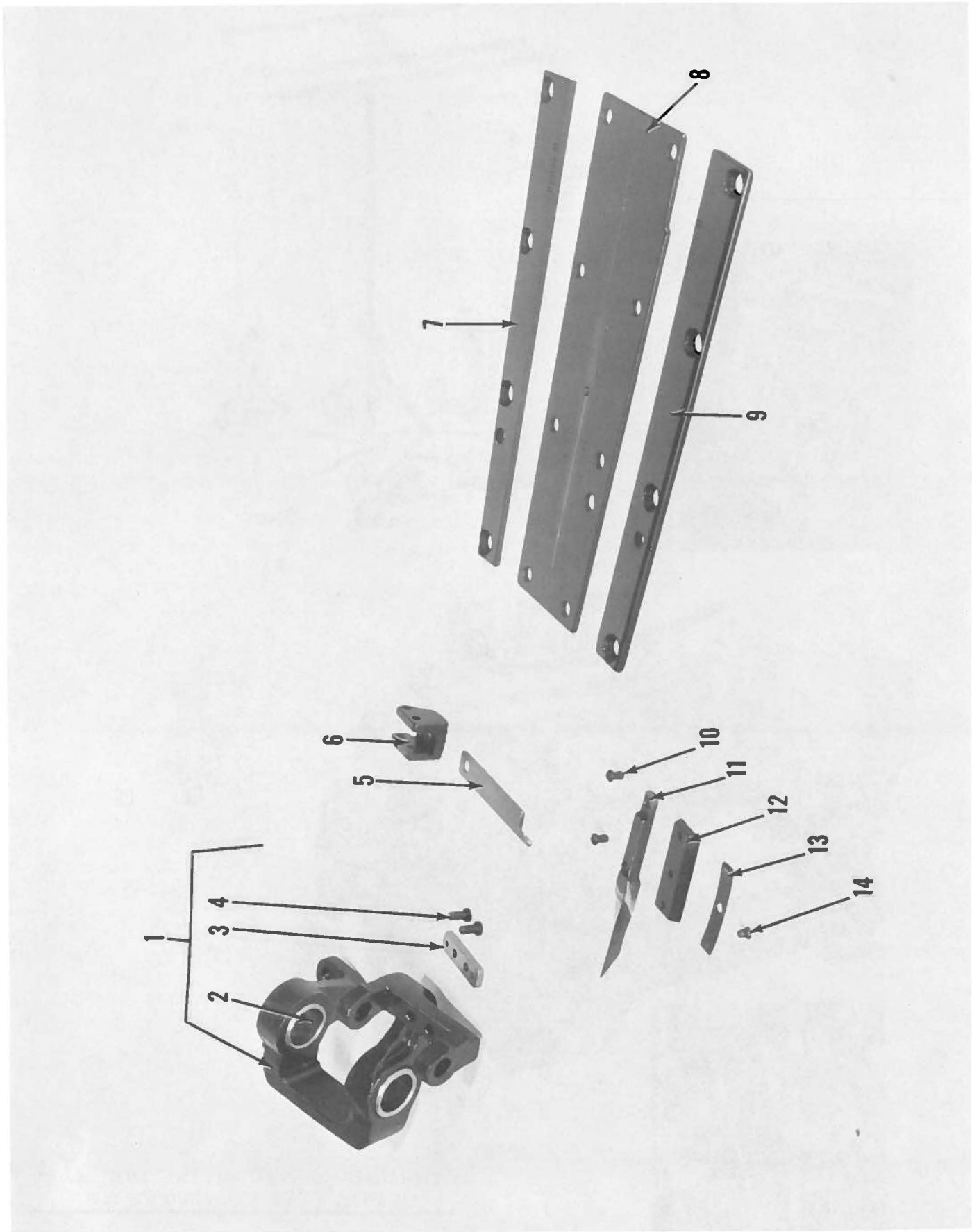


CC



EE

**THREADING AND OILING DIAGRAM
FOR STYLES 36200 C, E**

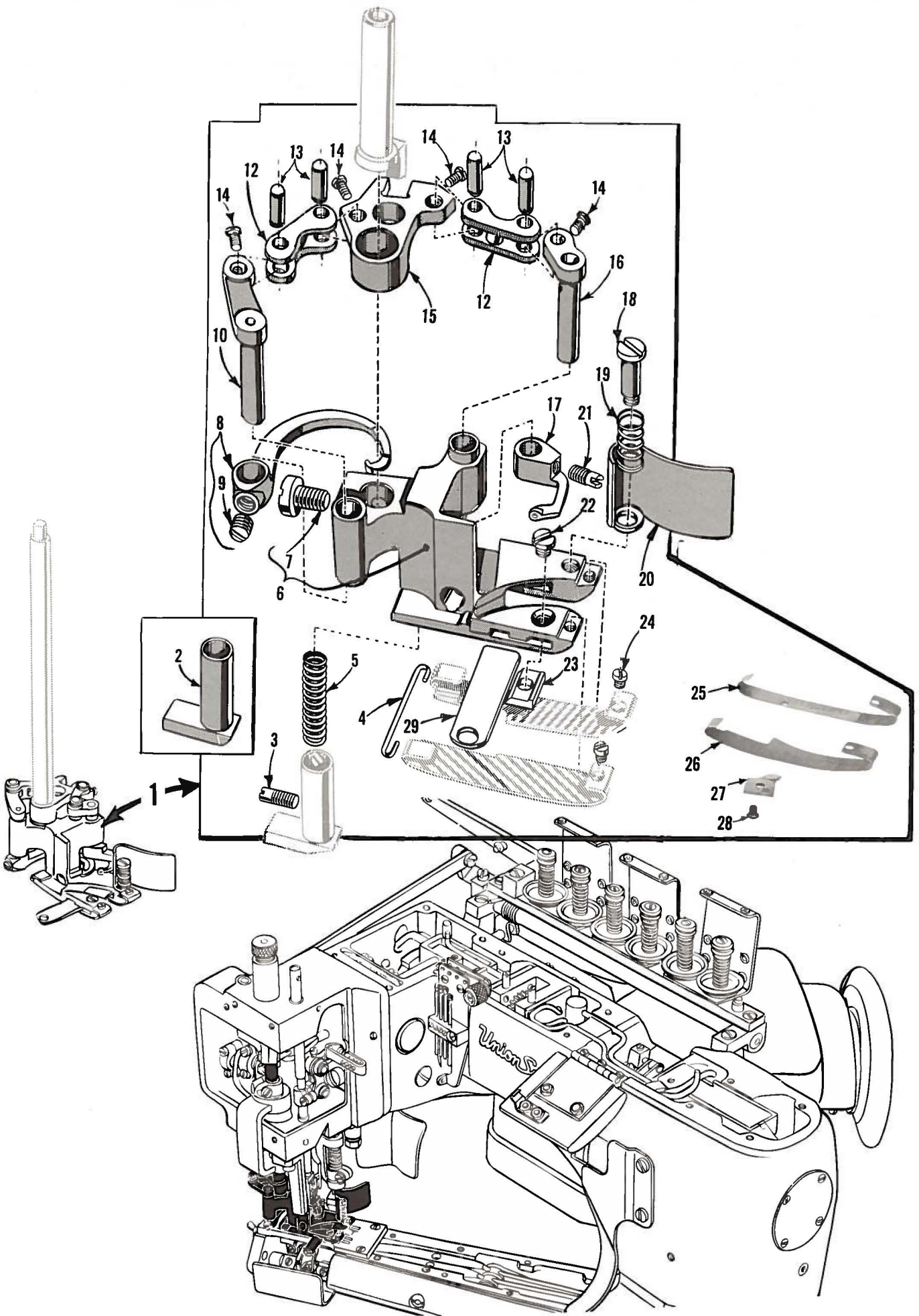


The parts illustrated on pages 8 and 10, and described below and on page 11 represent the parts that are used on Styles 36200 C, E, AC and AE, unless otherwise specified, but not used on Styles 36200 A, B, AA and AB.

Use Catalog No. 118 L for all parts not illustrated or described in this catalog.

Reference numbers that are inside a bracket or box on the picture plate and have indented descriptions, indicate they are component parts of a complete part or assembly.

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	36273 M	Knife Driving Bracket, for Styles 36200 E, AE -----	1
2	36273 F	Bushing-----	2
3	36273 J	Knife Holder Guide Plate -----	1
4	605 A	Screw -----	2
5	36270	Knife, upper, marked "C", for Styles 36200 E, AE-----	1
6	36273 G	Knife Holder, for Styles 36200 E, AE-----	1
7	36283 J	Gib, right-----	1
8	36283 G	Cylinder Cover -----	1
9	36283 H	Gib, left-----	1
10	22738 B	Screw, for lap former-----	2
11	23420 CY	Lap Former-----	1
12	23423 X	Lap Former Slide Block -----	1
13	23424 Z	Lap Former Slide Block Spring-----	1
14	22716 A	Screw, for lap former slide block spring -----	1



PRESSER FEET FOR STYLES 36200 C, E, AC AND AE

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	36220 C	Presser Foot Assembly, for Styles 36200 C, AC-----	1
	36220 E	Presser Foot Assembly, for Styles 36200 E, AE-----	1
2	36230 E	Yielding Section, marked "AH"-----	1
3	22565 A	Screw -----	1
4	36230 D	Shoe Holding Wire -----	1
5	36230 C	Spring -----	1
6	36230 K	Presser Foot, for No. 36220 C, marked "BN"-----	1
	36230 M	Presser Foot, for No. 36220 E, marked "BL"-----	1
7	94	Screw -----	1
8	36251 F	Cover Thread Hook -----	1
9	22562 A	Screw -----	1
10	36251 H	Cover Thread Hook Driving Lever and Shaft -----	1
12	36251 U	Link, for cover thread carrier and hook driving lever -----	2
13	36251 K	Link Pin -----	4
14	22738 B	Screw, for link pin-----	4
15	36251 L	Cover Thread Carrier and Hook Driving Segment----	1
16	36251 G	Cover Thread Carrier Driving Lever and Shaft-----	1
17	36251 E	Cover Thread Carrier, marked "A" -----	1
18	22731	Screw, for spring and chip guard -----	1
19	36279 D	Spring, for chip guard-----	1
20	36279 C	Chip Guard-----	1
21	22565 A	Screw, for cover thread carrier -----	1
22	22819	Screw, for stationary knife clamp -----	1
23	36250 A	Stationary Knife Clamp -----	1
24	22738 G	Screw, for presser foot shoes -----	2
25	36232 G	Presser Foot Shoe, right, .015 inch thick, 9/32 inch wide -----	1
26	36231 G	Presser Foot Shoe, left, .015 inch thick, 1/2 inch wide -----	1
27	36230 L	Cloth Guide Plate, marked "J"-----	1
28	22716 A	Screw, for cloth guide plate-----	1
29	36250	Stationary Knife -----	1



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

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