

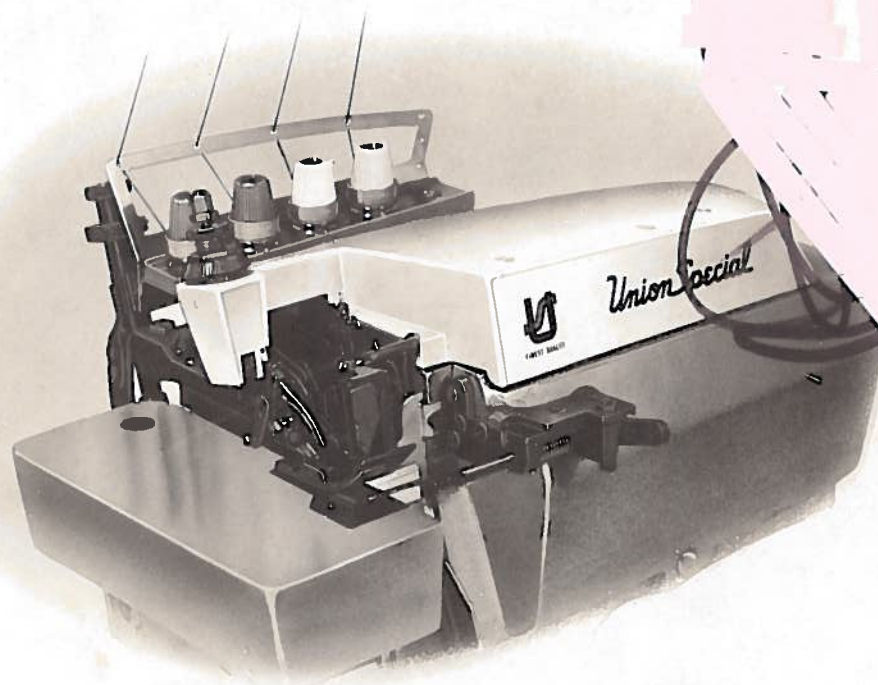
FINEST QUALITY

Union Special[®]
LEWIS • COLUMBIA

**INDUSTRIAL
SEWING
MACHINES**

STYLE

39600CU



CLASS 39600

HI-STYLED HIGH SPEED

FOUR THREAD

INTERMITTENT DIFFERENTIAL FEED

SAFETY STITCH MACHINES

CATALOG

No.

127P

Union Special **MACHINE COMPANY**

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. 127 P
(Supplement to Catalog No. 127 N)

INSTRUCTIONS
FOR
ADJUSTING AND OPERATING

LIST OF PARTS

CLASS 39600

Style

39600 CU

First Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U.S.A.

March, 1968

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 39600 CU". 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 39600 CUZ".

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: "39600".

The distance between the rows of stitches or between the needles is represented by a gauge number measured in 1/64ths of an inch, going from left to right. The width of overedge is represented by a fraction. Collectively, the gauge number and the width of overedge represent the machine gauge. Example: "5 1/8". Thus, 5 1/8 gauge represents a distance of 5/64 inch between the left needle (401 stitch) and the right needle (503 or 504 stitch) and the 1/8 represents the width of overedge to the right of the right hand needle.

APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 127 N and should be used in conjunction therewith. Only those parts used on Style 39600 CU, but not used on Style 39600 CP are illustrated and listed at the back of this catalog. On the page opposite the illustration will be found a listing of the parts, with their part numbers, description and the number of pieces required. 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.

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

STYLE OF MACHINE

Two Curved Needles, Left Needle in Front, Two Looper, One Spreader, Four Thread Dual Stitch Machine, 401 Double Locked Stitch on Left Needle and 503 Two Thread Overedge Stitch on Right Rear Needle, Intermittent Differential Feed, Straight Upper Knife, Trimming Mechanism with Spring Pressed Lower Knife, Automatic Lubricating System.

39600 CU Medium to heavy duty machine, for seaming and intermittently gathering or shirring on woven materials such as dresses, aprons, lingerie, smocks, nightgowns and similar garments. Knee press controlled tandem intermittent differential feed. A second knee press for lifting presser foot and pressure plate assembly. Independent swing-out pressure plate attachment for shirring. Gathering up to 5 to 1 depending on stitch length. Seam specification (401-503) 515-SSa-2. Standard gauge and seam widths are 5 1/8 and 12 3/16. Stitch range 8 to 16 per inch; cam adjusted main and differential feeds. Needle Type 158 GJ for 401 stitch and needle Type 154 GAS for 503 stitch. Maximum recommended speed up to 5500 R.P.M., depending on operation and ratio of shirring required.

OILING

CAUTION! Oil was drained from machine when shipped, so reservoir must be filled before beginning to operate. Oil capacity of Class 39600 is six ounces. A straight mineral oil of a Saybolt viscosity of 200 to 250 seconds at 100° Fahrenheit should be used.

Machine is filled with oil at spring cap in top cover. Oil level is checked at the sight gauge on front of the machine. Red bulb on the oil level indicator should show between gauge lines.

Machine is automatically lubricated. No oiling is necessary, other than keeping main reservoir filled. Check oil daily before the morning start; add oil as required.

The oil drain plug screw is located at the back of machine near bottom edge of base. It is a magnetic screw designed to accumulate possible foreign materials which may have entered the crank case. It should be removed and cleaned periodically.

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.

Two needles having different lengths are used in this machine. The shorter needle for the overedge stitch, located at the right, is Type 154 GAS. It is a round shank, round point, curved blade, standard length, single groove, struck groove, spotted, chromium plated needle and is available in sizes 022, 025, 027, 029, 032, 036, 040, 044, 049, 054.

The longer needle for the 401 stitch, located at the left, is Type 158 GJ. It is a round shank, round point, curved blade, flat tapered blade, Class "B" length, double groove, milled groove, long spot, government point, chromium plated needle and is available in sizes 027, 029, 032, 036, 040, 044.

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 154 GAS, Size 036".

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.

CHANGING NEEDLES

Release pressure on presser foot by turning the presser foot release bushing (A, Fig. 1) and swinging presser arm (B) out of position. Turn handwheel in operating direction (away from operator) until needle holding screws are just exposed from behind presser spring plunger and accessible to screw driver. Loosen screws and withdraw needles. When replacing needles observe the position of the flat which is at the left of the shank and be sure the needles are inserted the full depth to the combination eyelet and stop plate.

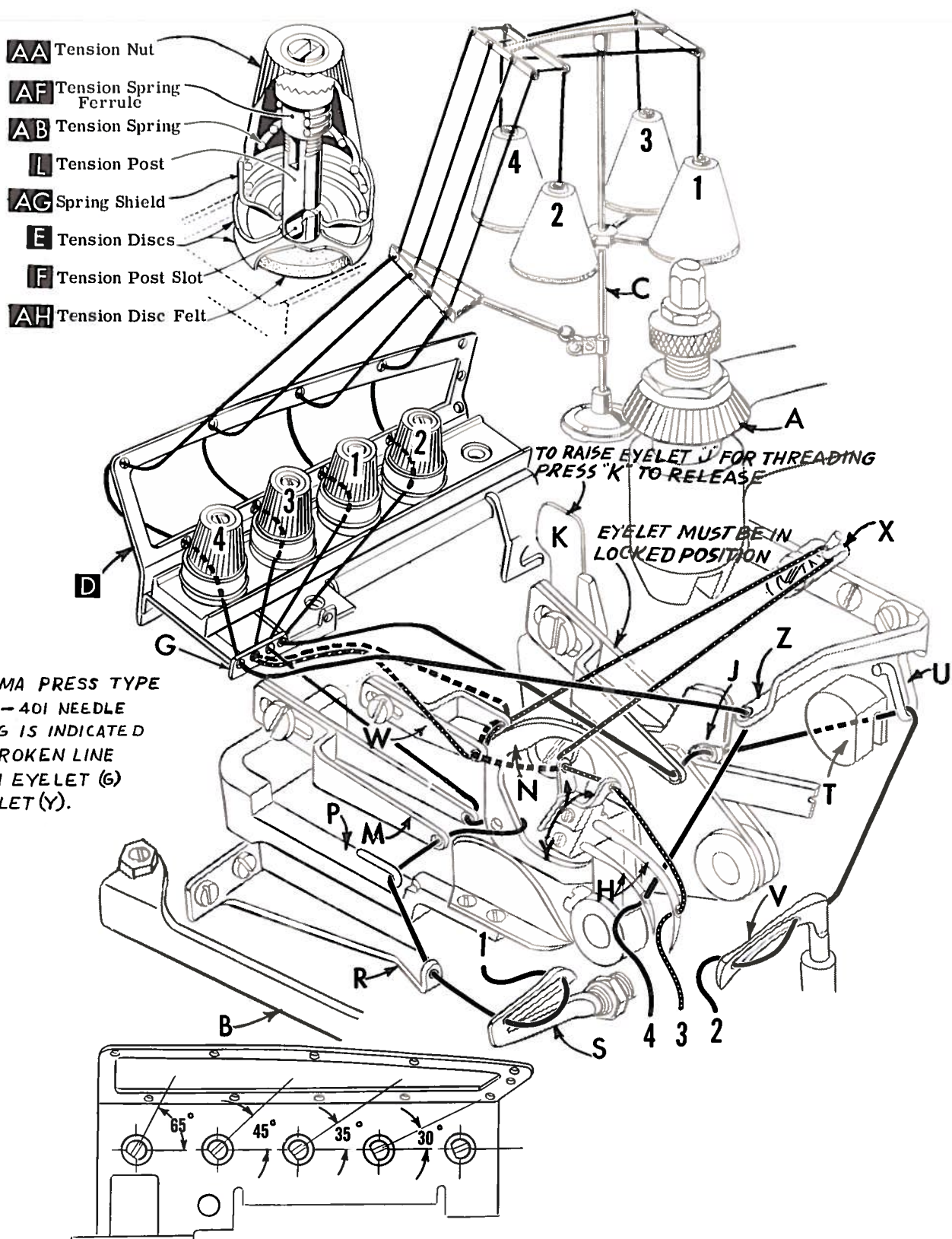


Fig. 1

THREADING

Only parts involved in threading are shown in threading diagram (Fig. 1). Parts are placed in their relative positions for clarity.

Thread from thread stand (C) is threaded through the upper holes of tension thread guide (D) from front to back and then through the lower holes from back to front. The threads then continue between the tension discs (E), through tension post slot (F) in tension post (L) and on through front thread guide (G).

It will simplify the threading of machine to follow the recommended sequence as designated by the numbers assigned to each thread, starting with thread No. 1, then No. 2, etc. The various eyelets and guides on the machine for each thread have been color coded to further aid the threading process.

Thus the sequence for Style 39600 CU is as follows: Thread No. 1, lower looper thread, yellow color code; thread No. 2, 401 looper thread, blue color code; thread No. 3, 401 needle thread, red color code, thread No. 4, overedge needle thread, green color code.

Before beginning to thread, swing cloth plate open, turn handwheel in operating direction until the needles (H) are at their highest position, release pressure on presser foot by turning presser foot release bushing (A), and swing presser arm (B) out of position.

RAISE 401 LOOPER THREAD TAKE-UP EYELET (J) BY RELEASING EYE-
LET LATCH (K) AND RAISING EYELET

THREADING LOWER LOOPER (Thread No. 1-Yellow Color Code)

Double end of lower looper thread (#1) and lead it through both eyes of lower looper thread eyelet (M) from right to left. NOTE: Thread must pass through the inside of needle thread cam pull-off (N). Lead thread back under hook of fabric guard bracket (P) and through eye of frame looper thread guide (R). Turn handwheel in operating direction until heel of lower looper (S) is all the way to the left; then thread through left eye, entering from the rear, and then through the right eye entering from the front. Left eye of lower looper can be threaded easily if tweezers are held with the left hand.

THREADING 401 LOOPER (Thread No. 2-Blue Color Code)

Double end of 401 looper thread (#2) and lead it through both eyes of looper thread take-up eyelet (J) from left to right, when the eyelet is in raised position. Return eyelet to its lower position by pressing it down. When eyelet is in correct position, latch will snap into place. Pass thread under knife arm, into groove of the upper knife support block (T), and over hook (U). Bring needle arm to bottom of its stroke. Insert double end of thread in right eye of 401 looper (V) and push through an inch or so of thread. Holding tweezers in left hand insert doubled end of thread into left eye, using about 3/16 inch projection of thread from point of tweezers. DO NOT THREAD LOOPER WITH NEEDLE LOOP AROUND LOOPER. REMOVE LOOP, OTHERWISE MACHINE WILL NOT SEW.

THREADING 401 NEEDLE (Thread No. 3-Red Color Code)

Lower needle arm to bottom of its stroke, by turning handwheel in operating direction. Threading from left to right, pass the 401 needle thread (#3) through both eyes of needle thread pull-off eyelet (W), passing over the outside of the needle

THREADING 401 NEEDLE (Thread No. 3-Red Color Code) (Continued)

thread cam pull-off (N). Then thread through eyelet (X) from front to back, through the top eye of needle driving arm thread eyelet (Y), through lower eye and finally through the eye of the left needle (H). Raise needle by rotating handwheel in operating direction and thread needle from front to back.

NOTE: When sewing perma-press type material, thread should pass through both eyes of needle thread pull-off eyelet (W) from right to left, then through both eyes of eyelet (Y) and finally through the needle.

THREADING OVEREDGE NEEDLE (Thread No. 4-Green Color Code)

Turn handwheel in operating direction until the needle is at its highest position. Pass overedge needle thread (#4) under overhanging arm of top cover and down through hole in top cover needle thread eyelet (Z). Thread needle (H) from front to back.

THREAD TENSION

The amount of tension on the needle and looper threads is regulated by the knurled tension nuts (AA, Fig. 1). Tension on the threads should be only enough to secure proper stitch formation. Using a postal scale, the measurements are taken with the needles at the top of their stroke and pulled in the direction as indicated. As a start the tensions may be as follows:

401 needle thread; 1 oz. straight out of lower eye of needle arm eyelet (Y).

Overedge needle thread; 1 to 1 1/2 oz. straight out of thread guide (G).

401 looper thread; 1 1/2 to 2 oz. straight out of looper thread eyelet (U).

Lower looper thread; 4 to 4 1/2 oz. straight out of frame looper thread guide (R).

FEED ECCENTRICS

Feed eccentrics used in Style 39600 CU machines have been selected to produce approximately 12 stitches per inch. It will be noted that the part number of main feed eccentric is No. 39540 B-12 while that of the differential feed eccentric is No. 39540 C. Minor numbers of the part symbol indicate approximately the number of stitches obtainable when using that eccentric. Unless otherwise specified, machine will be shipped with above combination of eccentrics.

Generally speaking, the main (right hand) feed eccentric determines the number of stitches produced, the differential (left hand) feed eccentric is selected so as to give the proper differential or gathering action.

Following stitch number feed eccentrics are available under No. 39540 B-4, -5, -6, -7, -8, -9, -10, -11, -12, -13, -14, -15, -16, -18, -20, -22, -24, -26, -28, -30, -32, -34, -36, -40. Only two eccentrics are supplied with each machine. Additional eccentrics may be ordered separately. To order an eccentric, use No. 39540 B with a minor number suffixed to indicate number of stitches desired. Example: "39540 B-12".

ASSEMBLING AND ADJUSTING SEWING PARTS

All of the adjusting instructions for Style 39600 CP covered in Catalog No. 127 N are applicable for Style 39600 CU. However, for Style 39600 CU there are additional instructions for setting the differential ratio and the pressure plate assembly as outlined below.

SETTING THE DIFFERENTIAL RATIO

Differential feed action is obtainable thru the use of two micrometer adjusting screws.

The position of the differential control lever (A, Fig. 27) is governed by an upper stop (B) and a lower stop (C). The amount of lever movement between these two stops determines the feed action.

The differential feed action is also controlled by the movement of the differential control lever between an upper and a lower stop, but both stops are moved by an adjusting thumbscrew rod.

To set the amount of differential or plain feed, turn the plain feed control adjusting rod, it is the larger knurled head screw located on the bed in back of the tension post assembly. Turning this rod clockwise decreases the amount of differential and turning it counterclockwise increases the amount of differential.

The amount of intermittent differential feed is set by turning the differential feed control adjusting rod, it is the smaller knurled head screw located just above the plain feed control adjusting rod. Turning this screw clockwise lowers the stop and thus increases the amount of differential, when the differential feed control lever is actuated. Turning this screw counterclockwise acts the reverse.

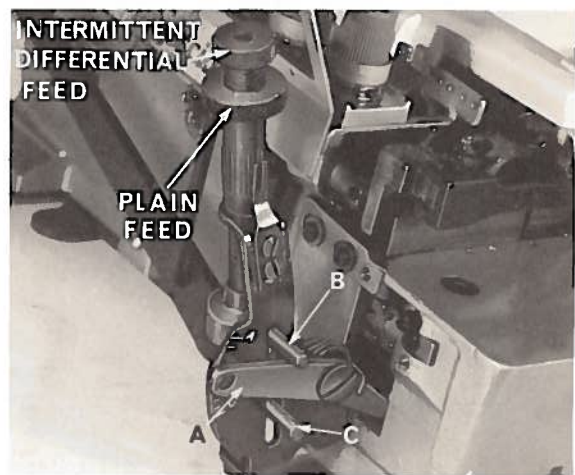


Fig. 27

SETTING THE AUXILIARY PRESSURE PLATE

This machine is equipped with an auxiliary pressure plate assembly (Fig. 28) which operates in conjunction with the presser foot. Check to operation of this assembly as follows:

1. With assembly in operating position, check to be sure latch spring (C, Fig. 28) is in notch of shaft bracket (G) when shaft bracket is up against the front of bracket (C, Fig. 29). If adjustment is necessary loosen screws (H, Fig. 28) and position latch spring.
2. Swing assembly out of operating position and see that it hinges freely on its pivot. Adjustment is made with screw (A, Fig. 28) and Nut (B).
3. Adjust shaft (D) laterally so that the pressure plate (E) locates centrally over the differential feed dog. Loosen screws (A and B, Fig. 29) to do this. Making this adjustment will release the spring tension on the pressure plate. To regain the tension, swing the pressure plate out and turn the shaft (D, Fig. 28) in either direction about 180° from operating position and tighten screw (B, Fig. 29).

SETTING THE AUXILIARY PRESSURE PLATE (Continued)

4. With the differential feed dog down below the surface of the throat plate, and the pressure plate resting on the throat plate with the maximum pressure the spring will allow, there should be about $\frac{1}{32}$ inch clearance between the operating lever (F, Fig. 28) and the hinge block (G). To make this adjustment loosen screw (A, Fig. 29) and move lever to desired position.

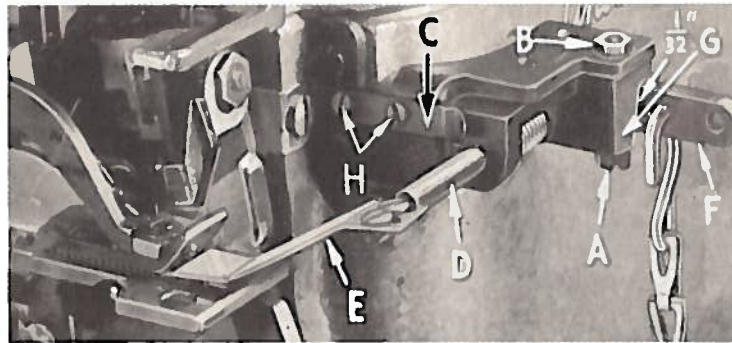


Fig. 28

5. With the differential feed dog at its highest point of travel, raise or lower the mounting bracket (C, Fig. 29) so that the auxiliary pressure plate is parallel with feed dog teeth.

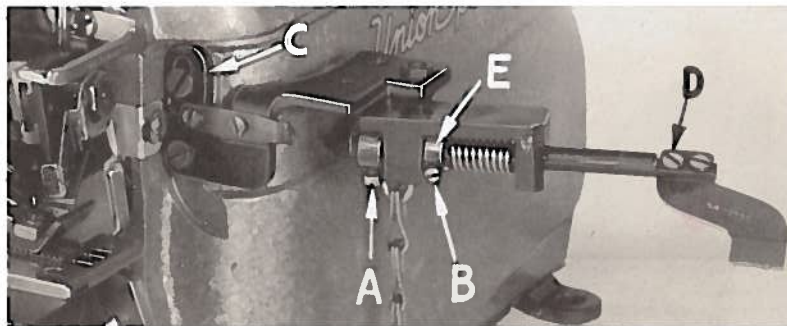
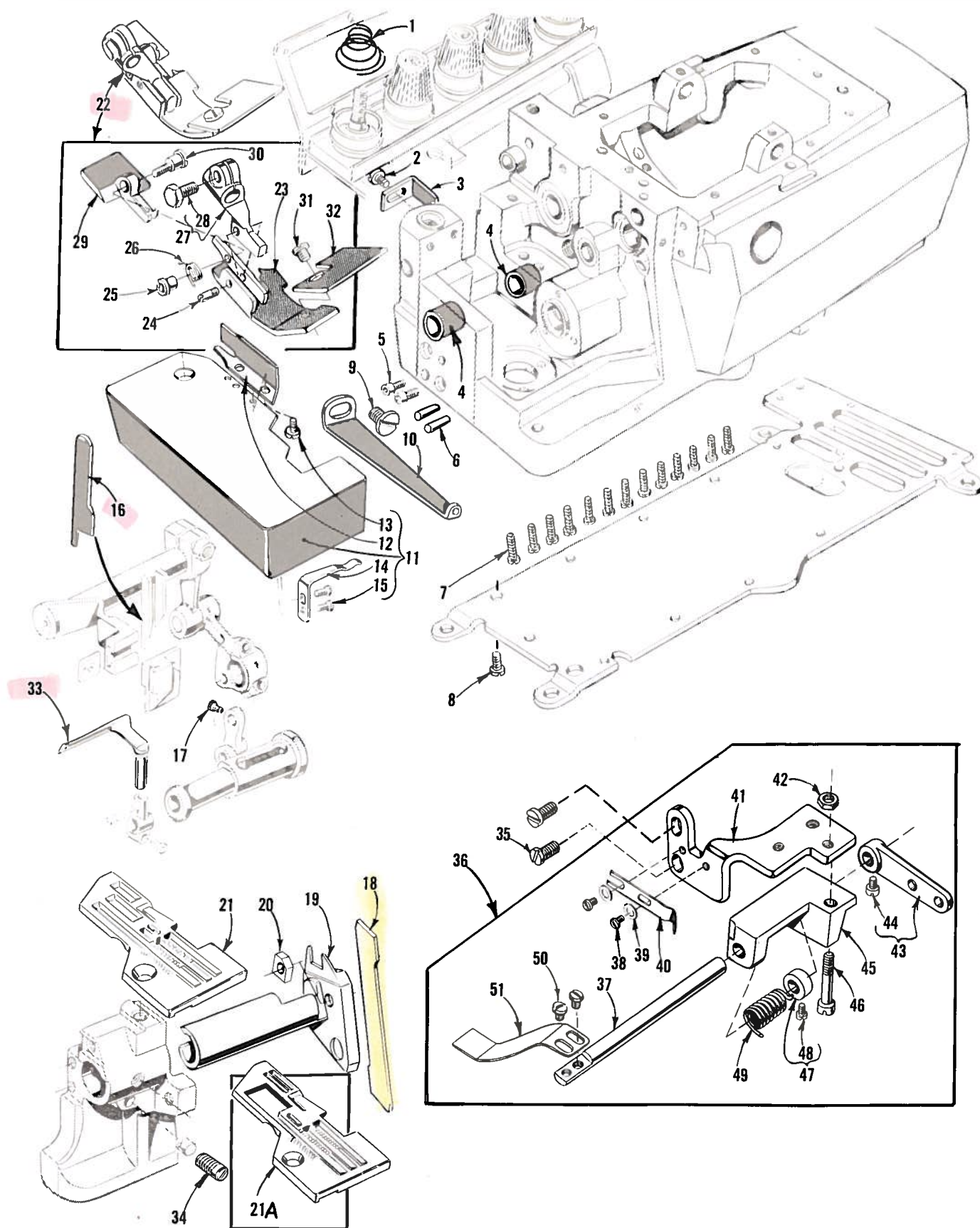


Fig. 29

6. Adjust the pressure plate in or out towards presser foot, maintaining it parallel with the feed dog, so that there is sufficient clearance between the end of plate and presser foot to permit free passage of the thickest part of the top ply being sewn. Use screws (D, Fig. 29) for this adjustment.
7. There are two spring anchoring holes in collar (E, Fig. 29) which may be used for increasing or decreasing spring tension on auxiliary pressure plate.
8. A chain is provided for raising the auxiliary pressure plate in conjunction with the presser foot. Couple this chain from the operating lever (F, Fig. 28) to the knee press rod that is part of the knee press assembly used to lift the presser foot. The presser foot should be raised before the pressure plate and the chain is normally attached to the pressure plate operating lever at the side hole.



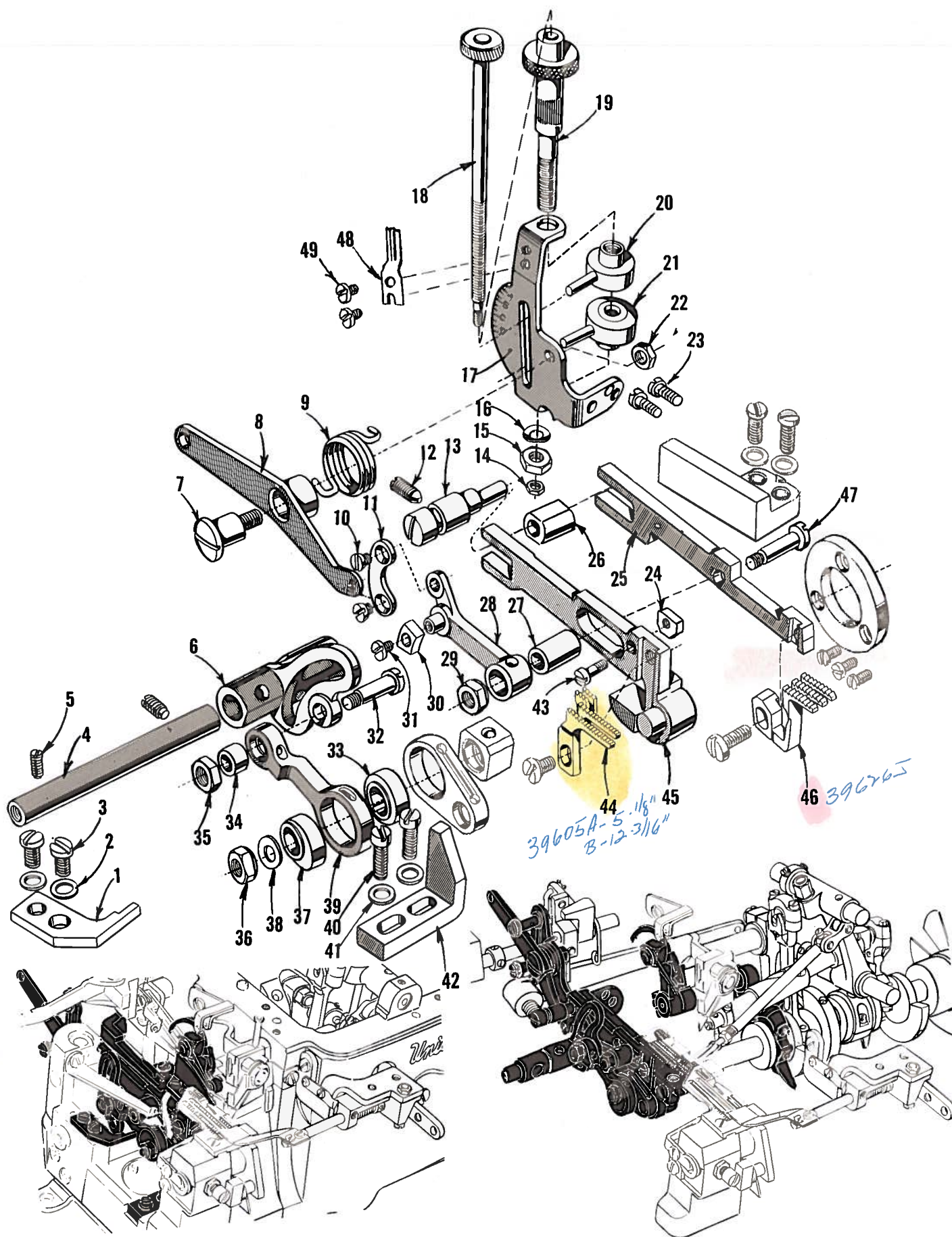
The parts illustrated on pages 10 and 12, and described on this page and page 13, represent the parts that are used on Style 39600 CU, but not used on Style 39600 CP.

Those parts shown in phantom views and bearing no reference numbers are common to Styles 39600 CP and CU.

Use Catalog No. 127 N (Style 39600 CP) for all parts not illustrated or described in this catalog.

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

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-----------------|---|--------------|
| 1 | 39592 AE-2 | Tension Spring, for 401 stitch looper ----- | 1 |
| | 39592 AE-5 | Tension Spring, for needles and 503 stitch looper ----- | 3 |
| 2 | 22569 C | Screw, for feed bar guide ----- | 1 |
| 3 | 39535 H | Feed Bar Guide ----- | 1 |
| 4 | 43243 N | Differential Feed Rocker Shaft Bushing ----- | 2 |
| 5 | 22653 B-12 | Socket Head Cap Screw ----- | 2 |
| 6 | 667 B-12 | Dowel Pin ----- | 2 |
| 7 | 22569 | Screw, for bottom cover ----- | 13 |
| 8 | 22569 C | Screw, for bottom cover ----- | 1 |
| 9 | 22569 D | Screw, for looper thread eyelet ----- | 1 |
| 10 | 39568 R | Looper Thread Eyelet ----- | 1 |
| 11 | 39501 DE | Cloth Plate Assembly ----- | 1 |
| 12 | 39578 F | Fabric Guard ----- | 1 |
| 13 | 138 | Screw, for fabric guard ----- | 2 |
| 14 | 39532 A | Latch Spring ----- | 1 |
| 15 | 90 | Screw, for latch spring ----- | 2 |
| 16 | 39270 J | Upper Knife ----- | 1 |
| 17 | 22781 | Screw, for looper avoid link pin ----- | 1 |
| 18 | 39549 J | Lower Knife ----- | 1 |
| 19 | 39650 C | Lower Knife Holder ----- | 1 |
| 20 | 39650 B | Lower Knife Clamp Screw Nut ----- | 1 |
| 21 | 39624 D-5-1/8 | Throat Plate, marked "BR-5-1/8", for No. 5-1/8 gauge ----- | 1 |
| 21A | 39624 D-12-3/16 | Throat Plate, marked "BR-12-3/16", for No. 12-3/16 gauge ----- | 1 |
| 22 | 39620 D-5-1/8 | Presser Foot, bottom marked "AS-5-1/8", for No. 5-1/8 gauge ----- | 1 |
| | 39620 D-12-3/16 | Presser Foot, bottom marked "AS-12-3/16", for No. 12-3/16 gauge --- | 1 |
| 23 | 39630 P-5-1/8 | Presser Foot Bottom, marked "AS-5-1/8", for No. 39620 D-5-1/8 | 1 |
| | 39630 P-12-3/16 | Presser Foot Bottom, marked "AS-12-3/16", for No. 39620 D-12-3/16 ----- | 1 |
| 24 | 22799 U | Hinge Screw ----- | 1 |
| 25 | 39630 L | Lock Nut ----- | 1 |
| 26 | 39630 N | Spring ----- | 1 |
| 27 | 39630 G | Presser Foot Shank, marked "D", for No. 39620 D-5-1/8 ----- | 1 |
| | 39630 J | Presser Foot Shank, marked "E", for No. 39620 D-12-3/16 ----- | 1 |
| 28 | 22781 | Screw ----- | 1 |
| 29 | 39630 H | Needle Hole Section, marked "AT", for No. 39620 D-5-1/8 ----- | 1 |
| | 39630 K | Needle Hole Section, marked "AR", for No. 39620 D-12-3/16 ----- | 1 |
| 30 | 39630 M | Hinge Screw, for needle hole section ----- | 1 |
| 31 | 187 A | Screw, for chip guard ----- | 1 |
| 32 | 39630 S | Chip Guard ----- | 1 |
| 33 | 39608 A | Looper, marked "CN", for 401 stitch ----- | 1 |
| 34 | 88 F | Screw, for 401 stitch rear needle guard ----- | 1 |
| 35 | 22569 C | Screw, for pressure plate assembly ----- | 2 |
| 36 | 29480 DC | Pressure Plate Assembly ----- | 1 |
| 37 | 39531 A | Pressure Plate Shaft ----- | 1 |
| 38 | 605 A | Screw, for latch spring ----- | 2 |
| 39 | 41358 G | Washer, for latch spring ----- | 2 |
| 40 | 39531 E | Latch Spring ----- | 1 |
| 41 | 39531 AS | Pressure Plate Mounting Bracket ----- | 1 |
| 42 | 907 | Nut, for hinge screw ----- | 1 |
| 43 | 39531 AR | Pressure Plate Operating Lever ----- | 1 |
| 44 | 77 A | Screw, for lever ----- | 1 |
| 45 | 39531 AT | Pressure Plate Shaft Bracket ----- | 1 |
| 46 | 22582 | Hinge Screw ----- | 1 |
| 47 | 39531 B | Pressure Plate Shaft Collar ----- | 1 |
| 48 | 604 | Screw, for collar ----- | 1 |
| 49 | 39531 C | Pressure Plate Spring ----- | 1 |
| 50 | 22561 | Screw, for pressure plate ----- | 2 |
| 51 | 39531 | Pressure Plate ----- | 1 |



DIFFERENTIAL FEED DRIVING MECHANISM

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-----------------|--|--------------|
| 1 | 39536 H | Thrust Finger ----- | 1 |
| 2 | 53634 C | Washer, for thrust finger ----- | 2 |
| 3 | 22569 C | Screw, for thrust finger ----- | 2 |
| 4 | 39536 M | Differential Feed Rocker Shaft ----- | 1 |
| 5 | 22565 B | Screw, for differential feed rocker shaft ----- | 2 |
| 6 | 39536 L | Differential Feed Rocker ----- | 1 |
| 7 | 22557 E | Screw, for differential feed control lever ----- | 1 |
| 8 | 39536 U | Differential Feed Control Lever ----- | 1 |
| 9 | 39536 V | Differential Feed Control Spring ----- | 1 |
| 10 | 39536 Y | Screw, for control lever connecting link ----- | 2 |
| 11 | 39536 W | Control Lever Connecting Link----- | 1 |
| 12 | 22565 F | Screw, for feed adjusting pin ----- | 1 |
| 13 | 39535 E | Feed Adjusting Pin ----- | 1 |
| 14 | 12934 A | Lock Nut, for differential feed control adjusting rod ----- | 1 |
| 15 | 39536 AH | Friction Nut, for differential feed control adjusting rod ----- | 1 |
| 16 | 39198 D | Spring Washer ----- | 1 |
| 17 | 39636 | Differential Feed Control Mounting Bracket ----- | 1 |
| 18 | 39636 C | Differential Feed Control Adjusting Rod----- | 1 |
| 19 | 39636 A | Plain Feed Control Adjusting Rod ----- | 1 |
| 20 | 39636 B | Plain Feed Control Adjustable Stop ----- | 1 |
| 21 | 39636 D | Differential Feed Control Adjustable Stop ----- | 1 |
| 22 | 18 | Nut, for differential feed control lever screw----- | 1 |
| 23 | 22569 C | Screw, for differential feed control mounting bracket ----- | 2 |
| 24 | 39536 X | Differential Feed Bar Guide Block----- | 1 |
| 25 | 39534 B | Differential Feed Bar ----- | 1 |
| 26 | 39535 J | Feed Bar Guide Block----- | 1 |
| 27 | 39536 R | Feed Bar Drive Connecting Bushing ----- | 1 |
| 28 | 39536 P | Differential Feed Drive Link----- | 1 |
| 29 | 39536 E | Nut, for differential feed bar driving stud ----- | 1 |
| 30 | 39536 N | Differential Feed Regulating Sliding Block----- | 1 |
| 31 | 28 | Screw, for differential feed regulating sliding block - | 1 |
| 32 | 39536 J | Differential Feed Drive Connecting Rod Stud----- | 1 |
| 33 | 39540 B-12 | Main Feed Driving Eccentric ----- | 1 |
| 34 | 39536 K | Feed Rocker Drive Connecting Bushing ----- | 1 |
| 35 | 39536 E | Nut, for differential feed drive connecting rod stud - | 1 |
| 36 | 258 | Nut, for crankshaft ----- | 1 |
| 37 | 39540 C | Differential Feed Driving Eccentric ----- | 1 |
| 38 | 40-46 | Washer, for crankshaft ----- | 1 |
| 39 | 39536 G | Differential Feed Drive Connecting Rod ----- | 1 |
| 40 | 22569 | Screw, for feed bar guide, left----- | 2 |
| 41 | 53634 C | Washer, for feed bar guide, left ----- | 2 |
| 42 | 39535 G | Feed Bar Guide, left ----- | 1 |
| 43 | 22726 L | Screw, for differential feed bar guide block ----- | 1 |
| 44 | 39605 A-5 1/8 | Main Feed Dog, 16 teeth per inch, marked "BC", for No. 5 1/8 gauge ----- | 1 |
| | 39605 B-12 3/16 | Main Feed Dog, 14 teeth per inch, marked "BH", for No. 12 3/16 gauge ----- | 1 |
| 45 | 39534 A | Main Feed Bar ----- | 1 |
| 46 | 39626 J | Differential Feed Dog, 16 teeth per inch, marked "CP", for all gauges ----- | 1 |
| 47 | 39536 S | Differential Feed Bar Driving Stud ----- | 1 |
| 48 | 39636 E | Ratchet Stop Spring----- | 1 |
| 49 | 88 A | Screw, for ratchet stop spring ----- | 2 |



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Union Special®

LEWIS and COLUMBIA

INDUSTRIAL SEWING MACHINES



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