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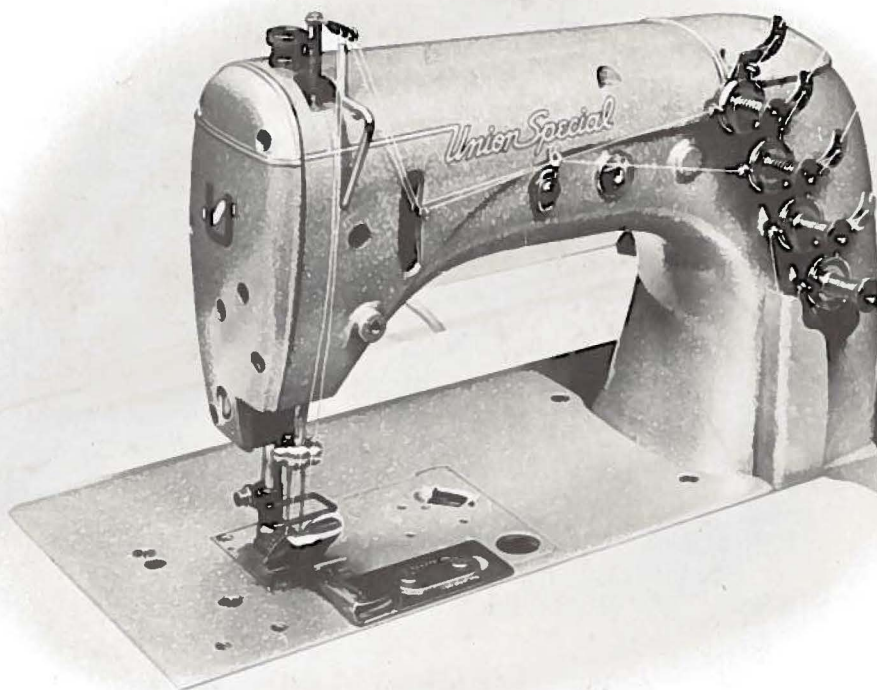
*Union Special*<sup>®</sup>  
LEWIS • COLUMBIA

INDUSTRIAL  
SEWING  
MACHINES

CLASSES

51400

51600



CATALOG  
NO.  
T128 L

STYLE 51600 BA

LIST OF PARTS FOR STYLES  
51400 BC      51600 BA

*Union Special* MACHINE COMPANY

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. T128 L

LIST OF PARTS

For Styles

51400 BC            51600 BA

First Edition

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*Union Special*  
**MACHINE COMPANY**  
INDUSTRIAL SEWING MACHINES  
**CHICAGO**

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May, 1969

## 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 51600 BA". 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 51600 BAZ".

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: "51600".

## 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 51400 and 51600. 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

Streamlined Flat Bed Machines, Low Throw, Two Needles, Independent Row, Treadle Controlled Intermittent Differential Feed, Light Weight Presser Bar and Needle Bar Driving Mechanism, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump and Head Oil Siphon Assembly, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 7 3/4 Inches.

51400 BC Left needle in front and 1/8 inch space between needles inline with feed. For setting puff sleeves in house dresses, waists, pajamas, and for similar operations on light to medium weight woven materials, where a large percent of the work calls for intermittently or continuously gathered curved seams and a small percent calls for intermittently or continuously gathered straight seams. Upper ply of fabric passes to the right of needles. Treadle controlled 3 to 1 differential feed gathering mechanism. Seam specification 401-LSc-2 modified. Type 106 GHS needles. Standard gauges Nos. 12 and 16.

51600 BA Same as Style 51400 BC except right needle in front. For gathering and attaching ruffles to body of garments made from light weight woven fabrics and similar operations where a large percent of the work calls for an intermittently or continuously gathered straight seam and a small percent of the work calls for an intermittently or continuously gathered curved seam. Upper ply of fabric passes to the left of needles. Treadle controlled 3 to 1 differential feed gathering mechanism. Seam specification 401-LSc-2 modified. Type 106 GS needles. Standard gauges Nos. 8, 10, 12 and 16.

## 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, type number 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:

Type No.	Description and Sizes
106 GS	Round shank, round point, extra short, double groove, struck groove, ball eye, chromium plated - sizes 027, 029, 032, 036, 040, 044, 049
106 GHS	Round shank, round point, extra short, ball point, double groove, struck groove, ball eye, chromium plated - sizes 032, 036, 040, 044

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 106 GS, Size 036".

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.

## 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.



## OILING AND THREADING

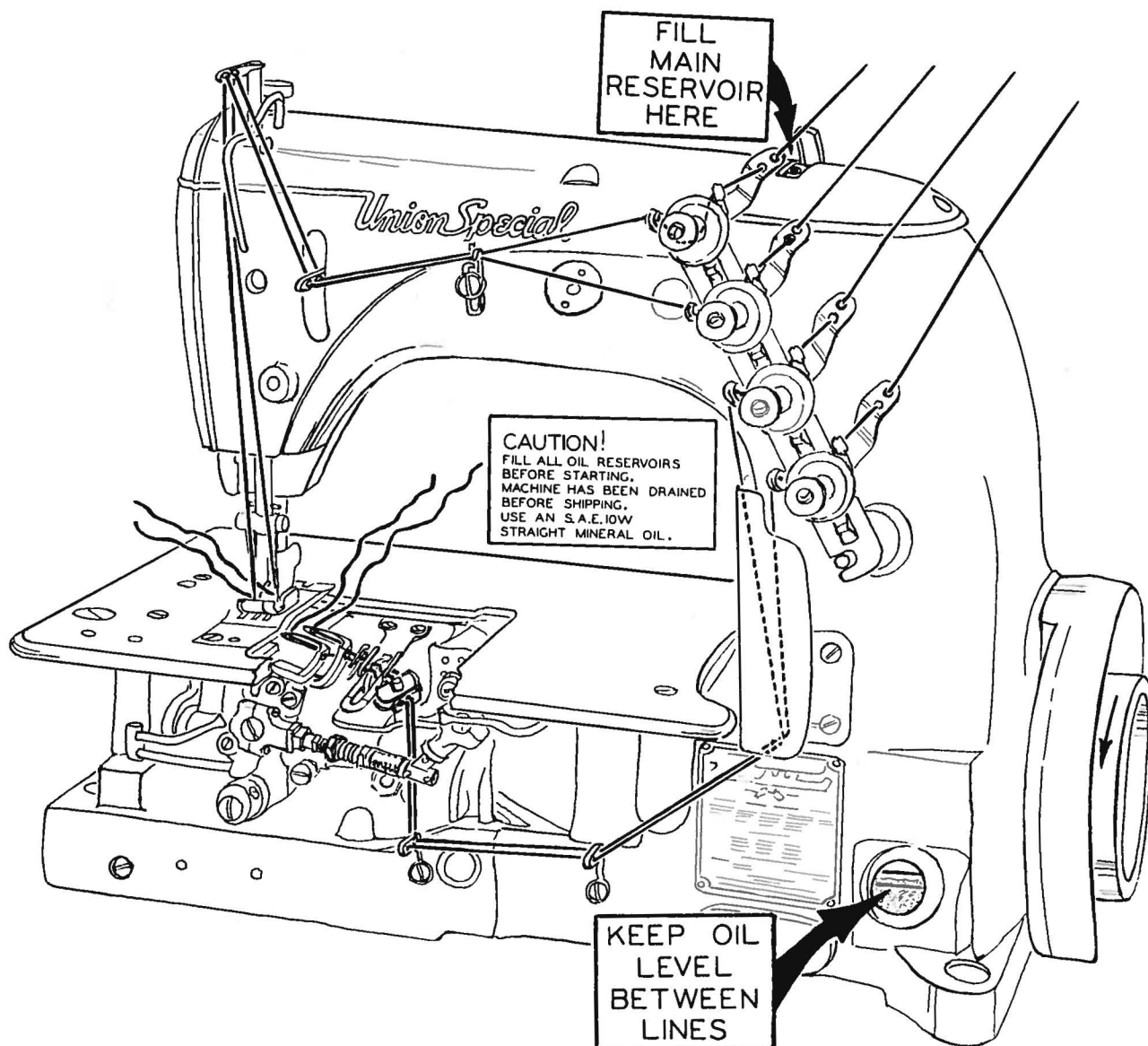
The oil has been drained from the machine before shipping and the reservoir must be filled before beginning to operate. Use a straight mineral oil with a Saybolt viscosity of 200 to 250 seconds at 100° Fahrenheit.

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

The machine is automatically lubricated and no oiling other than keeping the main reservoir filled is necessary.

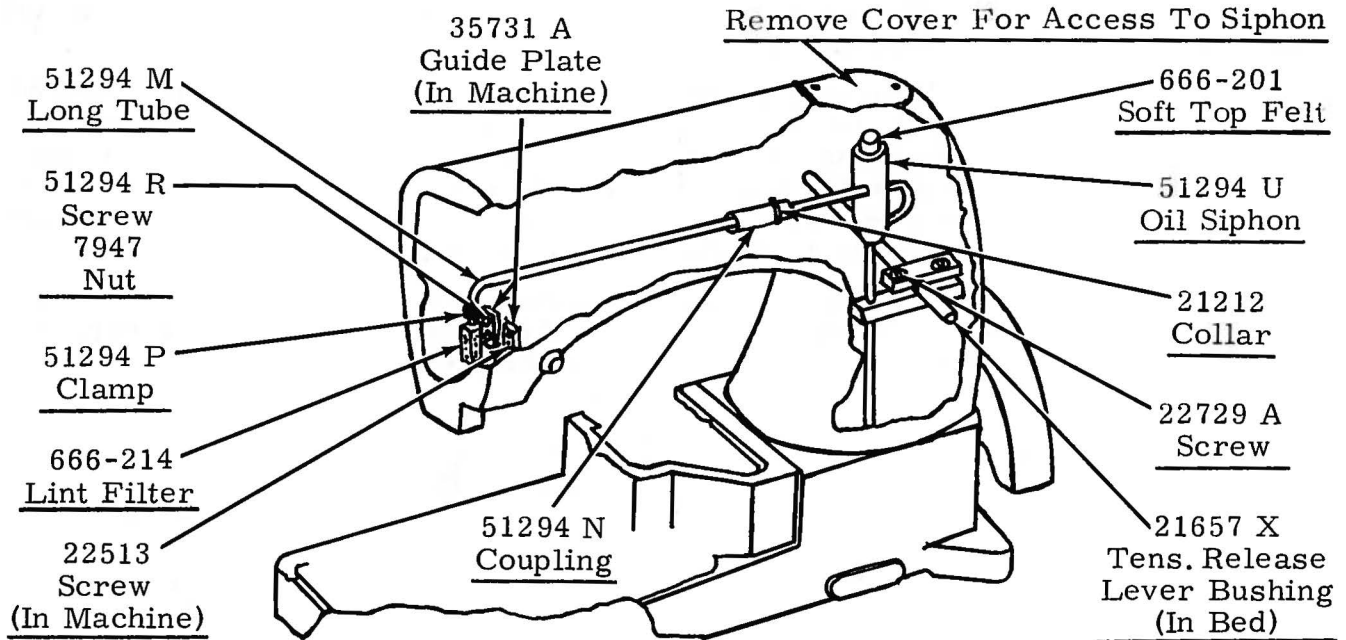
A daily check before the morning start should be made and oil added as required. Oil which has gone through the machine is filtered and pumped back into the main reservoir, making too frequent oilings unnecessary. Excessive oil in the main reservoir may be drained at the plug screw in the main frame directly under the handwheel. After draining oil, wipe the hole and plug screw dry, paint the hole and screw with a little gasket cement and reassemble screw.

The accompanying drawing shows the manner in which Styles 51400 BC and 51600 BA are threaded. The machines can be threaded in a similar manner, left needle in front or right needle in front makes no difference.



## SELF-PRIMING HEAD OIL SIPHON

Styles 51400 BC and 51600 BA are equipped with a self-priming head oil siphon. When the machine is started, oil splashes on the priming cup felts, filters through the felts, and trickles down the vertical oil tube, thus, priming the siphon. Once the prime is established, it is maintained, unless the felts are removed. The siphon operates twenty-four hours a day, removing oil at the rate of six to twelve drops per minute, which of course, far exceeds the rate at which oil collects in the head.



### INSTALLING AND MAINTENANCE OF OIL SIPHON

A newly installed siphon starts its action within three to five minutes after the machine is operating. However, it may be twenty minutes or so before all the air is removed from the line and the siphon is in full operation. Within an hour, there is a distinct drop in oil level in the head sump.

The felts in the priming cup are designed for a specific purpose. The bottom felt, 666-209, is thin and relatively dense, to meter the flow of priming oil and to prevent the entrance of air. The softer top felt, 666-201, is a filter to prevent the clogging of the metering felt. This felt, at the intake of the siphon, keeps the siphon clear of lint, and prevents the entrance of air at that point. For the best initial self-priming condition, the felts of the siphon should be dry. In this condition, it is difficult for air to be trapped between the felts or in the top soft felt itself.

However, if for some reason the priming cup felts had been oiled before installing, the siphon may fail because air is trapped between the felts or in the soft top felt. As a precaution, remove the soft felt from the cup. Then, while squeezing the felt between the fingers, saturate it well with oil. In other words, squeeze out the air and replace it with oil. Then, completely fill the cup with oil, and push or twist the soft felt down into cup so that it definitely contacts the harder thin felt. This precaution prevents the trapping of air, and no trouble should be experienced when starting the siphon.

If you want to be doubly sure that the siphon is functioning correctly, on a machine in operation, apply a certain amount of oil in the sump around the felt in the head. Before doing this, be certain that this felt has been saturated in the same manner as explained for the soft felt in the top of the siphon cup. When this is done, the siphoning action will begin, and the oil will be removed as explained.



The following is a numerical list of parts used in Styles 51400 BC and 51600 BA. Quantities, part numbers and descriptions are given. Unless otherwise specified, the parts listed are for both machines. 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	8	Feed Rocker Shaft	1	380	Latch Spring for	2	9937	Nut for 51435
3	18	Nut for 51240 D, 55241 N, 55244 G (right thread)	1	402	51402 on 51400 BC (357)	1	12538	Nut for 51241 K
2	PI18	Pin for 666-82	1	402	Screw for 21657 Y	2	12934 A	Nut for 22758 B
3	20	Washer for 51236 G, 51435, 51758	2	482	Screw for 53783 A	1	12982	Nut for 81
2	25 C	Screw for 23233 A	1	531	Feed Rocker Shaft Collar (98)	1	15105 B	Main Feed Dog for 8 gauge 51600 BA (22593)
2	25 C	Screw for 23253 F	2	531	Screw for 51257 M	1	15226 B	Diff. Feed Dog for 8 gauge 51600 BA(90)
2	25 C	Screw for 23253 Z	1	643-127	Screw for 51493 BQ	1	15465 F	Looper Rocker Cone for 29192 A (88)
2	25 CC	Screw for 43139 A (8372 A)	1	660-136	Gasket for 51493 AG	1	21210 A	Looper Collar for 51609 A
1	27-435	Needle Bar Eyelet	1	660-169	Oil Tube for feed crank link (258 A)	1	21212	Locking Ring for 51294 N
2	28	Washer	1	660-202	Needle Bearing for 51236 E	1	B21375 AH	Belt Guard (93)
1	28 C	Screw for 52804 A	1	660-207	"O" Ring for pulley	1	21657-4	Tension Release Separator
1	43	Adjusting Screw for 8344	2	660-212	Oil Seal Ring for pres- ser foot lifter lever	1	21657 E	Washer for 51457 A
1	43 C	Looper Avoid Eccen- tric for 29476 BJ (22894 D)	2	666-65	Oil Seal Ring for needle lever stud	1	21657 W	Tension Release Lever Shaft
1	43 C	Feed Lift Eccentric for 29476 AR (22894 D)	2	666-82	Oil Wick for looper rocker shaft(35178 D)	1	21657 X	Tension Release Shaft Bushing
2	50-216	Oil Wick for 51145 (PI18)	2	666-111	Oil Wick for feed rocker shaft	1	21657 Y	Tension Release and Lifter Lever Shaft Connection(402, 22596)
1	50-458	Pin for 51457 A	2	666-114	Oil Wick for main shaft bushing, right (35178 D)	2	22513	Screw for 23233 C
1	50-648	Spring Pin for 51241 K	2	666-118	Oil Wick for main shaft bushing, left	3	22513	Screw for 35731 A
1	54	Lucite Oil Gauge	2	666-170	Oil Wick for 51250 E	3	22516	Screw for 52836 H
1	54	Needle Bar Link on 29348 P	1	666-179	Wedge Pin for 666-111	2	22519 C	Screw for 52836 C
2	73	Screw for 51054	1	666-201	Felt Plug, upper, for 51294 U	1	22519 H	Screw for 51244 B
1	77	Screw for 51054 on 29348 P, upper	1	666-209	Siphon Cup Disc Felt for 51294 U	1	22519 J	Screw for needle guard and 52853
1	77	Screw for 51236 A	1	666-214	Felt Lint Filter for 51294 M	7	22524	Screw for 53782 B
1	78	Screw for 51054 on 29348 P, lower	1	719	Screw for 51150	1	22528	Screw for 51457 A
2	80	Screw for cloth plate	1	719	Screw for 51250 E	1	22539 H	Plug Screw for bed
3	80	Screw for 51480 C	1	719	Screw for 52835 U	3	22541 B	Screw for 52882 AD
1	81	Screw for 51242 Y (12982)	1	907	Nut for 22868 A	4	22548	Screw for 52882 AE
1	82	Stitch Regulating Screw	1	6042 A	Washer for 52894 AM	1	22557 B	Screw for 53783 L
2	87	Screw for throat plate on 51600 BA	1	7947	Nut for 51294 R	2	22559 A	Cap Screw for 29105 AA, small end
2	88	Screw for 15465 F	1	8305 L	Main Feed Dog for 16 gauge 51600 BA (22593)	2	22559 B	Cap Screw for 29105 AA, large end
1	89	Screw for 51418-16	1	8305 N	Main Feed Dog for 12 gauge 51600 BA (22593)	2	22559 G	Screw for 29066 R
1	90	Screw for differential feed dog	1	8305 S	Main Feed Dog for 10 gauge 51600 BA (22593)	2	22560 B	Screw for 51493 BP
2	90	Screw for 51282 AE	1	8324 L-2	Throat Plate for 8 gauge 51600 BA(87)	1	22560 B	Screw for 52834
2	90	Screw for 52882 Y	1	8324 L-4	Throat Plate for 12 gauge 51600 BA(87)	1	22560 B	Screw for 52894 AK
2	90	Screw for 52882 AA	1	8324 L-4	Throat Plate for 16 gauge 51600 BA(87)	2	22561	Screw for 23253 B
3	90	Screw for 52894 AB	1	8326	Diff. Feed Dog for 16 gauge 51600 BA(90)	2	22561	Screw for 23253 Y
1	91	Clamp Screw for 51600 BA presser feet	1	8326 A	Diff. Feed Dog for 12 gauge 51600 BA(90)	1	22562 A	Screw for 51254 H
2	93	Screw for B21375 AH	1	8326 G	Diff. Feed Dog for 10 gauge 51600 BA(90)	2	22565 C	Screw for 39237
1	95	Plug Screw for bed	1	8328 C-3	Throat Plate for 10 gauge 51600 BA(87)	5	22569 B	Screw for 51282 Y
2	95	Screw for 51147	1	8344	Stripper Blade for 51600 BA(28 C, 187 A)	3	22569 B	Screw for 51493 AH
1	95	Screw for 51270 B	1	8372 A	Washer for 25 CC	3	22569 B	Screw for 52891 B
1	96	Screw for 51244	1	9420 C-2	Presser Foot for 8 gauge 51600 BA	2	22570	Screw for throat plate on 51400 BC
1	96	Spot Screw for 51423 B	1	9420 C-3	Presser Foot for 10 gauge 51600 BA	18	22571 A	Plug Screw for bed
1	98	Needle Set Screw	1	9420 C-4	Presser Foot for 12 gauge 51600 BA	1	22580 D	Set Screw for 51423 B
1	98	Screw for 482	1	9420 C-4	Presser Foot for 12 gauge 51600 BA	2	22585 A	Screw for 53782 B
1	98	Screw for 51244	1	9420 C-4	Presser Foot for 12 gauge 51600 BA	1	22586 R	Screw for 660-212 (51250 D, 51250 F)
3	98 A	Screw for 158 B	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	2	22593	Screw for main feed dog
1	98 A	Screw for 51291 A	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	4	22593	Screw for 39237 D
8	109	Tension Disc	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	1	22596	Screw for 21657 Y
3	158 B	Looper Thread Eyelet (98 A)	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	1	22597 A	Screw for 51435 B
2	187 A	Screw for 8344	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	1	22597 A	Screw for 52835 U
1	258 A	Nut for 660-136	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	2	22704	Screw for 51444-12
1	258 A	Lock Nut for 22829 on 29192 A	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	2	22704	Screw for 51444-16
1	258 A	Nut for 52894 AM	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	1	22729	Screw for 51243 C
1	269	Nut for 51236 G	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	1	22729 A	Screw for 51294 U
1	269	Nut for 51240 D (left thread)	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	1	22729 B	Screw for 51294 U
1	357	Screw for 380	1	9420 C-4	Presser Foot for 16 gauge 51600 BA	2	22729 C	Screw for 55241 N
						1	22733 B	Plug Screw for 52882 L (41394 A)
						1	22747	Feed Dog Height Adjusting Screw for 52834
						1	22758 B	Screw for 52835 G
						2	22758 B	Screw for 52835 Q (12934 A)

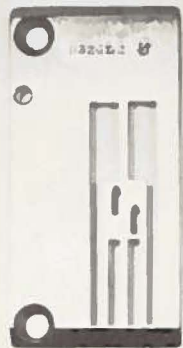


Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	22758 C	Screw for 53783 A	1	39237	Diff. Feed Bar Guide	1	51250 A	Bushing for 51215 J
3	22760 A	Screw for 51281 AC			(22565 C)	1	51250 D	Washer for 22586 R
1	22765	Shank Screw for	2	39237 D	Diff. Feed Bar Guide	1	51250 E	Needle Lever Stud
		51420 AC-12, -16			Plate (22593)			(666-170, 719)
2	22768	Screw for 51236 B	2	39237 G	Bushing for 52834	1	51250 F	Gasket for 22586 R
1	22768	Screw for 51244 B	1	39582 L	Oil Cap for 52882 AD	1	51254 C	Needle Bar Bushing,
1	22768	Screw for 51458 A	2	41394 A	Gasket for 22733 B			upper
1	22768	Screw for 56458	2	43139 A	Segment Stop Nut for	1	51254 D	Needle Bar Bushing,
1	22799 E	Hinge Screw for			25 CC			lower
		presser foot	2	43266	Nut for 51292 G	1	51254 H	Needle Bar Connec-
		51420 AC-12, -16	1	51054	Feed Crank Link Pin			tion on 29348 P
1	22811 B	Clamp Screw for			(77)			(22562 A)
		51242 W	2	51054	Link Pin for 29348 P	1	51256 C	Presser Bar Spring
1	22829	Screw for 15465 F	1	51134 C	(77, 78)	1	51256 N	Presser Spring
		(258 A)			Feed Bar Shaft			Regulator
3	22839	Screw for 51480 A	1	51144	Looper Rocker Shaft	1	51257 K	Presser Bar
2	22839 C	Screw for cloth plate			(51244 L)	1	51257 M	Presser Bar Connec-
1	22845 B	Screw for 51281 AC	1	51145	Feed Lift Eccentric			tion and Guide (531)
1	22848	Screw for 51758			Link for 29476 AR	1	51257 AA	Presser Bar Bushing,
2	22848	Screw for 52835 N	1	51145	Looper Avoid Eccen-			lower
9	22848	Screw for 52882 L			tric Link for	1	51270 B	Pull-off Wire (95)
1	22852 A	Screw for 51242 Y	1	51147	29476 BJ	1	51281 T-219	Cloth Plate Cover
		(51242 M)			Main Shaft Collar (95)			for 51600 BA
1	22868 A	Screw for 39236 T	1	51150	Needle Lever Thrust	1	51281 AC	Cloth Plate Cover
		(907, 39236 A)			Collar (719)			Spring for 51600 BA
1	22883 A	Plug Screw	1	51215 J	Needle Lever on			(22760 A, 22845 B,
1	22889 A	Adaptor Plug Screw			29348 P (51216 N,			35772 H)
		for 51758			51216 P	1	51282 Y	Head Cover (22569 B)
4	22894 C	Set Screw for 29105 AA	2	51216 G	Needle Lever Con-	1	51282 Z	Gasket for 51282 Y
1	22894 D	Screw for 43			necting Rod	1	51282 AE	Needle Lever Bearing
1	22894 D	Screw for 43 C	28	51216 M	Needle Bearing			Oiler (90)
1	22894 D	Spot Screw for	1	51216 N	Roller for 29476 FG	1	51283 H	Presser Foot Lifter
		29105 AA			Washer for 51215 J			and Tension Disc
2	22894 F	Screw for 51221 C	1	51216 N	Washer for 55244 G			Release Lever (402)
1	22894 H	Screw for 51242 W	1	51216 P	Nut for 51215 J	1	51290 T	Main Shaft Bushing,
2	22894 J	Screw for 51247	1	51221 C	#1 Vee Belt Pulley			middle
2	22894 P	Screw for 52836			(22894 F)	1	51291 A	Looper Thread Guard
1	23233 A	Attachment for	2	51235 G	Washer for 52836 C			(98 A)
		51400 BC (25 C)	2	51236 A	Link Pin for feed lift	4	51292 A	Tension Post Ferrule
1	23233 B	Lower Scroll and			and looper avoid (77)	4	51292 C	Tension Nut
		Base for 23233 A	1	51236 B	Feed Crank Stud Cap	4	51292 D	Tension Post Eyelet
1	23233 C	Upper Scroll for			(22768)	2	51292 F-2	Tension Spring, looper
		23233 A (22513)	1	51236 D	Feed Crank Link for	2	51292 F-5	Tension Spring, needle
1	23253 B	Attachment, upper,			51236 E	4	51292 G	Tension Post (43266)
		for 10, 12, 16 gauge	1	51236 E	Feed Crank Link	1	51294 K	Clamp, upper, for
		51600 BA (22561)	1	51236 F	Feed Crank Link			51294 U
1	23253 F	Attachment, lower,			Ferrule for 51236 E	1	51294 M	Oil Siphon Tube
		for 10, 12, 16 gauge	1	51236 G	Feed Crank Stud	1	51294 N	Oil Tube Connection
		51600 BA (25 C)			(20, 82, 269)			(21212)
1	23253 Y	Attachment, upper,	1	51240 D	Looper Connecting	1	51294 P	Oil Tube Clamp
		for 8 gauge 51600 BA			Rod (18, 269)	1	51294 R	Screw for 51294 P (7947)
		(22561)	1	51241 K	Looper Connecting	1	51294 U	Oil Siphon Assembly
1	23253 Z	Attachment, lower,			Rod and Ball Joint,			(22729 A, 22729 B)
		for 8 gauge 51600 BA	2	51242 L	right (12538)	1	51301 D	Cloth Plate for
		(25 C)			Thrust Washer for			51600 BA (80, 22839 C)
1	29066 R	Needle Lever Con-	1	51242 M	51242 P	1	51382 A	Gasket for 53782 B
		necting Rod Ball	1	51242 M	Washer for 22852 A	1	51401 M	Cloth Plate for
		Joint Assembly,	1	51242 P	Washer for 52841 G			51400 BC (80, 22839 C)
		upper (22559 G)			Looper Drive Lever	1	51402	Cloth Plate Slide for
1	29105 AA	Looper Drive Lever			Shaft (51242 L)			51400 BC
1	29192 A	Eccentric Assembly	1	51242 R	Looper Drive Lever	1	51405 AC-12	Main Feed Dog for
		Looper Rocker			Shaft Bushing, middle			51400 BC (22593)
1	29348 P	Assembly	1	51242 S	Looper Drive Lever	1	51408-12	Looper, front, for
		Needle Lever			Shaft Bushing, rear			12 gauge 51400 BC
1	29476 AR	Assembly	1	51242 W	Looper Drive Lever			(73)
		Feed Lift Assembly,			(22811 B, 22894 H)	1	51408-16	Looper, front, for
		.080 inch throw	1	51242 Y	Looper Drive Lever			16 gauge 51400 BC
1	29476 BJ	Looper Avoid			Rocker (81, 22852 A)	1	51409	(73)
		Assembly, .062 inch	1	51242 Z	Looper Drive Lever			Looper, back, for
		throw			Shaft Bushing, front			51400 BC (73)
1	29476 FG	Crankshaft Assembly	1	51243 C	Ball Stud Fork for	1	51413	Looper Rocker for
		.770 inch throw			29105 AA (22729)			29192 A
4	35178 D	Spring for 666-65,	1	51244	Looper Rocker	1	51417 C-8	Needle Bar for 10
		666-114			Frame (96, 98)			gauge 51600 BA
2	35731 A	Presser Bar Con-	1	51244 B	Looper Rocker Shaft	1	51417 C-12	Needle Bar for 12
		nection Guide Plate	2	51244 L	Arm (22519 H)	1	51417 C-16	gauge 51400 BC
		(22513)			Thrust Washer for			Needle Bar for 16
3	35772 H	Washer for 51281 AC			51144	1	51418-16	gauge 51400 BC
1	39236	Regulating Screw	1	51244 M	Looper Rocker Shaft	1	51420 AC-12	Needle Holder (89, 98)
		Sliding Block			Bushing, right	1		Presser Foot for 12
2	39236 A	Differential Feed Bar	1	51244 N	Looper Rocker Shaft			gauge 51400 BC
		Regulating Stud			Clamp Collar	1	51420 AC-16	Presser Foot for 16
		Washer	1	51246	Nut for 51745			gauge 51400 BC
1	39236 T	Diff. Feed Driving	1	51247	Main Shaft Counter-	1	51422	Main Shaft
		Link (22868 A)			weight (22894 J)	1	51423 B	Take-up (96, 22580 D)

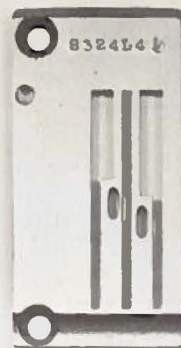


Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51424 AC-12	Throat Plate for 12 gauge 51400 BC (22570)	1	51608 A-12	Looper, front, for 12 gauge 51600 BA(73)	1	52882 Y	Baffle Plate (90)
1	51424 AC-16	Throat Plate for 16 gauge 51400 BC (22570)	1	51608 A-16	Looper, front, for 16 gauge 51600 BA(73)	1	52882 AA	Drip Plate for 52882 AD (90)
1	51425 AC	Needle Guard for 51400 BC(22519 J)	1	51609 A	Looper, back for 51600 BA (73, 21210 A)	1	52882 AC	Torsion Spring for 52882 AD
1	51426 AC	Diff. Fed Dog for 51400 BC (90)	1	51617 B-8	Needle Bar for 8 gauge 51600 BA	1	52882 AD	Crank Chamber Cover (22541 B)
1	51430 AC-12	Bottom, for presser foot 51420 AC-12	1	51617 B-12	Needle Bar for 12 gauge 51600 BA	1	52882 AE	Crank Chamber Cover, lower (22548)
1	51430 AD	Plunger Spring for presser foot 51420 AC-12, -16	1	51617 B-16	Needle Bar for 16 gauge 51600 BA	1	52883 R	Presser Foot Lifter Lever Bushing
1	51430 AE	Plunger Pin for presser foot 51420 AC-12, -16	1	51625	Needle Guard for 51600 BA (22519 J)	1	52883 S	Presser Foot Lifter Lever Bell Crank Spring
1	51435	Diff. Feed Control Lever, rear (20, 9937)	1	51745	Looper Rocker Cone Stud for 29192 A (51246)	2	52890 C	Main Shaft Bushing, left and inner right
1	51435 B	Control Lever Bushing (22597 A)	1	51758	Frame Needle Thread Eyelet (20, 22848, 22889 A)	1	52891 B	Crankshaft Bushing Housing, including bushing (22569 B)
1	51444-12	Stripper Blade for 12 gauge 51400 BC (22704)	2	51959 B	Looper Thread Nipper Disc	3	52894 AB	Oil Tube Holder (90)
1	51444-16	Stripper Blade for 16 gauge 51400 BC (22704)	1	51959 D	Looper Thread Nipper Nut	1	52894 AC	Oil Tube for feed lift and looper avoid eccentric
1	51457 A	Cast-off Wire Support (50-216 Blk., 21657 E, 22528)	1	51959 K	Looper Thread Nipper Spring	1	52894 AD	Oil Tube for diff. feed bar shaft
1	51458 A	Needle Bar Thread Eyelet (27-435 Blk., 22768)	1	52804 A	Cast-off Wire (28)	1	52894 AE	Oil Tube for diff. feed bar guide
1	51459 A	Looper Thread Tension Post Thread Guide	1	52834	Main Feed Bar (22560 B, 22747)	1	52894 AK	Oil Tube for looper rocker and left ball joint (22560 B)
1	51480 A	Throat Plate Support for 51400 BC (22839)	1	52834 H	Diff. Feed Bar	1	52894 AM	Oil Tube for looper rocker ball joint, right (258 A, 6042 A)
1	51480 C	Throat Plate Support for 51600 BA (80)	1	52835	Diff. Feed Control Lever	1	52925 D	Needle Guard Holder
4	51491 C	Lead-in Thread Eyelet	1	52835 G	Control Lever Link (22758 B)	1	53592	Tension Post Support
1	51492	Looper Thread Tension Post	1	52835 K	Diff. Control Lever Spring (61267 G)	1	53782 B	Oil Reservoir Top Cover (22524, 22585 A)
1	51493 D	Oil Pump Driving Shaft	1	52835 N	Control Lever Stop Plate (22848)	1	53783 A	Lifter Lever Link (402, 22758 C)
2	51493 E	Oil Pump Driving Shaft Gear	1	52835 Q	Intermediate Diff. Feed Fork (22758 B)	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
1	51493 AG	Oil Pump Housing	1	52835 S	Diff. Feed Fork Block	1	53783 M	Presser Foot Lifter Lever Connecting Rod
1	51493 AH	Oil Pump Housing Cover (22569 B)	1	52835 U	Pivot Stud Insert (719, 22597 A)	1	53783 N	Presser Foot Lifter Lever, internal
1	51493 BK	Lint Filter Screen	1	52836	Feed Rocker (22894 P)	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
1	51493 BP	Oil Pump Driving Gear (22560 B)	1	52836 C	Feed Rocker Arm (22519 C, 51235 G)	1	55244 G	Looper Rocker Rock Shaft Collar Stud (18, 51216 N)
1	51493 BQ	Oil Pump Driven Gear (531)	1	52836 H	Feed Rocker Segment Slot Plate (22516)	1	56341 G	Spring for 51241 K
1	51608 A-8	Looper, front, for 8 gauge 51600 BA(73)	2	52836 P	Feed Rocker Shaft Bushing	1	56390 E	Gasket for 52891 B
			1	52836 R	Looper Rocker Shaft Bushing, left	1	56458	Needle Lever Thread Eyelet (22768)
			1	52841 G	Looper Lever Locking Stud (51242 M, 52841 G)	1	K56823	Looper, front, for 10 gauge Style 51600 BA (73)
			1	52841 J	Nut for 52841 G	1	61267 G	Spring Pin for 52835 K
			1	52853	Feed Dog Holder (22519 J)			
			1	52882 L	Oil Reservoir Back Cover (22733 B, 22848)			
			1	52882 M	Gasket for 52882 L			
			1	52882 P	Gasket for 52882 AD			
			1	52882 U	Gasket for 52882 AE			

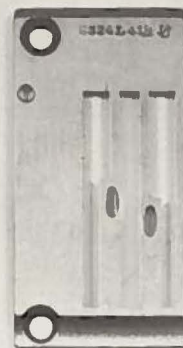
NOTE: Numbers in parenthesis following parts' description indicate the screws, nuts, etc., used to attach these parts.



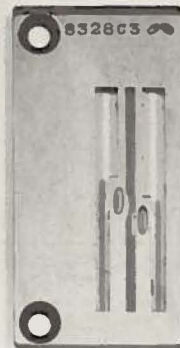
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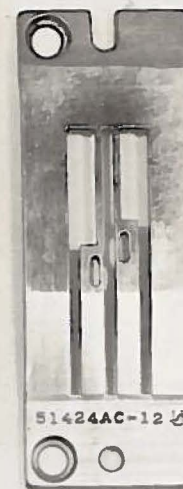
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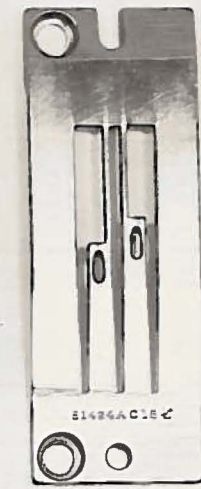
8324 L-4 1/2



8328 C-3



51424 AC-12



51424 AC-16



87



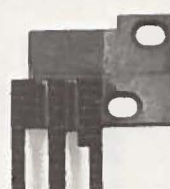
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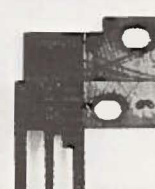
15105 B



8305 N



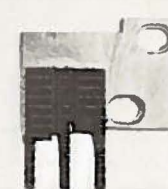
8305 L



8305 S



22593



51405 AC-12



15226 B



8326 A



8326



8326 G



90



51426 AC



23253 B  
23253 Y

22561

22765 (Incl.)

91 (Incl.)

28 C (Adj. Screw for 8344)

51420 AC-12

51420 AC-16

9420 C-2

9420 C-3

9420 C-4

9420 C-4 1/2

8344

51409

187 A

51609 A

51408-12

51408-16

21210 A

51608 A-8

K56823

51608 A-12

51608 A-16

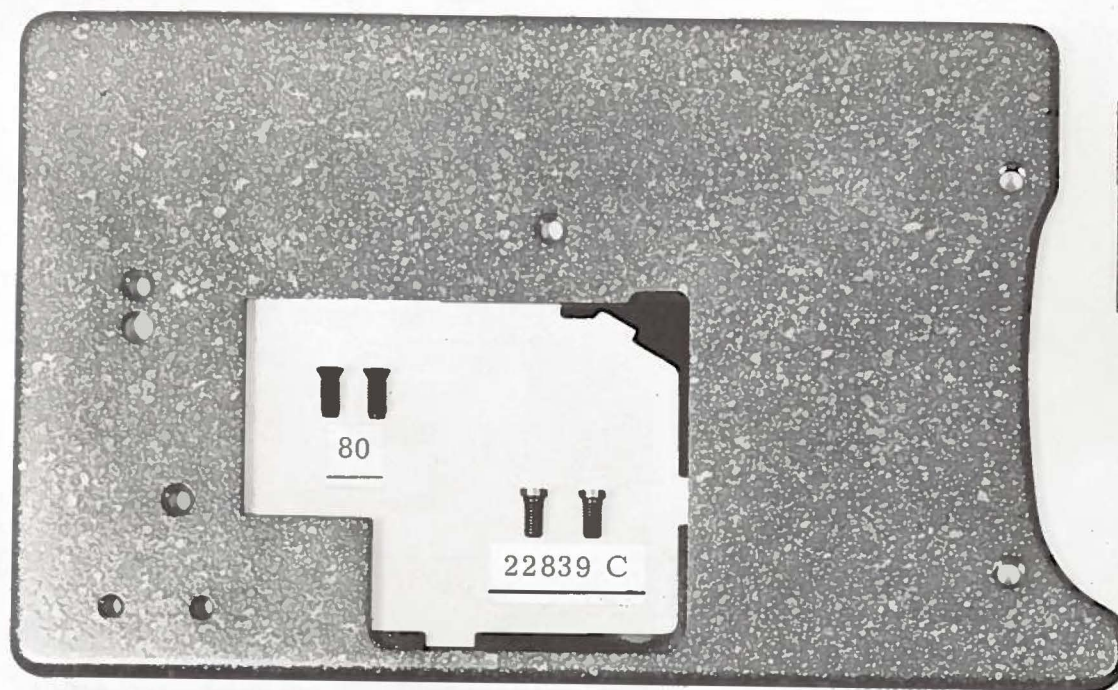
52853

52925 D

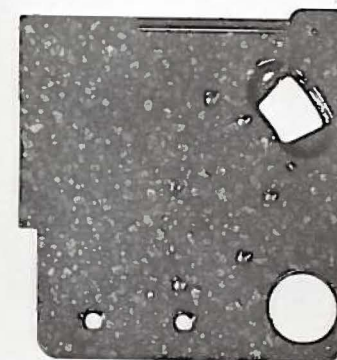
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51625

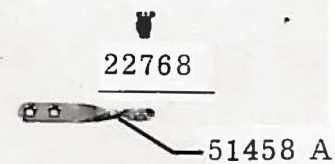
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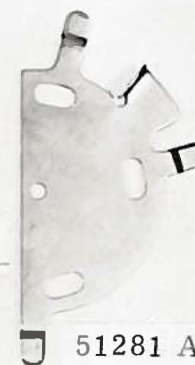
51301 D



51281 T-219

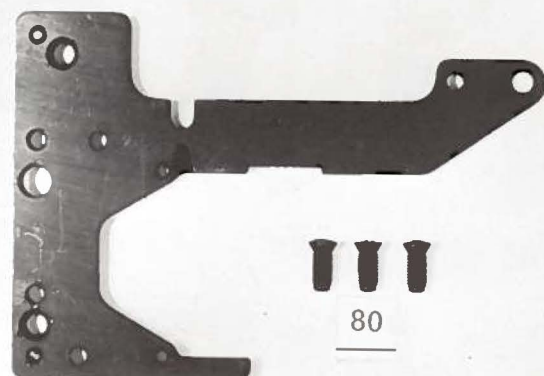
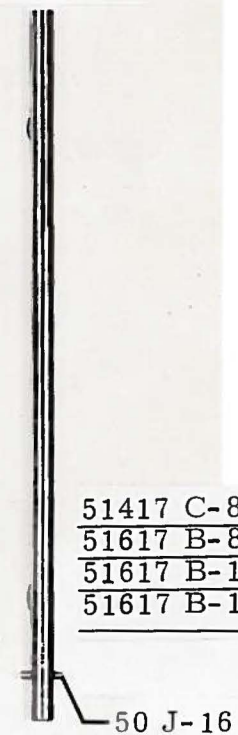


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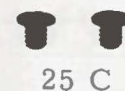


22845 B

51417 C-8  
51617 B-8  
51617 B-12  
51617 B-16



51480 C



25 C

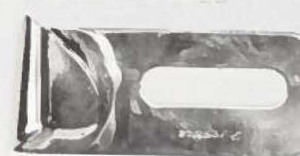


23425 V

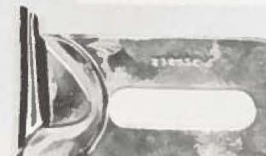


22760 A

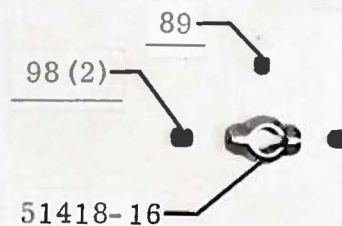
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23235 F

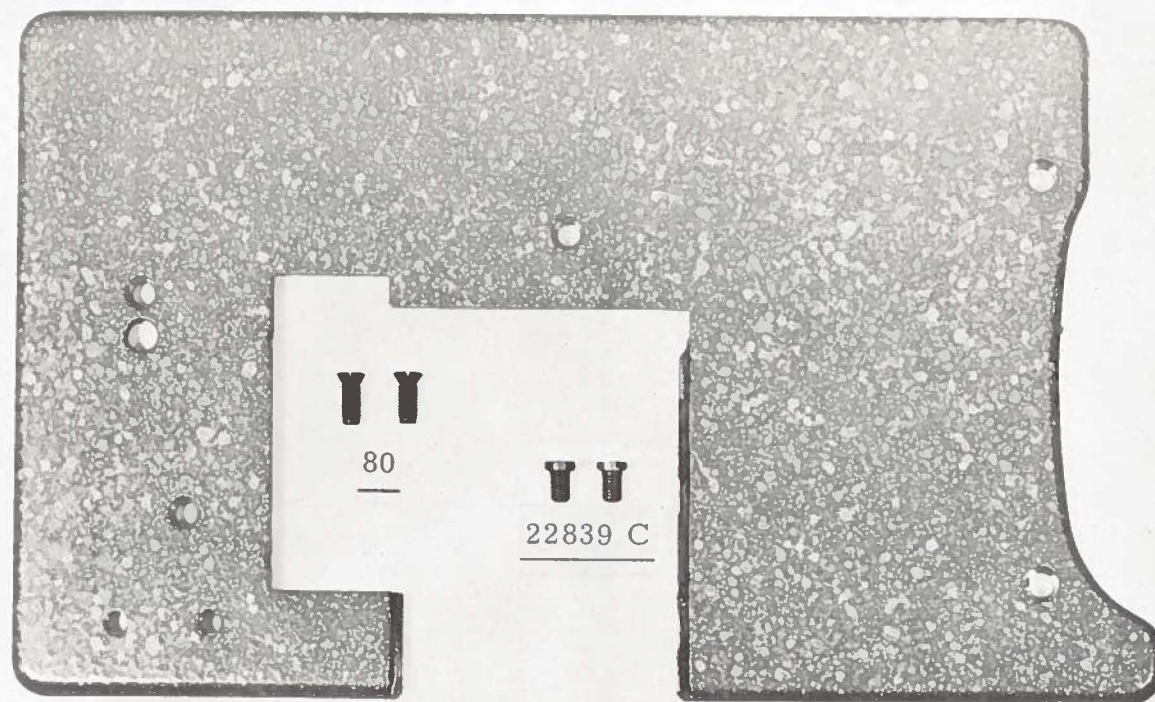


23235 Z



51418-16





51401 M



80



22839 C



380



357

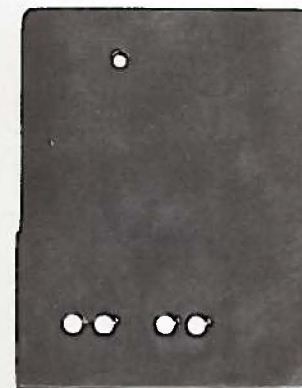


22768



51458 A

27-435 Blk.



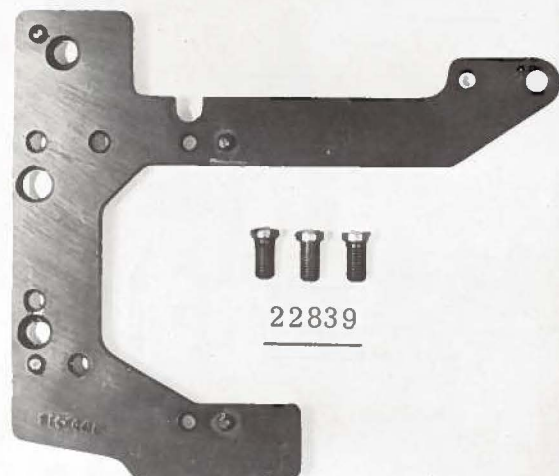
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25 C

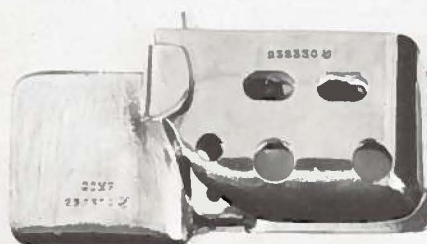


23425 V



22839

51480 A



23233 A



22704



51444-12

51444-16

98 (2)

89



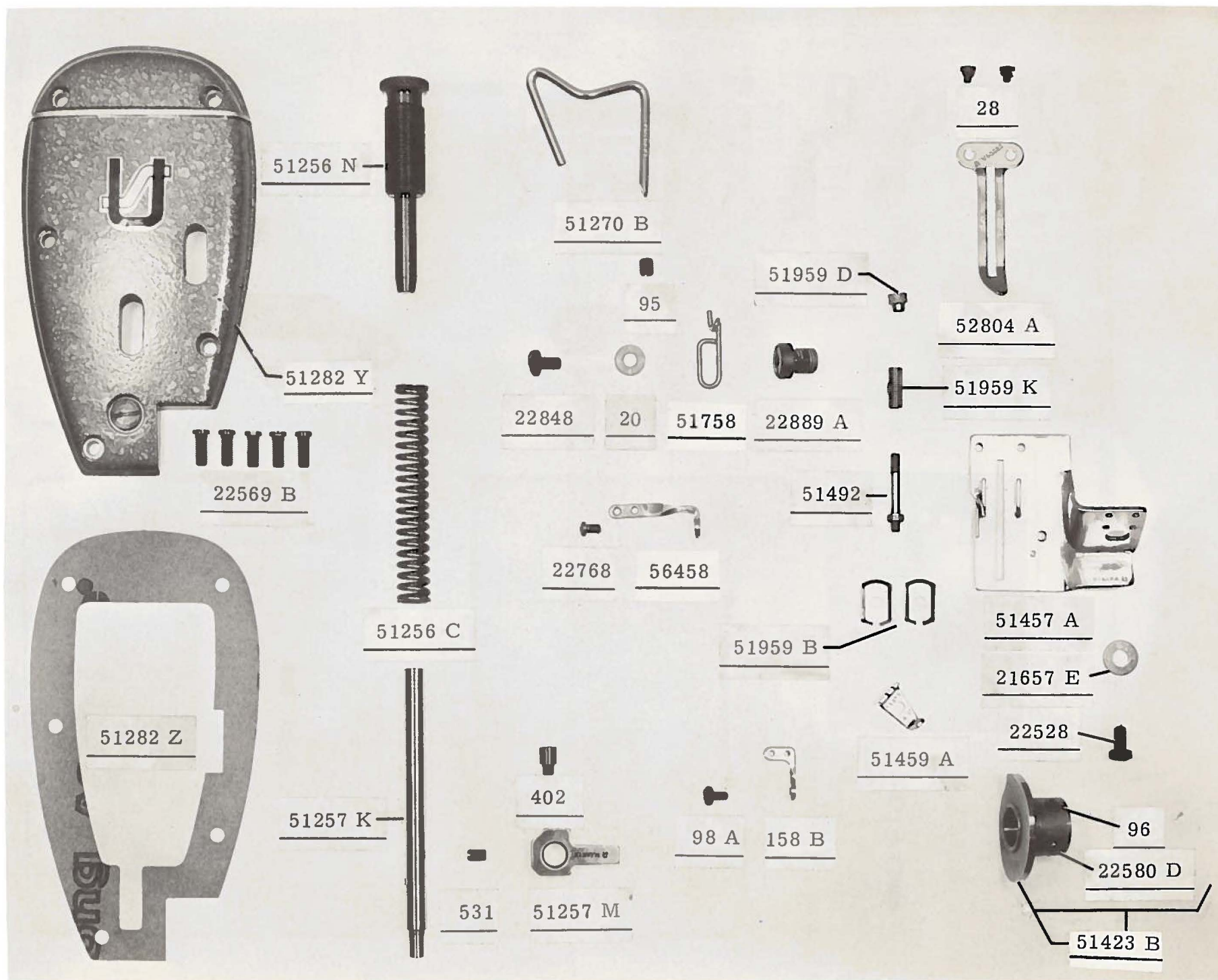
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51417 C-12

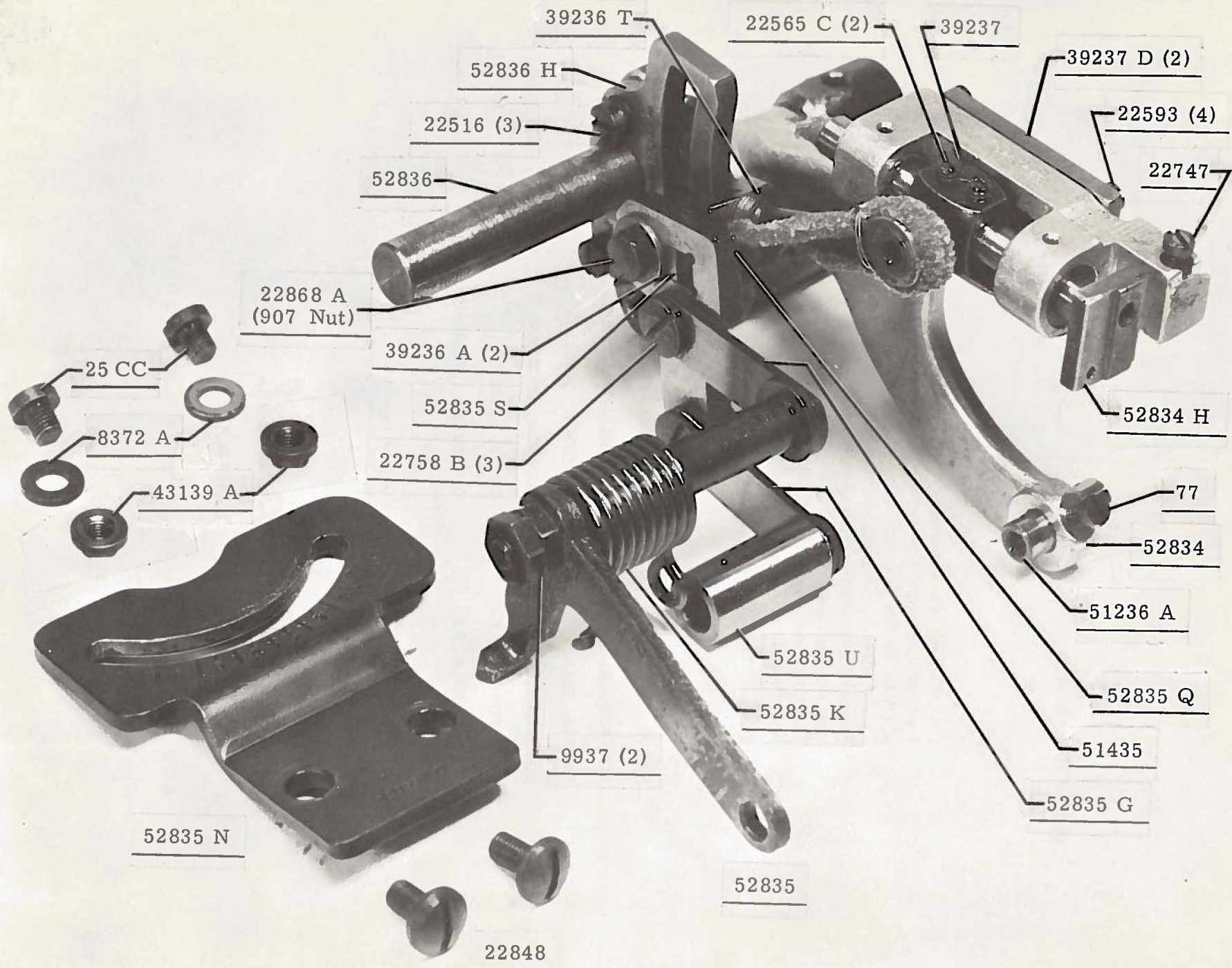
51417 C-16

50 J-16





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