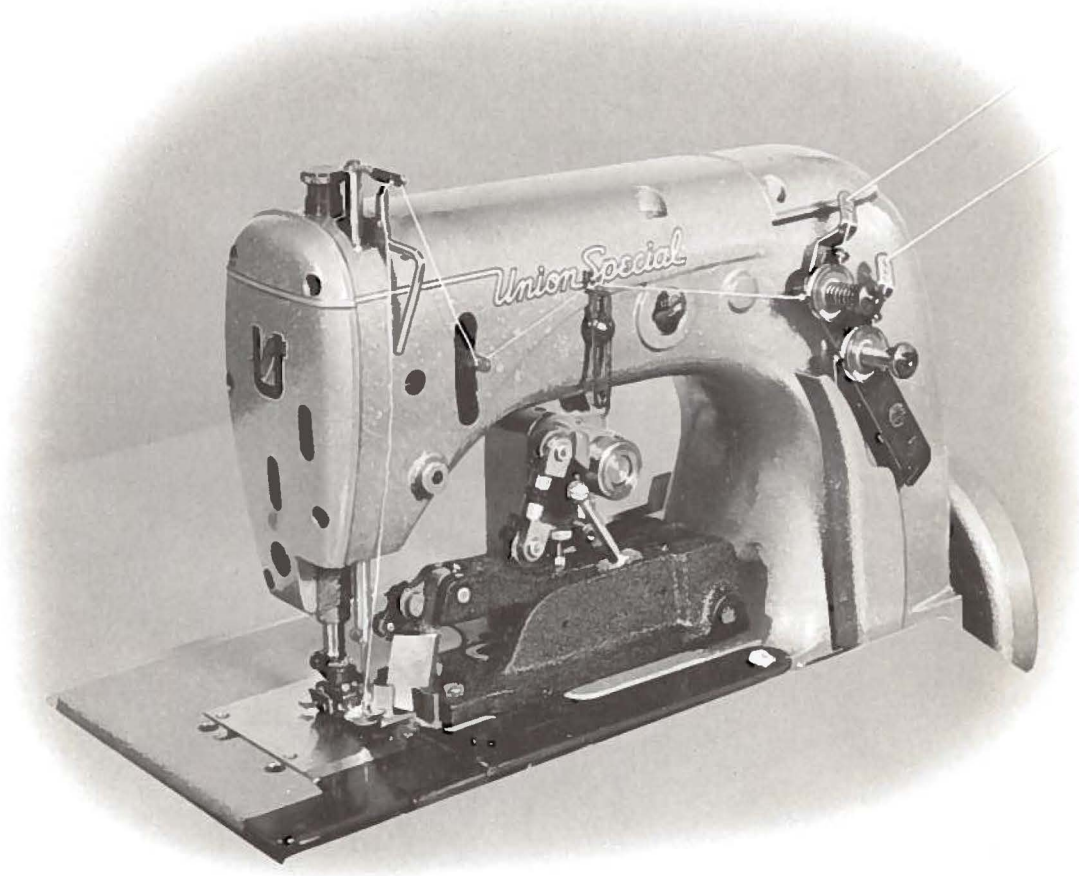


FINEST QUALITY

Union Special®
LEWIS • COLUMBIA

**INDUSTRIAL
SEWING
MACHINES**

**CLASS
54400**



**CATALOG
No.
102 M**

**LIST OF PARTS
FOR
STYLE 54400K**

Union Special **MACHINE COMPANY**

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

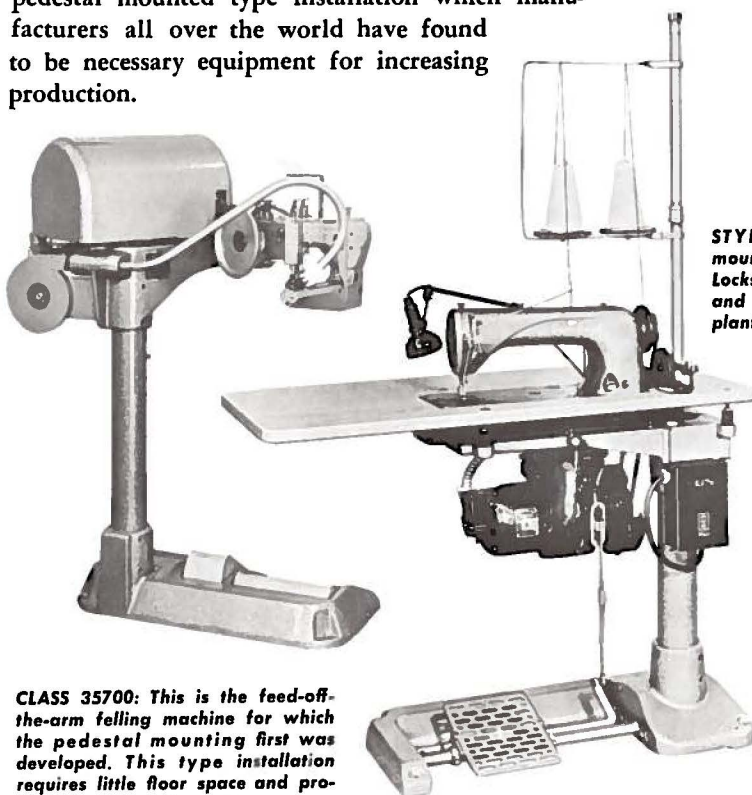
Aid Plant Layout! Boost Production!

PEDESTAL MOUNTED MACHINES

UNION SPECIAL'S pedestal mountings for sewing heads have offered a great many advantages to manufacturers ever since they were introduced as a revolutionary new type of mounting for feed-off-the-arm machines in Classes 35700 and 35800.

In the pedestal mounted type installation, the machine is completely isolated from the base and, where table boards are used, they are completely isolated from the pedestal and from the machine, which makes for smoother, quieter operation. In various cases, the motor may be mounted to the right or to the left under the machine handwheel. Mounting of the motor to the right provides maximum space under machine for the operator.

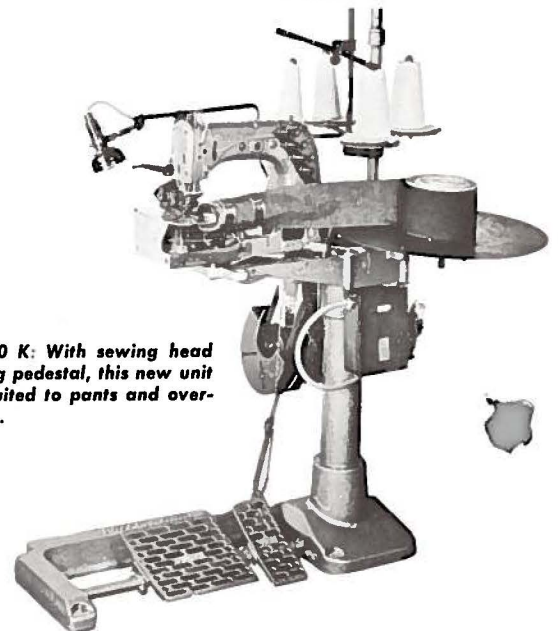
These new pedestals offer maximum flexibility, convenience, and adaptability to production lines, especially where variations in operation or garment styles are necessary from time to time. The foot treadles are adjustable laterally and the machine mounting bracket is adjustable vertically to suit the individual operator and to provide the most comfortable working position, thus reducing fatigue. The illustrations shown here are just a few of the many styles of machines that Union Special has to offer in the pedestal mounted type installation which manufacturers all over the world have found to be necessary equipment for increasing production.



CLASS 35700: This is the feed-off-the-arm felling machine for which the pedestal mounting first was developed. This type installation requires little floor space and provides large working area.

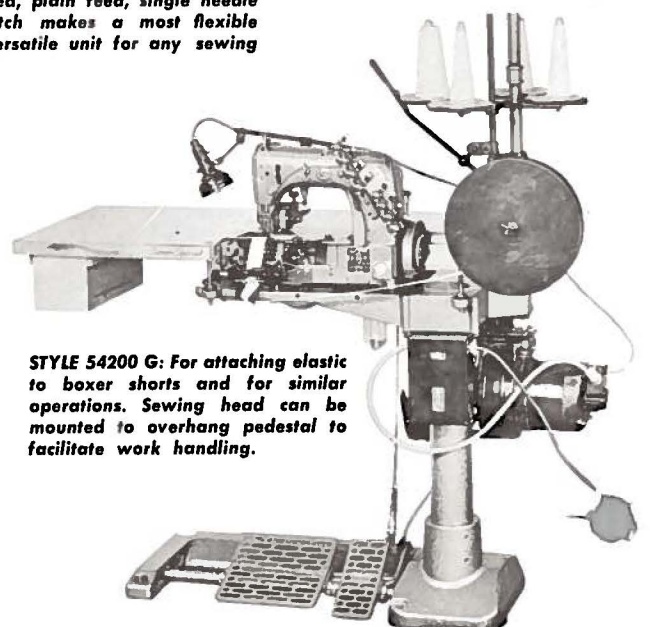


STYLE 52900 BH: For simultaneously seaming and overedging the in-seams and outseams of corduroy pants and similar articles.



STYLE 54200 K: With sewing head overhanging pedestal, this new unit is ideally suited to pants and over-all banding.

STYLE 61400 A: The pedestal mounted, plain feed, single needle Lockstitch makes a most flexible and versatile unit for any sewing plant.



STYLE 54200 G: For attaching elastic to boxer shorts and for similar operations. Sewing head can be mounted to overhang pedestal to facilitate work handling.

Catalog No. 102 M
(Supplement to Catalog No. 102 L)

LIST OF PARTS

CLASS 54400

Style

54400 K

The parts listed in this catalog are
furnished at list prices for repairs only.

First Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U.S.A.

IDENTIFICATION OF MACHINE

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 54400 K". 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 54400 KZ".

Styles of machines similar in construction are grouped under a class number which differs from the style number, in that it contains no letter. Example: "54400".

APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 102 L and should be used in conjunction therewith. Only parts found on Style 54400 K, but not on Style 54400 A or any of the other styles listed in Catalog No. 102 L, are illustrated. For clarity, some parts common to all machines are listed and other parts are shown in phantom to help locate the 54400 K parts. Opposite the illustrated page are listed each part by part number, description and amount required, which have been itemized by detail reference numbers.

This catalog applies specifically to the Standard style of machine as listed herein. It can also be applied with discretion, to some Special machines in this Class. References 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.

STYLE OF MACHINE

Streamlined Flat Bed, Low Throw, Single Needle Machine, With Looper Traveling in Line With Feed, Prepared With Pinking Attachment, Front Disposal of Trimmings, Light Weight Presser Bar, Light Weight Needle Bar and Needle Bar Driving Mechanism, Needle Bearing Needle Bar Drive, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump, Oil Pan Base Plate and Oil Siphon Assembly, Light Weight Pulley and Prepared for Oil Shield.

54400 K-3/16 For seaming and simultaneously pinking on women's street dresses, uniform dresses, slips, half slips, blouses, slacks, robes and similar garments made of light to medium weight material. Width of pink 3/16 inch. Seam specification 401-SSa-1.

54400 K-1/4 Same as Style 54400 K-3/16 except prepared for 1/4 inch width of pink and with parts furnished for 5/16 inch width of pink.

54400 K-3/8 Same as Style 54400 K-3/16 except prepared for 3/8 inch width of pink and with parts furnished for 1/2 inch width of pink.

54400 K-5/8 Same as Style 54400 K-3/16 except prepared for 5/8 inch width of pink and with parts furnished for 3/4 inch width of pink.

NOTE: Fraction denotes the width of pink, measured from centerline of needle to point of pinking knife.

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 blade measured in thousandths of an inch, midway between the shank and the eye. Collectively, the type number and the size number is the complete symbol.

Standard needle for Style 54400 K is Type 113 GS in size 036. It has a round shank, round point, extra short, double groove, struck groove, spiral groove, ball eye, spotted, chromium plated - sizes 029, 032, 036, 040, 044, 049, 054.

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 as follows: "1000 Needles, Type 113 GS, Size 036".

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

ORDERING REPAIR PARTS

This catalog has been arranged to simplify the ordering of repair parts. Exploded views of the 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 the listing of the parts with their part numbers, descriptions, and the number of pieces required in the particular view being shown.

The numbers in the first column are reference numbers only, and merely indicate the position of that part in the illustration. The reference number should never be used in ordering parts. Always use the part number listed in the second column.

In those cases where a part is common to all of 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.

IDENTIFYING PARTS

Where construction permits, each Union Special part is stamped with its catalog number. A part too small for its complete catalog stamping is identified by a letter symbol which distinguishes it from another part similar in appearance.

Each part number represents the same part regardless of catalog in which it appears.

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 by the use of 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 made with the utmost precision. Maximum efficiency and durability are assured.

USE GENUINE NEEDLES AND REPAIR PARTS (Continued)

Genuine needles are packaged with labels marked *Union Special*. Genuine repair parts are stamped with the familiar 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 f.o.b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

THREADING AND OILING

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 oil reservoir is 12 ounces.

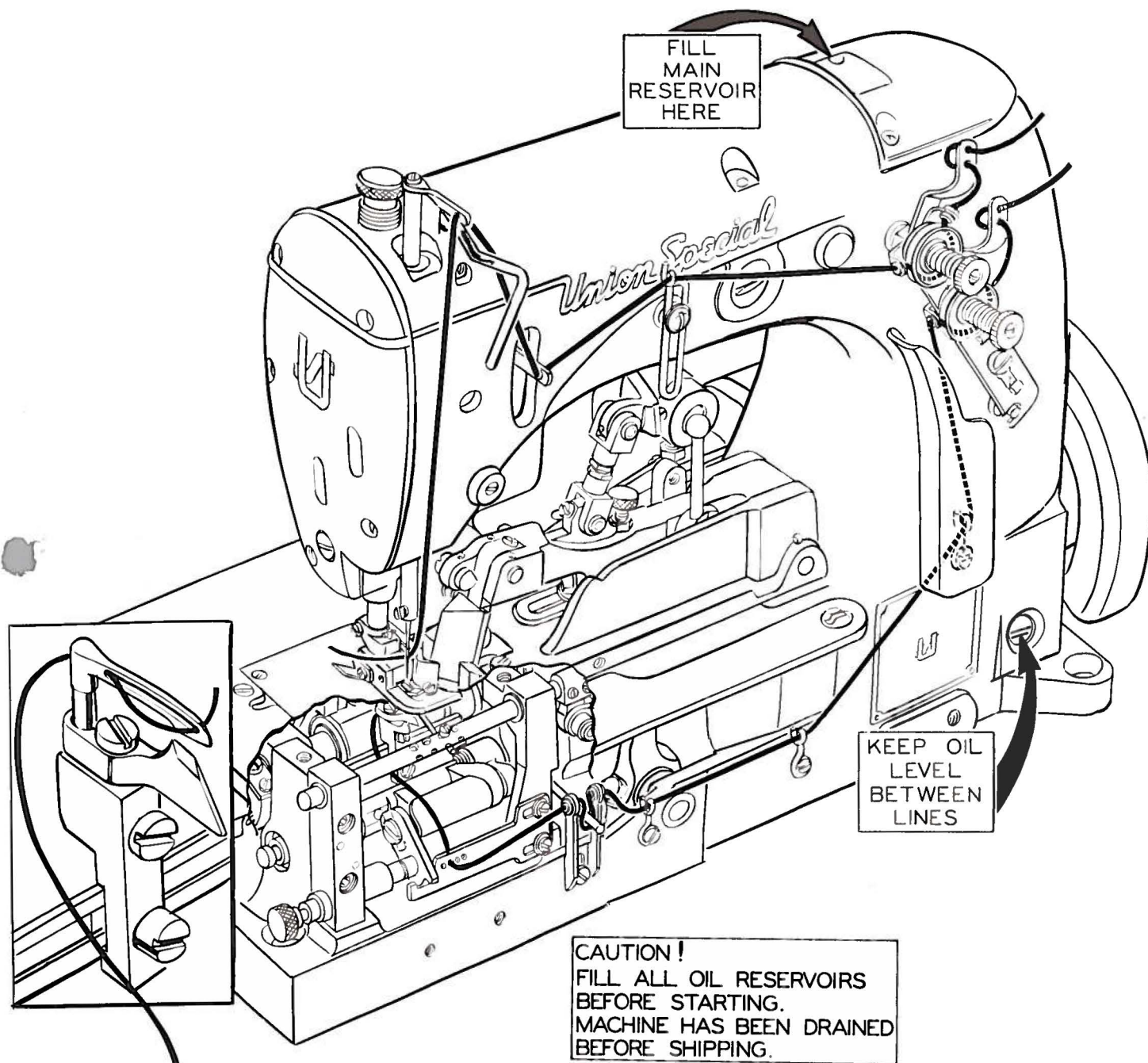
The machine is almost entirely automatically lubricated, and no oiling, other than an occasional drop of oil at both bearings of the retainer holder, the looper throw-out pin, and the looper holder frame locking pin, are required.

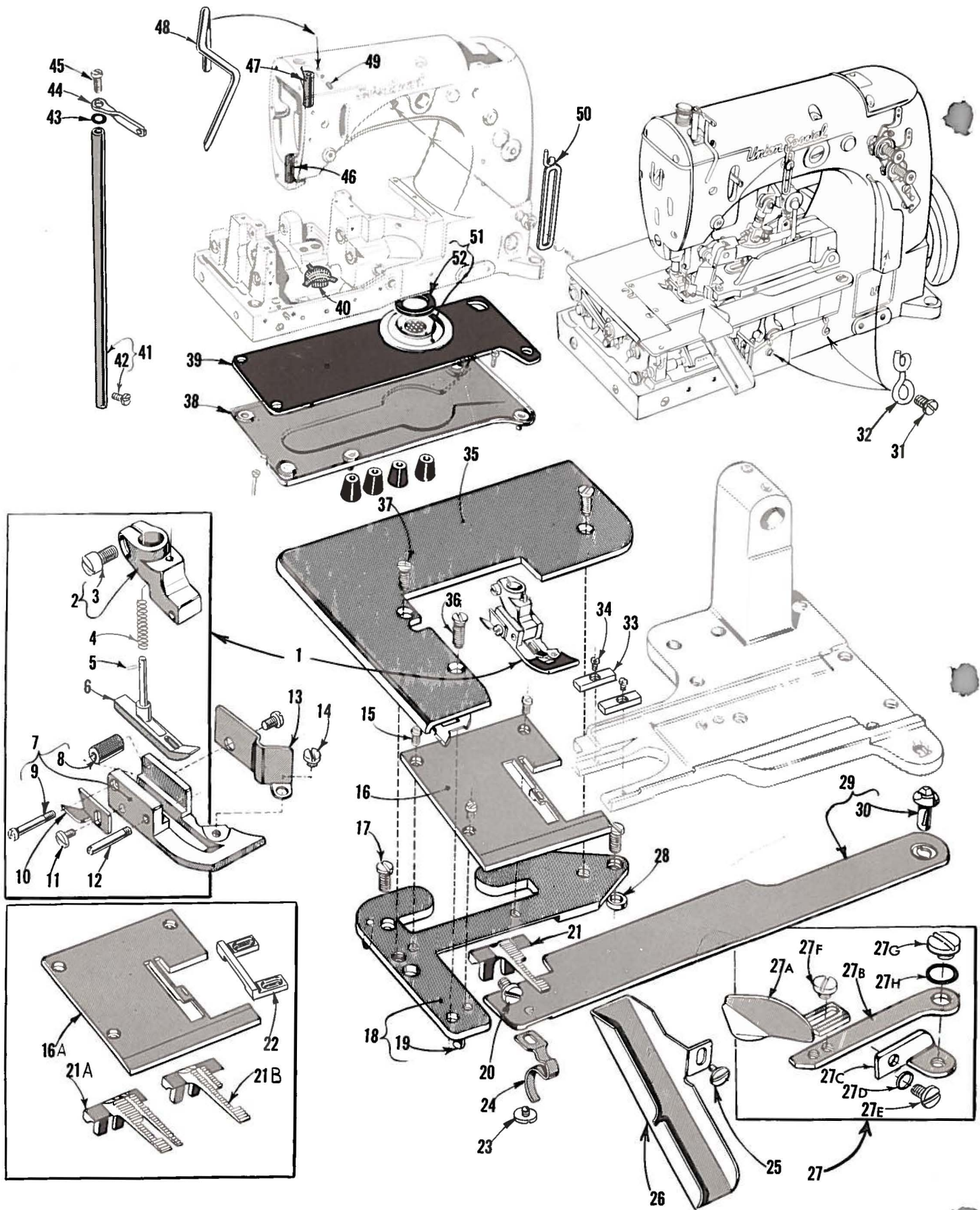
NOTE: All moving parts of the pinking attachment to be oiled once daily. Oil knife lever shaft front and rear, also oil two oil holes for lubricating both sides of lever bearings and knife holder shaft. Major pinker oiling points are marked in red on the attachment.

A daily check before the morning start should be made, to see that the level of the oil in the main reservoir is kept between the two red lines on the gauge. At this time, it may be well to manually oil the pinker and the other suggested points. 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.

On the next page is a diagram showing the manner in which the machine is threaded. Please note, that the needle is inserted in the needle bar with the eye in a plane at right angles to the direction of line of feed, the spot or scarf to the left, and is threaded from right to left. Also please note, that the looper is threaded from back to front.

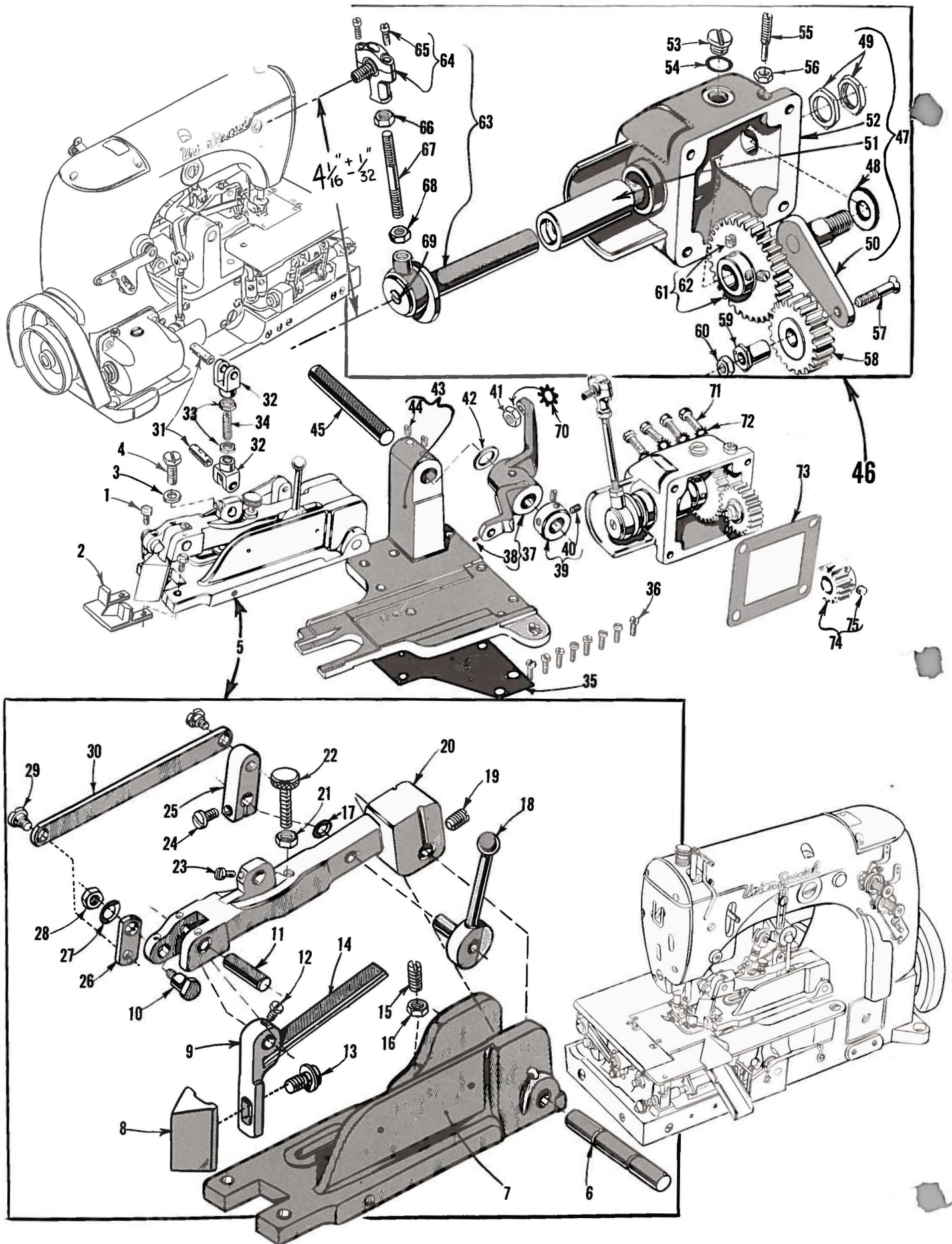
THREADING AND OILING DIAGRAM FOR STYLE 54400 K





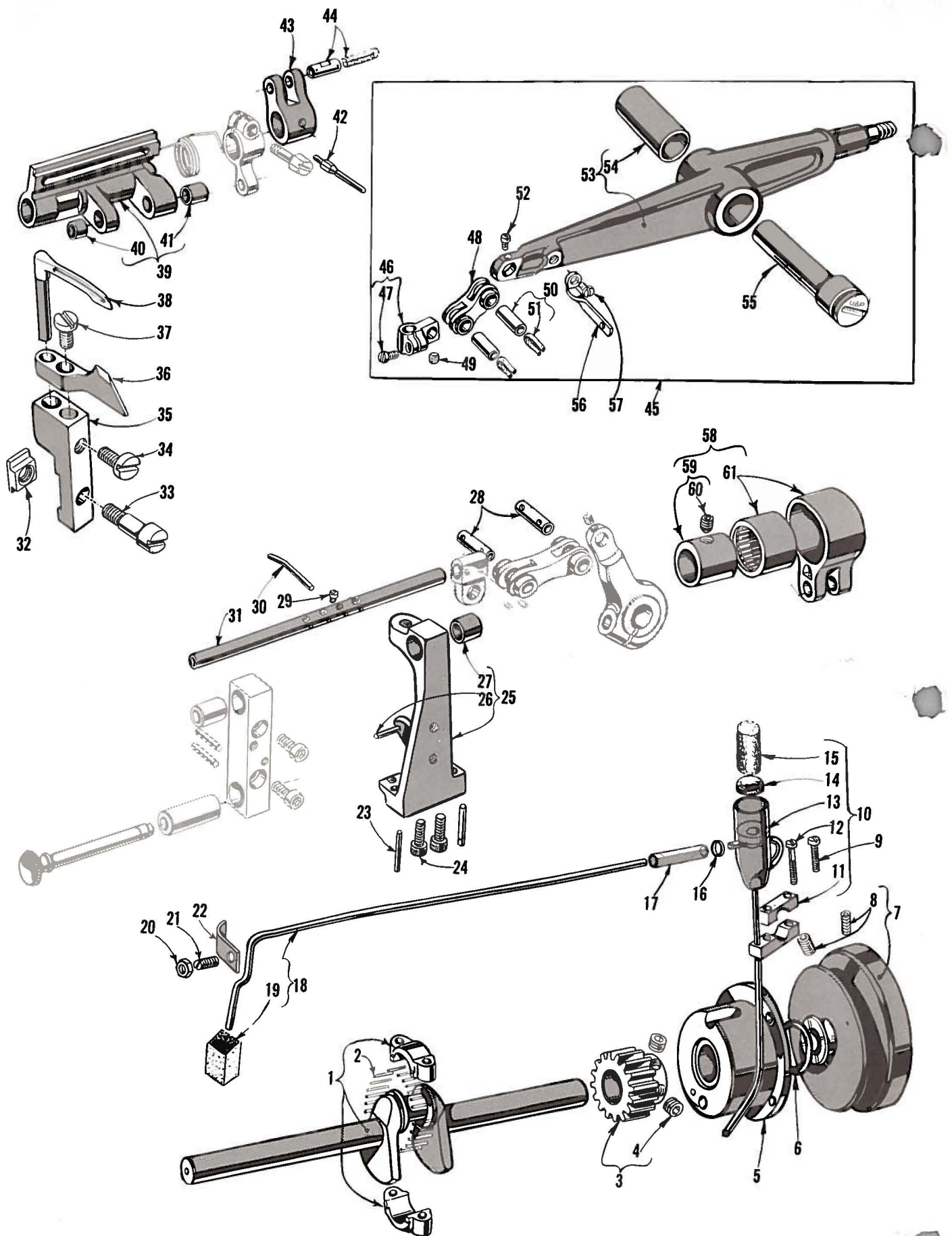
SEWING PARTS COMBINATIONS AND MISCELLANEOUS PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	54420 K-5/16	Presser Foot, for Styles 54400 K-3/16, 1/4 -----	1
	54420 K-3/4	Presser Foot, for Styles 54400 K-3/8, 5/8 -----	1
2	54430 A	Presser Foot Shank-----	1
3	91	Screw-----	1
4	35730 Y	Plunger Spring -----	1
5	54430 D	Pin -----	1
6	54430 B	Yielding Section -----	1
7	54430 K-5/16	Presser Foot Bottom, for presser foot No. 54420 K-5/16-----	1
	54430 K-3/4	Presser Foot Bottom, for presser foot No. 54420 K-3/4 -----	1
8	54430 C	Spacer -----	1
9	22734	Screw-----	1
10	52930 AC	Chain Cutter -----	1
11	604	Screw -----	1
12	22799 A	Hinge Screw -----	1
13	8-66	Presser Foot Guard, for Styles 54400 K-3/16, 1/4, 3/8 -----	1
	408-75	Presser Foot Guard, for Style 54400 K-5/8 (3/4 inch width of pink) ----	1
	408-79	Presser Foot Guard, for Style 54400 K-5/8 (5/8 inch width of pink) ----	1
14	22798	Screw -----	2
15	87	Screw -----	3
16	54424 K-3/4	Throat Plate, for Styles 54400 K-1/4, 3/8, 5/8 -----	1
16A	54424 K-3/16	Throat Plate, for Style 54400 K-3/16 -----	1
17	22839	Screw -----	2
18	54480	Throat Plate Support -----	1
19	51280 J	Dowel Pin -----	2
20	HA61 D	Screw, for feed dog -----	1
21	54405 K-5/16	Feed Dog, for Style 54400 K-1/4 -----	1
21A	54405 K-3/4	Feed Dog, for Styles 54400 K-3/8, 5/8 -----	1
21B	54405 K-3/16	Feed Dog, for Style 54400 K-3/16 -----	1
22	54484 N-5/8	Knife Spacer, for Style 54400 K-5/8 (5/8 inch width of pink) -----	1
	54484 N-3/4	Knife Spacer, for Style 54400 K-5/8 (3/4 inch width of pink) -----	1
23	12986 B	Screw -----	1
24	54264 C	Spring, with finger projection -----	1
25	22542	Screw -----	1
26	54478	Chip Chute -----	1
27	23441 M	Edge Guide Assembly -----	1
27A	475-68	Edge Guide -----	1
27B	99-143	Edge Guide Holder-----	1
27C	99-329	Holder -----	1
27D	21210 A	Washer-----	1
27E	810 L	Screw -----	1
27F	18-422	Screw -----	1
27G	18-353	Screw -----	1
27H	40-86	Washer-----	1
28	54480 A	Throat Plate Support Spacer -----	1
29	54484 J	Swinging Bracket -----	1
30	660-237	Spring Lock-----	1
31	98 A	Screw -----	3
32	52 A	Looper Thread Eyelet -----	3
33	54484 P	Knife Support Block -----	2
34	605	Screw -----	2
35	54401 B	Cloth Plate-----	1
36	22574	Screw -----	1
37	80	Screw -----	2
38	51493 AY	Oil Pan Base Plate-----	1
39	51493 BG	Base Plate Oil Pad, felt -----	1
40	51493 BK	Lint Filter Screen -----	1
41	54417 A	Needle Bar-----	1
42	22819	Screw -----	1
43	27-484 Blk.	Eyelet Lock Washer-----	1
44	51258 A	Needle Bar Eyelet -----	1
45	22768	Screw -----	1
46	51254 D	Needle Bar Bushing, lower -----	1
47	51254 C	Needle Bar Bushing, upper -----	1
48	51270 B	Needle Thread Take-up Wire-----	1
49	95	Screw -----	1
50	539	Frame Needle Thread Eyelet-----	1
51	51493 BH	Filter Cap Assembly -----	1
52	51493 BJ	Washer, sponge rubber -----	1



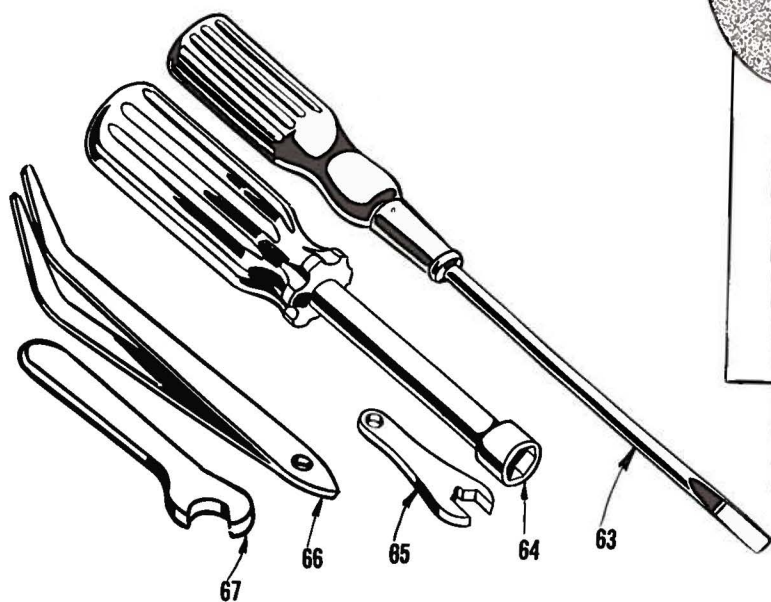
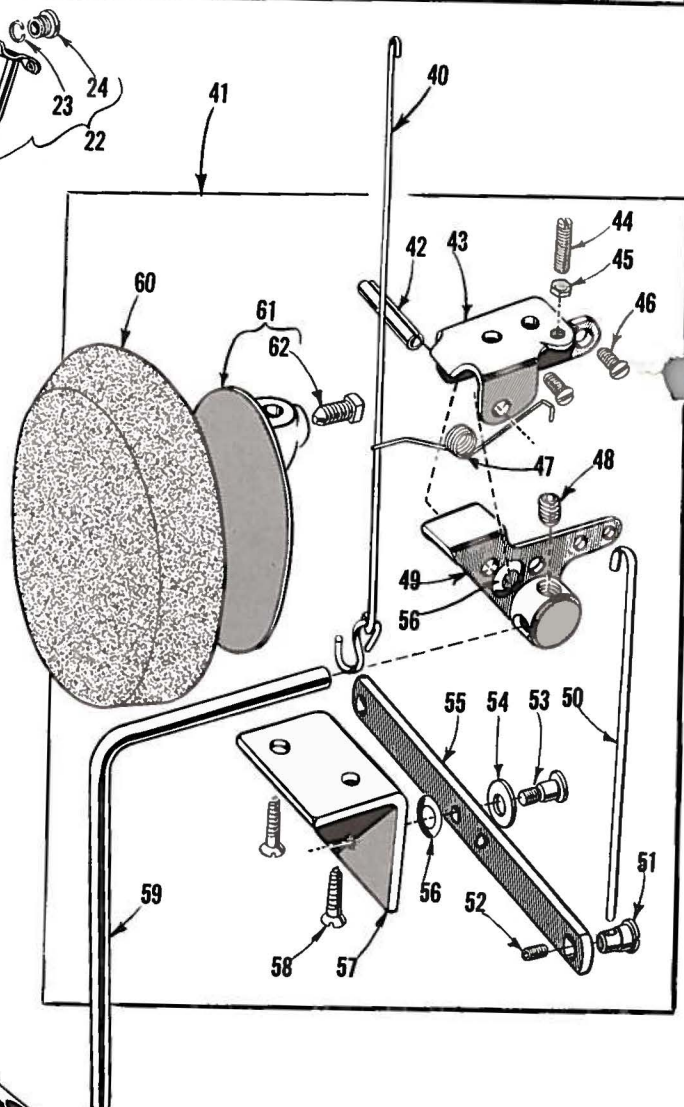
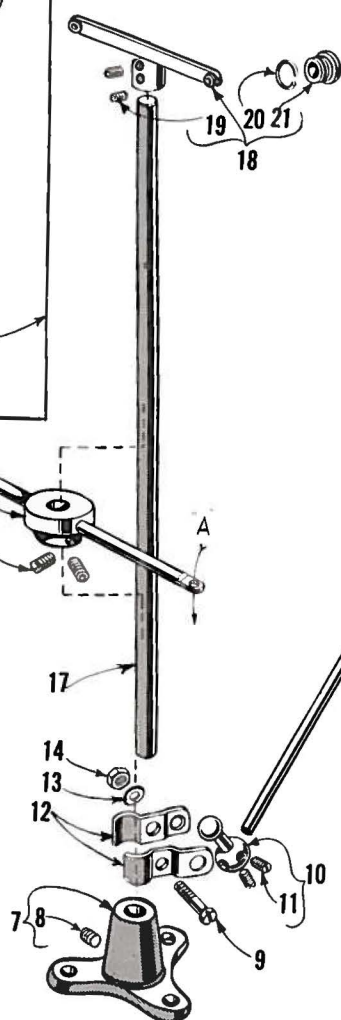
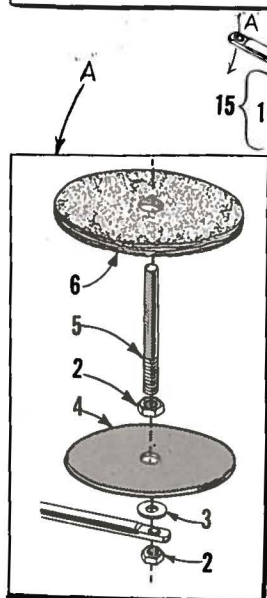
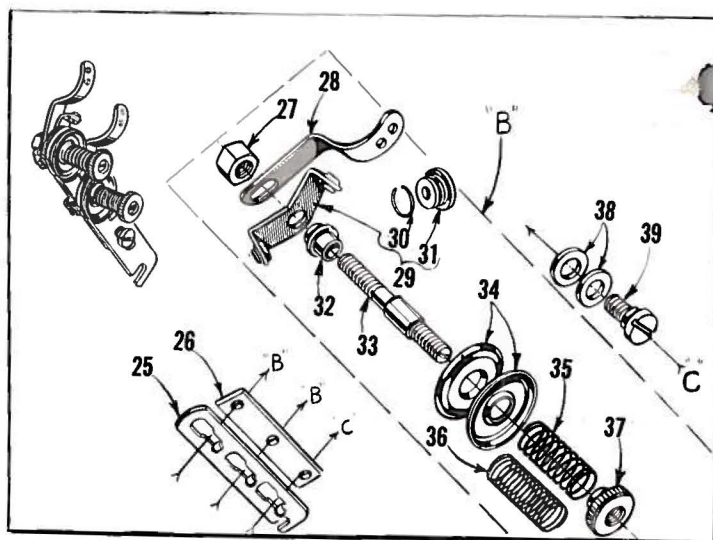
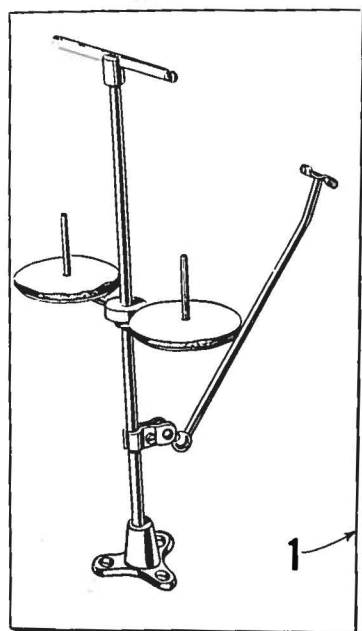
PINKER DRIVING PARTS AND PINKER ASSEMBLY

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	18-558	Screw, for lower pinker knife -----	2
2	119-24	Lower Pinker Knife, for Styles 54400 K-3/16, 1/4, 3/8-----	1
	119-34	Lower Pinker Knife, for Styles 54400 K-1/4 (5/16 inch width of pink, for Style 54400 K-3/8 (1/2 inch width of pink) and for Style 54400 K-5/8 (both 5/8 and 3/4 inch width of pink)-----	1
3	21657 E	Washer -----	1
4	627 A	Screw, for mounting pinker assembly -----	1
5	29482 A	Pinker Assembly -----	1
6	14-171	Shaft, for base -----	1
7	3-46	Pinker Base -----	1
8	119-25	Upper Pinker Knife -----	1
9	99-134	Upper Knife Holder -----	1
10	34-26	Upper Knife Cam Throw-out -----	1
11	14-172	Shaft, for upper knife holder -----	1
12	18-178	Screw, for upper knife holder shaft-----	1
13	18-544	Screw, for upper pinker knife-----	1
14	21-309	Knife Tension Spring, flat -----	2
15	18-547	Screw, for leveling base -----	1
16	1012 L	Nut -----	1
17	39536 AD	Spring Washer -----	1
18	76-18	Handle, for knife throw-out-----	1
19	1003 L	Screw, for base shaft -----	1
20	54484	Pinker Drive Lever-----	1
21	1160 L	Nut -----	1
22	18-844	Knife Tension Adjusting Screw -----	1
23	J87 J	Screw, for link pin -----	1
24	18-71	Screw, for throw-out lever -----	1
25	45-248	Throw-out Lever -----	1
26	45-249	Knife Throw-out Lever-----	1
27	40-101	Tension Washer, for upper knife cam throw-out -----	1
28	CS231	Nut -----	1
29	1776 L	Screw -----	2
30	46-108	Knife Throw-out Link -----	1
31	51236 A	Link Pin -----	2
32	53552 P	Connecting Clevis-----	2
33	15037 A	Nut-----	2
34	92201	Connecting Stud-----	1
35	52882 K	Gasket-----	1
36	22585 R	Screw -----	8
37	54484 H	Pinker Drive Lever -----	1
38	22797	Screw -----	1
39	35895 L	Collar -----	1
40	531	Screw -----	2
41	18	Nut-----	1
42	62295 A	Washer -----	1
43	54484 K	Pinker Base Plate -----	1
44	95	Screw -----	2
45	54484 G	Pinker Drive Lever Shaft -----	1
46	29480 DD	Pinker Gear Drive Housing Assembly -----	1
47	29476 LF	Housing, complete-----	1
48	652 P-36	Washer -----	1
49	39153 G	Nut -----	2
50	54484 F	Idler Gear Bracket -----	1
51	54484 B	Bushing -----	1
52	54484 A	Pinker Drive Housing-----	1
53	22733 B	Plug Screw-----	1
54	41394 A	Gasket -----	1
55	22791 G	Pin Screw -----	1
56	18	Nut-----	1
57	22888 A	Screw -----	1
58	54484 E	Idler Gear -----	1
59	53139 E	Eccentric Bushing -----	1
60	269	Nut -----	1
61	54484 D	Pinker Driving Shaft Gear -----	1
62	98	Screw-----	2
63	54484 M	Pinker Connecting Rod Assembly-----	1
64	52841 A	Ball Joint -----	1
65	22729 C	Screw -----	2
66	269	Nut, left thread -----	1
67	35741 A	Connecting Rod-----	1
68	18	Nut, right thread-----	1
69	22526	Screw-----	1
70	652 N-14	Lock Washer -----	1
71	627	Screw -----	4
72	652 N-14	Lock Washer -----	4
73	54484 R	Shim Gasket-----	1
74	53138 L	Main Shaft Gear -----	1
75	22894 X	Screw -----	2



CRANKSHAFT, NEEDLE LEVER, OIL SIPHON PARTS, LOOPER
AND LOOPER HOLDER PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	29476 HA	Crankshaft Assembly, .770 inch throw-----	1
2	51216 M	Needle Bearing-----	28
3	53138 L	Main Shaft Gear-----	1
4	22894 X	Screw-----	2
5	52891 B	Main Shaft Housing-----	1
6	660-202	Oil Seal Ring-----	1
7	52921 B	Pulley, for No. 1 "V" or round belt-----	1
8	22894 G	Screw-----	2
9	22729 A	Screw-----	1
10	51294 U	Oil Siphon Assembly-----	1
11	51294 K	Clamp, upper-----	1
12	22729 B	Screw-----	1
13	643-263	Siphon-----	1
14	666-209	Felt Plug-----	1
15	666-201	Felt Plug-----	1
16	21212	Locking Ring, for oil siphon connection-----	1
17	51294 N	Oil Tube Connection-----	1
18	51294 M	Oil Siphon Tube-----	1
19	666-214	Felt Lint Filter-----	1
20	7947	Nut-----	1
21	51294 R	Screw-----	1
22	51294 P	Oil Tube Clamp-----	1
23	667 B-12	Dowel Pin-----	2
24	22652 B-8	Screw-----	2
25	54242 DA	Retainer Holder Bearing, right-----	1
26	667 B-12	Dowel Pin-----	1
27	61354 A	Bushing-----	1
28	51134 V	Taper Pin-----	2
29	22845 B	Screw-----	1
30	54611	Retainer, marked "BS"-----	1
31	54242 B-4-21	Retainer Holder-----	1
32	54285 C	Nut, for looper holder-----	1
33	97 A	Screw-----	1
34	J87 J	Screw-----	1
35	54285 B	Looper Holder, marked "M"-----	1
36	54225	Needle Guard-----	1
37	22768	Screw-----	1
38	54208 A	Looper, marked "CB"-----	1
39	54244 P	Looper Holder Frame-----	1
40	54244 E	Bushing, left-----	1
41	54244 F	Bushing, right-----	1
42	54223 A	Looper Thread Take-up-----	1
43	54245 A	Looper Thread Take-up Driving Link-----	1
44	51236 A	Link Pin-----	1
45	29348 P	Needle Lever Assembly-----	1
46	51254 H	Needle Bar Connection-----	1
47	22562 A	Screw-----	1
48	54	Needle Bar Connection Link-----	1
49	78	Screw-----	1
50	51054	Link Pin-----	2
51	666-149	Felt Wick-----	1
52	77	Screw-----	1
53	51215 J	Needle Lever-----	1
54	51250 A	Needle Lever Bushing-----	1
55	51250 E	Needle Lever Stud-----	1
56	51258	Needle Lever Eyelet-----	1
57	22768	Screw-----	1
58	29476 KR	Feed Lift Eccentric Assembly-----	1
59	51406	Feed Lift Eccentric, .062 inch throw-----	1
60	22894 D	Spot Screw-----	1
61	54245 C	Eccentric Bearing-----	1



THREAD STAND, THREAD TENSION PARTS, KNEE PRESS
ASSEMBLY AND ACCESSORIES

Ref. No.	Part No.	Description	Amt. Req.
1	21101 H-2	Thread Stand, complete -----	1
2	258 A	Nut -----	4
3	652-16	Washer -----	2
4	21114	Spool Seat Disc -----	2
5	21114 W	Spool Pin-----	2
6	21104 V	Felt Pad -----	2
7	21114 A	Thread Stand Base -----	1
8	22651 CD-3	Screw -----	1
9	22810	Screw-----	1
10	21114 T	Lead Eyelet Socket Ball-----	1
11	22651 CD-4	Screw -----	2
12	21114 U	Lead Eyelet Ball Split Socket -----	2
13	652-16	Washer -----	1
14	21104 H	Nut -----	1
15	21114 D-2	Spool Seat Support-----	1
16	22651 CD-5	Screw -----	2
17	21104 B-24	Thread Stand Rod -----	1
18	21114 H-2	Eyelet Support -----	1
19	22651 CD-4	Screw -----	2
20	21114 M	Eyelet Locking Ring-----	2
21	21114 L	Eyelet -----	2
22	21114 S-2	Lead Eyelet -----	1
23	21114 M	Eyelet Locking Ring-----	2
24	21114 L	Eyelet -----	2
25	21657-3	Tension Disc Separator -----	1
26	52892	Tension Post Support -----	1
27	43266	Nut-----	1
28	51491 C	Lead-in Thread Guide-----	2
29	51292 D	Tension Thread Eyelet -----	2
30	21114 M	Eyelet Locking Ring -----	2
31	21114 L	Eyelet -----	2
32	51292 A	Tension Post Ferrule -----	2
33	51292 G	Tension Post-----	2
34	109	Tension Disc-----	4
35	51292 F-5	Tension Spring, needle-----	1
36	51292 F-2	Tension Spring, looper-----	1
37	51292 C	Tension Post Nut -----	2
38	80557	Spacing Washer -----	2
39	22598 C	Screw -----	1
40	51493 BC	Lifter Link -----	1
41	21660 H	Knee Press Assembly-----	1
42	660-219 G	Roll Pin-----	1
43	21664 F	Mounting Bracket -----	1
44	92201	Screw-----	1
45	12982	Nut -----	1
46	80	Screw, for attaching-----	2
47	21662 V	Torsion Spring-----	1
48	22650 CE-6	Screw-----	1
49	21662 R	Knee Press Lifter Arm -----	1
50	21662 T	Knee Press Link -----	1
51	21662 S	Knee Press Link Connection-----	1
52	22894 Z	Screw-----	1
53	22557 A	Screw-----	1
54	43137 E	Washer -----	1
55	21662 W	Knee Press Lever-----	1
56	39536 AD	Spring Washer -----	2
57	21664 C	Bracket -----	1
58		Wood Screw, flat head 1 inch long-----	2
59	21663 A	Knee Press Plate Lever -----	1
60	660-168	Knee Press Plate Cushion-----	1
61	21664	Knee Press Plate -----	1
62	69 FD	Screw -----	1
63	21202	Screw Driver, 3/16 inch round blade, length over-all 9 3/8 inches-----	1
64	21388 AU	Socket Wrench, for 3/8 inch hexagonal nuts -----	1
65	116	Wrench, single end, 9/32 inch opening-----	1
66	118 B	Thread Tweezer-----	1
67	21388	Wrench, single end, 3/8 inch opening-----	1
	35780 B	Lifter Lever Extension (not shown) -----	1
	258	Nut, for 35780 B (not shown)-----	2



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