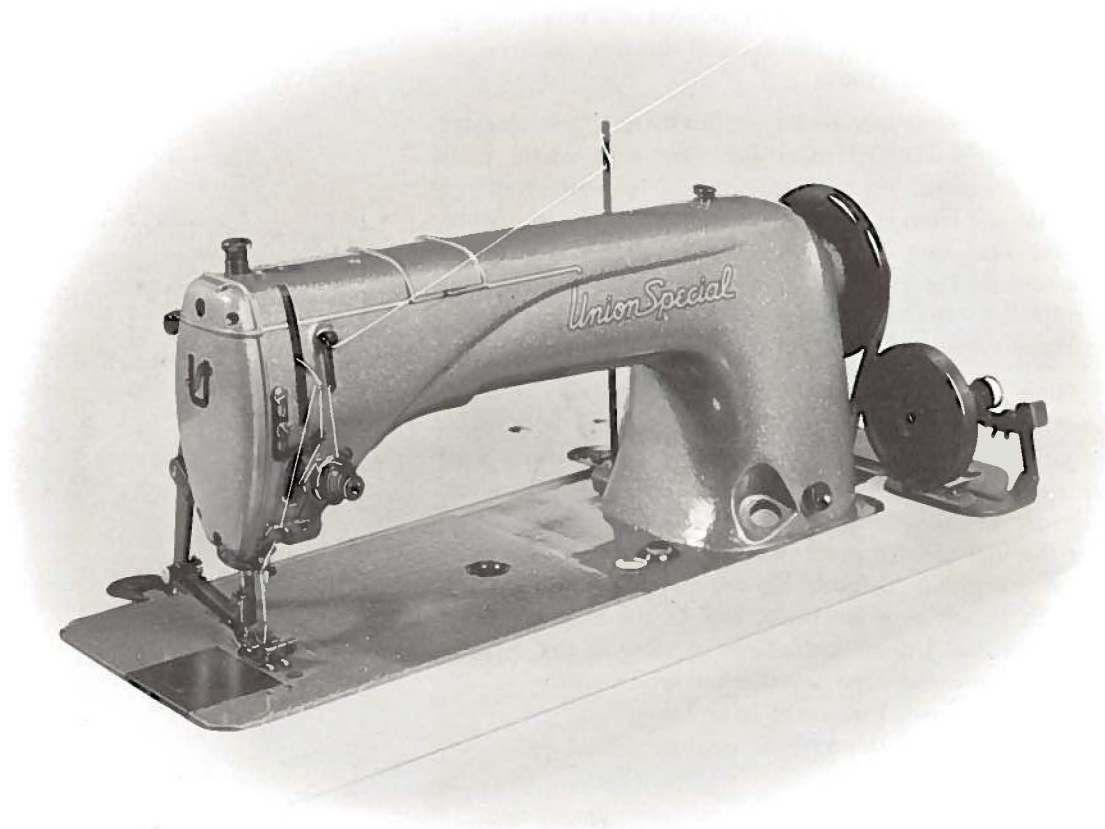


FINEST QUALITY

Union Special[®]
LEWIS • COLUMBIA

**INDUSTRIAL
SEWING
MACHINES**

**STYLE
61400AB**



CLASS 61400

STREAMLINED

HIGH SPEED LOCKSTITCH MACHINES

**CATALOG
No.
83AB**

Union Special **MACHINE COMPANY**

CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

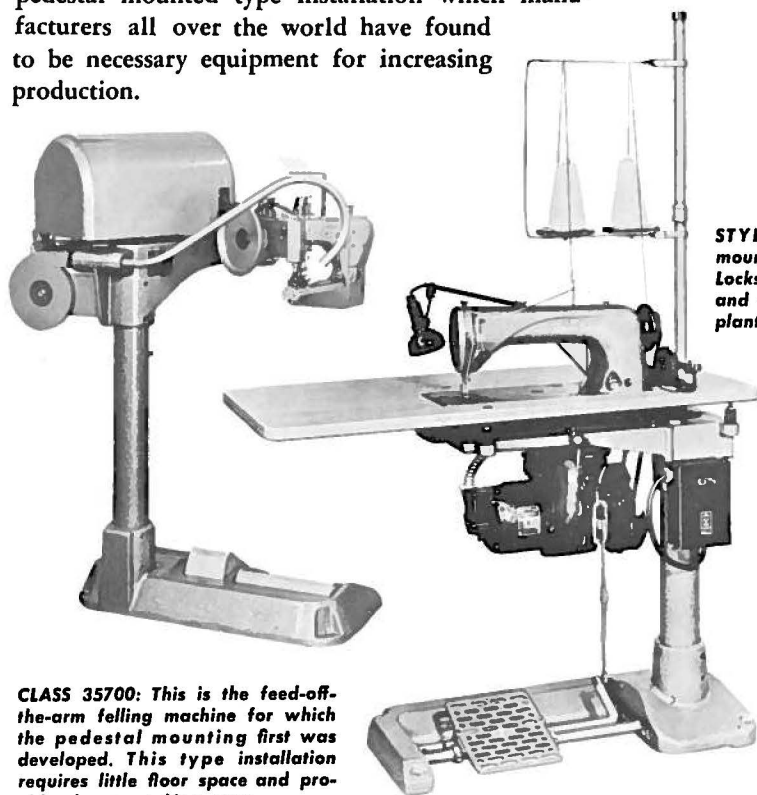
Aid Plant Layout! Boost Production!

PEDESTAL MOUNTED MACHINES

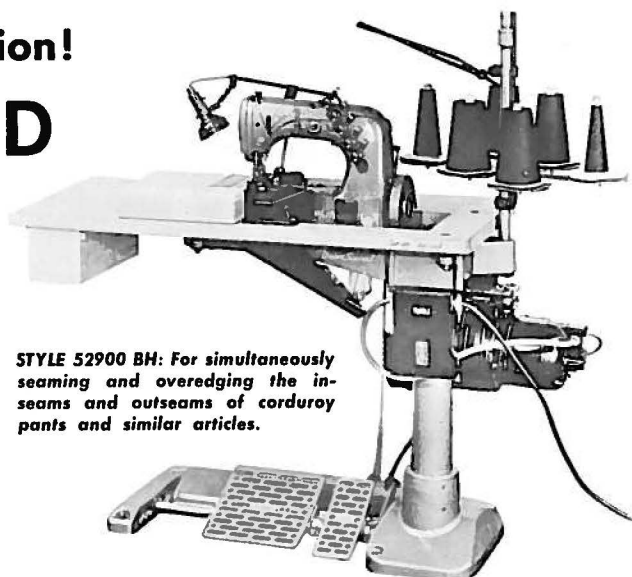
UNION SPECIAL'S pedestal mountings for sewing heads have offered a great many advantages to manufacturers ever since they were introduced as a revolutionary new type of mounting for feed-off-the-arm machines in Classes 35700 and 35800.

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.

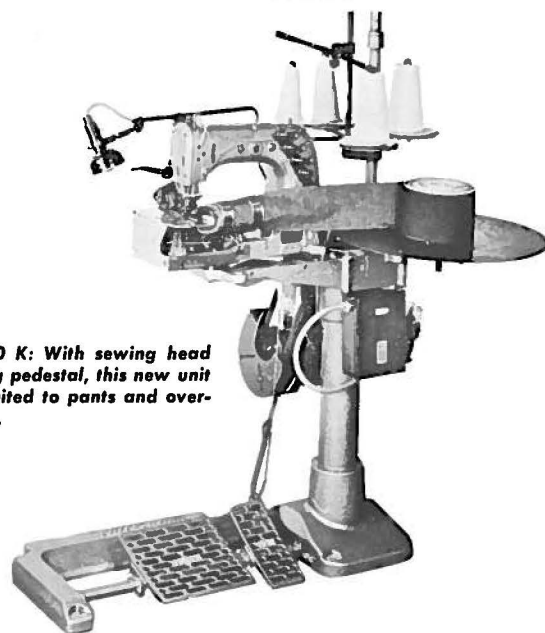
These new pedestals offer maximum flexibility, convenience, and adaptability to production lines, especially where variations in operation or garment styles are necessary from time to time. The foot treadles are adjustable laterally and the machine mounting bracket is adjustable vertically to suit the 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 tending machine for which the pedestal mounting first was developed. This type installation requires little floor space and provides large working area.

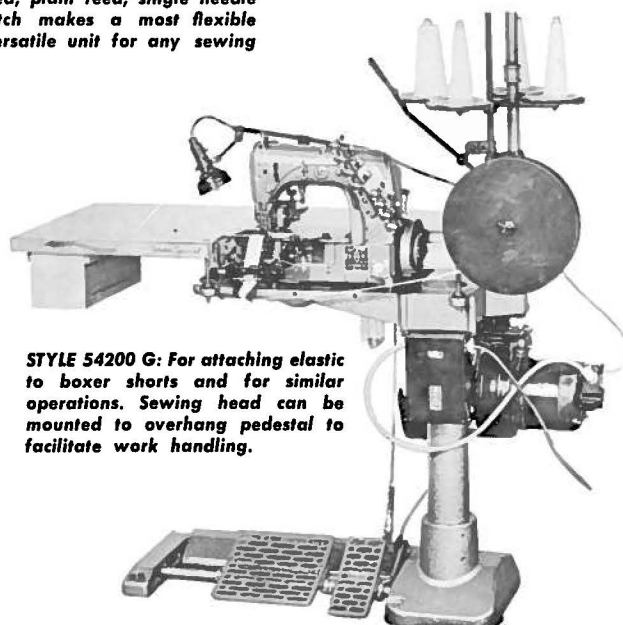


STYLE 52900 BH: For simultaneous seaming and overedging the in-seams and outseams of corduroy pants and similar articles.



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. 83 AB
(Supplement to Catalog No. 83 R)

INSTRUCTIONS
FOR
ADJUSTING AND OPERATING

LIST OF PARTS

CLASS 61400

Style
61400 AB

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 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 61400 AB". Special Style numbers contain the letter "Z". When only minor changes are made in a standard machine, a "Z" is suffixed to the standard Style number. Example: "Style 61400 ABZ".

Styles of machines similar in construction are grouped under a class number which differs from the style number, in that it contains no letters. Example: "61400".

APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 83 R and should be used in conjunction therewith. Only those parts which are used on Style 61400 AB and not on Style 61400 A are illustrated and listed at the back of the book.

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 the handwheel is toward the operator.

STYLE OF MACHINE

Streamlined Flat Bed Lockstitch Machine, Single Needle, Medium and Heavy Duty, Drop Feed, Top Driven "Grip-Feed", Rotary Hook, Horizontal Hook Shaft, Needle Bearing Adjustable Feed Eccentric, Stitch Length Indicator, Push Button Stitch Regulator for Bottom Feed, One Reservoir Enclosed Automatic Lubricating System for Main Driving Mechanism, Separate Reservoir for Automatic Lubrication of Rotary Hook Mechanism, Upper Left Head Mechanism Manually Lubricated, Head Oil Siphon Assembly, Maximum Work Space to Right of Needle Bar 11 3/8 Inches.

61400 AB For miscellaneous seaming operations on hard to handle materials, such as vinyls, foam laminates, wash and wear and materials made of natural fibers. Machine is fitted with top driven "Grip-Feed". Top and bottom feeds are independently adjustable.

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 across the eye. Collectively, the type number and the size number is the complete symbol.

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 180 GXS, Size 036".

The type numbers of the needles recommended for Style 61400 AB covered by this catalog are 180 GXS or 180 GYS. 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 description, and the sizes available, are listed below:

Type No.	Description and Sizes
180 GXS	Lockstitch, short length, ball eye, single groove, wide angle groove, struck groove, deep spot, ball point, chromium plated, sizes 028, 032, 036, 040, 044, 048, 054, 060.
180 GYS	Lockstitch, short length, ball eye, single groove, wide angle groove, struck groove, deep spot, chromium plated, sizes 028, 032, 036, 040, 044, 048, 054, 060.

NEEDLES (continued)

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.

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

ORDERING REPAIR PARTS

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

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.

Component parts of sub-assemblies, which can be furnished for repairs, are indicated by indenting their descriptions under the description of the main sub-assembly. Example:

19	29475 AJ	Bed Slide Assembly -----	1
19A	61902	Bed Slide -----	1
20	61273	Spring-----	1
21	91 A	Screw-----	2

IDENTIFYING PARTS

Where 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.

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 the postage and insurance.

LUBRICATION

Before starting to operate, be sure to remove the vent hole plug from the right side of the hook shaft gear case. This plug is used during shipment only, to prevent oil leakage through the vent hole. Then, lubricate machine thoroughly in accordance with instructions and run slowly for several minutes to distribute the oil to the various parts. Full speed operation can then be expected without damage.

RECOMMENDED OILS

Use a straight mineral oil of a Saybolt viscosity of 200 to 250 seconds at 100° Fahrenheit in hook oil reservoir, feed driving shaft gear case, and hook shaft gear case. This is equivalent to Union Special oil specification No. 83.

Stainless water white straight mineral oil of the same viscosity as that described in the preceding paragraph, can be used in the hook oil reservoir. The stainless oil is Union Special specification No. 86.

Oils conforming to specification No. 83 or No. 86 may also be used in the manually oiled places.

Fill main reservoir through the oil cup (C, Fig. 1) in the top of the machine. This oil level should be checked from time to time and kept between the lines on the gauge (D) in front of the machine.

With the needle bar at the top of its stroke, oil holes (A and B, Fig. 1) in the top of the machine twice daily.

The hook oil reservoir is drained when machine leaves factory and must be filled before starting to operate. It is filled at plug screw (E). Its level should be checked twice daily and kept between the lines of the gauge (F).

The hook shaft gear case is filled before shipment with a sufficient volume of oil to bring the level up to the plug screw hole (G, Fig. 2) in gear case cover when machine is tilted back against rest pin. Remove plug screw and check level of oil about every six months.

CAUTION! Do not use a compound oil in the hook oil reservoir, feeding drive shaft gear case, or hook shaft gear case, as these oils separate and froth.

Lubrication of the mechanism below the bed plate is automatically accomplished through the feed driving shaft which is tubular. Oil is introduced into the shaft at the gear end by means of an oil distributing plate (A, Fig. 3) which is secured to the large gear case cover (B) by means of two screws (C) and retaining block (D).

Should it ever become necessary to remove any of the parts from the gear case, it is imperative that the adjustment of the oil distributing plate be checked very carefully. This can be done by removing the large plug screw at right end of the gear housing and looking through the hole. The low point of the oil distributing plate must be even with or slightly below the center of the shaft (E) and just touching it. This is a very important adjustment, as the functioning of the automatic lubrication of the lower part of the machine depends upon it.

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.

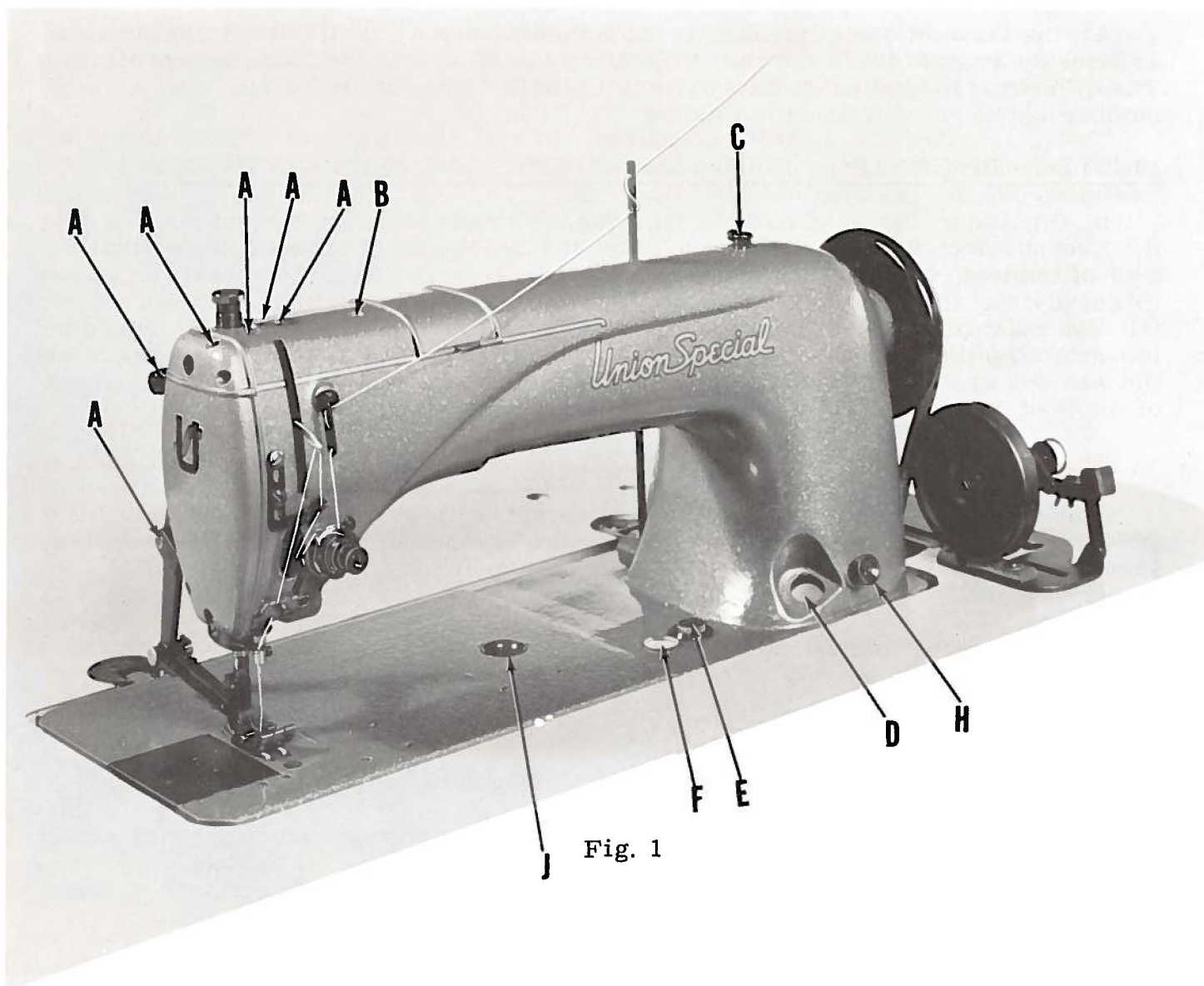


Fig. 1

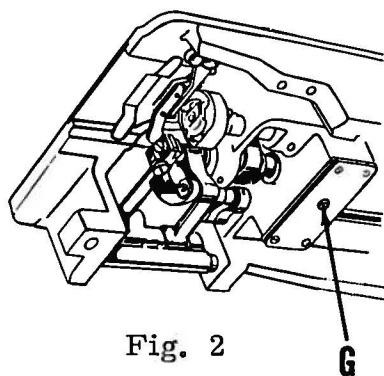


Fig. 2

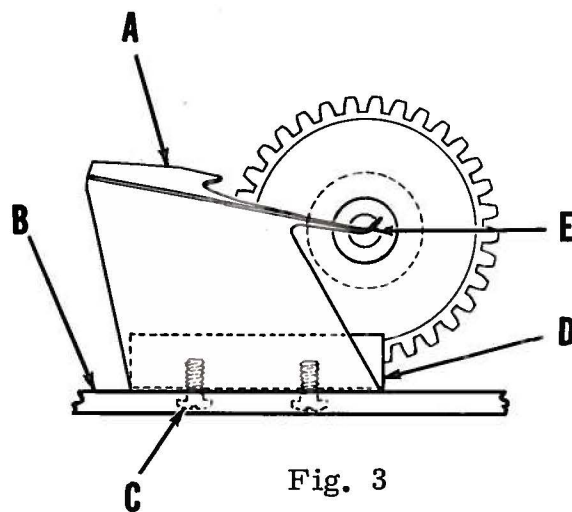


Fig. 3

MECHANIC'S INSTRUCTIONS

All the instructions pertaining to the adjustment of Style 61400 AB are the same as those for Style 61400 B covered by Catalog No. 83 R with the following exceptions. The differences, applicable only to Style 61400 AB are outlined below with the page number where each is found in Catalog No. 83 R.

FEED DOG HEIGHT (Page 18) should read ADJUSTING FEED MECHANISM

In regulating the height of the feed dog, it should be at its highest position and the presser foot resting directly against it. Set the height of feed dog so that the tips of the teeth are parallel with the throat plate as they begin to appear above the throat plate at the front of the feed dog travel and a maximum of 1/16 inch above at the high point of travel. The feed dog holder attaching screw (A, Fig. 17) should be loosened slightly, and regulating screw (B) should be turned either clockwise to raise the feed dog or counterclockwise to lower it. Make sure that the bottom of the shank of the feed dog holder rests against the head of regulating screw.

The feed dog can be tilted up or down as required by loosening screws (A and C).

Space the feed dog in the throat plate slots so that there is a clearance of at least 1/64 inch at all points and the rear teeth pass beyond the rear of the presser foot. Loosen feed dog holding screws (D) to space the feed dog, front to back or sideways in throat plate.

Adjust presser foot pressure for good feeding action (A, Fig. 12).

Set stitch to required length. Steps necessary to change stitch length are as follows:

- (a) Loosen lock screw (F, Fig. 24) for stitch regulator plunger.
- (b) Press plunger (H, Fig. 1) in firmly.
- (c) While holding plunger in, turn handwheel in operating direction until stitch regulator plunger lever is felt to drop into the slot of feed eccentric.
- (d) Continuing to hold the plunger in, turn handwheel in operating direction to increase the stitch length and in opposite direction to decrease the stitch length.
- (e) Release plunger and retighten lock screw.

NOTE: Comparative stitch lengths are indicated by the graduations in the indicator window (J) in bed plate, ranging from S (short) to L (long).

Open top cover in the head of the machine and loosen the "Grip-Feed" drive segment locking nut (A, Fig. 17A), and set connection (B) to point of shortest stitch length. This would locate the connection (B) at letter "A" (point C).

Loosen two set screws (D) on the "Grip-Feed" drive eccentric (E). Rotate the handwheel until the needle bar is at the top of its stroke. Rotate the eccentric (E) only, until the timing lines on the connection (B) and the eccentric hub (E) coincide. Tighten all screws.

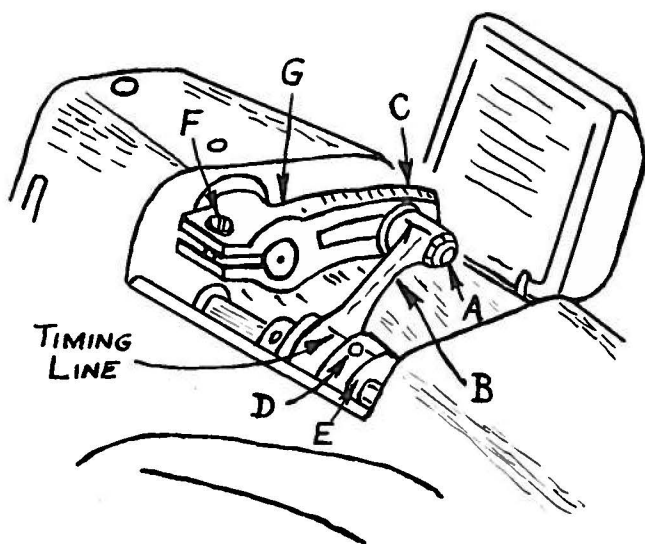


Fig. 17A

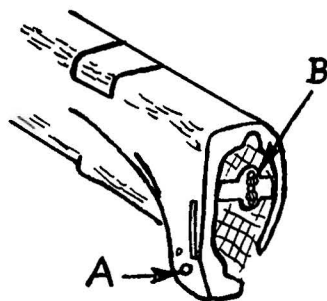


Fig. 17B

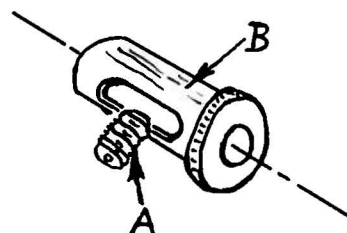


Fig. 17C

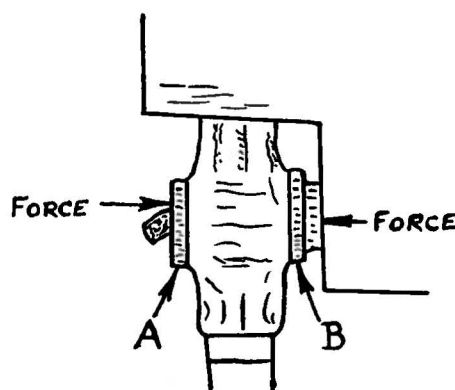


Fig. 17D

The needle should be in the center of the needle hole, left to right, located in the throat plate. If it is not, loosen the set screw (A, Fig. 17B) which holds the lower stud and adjustable bushing (B, Fig. 17C) in place.

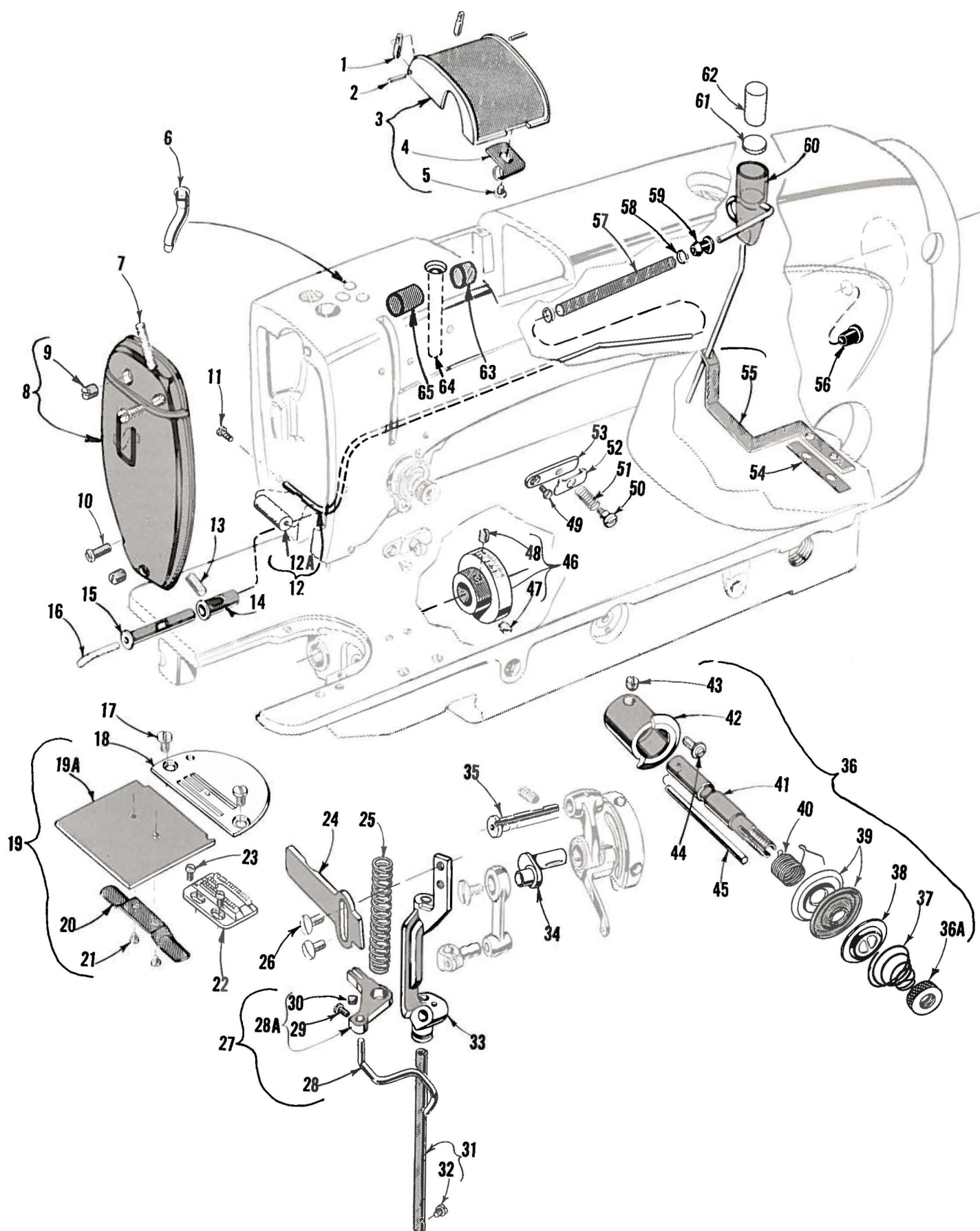
CAUTION! Do not loosen this screw more than necessary to remove stud from bushing, otherwise, the adjustable bushing may have to be relocated in order to assure that set screw will enter the screw slot in adjustable bushing and clamp on the stud (Fig. 17C).

Using the stud (A) and adjustable bushing (B) as thrust face (Fig. 17D), remove all side play from needle frame. Then, set needle bar frame clamp (B, Fig. 17B) so that the needle is centered laterally in the throat plate and there is no lateral motion in the needle bar frame. Make final check of needle location and tighten set screw (A, Fig. 17B) and needle bar frame clamp attaching screws (B, Fig. 17B).

CAUTION! Be sure set screw clamps on stud and not on bushing.

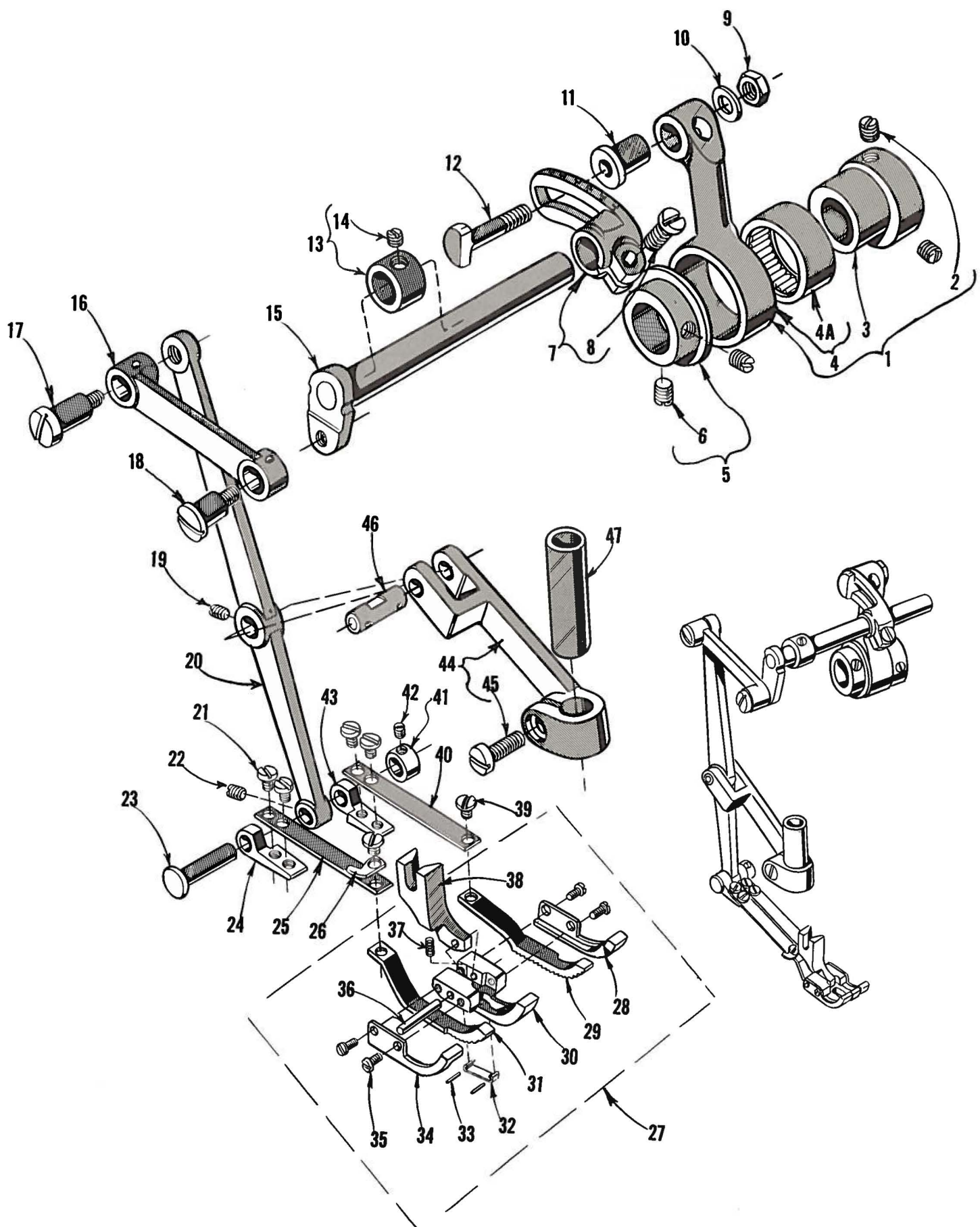
See that the presser foot hinges freely and that its under surface is in lateral alignment with the feed dog. Also, line up presser foot needle hole and check to be sure top feed prongs are directly over corresponding lower feed dog prongs.

Assemble top feed driving connections onto top feed drive lever with connecting pin 61485 G and collar 41061 C. Set the top and bottom feed dog with the back row of teeth point to point, in time and same travel (see paragraph on timing). Make sure the lower feed dog lifts the presser foot 1/32 inch at high point of travel.



MISCELLANEOUS PARTS FOR STYLE 61400 AB

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	61982 C	Top Cover Hinge -----	2
2	61982 D	Top Cover Hinge Pin-----	4
3	61982 B	Top Cover -----	1
4	62282 B	Spring -----	1
5	138	Screw-----	1
6	61993 D	Oil Tube, for needle bar and take-up lever -----	1
7	666-20	Oil Wick-----	1
8	61482 P	Head Cover -----	1
9	74 E	Screw-----	2
10	22569 B	Screw -----	2
11	22738	Screw -----	1
12	61994 B	Oil Siphon Tube -----	1
12A	666-174	Felt Wick -----	1
13	22894 E	Screw -----	1
14	61985 J	Needle Bar Frame Pivot Adjusting Bushing-----	1
15	61985 A	Needle Bar Frame Pivot Stud-----	1
16	666-173	Oil Wick-----	1
17	376	Screw -----	2
18	61324 D-063	Throat Plate -----	1
19	29475 AJ	Bed Slide Assembly-----	1
19A	61902	Bed Slide-----	1
20	61273	Spring -----	1
21	91 A	Screw-----	2
22	61405 AG	Feed Dog -----	1
23	22768	Screw -----	2
24	61485 A	Needle Bar Frame Clamp -----	1
25	61356	Presser Spring-----	1
26	88 D	Screw -----	2
27	29475 AP	Take-up Thread Wire Assembly-----	1
28	61953 A	Thread Take-up Wire-----	1
28A	61958	Presser Bar Guide -----	1
29	22768 B	Screw -----	1
30	22894 W	Set Screw -----	1
31	61917	Needle Bar -----	1
32	22768 A	Screw-----	1
33	61485	Needle Bar Frame-----	1
34	61952	Take-up Lever Crank Pin -----	1
35	61451 B	Take-up Lever Pin -----	1
36	29475 AA	Tension Assembly -----	1
36A	61292 C	Tension Regulating Nut -----	1
37	61392 F-14	Tension Spring-----	1
38	61292 H	Tension Release Washer -----	1
39	109	Tension Disc -----	2
40	61453	Take-up Spring -----	1
41	61492	Tension Post -----	1
42	61492 A	Tension Post Socket -----	1
43	89	Spot Screw -----	1
44	22863 B	Adjusting Screw -----	1
45	61292 G	Tension Release Pin -----	1
46	61949	Stitch Length Indicator -----	1
47	96	Spot Screw -----	1
48	95	Set Screw -----	1
49	22564 B	Screw -----	1
50	57 WD	Screw -----	1
51	15438 C	Nipper Spring -----	1
52	57 WB	Nipper Plate -----	1
53	62271 F	Nipper Base -----	1
54	61394 R	Gasket -----	1
55	61994 A	Oil Siphon Bracket-----	1
56	63494 B	Plug Plastic -----	1
57	51294 N	Oil Siphon Connection -----	1
58	21212	Oil Siphon Connection Locking Ring-----	2
59	61494 N	Priming Tube Grommet -----	1
60	61994	Oil Siphon -----	1
61	666-209	Felt Disc -----	1
62	666-201	Felt Plug -----	1
63	61985 H	Needle Bar Frame Shaft Bushing, right -----	1
64	61993 B	Oil Tube, for upper left main shaft bushing-----	1
65	61985 G	Needle Bar Frame Shaft Bushing, left -----	1
	666-213	Head Oil Attraction Felt (not shown) -----	1



PRESSER FOOT AND GRIP FEED DRIVE MECHANISM

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	29126 CZ	Needle Frame Drive Eccentric Assembly -----	1
2	95	Screw -----	2
3	61984	Eccentric (.136 inch throw) -----	1
4	61984 B	Driving Eccentric Connection -----	1
4A	660-226	Needle Bearing-----	1
5	61984 A	Needle Bearing Retaining Collar -----	1
6	95	Screw -----	2
7	61985 F	Rocker Shaft Driving Lever -----	1
8	22839	Screw -----	1
9	18	Nut -----	1
10	20	Washer -----	1
11	60038 G	Bearing Sleeve-----	1
12	61984 C	Needle Feed Drive Eccentric Connection Stud -----	1
13	51773	Collar -----	1
14	88 B	Screw -----	1
15	61985 B	Needle Bar Frame Rock Shaft -----	1
16	61485 C	Feed Driving Connecting Rod -----	1
17	22504 F	Screw-----	1
18	22504 E	Screw-----	1
19	22565 C	Screw-----	1
20	61485 D	Top Feed Drive Lever -----	1
21	28	Screw-----	4
22	22565 C	Screw-----	1
23	61485 G	Connecting Pin-----	1
24	61485 E	Top Feed Driving Connection, left -----	1
25	61485 H	Top Feed Drive Connection-----	1
26	51330 S	Chain Cutter-----	1
27	61420 CG	Presser Foot, complete -----	1
28	61430 BR	Presser Foot Feeding Section Guide, right ----	1
29	61430 BN	Presser Foot Feeding Section, right -----	1
30	61430 BK	Presser Foot Bottom-----	1
31	61430 BM	Presser Foot Feeding Section, left -----	1
32	61430 BS	Yielding Section -----	1
33	.031 dia. x 1/4	Drill Rod -----	2
34	61430 BP	Presser Foot Feeding Section Guide, left-----	1
35	22738	Screw -----	4
36	.092 dia. x 5/8	Drill Rod -----	1
37	61430 BT	Spring -----	1
38	61430 BL	Presser Foot Shank -----	1
39	22561	Screw-----	2
40	61485 H	Top Feed Drive Connection-----	1
41	41061 C	Connecting Pin Collar -----	1
42	HA73 B	Screw-----	1
43	61485 F	Top Feed Driving Connection, right -----	1
44	61485 B	Drive Mounting Bracket-----	1
45	22596	Screw -----	1
46	51236 A	Pin -----	1
47	61457 G	Presser Bar Bushing, lower -----	1



FINEST QUALITY

Union Special®

LEWIS and COLUMBIA

INDUSTRIAL SEWING MACHINES



SALES OFFICES AND REPRESENTATIVES

†Handle Union Special and Columbia only.

†Handle Lewis and Columbia only.

All others handle Union Special, Lewis and Columbia with certain exceptions.

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ARKANSAS, LITTLE ROCK, P.O. Box 1783, James T. Taylor, Tel. (501) FR 2-2356.

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†MASSACHUSETTS, TAUNTON, P.O. Box #2 Raynham, Walter P. Godek, Tel. VanDyke 2-6149.

MICHIGAN, DETROIT, John Joyce, Tel. 584-4210.

MINNESOTA, MINNEAPOLIS, 2800 Texas Ave., St. Louis Park 26, Minn., Leonard W. Koehler, Tel. 644-6236.

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MISSISSIPPI, TUPELO, 606 Racove Drive, Bill Haywood, Tel. VI 2-5848.

†MISSOURI, KANSAS CITY 5, Textile Machinery Co., 915 Broadway, Tel. Victor 2-9558.

MISSOURI, ST. LOUIS 34, 9860 Guthrie Ave., Carl E. McLaughlin, Tel. Chestnut 1-2368, 3940 Shenandoah St., Jerry Hicks.

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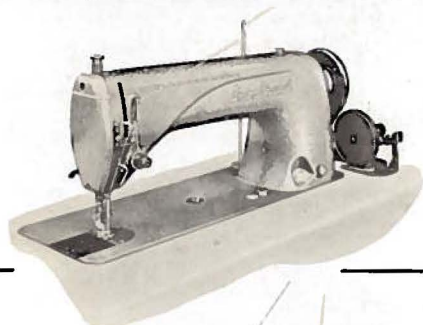
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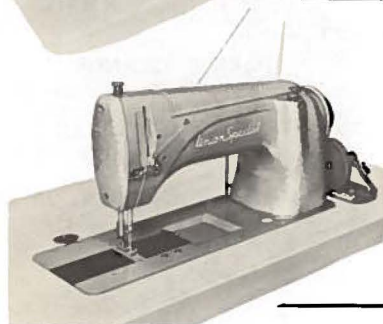
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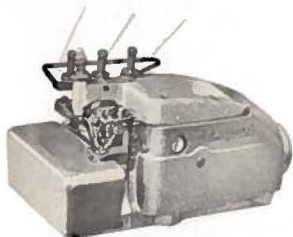
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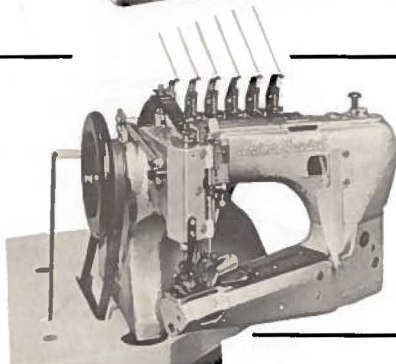
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