

**FIRST  
EDITION**



*Union Special*<sup>®</sup>  
INDUSTRIAL SEWING EQUIPMENT

**CATALOG NO. T118 H**

---

---

**STYLES**

**36200 H**

**36200 J**

**36200 AH**

**36200 AJ**

---

---

**HIGH SPEED CYLINDER FLATSEAMER  
MACHINES**



Catalog No. T118 H  
(Supplement To Catalog No. 118L)

INSTRUCTIONS

FOR

ADJUSTING AND OPERATING

LIST OF PARTS

STYLES

36200 H	36200 AH
36200 J	36200 AJ

First Edition

© 1977

by

Union Special Corporation  
Rights Reserved in All Countries

**UNION SPECIAL CORPORATION**

INDUSTRIAL SEWING MACHINES

**CHICAGO**

Printed in U. S. A.

April, 1980

## IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine is identified by a Style number which is stamped into the name plate on the machine. Style numbers are classified as standard and special. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 36200 H". Special Style numbers contain the letter "Z". When only minor changes are made in a standard machine, a "Z" is suffixed to the standard Style number. Example: "Style 36200 HZ".

Styles of machines similar in construction are grouped under a Class number, which differs from the Style number in that it contains no letters. Example: "Class 36200".

## APPLICATION OF CATALOG

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

## STYLES OF MACHINES

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

36200 H LAP-SEAMER. Six threads for simultaneously trimming and lap seaming on men's briefs. For closing the crotch seam on men's knitted briefs, when the added strength of a reinforced seam is required. The right section is raised .050 inch (1.27 mm) which helps prevent uneven or "peaks" when sewing on and off the leg binding. Seam Specification 607-LSa-1. Maximum recommended speed 4200 R.P.M.

36200 J FLATSEAMER. Six threads for simultaneously trimming and flatseaming knit undergarments, infants' clothing, corsets, girdles, and similar knitted light to medium weight garments where seaming and closing elastic is necessary. Fitted with sewing components that produce a seam .236 inch (6 mm) wide, .032 inch (.813 mm) wider than on other 36200 styles. Seam Specification 607 FSA-1. Maximum recommended speed 4200 R.P.M.

36200 AH Same as Style 36200 H, except prepared for Pedestal Installation.

36200 AJ Same as Style 36200 J, except prepared for Pedestal Installation.

## NEEDLES

Each UNION SPECIAL needle has both a type number 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 the largest diameter of the blade, measured in thousandths of an inch midway between the shank and the eye. Collectively, the type number and size number represent the complete symbol, which is given on the label of all needles packaged and sold by Union Special.

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

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

Standard needle for Styles 36200 H, J, AH and AJ is Type 118 GKS-075/029. It has a round shank, round point, extra short, double groove, struck groove, spotted, .060 inch (1.52 mm) diameter shank, chromium plated, and is available in sizes 070/027, 075/029, 080/032.

To have needle orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. Use description on label. A complete order would read: "1000 Needles, Type 118 GAS, Size 075/029".

### USE GENUINE NEEDLES AND REPAIR PARTS

Success in the operation of these machines can be secured only with genuine UNION SPECIAL Needles and Repair Parts as furnished by the Union Special Corporation, 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, U S Emblem. Each trademark is your guarantee of the highest quality in materials and workmanship.

### TERMS

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

## THREADING AND OILING INFORMATION

### VIEWS AA and BB:

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

### VIEW CC:

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

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

### VIEW DD:

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

### VIEW EE:

Close-up of needle thread sequence.

## OILING

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

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

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

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



## INSTRUCTIONS FOR SEWING ADJUSTMENTS

In addition to the "INSTRUCTIONS FOR SEWING ADJUSTMENTS" covered in Catalog No. 118 L, the following instructions will apply to the Styles 36200 H and AH covered in this supplement catalog.

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

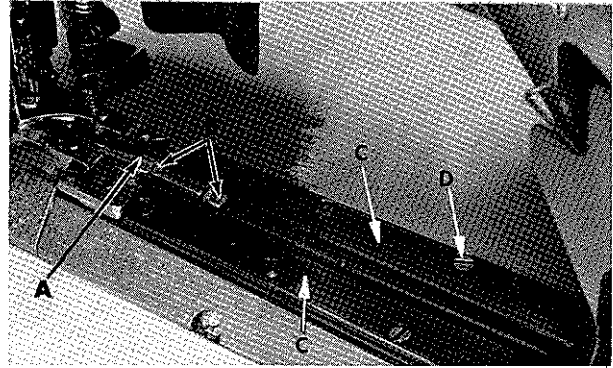


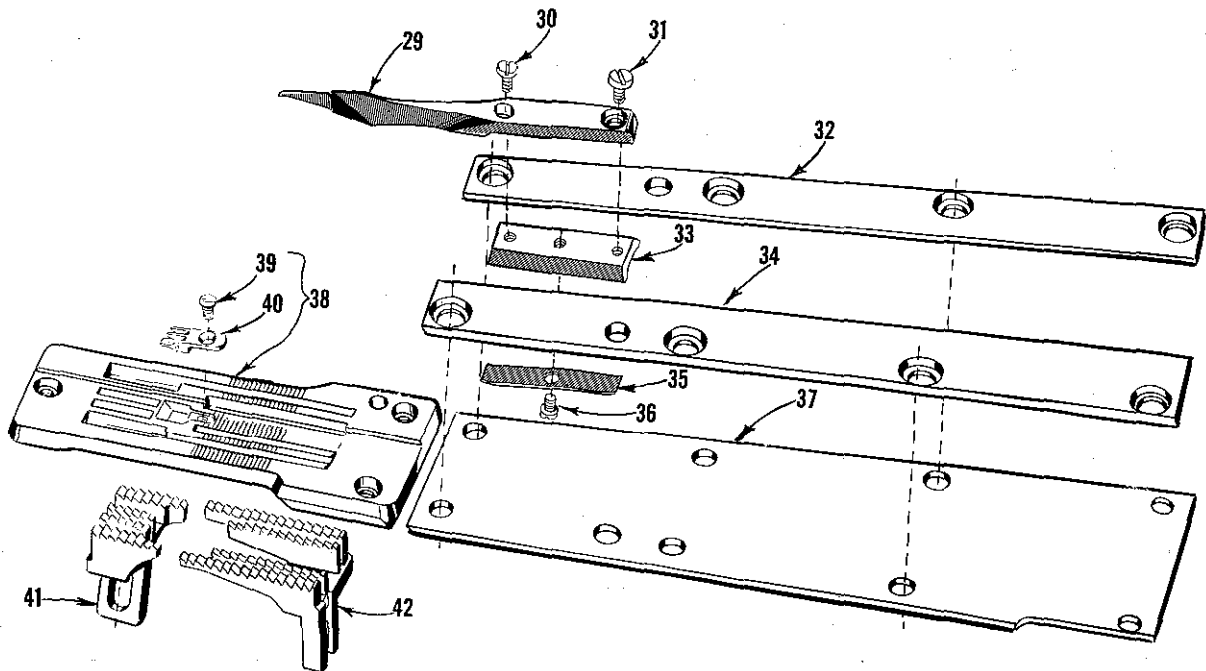
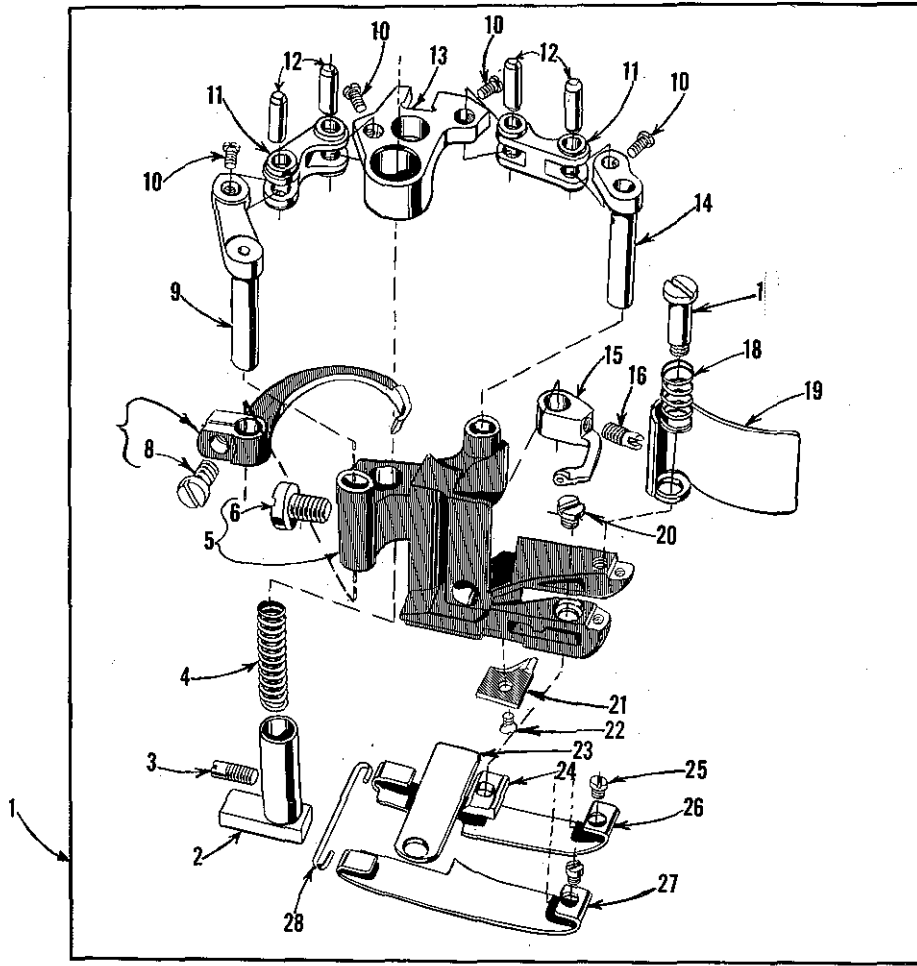
Fig. S

The only difference in the "INSTRUCTIONS FOR SEWING ADJUSTMENTS" covered in Catalog No. 118 L and the adjustment for 36200 J and AJ is:

In the "Needles and Needle Bar" instructions, with the Needle Bar motion at its highest point of travel, the fourth or lowest needle should be 1/2 inch (12.7 mm) from the top of throat plate on 36200 J and AJ (this adjustment may be obtained by using needle gauge 21227 DS), compared to the 17/32 inch (13.49 mm) measurement used for 36200 H and AH (using needle gauge 21227 BU).



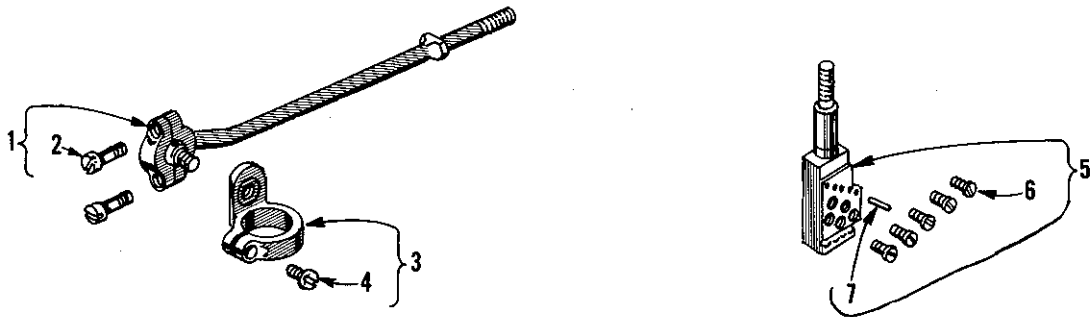
EXPLODED VIEWS  
AND  
DESCRIPTION OF PARTS  
PECULIAR TO  
STYLES 36200 H, J, AH and AJ  
HIGH SPEED CYLINDER FLATSEAMER MACHINES



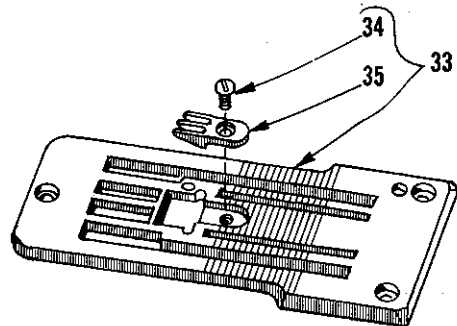
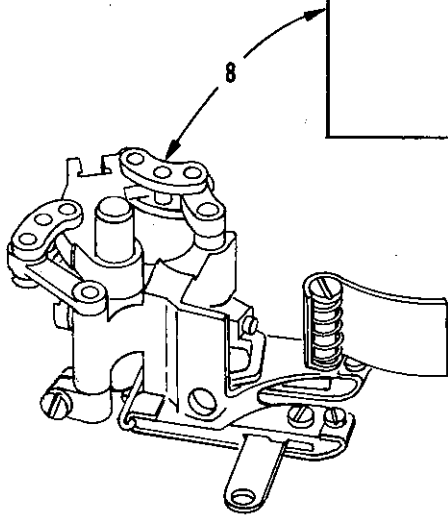
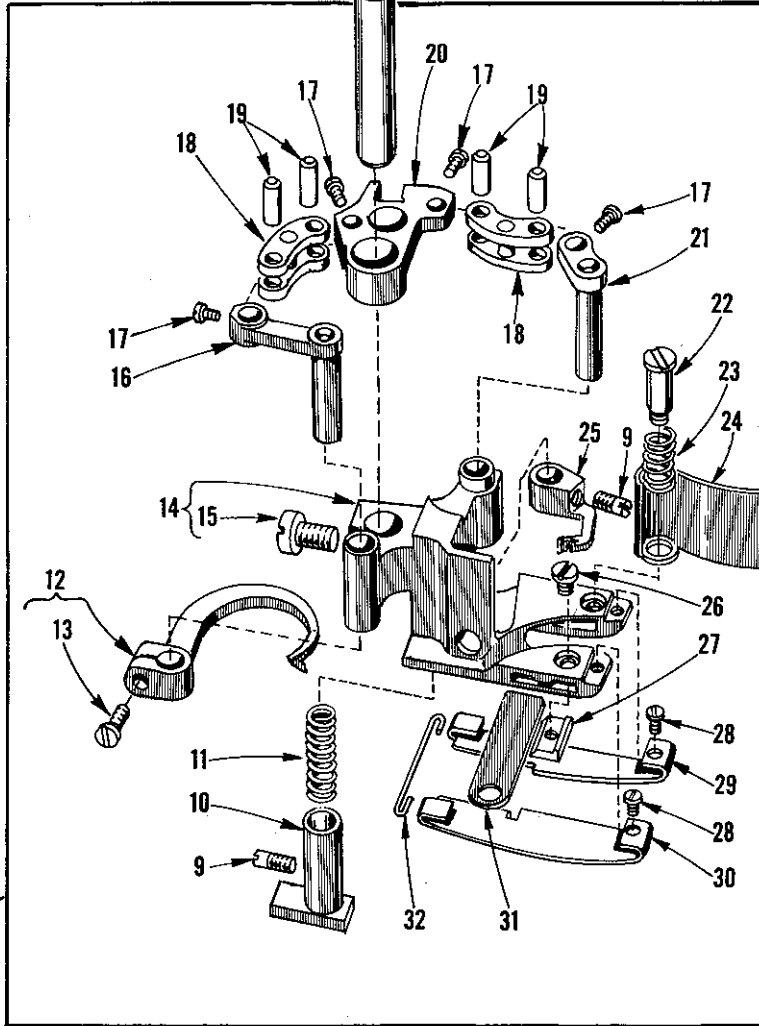
PRESSER FOOT, LAP FORMER, CYLINDER COVER, GIBS  
THROAT PLATE AND FEED DOGS  
(FOR STYLES 36200 H AND AH)

Ref. No.	Part No.	Description	Amt. Req.
1	36220 H	Presser Foot Assembly-----	1
2	36230 E	Yielding Section, marked "AH"-----	1
3	22565 A	Screw-----	1
4	36230 C	Yielding Section Spring-----	1
5	36230 S	Presser Foot, marked "BP" (late parts have part number)-----	1
6	94	Screw-----	1
7	36251 F	Cross Cover Thread Hook-----	1
8	22562 A	Screw-----	1
9	36251 H	Cover Thread Hook Driving Lever and Shaft-----	1
10	22738 B	Screw, for link pin-----	4
11	36251 U	Link, for cover thread carrier and hook driving lever-----	2
12	36251 K	Link Pin-----	4
13	36251 L	Cover Thread Carrier and Hook Driving Segment-----	1
14	36251 G	Cover Thread Carrier Driving Lever and Shaft-----	1
15	36251 E	Cover Thread Carrier, marked "A"-----	1
16	22565 A	Screw-----	1
17	22731	Screw-----	1
18	36279 D	Spring, for chip guard-----	1
19	36279 C	Chip Guard-----	1
20	150	Screw-----	1
21	36230 R	Cloth Guide Plate, marked "T"-----	1
22	22716 A	Screw-----	1
23	36250	Stationary Knife-----	1
*24	36250 G	Stationary Knife Clamp, .326 inch (8.28 mm) Bright Finish-----	1
*	36250 B	Stationary Knife Clamp, .318 inch (8.08 mm) Black Finish-----	1
25	22738 G	Screw-----	2
26	36232 H	Presser Foot Shoe, right-----	1
27	36231 G	Presser Foot Shoe, left-----	1
28	36230 D	Shoe Holding Wire-----	1
29	23420 DB	Lap Former-----	1
30	22738 F	Screw, for lap former-----	1
31	73 A	Screw, for lap former-----	1
32	36283 J	Gib, right-----	1
33	23423 X	Lap Former Slide Block-----	1
34	36283 H	Gib, left-----	1
35	23424 Z	Lap Former Slide Block Spring-----	1
36	22716 A	Screw-----	1
37	36283 G	Cylinder Cover-----	1
38	36224 H	Throat Plate, .050 inch (1.27 mm) step on right side-----	1
40	36240	Stitch Tongue, marked "D"-----	1
41	36205 H	Main Feed Dog, marked "PR", 14 t.p.i. (1.83 mm per tooth)-----	1
42	36226 H	Differential Feed Dog, marked "PQ", 14 t.p.i. (1.83 mm per tooth)-----	1

\* When replacing the stationary knife clamp, order the clamp that has the same finish as the one being replaced.



FURNISHED FOR SHIPPING PURPOSES ONLY.  
REMOVE BEFORE ASSEMBLING ON MACHINE.

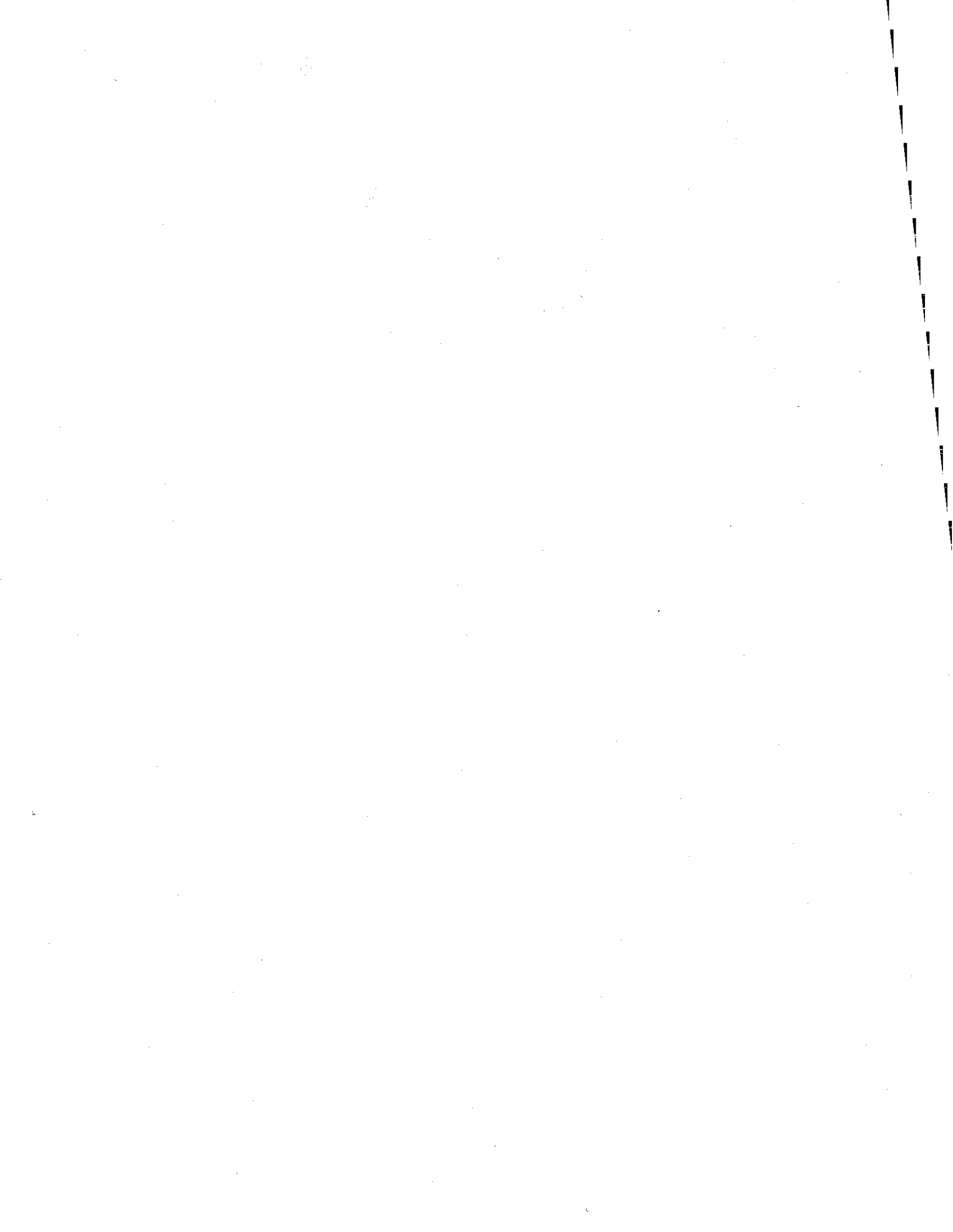


BALL JOINT, LEVER, NEEDLE BAR HEAD,  
PRESSER FOOT AND THROAT PLATE  
(FOR STYLES 36200 J AND AJ)

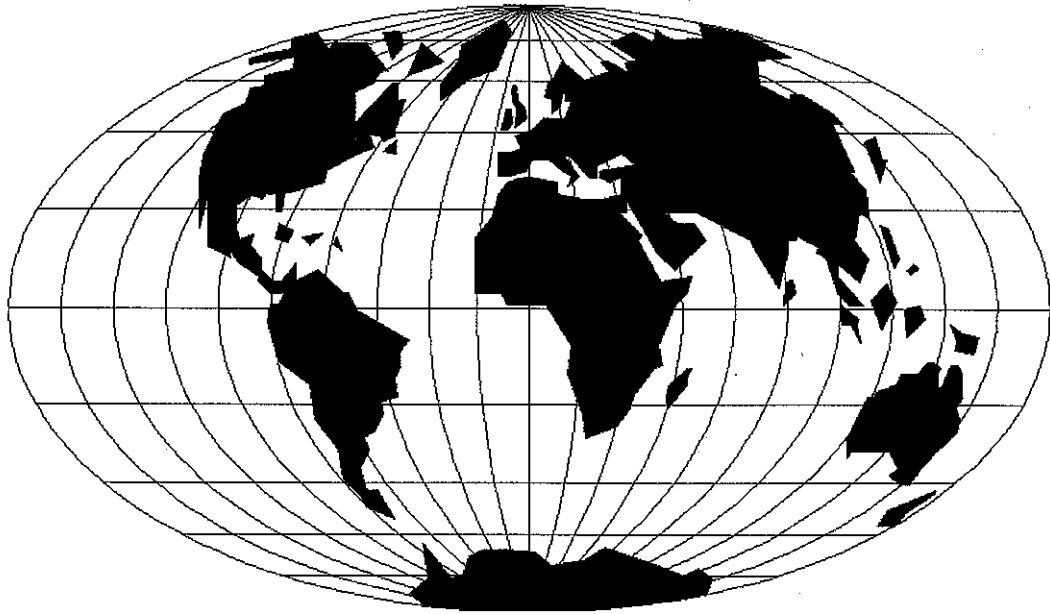
Ref. No.	Part No.	Description	Amt. Req.
1	36251 Y	Cover Thread Carrier and Hook Driving Connecting Rod	
		Ball Joint-----	1
2	97 A	Screw-----	2
3	36251 V	Sleeve Driving Lever-----	1
4	22585	Screw-----	1
5	36218 J	Needle Bar Head-----	1
6	22738 H	Screw-----	5
7	96651	Roll Pin-----	5
8	36220 K	Presser Foot Assembly, for Styles 36200 J, AJ-----	1
9	22565 A	Screw-----	2
10	36230 J	Yielding Section, marked "AP"-----	1
11	36230 C	Spring-----	1
12	36251 FA	Cover Thread Hook-----	1
13	22562 A	Screw-----	1
14	36230 U	Presser Foot, marked "BT"-----	1
15	94	Screw-----	1
16	36251 H	Cover Thread Hook Driving Lever and Shaft-----	1
17	22738 B	Screw-----	4
18	36251 U	Link, for cover thread carrier and hook driving	
		lever-----	2
19	36251 K	Link Pin-----	4
20	36251 L	Cover Thread Carrier and Hook Driving Segment-----	1
21	36251 G	Cover Thread Carrier Carrier Driving Lever and	
		Shaft-----	1
22	22731	Screw-----	1
23	36279 D	Spring-----	1
24	36279 C	Chip Guard-----	1
25	36251 W	Cover Thread Carrier, marked "B"-----	1
26	150	Screw-----	1
*27	36250 G	Stationary Knife Clamp, .326 inch (8.28 mm)	
		Bright Finish-----	1
* -	36250 B	Stationary Knife Clamp, .318 inch (8.08 mm)	
		Black Finish-----	1
28	22738 G	Screw-----	2
29	36232 N	Presser Foot Shoe, right-----	1
30	36231 N	Presser Foot Shoe, left-----	1
31	36250	Stationary Knife-----	1
32	36230 D	Shoe Holding Wire-----	1
33	36224 J	Throat Plate-----	1
34	22716 A	Screw-----	1
35	36240 J	Stitch Tongue, marked "AC"-----	1
# -	21227 DS	Needle Height Gauge (not shown)-----	1

\* When replacing the stationary knife clamp, order the clamp that has the same finish as the one being replaced.

# Available as extra send and charge item.







## WORLDWIDE SALES AND SERVICE

Union Special Corporation maintains sales and service facilities throughout the world. These offices will aid you in the selection of the right sewing equipment for your particular operation. Union Special Corporation representatives and service technicians are factory trained and are able to serve your needs promptly and efficiently. Whatever your location, there is a qualified representative to serve you.

---

Corporate Office: One Union Special Plaza  
Huntley, IL 60142  
Phone: 847•669•5101  
Fax: 847•669•4454

European Distribution Center: Union Special GmbH  
Raiffeisenstrasse 3  
D-71696 Möglingen, Germany  
Tel: 49•07141•247•0  
Fax: 49•07141•247•100

Brussels, Belgium  
Charlotte, N.C.  
El Paso, TX  
Hong Kong, China  
Huntley, IL  
Leicester, England  
Lille, France  
Miami, FL  
Milan, Italy  
Möglingen, Germany  
Montreal, Quebec  
Osaka, Japan  
Santa Fe Springs, CA

Other Representatives throughout  
all parts of the world.



*Union Special*  
INDUSTRIAL SEWING EQUIPMENT