

**SECOND
EDITION**

Union Special[®]
INDUSTRIAL SEWING EQUIPMENT

**CATALOG NO.
104L**

STYLES

51200

51300

51400

51500

51700

51900

**STREAMLINED
FIFTY THOUSAND SERIES**

Catalog No. 104 L

LIST OF PARTS

CLASSES

51200, 51300, 51400, 51500, 51700, 51900

STYLES

| | | |
|----------|----------|----------|
| 51200 BG | 51300 BM | 51400 BY |
| 51200 BK | 51400 BA | 51500 BJ |
| 51200 BL | 51400 BB | 51500 BK |
| 51200 BM | 51400 BD | 51500 BM |
| 51200 BP | 51400 BP | 51500 BN |
| 51200 BR | 51400 BQ | 51500 BP |
| 51200 BS | 51400 BR | 51500 BR |
| 51200 BT | 51400 BS | 51700 BJ |
| 51200 BW | 51400 BT | 51700 BK |
| 51200 BX | 51400 BU | 51700 BQ |
| 51300 BG | 51400 BV | 51700 BR |
| 51300 BH | 51400 BW | 51900 BG |
| 51300 BJ | 51400 BX | 51900 BH |
| 51300 BL | | 51900 BJ |

Second Edition

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UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES

Printed in U.S.A.

April, 1979

FOREWORD

The 50000 series streamlined machines covered by this catalog represent the latest design of the Union Special flatbed line. Light weight needle bars and driving mechanisms and light weight presser bars make it possible to attain the utmost in speed and production. Automatic lubrication, with a pump for returning filtered oil to the main reservoir, has made maintenance simple. All parts are made by precision methods insuring complete interchangeability.

It is our constant aim to furnish carefully prepared information that will enable the customer to secure all possible advantages from the use of UNION SPECIAL machines. The following pages illustrate and describe the parts used in all of the machines covered by this catalog.

Additional catalogs, containing information relative to these machines, and which will be furnished on request, are listed below:

Catalog No. 45 N
Form 357

Needle Manual
Engineering Department Adjusting
Instructions. Specify the style of
machine for which the adjusting
instructions are required.

In all manufacturing centers will be found Union Special representatives, who will co-operate with those who desire in planning and estimating their requirements.

NOTE: Machine Styles listed in this catalog are discontinued. In most instances, component parts can be ordered for customer repair.

UNION SPECIAL CORPORATION

IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine carries a style number which is stamped in the name plate on the machine. Style numbers are classified as standard and special. Those which are standard have one or more letters suffixed, but never contain the letter "Z". Example: "51400 BP". Style numbers containing the letter "Z" are special. When only minor changes are made in a standard machine, a "Z" is merely suffixed to the respective standard style number. Example: "51400 BPZ".

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: "51400".

The distance between the rows of stitches on machines in Classes 51400, 51500, 51700, 51900 is represented by a gauge number measured in 1/64ths of an inch. Thus, 12 gauge represents a distance of 12/64 or 3/16 inch. Similarly, 64 gauge represents a distance of 64/64 or 1 inch.

APPLICATION OF CATALOG

This catalog applies only to the standard styles of machines as listed herein. It can also be applied with discretion to the special machines in Classes 51200, 51300, 51400, 51500, 51700 and 51900.

STYLES OF MACHINES IN CLASS 51200

Streamlined Flat Bed, One Needle, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Light and Medium Duty, Single Reservoir Enclosed Automatic Lubricating System and Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51200 BG Light duty, for seaming light to medium weight trousers and similar operations; seam Type SSa-1. Type 106 GLS needle.
- 51200 BK Light duty, for binding aprons, dresses and similar garments; seam Type BSc-1. Type 106 GLS needle. Uses cut edge strips, standard widths 3/4, 7/8, 1, 1 1/8 and 1 1/4 inch.
- 51200 BL Medium duty, for binding mattress ticks and similar operations; seam Type BSa-1. Type 126 GS needle. Uses selvage edge binding, standard widths 5/8, 7/8 and 3/4 inch.
- 51200 BM Medium duty, for seaming mattress ticks; seam Type SSa-1. Type 128 GAS needle.
- 51200 BP Light duty, for stitching side stays to shoe linings; seam Type LSa-1. Type 301 GS needle.
- 51200 BR Light duty, for joining shoulders on shirts and similar garments in one operation; seam Type LSe-1. Type 106 GLS needle.
- 51200 BS Light duty, for miscellaneous operations on knitted drawer bands and knitted shirt fronts; seam Type SSa-1. Type 101 GS needle.
- 51200 BT Medium duty, for facing sleeves and attaching one piece button stays to fronts and sleeves of woven shirts; seam Type BSc-1. Type 106 GLS needle. Strips used in either garment lengths or long lengths, standard widths 1/2, 3/4, 7/8 and 1 inch.
- 51200 BW Medium duty, for seaming canton flannel or leather palm gloves. Knee lifter. Seam Type SSa-1. Type 110 GAS needle.
- 51200 BX Medium duty, for seaming light weight canton flannel and jersey cloth gloves. Knee lifter. Seam Type SSa-1. Type 109 GS needle.

STYLES OF MACHINES IN CLASS 51300

Streamlined Flat Bed, One Needle, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Medium and Heavy Duty, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Loper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51300 BG Medium duty, for seaming trousers, coats and similar garments; seam Type SSa-1. Type 128 GAS needle.
- 51300 BH Heavy duty, for seaming couch covers with or without rope welt. Welt guided to left of needle, seam Type SSk-1. Type 143 GS needle.
- 51300 BJ Medium duty, for welt seaming trousers, coats and similar garments; seam Type LSb-1. Type 128 GAS needle.
- 51300 BL Heavy duty, for seaming heavy weight auto cushions and similar operations; seam Type SSa-1. Type 143 GS needle.
- 51300 BM Heavy duty, for binding mattress ticks and similar operations; seam Type BSa-1. Type 126 GS needle. Uses selvage edge binding, standard widths 5/8, 7/8 and 3/4 inch.

STYLES OF MACHINES IN CLASS 51400

Streamlined Flat Bed, Two Needle, Left Needle in Front, Independent Row, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Light and Medium Duty, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Loper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51400 BA Light duty, for folding and attaching single piece facing to sleeves of shirts and similar garments in one operation; seam Type BSc-2. Facing used in garment lengths. Type 106 GS needle. Standard gauge No. 48.
- 51400 BB Light duty, for "cut-on" button stay operation on shirts. Starts operation at neck; stitching Type EFb-2. Type 106 GHS needle. Standard gauge No. 48.
- 51400 BD Light duty, for hemming and simultaneously inserting elastic in tops and legs of knitted undergarments. Prepared for use with Galkin close coupled puller. No attachments; stitching Type EFg-2. Type 106 GS needle. Standard gauge Nos. 12 and 16.
- 51400 BP Light duty, for piecing sleeves, joining shoulders and setting sleeves of ordinary quality light weight shirts and similar garments; seam Type LSc-2. Type 106 GHS needle. Standard gauge Nos. 6, 8, 10, 12, 16 and 18.
- 51400 BQ Light duty, for one operation folding and attaching extension center plait, interlining strip and facing strip to fronts of shirts and similar garments; seam Type LSj-2. Starts operation at neck. Plaits used in garment lengths and have 1/4 inch margins on each side. Facing and interlining strips used in long lengths. Type 106 GHS needle. Standard gauge No. 48.
- 51400 BR Light duty, for folding and attaching set-on center plait and interlining strip. No body guide or lower strip folder required; seam Type LSm-2. Type 106 GHS needle. Standard gauge No. 48.
- 51400 BS Light duty, for one operation folding and attaching inside button facing to shirts and similar garments; seam Type LSk-2. Starts operation at neck. Seam produced with 1/16 inch margin on each side. Facing strip used in long lengths and guided next to feed dog. Type 106 GHS needle. Standard gauge Nos. 32 and 48.

STYLES OF MACHINES IN CLASS 51400 (Cont'd.)

- 51400 BT Light duty, for piecing sleeves, joining and setting sleeves of light and medium weight extra fine quality shirts and similar garments; seam Type LSc-2. Type 106 GHS needle. Standard gauge Nos. 8, 10, 12 and 16.
- 51400 BU Light duty, for "cut-on" button stay operations on shirts, Starts operation at neck; stitching Type EFb-2 inverted. Type 106 GHS needle. Standard gauge No. 32.
- 51400 BV Light duty, for uniting the lower edge of French drawer bands to body fabric; seam Type LSd-2. Type 101 GS needle. Standard gauge Nos. 12 and 16.
- 51400 BW Light duty, for piecing sleeves of shirts and pajamas and for joining operations on woven shorts, where the majority of the work consists of straight seams; seam Type LSc-2. Type 106 GHS needle. Standard gauge Nos. 8, 10, 12 and 16.
- 51400 BX Light duty, for quilting collar bands of shirts and similar garments; seam Type SSa-2. Type 106 GHS needle. Standard gauge Nos. 24 and 26.
- 51400 BY Light duty, for folding and attaching "set-on" button stays to fronts of work shirts and similar garments. Starts operation at neck. Seam produced with 1/32 inch margin on both sides. Stays used in garment lengths and guided next to presser foot; seam Type LSk-2. Type 106 GHS. Standard gauge No. 32.

STYLES OF MACHINES IN CLASS 51500

Streamlined Flat Bed, Two Needle, Independent Row, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Heavy Duty, Single Reservoir Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51500 BJ For felling overalls, coats, combination suits and similar garments, left needle in front; seam Type LSc-2. Type 128 GAS needle. Standard gauge Nos. 16 and 18.
- 51500 BK For seaming trousers and similar garments. Tandem needle seat. Right needle in front, seam Type SSa-2. Type 130 GS needle. 10 stitches per inch. Standard gauge No. 1.
- 51500 BM For facing bibs of overalls. Facing strip cut parallel with selvage, used in long lengths and guided next to feed dog. Left needle in front; seam Type LSk-2. Type 128 GAS needle. Standard gauge No. 18.
- 51500 BN For seaming trousers and similar garments. Tandem needle seat. Right needle in front; seam Type SSa-2. Type 130 GS needle. 7 stitches per inch. Standard gauge No. 1.
- 51500 BP For seaming windbreakers and mackinaws, coats and similar garments made from heavy weight melton and similar fabrics, left needle in front; seam Type LSb-2. Type 128 GAS needle. Standard gauge No. 18.
- 51500 BR For felling overalls and similar garments, left needle in front; seam Type LSc-2. Type 128 GAS needle. Standard gauge No. 18.

STYLES OF MACHINES IN CLASS 51700

Streamlined Flat Bed, Two Needle, Independent Row, Needles Abreast, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Driving Mechanism, Light and Heavy Duty, Single Reservoir Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51700 BJ Light duty, for one operation folding and attaching "set-on" center plait and interlining strips to fronts of shirts and similar garments. Starts operation at neck. Plaits used in garment lengths and extend 1/4 inch beyond the rows of stitching; seam Type LSm-2. Type 108 GKS needle. Standard gauge Nos. 56 and 64.

STYLES OF MACHINES IN CLASS 51700 (Cont'd.)

- 51700 BK Light duty, for one operation folding and attaching extension center plait, interlining strip and facing strips to fronts of shirts and similar garments. Starts operation at neck. Plaits used in garment lengths and extend 1/4 inch beyond the rows of stitching; seam Type LSj-2. Type 108 GKS needle. Standard gauge No. 64.
- 51700 BQ Light duty, for one operation folding and attaching "set-on" center plaits to fronts of medium weight army shirts and similar garments. Starts operation at neck. Plaits used in garments lengths and extend 1/4 inch beyond rows of stitching; seam Type LSk-2. Type 108 GKS needle. Standard gauge No. 64.
- 51700 BR Light duty, for one operation folding and attaching inside button facings to medium weight army shirts and similar garments. Starts operation at neck. Facing strip cut from body fabric, used in long lengths and guided next to feed dog. Seam has 1/16 inch margins; seam Type LSk-2. Type 108 GKS needle. Standard gauge No. 64.

STYLES OF MACHINES IN CLASS 51900

Streamlined Flat Bed, Three Needle, Left Needle in Front, Independent Row, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Light and Heavy Duty, Single Reservoir Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/4 Inches.

- 51900 BG Light duty, for piecing sleeves, joining shoulders and setting sleeves of light and medium weight shirts and similar garments; seam Type LSc-3. Type 108 GKS needle. Standard gauge Nos. 5, 6 and 7.
- 51900 BH Heavy duty, for seaming overalls, dungarees, coats, combination suits and similar garments; seam Type LSc-3. Type 128 GAS needle. Standard gauge Nos. 7, 8 and 9.
- 51900 BJ Heavy duty, for seaming windbreakers, mackinaws, lumber jackets and similar garments; seam Type LSb-3. Type 147 GS needle. Standard gauge No. 9.

NEEDLES

TYPE NUMBERS AND SIZES

Each needle has a type number and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number denotes the largest diameter of the blade, measured in thousandths of an inch, midway between the shank and the eye and is stamped in the needle shank. Collectively, the type number and size number is the complete symbol.

To have orders promptly and accurately filled, the empty package, a sample needle, or the type and size number should be given. See remarks on labels. An intelligent order would read as follows: "1000 Needles, Type 108 GKS Size 090/036".

The type numbers of the needle 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:

| <u>Type No.</u> | <u>Description</u> |
|-----------------|--|
| 101 GS | Round shank, round point, extra short, double groove, struck groove, chromium plated - sizes 022, 025, 027, 080/032, 049, 054. |
| 106 GS | Round shank, round point, extra short, double groove, struck groove, ball eye, chromium plated - sizes 090/036. |
| 106 GHS | Round shank, round point, extra short, double groove, struck groove, ball eye, ball point, chromium plated - sizes 070/027, 075/029, 080/032, 090/036. |

TYPE NUMBER AND SIZES (Continued)

| <u>Type No.</u> | <u>Description</u> |
|-----------------|---|
| 106 GLS | Round shank, round point, extra short, double groove, struck groove, oversize ball eye, ball point, chromium plated - sizes 036, 040. |
| 108 GKS | Round shank, round point, extra short, double groove, struck groove, oversize ball eye, spotted, chromium plated - sizes 080/032, 090/036, 100/040. |
| 109 GS | Round shank, round point, extra short, double groove, struck groove, ball eye, government point, chromium plated - sizes 070/027, 090/036, 100/040, 110/044, 125/049, 140/054. |
| 110 GAS | Round shank, round point, extra short, double groove, struck groove, ball eye, long spot, government point, chromium plated - sizes 090/036, 100/040, 110/044, 125/049. |
| 126 GS | Round shank, round point, short, double groove, struck groove, ball eye, chromium plated - sizes 080/032, 100/040, 054. |
| 128 GAS | Round shank, round point, short, double groove, struck groove, ball eye, spotted, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060, 170/067. |
| 130 GS | Round shank, round point, short, double groove, struck groove, ball eye, spotted, government point, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060. |
| 143 GS | Round shank, round point, No. 2 bag, double groove, struck groove, spotted, chromium plated - sizes 140/054, 150/060, 170/067. |
| 147 GS | Round shank, round point, long, double groove, struck groove, ball eye, spotted, short point, undersize eye in grooves, one step reduction, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060, 170/067. |
| 301 G | Round shank, stay point, extra short, double groove, chromium plated - sizes 085/034, 100/040. |
| 306 GS | Round shank, stay point, extra short, double groove, struck groove, ball eye, chromium plated - sizes 090/036, 100/040, 110/044, 125/049, 140/054. |

ORDERING REPAIR PARTS

ILLUSTRATIONS

This catalog has been so arranged as 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 indicate the position of that part in the illustration. The reference number should never be used in ordering parts. Always use the part number shown in the second column.

Those component parts of sub-assemblies which can be furnished for repairs are indicated by the fact that their descriptions are indented under the description of the main sub-assembly. Example:

| | | |
|---|---------|--|
| 3 | 29105 Z | Looper Drive Eccentric Assembly, for Styles in Classes 51300, 51500; Styles 51200 BL, BM, BT, BW, BX; 51900 BH, BJ--1 |
| 4 | 22559 A | Bearing Cap Screw, lower -----2 |
| 5 | 22559 B | Bearing Cap Screw, upper -----2 |
| 6 | 22894 C | Eccentric Set Screw -----4 |
| 7 | 22894 D | Eccentric Spot Screw -----1 |

It will be noted in the above example that the eccentric, ball stud and bearing are not listed. The reason for this is that the replacement of any of these parts individually is not recommended and the complete sub-assembly should be ordered.

ORDERING REPAIR PARTS

ILLUSTRATIONS (Continued)

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 descriptions and, if necessary, the difference will be shown in the illustration.

At the back of the book will be found a numerical index of all the parts shown in the illustrations, which will facilitate locating the illustration and description when only the part number is known.

IDENTIFYING PARTS

Where the construction permits each part is stamped with its part number. On some smaller parts and on those where the construction does not permit, an identification letter is stamped to distinguish the part from similar ones.

All part numbers represent the same part, regardless of the catalog in which they appear.

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 Corporation, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles and made with the utmost precision. The 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, US Emblem. Each trademark is your guarantee of the highest quality in materials and workmanship.

TERMS

Prices are strictly net cash and 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.

OILING AND THREADING INSTRUCTIONS

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 90 to 125 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 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 if 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 hand-wheel.

The accompanying drawing also shows the manner in which a two needle machine is threaded. Single and three needle machines are threaded in substantially the same manner. The looper threading of the various classes is indicated in the inserts.

FILL
MAIN
RESERVOIR
HERE

Union Special

KEEP OIL
LEVEL
BETWEEN
LINES

CAUTION!
FILL ALL OIL RESERVOIRS
BEFORE STARTING.
MACHINE HAS BEEN DRAINED
BEFORE SHIPPING.



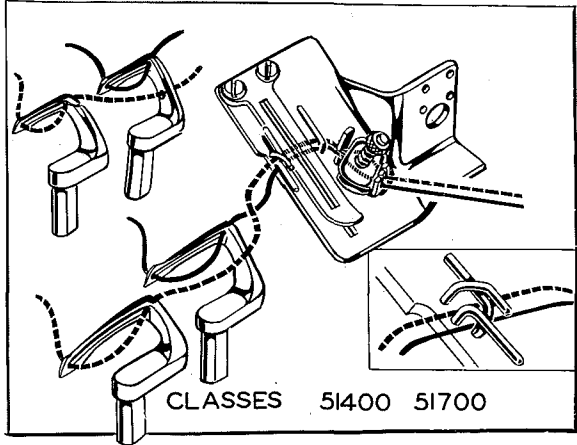
CLASS 51500



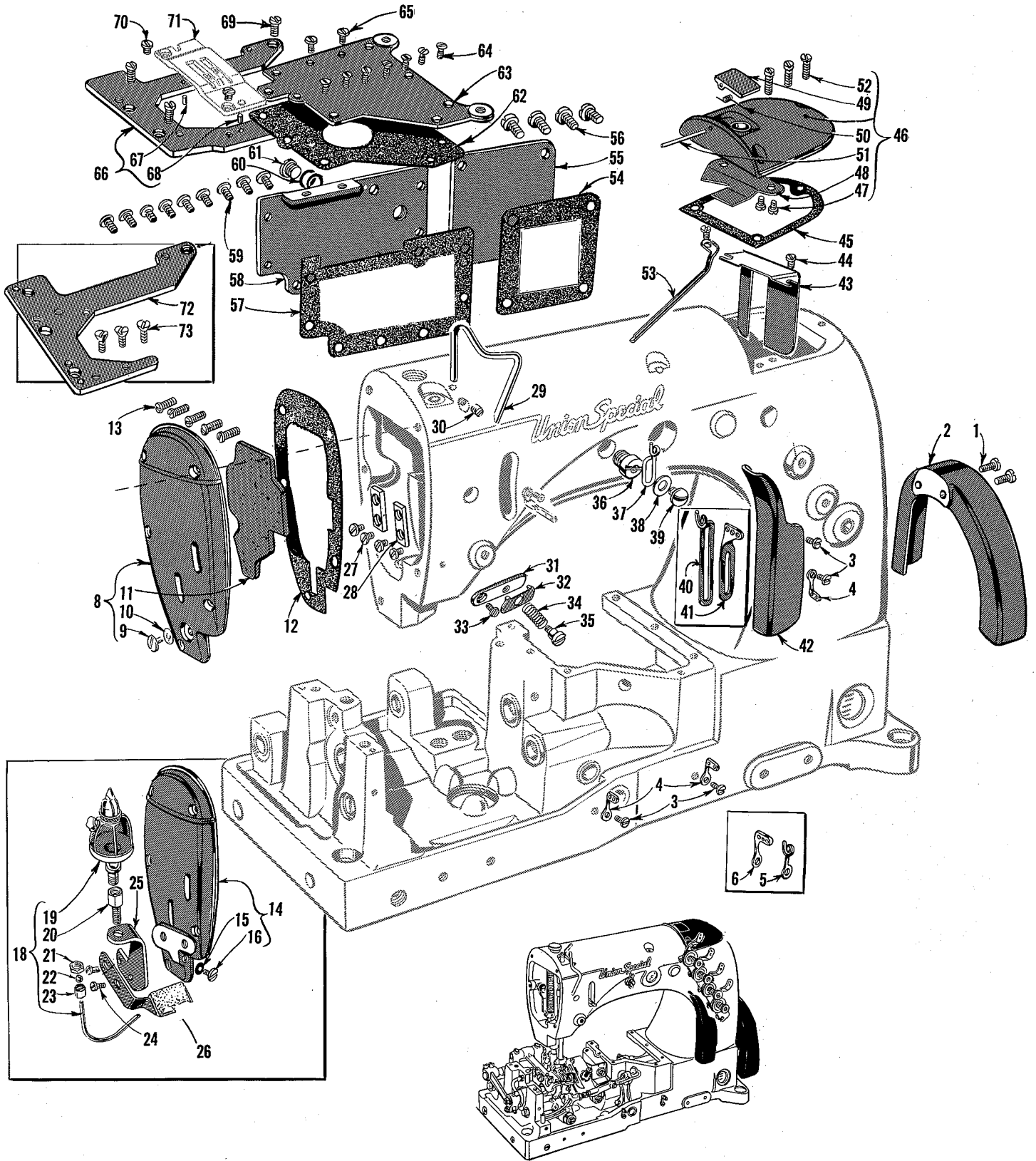
CLASSES
51200
51300



CLASS 51900



CLASSES 51400 51700



MAIN FRAME, MISCELLANEOUS COVERS AND PLATES

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-------------|---|-----------|
| 1 | 93 | Screw----- | 2 |
| 2 | B21375 AH | Belt Guard----- | 1 |
| 3 | 98 A | Screw----- | 4 |
| 4 | 158 B | Thread Eyelet, for two needle machines----- | 3 |
| 5 | 52 A | Thread Eyelet, for one needle machines----- | 3 |
| 6 | 158 A | Thread Eyelet, for three needle machines----- | 3 |
| 8 | 51282 Y | Head Cover, for Styles in Classes 51200, 51300, 51900; Styles 51400 BA, BB, BD, BP, BS, BT, BU, BV, BW, BX, BY; 51500 BJ, BK, BM, BN, BR; 51700 BR----- | 1 |
| 9 | 22542 | Screw----- | 1 |
| 10 | 52882 W | Gasket----- | 1 |
| 11 | 51282 AC | Felt Liner----- | 1 |
| 12 | 51282 Z | Gasket----- | 1 |
| 13 | 22569 B | Screw----- | 5 |
| 14 | 51782 A | Head Cover, for Styles 51400 BQ, BR; 51500 BP; 51700 BJ, BK, BQ----- | 1 |
| 15 | 52882 W | Gasket----- | 1 |
| 16 | 22542 | Screw----- | 1 |
| 18 | 21396 BJ | Needle Thread Lubricator Oil Reservoir, for Style 51500 BP----- | 1 |
| 19 | 666-79 | Oil Cup----- | 1 |
| 20 | 61394 V | Adapter----- | 1 |
| 21 | 11638 M | Nut----- | 1 |
| 22 | 660-74 | Connection Sleeve----- | 1 |
| 23 | 660-75 | Coupling----- | 1 |
| 24 | 22569 C | Screw----- | 2 |
| 25 | 21396 BK | Needle Thread Lubricator Oil Reservoir Bracket, for Style 51500 BP----- | 1 |
| 26 | 21396 BP | Needle Thread Lubricator, for Styles 51500 BP, 51900 BJ (felt No. 21396 AG)----- | 1 |
| 27 | 22513 | Screw----- | 4 |
| 28 | 35731 A | Presser Bar Connection Guide Plate----- | 2 |
| 29 | 51270 B | Needle Thread Take-up Wire----- | 1 |
| 30 | 95 | Screw----- | 1 |
| 31 | 43296 | Nipper Spring Base, for Styles 51200 BG, BW, BX; 51300 BG, BJ----- | 1 |
| 32 | 57 WB | Nipper Spring Plate, for Styles 51200 BG, BW, BX; 51300 BG, BJ----- | 1 |
| 33 | 605 A | Screw, for Styles 51200 BW, BX----- | 1 |
| | 22798 A | Screw, for Styles 51200 BG; 51300 BG, BJ----- | 1 |
| 34 | 15438 C | Nipper Spring, for Styles 51200 BG, BW, BX; 51300 BG, BJ----- | 1 |
| 35 | 57 WD | Nipper Spring Stud, for Styles 51200 BG, BW, BX; 51300 BG, BJ----- | 1 |
| 36 | 22889 A | Adapter Screw----- | 1 |
| 37 | 51758 | Frame Needle Thread Eyelet, for Styles in Classes 51200, 51400, 51500, 51700----- | 1 |
| 38 | 20 | Washer----- | 1 |
| 39 | 22848 | Screw----- | 1 |
| 40 | 539 | Frame Needle Thread Eyelet, for Styles in Class 51300----- | 1 |
| 41 | 51858 | Frame Needle Thread Eyelet, for Styles in Class 51900----- | 1 |
| 42 | 51291 A | Looper Thread Guard----- | 1 |
| 43 | 52882 Y | Baffle Plate----- | 1 |
| 44 | 90 | Screw----- | 2 |
| 45 | 52882 P | Gasket----- | 1 |
| 46 | 52882 AD | Crank Chamber Cover, upper----- | 1 |
| 47 | 90 | Screw----- | 2 |
| 48 | 52882 AA | Oil Drip Plate----- | 1 |
| 49 | 39582 L | Oil Cap----- | 1 |
| 50 | 52882 AC | Spring----- | 1 |
| 51 | 50-789 Blk. | Pin----- | 1 |
| 52 | 22541 B | Screw----- | 3 |
| 53 | 51282 AE | Needle Lever Bearing Oiler----- | 1 |
| 54 | 52882 U | Gasket----- | 1 |
| *55 | 52882 AE | Crank Chamber Cover, lower----- | 1 |
| 56 | 22548 | Screw----- | 4 |
| 57 | 52882 M | Gasket----- | 1 |
| 58 | 52882 L | Oil Reservoir Back Cover----- | 1 |
| 59 | 22848 | Screw----- | 9 |
| 60 | 41394 A | Gasket----- | 2 |
| 61 | 22733 B | Plug Screw----- | 1 |
| 62 | 51382 A | Gasket----- | 1 |
| 63 | 53782 B | Oil Reservoir Top Cover----- | 1 |
| 64 | 22524 | Screw----- | 7 |
| 65 | 22585 A | Screw----- | 2 |
| 66 | 51480 | Throat Plate Support, for Styles in Classes 51500, 51700, 51900; Styles 51200 BG, BK, BL, BW, BX; 51300 BH, BM; 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BX, BY----- | 1 |
| 67 | 51280 J | Dowel Pin, lower----- | 2 |
| 68 | 51280 K | Dowel Pin, for Throat Plate----- | 2 |
| 69 | 22839 | Screw----- | 3 |
| 70 | 22570 | Throat Plate Screw, fillister head----- | 2 |
| | 87 | Throat Plate Screw, countersunk head----- | 2 |
| 71 | | Throat Plate (See Pages 33, 35, 37, 39, 41, 43)----- | 1 |
| 72 | 51280 A | Throat Plate Support, for Styles 51200 BM, BN, BP, BR, BS, BT; 51300 BG, BJ, BL; 51400 BV----- | 1 |
| †73 | 80 | Screw----- | 3 |

* NOTE: Use No. 52882 AF on late model machines.

† NOTE: Use No. 22839 counter bore head screw for late model No. 51280 A.



MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 643-127 Blk. | Gasket ----- | 1 |
| 2 | 51493 K | Oil Pump Driven Gear ----- | 1 |
| 3 | 531 | Screw----- | 2 |
| 4 | 51493 AG | Oil Pump Housing ----- | 1 |
| 5 | 51493 BA | Base Plate----- | 1 |
| 6 | 51493 D | Oil Pump Driving Shaft----- | 2 |
| 7 | 51493 E | Oil Pump Driving Shaft Gear----- | 2 |
| 8 | 51493 AH | Oil Pump Housing Cover ----- | 1 |
| 9 | 22569 B | Screw----- | 3 |
| 10 | 22823 A | Screw----- | 2 |
| †11 | 51493 BH | Filter Cap Assembly----- | 1 |
| 12 | 51493 BJ | Washer, rubber ----- | 1 |
| 13 | 22823 B | Screw----- | 1 |
| 14 | 22571 A | Plug Screw ----- | 18 |
| 15 | 666-114 | Oil Wick----- | 2 |
| 16 | 35178 D | Spring----- | 2 |
| 17 | 666-65 | Oil Wick----- | 2 |
| 18 | 35178 D | Spring----- | 2 |
| 19 | 666-118 | Oil Wick----- | 2 |
| 20 | 666-111 | Oil Wick----- | 2 |
| 21 | 666-179 | Wedge Pin----- | 2 |
| 22 | 22539 H | Plug Screw ----- | 1 |
| 23 | 52944 T | Looper Rock Shaft Bushing, left----- | 1 |
| 24 | 52890 C | Main Shaft Bushing, left, middle, inner right----- | 3 |
| 25 | 52936 | Feed Rocker Shaft Bushing ----- | 2 |
| 26 | 660-136 | Oil Tube for feed crank link ----- | 1 |
| 27 | 258 A | Nut----- | 1 |
| 28 | 52894 AK | Oil Tube for looper rocker ball joint, left, on Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| 29 | 51794 C | Oil Tube for looper rocker ball joint, left on Styles in Class 51700 ----- | 1 |
| 30 | 22560 B | Screw----- | 1 |
| 31 | 52894 AB | Oil Tube Holder ----- | 2 |
| *32 | 51293 T | Oil Tube for feed lift eccentric; also for looper avoid eccentric on Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 2 |
| 33 | 90 | Screw----- | 2 |
| 34 | 51794 A | Oil Tube for looper avoid eccentric on Styles in Class 51700 ----- | 1 |
| 35 | 51257 AA | Lower Presser Bar Bushing ----- | 1 |
| 36 | 51254 D | Lower Needle Bar Bushing ----- | 1 |
| 37 | 51254 C | Upper Needle Bar Bushing----- | 1 |
| 38 | 51242 S | Rear Looper Drive Lever Shaft Bushing----- | 1 |
| 39 | 52944 U | Looper Rock Shaft Bushing, right ----- | 1 |
| 40 | 52894 AM | Oil Tube for looper connecting rod ball joint, right--- | 1 |
| 41 | 6042 A | Washer----- | 1 |
| 42 | 258 A | Nut ----- | 1 |
| 43 | 51242 R | Middle Looper Drive Lever Shaft Bushing ----- | 1 |
| 44 | 51242 Z | Front Looper Drive Lever Shaft Bushing ----- | 1 |
| 45 | 21657 X | Tension Release Lever Shaft Bushing ----- | 1 |
| 46 | 52891 B | Crank Shaft Bushing Housing, including bushing----- | 1 |
| 47 | 50-648 Blk. | Lucite Oil Gauge ----- | 1 |
| 48 | 52883 R | Foot Lifter Lever Bushing----- | 1 |
| 49 | 51295 A | Mounting Isolator----- | 4 |

† Use No. 51493 BG base plate oil pad with No. 51493 BH filter.
 * Two No. 51293 T replaced by one each Nos. 22571 B, 52794 G.



CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-------------|--|-----------|
| 1 | 22729 | Screw----- | 1 |
| 2 | 51243 C | Ball Stud Guide Fork ----- | 1 |
| 3 | 29105 AA | Looper Drive Lever Eccentric Assembly, for Styles in Classes 51400, 51700; Styles 51200 BG, BK, BP, BR, BS; 51900 BG ----- | 1 |
| | 29105 Z | Looper Drive Lever Eccentric Assembly, for Styles in Classes 51300, 51500; Styles 51200 BL, BM, BT, BW, BX; 51900 BH, BJ----- | 1 |
| 4 | 22559 A | Bearing Cap Screw, lower ----- | 2 |
| 5 | 22559 B | Bearing Cap Screw, upper ----- | 2 |
| 6 | 22894 C | Eccentric Set Screw ----- | 4 |
| 7 | 22894 D | Eccentric Spot Screw ----- | 1 |
| 8 | 22852 A | Clamp Screw ----- | 1 |
| 9 | 81 | Spot Screw ----- | 1 |
| 10 | 51242 M | Washer ----- | 1 |
| 11 | 51242 Y | Looper Drive Lever Rocker ----- | 1 |
| 12 | 52841 J | Nut ----- | 1 |
| 13 | 51242 M | Washer ----- | 1 |
| 14 | 52841 G | Locking Stud ----- | 1 |
| 15 | 12982 | Lock Nut ----- | 1 |
| 16 | 51242 P | Looper Drive Lever Shaft ----- | 1 |
| 17 | 22539 H | Plug Screw ----- | 1 |
| 18 | 51242 L | Thrust Washer ----- | 2 |
| 19 | 51493 BP | Oil Pump Driving Gear ----- | 1 |
| 20 | 22560 B | Screw ----- | 2 |
| 21 | 29476 FF | Crankshaft Assembly, .910 inch throw, for Styles 51200 BL, BM, BT, BW, BX; 51300 BG, BJ ----- | 1 |
| | 29476 GZ | Crankshaft Assembly, .990 inch throw, for Styles in Class 51500; Styles 51300 BH, BL, BM; 51900 BH, BJ ----- | 1 |
| | 29476 HA | Crankshaft Assembly, .770 inch throw, for Styles in Classes 51400, 51700; Styles 51200 BG, BK, BP, BR, BS; 51900 BG ----- | 1 |
| 22 | 51216 M | Needle Bearings ----- | 28 |
| 23 | 51247 | Counterweight ----- | 1 |
| 24 | 22894 J | Screw ----- | 2 |
| 25 | 51147 | Thrust Collar ----- | 1 |
| 26 | 95 | Screw ----- | 2 |
| 28 | 22569 B | Screw ----- | 3 |
| 29 | 51221 C | Handwheel, for No. 1 "V" or round belt ----- | 1 |
| 30 | 22894 F | Screw ----- | 2 |
| 31 | | Needle Holder (See Pages 29, 31) ----- | 1 |
| 32 | | Needle Bar (See Pages 29, 31) ----- | 1 |
| 33 | 27-435 Blk. | Eyelet Lock Washer ----- | 1 |
| 34 | 22768 | Screw ----- | 1 |
| 35 | 56458 A | Needle Bar Thread Eyelet, for two needle machine ----- | 1 |
| 36 | 56358 | Needle Bar Thread Eyelet, for one needle machine ----- | 1 |
| 37 | 56958 A | Needle Bar Thread Eyelet, for three needle machine ----- | 1 |
| 38 | 29348 Y | Needle Lever Assembly ----- | 1 |
| 39 | 51254 J | Needle Bar Connection ----- | 1 |
| 40 | 22562 A | Screw ----- | 1 |
| 41 | 56354 A | Needle Bar Connection Link ----- | 1 |
| 42 | 22564 | Screw for lower link pin ----- | 1 |
| 43 | 51054 | Link Pin ----- | 2 |
| 44 | 666-149 | Lubricating Felt ----- | 1 |
| 45 | 77 | Screw for upper link pin ----- | 1 |
| 46 | 56350 A | Needle Lever Stud ----- | 1 |
| 47 | 56315 | Needle Lever ----- | 1 |
| *48 | 666-170 | Oil Wick, for needle lever stud ----- | 1 |
| 49 | 719 | Screw ----- | 2 |
| 50 | 22586 R | Screw ----- | 1 |
| 51 | 51250 F | Gasket ----- | 1 |
| 52 | 51250 D | Washer ----- | 1 |
| 53 | 660-212 | Oil Seal Ring ----- | 2 |
| 54 | 51150 | Needle Lever Thrust Collar ----- | 1 |
| 55 | 29066 R | Needle Lever Ball Joint ----- | 1 |
| 56 | 22559 G | Screw ----- | 2 |
| 57 | 51216 N | Washer ----- | 1 |
| 58 | 51216 P | Nut ----- | 1 |
| 59 | 51216 G | Needle Lever Connecting Rod ----- | 2 |
| 60 | 22768 | Screw ----- | 1 |
| 61 | 56458 | Needle Lever Thread Eyelet, for two needle machine ----- | 1 |
| 62 | 56358 A | Needle Lever Thread Eyelet, for one needle machine ----- | 1 |
| 63 | 56958 | Needle Lever Thread Eyelet, for three needle machine ----- | 1 |

* For use with needle lever stud No. 51250 E in old machines.



LOOPER ROCKER AND CONNECTING ROD PARTS

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-------------|--|-----------|
| 1 | 22894 H | Spot Screw ----- | 1 |
| 2 | 51242 W | Looper Drive Lever ----- | 1 |
| 3 | 22811 B | Screw ----- | 1 |
| 4 | 12538 | Nut ----- | 1 |
| 5 | 51241 K | Looper Connecting Rod and Ball Joint, right, for Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| 6 | 56341 G | Spring ----- | 1 |
| 7 | 50-458 Blk. | Spring Pin ----- | 1 |
| 8 | 18 | Nut, right thread ----- | 1 |
| 9 | 51240 D | Looper Connecting Rod, for Styles in Class 51300, 51400, 51500, 51900; Styles 51200 BL, BM, BT, BW, BX ----- | 1 |
| | 51240 E | Looper Connecting Rod, for Styles 51200 BG, BK, BP, BR, BS ----- | 1 |
| 10 | 269 | Nut, left thread ----- | 1 |
| 11 | 55241 N | Looper Connecting Rod Ball Joint, left, for Styles in Classes 51200, 51300, 51400, 51500 ----- | 1 |
| 12 | | Looper Rocker Assembly (See Chart Below) ----- | 1 |
| 13 | 22829 | Lock Nut Screw ----- | 1 |
| 14 | 258 A | Lock Nut ----- | 1 |
| 15 | 15465 F | Looper Rocker Cone ----- | 1 |
| 16 | 88 | Set Screw ----- | 2 |
| 17 | | Looper Rocker (See Chart Below) ----- | |
| 18 | 51745 | Looper Rocker Cone Stud ----- | 1 |
| 19 | 51241 D | Looper Connecting Rod Ball Joint, left, for Styles in Class 51900 ----- | 1 |
| 20 | 18 | Nut, for Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| 21 | 73 | Looper Set Screw ----- | 1, 2, 3 |
| 22 | 51244 L | Thrust Washer ----- | 2 |
| 23 | 51246 | Looper Rocker Stud Nut, for Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| 24 | 51244 | Looper Rocker Frame, for Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| 25 | 98 | Set Screw ----- | 1 |
| 26 | 96 | Spot Screw ----- | 1 |
| 27 | 77 | Screw ----- | 1 |
| 28 | 51244 B | Looper Rocker Shaft Arm ----- | 1 |
| 29 | 22519 H | Screw ----- | 1 |
| 30 | | Looper (See Page 45) ----- | |
| 31 | 51144 | Looper Rocker Rock Shaft, for Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| 32 | 18 | Nut ----- | 1 |
| 33 | 20 | Washer ----- | 1 |
| 34 | 51244 N | Looper Rocker Rock Shaft Collar, for Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| 35 | 55244 G | Locking Stud ----- | 1 |
| 36 | 51741 C | Looper Connecting Rod Ball Joint, right, for Styles in Class 51700 ----- | 1 |
| 37 | 41047 | Looper Connecting Rod, for No. 64 to 96 gauge, Styles in Class 51700 ----- | 1 |
| | 39141 | Looper Connecting Rod, for No. 56 gauge, Style 51700 ----- | 1 |
| | 4761 | Looper Connecting Rod, for No. 112 and 128 gauges, Style 51700 ----- | 1 |
| 38 | 55641 | Looper Connecting Rod Ball Joint, left, for Styles in Class 51700 ----- | 1 |
| 39 | 22835 | Looper Rocker Link Stud, for Styles in Class 51700 ----- | 1 |
| 40 | 51771 | Looper Rocker Link Ferrule, for Styles in Class 51700 ----- | 2 |
| 41 | 51770-56 | Looper Rocker Link, for No. 56 gauge, Styles in Class 51700 ----- | 1 |
| | 51770-64 | Looper Rocker Link, for No. 64 gauge ----- | 1 |
| | 51770-72 | Looper Rocker Link, for No. 72 gauge ----- | 1 |
| | 51770-80 | Looper Rocker Link, for No. 80 gauge ----- | 1 |
| | 51770-88 | Looper Rocker Link, for No. 88 gauge ----- | 1 |
| | 51770-96 | Looper Rocker Link, for No. 96 gauge ----- | 1 |
| | 51700-112 | Looper Rocker Link, for No. 112 gauge ----- | 1 |
| | 51770-128 | Looper Rocker Link, for No. 128 gauge ----- | 1 |
| 42 | 14077 | Nut ----- | 2 |
| 43 | 51772-56 | Looper Rocker Spacing Plate, for No. 56 and 96 gauges, Styles in Class 51700 ----- | 1 |
| | 51772-64 | Looper Rocker Spacing Plate, for No. 64 and 104 gauges ----- | 1 |
| | 51772-72 | Looper Rocker Spacing Plate, for No. 72 and 112 gauges ----- | 1 |
| | 51772-80 | Looper Rocker Spacing Plate, for No. 80 gauge ----- | 1 |
| | 51772-88 | Looper Rocker Spacing Plate, for No. 88 and 128 gauges ----- | 1 |
| 44 | 51744 A | Looper Rocker Frame, for Styles in Class 51700 ----- | 1 |
| 45 | 1280 | Looper Rocker Stud Nut, for Styles in Class 51700 ----- | 2 |
| 46 | 51773 | Looper Rocker Frame Spacing Collar, for Styles in Class 51700 ----- | 1 |
| 47 | 88 B | Screw ----- | 1 |
| 48 | 54244 L | Thrust Washer, for Styles in Class 51700 ----- | 1 |
| 49 | 51244 A | Looper Rocker Rock Shaft, for Styles in Class 51700 ----- | 1 |

| | Ref. 12 Assembly | Ref. 17 Assembly | Identification Mark | Machine Styles | Amt. Req. |
|---|------------------|------------------|---------------------|--|-----------|
| A | 29192 A | 51413 | "C" | 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY | 1 |
| B | 29192 | 51213 | "B" | 51200 BG, BK, BL, BM, BP, BR, BS, BT, BW, BX, 51300 BG, BH, BJ, BL, BM | 1 |
| C | 29192 D | 51513 | "D" | 51500 BJ, BK, BM, BN, BR | 1 |
| D | 29192 B | 51913 | "F" | 51500 BP, 51900 BG, BH, BJ | 1 |
| E | 29192 C | 51713 | "E" | 51700 BJ, BK, BQ, BR | 2 |



MAIN SHAFT AND FEED DRIVING PARTS

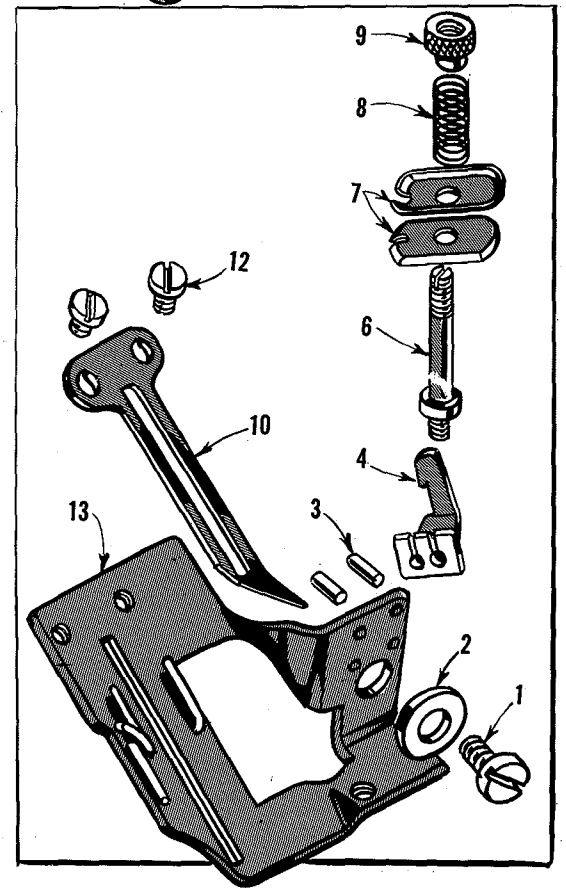
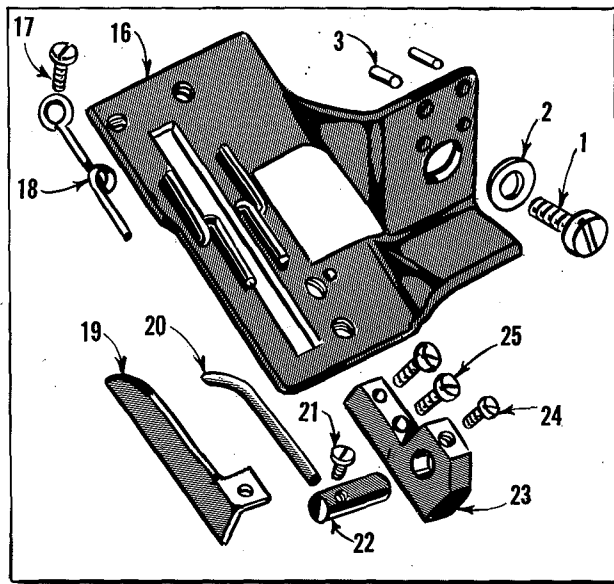
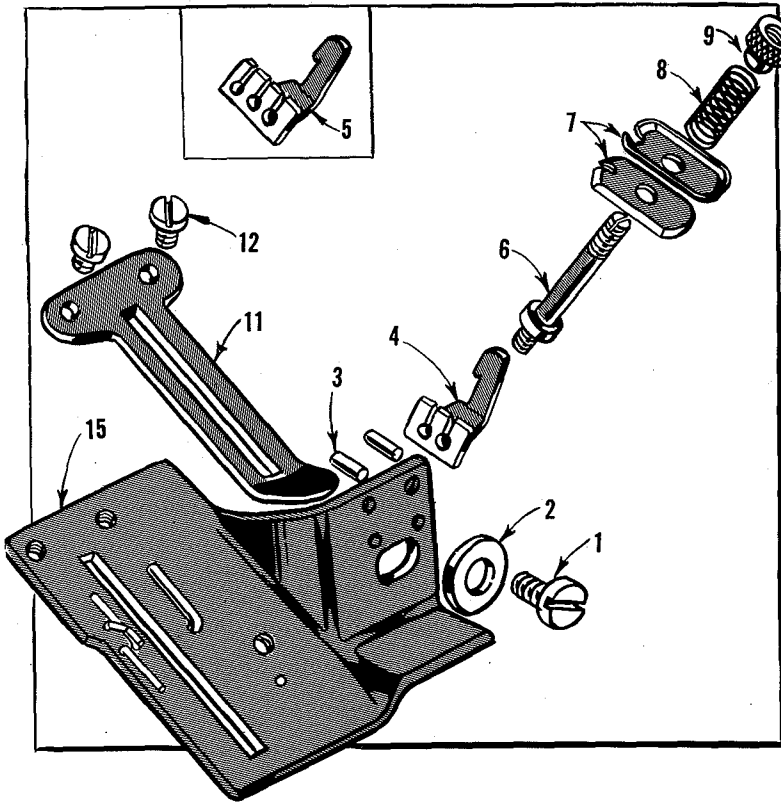
| Ref. No. | Part No. | Description | Amt. Req. |
|----------|----------|--|-----------|
| 1 | 269 | Nut, left thread ----- | 1 |
| 2 | 20 | Washer----- | 1 |
| 3 | 660-169 | Needle Bearing----- | 1 |
| 4 | 51236 D | Feed Crank Link ----- | 1 |
| 5 | 51054 | Link Pin----- | 1 |
| 6 | 666-149 | Oil Wick ----- | 1 |
| 7 | 51236 F | Feed Crank Link Ferrule----- | 1 |
| 8 | 51236 G | Feed Crank Stud----- | 1 |
| 9 | 51236 B | Feed Crank Stud Cap----- | 1 |
| 10 | 22768 | Screw----- | 2 |
| 11 | 22795 | Stitch Regulating Screw ----- | 1 |
| 12 | 51222 | Main Shaft, for Styles in Classes 51200, 51300, 51400, 51500, 51900 ----- | 1 |
| | 51722 | Main Shaft, for Styles in Class 51700 ----- | 1 |
| 13 | 77 | Screw----- | 1 |
| 14 | 51235 A | Feed Rocker Arm ----- | 1 |
| 15 | 22519 C | Screw----- | 2 |
| 16 | 51235 G | Washer----- | 2 |
| 17 | 51235 | Feed Rocker, for Styles in Classes 51200, 51300, 51400, 51500, 51700; Style 51900 BG----- | 1 |
| 18 | 98 | Screw----- | 2 |
| 19 | 51135 | Feed Rocker, for Styles 51900 BH, BJ----- | 1 |
| 20 | 98 | Screw----- | 2 |
| 21 | 22585 B | Needle Guard Screw ----- | 1 |
| 22 | 51225 W | Washer ----- | 1 |
| 23 | | Needle Guard (See Pages 29, 31) ----- | 1 |
| 24 | 22528 | Feed Dog Screw ----- | 1 |
| 25 | | Feed Dog (See Pages 33, 35, 37, 39, 41, 43) ----- | 1 |
| 26 | 77 | Screw----- | 1 |
| 27 | 51134 | Feed Bar ----- | 1 |
| 28 | 56334 E | Feed Dog Holder ----- | 1 |
| 29 | 22863 | Feed Dog Holder Adjusting Screw ----- | 1 |
| 30 | 51134 J | Feed Dog Holder Washer ----- | 1 |
| 31 | 258 A | Nut ----- | 1 |
| 32 | 538 | Feed Dog Height Adjusting Screw ----- | 1 |
| 33 | 22560 B | Screw----- | 1 |
| 34 | 22834 | Needle Guard Adjusting Screw ----- | 1 |
| 35 | 482 | Feed Rocker Shaft Collar ----- | 2 |
| 36 | 98 | Screw----- | 1 |
| 37 | 51134 C | Feed Bar Shaft ----- | 1 |
| 38 | 51134 R | Lubricating Felt Guard ----- | 1 |
| 39 | 51134 P | Lubricating Felt ----- | 1 |
| 40 | 8 | Feed Rocker Shaft ----- | 1 |
| 41 | 51423 B | Looper Thread Take-up, for Styles in Class 51400; Styles 51200 BG, BK, BP, BR, BS; 51900 BG----- | 1 |
| 42 | 96 | Spot Screw----- | 1 |
| 43 | 22580 D | Set Screw----- | 1 |
| 44 | 51423 C | Looper Thread Take-up, for Styles in Class 51500 ----- | 1 |
| 45 | 51723 A | Looper Thread Take-up, for Styles in Class 51700 ----- | 1 |
| 46 | 51523 C | Looper Thread Take-up, for Styles in Class 51300; Styles 51200 BL, BM, BT, BW, BX; 51900 BH, BJ----- | 1 |
| 47 | 51236 A | Link Pin----- | 2 |
| 48 | | Feed Lift Eccentric Assembly (See Chart Below)----- | 1 |
| 49 | 22894 D | Screw----- | 1 |
| 50 | | Feed Lift Eccentric (See Chart Below) ----- | 1 |
| 51 | 51145 A | Eccentric Bearing ----- | 1 |
| 52 | | Looper Avoid Eccentric Assembly (See Chart Below) ----- | 1 |
| 53 | | Looper Avoid Eccentric (See Chart Below) ----- | 1 |

FEED LIFT

LOOPER AVOID

| MACHINE STYLES | Ref. 48 Assembly | Ref. 50 Eccentric | Throw |
|--|------------------|-------------------|-------|
| 51200 BL, BM, BT BW, BX 51300 BG, BJ 51500 BJ, BK, BM BN, BR 51900 BH, BJ | 29476 DR | 51142 C | .080 |
| 51300 BH, BM | 29476 DS | 51142 E | .096 |
| 51200 BG, BK, BP, BR, BS 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY 51700 BJ, BK, BQ, BR 51900 BG | 29476 DV | 51406 | .062 |
| 51300 BL 51500 BP | 29476 DY | 51142 F | .112 |

| MACHINE STYLES | Ref. 52 Assembly | Ref. 53 Eccentric | Throw |
|---|------------------|-------------------|-------|
| 51200 BL, BM, BW 51300 BH, BL, BM 51500 BJ, BK, BM, BN, BP, BR 51900 BJ | 29476 DR | 51142 C | .080 |
| 51300 BG, BJ 51900 BH | 29476 DX | 51306 | .072 |
| 51200 BG, BK, BP, BR, BS, BT, BX 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY 51700 BJ, BK, BQ, BR 51900 BG | 29476 DV | 51406 | .062 |



LOOPER THREAD TAKE-UP PARTS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 22528 | Screw ----- | 1 |
| 2 | 21657 E | Washer----- | 1 |
| 3 | 50-216 Blk. | Dowel Pin ----- | 2 |
| 4 | 51459 A | Thread Guide, for Styles in Classes 51400, 51700--- | 1 |
| 5 | 51959 J | Thread Guide, for Styles in Class 51900 ----- | 1 |
| 6 | 51492 | Tension Post, for Styles in Classes 51400, 51700, 51900 ----- | 1 |
| 7 | 51959 B | Tension Disc, for Styles in Classes 51200, 51300, 51400, 51700, 51900----- | 2 |
| 8 | 51959 K | Tension Spring, for Styles in Classes 51400, 51700, 51900 ----- | 1 |
| | 51959 C | Tension Spring, for Styles in Classes 51200, 51300 ----- | 1 |
| 9 | 51959 D | Tension Nut, for Styles in Classes 51200, 51300, 51400, 51700, 51900----- | 1 |
| 10 | 51704 | Cast-off Plate, for Styles in Class 51700----- | 1 |
| 11 | 52804 A | Cast-off Plate, for Styles in Classes 51200, 51300, 51400, 51900----- | 1 |
| 12 | 28 | Screw ----- | 2 |
| 13 | 51757 B | Take-up Shield, for Styles in Class 51700 ----- | 1 |
| 14 | 51557 | Take-up Shield, for Styles in Classes 51200, 51300 ----- | 1 |
| 15 | 51457 A | Take-up Shield, for Styles in Classes 51400, 51900 ----- | 1 |
| 16 | 51257 P | Take-up Shield, for Styles in Class 51500 ----- | 1 |
| 17 | 22768 | Screw ----- | 1 |
| 18 | 52958 | Thread Eyelet, for Styles in Class 51500----- | 1 |
| 19 | 51204 B | Cast-off, for Styles in Class 51500 ----- | 1 |
| 20 | 51204 | Looper Thread Retaining Finger, for Styles in Class 51500 ----- | 1 |
| 21 | 22798 A | Screw ----- | 1 |
| 22 | 51204 A | Looper Thread Retaining Finger Holder, for Styles in Class 51500 ----- | 1 |
| 23 | 51204 C | Cast-off and Retaining Finger Support Bracket, for Styles in Class 51500----- | 1 |
| 24 | 77 | Screw ----- | 1 |
| 25 | J87 J | Screw ----- | 2 |



THREAD TENSION AND LIFTER LEVER PARTS

TENSION PARTS

| Ref. No. | Part No. | Description | AMOUNT REQUIRED | | |
|----------|----------|------------------------------|--------------------|--------------------|----------------------|
| | | | One Needle Machine | Two Needle Machine | Three Needle Machine |
| 1 | 43266 | Nut | 1 | 2 | 5 |
| 2 | 51491 C | Lead-in Guide | 2 | 4 | 6 |
| 3 | 51292 D | Tension Thread Eyelet | 2 | 4 | 6 |
| 4 | 668-25 | Eyelet | 4 | 8 | 12 |
| 5 | 668-28 | Locking Ring | 4 | 8 | 12 |
| 6 | 51292 A | Ferrule | 2 | 4 | 6 |
| 7 | 51292 G | Tension Post | 2 | 4 | 6 |
| 8 | 109 | Tension Disc | 4 | 8 | 12 |
| 9 | | Needle Thread Tension Spring | | (See Chart Below) | |
| 10 | 51292 C | Tension Nut | 2 | 4 | 6 |
| 11 | | Looper Thread Tension Spring | | (See Chart Below) | |
| 12 | 22598 C | Screw | 1 | | 1 |
| 13 | 80557 | Washer | 2 | | 2 |
| 14 | 21657-4 | Tension Disc Separator | | | 1 |
| 15 | 51992 A | Tension Post Support | | | 1 |
| 16 | 21657-4 | Tension Disc Separator | | 1 | |
| 17 | 56382 X | Tension Post Support | | 1 | |
| 18 | 21657-3 | Tension Disc Separator | 1 | | |
| 19 | 52892 | Tension Post Support | 1 | | |

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|----------|---|-----------|
| 20 | | Presser Foot (See Pages 33, 35, 37, 39, 41, 43)----- | 1 |
| 21 | 51257 K | Presser Bar, for Styles in Classes 51200, 51300, 51400, 51700; Styles 51500 BJ, BK, BM, BN, BR; 51900 BG, BH----- | 1 |
| 22 | 51957 E | Presser Bar, for Styles 51500 BP; 51900 BJ----- | 1 |
| 23 | 51257 M | Presser Bar Connection and Guide----- | 1 |
| 24 | 531 | Screw----- | 1 |
| 25 | 51256 C | Presser Spring, for Styles in Classes 51200, 51300, 51400, 51500, 51700; Styles 51900 BG, BH----- | 1 |
| | 53787 | Presser Spring, for Style 51900 BH----- | 1 |
| 26 | 56356 | Presser Spring Regulator----- | 1 |
| 27 | 402 | Screw----- | 2 |
| 28 | 53783 L | Lifter Lever Bell Crank----- | 1 |
| 29 | 52883 S | Lifter Lever Bell Crank Spring----- | 1 |
| 30 | 22557 B | Screw----- | 1 |
| 31 | 22758 C | Screw----- | 1 |
| 32 | 53783 A | Lifter Lever Link----- | 1 |
| 33 | 53783 M | Lifter Lever Connecting Rod----- | 1 |
| 34 | 53783 N | Lifter Lever, internal----- | 1 |
| 35 | 22537 | Screw----- | 1 |
| 36 | 660-207 | Oil Seal Ring----- | 1 |
| 37 | 51283 H | Lifter Lever----- | 1 |
| 38 | 22596 | Screw----- | 1 |
| 39 | 21657 Y | Tension Release and Lifter Lever Shaft Connection----- | 1 |
| 40 | 21657 W | Tension Release and Lifter Lever Shaft----- | 1 |

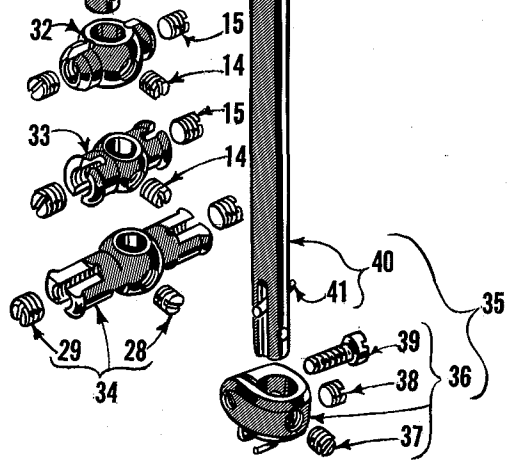
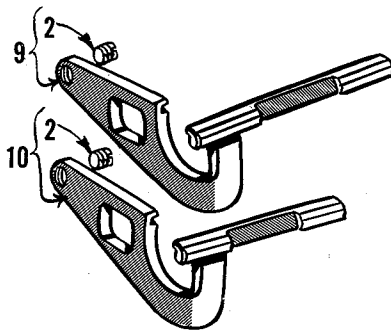
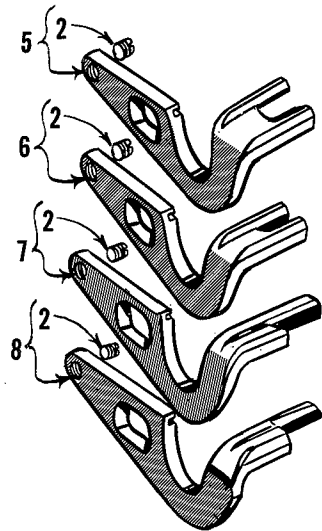
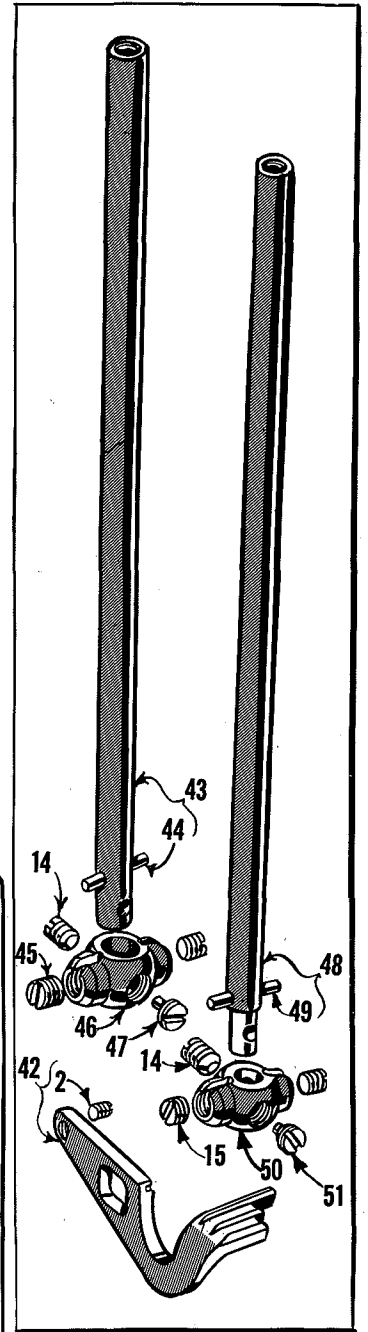
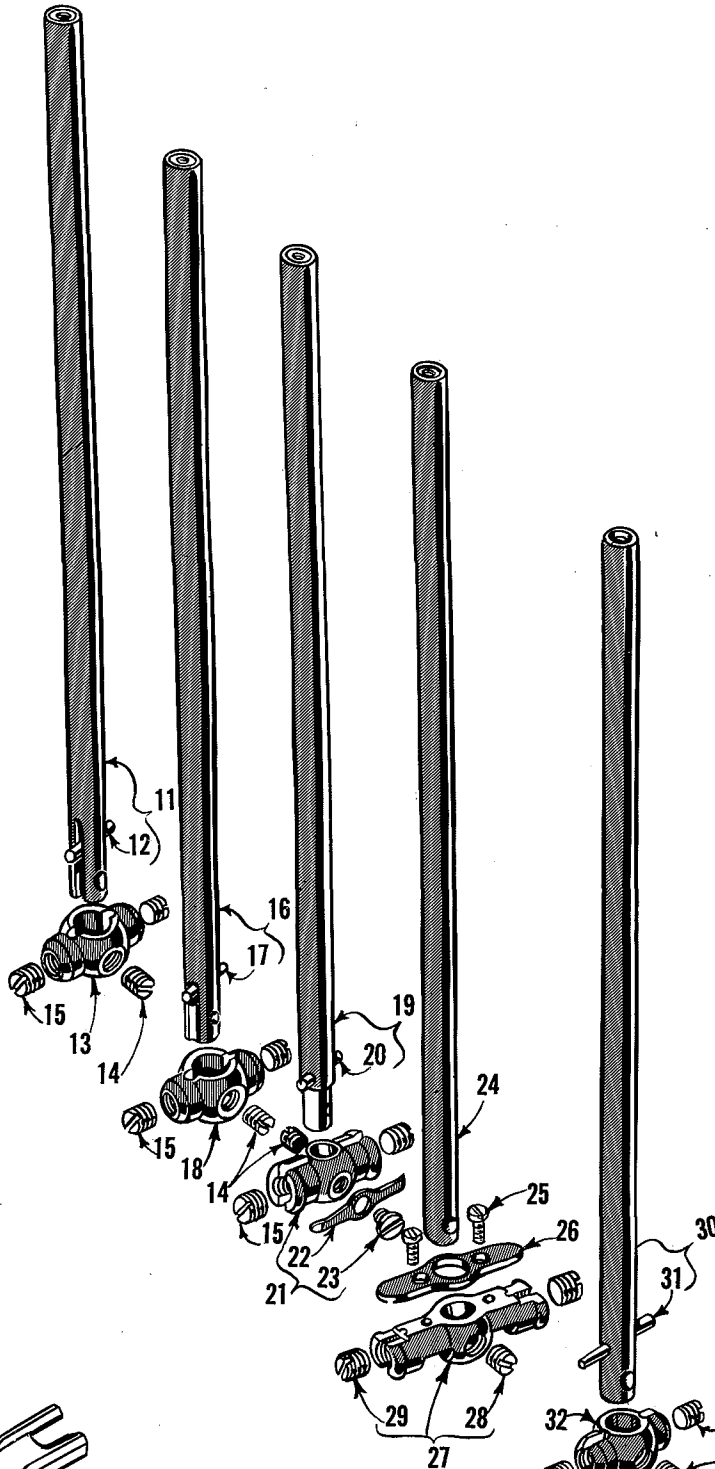
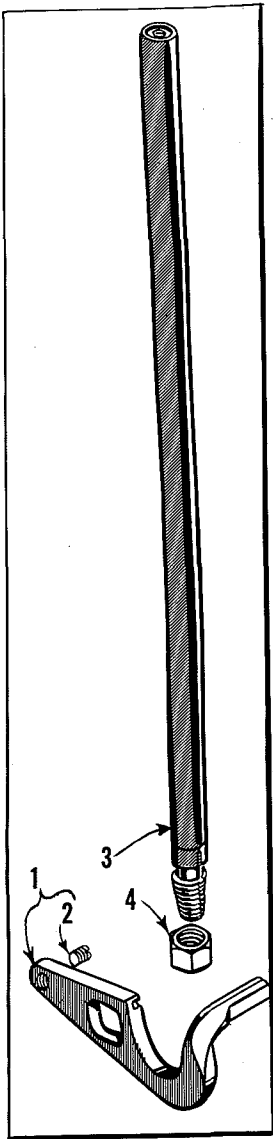
TENSION SPRING CHART

| Ref. No. | Part No. | Description | Machine Style | Amt. Req. |
|----------|------------|------------------------------|---|-----------|
| 9 | 51292 F-5 | Needle Thread Tension Spring | 51200 BK, BM, BP, BR, BS, BT | 1 |
| | | | 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BV, BW, BX, BY; | 2 |
| | | | 51700 BJ, BK, BQ, BR | |
| | | | 51900 EG | 3 |
| 9 | 51292 F-8 | Needle Thread Tension Spring | 51200 BG, BL, BW, BX; | |
| | | | 51300 EG, BJ, BL, BM | 1 |
| | | | 51500 BJ, BK, BM, BN, BP, BR | 2 |
| | | | 51900 BH, BJ | 3 |
| 9 | 51292 F-14 | Needle Thread Tension Spring | 51300 BH | 1 |
| 11 | 51292 F-1 | Looper Thread Tension Spring | 51200 BK, BM, BP, BR, BS, BT | 1 |
| | | | 51400 EA, EB, ED, EP, EQ, BR, BS, BT, BU, BV, BX, BY; | 2 |
| | | | 51700 BJ, BK, BQ, BR | |
| | | | 51900 EG | 3 |
| 11 | 51292 F-2 | Looper Thread Tension Spring | 51200 BG, BL, BW, BX; | |
| | | | 51300 EG, BH, BJ, BL, BM | 1 |
| | | | 51500 BJ, BK, BM, BN, BP, BR | 2 |
| | | | 51900 BH, BJ | 3 |



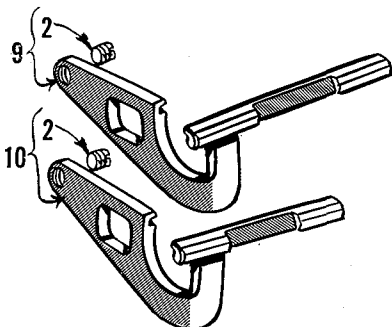
CLOTH PLATES AND CLOTH PLATE COVERS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 80 | Screw- - - - - | 3 |
| 2 | 22760 A | Screw- - - - - | 3 |
| 3 | 35772 H | Washer - - - - - | 3 |
| 4 | 22845 B | Screw- - - - - | 1 |
| 5 | 51281 AC | Cloth Plate Cover Spring, for Styles in Classes 51200, 51300, 51400, 51700, 51900; Styles 51500 BJ, BK, BN, BP, BR- - - - - | 1 |
| 6 | 22839 C | Screw- - - - - | 2 |
| 7 | 51501 | Cloth Plate, for Style 51500 BM- - - - - | 1 |
| 8 | 51281 Y-161 | Cloth Plate Cover, for Style 51500 BM- - - - - | 1 |
| 9 | 51281 Z | Cloth Plate Cover Spring, for Style 51500 BM - - - - - | 1 |
| 10 | 22726 A | Screw- - - - - | 3 |
| 11 | 51701 R | Cloth Plate, for Styles in Class 51700; No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS - - - - - | 1 |
| 12 | 53701 | Cloth Plate, for Styles 51200 BG, BK, BL, BW, BX; 51300 BH, BM; 51400 BD, BP, BT, BU, BW, BX, BY and No. 32 gauge, Style 51400 BS; 51500 BJ, BK, BN, BP, BR; 51900 BG, BH, BJ- - - - - | 1 |
| 13 | 51301 D | Cloth Plate, for Styles 51200 BM, BP, BR, BS, BT; 51300 BG, BJ, BL; 51400 BV- - - - - | 1 |
| 14 | 51281 AB-207 | Cloth Plate Cover, 3 15/64 inches long, for Styles 51200 BK, BL; 51300 BM- - - - - | 1 |
| 15 | 51281 U-207 | Cloth Plate Cover, 3 15/64 inches long, for Styles 51200 BW, BX- - - - - | 1 |
| 16 | 51281 T-190 | Cloth Plate Cover, 2 31/32 inches long, for Styles 51200 BT- - - - - | 1 |
| 17 | 51281 T-212 | Cloth Plate Cover, 3 5/16 inches long, for Styles 51200 BM; 51300 BL; No. 18 gauge, Style 51400 BV- - - - - | 1 |
| 18 | 51281 T-219 | Cloth Plate Cover, 3 27/64 inches long, for No. 16 gauge, Style 51400 BV- - - - - | 1 |
| 19 | 51281 T-222 | Cloth Plate Cover, 3 15/32 inches long, for Styles 51200 BR; 51300 BG, BJ- - - - - | 1 |
| 20 | 51281 T-227 | Cloth Plate Cover, 3 35/64 inches long, for Styles 51200 BP, BS- - - - - | 1 |
| 21 | 51281 P-187 | Cloth Plate Cover, 2 59/64 inches long, for Styles in Class 51700; No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS- - - - - | 1 |
| 22 | 51281 P-207 | Cloth Plate Cover, 3 15/64 inches long, for Styles 51200 BG; 51300 BH; 51400 BD, BP, BT, BU, BW, BX, BY; No. 32 gauge, Style 51400 BS; 51500 BJ, BK, BN, BP, BR; 51900 BG, BH, BJ- - - - - | 1 |



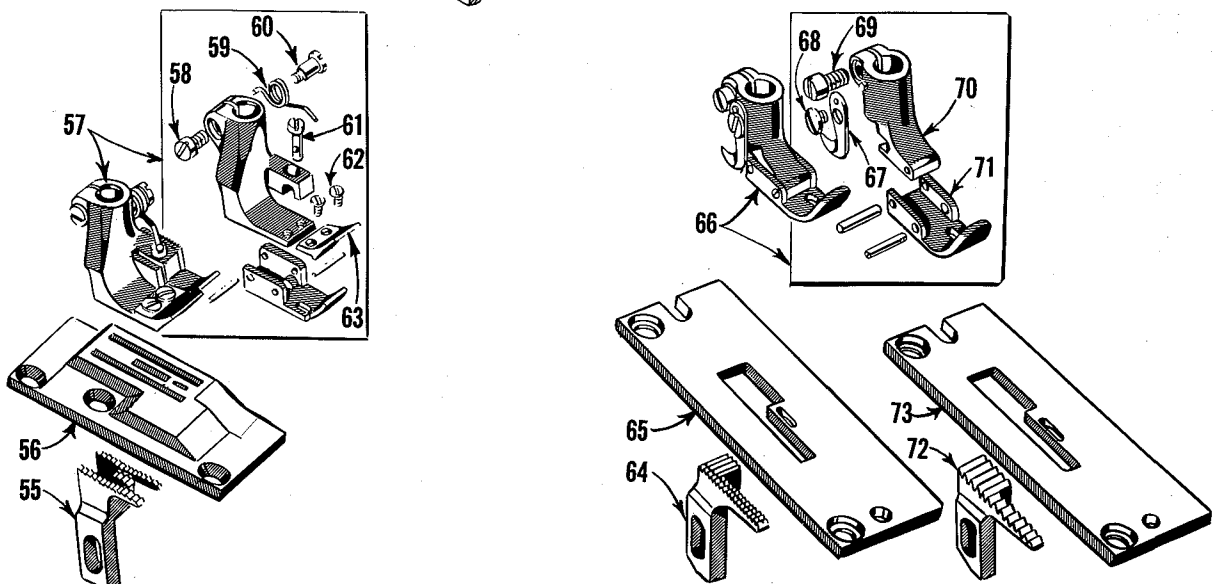
NEEDLE GUARDS, NEEDLE BARS AND NEEDLE HOLDERS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 51225 | Needle Guard, for Styles in Classes 51200, 51300 ----- | 1 |
| 2 | 22801 | Pivot Screw----- | 1 |
| 3 | 51217 C | Needle Bar, marked "CU", for Styles in Classes 51200, 51300 ----- | 1 |
| 4 | 56 | Needle Clamp Nut, for Styles in Classes 51200, 51300 ----- | 1 |
| 5 | 51525 C | Needle Guard, for Style 51500 BK ----- | 1 |
| 6 | 51525 G | Needle Guard, for Style 51500 BN ----- | 1 |
| 7 | 51425 | Needle Guard, for Styles 51400 BA, BB, BD, BP, BQ, BR, BS, BT, BU, BW, BX, BY ----- | 1 |
| 8 | 51525 | Needle Guard, for Styles 51400 BV; 51500 BJ, BM, BR ----- | 1 |
| 9 | 51725 | Needle Guard, for No. 56 to 96 gauges, Styles in Class 51700 ----- | 1 |
| 10 | 51725 A | Needle Guard, for No. 96 to 112 gauges, Styles in Class 51700 ----- | 1 |
| 11 | 51417 C-6 | Needle Bar, marked "CV-6", for No. 6 gauge, Style 51400 BP ----- | 1 |
| | 51417 C-8 | Needle Bar, marked "CV-8", for No. 8 gauge, Styles 51400 BP, BT, BW ----- | 1 |
| | 51417 C-10 | Needle Bar, marked "CV-10", for No. 10 gauge, Styles 51400 BP, BT, BW ----- | 1 |
| | 51417 C-12 | Needle Bar, marked "CV-12", for No. 12 gauge, Styles 51400B D, BP, BT, BW----- | 1 |
| | 51417 C-16 | Needle Bar, marked "CV-16", for No. 16 gauge, Styles 51400 BD, BP, BT, BW----- | 1 |
| | 51417 C-18 | Needle Bar, marked "CV-18", for No. 18 gauge, Style 51400 BP ----- | 1 |
| 12 | 50 J-16 | Stop Pin----- | 1 |
| 13 | 51418-16 | Needle Holder, marked "D-16", for all gauges, Styles 51400 BD, BP, BT, BW----- | 1 |
| 14 | 89 | Spot Screw ----- | 1 |
| 15 | 98 | Set Screw ----- | 2 |
| 16 | 56517 B-16 | Needle Bar, marked " ET ", for No. 16 gauge, Styles 51400 BV; 51500 BJ ----- | 1 |
| 17 | 50 J-16 | Stop Pin----- | 1 |
| 18 | 51418-16 | Needle Holder, marked "D-16", for No. 16 gauge, Styles 51400 BV; 51500 BJ----- | 1 |
| 19 | 56517 B-18 | Needle Bar, marked "EU", for No. 18 gauge, Styles 51400 BV; 51500 BJ, BM, BR ----- | 1 |
| 20 | 50 J-16 | Stop Pin----- | 1 |
| 21 | 7018 E-5 | Needle Holder, for No. 18 gauge, Styles 51400 BV; 51500 BJ, BM, BR ----- | 1 |
| 22 | 7040-6 | Thread Guide ----- | 1 |
| 23 | 187 B | Screw ----- | 1 |
| 24 | 51717 A | Needle Bar, marked "CZ", for Styles in Class 51700 ----- | 1 |
| 25 | 605 A | Screw ----- | 2 |
| 26 | 7933-48 | Needle Stop Plate, for No. 56 and 64 gauges, Styles in Class 51700 -- | 1 |
| | 7933-61 | Needle Stop Plate, for No. 72 to 88 gauges, Styles in Class 51700----- | 1 |
| | 16182 B | Needle Stop Plate, for No. 96 gauge, Styles in Class 51700----- | 1 |
| | 16182 C | Needle Stop Plate, for No. 128 gauge, Styles in Class 51700----- | 1 |
| 27 | 51718 A-56 | Needle Holder, marked "AB-56", for No. 56 gauge, Styles in Class 51700----- | 1 |
| | 51718 A-64 | Needle Holder, marked "AB-64", for No. 64 gauge, Styles in Class 51700----- | 1 |
| | 51718 A-72 | Needle Holder, marked "AB-72", for No. 72 gauge, Styles in Class 51700----- | 1 |
| | 51718 A-80 | Needle Holder, marked "AB-80", for No. 80 gauge, Styles in Class 51700----- | 1 |
| | 51718 A-88 | Needle Holder, marked "AB-88", for No. 88 gauge, Styles in Class 51700----- | 1 |
| | 51718 A-96 | Needle Holder, marked "AB-96", for No. 96 gauge, Styles in Class 51700----- | 1 |
| | 51718 A-112 | Needle Holder, marked "AB-112", for No. 112 gauge, Styles in Class 51700----- | 1 |
| | 51718 A-128 | Needle Holder, marked "AB-128", for No. 128 gauge, Styles in Class 51700----- | 1 |
| 28 | 22894 P | Spot Screw ----- | 1 |
| 29 | 98 | Needle Set Screw----- | 2 |
| 30 to 51 | | See following page | |



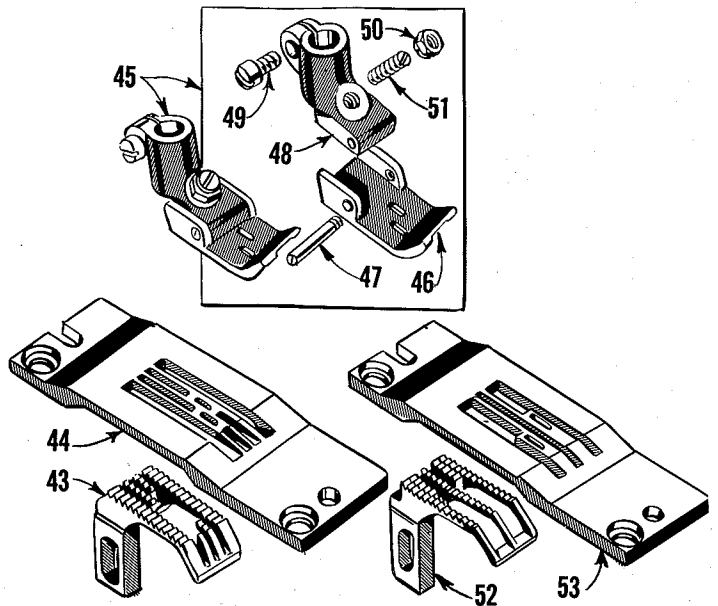
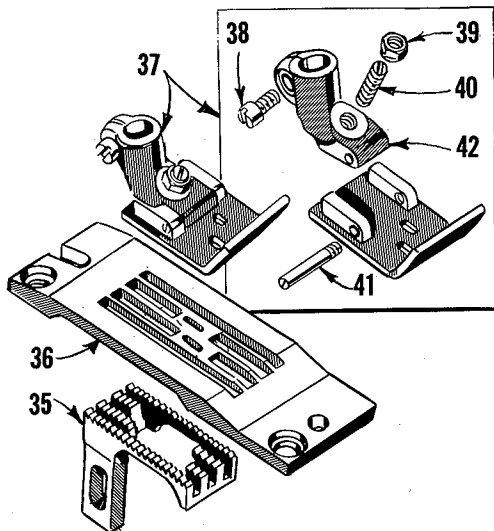
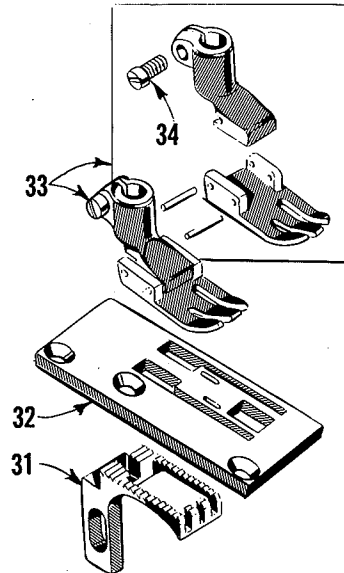
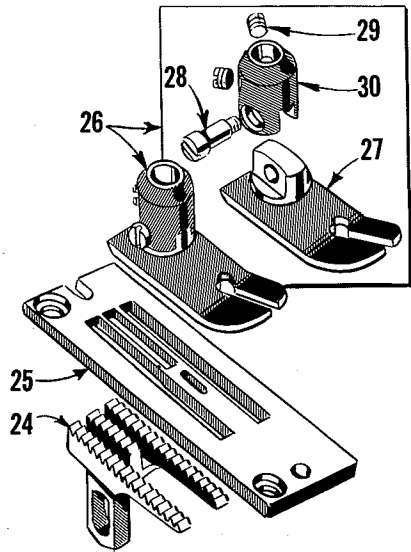
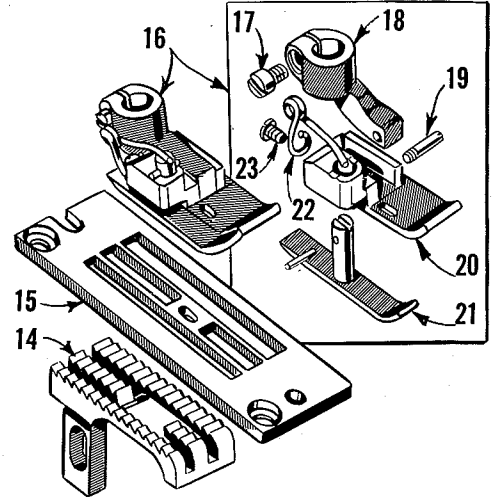
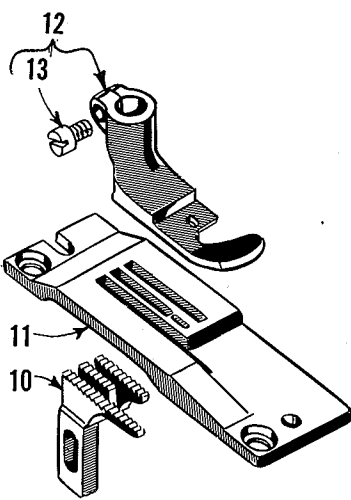
NEEDLE GUARDS, NEEDLE BARS AND NEEDLE HOLDERS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|---|------------------|
| 1 to 29 | | See preceding page | |
| 30 | 51417 D | Needle Bar, marked "DE", for Nos. 24, 26, 32, 48 gauges, Styles 51400 BA, BB, BQ, BR, BS, BU, BX, BY----- | 1 |
| 31 | 50 J-40 | Stop Pin----- | 1 |
| 32 | 51418 K-24 | Needle Holder, marked "L-24", for No. 24 gauge, Style 51400 BX----- | 1 |
| | 51418 K-26 | Needle Holder, marked "L-26", for No. 26 gauge, Style 51400 BX----- | 1 |
| 33 | 51418 B-32 | Needle Holder, marked "D-32", for No. 32 gauge, Styles 51400 BS, BU, BY----- | 1 |
| 34 | 51418 D-48 | Needle Holder, marked "AC-48", for No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS----- | 1 |
| 35 | 29202 E-1 | Needle Bar Assembly, for No. 1 gauge, Style 51500 BK-- | 1 |
| | 29202 F-1 | Needle Bar Assembly, for No. 1 gauge, Style 51500 BN-- | 1 |
| 36 | 51518 C-1 | Needle Holder, for No. 1 gauge, Style 51500 BK---- | 1 |
| | 51518 G-1 | Needle Holder, for No. 1 gauge, Style 51500 BN---- | 1 |
| 37 | 89 | Spot Screw----- | 1 |
| 38 | 88 B | Needle Set Screw----- | 1 |
| 39 | 22729 | Needle Clamp Screw----- | 1 |
| 40 | 56517 E-1 | Needle Bar, marked "EL", for No. 1 gauge, Style 51500 BK----- | 1 |
| | 56517 D-1 | Needle Bar, marked "EK", for No. 1 gauge, Style 51500 BN----- | 1 |
| 41 | 50 J-16 | Stop Pin----- | 1 |
| 42 | 51925 | Needle Guard, for Styles 51500 BP; 51900 BG, BH, BJ---- | 1 |
| 43 | 56917 | Needle Bar, marked "EP-9", for No. 18 gauge, Style 51500 BP; Nos. 8 and 9 gauges, Styles 51900 BH, BJ--- | 1 |
| 44 | 50 J-26 | Stop Pin----- | 1 |
| 45 | 22580 | Needle Set Screw, outer----- | 2 |
| 46 | 35818 N-8 | Needle Holder, marked "C-8", for No. 8 gauge, Style 51900 BH----- | 1 |
| | 35818 N-9 | Needle Holder, marked "C-9", for No. 18 gauge, Style 51500 BP; No. 9 gauge, Styles 51900 BH, BJ----- | 1 |
| 47 | 22752 | Needle Set Screw, middle----- | 1 |
| 48 | 51917 A | Needle Bar, marked "DC", for Nos. 5, 6, 7 gauges, Styles 51900 BG, BH----- | 1 |
| 49 | 50 J-26 | Stop Pin----- | 1 |
| 50 | 51918-5 | Needle Holder, marked "E-5", for No. 5 gauge, Style 51900 BG----- | 1 |
| | 51918-6 | Needle Holder, marked "E-6", for No. 6 gauge, Style 51900 BG----- | 1 |
| | 51918-7 | Needle Holder, marked "E-7", for No. 7 gauge, Style 51900 BG----- | 1 |
| 51 | 22752 A | Needle Set Screw, middle----- | 1 |



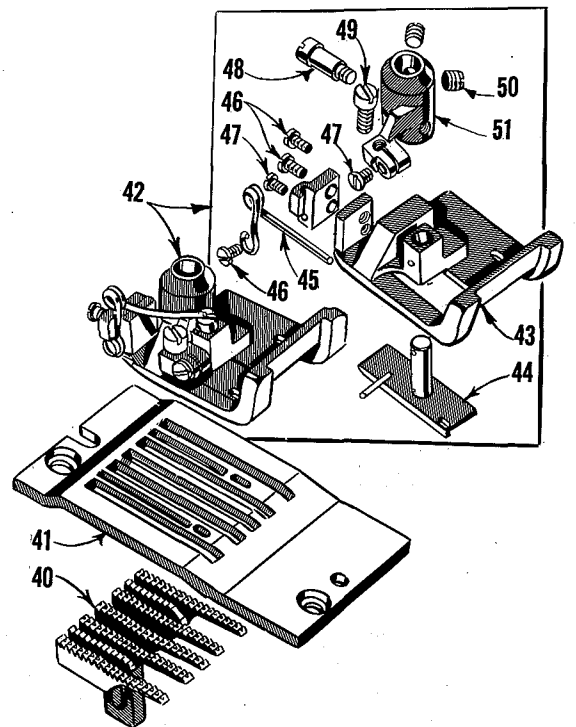
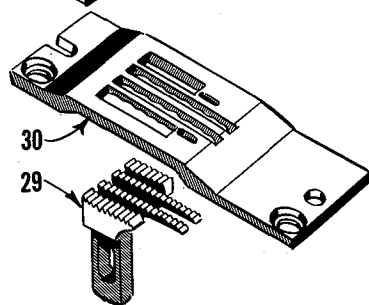
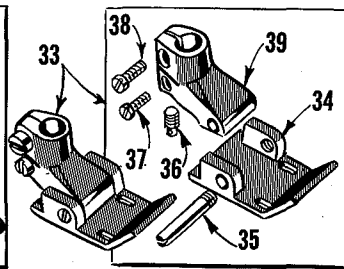
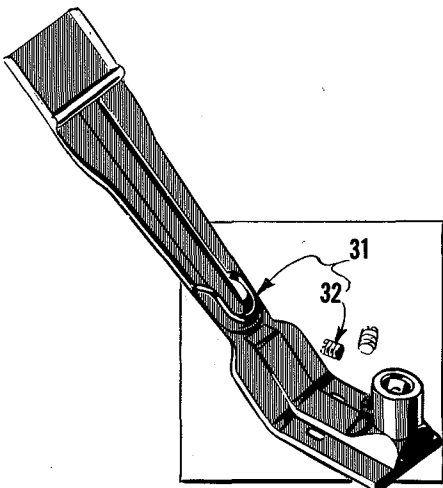
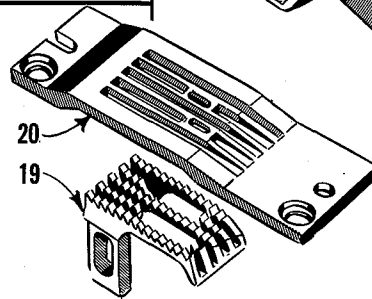
FEED DOGS, THROAT PLATES, PRESSER FEET

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|----------|---------------------------------------|-----------|
| 1 | 22 I | Feed Dog, for Style 51200 BS- | 1 |
| 2 | 195 D | Throat Plate, for Style 51200 BS- | 1 |
| 3 | 65 A | Presser Foot, for Style 51200 BS- | 1 |
| 4 | 65 AD | Presser Foot Bottom- | 1 |
| 5 | 91 | Clamp Screw- | 1 |
| 6 | 22 D | Feed Dog, for Style 51200 BP- | 1 |
| 7 | 1724 F | Throat Plate, for Style 51200 BP- | 1 |
| 8 | 51220 E | Presser Foot, for Style 51200 BP- | 1 |
| 9 | 51230 E | Presser Foot Bottom- | 1 |
| 10 | 22799 G | Hinge Screw- | 1 |
| 11 | 51230 | Presser Foot Shank | 1 |
| 12 | 91 | Clamp Screw- | 1 |
| 13 | 6235 | Spring Toe | 1 |
| 14 | 91 A | Screw- | 1 |
| 15 | 51305 A | Feed Dog, for Styles 51300 BG, BJ | 1 |
| 16 | 9224 E | Throat Plate, for Styles 51300 BG, BJ | 1 |
| 17 | 51320 G | Presser Foot, for Style 51300 BG- | 1 |
| 18 | 6530 A | Presser Foot Bottom- | 1 |
| 19 | 22799 B | Hinge Screw- | 1 |
| 20 | 1741 B | Chain Cutting Knife- | 1 |
| 21 | 187 A | Screw- | 1 |
| 22 | 91 | Clamp Screw- | 1 |
| 23 | 6530 | Presser Foot Shank | 1 |
| 24 | 51320 C | Presser Foot, for Style 51300 BJ- | 1 |
| 25 | 51330 C | Presser Foot Bottom- | 1 |
| 26 | 51530 A | Presser Foot Shank | 1 |
| 27 | 91 | Clamp Screw- | 1 |
| 28 | 22799 B | Hinge Screw- | 1 |
| 29 | 6405 W | Feed Dog, for Style 51200 BM- | 1 |
| 30 | 6424 W | Throat Plate, for Style 51200 BM- | 1 |
| 31 | 6420 W | Presser Foot, for Style 51200 BM- | 1 |
| 32 | 22799 E | Hinge Screw- | 1 |
| 33 | 6430 | Presser Foot Shank | 1 |
| 34 | 91 | Clamp Screw- | 1 |
| 35 | 51430 F | Adjusting Nut- | 1 |
| 36 | 22840 A | Adjusting Screw- | 1 |
| 37 | 6430 A | Presser Foot Bottom- | 1 |
| 38 | 6405 U | Feed Dog, for Style 51200 BT- | 1 |
| 39 | 6428 L | Throat Plate, for Style 51200 BT- | 1 |
| 40 | 51220 J | Presser Foot, for Style 51200 BT- | 1 |
| 41 | 11534 | Yielding Section Spring- | 1 |
| 42 | 605 | Screw- | 1 |
| 43 | 91 | Clamp Screw- | 1 |
| 44 | 187 A | Screw- | 1 |
| 45 | 22799 B | Hinge Screw- | 1 |
| 46 | 197 X | Feed Dog, for Style 51300 BL- | 1 |
| 47 | 6624 | Throat Plate, for Style 51300 BL- | 1 |
| 48 | 6627 A | Presser Foot, for Style 51300 BL- | 1 |
| 49 | 1741 B | Chain Cutting Knife- | 1 |
| 50 | 187 A | Screw- | 1 |
| 51 | 86 X | Hinge Screw- | 1 |
| 52 | 88 | Set Screw- | 2 |
| 53 | 25 B | Screw- | 2 |
| 54 | 199 | Needle Guard | 1 |
| 55 | 9705 | Feed Dog, for Style 51200 BR- | 1 |
| 56 | 9724 | Throat Plate, for Style 51200 BR- | 1 |
| 57 | 9720 | Presser Foot, for Style 51200 BR- | 1 |
| 58 | 91 | Clamp Screw- | 1 |
| 59 | 9634 | Yielding Section Spring- | 1 |
| 60 | 57 WD | Screw- | 1 |
| 61 | 9634 A | Spring Pin | 1 |
| 62 | 605 | Screw- | 2 |
| 63 | 9735 | Detachable Toe | 1 |
| 64 | 22 W | Feed Dog, for Style 51200 BX- | 1 |
| 65 | 51224 X | Throat Plate, for Style 51200 EX- | 1 |
| 66 | 51220 W | Presser Foot, for Styles 51200 BW, BX | 1 |
| 67 | 1741 B | Chain Cutting Knife- | 1 |
| 68 | 187 B | Screw- | 1 |
| 69 | 91 | Clamp Screw- | 1 |
| 70 | 51230 F | Presser Foot Shank | 1 |
| 71 | 51230 G | Presser Foot Bottom- | 1 |
| 72 | 51205 W | Feed Dog, for Style 51200 BW- | 1 |
| 73 | 51224 E | Throat Plate, for Style 51200 BW- | 1 |



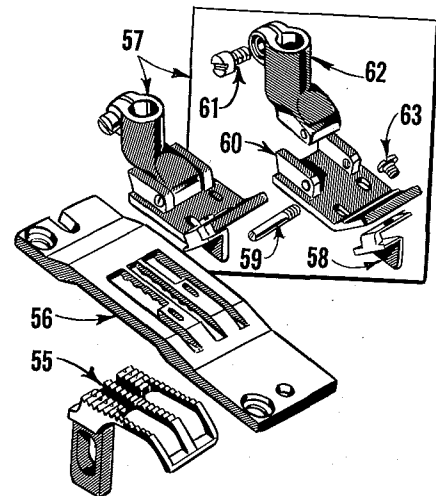
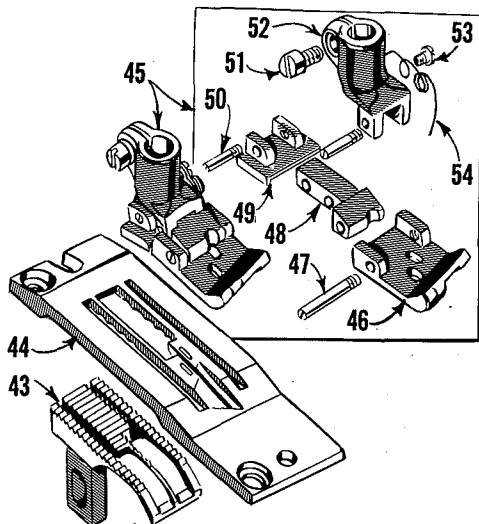
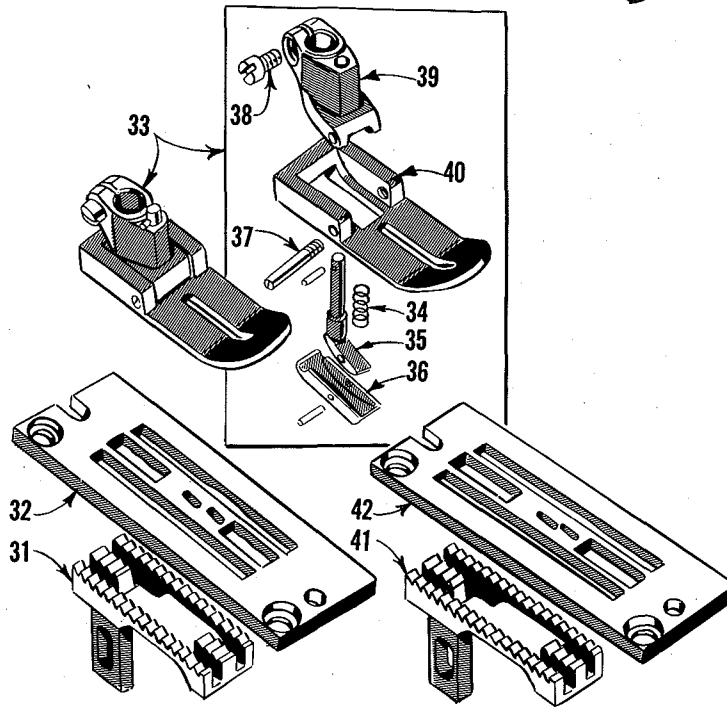
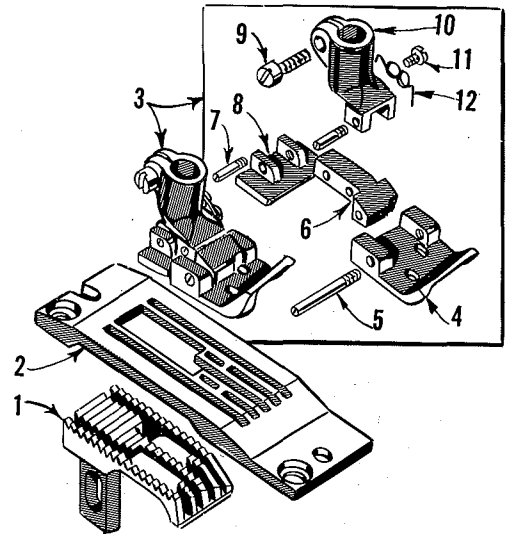
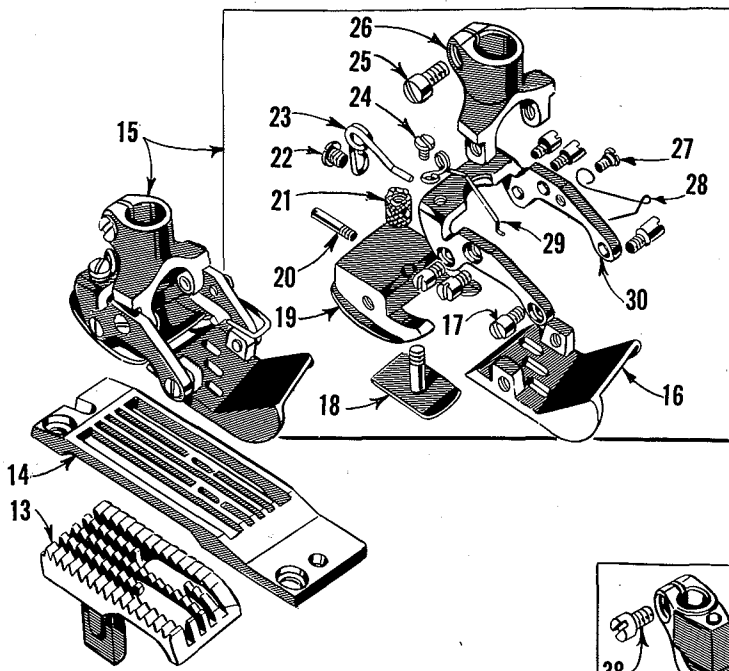
FEED DOGS, THROAT PLATES, PRESSER FEET

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 6405 M | Feed Dog, for Styles 51200 BL; 51300 BM----- | 1 |
| 2 | 51224 B | Throat Plate, for Styles 51200 BL; 51300 BM----- | 1 |
| 3 | 6420 W | Presser Foot, for Styles 51200 BL; 51300 BM----- | 1 |
| 4 | 22799 E | Hinge Screw----- | 1 |
| 5 | 6430 | Presser Foot Shank----- | 1 |
| 6 | 91 | Clamp Screw----- | 1 |
| 7 | 51430 F | Adjusting Nut----- | 1 |
| 8 | 22840 A | Adjusting Screw----- | 1 |
| 9 | 6430 A | Presser Foot Bottom----- | 1 |
| 10 | 51205 A | Feed Dog, for Style 51200 BK----- | 1 |
| 11 | 51224 A | Throat Plate, for Style 51200 BK----- | 1 |
| 12 | 51220 A | Presser Foot, for Style 51200 BK----- | 1 |
| 13 | 91 | Clamp Screw----- | 1 |
| 14 | 51205 F | Feed Dog, for Style 51200 BG----- | 1 |
| 15 | 51224 F | Throat Plate, for Style 51200 BG----- | 1 |
| 16 | 56320 R | Presser Foot, for Style 51200 BG----- | 1 |
| 17 | 91 | Clamp Screw----- | 1 |
| 18 | 56330 D | Presser Foot Shank----- | 1 |
| 19 | 22799 G | Hinge Screw----- | 1 |
| 20 | 56330 C | Presser Foot Bottom----- | 1 |
| 21 | 51230 N | Yielding Section----- | 1 |
| 22 | 19146 A | Yielding Section Spring----- | 1 |
| 23 | 604 | Screw----- | 1 |
| 24 | 51305 B | Feed Dog, for Style 51300 BH----- | 1 |
| 25 | 51324 B | Throat Plate, for Style 51300 BH----- | 1 |
| 26 | 51320 B | Presser Foot, for Style 51300 BH----- | 1 |
| 27 | 51330 B | Presser Foot Bottom----- | 1 |
| 28 | 86 X | Hinge Screw----- | 1 |
| 29 | 88 | Set Screw----- | 2 |
| 30 | 65 XD | Presser Foot Shank----- | 1 |
| 31 | 7005 A-6 | Feed Dog, for No. 18 gauge, Style 51400 BV----- | 1 |
| 32 | 7024 C-5 | Throat Plate, for No. 18 gauge, Style 51400 BV----- | 1 |
| 33 | 7020 B-4 1/2 | Presser Foot, for No. 16 gauge, Style 51400 BV----- | 1 |
| | 7020 B-5 | Presser Foot, for No. 18 gauge, Style 51400 BV----- | 1 |
| 34 | 91 | Clamp Screw----- | 1 |
| 35 | 51405 AD-12 | Feed Dog, for No. 12 gauge, Style 51400 BD----- | 1 |
| | 51405 AD-16 | Feed Dog, for No. 16 gauge, Style 51400 BD----- | 1 |
| 36 | 51424 AD-12 | Throat Plate, for No. 12 gauge, Style 51400 BD----- | 1 |
| | 51424 AD-16 | Throat Plate, for No. 16 gauge, Style 51400 BD----- | 1 |
| 37 | 51420 AD-12 | Presser Foot, for No. 12 gauge, Style 51400 BD----- | 1 |
| | 7420 AG-4 1/2 | Presser Foot, for No. 16 gauge, Style 51400 BD----- | 1 |
| 38 | 91 | Clamp Screw----- | 1 |
| 39 | 51430 F | Adjusting Nut----- | 1 |
| 40 | 22840 A | Adjusting Screw----- | 1 |
| 41 | 22799 E | Hinge Screw----- | 1 |
| 42 | 51430 D | Presser Foot Shank----- | 1 |
| 43 | 51405 A-8 | Feed Dog, for Nos. 6 and 8 gauge, Style 51400 BP----- | 1 |
| | 51405 A-10 | Feed Dog, for Nos. 10 and 12 gauge, Style 51400 BP----- | 1 |
| 44 | 51424 A-6 | Throat Plate, for No. 6 gauge, Style 51400 BP----- | 1 |
| | 51424 A-8 | Throat Plate, for No. 8 gauge, Style 51400 BP----- | 1 |
| | 51424 A-10 | Throat Plate, for No. 10 gauge, Style 51400 BP----- | 1 |
| | 51424 A-12 | Throat Plate, for No. 12 gauge, Style 51400 BP----- | 1 |
| 45 | 51420-6 | Presser Foot, for No. 6 gauge, Style 51400 BP----- | 1 |
| | 51420-8 | Presser Foot, for No. 8 gauge, Style 51400 BP----- | 1 |
| | 51420-10 | Presser Foot, for No. 10 gauge, Style 51400 BP----- | 1 |
| | 51420-12 | Presser Foot, for No. 12 gauge, Style 51400 BP----- | 1 |
| | 51420-16 | Presser Foot, for No. 16 gauge, Style 51400 BP----- | 1 |
| | 51420-18 | Presser Foot, for No. 18 gauge, Style 51400 BP----- | 1 |
| 46 | 51430 A-6 | Presser Foot Bottom, for No. 6 gauge, Style 51400 BP----- | 1 |
| | 51430 A-8 | Presser Foot Bottom, for No. 8 gauge, Style 51400 BP----- | 1 |
| | 51430 A-10 | Presser Foot Bottom, for No. 10 gauge, Style 51400 BP----- | 1 |
| | 51430 A-12 | Presser Foot Bottom, for No. 12 gauge, Style 51400 BP----- | 1 |
| | 51430 A-16 | Presser Foot Bottom, for No. 16 gauge, Style 51400 BP----- | 1 |
| | 51430 A-18 | Presser Foot Bottom, for No. 18 gauge, Style 51400 BP----- | 1 |
| 47 | 22799 B | Hinge Screw----- | 1 |
| 48 | 51430 D | Presser Foot Shank----- | 1 |
| 49 | 91 | Clamp Screw----- | 1 |
| 50 | 51430 F | Adjusting Nut----- | 1 |
| 51 | 22840 A | Adjusting Screw----- | 1 |
| 52 | 51405-16 | Feed Dog, for Nos. 16 and 18 gauge, Style 51400 BP----- | 1 |
| 53 | 51424-16 | Throat Plate, for No. 16 gauge, Style 51400 BP----- | 1 |
| | 51424-18 | Throat Plate, for No. 18 gauge, Style 51400 BP----- | 1 |



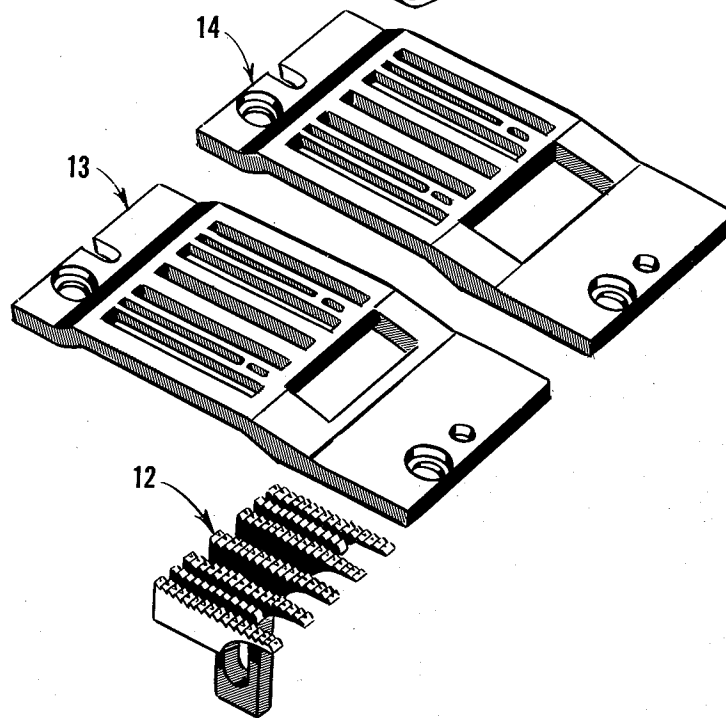
FEED DOGS, THROAT PLATES, PRESSER FEET

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|------------|--|-----------|
| 1 | 51405 B-32 | Feed Dog, for No. 32 gauge, Style 51400 BS | 1 |
| | 51405 B-48 | Feed Dog, for No. 48 gauge, Style 51400 BS | 1 |
| 2 | 51424 B-32 | Throat Plate, for No. 32 gauge, Style 51400 BS | 1 |
| | 51424 B-48 | Throat Plate, for No. 48 gauge, Style 51400 BS | 1 |
| 3 | 51420 C-32 | Presser Foot, for No. 32 gauge, Style 51400 BS | 1 |
| | 51420 C-48 | Presser Foot, for No. 48 gauge, Style 51400 BS | 1 |
| 4 | 51430 C-32 | Presser Foot Bottom, for No. 32 gauge, Style 51400 BS | 1 |
| | 51430 C-48 | Presser Foot Bottom, for No. 48 gauge, Style 51400 BS | 1 |
| 5 | 22799 D | Hinge Screw | 1 |
| 6 | 22752 B | Adjusting Screw | 1 |
| 7 | 77 | Clamp Screw, lower | 1 |
| 8 | 91 | Clamp Screw, upper | 1 |
| 9 | 51430 | Presser Foot Shank | 1 |
| 10 | 51405 G-8 | Feed Dog, for Nos. 8, 10 and 12 gauge, Style 51400 BT | 1 |
| | 51405 G-16 | Feed Dog, for No. 16 gauge, Style 51400 BT | 1 |
| 11 | 51424 E-8 | Throat Plate, for No. 8 gauge, Style 51400 BT | 1 |
| | 51424 E-10 | Throat Plate, for No. 10 gauge, Style 51400 BT | 1 |
| | 51424 E-12 | Throat Plate, for No. 12 gauge, Style 51400 BT | 1 |
| | 51424 E-16 | Throat Plate, for No. 16 gauge, Style 51400 BT | 1 |
| 12 | 51420 E-8 | Presser Foot, for No. 8 gauge, Style 51400 BT | 1 |
| | 51420 E-10 | Presser Foot, for No. 10 gauge, Style 51400 BT | 1 |
| | 51420 E-12 | Presser Foot, for No. 12 gauge, Style 51400 BT | 1 |
| | 51420 E-16 | Presser Foot, for No. 16 gauge, Style 51400 BT | 1 |
| 13 | 51430 E-8 | Presser Foot Bottom, for No. 8 gauge, Style 51400 BT | 1 |
| | 51430 E-10 | Presser Foot Bottom, for No. 10 gauge, Style 51400 BT | 1 |
| | 51430 E-12 | Presser Foot Bottom, for No. 12 gauge, Style 51400 BT | 1 |
| | 51430 E-16 | Presser Foot Bottom, for No. 16 gauge, Style 51400 BT | 1 |
| 14 | 22799 B | Hinge Screw | 1 |
| 15 | 51430 D | Presser Foot Shank | 1 |
| 16 | 91 | Clamp Screw | 1 |
| 17 | 22840 A | Adjusting Screw | 1 |
| 18 | 51430 F | Adjusting Nut | 1 |
| 19 | 51505-18 | Feed Dog, for Nos. 16 and 18 gauge, Style 51500 BJ | 1 |
| 20 | 51524-16 | Throat Plate, for No. 16 gauge, Style 51500 BJ | 1 |
| | 51524-18 | Throat Plate, for No. 18 gauge, Style 51500 BJ | 1 |
| 21 | 51520-16 | Presser Foot, for No. 16 gauge, Style 51500 BJ | 1 |
| | 51520-18 | Presser Foot, for No. 18 gauge, Style 51500 BJ | 1 |
| 22 | 51530-16 | Presser Foot Bottom, for No. 16 gauge, Style 51500 BJ | 1 |
| | 51530-18 | Presser Foot Bottom, for No. 18 gauge, Style 51500 BJ | 1 |
| 23 | 22799 C | Hinge Screw | 1 |
| 24 | 51930 | Spring | 1 |
| 25 | 35830 | Presser Foot Shank | 1 |
| 26 | 91 | Clamp Screw | 1 |
| 27 | 7527 U-5 | Presser Foot, for No. 18 gauge, Style 51500 BM | 1 |
| 28 | 91 | Clamp Screw | 1 |
| 29 | 51405 F-32 | Feed Dog, for No. 32 gauge, Styles 51400 BU, BY | 1 |
| 30 | 51424 F-32 | Throat Plate, for No. 32 gauge, Styles 51400 BU, BY | 1 |
| 31 | 51420 L-32 | Folder Presser Foot, for No. 32 gauge, Style 51400 BY | 1 |
| 32 | 88 | Screw | 2 |
| 33 | 51420 C-32 | Presser Foot, for No. 32 gauge, Style 51400 BU | 1 |
| | 51420 C-48 | Presser Foot, for No. 48 gauge, Styles 51400 BB, BR | 1 |
| 34 | 51430 C-32 | Presser Foot Bottom, for No. 32 gauge, Style 51400 BU | 1 |
| | 51430 C-48 | Presser Foot Bottom, for No. 48 gauge, Styles 51400 BB, BR | 1 |
| 35 | 22799 D | Hinge Screw | 1 |
| 36 | 22752 B | Adjusting Screw | 1 |
| 37 | 77 | Clamp Screw, lower | 1 |
| 38 | 91 | Clamp Screw, upper | 1 |
| 39 | 51430 | Presser Foot Shank | 1 |
| 40 | 51405 C-48 | Feed Dog, for No. 48 gauge, Styles 51400 BA, BB, BR | 1 |
| 41 | 51424 C-48 | Throat Plate, for No. 48 gauge, Styles 51400 BA, BB, BR | 1 |
| 42 | 51420 M-48 | Presser Foot, for No. 48 gauge, Style 51400 BA | 1 |
| 43 | 51430 M-48 | Presser Foot Bottom, for No. 48 gauge, Style 51400 BA | 1 |
| 44 | 51430 N-48 | Yielding Section, for No. 48 gauge, Style 51400 BA | 1 |
| 45 | 16194 | Yielding Section Spring | 1 |
| 46 | 605 | Screw | 3 |
| 47 | 605 A | Screw | 2 |
| 48 | 86 X | Hinge Screw | 1 |
| 49 | 97 | Screw | 1 |
| 50 | 88 | Set Screw | 2 |
| 51 | 51430 G | Presser Foot Shank | 1 |



FEED DOGS, THROAT PLATES, PRESSER FEET

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 51505 BR-18 | Feed Dog, for No. 18 gauge, Style 51500 BR----- | 1 |
| 2 | 51524 BR-18 | Throat Plate, for No. 18 gauge, Style 51500 BR----- | 1 |
| 3 | 51520 BR-18 | Presser Foot, for No. 18 gauge, Style 51500 BR----- | 1 |
| 4 | 51530 BR-18 | Bottom, front section----- | 1 |
| 5 | 22799 C | Hinge Screw----- | 1 |
| 6 | 35730 AC | Hinged Section----- | 1 |
| 7 | 22799 G | Hinge Screw----- | 2 |
| 8 | 51530 J | Bottom, rear section----- | 1 |
| 9 | 91 | Clamp Screw----- | 1 |
| 10 | 35730 AD | Shank----- | 1 |
| 11 | 73 A | Screw----- | 1 |
| 12 | 35730 AE | Spring----- | 1 |
| 13 | K65184 | Feed Dog, for No. 18 gauge, Style 51500 BP----- | 1 |
| 14 | K65183 | Throat Plate, for No. 18 gauge, Style 51500 BP----- | 1 |
| 15 | 35820 R-9 | Presser Foot, for No. 18 gauge, Style 51500 BP----- | 1 |
| 16 | 35830 R-9 | Bottom, front section----- | 1 |
| 17 | 22845 A | Hinge Screw----- | 6 |
| 18 | 35830 E | Yielding Section----- | 1 |
| 19 | 35830 G | Bottom, rear section----- | 1 |
| 20 | 22799 L | Set Screw----- | 1 |
| 21 | 35830 F | Adjusting Nut----- | 1 |
| 22 | 73 A | Screw----- | 1 |
| 23 | 35830 D | Yielding Section Spring----- | 1 |
| 24 | 22561 | Screw----- | 1 |
| 25 | 91 D | Clamp Screw----- | 1 |
| 26 | 35830 B | Shank----- | 1 |
| 27 | 22599 | Screw----- | 1 |
| 28 | 35830 K | Equalizing Spring, front----- | 1 |
| 29 | 35830 H | Equalizing Spring, rear section----- | 1 |
| 30 | 35830 C | Yoke----- | 1 |
| 31 | 51505 C-1 | Feed Dog, for No. 1 gauge, Style 51500 BK----- | 1 |
| 32 | 56528 C-1 | Throat Plate, for No. 1 gauge, Style 51500 BK----- | 1 |
| 33 | 51520 C-1 | Presser Foot, for No. 1 gauge, Style 51500 BK, BN----- | 1 |
| 34 | 51530 G | Plunger Spring----- | 1 |
| 35 | 51530 F | Plunger----- | 1 |
| 36 | 51530 E | Yielding Section----- | 1 |
| 37 | 22799 C | Hinge Screw----- | 1 |
| 38 | 91 | Clamp Screw----- | 1 |
| 39 | 51530 D | Shank----- | 1 |
| 40 | 51530 C-1 | Bottom----- | 1 |
| 41 | 51505 G-1 | Feed Dog, for No. 1 gauge, Style 51500 BN----- | 1 |
| 42 | 51524 G-1 | Throat Plate, for No. 1 gauge, Style 51500 BN----- | 1 |
| 43 | 51405 R-8 | Feed Dog, for Nos. 8 and 10 gauge, Style 51400 BW----- | 1 |
| | 51405 R-12 | Feed Dog, for Nos. 12 and 16 gauge, Style 51400 BW----- | 1 |
| 44 | 51424 R-8 | Throat Plate, for No. 8 gauge, Style 51400 BW----- | 1 |
| | 51424 R-10 | Throat Plate, for No. 10 gauge, Style 51400 BW----- | 1 |
| | 51424 R-12 | Throat Plate, for No. 12 gauge, Style 51400 BW----- | 1 |
| | 51424 R-16 | Throat Plate, for No. 16 gauge, Style 51400 BW----- | 1 |
| 45 | 51420 R-8 | Presser Foot, for No. 8 gauge, Style 51400 BW----- | 1 |
| | 51420 R-10 | Presser Foot, for No. 10 gauge, Style 51400 BW----- | 1 |
| | 51420 R-12 | Presser Foot, for No. 12 gauge, Style 51400 BW----- | 1 |
| | 51420 R-16 | Presser Foot, for No. 16 gauge, Style 51400 BW----- | 1 |
| 46 | 51430 R-8 | Bottom, front section, for No. 8 gauge, Style 51400 BW----- | 1 |
| | 51430 R-10 | Bottom, front section, for No. 10 gauge, Style 51400 BW----- | 1 |
| | 51430 R-12 | Bottom, front section, for No. 12 gauge, Style 51400 BW----- | 1 |
| | 51430 R-16 | Bottom, front section, for No. 16 gauge, Style 51400 BW----- | 1 |
| 47 | 22799 E | Hinge Screw----- | 1 |
| 48 | 35730 AC | Hinged Section----- | 1 |
| 49 | 35730 AB | Bottom, rear section----- | 1 |
| 50 | 22799 G | Hinge Screw----- | 2 |
| 51 | 91 | Clamp Screw----- | 1 |
| 52 | 35730 AD | Shank----- | 1 |
| 53 | 73 A | Screw----- | 1 |
| 54 | 35730 AE | Spring----- | 1 |
| 55 | 51405 K-26 | Feed Dog, for Nos. 24 and 26 gauge, Style 51400 BX----- | 1 |
| 56 | 51424 K-24 | Throat Plate, for No. 24 gauge, Style 51400 BX----- | 1 |
| | 51424 K-26 | Throat Plate, for No. 26 gauge, Style 51400 BX----- | 1 |
| 57 | 51420 K-24 | Presser Foot, for No. 24 gauge, Style 51400 BX----- | 1 |
| | 51420 K-26 | Presser Foot, for No. 26 gauge, Style 51400 BX----- | 1 |
| 58 | 53530 E | Guide----- | 1 |
| 59 | 22799 B | Hinge Screw----- | 1 |
| 60 | 51430 K-26 | Bottom, for No. 26 gauge, Style 51400 BX----- | 1 |
| 61 | 91 | Clamp Screw----- | 1 |
| 62 | 51430 B | Shank----- | 1 |
| 63 | 187 A | Screw----- | 1 |



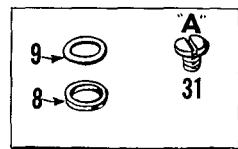
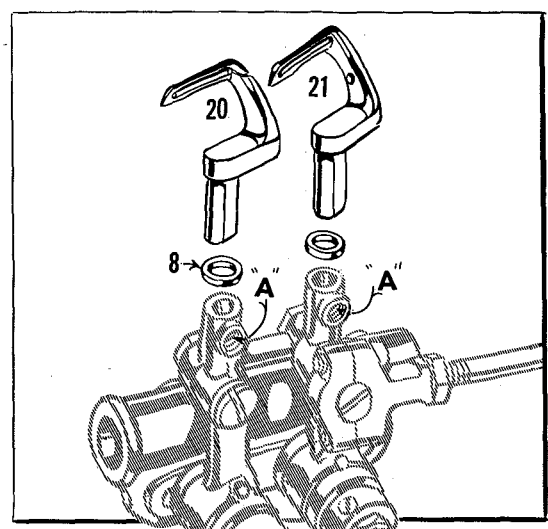
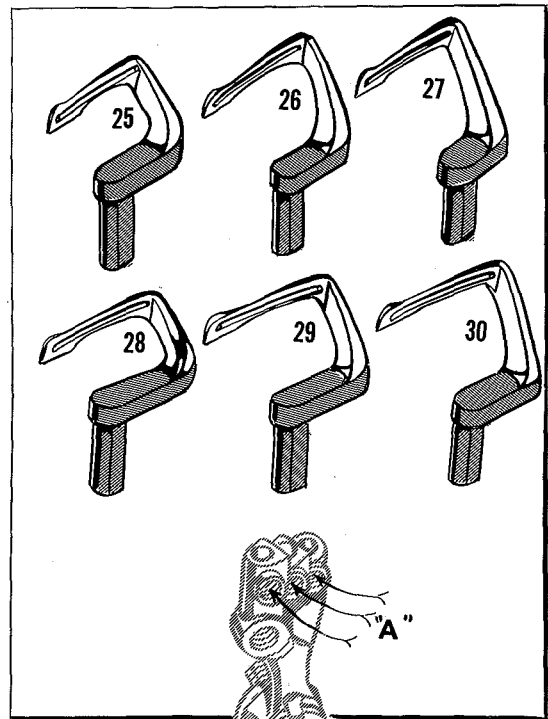
FEED DOGS, THROAT PLATES, PRESSER FEET

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-------------|---|-----------|
| 1 | 51705-56 | Feed Dog, for No. 56 gauge, Styles 51700 BJ, BQ- | 1 |
| | 51705-64 | Feed Dog, for No. 64 gauge, Styles 51700 BJ, BQ- | 1 |
| | 51705-72 | Feed Dog, for No. 72 gauge - - - - - | 1 |
| | 51705-80 | Feed Dog, for No. 80 gauge - - - - - | 1 |
| | 51705-96 | Feed Dog, for No. 96 gauge - - - - - | 1 |
| | 51705-112 | Feed Dog, for No. 112 gauge- - - - - | 1 |
| 2 | 51724-56 | Throat Plate, for No. 56 gauge, Styles 51700 BJ, BQ- | 1 |
| | 51724-64 | Throat Plate, for No. 64 gauge, Styles 51700 BJ, BQ- | 1 |
| | 51724-72 | Throat Plate, for No. 72 gauge - - - - - | 1 |
| | 51724-80 | Throat Plate, for No. 80 gauge - - - - - | 1 |
| | 51724-96 | Throat Plate, for No. 96 gauge - - - - - | 1 |
| | 51724-112 | Throat Plate, for No. 112 gauge- - - - - | 1 |
| 3 | 51720-56 | Presser Foot, for No. 56 gauge, Styles 51700 BJ, BQ- | 1 |
| | 51720-64 | Presser Foot, for No. 64 gauge, Styles 51700 BJ, BQ- | 1 |
| | 51720-72 | Presser Foot, for No. 72 gauge - - - - - | 1 |
| | 51720-80 | Presser Foot, for No. 80 gauge - - - - - | 1 |
| | 51720-96 | Presser Foot, for No. 96 gauge - - - - - | 1 |
| | 51720-112 | Presser Foot, for No. 112 gauge- - - - - | 1 |
| 4 | 51730 A-56 | Flexible Toe, for No. 56 gauge, Styles 51700 BJ, BQ | 1 |
| | 51730 A-64 | Flexible Toe, for No. 64 gauge, Styles 51700 BJ, BQ | 1 |
| | 51730 A-72 | Flexible Toe, for No. 72 gauge- - - - - | 1 |
| | 51730 A-80 | Flexible Toe, for No. 80 gauge- - - - - | 1 |
| | 51730 A-96 | Flexible Toe, for No. 96 gauge- - - - - | 1 |
| | 51730 A-112 | Flexible Toe, for No. 112 gauge - - - - - | 1 |
| 5 | 91 A | Screw - - - - - | 2 |
| 6 | 51730-56 | Presser Foot Bottom, for No. 56 gauge, Style 51700 BJ, BQ | 1 |
| | 51730-64 | Presser Foot Bottom, for No. 64 gauge, Styles 51700 BJ, BQ- | 1 |
| | 51730-72 | Presser Foot Bottom, for No. 72 gauge - - - - - | 1 |
| | 51730-80 | Presser Foot Bottom, for No. 80 gauge - - - - - | 1 |
| | 51730-96 | Presser Foot Bottom, for No. 96 gauge - - - - - | 1 |
| | 51730-112 | Presser Foot Bottom, for No. 112 gauge- - - - - | 1 |
| 7 | 51430 | Presser Foot Shank- - - - - | 1 |
| 8 | 91 | Clamp Screw, upper- - - - - | 1 |
| 9 | 77 | Clamp Screw, lower- - - - - | 1 |
| 10 | 22752 B | Adjusting Screw - - - - - | 1 |
| 11 | 22799 D | Hinge Screw - - - - - | 1 |
| 12 | 51705 D-56 | Feed Dog, for No. 56 gauge, Style 51700 BR - - - - - | 1 |
| | 51705 D-64 | Feed Dog, for No. 64 gauge, Style 51700 BK - - - - - | 1 |
| | 51705 D-72 | Feed Dog, for No. 72 gauge - - - - - | 1 |
| | 51705 D-80 | Feed Dog, for No. 80 gauge - - - - - | 1 |
| | 51705 D-96 | Feed Dog, for No. 96 gauge - - - - - | 1 |
| | 51705 D-112 | Feed Dog, for No. 112 gauge- - - - - | 1 |
| 13 | 51724 D-56 | Throat Plate, for No. 56 gauge - - - - - | 1 |
| | 51724 D-64 | Throat Plate, for No. 64 gauge, Style 51700 BK - - - - - | 1 |
| | 51724 D-72 | Throat Plate, for No. 72 gauge - - - - - | 1 |
| | 51724 D-80 | Throat Plate, for No. 80 gauge - - - - - | 1 |
| | 51724 D-96 | Throat Plate, for No. 96 gauge - - - - - | 1 |
| | 51724 D-112 | Throat Plate, for No. 112 gauge- - - - - | 1 |
| 14 | K59843 | Throat Plate, for No. 56 gauge, Style 51700 BR - - - - - | 1 |
| 15 | 51720 D-56 | Presser Foot, for No. 56 gauge, Style 51700 BR - - - - - | 1 |
| | 51720 D-64 | Presser Foot, for No. 64 gauge, Style 51700 BK - - - - - | 1 |
| | 51720 D-72 | Presser Foot, for No. 72 gauge - - - - - | 1 |
| | 51720 D-80 | Presser Foot, for No. 80 gauge - - - - - | 1 |
| | 51720 D-96 | Presser Foot, for No. 96 gauge - - - - - | 1 |
| | 51720 D-112 | Presser Foot, for No. 112 gauge- - - - - | 1 |
| 16 | 51730 D-56 | Presser Foot Bottom, for No. 56 gauge, Style 51700 BK - - - - - | 1 |
| | 51730 D-64 | Presser Foot Bottom, for No. 64 gauge, Styles 51700 BK, BR- - - - - | 1 |
| | 51730 D-72 | Presser Foot Bottom, for No. 72 gauge - - - - - | 1 |
| | 51730 D-80 | Presser Foot Bottom, for No. 80 gauge - - - - - | 1 |
| | 51730 D-96 | Presser Foot Bottom, for No. 96 gauge - - - - - | 1 |
| | 51730 D-112 | Presser Foot Bottom, for No. 112 gauge- - - - - | 1 |
| 17 | 22799 D | Hinge Screw - - - - - | 1 |
| 18 | 22752 B | Adjusting Screw - - - - - | 1 |
| 19 | 77 | Clamp Screw, lower- - - - - | 1 |
| 20 | 91 | Clamp Screw, upper- - - - - | 1 |
| 21 | 51430 | Presser Foot Shank- - - - - | 1 |



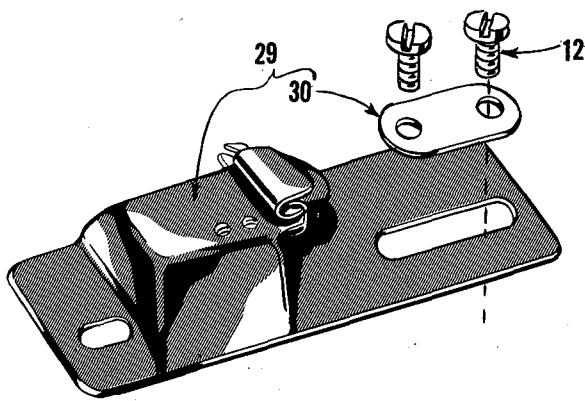
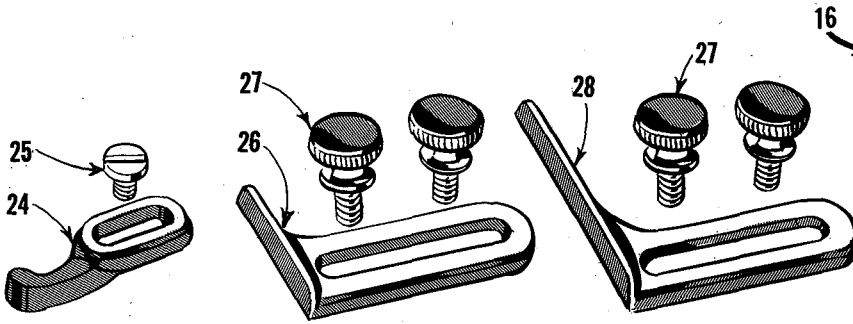
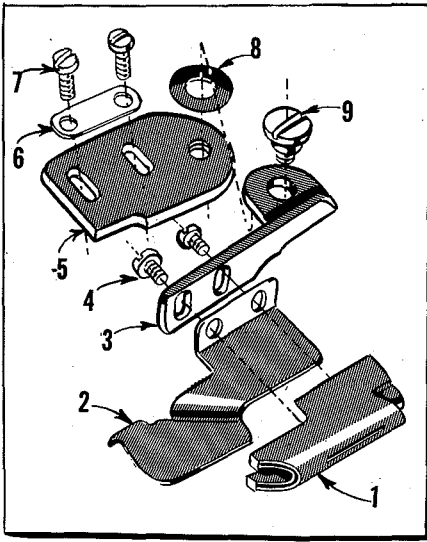
FEED DOGS, THROAT PLATES, PRESSER FEET

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 51905-5 | Feed Dog, for No. 5 gauge, Style 51900 BG ----- | 1 |
| 2 | 51905 A-7 | Feed Dog, for Nos. 6 and 7 gauges, Styles 51900 BG, BH----- | 1 |
| 3 | 51924 A-6 | Throat Plate, for No. 6 gauge, Style 51900 BG ----- | 1 |
| | 51924 A-7 | Throat Plate, for No. 7 gauge, Styles 51900 BG, BH----- | 1 |
| 4 | 51920-5 | Presser Foot, for No. 5 gauge, Style 51900 BG----- | 1 |
| | 51920-6 | Presser Foot, for No. 6 gauge, Style 51900 BG----- | 1 |
| | 51920-7 | Presser Foot, for No. 7 gauge, Styles 51900 BG, BH ----- | 1 |
| 5 | 51930 B-5 | Presser Foot Bottom, for No. 5 gauge, Style 51900 BG--- | 1 |
| | 51930 B-6 | Presser Foot Bottom, for No. 6 gauge, Style 51900 BG--- | 1 |
| | 51930 B-7 | Presser Foot Bottom, for No. 7 gauge, Styles 51900 BG, BH ----- | 1 |
| 6 | 22799 B | Hinge Screw ----- | 1 |
| 7 | 51930 A | Presser Foot Shank----- | 1 |
| 8 | 91 | Clamp Screw----- | 1 |
| 9 | 12935 A | Adjusting Screw ----- | 1 |
| 10 | 51905 B-9 | Feed Dog, for Nos. 8 and 9 gauges, Style 51900 BH----- | 1 |
| 11 | 51924 B-8 | Throat Plate, for No. 8 gauge, Style 51900 BH ----- | 1 |
| | 51924 B-9 | Throat Plate, for No. 9 gauge, Style 51900 BH ----- | 1 |
| 12 | 35820 P-8 | Presser Foot, for No. 8 gauge, Style 51900 BH----- | 1 |
| | 35820 P-9 | Presser Foot, for No. 9 gauge, Style 51900 BH----- | 1 |
| 13 | 35830 P-8 | Presser Foot Bottom, for No. 8 gauge, Style 51900 BH--- | 1 |
| | 35830 P-9 | Presser Foot Bottom, for No. 9 gauge, Style 51900 BH--- | 1 |
| 14 | 22799 C | Hinge Screw ----- | 1 |
| 15 | 51930 | Spring----- | 1 |
| 16 | 35830 | Presser Foot Shank----- | 1 |
| 17 | 91 | Clamp Screw----- | 1 |
| 18 | 51905 C-9 | Feed Dog, for No. 9 gauge, Style 51900 BJ----- | 1 |
| 19 | 51924 C-9 | Throat Plate, for No. 9 gauge, Style 51900 BJ----- | 1 |
| 20 | 35820 R-9 | Presser Foot, for No. 9 gauge, Style 51900 BJ----- | 1 |
| 21 | 35830 R-9 | Bottom, front section ----- | 1 |
| 22 | 22845 A | Hinge Screw ----- | 6 |
| 23 | 35830 E | Yielding Section ----- | 1 |
| 24 | 35830 G | Bottom, rear section ----- | 1 |
| 25 | 22799 L | Set Screw----- | 1 |
| 26 | 35830 F | Adjusting Nut ----- | 1 |
| 27 | 73 A | Screw ----- | 1 |
| 28 | 35830 D | Yielding Section Spring----- | 1 |
| 29 | 22561 | Screw ----- | 1 |
| 30 | 35830 B | Presser Foot Shank----- | 1 |
| 31 | 91 D | Clamp Screw----- | 1 |
| 32 | 22599 | Screw ----- | 1 |
| 33 | 35830 K | Equalizing Spring, front section----- | 1 |
| 34 | 35830 C | Yoke ----- | 1 |
| 35 | 35830 H | Equalizing Spring, rear section ----- | 1 |



LOOPERS

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-------------|---|--------------|
| 1 | 51208 D | Looper, for Styles 51200 BG, BP, BS, BT ----- | 1 |
| 2 | 51409 | Looper, for Styles 51200 BK, BR ----- | 1 |
| 3 | 51909 C | Looper, for Styles 51200 BL; 51300 BM ----- | 1 |
| 4 | 51208 | Looper, for Styles 51200 BM; 51300 BG, BH, BJ, BL ----- | 1 |
| 5 | 51208 W | Looper, for Styles 51200 BW, BX ----- | 1 |
| 6 | 51210 | Looper Needle Guard, for Styles 51200 BW, BX ----- | 1 |
| 7 | 73 A | Screw ----- | 1 |
| 8 | 21210 | Looper Collar, .040 inch thick, for Styles 51200 BL, BM, BT, BW, BX; 51300 BH, BJ, BL, BM; 51700 BJ, BK, BQ, BR -- | 1 |
| 9 | 21210 A | Looper Collar, .020 inch thick, for Styles 51200 BG, BK, BP, BS; 51300 BG ----- | 1 |
| 10 | 51408-6 | Looper, front, for No. 6 gauge, Style 51400 BP ----- | 1 |
| | 51408-8 | Looper, front, for No. 8 gauge, Styles 51400 BP, BT, BW --- | 1 |
| | 51408-10 | Looper, front, for No. 10 gauge, Styles 51400 BP, BT, BW -- | 1 |
| | 51408-12 | Looper, front, for No. 12 gauge, Styles 51400 BD, BP, BT, BW ----- | 1 |
| | 51408-16 | Looper, front, for No. 16 gauge, Styles 51400 BD, BP, BT, BW ----- | 1 |
| | 51408-18 | Looper, front, for No. 18 gauge, Style 51400 BP ----- | 1 |
| | 51408-24 | Looper, front, for No. 24 gauge, Style 51400 BX ----- | 1 |
| | 51408-26 | Looper, front, for No. 26 gauge, Style 51400 BX ----- | 1 |
| | 51408-32 | Looper, front, for No. 32 gauge, Styles 51400 BS, BU, BY --- | 1 |
| | 51408-48 | Looper, front, for No. 48 gauge, Styles 51400 BA, BB, BQ, BR, BS ----- | 1 |
| 11 | 51409 | Looper, back, for Styles 51400 BD, BP, BT, BW, BX ----- | 1 |
| 12 | 51409 B | Looper, back, for Styles 51400 BA, BB, BQ, BR, BS, BU, BY -- | 1 |
| 13 | K55001 | Looper, front, for No. 18 gauge, Style 51400 BV ----- | 1 |
| 14 | 51208 D | Looper, back, for Style 51400 BV ----- | 1 |
| 15 | 51508 M-16 | Looper, front, for No. 16 gauge, Style 51500 BJ ----- | 1 |
| | 51508 M-18 | Looper, front, for No. 18 gauge, Styles 51500 BJ, BM, BR -- | 1 |
| 16 | 51909 C | Looper, back, for Styles 51500 BJ, BM, BR ----- | 1 |
| 17 | 51508 C-1 | Looper, front, for No. 1 gauge, Style 51500 BK ----- | 1 |
| 18 | 51509 C | Looper, back, for Styles 51500 BK, BN ----- | 1 |
| 19 | 51508 G-1 | Looper, front, for No. 1 gauge, Style 51500 BN ----- | 1 |
| 20 | 51709 | Looper, left, for Styles 51700 BJ, BK, BQ, BR ----- | 1 |
| 21 | 51708 | Looper, right, for Styles 51700 BJ, BK, BQ, BR ----- | 1 |
| 22 | 51408 A-16 | Looper, front, for No. 16 gauge, Style 51400 BV ----- | 1 |
| 23 | 51908 B-9 | Looper, front, for No. 18 gauge, Style 51500 BP ----- | 1 |
| 24 | 51909 D-9 | Looper, back, for No. 18 gauge, Style 51500 BP ----- | 1 |
| 25 | 51908-5 | Looper, front, for No. 5 gauge, Style 51900 BG ----- | 1 |
| | 51908-6 | Looper, front, for No. 6 gauge, Style 51900 BG ----- | 1 |
| | 51908-7 | Looper, front, for No. 7 gauge, Style 51900 BG ----- | 1 |
| 26 | 51409 | Looper, middle, for Style 51900 BG ----- | 1 |
| 27 | 51909-5 | Looper, back, for No. 5 gauge, Style 51900 BG ----- | 1 |
| | 51909-6 | Looper, back, for No. 6 gauge, Style 51900 BG ----- | 1 |
| | 51909-7 | Looper, back, for No. 7 gauge, Style 51900 BG ----- | 1 |
| 28 | 51908 B-7 | Looper, front, for No. 7 gauge, Style 51900 BH ----- | 1 |
| | 51908 B-8 | Looper, front, for No. 8 gauge, Style 51900 BH ----- | 1 |
| | 51908 B-9 | Looper, front, for No. 9 gauge, Style 51900 BH, BJ ----- | 1 |
| 29 | 51909 C | Looper, middle, for Styles 51900 BH, BJ ----- | 1 |
| 30 | 51909 D-7 | Looper, back, for No. 7 gauge, Style 51900 BH ----- | 1 |
| | 51909 D-8 | Looper, back, for No. 8 gauge, Style 51900 BH ----- | 1 |
| | 51909 D-9 | Looper, back, for No. 9 gauge, Styles 51900 BH, BJ ----- | 1 |
| 31 | 73 | Screw ----- | 1, 2, 3 |



ATTACHMENTS

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|----------------|--|-----------|
| 1 | 23215 BC-5/8 | English Binder, uses selvage edge binding strip 5/8 inch wide, 5/32 inch capacity for body fabric, finishes 5/16 inch wide, for Styles 51200 BL; 51300 BM----- | 1 |
| | 23215 BC-3/4 | English Binder, uses 3/4 inch strip and finishes 3/8 inch----- | 1 |
| | 23215 BC-7/8 | English Binder, uses 7/8 inch strip and finishes 7/16 inch----- | 1 |
| 2 | 23438 B | Body Fabric Lead-in Platform, for Styles 51200 BL; 51300 BM----- | 1 |
| 3 | 23437 Y | Binder Swinging Bracket, for Styles 51200 BL; 51300 BM----- | 1 |
| 4 | 90 | Screw----- | 2 |
| 5 | 23437 B | Binder Swinging Bracket Support, for Styles 51200 BL; 51300 BM----- | 1 |
| 6 | 23425 T | Washer Plate----- | 1 |
| 7 | 22585 | Screw----- | 2 |
| 8 | 12957 E | Spring Washer----- | 1 |
| 9 | 22735 | Screw----- | 1 |
| 10 | 23438 A | Body Fabric Lead-in Platform, for Style 51200 BK----- | 1 |
| 11 | 23425 V | Washer Plate----- | 1 |
| 12 | 25 C | Screw----- | 2 |
| 13 | 23322 AB-3/4 | Cut Edge Binder, uses strip cut 3/4 inch wide, finishes 7/32 inch wide, for Style 51200 BK----- | 1 |
| | 23322 AB-7/8 | Cut Edge Binder, uses strip cut 7/8 inch wide, finishes 1/4 inch wide---- | 1 |
| | 23322 AB-1 | Cut Edge Binder, uses strip cut 1 inch wide, finishes 9/32 inch wide---- | 1 |
| | 23322 AB-1 1/8 | Cut Edge Binder, uses strip cut 1 1/8 inch wide, finishes 11/32 inch wide----- | 1 |
| | 23322 AB-1 1/4 | Cut Edge Binder, uses strip cut 1 1/4 inch wide, finishes 13/32 inch wide----- | 1 |
| 14 | 23322 AC | Binder Support, for Style 51200 BK----- | 1 |
| 15 | 90 | Screw----- | 2 |
| 16 | 23184 K | Swinging Folder and Guide, for Style 51300 BJ----- | 1 |
| 17 | 23184 E | Lower Portion----- | 1 |
| 18 | 23184 G | Adjustable Guide, lower----- | 1 |
| 19 | 23184 L | Upper Portion----- | 1 |
| 20 | 23184 M | Adjustable Guide, upper----- | 1 |
| 21 | 187 A | Screw----- | 4 |
| 22 | 22726 | Screw----- | 1 |
| 23 | 12957 E | Spring Washer----- | 1 |
| 24 | 24 S | Edge Guide, for Styles 51200 BQ, BW, BX----- | 1 |
| 25 | 25 S | Screw----- | 1 |
| 26 | 24 X | Edge Guide, for Style 51200 BM----- | 1 |
| 27 | 25 | Screw----- | 2 |
| 28 | 24 | Edge Guide, for Styles 51200 BG, BS; 51300 BG; 51400 BX; 51500 BK, BN----- | 1 |
| 29 | 23100 | Double Edge Folder and Guide, 3/64 inch capacity, 3/16 inch overlap, for Style 51200 BR----- | 1 |
| 30 | 23425 V | Washer Plate----- | 1 |
| 31 | | Double Lap Seam Feller Assembly (See Chart Below)----- | 1 |
| 32 | | Lower Scroll and Base (See Chart Below)----- | 1 |
| 33 | | Upper Scroll (See Chart Below)----- | 1 |
| 34 | 28 | Screw----- | 1 |
| 35 | 23425 V | Washer Plate----- | 1 |

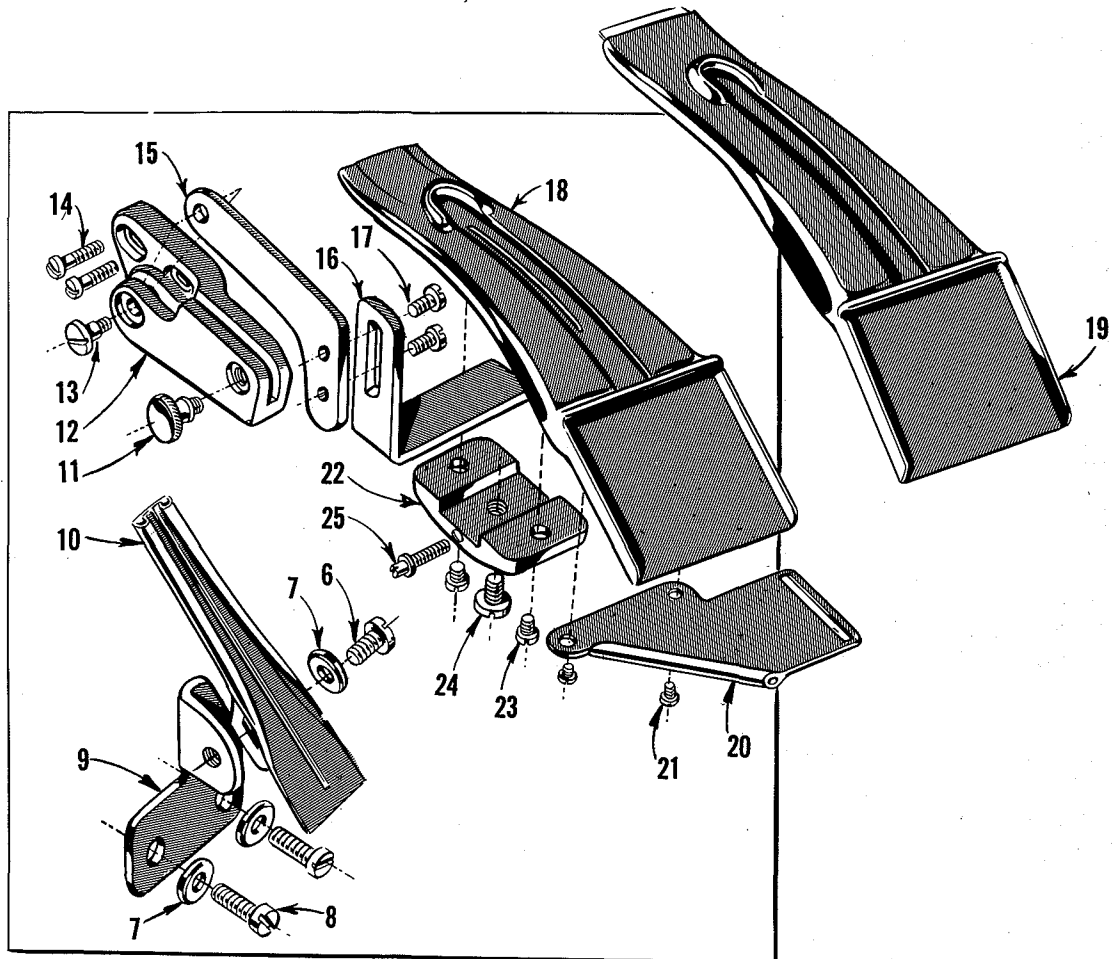
DOUBLE LAP SEAM FELLERS

| Assembly No. Ref. 31 | Gauge | Capacity | Lower Scroll Ref. 32 | Upper Scroll Ref. 33 | Machine Style |
|-------------------------|-------|----------|-------------------------|-------------------------|-----------------------------------|
| 23420 U-6-1/32 | 6 | 1/32 | 23422 U-1/32 | 23421 U-6-1/32 | 51400 BP-6 |
| 23420 U-8-1/32 | 8 | 1/32 | 23422 U-1/32 | 23421 U-8-1/32 | 51400 BP-8, BW-8 |
| 23420 U-10-1/32 | 10 | 1/32 | 23422 U-1/32 | 23421 U-10-1/32 | 51400 BP-10, BW-10 |
| 23420 U-10-1/16 | 10 | 1/16 | 23422 U-1/16 | 23421 U-10-1/16 | 51900 BG-5 |
| 23420 U-12-1/16 | 12 | 1/16 | 23422 U-1/16 | 23421 U-12-1/16 | 51400 BP-12, BW-12; 51900 BG-6 |
| 23420 U-16-1/16 | 16 | 1/16 | 23422 U-1/16 | 23421 U-16-1/16 | 51400 BP-16, BW-16; 51900 BG-7 |
| 23420 U-16-3/32 | 16 | 3/32 | 23422 U-3/32 | 23421 U-16-3/32 | 51500 BJ-16; 51900 BH-7, BH-8 |
| 23420 U-18-1/16 | 18 | 1/16 | 23422 U-1/16 | 23421 U-18-1/16 | 51400 BP-18 |
| 23420 U-18-3/32 | 18 | 3/32 | 23422 U-3/32 | 23421 U-18-3/32 | 51500 BJ-18, BR-18; 51900 BH-9 |
| 23420 U-26-1/16 | 26 | 1/16 | 23422 U-1/16 | 23421 U-26-1/16 | 51400 BX-26 |
| 23420 V-8-1/32 | 8 | 1/32 | 23422 V-1/32 | 23421 V-8-1/32 | 51400 BT-8 |
| 23420 V-10-1/32 | 10 | 1/32 | 23422 V-1/32 | 23421 V-10-1/32 | 51400 BT-10 |
| 23420 V-12-1/32 | 12 | 1/32 | 23422 V-1/32 | 23421 V-12-1/32 | 51400 BT-12 |
| 23420 V-16-1/32 | 16 | 1/32 | 23422 V-1/32 | 23421 V-16-1/32 | 51400 BT-16 |



ATTACHMENTS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 23151 A | Plate Folder and Guide, for heavy material, 1/4 inch capacity for both plies, top ply folded, lower ply flat, 1/2 inch overlap, for Styles 51500 BP; 51900 BJ----- | 1 |
| 2 | 25 C | Screw----- | 2 |
| 3 | 23405 J | Folder, for turning body of garment downwardly, 1/32 inch capacity, 5/16 inch fold, for Style 51400 BS ----- | 1 |
| | K59386 | Folder, for turning body of garment downwardly, 1/16 inch capacity, 5/16 inch fold, for Style 51700 BR----- | 1 |
| 4 | 23425 V | Washer Plate ----- | 1 |
| 5 | 23405 F | Folder, for turning body of garment upwardly, 1/32 inch capacity, 5/16 inch fold, for Style 51400 BY ----- | 1 |
| | K59432 | Folder, for turning body of garment upwardly, 1/16 inch capacity, 5/16 inch fold, for Style 51700 BQ ----- | 1 |
| 6 | K30773 | Strip Folder, for facing overall bibs, strip cut 1 inch wide, finishes 9/16 inch, on Style 51500 BM ----- | 1 |
| 7 | K38038 | Edge Guide, adjustable, for facing overall bibs, on Style 51500 BM ----- | 1 |
| 8 | K38197 | Folder, for turning bib of overall downwardly, on Style 51500 BM ----- | 1 |
| 9 | 22514 | Screw----- | 4 |
| 10 | 23404 E | Edge Guide, for body of garment, on Styles 51400 BQ; 51700 BK----- | 1 |
| 11 | 25 C | Screw----- | 1 |
| 12 | 23405 L | Folder, for turning body of garment upwardly, 1/32 inch capacity, 5/16 inch fold, on Styles 51400 BR; 51700 BJ----- | 1 |
| 13 | 21182 N | Strip Tension Assembly, for Styles 51400 BS; 51700 BK, BR ----- | 1 |
| 14 | 21182 P | Strip Tension Base ----- | 1 |
| 15 | 11261 B | Tension Post Ferrule ----- | 2 |
| 16 | 56392 E | Tension Post----- | 2 |
| 17 | 21182 L | Strip Tension Plate, inner----- | 1 |
| 18 | 21182 K | Strip Tension Plate, outer----- | 1 |
| 19 | 110-3 | Tension Spring----- | 2 |
| 20 | 39592 AK | Tension Spring Ferrule ----- | 2 |
| 21 | 39592 Z | Tension Nut----- | 2 |
| 22 | 23406 B-7/8 | Folder, for attaching single piece facing to sleeves of shirts, uses strip 2 1/4 inches wide, finishes 7/8 inch, on Style 51400 BA ----- | 1 |
| 23 | 22730 | Screw----- | 2 |
| 24 | 23402 D | Folder Support----- | 1 |
| 25 | 23439 A | Pin Tension, for Styles 51200 BK, BL; 51300 BM----- | 1 |
| 26 | 90 | Screw----- | 1 |



ATTACHMENTS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|--|------------------|
| 1 | 23360 F-1/2 | Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 1 1/2 inches wide, finishes 1/2 inch, on Style 51200 BT ----- | 1 |
| | K40881 | Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 2 1/8 inches wide, finishes 3/4 inch, on Style 51200 BT ----- | 1 |
| | K49640 | Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 2 3/8 inches wide, finishes 7/8 inch, on Style 51200 BT ----- | 1 |
| | K49746 | Folder, for attaching single piece extension button stays to fronts and sleeves of shirts, uses strip 2 5/8 inches wide, finishes 1 inch, on Style 51200 BT ----- | 1 |
| 2 | 23425 V | Washer Plate ----- | 1 |
| 3 | 25 C | Screw ----- | 2 |
| 4 | 23168 Q | Folder, for making 7/8 inch "cut-on" button stays on shirts, starts operation at neck, turned up hem, on Style 51400 BB ----- | 1 |
| 5 | 23168 R | Folder, for making 5/8 inch "cut-on" button stays on shirts, starts operation at neck, turned down hem, on Style 51400 BU ----- | 1 |
| 6 | 22548 | Screw ----- | 1 |
| 7 | 9255 | Washer ----- | 3 |
| 8 | 136 | Screw ----- | 2 |
| 9 | 23436 | Folder Bracket, for Styles 51400 BQ, BS; 51700 BK, BR ----- | 1 |
| 10 | 23435-32 | Facing Strip Folder, for shirt front operations, 1/32 inch capacity, uses strip 1 inch wide, finishes 5/8 inch, on No. 32 gauge, Style 51400 BS ----- | 1 |
| | 23435-48 | Facing Strip Folder, for shirt front operations, 1/32 inch capacity, uses strip 1 1/4 inches wide, finishes 7/8 inch, on No. 48 gauge, Styles 51400 BQ, BS ----- | 1 |
| | K59825 | Facing Strip Folder, for shirt front operations, 1/16 inch capacity, uses strip 1 3/8 inches wide, finishes 1 inch, on No. 56 gauge, Style 51700 BR ----- | 1 |
| | 23435-64 | Facing Strip Folder, for shirt front operations, 1/32 inch capacity, uses strip 1 1/2 inches wide, finishes 1 1/8 inches, on No. 64 gauge, Style 51700 BK ----- | 1 |
| *11 | 25 T | Screw ----- | 1 |
| *12 | 23229 W | Folder Swinging Arm Support, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ ----- | 1 |
| *13 | 22773 | Screw ----- | 1 |
| 14 | 22541 | Screw ----- | 2 |
| *15 | 23229 N | Folder Swinging Arm, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ ----- | 1 |
| *16 | 23229 P | Folder Bracket, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ ----- | 1 |
| *17 | 22528 | Screw ----- | 2 |
| 18 | 23401 K-48 | Center Plait Folder, 1/32 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/4 inches wide, finishes 1 1/4 inches, interlining strip cut 1 7/32 inches wide, for No. 48 gauge, Styles 51400 BQ, BR ----- | 1 |
| | 23401 K-56 | Center Plait Folder, 1/32 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 3/8 inches wide, finishes 1 3/8 inches, interlining strip, cut 1 11/32 inches wide for No. 56 gauge, Styles 51700 BJ, BK ----- | 1 |
| | 23401 K-64 | Center Plait Folder, 1/32 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches, interlining strip cut 1 15/32 inches wide, for No. 64 gauge, Styles 51700 BJ, BK ----- | 1 |
| 19 | K58357 | Center Plait Folder, 1/16 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches, for No. 64 gauge, Style 51700 BQ, no provision for interlining ----- | 1 |
| † | K58337 | Center Plait Folder, 1/16 inch capacity, plait extends 1/4 inch beyond rows of stitches, uses plait cut 2 1/2 inches wide, finishes 1 1/2 inches, interlining strip cut 1 7/16 inches wide, for No. 64 gauge ----- | 1 |
| 20 | 23403-48 | Angular Strip Guide, reversible, for No. 48 gauge, Styles 51400 BQ, BR -- | 1 |
| | 23403-56 | Angular Strip Guide, reversible, for No. 56 gauge, Style 51700 BJ ----- | 1 |
| | 23403-64 | Angular Strip Guide, reversible, for No. 64 gauge, Style 51700 BJ, BK --- | 1 |
| 21 | 25 B | Screw ----- | 2 |
| *22 | 23229 Q | Folder Clamp, for Styles 51400 BQ, BR; 51700 BJ, BK, BQ ----- | 1 |
| *23 | 25 CC | Screw ----- | 2 |
| *24 | 25 S | Screw ----- | 1 |
| *25 | 22863 A | Adjusting Screw ----- | 1 |

* Available complete as part No. 29481 D (Suspended Folder Arm Assembly).

† Available as an extra send and charge item or on special machine.



THREAD STAND PARTS

| Ref. No. | Part No. | Description | Amount Required | | |
|----------|------------|-------------------------------|-----------------|------------|--------------|
| | | | One Needle | Two Needle | Three Needle |
| 1 | 21101 H-2 | Thread Stand, complete | 1 | | |
| 2 | 21101 H-4 | Thread Stand, complete | | 1 | |
| 3 | 21101 H-6 | Thread Stand, complete | | | 1 |
| 4 | 21104 B-24 | Thread Stand Rod | 1 | 1 | 1 |
| 5 | 21104 H | Nut | 1 | 1 | 1 |
| 6 | 652-16 | Washer | 1 | 1 | 1 |
| 7 | 21114 U | Lead Eyelet Ball Split Socket | 2 | 2 | 2 |
| 8 | 21114 A | Base | 1 | 1 | 1 |
| 9 | 22651 CD-5 | Screw | 2 | 2 | 2 |
| 10 | 22810 | Screw | 1 | 1 | 1 |
| 11 | 21114 T | Lead Eyelet Socket Ball | 1 | 1 | 1 |
| 12 | 22651 CD-4 | Screw | 2 | 2 | 2 |
| 13 | 21104 V | Felt Pad | 2 | 4 | 6 |
| 14 | 21114 W | Spool Pin | 2 | 4 | 6 |
| 15 | 258 A | Nut | 4 | 8 | 12 |
| 16 | 21114 | Spool Seat Disc | 2 | 4 | 6 |
| 17 | 652-16 | Washer | 2 | 4 | 6 |
| 18 | 21114 H-2 | Eyelet Support | 1 | | |
| 19 | 21114 H-4 | Eyelet Support | | 1 | |
| 20 | 21114 H-6 | Eyelet Support | | | 1 |
| 22 | 21114 M | Eyelet Locking Ring | 2 | 8 | 12 |
| 23 | 21114 L | Eyelet | 2 | 8 | 12 |
| 24 | 22651 CD-4 | Screw | 2 | 2 | 2 |
| 25 | 21114 D-2 | Spool Seat Support | 1 | | |
| 26 | 21114 D-4 | Spool Seat Support | | 1 | |
| 27 | 21114 D-6 | Spool Seat Support | | | 1 |
| 28 | 22651 CD-5 | Screw | 2 | 2 | 2 |
| 29 | 21114 S-2 | Lead Eyelet | 1 | | |
| 30 | 21114 S-4 | Lead Eyelet | | 1 | |
| 31 | 21114 S-6 | Lead Eyelet | | | 1 |
| 32 | 21114 M | Eyelet Locking Ring | 2 | 4 | 6 |
| 33 | 21114 L | Eyelet | 2 | 4 | 6 |

*ACCESSORIES AVAILABLE AS EXTRAS

| <u>Part No.</u> | <u>Description</u> |
|-----------------|---|
| WA15 A | Stop Watch |
| TA55 B | Hand Tachometer |
| 660-240 | Thread Tweezers |
| Y500-257 | Expansion Reamer, for needle bar bearings, size .257 |
| Y503-319 | Expansion Reamer, for lower presser bar bearings, size .319 |
| Y505-407 | Expansion Reamer, for looper rocker and feed rocker shaft bearings, size .407 inch |
| Y506-530 | Expansion Reamer, for mainshaft and upper feed drive rock shaft bearings, size .530 inch |
| Y802 | Taper Reamer, for needle lever and feed crank link pins |
| 21201 | Screw Driver, 9/64 inch round blade, length overall 7 5/8 inches |
| 21202 | Screw Driver, 7/32 inch round blade, length overall 11 1/4 inches |
| 21203 | Screw Driver, 13/64 inch round blade, length overall 15 1/2 inches |
| 21204 | Screw Driver, 9/32 inch round blade, length overall 15 inches |
| 21205 A | Screw Driver, 3/8 inch round blade, length overall 14 inches |
| 21207 | Screw Driver, 7/64 inch round blade, length overall 2 1/2 inches |
| 21208 | Screw Driver Set, three detachable blades |
| 21225-1/8 | Looper Adjusting Gauge, 1/8 inch measurement |
| 21225-5/32 | Looper Adjusting Gauge, 5/32 inch measurement |
| 21236 | Belt Plier, for 3/8 and smaller round belting |
| 21260 | Emery Cord, 3/64 inch diameter, grade No. 120, 50 yard spool |
| 21260 A | Emery Cord, 3/64 inch diameter, grade No. 150, 50 yard spool |
| 21260 B | Emery Cord, 1/32 inch diameter, grade No. 180, 50 yard spool |
| 21260 C | Emery Cord, .025 inch diameter, grade No. 200, 50 yard spool |
| 21260 D | Emery Tape, 3/32 inch wide, grade No. 180, 50 yard spool |
| 21260 E | Emery Cord, .018 inch diameter, grade No. 200, 50 yard spool |
| 21261 | Leather Belt, flat, 1 inch wide, 63 inches long, includes fastener No. 21350 |
| 21261 M-340 | "V" Belt, No. 1 size, 34 inches outside circumference |
| 21261 M-350 | "V" Belt, 35 inches outside circumference |
| 21261 M-360 | "V" Belt, 36 inches outside circumference |
| 21261 M-370 | "V" Belt, 37 inches outside circumference |
| 21261 M-380 | "V" Belt, 38 inches outside circumference |
| 21262 | Leather Belt, round 9/32 inch diameter, 44 inches long, includes belt hook No. 21351 |
| 21350 | Belt Fastener, for 1 inch flat belt |
| 21351 | Belt Hook, for 9/32 inch round belt |
| 21388 | Wrench, single end, 3/8 inch opening |
| 21388 N | Wrench, double end, 3/16 and 5/16 inch openings |
| 21388 R | Wrench, double end, 3/8 and 1/2 inch openings |
| 21388 W | Wrench, double end, curved, 9/32 inch openings |
| 21388 X | Wrench, for main shaft bearing housing |
| 21388 AE | Socket Wrench Assembly, for 9/32 and 3/8 inch hexagonal nuts |
| 21388 AN | Socket Head Wrench Kit, five wrenches, for socket head set screws from size No. 10 to 7/16 inch inclusive |
| 21394 | Utility Grinder, including emery wheel, 5 inches diameter, 1/4 inch face, recommended speed 3000 R. P. M. |
| 21394 G | Emery Wheel, 5 inches diameter, 1/4 inch face, 3/8 inch hole, grade "M" emery 60 |
| 21394 H | Emery Wheel, 5 inches diameter, 1/2 inch face, 3/8 inch hole, grade "M" emery 60 |
| 21394 K | Utility Grinder, including emery wheel, 5 inches diameter, 1/2 inch face, recommended speed 3000 R. P. M. |
| 21660 H | Knee Press Assembly, machine mounted for lifting presser foot |
| 28606-1/2 | Powdered Oil Stone, 1/2 lb. package |
| 28606-1 | Powdered Oil Stone, 1 lb. package |

* The above tools and accessories are not illustrated but will prove helpful in the successful operation and maintenance of the machine.

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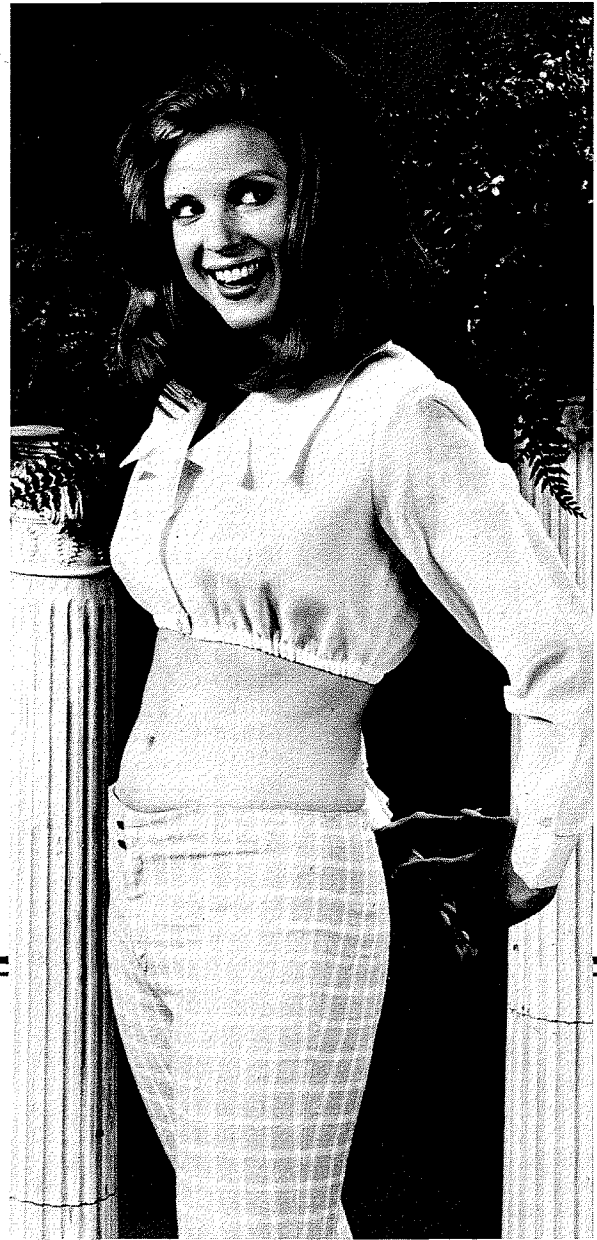
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Here are Oil Specifications for Union Special Sewing Machines



Specification 174 specifies a high quality petroleum oil, viscosity 100 seconds at 100°F. Recommended for all oiling applications on high speed machines.

Specification 175 specifies a high quality petroleum oil, viscosity 100 seconds at 100°F., water white or with a maximum A.S.T.M. color number of 1. *For use where freedom from oil staining is paramount.*

Specification 87 specifies a high quality petroleum oil, viscosity 300 seconds at 100°F.

Specification 100 specifies a general purpose high quality grease for use in ball bearings and transmitters. It is similar to commercial N.L.G.I., grease No. 3. Where No. 3 grease is not obtainable, No. 2 may be used.

UNION SPECIAL

| SPECIFICATION NO. | 174 | 175 | 87 |
|---------------------------------|--------|--------|---------|
| Viscosity S.S.U. at 100°F | 90-125 | 90-125 | 300-350 |
| Flash (Min.) | 350 | 350 | 350 |
| Pour (Max.) | 20 | 20 | 20 |
| Color A.S.T.M. (Max.) | 3 | 1 | 3 |
| Neutralization No. (Max.) | 0.10 | 0.10 | 0.10 |
| Viscosity Index (D & D Min.) | 85 | 85 | 85 |
| Compounding | None | None | None |
| Copper Corrosion (Max.) | 1A | 1A | 1A |

*Anline No. 175-225 175-225 175-225

*Used with Buna N Rubber "O" Retainers

NOTE 1: The use of non-corrosive additives in oils meeting above classification is desirable but not essential. These may include:

1. Oxidation inhibitors
2. Rust inhibitors
3. Lubricity additives
4. Anti-oxidants
5. Film strength additives

These additives must be completely soluble in the oil and not removable by wick feeding nor shall they separate.

NOTE 2: Oils containing the following type additives shall not be used at any time:

1. Extreme pressure additives—corrosive
2. Tackiness or adhesive additives
3. Lead soap additives
4. Detergents



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CORPORATION**





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Union Special
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