

CATALOG NO.

PT0901

Supplement to 129M
First Edition

ILLUSTRATED PARTS LIST

STYLES

56400U16
56400UZ155



CLASS 56400 - ADVANCED SERIES,
TAPING MACHINES



Union Special[®]
INDUSTRIAL SEWING EQUIPMENT

12-30-09



CATALOG NO. PT0901
ADJUSTING INSTRUCTIONS AND
ILLUSTRATED PARTS LIST FOR
CLASS 56400
ADVANCED SERIES
TAPING MACHINE

STYLE
56400U16
56400UZ155

First Edition
© 2009

PRINTED 2009 IN USA

INFORMATION SUBJECT TO
CHANGE WITHOUT NOTICE

© Union Special Corporation
ALL Rights Reserved in All
Countries

IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine carries a Style number, which on this Class machine is stamped into the style plate affixed to the right front of machine.

The serial number is stamped in the casting at the right rear base of machine.

Reference to directions, such as right, left, front or rear, are given relative to the operator's position while seated at the machine. Operating direction of the handwheel is counterclockwise, as viewed from the right end of machine.

CLASS DESCRIPTION

Advanced high speed, single needle, flat bed machine, low and medium throw, needle bearing needle bar drive, light weight presser bar and needle bar driving mechanism, enclosed automatic lubricating system, filtered oil return pumps for head and base, lateral looper travel. Maximum work space to right of needle bar, 8 1/4 inches (209.6mm).

MACHINE STYLE

56U00U16 Typical application - TAPING T SHIRTS COLLARS - For covering the overedge seam formed when attaching the collar to necks of T-shirts. Stitch range 9-20 SPI (1.3-2.8mm). Seam specification 401-SSag-3 (inv.) Maximum recommended speed 6500 R.P.M.

56100UZ155 Typical application - TAPING HEAVY WEIGHT T SHIRT COLLARS - Same as 56400U16 except medium throw crankshaft, longer looper travel, special needle guard and larger looper avoid for sewing heavier weight materials.

NEEDLES

Each needle has both a type and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes largest diameter of blade, measured midway between shank and eye. Collectively, type and size number represent the complete symbol, which is given on the label of all needles packaged and sold by UNION SPECIAL.

Recommended needle for Style 56400U16 & UZ155 is Type 192GS. It has a round shank, round point, double groove, spotted, chromium plated, and is available in sizes -

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

To have needle orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. Use description on label. A complete order would read: "1000 Needles, Type 192GLS080/032". Available in sizes 070/027, 080/032 & 090/036.

Before this machine left the factory it was adjusted and inspected to give you the utmost satisfaction and durability at all times. If, however, the machine has been readjusted and is not sewing properly, see the chart below for suggestions which may prove beneficial to you.

SKIPPED STITCHES

Condition	Causes	Cures
Needle loop too small	Frame needle thread guide set too low	Raise frame needle thread guide slightly.
	Needle thread stretched at bottom of stroke, loop not formed till stretch relieved	Lower frame thread eyelet and/or reduce needle tension
	Needle thread creased because it is too tight and needle is hot	Use oversize ball eye needle, lower frame needle eyelet, reduce tension
	Needle thread pinched by needle guard, collapsing needle loop	Drop needle guard slightly
	Thread twisting around needle	Keep needle loop as small as possible, keep needle thread tension to a minimum. Use a left twist thread
	Needle thread sticking in needle grooves, due to heat	Use lubricant on thread
	Needle does not rise enough to form needle loop properly	Increase looper gauge 1/64 to 1/32 inch
Looper misses needle loop as presser foot is coming off a seam	Material is not held down in front of seam and is flagging	See if presser bar is sticking
	Needle deflecting towards operator	Use sharp point needle
Needle loop formed properly but brushed out of the way .by looper	Needle bar set too high	Lower needle bar slightly
Looper misses needle loop when operator is trying to match seams or ends	Needle deflecting toward operator who may be holding back on material while matching seams or ends of garment	Do not hold back excessively on material. Properly adjust feed and maintain a proper feeding pressure on foot so operator does not hold back
Needle misses triangle on looper thread side	Looper thread too loose, not making a good triangle	Increase looper thread tension
	Needle being deflected to the rear by burr on needle point or due to operator pulling on material, or needle glancing off when coming on a seam	Do not pull material at the back. Use a sharp needle to stop needle from glancing off seam. Check needle for burr

NOTE: More detailed information concerning the double locked stitch (stitch type 401) is available under "Stitch Formation, Type 401".

ORDERING REPAIR PARTS

ILLUSTRATIONS

This catalog has been arranged to simplify ordering repair parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the machine. On the page opposite the illustration will be found a listing of the parts with their part numbers, descriptions and the number of pieces required in the particular view being shown.

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

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

48	29105AK	Crank Assembly, looper driving lever	1
49	22587K	Screw, bearing cap ,(upper)	2
50	56343C	Guide, ball joint	1
51	56343E	Splasher, oil	1
52	22559A	Screw, bearingcap (lower)	2

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

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

IDENTIFYING PARTS

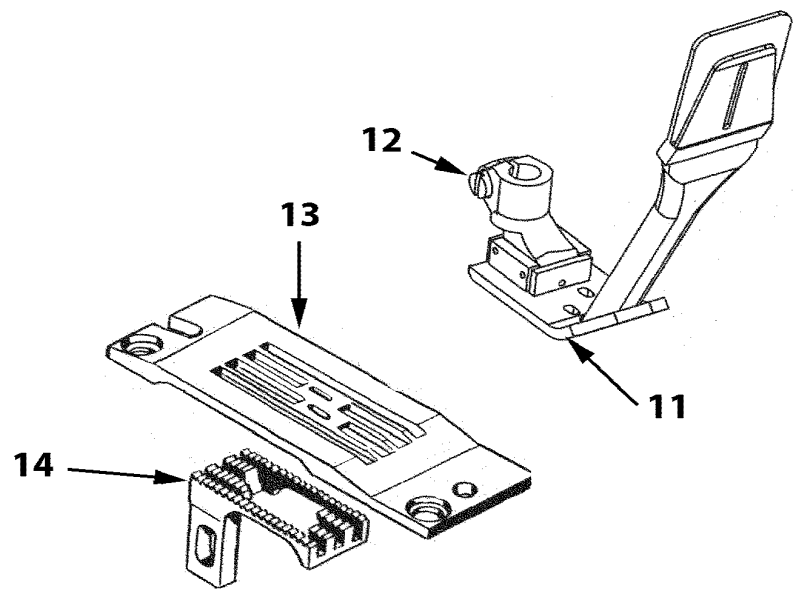
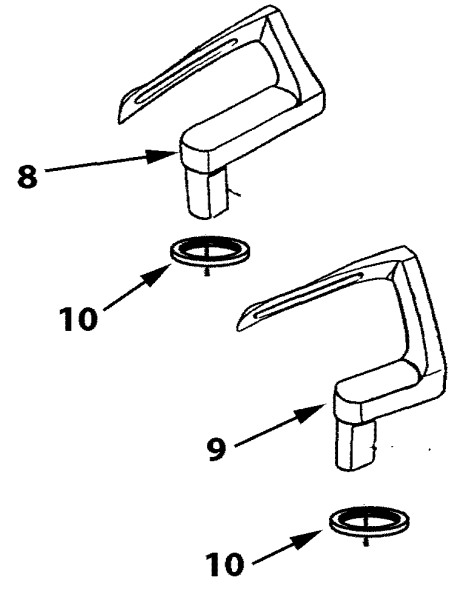
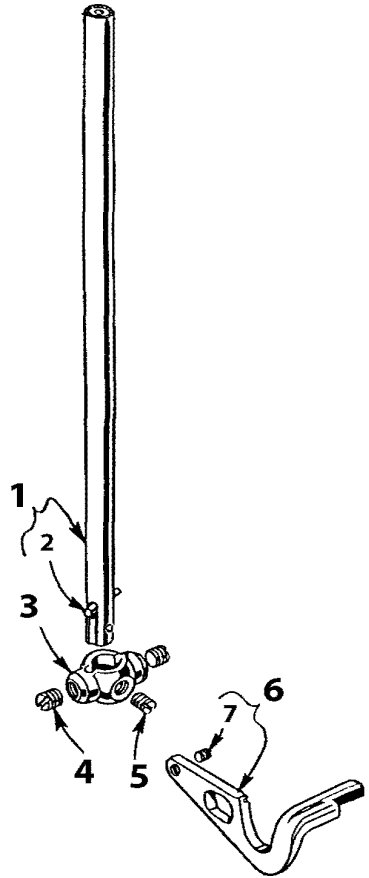
Where the construction permits, each part is stamped with its part number. On some of the smaller parts, and on those where construction does not permit, an identification letter is stamped in to distinguish the part from similar ones.

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

IMPORTANT! ON ALL ORDERS, PLEASE INCLUDE PART NAME AND STYLE OF MACHINE FOR WHICH PART IS ORDERED.

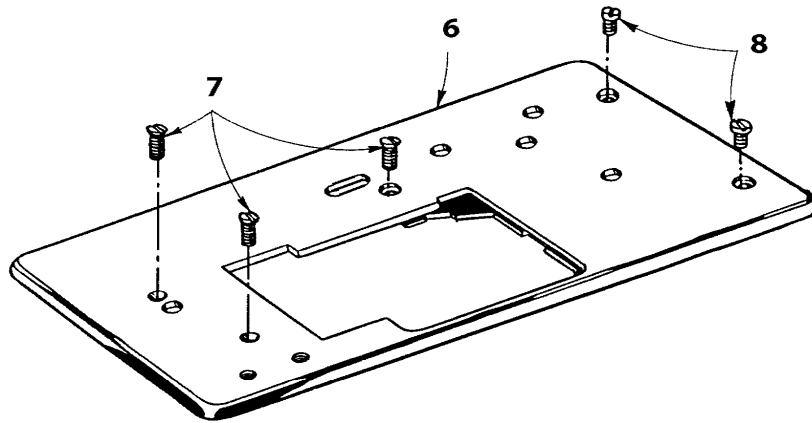
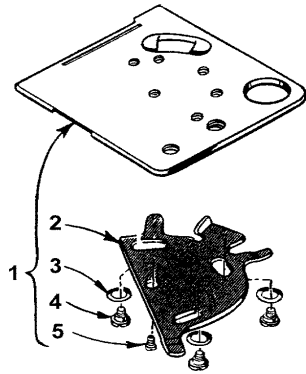
USE GENUINE REPAIR PARTS

Success in the operation of these machines can be secured only with genuine UNION SPECIAL repair parts as furnished by the Union Special Corporation, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles, and are made with utmost precision. Maximum efficiency and durability are assured.



SEWING PARTS 56400U16 & 56400UZ155

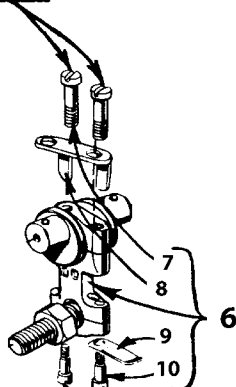
Ref. No.	Part No.	Description	Amt. Req.
1.	51417C16	Needle bar.....	1
2.	50J16	Stop pin.....	1
3.	51418-16	Needle head.....	1
4.	98	Screw for needle.....	2
5.	89	Spot Screw.....	1
6.	56425	Rear needle guard for 56400U16.....	1
	56425A	Rear needle guard for 56400UZ155..(formerly K74094).....	1
7.	22801	Screwf.....	1
8.	51408-16	Front looper.....	1
9.	51409	Rear looper.....	1
10.	21210	Looper collar.....	1
11.	50320AV	Presser foot (formerly K70247).....	1
12.	91	Screw.....	1
13.	51424AD16	Throat plate.....	1
14.	51405AD16	Feed dog.....	1



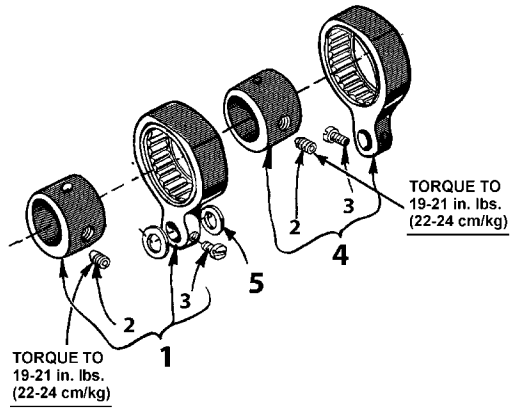
CLOTH PLATE FOR 56400U16 & 56400UZ155

Ref. No.	Part No.	Description	Amt. Req.
1.	56381-207A	Cloth plate insert.....	1
2.	51-902BLK	Spring.....	1
3.	35772H	Washer, sprin.....	3
4.	22760A	Screw.....	3
5.	22856B	Screw.....	1
6.	56401D	Cloth plate.....	1
7.	22526C	Screw.....	3
8.	22839C	Screw.....	2

TORQUE TO
19-21 in. lbs.
(22-24 cm/kg)

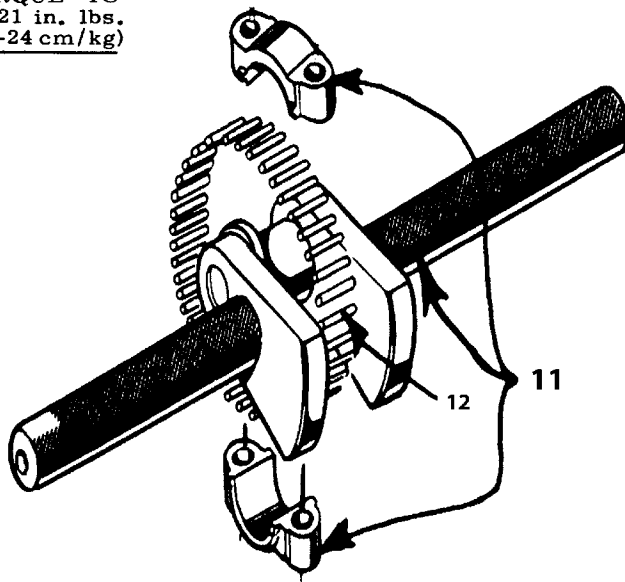


TORQUE TO
19-21 in. lbs.
(22-24 cm/kg)



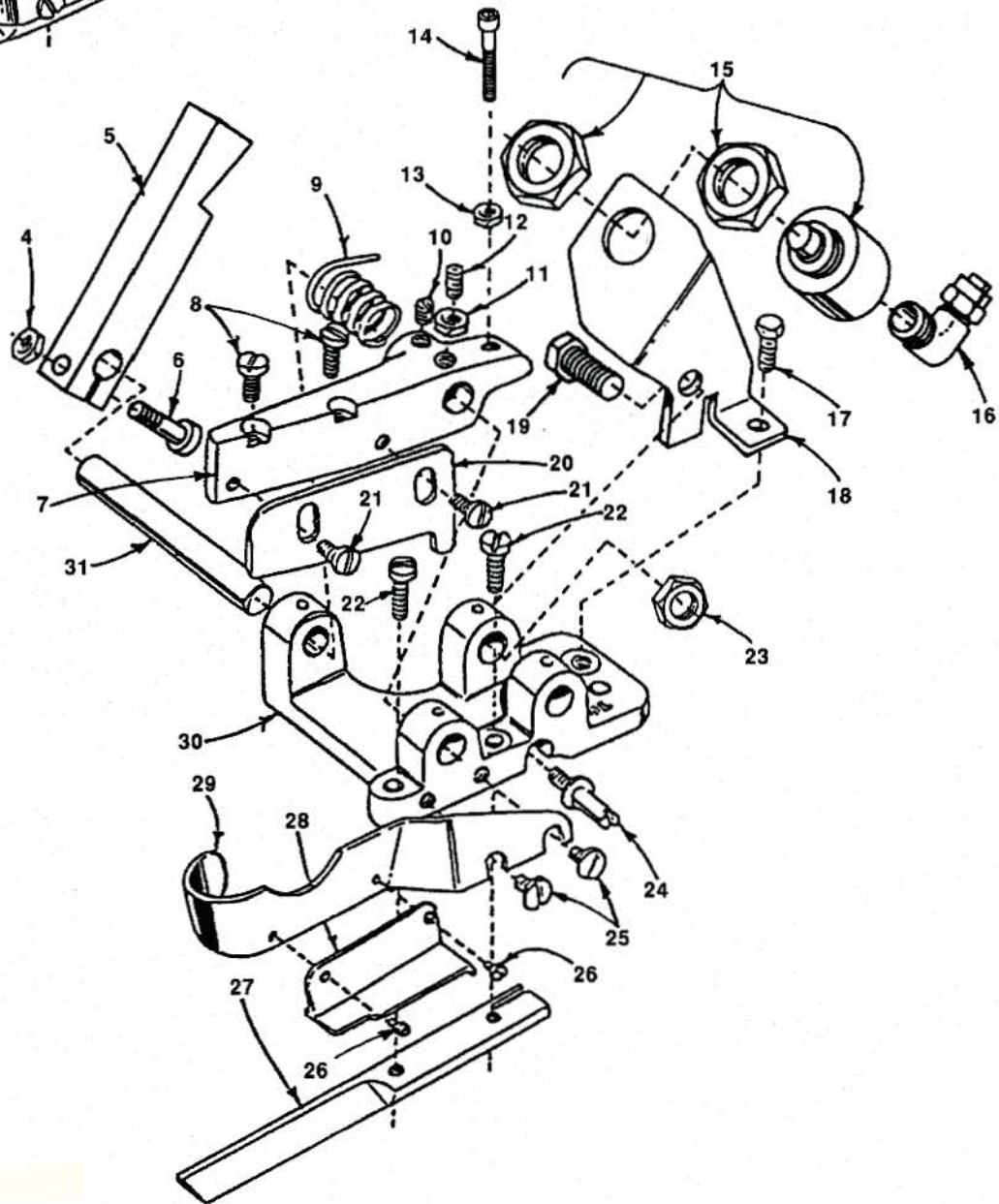
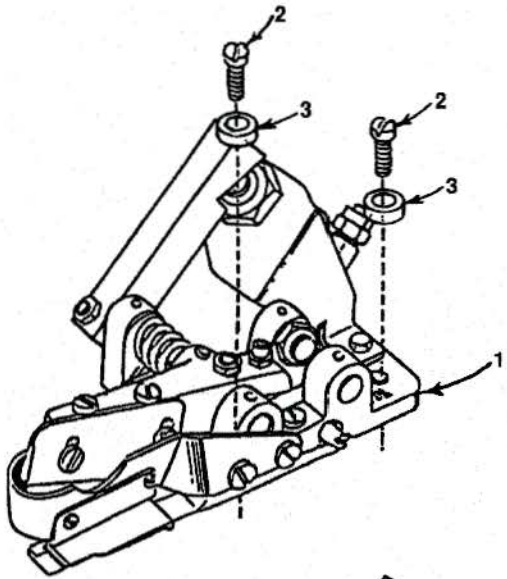
TORQUE TO
19-21 in. lbs.
(22-24 cm/kg)

TORQUE TO
19-21 in. lbs.
(22-24 cm/kg)



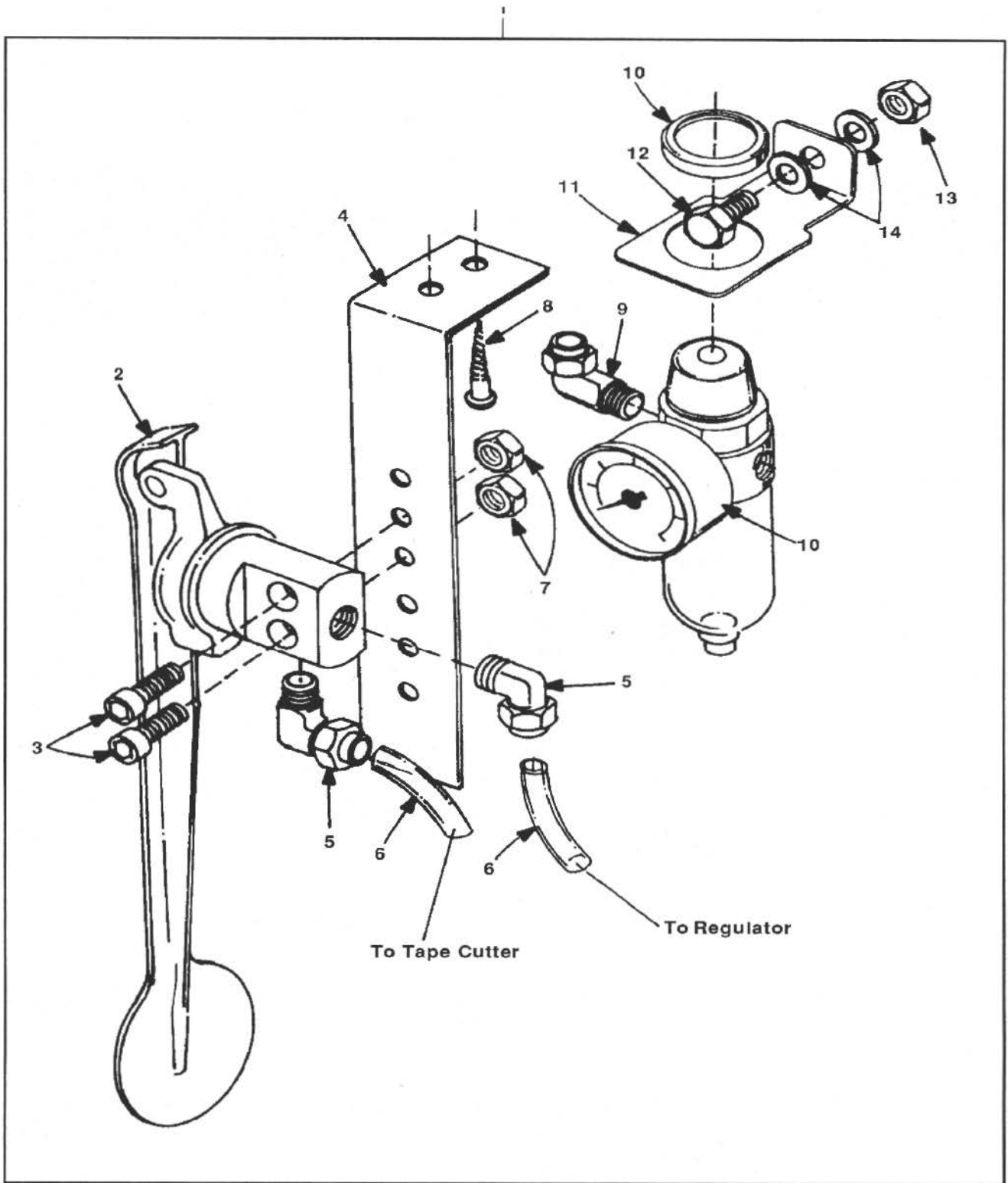
CRANKSHAFT, LOOPER DRIVING, FEED LIFT & LOOPER AVOID PARTS

Ref. No.	Part No.	Description	Amt. Req.
1.	29476NM062	Feed lift eccentric assembly.....	1
2.	22894AA	Spot screwr	1
3.	77	Screw.....	1
4.	29476NM054	Looper avoid eccentric assembly for 56400U16.....	1
	29476NM062	Looper avoid eccentric assembly for 56400UZ155.....	1
5.	39543N	Washer.....	2
6.	29105AL	Looper drive lever crank assembly (.308 inch throw) for 56400U16....	1
	29105AK	Looper drive lever crank assembly (.440 inch throw) for 56400UZ155....	1
7.	22587K	Screw.....	2
8.	56343C	Guide.....	1
9.	56343E	Oil splasher	1
10.	22559A	Screw.....	2
11.	29476LM	Crankshaft assembly (.770 inch throw) for 56400U16.....	1
	29476LL	Crankshaft assembly (.910 inch throw) for 56400UZ155.....	1
12.	51216M625	Needle bearing .0625 inch (1.588mm) diameter.....	28
	51216M626	Needle bearing .0626 inc (1.590mm) diameter.....	28
	51216M627	Needle bearing .0627 inch (1.593mm) diameter.....	28



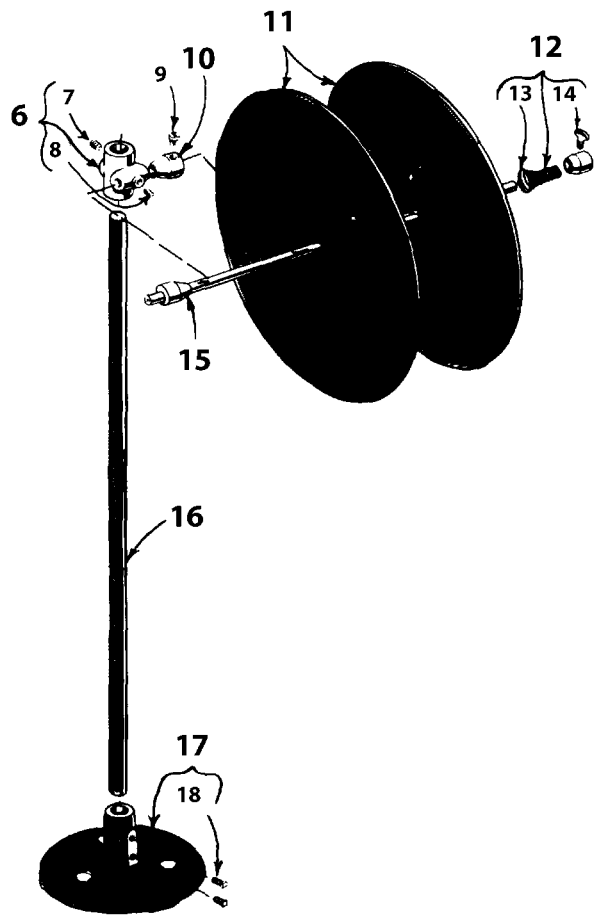
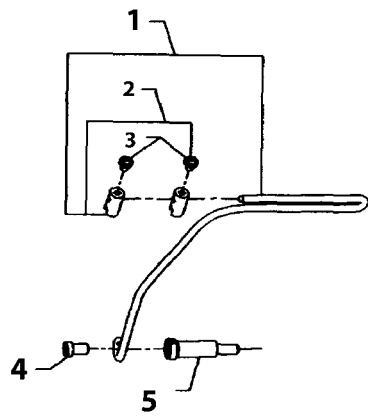
PNEUMATIC TAPE CUTTER ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	29486R	Tape cutter assembly	1
2.	136	Cutter mounting screw.....	2
3.	21212	Collar	2
4.	18	Nut.....	1
5.	52875T	Blade actuatuig arm.....	1
6.	55244G	Screw.....	1
7.	52875EA	Holder.....	1
8.	93	Screw	2
9.	52875G	Spring	1
10.	22894J	Set screw.....	1
11.	12538	Nut	1
12.	22894H	Set screw.....	1
13.	NU12	Nut	1
14.	22652A16	Screw.....	1
15.	671A2	Tape cutter air cylinder.....	1
16.	671F3	Male elbow	1
17.	22852	Screw	1
18.	52875S	Cylinder mounting bracket.....	1
19.	22604	Screw	1
20.	52875R	Curved upper knife.....	2
21.	22528	Screw for upper knife.....	2
22.	22596	Screw.....	1
23.	11698L	Nut	1
24.	15447A	Adjusting screw	2
25.	22829	Screw.....	2
26.	604	Screw for cloth guide	1
27.	52875C	Lower knife.....	1
28.	52875J	Cloth guide	1
29.	52875H	Knife guard	1
30.	52875	Frame	1
31.	52875U	Shaft	1



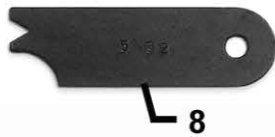
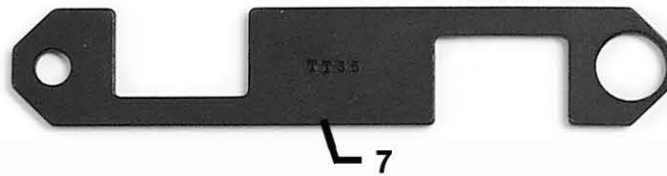
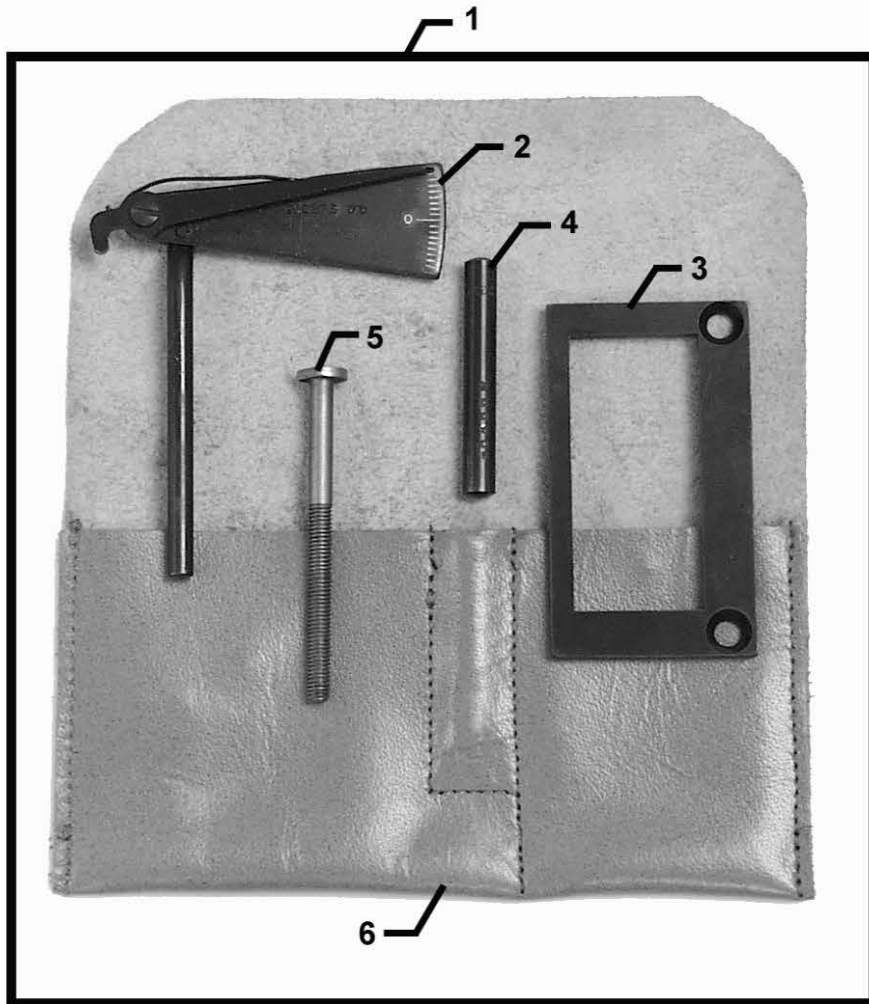
PNEUMATIC KNEE ACTUATOR & REGULATOR PARTS

Ref. No.	Part No.	Description	Amt. Req.
1.	29480ARB	Pneumatic knee lift kit	1
2.	660-434	Pneumatic knee lift actuator.....	1
3.	22652J14	Screw.....	2
4.	52875L	Mounting bracket.....	1
5.	671F3	Elbow fitting.....	2
6.	671B13	Tubing.....	1
7.	NU11	Nut	2
8.	SC330	Screw	2
9.	671F10	Elbow fitting	1
10.	671D31	Regulator.....	1
11.	39583A	Mounting bracket.....	1
12.	22642K48	Bolt	1
13.	21104H	Nut	1
14.	RM3293-2	Washer	2



TAPE GUIDE AND TAPE REEL PARTS

Ref. No.	Part No.	Description	Amt. Req.
1.	23306AP	Head cover tape guide	1
2.	23306AV	Tape stop guide	2
3.	25B	Screw	2
4.	88D	Screw	1
5.	52782C	Screw stud.....	1
6.	21217A	Tape reel axle support.....	1
7.	22650CB4	Screw	1
8.	22651CD4	Screw	1
9.	93A	Screw	1
10.	753	Tape reel disc collar.....	1
11.	21178A	Tape reel disc	2
12.	21177A	Tape reel spring collar.....	1
13.	22647K24	Thumb screw	1
14.	1349A5	Tension spring.....	1
15.	752	Tape reel axle	1
16.	21104B20	Tape reel rod	1
17.	21114AU	Tape reel base	1
18.	22651CD4	Screw	2



GAUGES
(EXTRA SEND AND CHARGE)

Ref. No.	Part No.	Description	Amt. Req.
1.	TT34	Synchronization Gauge Set	1
2.	21227S	Indicator	1
3.	21227T	Plate	1
4.	21227U	Pin	1
5.	99271	Screw	1
6.	21227AB	Pouch	1
7.	TT35	Gauge	1
*8.	21225-1/8	Looper Gauge	1

*May also be purchased as TT33
Which is a full set of looper gauges.

BLANK

BLANK

NUMERICAL INDEX OF PARTS

<u>Part No.</u>	<u>Page No.</u>	<u>Part No.</u>	<u>Page No.</u>	<u>Part No.</u>	<u>Page No.</u>	<u>Part No.</u>	<u>Page No.</u>
11698L.....	13	35772H.....	9	99271.....	19		
1349A5.....	17	39543N.....	11	NU11.....	15		
136.....	13	39583A.....	15	NU12.....	13		
12538.....	13	50J16.....	7	RM3293-2.....	15		
15447A.....	13	50320AV.....	7	SC330.....	15		
18.....	13	51-902BLK.....	9	TT34.....	19		
21104B20.....	17	51216M625.....	11	TT35.....	19		
21104H.....	15	51216M626.....	11				
21114AU.....	17	51216M627.....	11				
21177A.....	17	51405AD16.....	7				
21178A.....	17	51408-16.....	7				
21210.....	7	51409.....	7				
21212.....	13	51417C16.....	7				
21217A.....	17	51418-16.....	7				
21225-1/8.....	19	51424AD16.....	7				
21227AB.....	19	52782C.....	17				
21227S.....	19	52875.....	13				
21227T.....	19	52875C.....	13				
21227U.....	19	52875EA.....	13				
22526C.....	9	52875G.....	13				
22559A.....	11	52875H.....	13				
22587K.....	11	52875J.....	13				
22596.....	13	52875L.....	15				
22604.....	13	52875R.....	13				
22642K48.....	15	52875S.....	13				
22647K24.....	17	52875T.....	13				
22651CB4.....	17	52875U.....	13				
22651CD4.....	17	55244G.....	13				
22652A16.....	13	56343C.....	11				
22652J14.....	15	56343E.....	11				
22760A.....	9	56381-207A.....	9				
22801.....	7	56401D.....	9				
22829.....	13	56425.....	7				
22839C.....	9	56425A.....	7				
22852.....	13	604.....	13				
22856B.....	9	660-434.....	15				
22894H.....	13	671A2.....	13				
22894J.....	13	671B13.....	15				
22894AA.....	11	671D31.....	15				
23306AP.....	17	671F3.....	13, 15				
23306AV.....	17	671F10.....	15				
25B.....	17	752.....	17				
29105AK.....	11	753.....	17				
29105AL.....	11	77.....	11				
29476LL.....	11	88D.....	17				
29476LM.....	11	89.....	7				
29476NM054.....	11	91.....	7				
29476NM062.....	11	93.....	13				
29480ARB.....	15	93A.....	17				
29486R.....	13	98.....	7				

NUMERICAL INDEX OF PARTS

Part No. **Page No.** Part No. **Page No.** Part No. **Page No.**

Union Special Corporation
Corporate Office
One Union Special Plaza
Huntley, IL 60142
Phone: 847•669•4500
Fax: 847•669•4454

Union Special GmbH
Raiffeisenstrasse 3
D-71696 Möglingrn, Germany
Tel: 49-07141-247-0
Fax: 49-7141-247-100



Union Special[®]
INDUSTRIAL SEWING EQUIPMENT