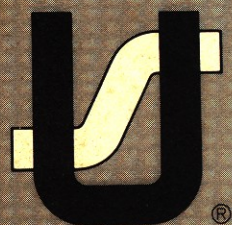
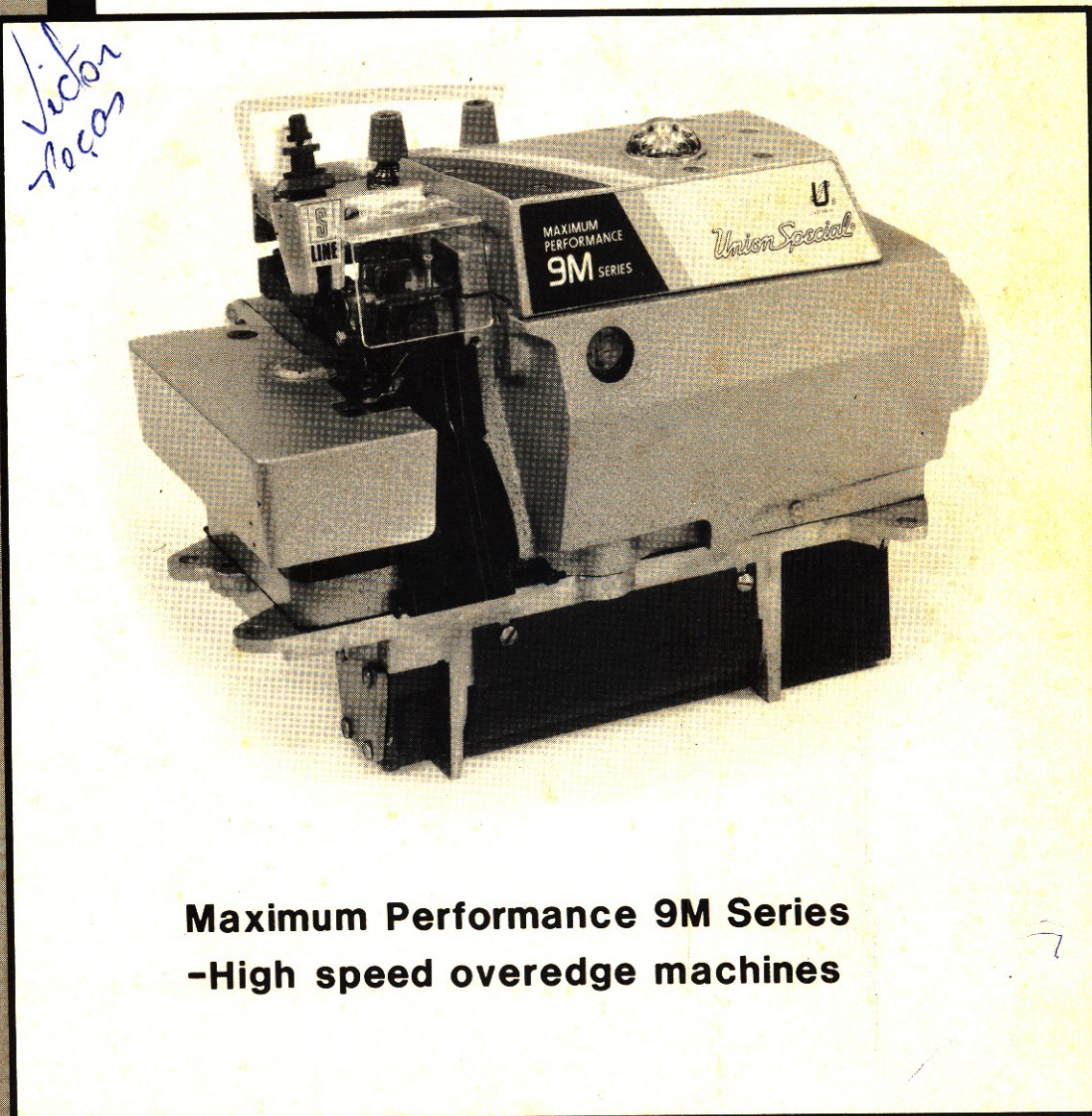


CATALOG NO.
103XQA

First Edition

SERIES
39500
9M

Adjusting instructions and illustrated parts list

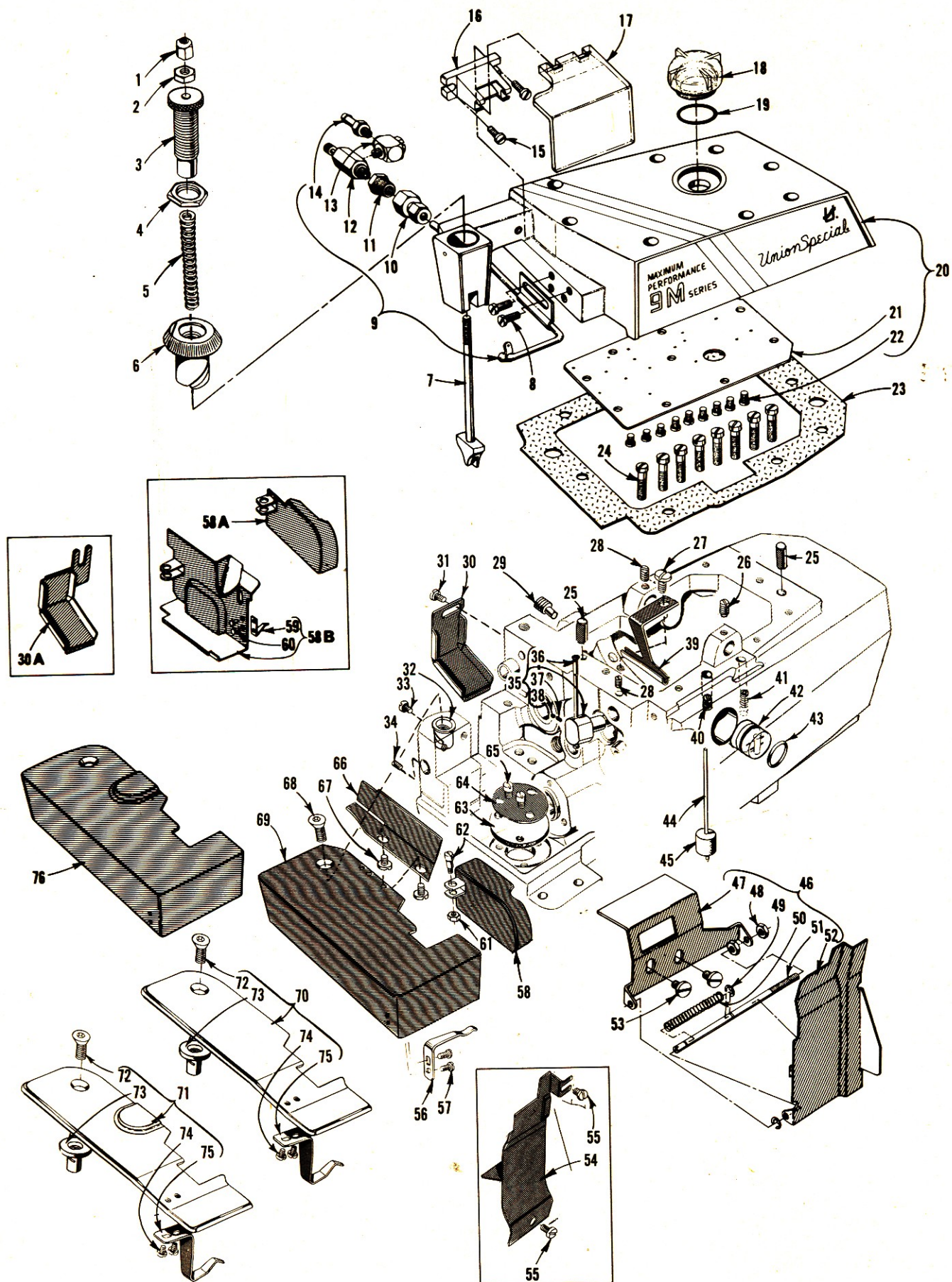


Finest Quality

30 folhas

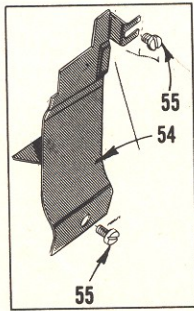
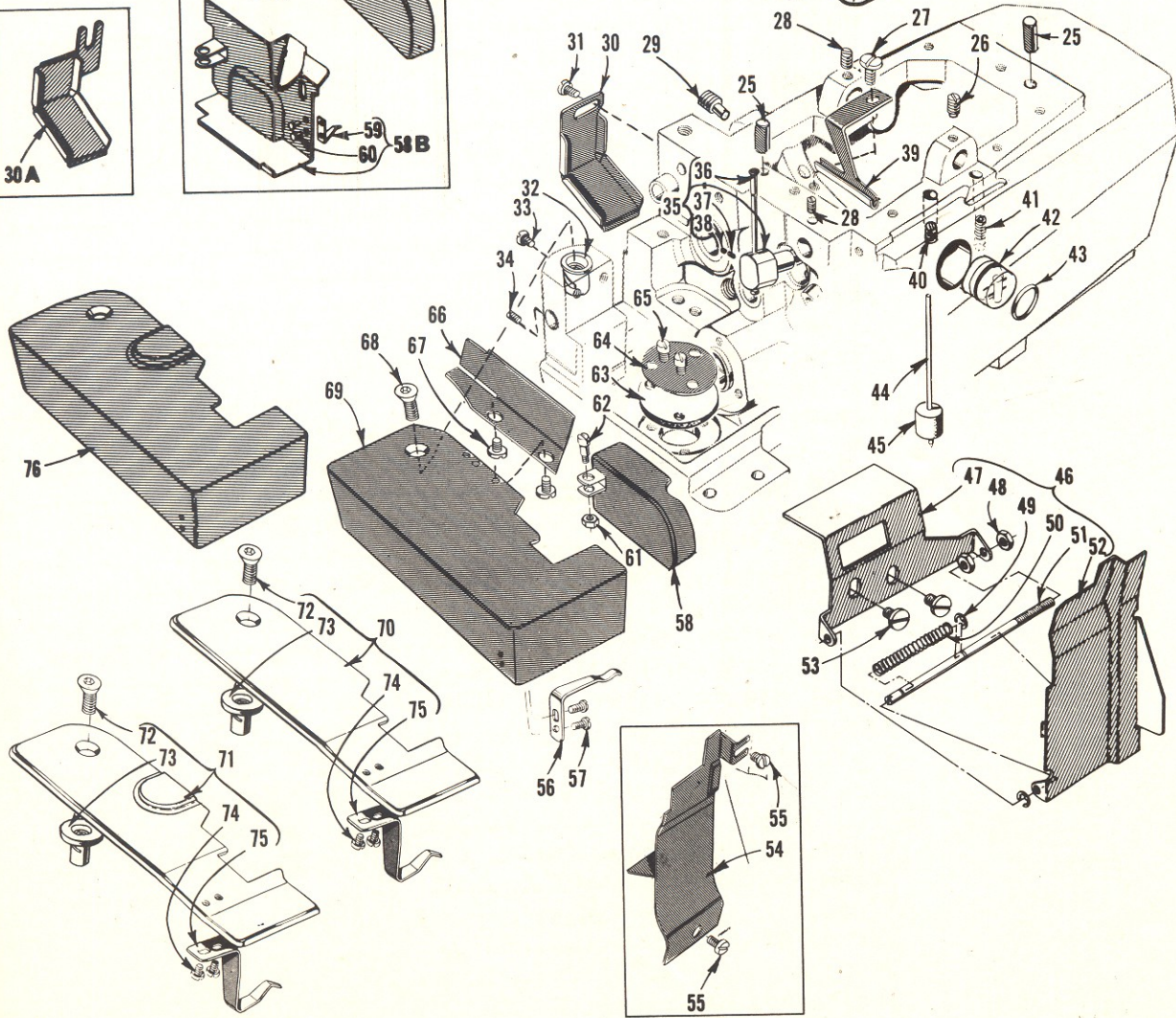
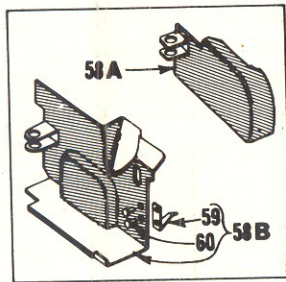
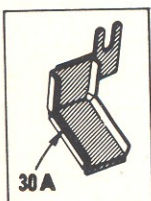
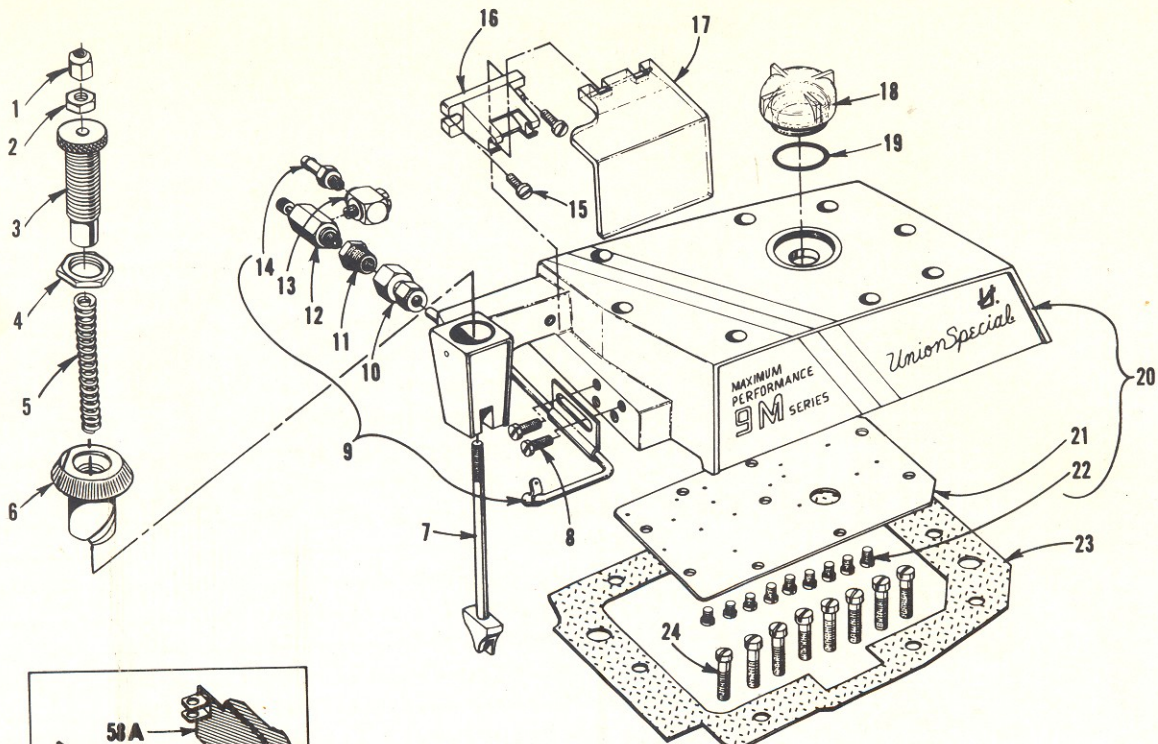
Union Special®
Industrial Sewing Equipment

ORIGINAL



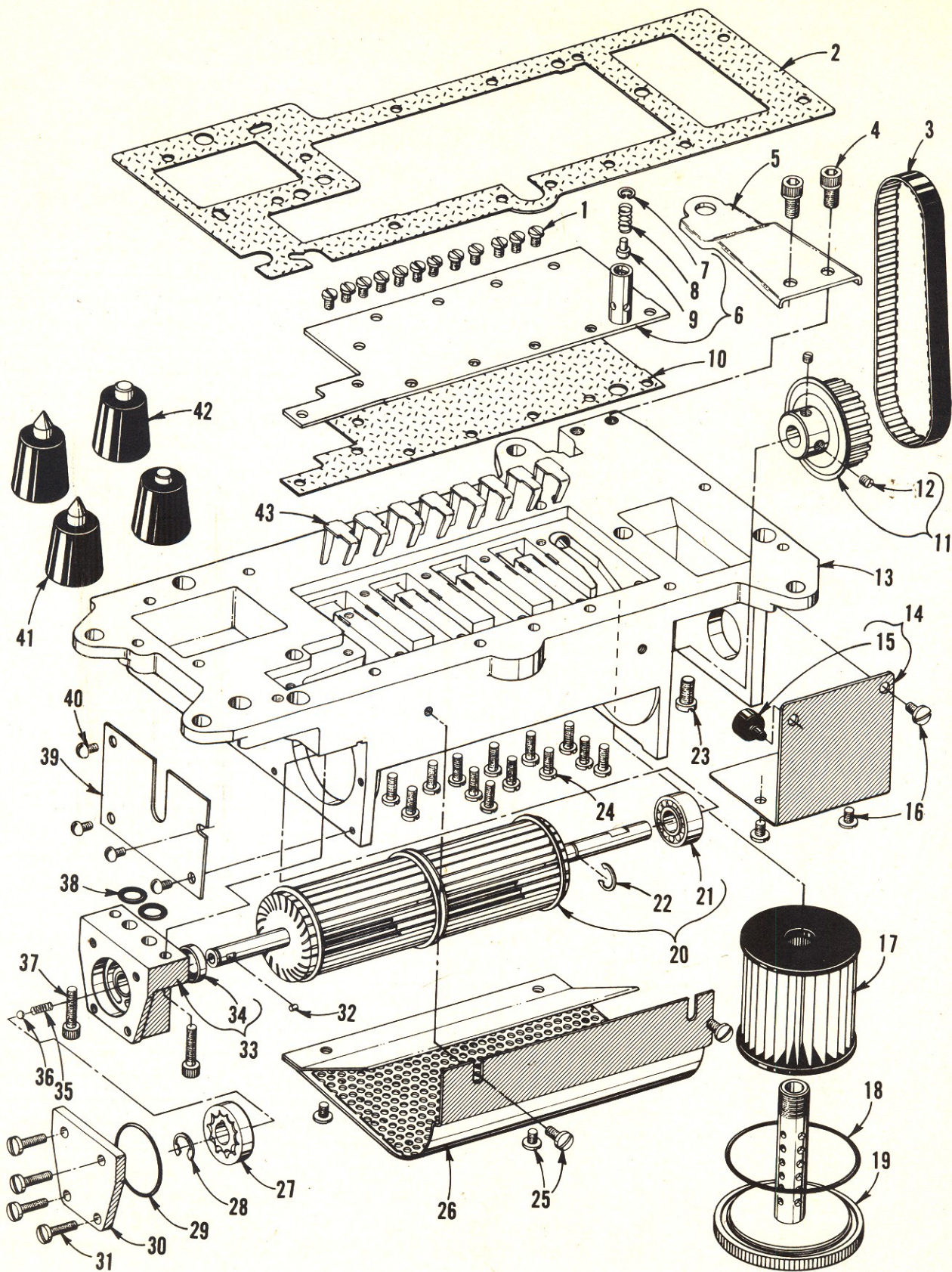
MAIN FRAME, PRESSER FOOT RELEASE PARTS,
MISCELLANEOUS COVERS AND PLATES

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	39557 B	Nut, cap, presser spring plunger -----	1
2	39557 E	Nut, locking -----	1
3	39557 C	Screw, adjusting -----	1
4	39557 F	Nut, lock, adjusting screw -----	1
5	39557 H	Spring, presser -----	1
6	39556 A	Bushing, presser foot release -----	1
7	39557 A	Plunger, presser spring -----	1
8	22569 B	Screw, needle cooler and thread eyelet -----	2
9	21237 CR	Cooler, needle all Styles except XRB, XRC -----	1
-	21237 DK	Cooler, needle, Styles XRB, XRC -----	1
10	660-372	Connector -----	1
11	671 C-13	Bushing, reducer -----	1
12	671-17	Valve, control -----	1
13	671 F-62	Elbow, adjustable -----	1
14	671 F-4	Fitting, barb -----	1
15	22585 R	Screw -----	2
16	21695 AT	Bracket, mounting -----	1
17	21695 AU	Shield, sewing -----	1
18	39594 Y	Cap, oil fill -----	1
19	660 705	"O" Ring -----	1
20	39582 DV	Cover, top -----	1
21	39582 DS	Plate, oil drip -----	1
22	22564 D	Screw -----	9
23	39582 BZ	Gasket, top cover -----	1
24	22541	Screw, top cover -----	8
25	667 D-8	Pin, dowel -----	2
26	22565 S	Screw, spot, upper looper drive lever shaft -----	1
27	22569 D	Screw -----	1
28	22565	Screw, set, upper thread tube assembly and upper looper drive lever shaft -----	2
29	22571 E	Screw, oil drain plug -----	1
30	39534 R	Shield, oil, feed bar, all Styles w/o Power "AIR-KLIPP" chain cutter -----	1
30A	39534 RB	Shield, oil, feed bar, all Styles w/Power "AIR-KLIPP" chain cutter -----	1
31	90	Screw -----	1
32	39501 K	Stud, cloth plate, all Styles except XRN, XSD, CXRN, CXSD -----	1
33	22569	Screw, locking, cloth plate stud -----	1
34	22565 F	Screw, locking, feed adjusting pin -----	1
35	29477 GW	Thread Tube Assembly, upper looper -----	1
36	39568 G	Tube, thread -----	1
37	39568 J	Spring, tension -----	1
38	22743	Screw, set -----	1
39	39594 R	Plate, oil collector -----	1
40	22569 K	Screw, oil gauge -----	1
41	22894 AE	Screw, set, lower looper bar driving lever shaft -----	2
42	39593 H	Gauge, oil -----	1
43	660-243	Ring, oil seal -----	1
44	39593 D	Indicator, oil gauge -----	1
45	39593 C	Float, oil gauge -----	1
46 thru 76		See following page	



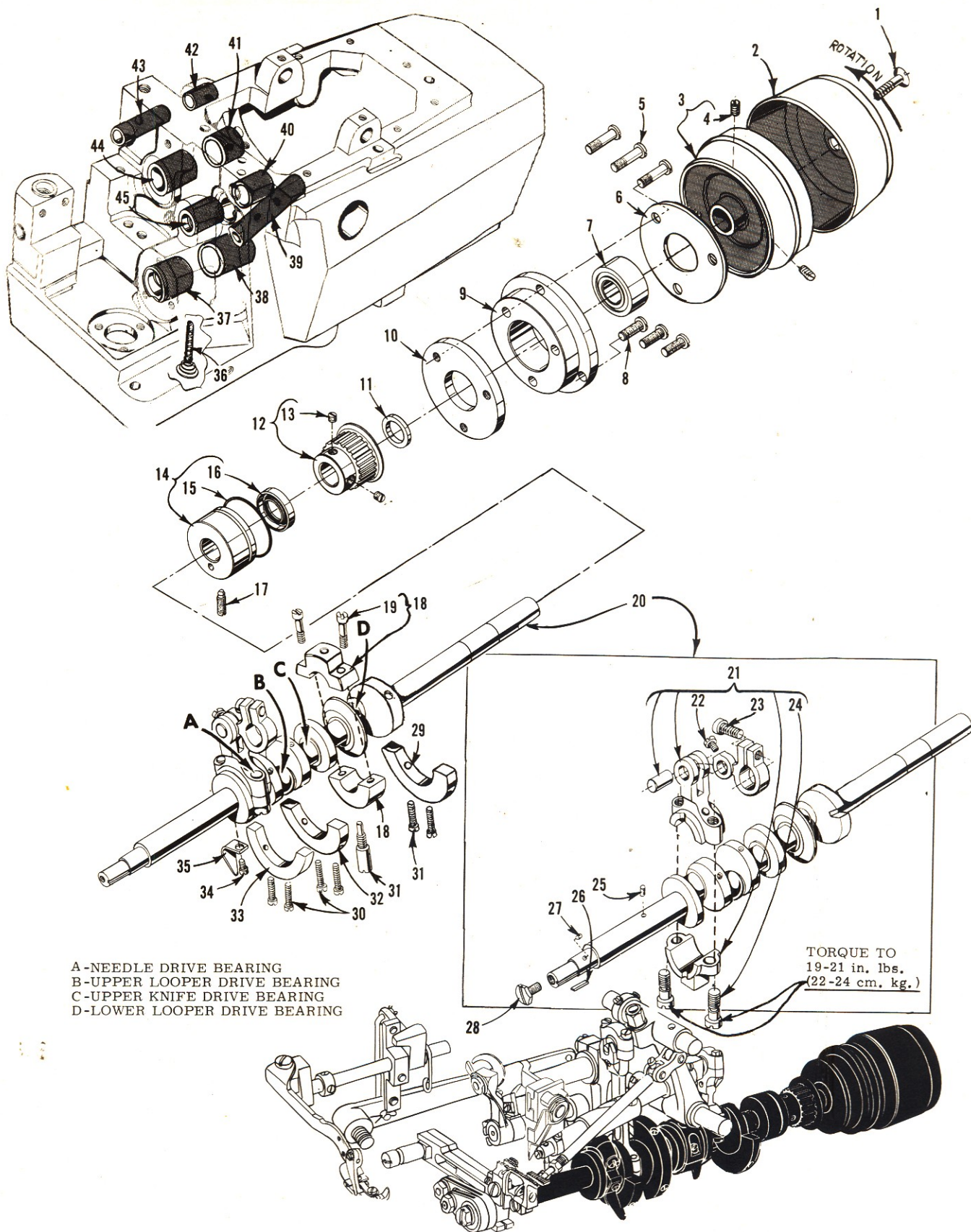
MAIN FRAME, PRESSER FOOT RELEASE PARTS,
MISCELLANEOUS COVERS AND PLATES

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1 thru 45		See preceding page	
46	39578 AX	Guard Assembly, chip, all Styles except XRC, XRN, XSD, CXRN, CXSD -----	1
47	39578 AL	Base -----	1
48	43443 Q	Nut -----	2
49	660-210	Ring, retaining -----	2
50	39158 U	Spring -----	1
51	39878 C	Pin, hinge -----	1
52	39578 AY	Cover -----	1
53	22569 D	Screw -----	2
54	39578 T	Guard, chip, Styles XRN, XSD, CXRN, CXSD -----	1
-	39578 U	Guard, chip, Style XRC -----	1
55	22569 D	Screw -----	2
56	39532 A	Spring, cloth plate latch, all Styles except XRN, XSD, CXRN, CXSD -----	1
57	90	Screw, latch spring, all Styles except XRN, XSD, CXRN, CXSD -----	2
58	39582 D	Cover, feed mechanism, all Styles w/o Power "AIR-KLIPP" chain cutter except XQJ, XRN, XSD -----	1
-	39582 K	Cover, feed mechanism, Style XQJ -----	1
58A	99679	Cover, feed mechanism, Styles CXQA, CXQB, CXQJ, CXSQB --	1
58B	39582 EA	Cover, feed mechanism, Styles XRN, XSD, CXRN, CXSD -----	1
59	39582 H	Spring -----	1
60	39582 J	Rivet -----	2
61	41071 G	Nut -----	1
62	86 X	Screw -----	1
63	39594 H	Strainer, oil -----	1
64	39594 G	Screen, oil filter -----	1
65	22569 B	Screw -----	2
66	39578 F	Guard, cloth plate fabric, Styles XQA, XQB, XQJ, XRB, XRC, XTA, XSQB -----	1
67	138	Screw, Styles XQA, XQB, XQJ, XRB, XRC, XTA, XSQB -----	2
68	22657 D-12	Screw, cloth plate, all Styles except XRN, XSD, CXRN, CXSD -----	1
69	39501 D	Cloth Plate, Styles XQA, XQB, XRC-045, XTA, XSQB -----	1
-	39501 DG	Cloth Plate, Style XQJ -----	1
-	39501 DD	Cloth Plate, Style XRB -----	1
-	39501 DC	Cloth Plate, Style XRC-060 -----	1
70	39501 AP	Cloth Plate, Styles XRN, XSD -----	1
71	39501 M	Cloth Plate, Styles CXRN, CXSD -----	1
72	22657 D-12	Screw, Styles XRN, XSD, CXRN, CXSD -----	1
73	39501 K	Stud, Styles XRN, XSD, CXRN, CXSD -----	1
74	22513	Screw, Styles XRN, XSD, CXRN, CXSD -----	2
75	39532 D	Spring, latch, Styles XRN, XSD, CXRN, CXSD -----	1
76	G39501 D	Cloth Plate, Styles CXQA, CXQB, CXQJ, CXSQB -----	1



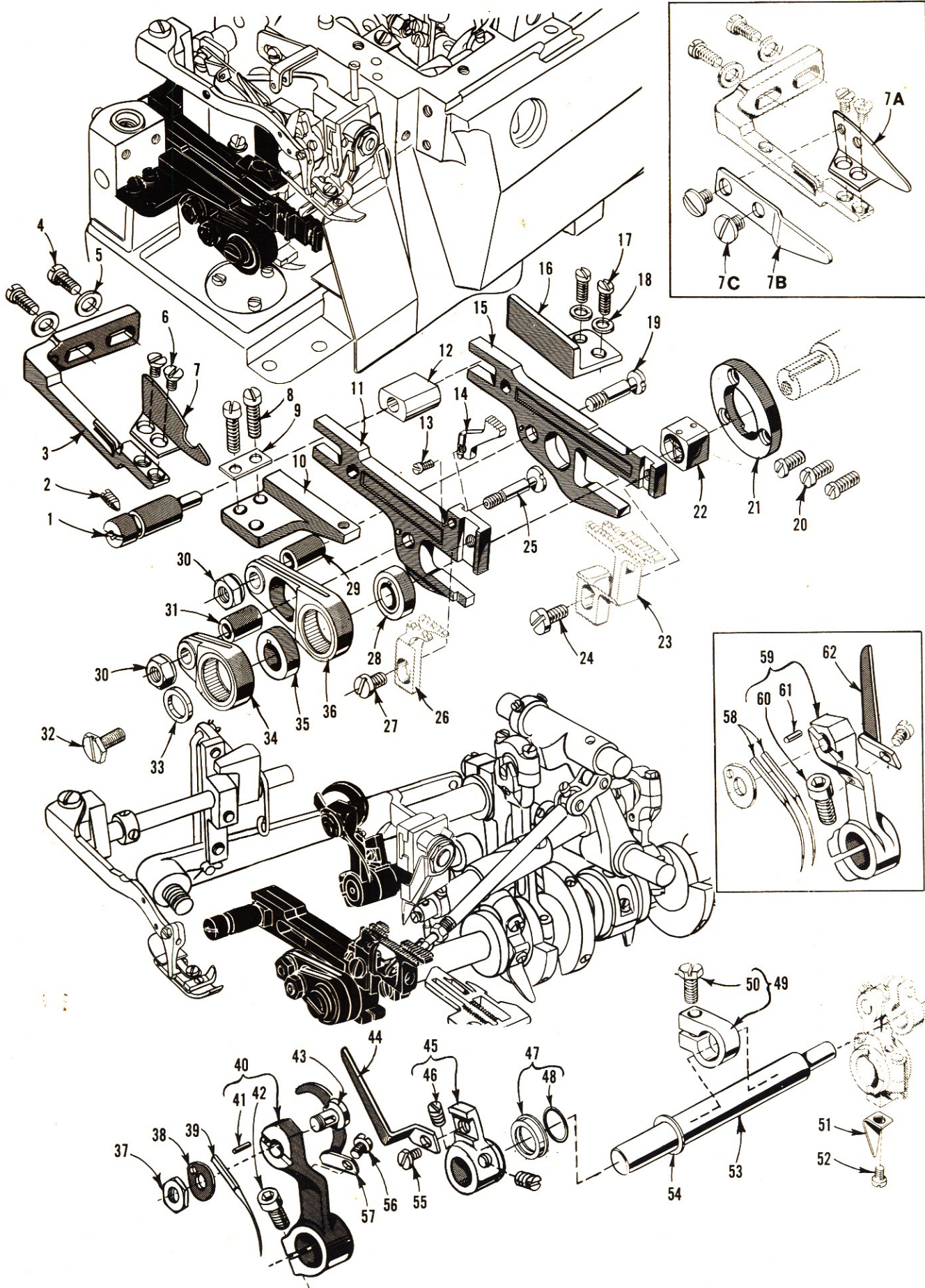
BOTTOM COVER, LUBRICATING AND OIL COOLING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1	22569 T	Screw, internal bottom cover -----	12
2	39582 DU	Gasket, bottom cover -----	1
3	660-828	Belt, oil cooler drive -----	1
4	22652 D-6	Screw -----	2
5	39582 F	Extension, bottom cover -----	1
6	39582 DZ	Cover, bottom (internal) -----	1
7	660-700	Ring, retaining -----	1
8	39536 DA	Spring -----	1
9	39536 CZ	Plunger -----	1
10	39582 DY	Gasket, internal bottom cover -----	1
11	39542 A	Pulley, blower and oil pump -----	1
12	22650 CB-4	Screw, set -----	2
13	39582 ES	Cover, bottom -----	1
14	21375 BR	Cover, pulley -----	1
15	660-731	Bumper -----	1
16	RM2813-1	Screw -----	3
17	666-295	Filter, oil -----	1
18	660-717	"O" Ring -----	1
19	39582 DT	Cover, oil filter -----	1
20	21237 DM	Blower, transverse -----	1
21	660-841	Bearing -----	1
22	660-550	Ring, retaining -----	1
23	22586 T	Screw, bottom cover -----	1
24	22541 B	Screw, bottom cover -----	13
25	RM2813-1	Screw -----	4
26	21237 CT	Cover, fan -----	1
27	C50093 U	Gear, oil pump -----	1
28	660-550	Ring, retaining -----	1
29	660-695	"O" Ring, oil pump -----	1
30	39582 DP	Cover, oil pump housing, end -----	1
31	RM2813-4	Screw -----	4
32	39541 D	Key, oil pump shaft -----	1
33	21237 CW	Housing, oil pump -----	1
34	660-726	Seal, oil lip -----	1
35	21237 DN	Spring -----	1
36	79-33	Ball -----	1
37	22652 B-12	Screw -----	2
38	660-716	"O" Ring, oil pump -----	2
39	39582 EN	Cover, fan end -----	1
40	22635 C-12	Screw -----	4
41	51295 B	Isolator, all Styles except XRC -----	2
42	39595	Isolator, all Styles except XRC -----	2
-	39595	Isolator, Style XRC -----	4
43	39594 X	Deflector, oil flow -----	8



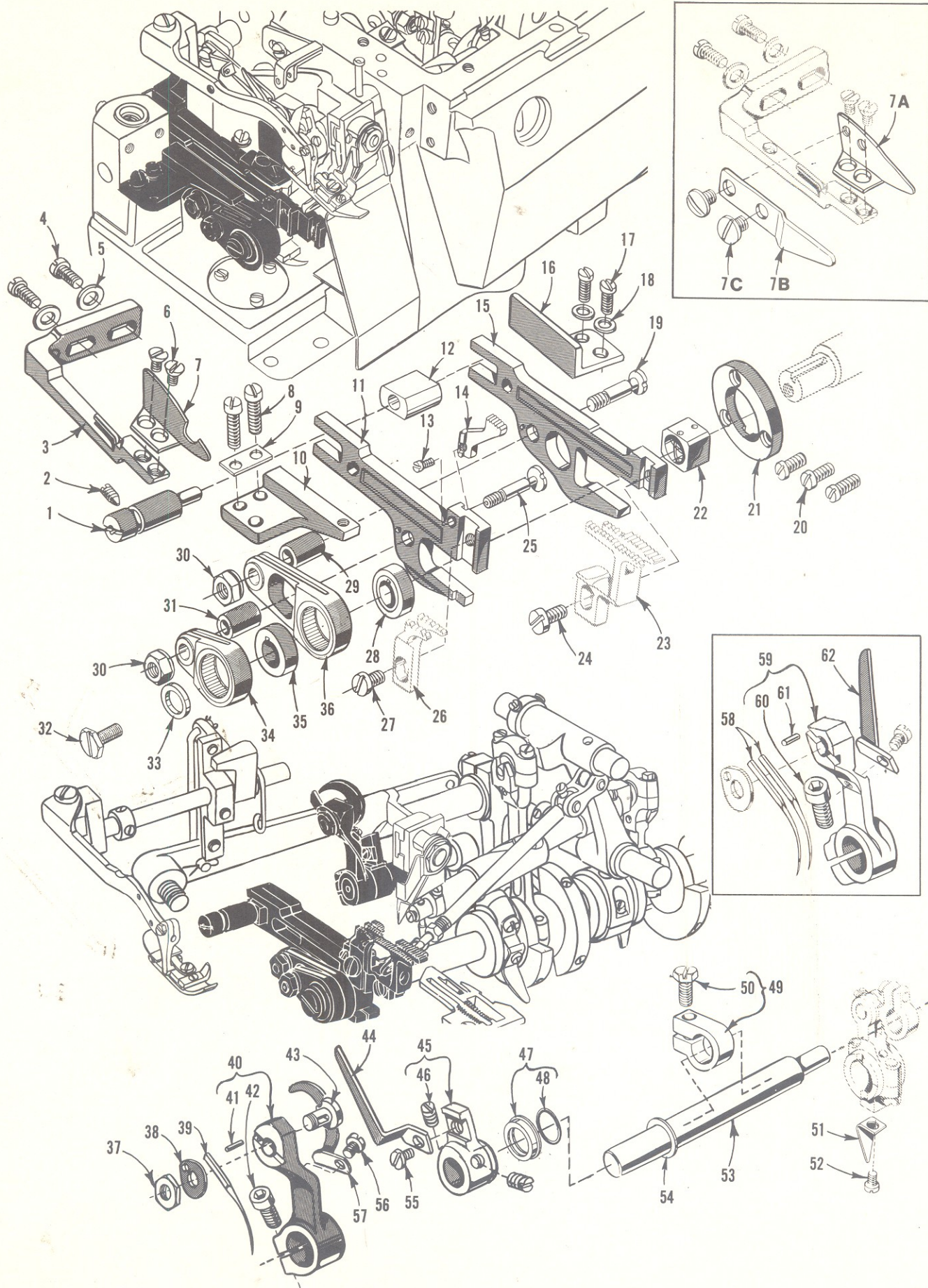
CRANKSHAFT MECHANISM AND BUSHINGS

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	22769 B	Screw -----	1
2	39521 D	Cap, pulley -----	1
3	39521 H	Pulley -----	1
4	22650 CD-4	Screw -----	2
5	22569 X	Screw -----	3
6	39590 H	Plate, retaining, crankshaft ball bearing -----	1
7	660-835	Bearing, ball -----	1
8	22569 Y	Screw -----	3
9	39590 Z	Housing, bearing -----	1
10	39590 AA	Plate, retaining, crankshaft ball bearing -----	1
11	39590 J	Washer, thrust -----	1
12	39542	Pulley, crankshaft -----	1
13	22650 CB-4	Screw, set -----	2
14	39590 Y	Bearing, crankshaft (intermediate) -----	1
15	660-443	"O" Ring -----	1
16	660-764	Seal, oil -----	1
17	22565 F	Screw -----	1
18	39590 D	Bearing, split -----	1
19	97 A	Screw -----	2
20	29477 MS	Crankshaft and Needle Driving Arm Crank Assembly -----	1
21	29477 MC	Needle Driving Arm Crank and Connecting Rod Assembly -----	1
22	22768 C	Screw, connecting rod pin -----	1
23	22596 H	Screw, driving arm crank -----	1
24	22587 M	Screw, connecting rod -----	2
25	51-228 Blk.	Plug, vent -----	1
26	39541 C	Key, feed driving eccentric -----	1
27	30-106 Blk.	Plug, wood -----	1
28	22781 A	Screw -----	1
29	39591 B	Counterweight, crankshaft (right) -----	1
30	22747 B	Screw -----	6
31	39590 N	Stud, split bearing -----	1
32	39591 A	Counterweight, crankshaft (intermediate) -----	1
33	39591 K	Counterweight, crankshaft (left) -----	1
34	87 C	Screw -----	1
35	39594 N	Splasher, oil -----	1
36	666-94	Wick and Spring, oil -----	1
37	39590 AB	Bushing, crankshaft (left) -----	1
38	39590 T	Bushing, crankshaft (intermediate) -----	1
39	39544 X	Bushing, lower looper bar -----	1
40	39552 P	Bushing, needle driving arm crank (right) -----	1
41	39573 AA	Bushing, upper knife driving arm (right) -----	1
42	39555 R	Bushing, foot lifter shaft (right) -----	1
43	39555 P	Bushing, foot lifter shaft (left) -----	1
44	39573 K	Bushing, upper knife driving arm (left) -----	1
45	39552 U	Bushing, needle driving arm crank (left) -----	1



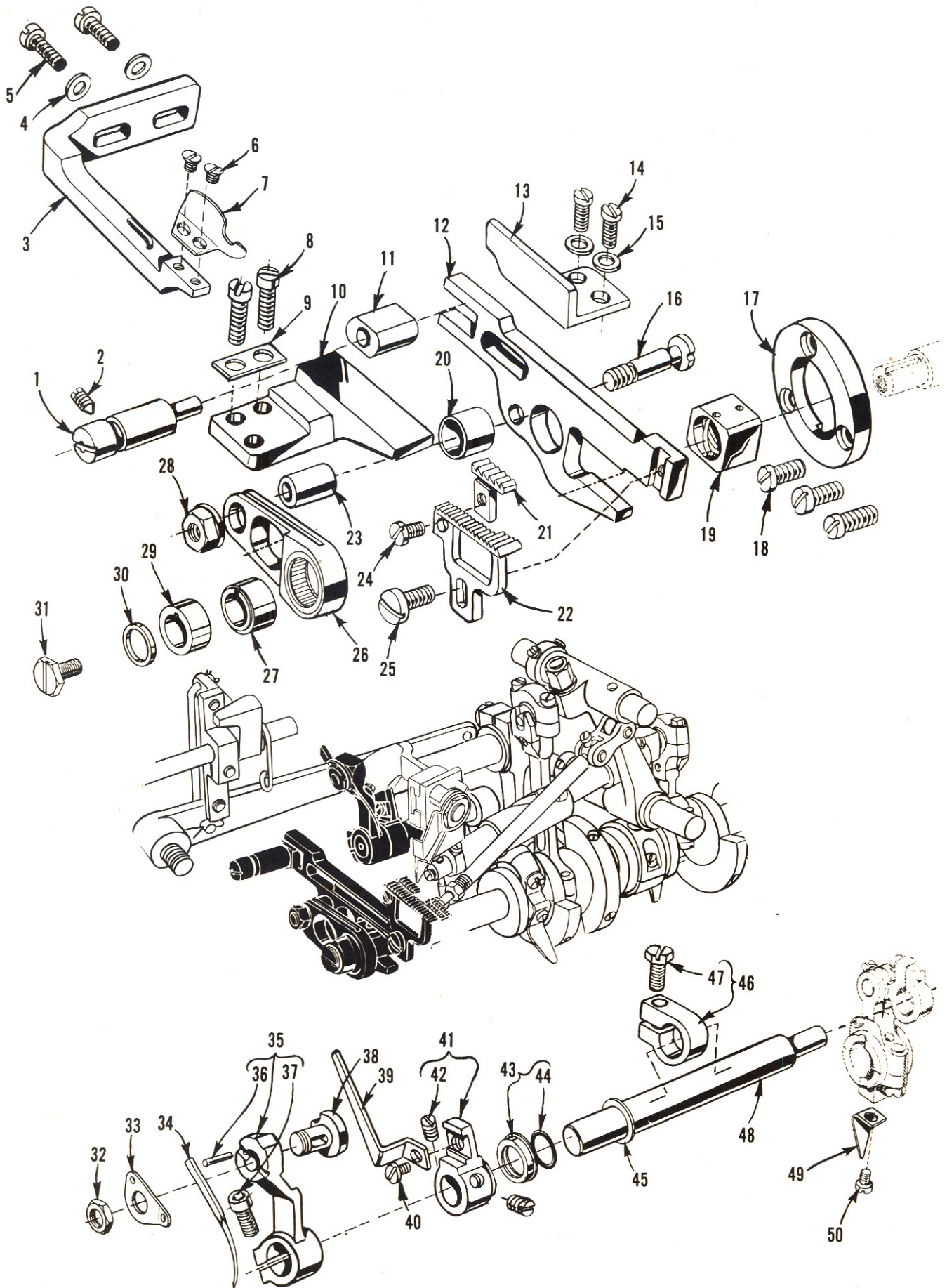
NEEDLE DRIVE AND FEED MECHANISM
(ALL STYLES EXCEPT 39500 XQJ AND CXQJ)

Ref. No.	Part No.	Description	Amt. Req.
1	39535 C	Pin, feed adjusting -----	1
2	22565 F	Screw, locking -----	1
3	39578 P	Bracket, fabric guard mounting, all Styles w/o Power "AIR-KLIPP" chain cutter -----	1
4	22569 B	Screw, all Styles w/o Power "AIR-KLIPP" chain cutter ---	2
5	8372 A	Washer, all Styles w/o Power "AIR-KLIPP" chain cutter --	2
6	87	Screw, all Styles w/o Power "AIR-KLIPP" chain cutter ---	2
7	G39578 M	Guard, fabric, all Styles w/o Power "AIR-KLIPP" chain cutter except XRN -----	1
7A	39578 V	Guard, fabric, Style XRN -----	1
7B	39556 N	Lever, tilt, presser foot, Style XRN -----	1
7C	22561	Screw, presser foot tilt lever, Style XRN -----	2
8	22541 B	Screw -----	2
9	39835 G	Washer, plate -----	1
10	39535 W	Guide, main feed bar (left) -----	1
11	39534	Feed Bar, main -----	1
12	39535 V	Block, feed bar guide -----	1
13	22797 A	Screw, chaining feed dog, all Styles except XRB, XTA ---	1
14		Feed Dog, chaining (See Pages 49 & 51) -----	1
15	39534 G	Feed Bar, differential -----	1
16	39535 D	Guide, differential feed bar (right) -----	1
17	22569 B	Screw -----	2
18	53634 C	Washer -----	2
19	39536 CV	Stud, differential, feed bar driving -----	1
20	22569 G	Screw -----	3
21	39534 AF	Washer, thrust, differential feed bar -----	1
22	39538 A	Block, feed lift -----	1
23		Feed Dog, differential (See Pages 49 & 51) -----	1
24	22528	Screw, differential feed dog -----	1
25	39536 CX	Stud, main feed bar driving -----	1
26		Feed Dog, main (See Pages 49 & 51) -----	1
27	93 A	Screw, main feed dog, all Styles except XRN, CXRN -----	1
-	22528	Screw, main feed dog, Styles XRN, CXRN -----	1
28	39540 M-7	Eccentric, differential feed driving, Styles XRN, CXRN -	1
-	39540 M-8	Eccentric, differential feed driving, Styles XSD, CXSD -	1
-	39540 M-10	Eccentric, differential feed driving, Styles XQA, XQB, CXQA, CXQB, XSQB, CXSQB -----	1
-	39540 M-18	Eccentric, differential feed driving, Styles XRB, XRC --	1
-	39540 M-30	Eccentric, differential feed driving, Style XTA -----	1
29	39536 CW	Bushing, differential feed bar driving stud -----	1
30	39536 E	Nut, feed bar driving stud -----	2
31	39536 CY	Bushing, main feed bar driving stud -----	1
32	22781 A	Screw, crankshaft -----	1
33	39543 AA	Spacer, crankshaft -----	1
34	39536 CT	Connection, main feed bar driving -----	1
35 thru 62		See following page	



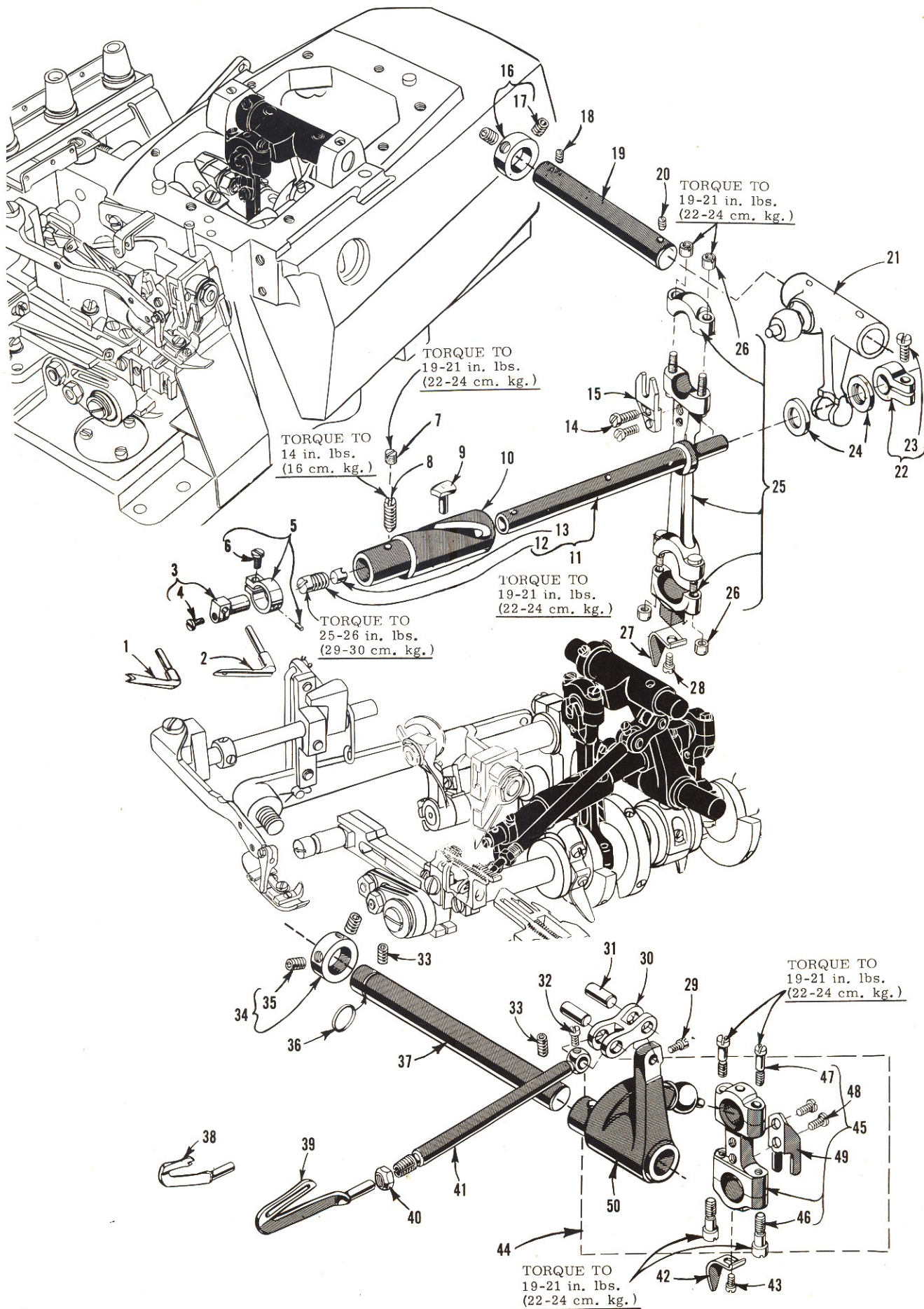
NEEDLE DRIVE AND FEED MECHANISM
(ALL STYLES EXCEPT 39500 XQJ AND CXQJ)

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1 thru 34		See preceding page	
35	39540 M-9	Eccentric, main feed driving, Styles XRN, CXRN -----	1
-	39540 M-12	Eccentric, main feed driving, Styles XQA, XQB, CXQA, CXQB, XSQB, CXSQB -----	1
-	39540 M-14	Eccentric, main feed driving, Styles XSD, CXSD -----	1
-	39540 M-20	Eccentric, main feed driving, Styles XRB, XRC -----	1
-	39540 M-30	Eccentric, main feed driving, Style XTA -----	1
36	39536 CU	Connection, differential feed bar driving -----	1
37	14077 A	Nut, needle clamp stud -----	1
38	39551 H	Washer, needle clamp -----	1
39	154 GAS	Needle, all Styles except XRB, XRC, XSQB, CXSQB -----	1
-	162 SAS	Needle, Styles XSQB, CXSQB -----	1
40	39552 Z	Arm, needle driving, marked "K", all Styles except XRB, XRC, XSQB, CXSQB -----	1
-	39552 AJ	Arm, needle driving, marked "S", Styles XSQB, CXSQB ----	1
41	39552 AD	Pin, stop -----	1
42	22596 E	Screw -----	1
43	39551 J	Stud, needle clamp -----	4
44	39568 AH	Pull-off, looper thread -----	1
45	39568 AC	Lever, looper thread pull-off -----	1
46	88 B	Screw -----	2
47	39552 AG	Seal, oil, needle driving shaft -----	1
48	660-207	Ring, oil seal -----	1
49	39543 Y	Collar, thrust, needle drive shaft -----	1
50	22782 A	Screw -----	1
51	39594 N	Splasher, oil -----	1
52	87 C	Screw -----	1
53	39552 R	Shaft, needle driving -----	1
54	C50043 F	Washer, for thrust collar -----	1
55	22513 D	Screw -----	1
56	87 C	Screw -----	1
57	39563 AC	Cam Pull-off, needle thread, all Styles except XRB ----	1
58	154 GDS	Needle, Style XRC-060 -----	2
-	154 GFS	Needle, Styles XRB, XRC-045 -----	2
59	39552 AA	Arm, needle driving, marked "L", Styles XRB, XRC-045 ---	1
-	39552 AB	Arm, needle driving, marked "M", Style XRC-060 -----	1
60	22596 E	Screw -----	1
61	39552 AD	Pin, stop -----	1
62	39563 P	Pull-off, needle thread, Style XRB -----	1



NEEDLE DRIVE AND PLAIN FEED MECHANISM
(STYLES 39500 XQJ, CXQJ, UNLESS OTHERWISE SPECIFIED)

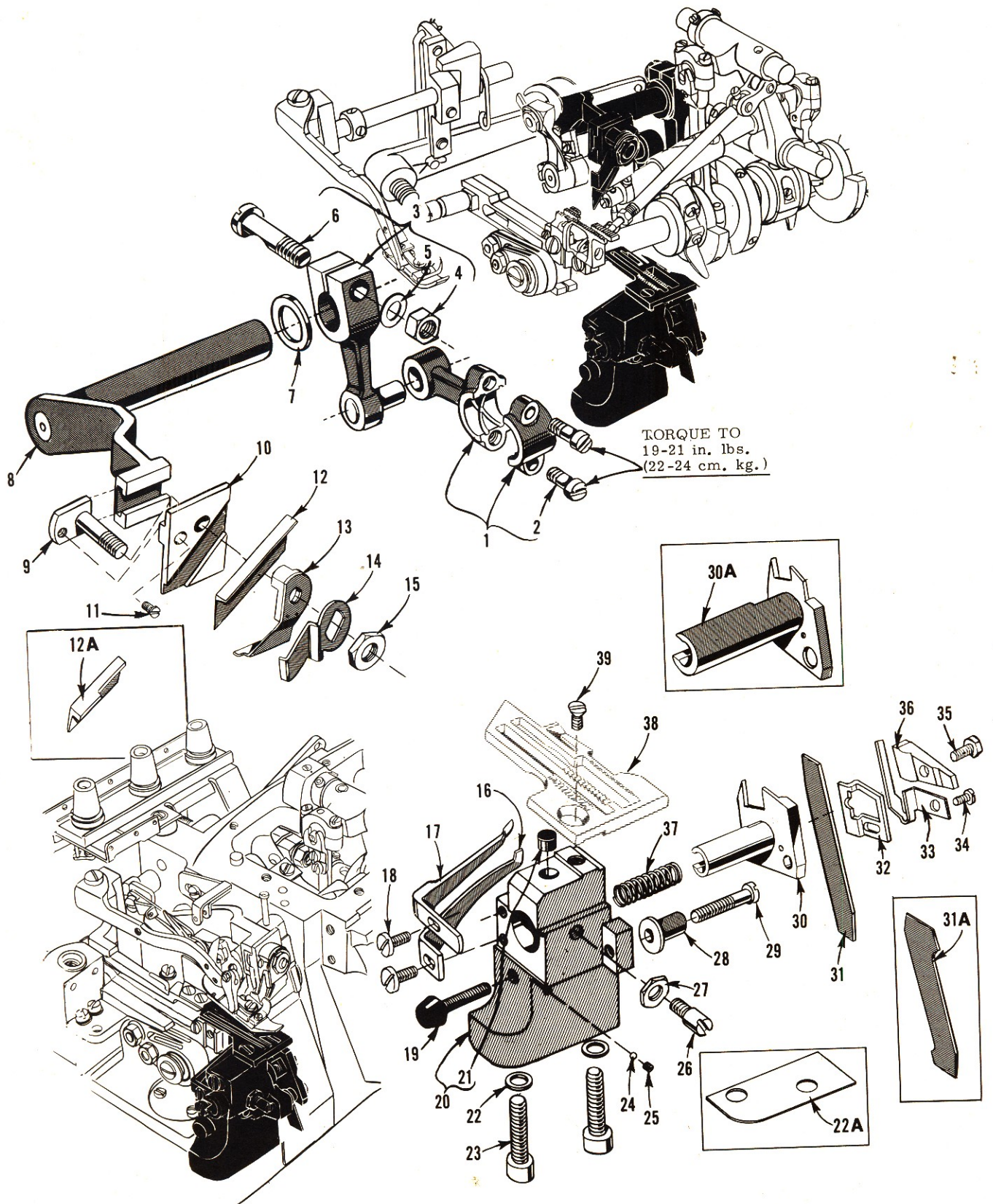
<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	39535 C	Pin, feed adjusting -----	1
2	22565 F	Screw, locking -----	1
3	39578 P	Bracket, fabric guard mounting, Style XQJ -----	1
4	8372 A	Washer, Style XQJ -----	2
5	22569 B	Screw, Style XQJ -----	2
6	87	Screw, Style XQJ -----	2
7	G39578 M	Guard, fabric, Style XQJ -----	1
8	22541 B	Screw -----	2
9	39835 G	Washer, plate -----	1
10	39535 F	Guide, feed bar (left) -----	1
11	39535 V	Block, feed bar guide -----	1
12	39534 G	Feed Bar -----	1
13	39535 D	Guide, feed bar (right) -----	1
14	22569 B	Screw -----	2
15	53634 C	Washer -----	2
16	39536 CV	Stud, feed bar driving -----	1
17	39534 AF	Washer, thrust, feed bar -----	1
18	22569 G	Screw -----	3
19	39538 A	Block, feed lift -----	1
20	39536 D	Spacer, feed bar -----	1
21	39505 K	Feed Dog, chaining -----	1
22	39505 J	Feed Dog, main -----	1
23	39536 CY	Bushing, feed bar driving stud -----	1
24	22768 B	Screw, chaining feed dog -----	1
25	22528	Screw, main feed dog -----	1
26	39536 CU	Connection, feed bar driving -----	1
27	39540 M-5 1/2	Eccentric, main feed driving -----	1
28	39536 E	Nut, feed bar driving stud -----	1
29	39540 R	Spacer, feed drive eccentric -----	1
30	39543 AA	Spacer, crankshaft -----	1
31	22781 A	Screw, crankshaft -----	1
32	14077 A	Nut, needle clamp stud -----	1
33	39563 AA	Washer, needle clamp and needle thread pull-off eyelet -	1
34	154 GAS	Needle -----	1
35	39552 Z	Arm, needle driving, marked "K" -----	1
36	39552 AD	Pin, stop -----	1
37	22596 E	Screw -----	1
38	39551 J	Stud, needle clamp -----	1
39	39568 AH	Pull-off, looper thread -----	1
40	22513 D	Screw -----	1
41	39568 AC	Lever, looper thread pull-off -----	1
42	88 B	Screw -----	2
43	39552 AG	Seal, oil, needle driving shaft -----	1
44	660-207	Ring, oil seal -----	1
45	C50043 F	Washer, for thrust collar -----	1
46	39543 Y	Collar, thrust, needle driving shaft -----	1
47	22782 A	Screw -----	1
48	39552 R	Shaft, needle driving -----	1
49	39594 N	Splasher, oil -----	1
50	87 C	Screw -----	1



UPPER AND LOWER LOOPER/SPREADER DRIVING PARTS

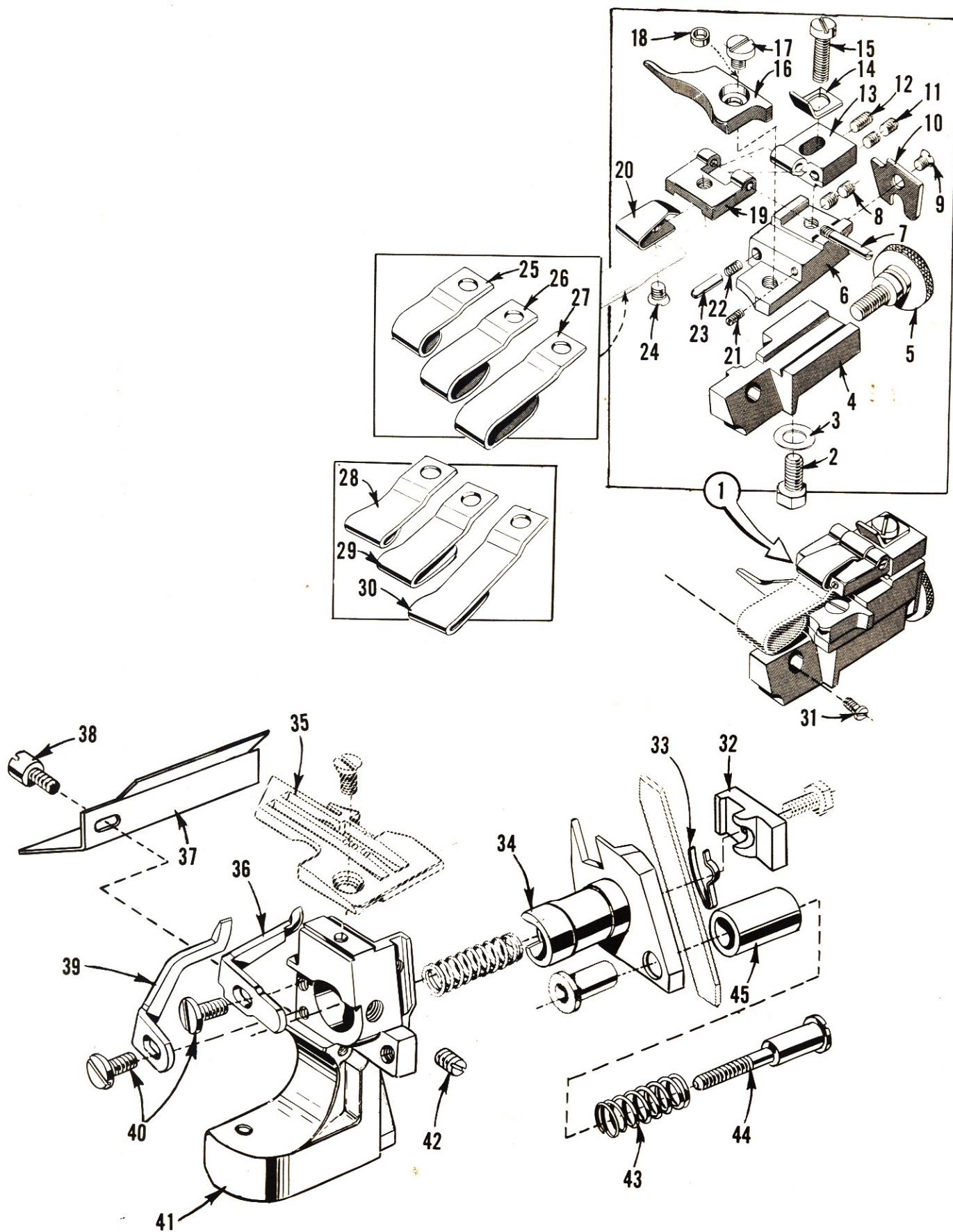
<u>Ref.</u> <u>No.</u>	<u>Parts</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	39560 A	Spreader, upper, Styles XQJ, XRC-060, XSD, CXQJ, CXSD -----	1
2	39508 A	Looper, upper, marked "CC", all Styles except XQJ, XRC-060 XSD, CXQJ, CXSD -----	1
3	39843 H	Holder, upper looper/spreader -----	1
4	22768 B	Screw -----	1
5	39743	Clamp, upper looper/spreader holder -----	1
6	22768 B	Screw -----	1
7	1025 L	Screw, locking -----	1
8	22565 H	Screw, spot, bushing and cam guide -----	1
* 9	39543 T	Follower, cam -----	1
*10	39543 S	Bushing and Cam Guide -----	1
*11	39543 Z	Shaft, upper looper/spreader drive -----	1
12	22503 F	Screw, cam follower locking clamp -----	1
13	39543 E	Clamp, cam follower locking -----	1
14	97	Screw -----	2
15	39544 J	Fork, ball joint guide -----	1
16	482 C	Collar, upper looper/spreader shaft -----	1
17	22894 C	Screw, set -----	2
18	22565	Screw, set -----	1
19	39543 X	Shaft, upper looper/spreader drive lever -----	1
20	22565 S	Screw, spot -----	1
21	39543 W	Lever, upper looper/spreader drive -----	1
22	39543 M	Collar, clamp -----	1
23	22562 A	Screw -----	1
24	39543 P	Washer, thrust -----	2
25	39543 AC	Connecting Rod -----	1
26	39543 AF	Nut, barrel -----	4
27	39594 N	Splasher, oil -----	1
28	87 C	Screw -----	1
29	77	Screw -----	1
30	39544 B	Link, lower looper bar connecting -----	1
31	39544 D	Pin, connecting link -----	2
32	77	Screw -----	1
33	22894 AE	Screw, set -----	2
34	482 C	Collar, lower looper driving shaft -----	1
35	22894 C	Screw, set -----	2
36	660-206	"O" Ring -----	1
37	39544 V	Shaft, lower looper driving -----	1
38	39560 B	Spreader, lower, Styles XRB, XRC-045, XRN, CXRN -----	1
39	39508 B	Looper, lower, all Styles except XRB, XRC-045, XRN, CXRN -----	1
40	39151	Nut -----	1
41	39544	Bar, lower looper -----	1
42	39594 N	Splasher, oil -----	1
43	87 C	Screw -----	1
44	29126 DF	Looper Bar Driving Lever and Connecting Rod Assembly, lower -----	1
45	39544 N	Connecting Rod -----	1
46	22729 E	Screw -----	2
47	22729 D	Screw -----	2
48	97	Screw -----	2
49	39544 S	Fork, guide -----	1
50	39544 U	Lever, lower looper bar driving -----	1

*Assembly No. 29126 EP is recommended for replacement instead of individual parts.



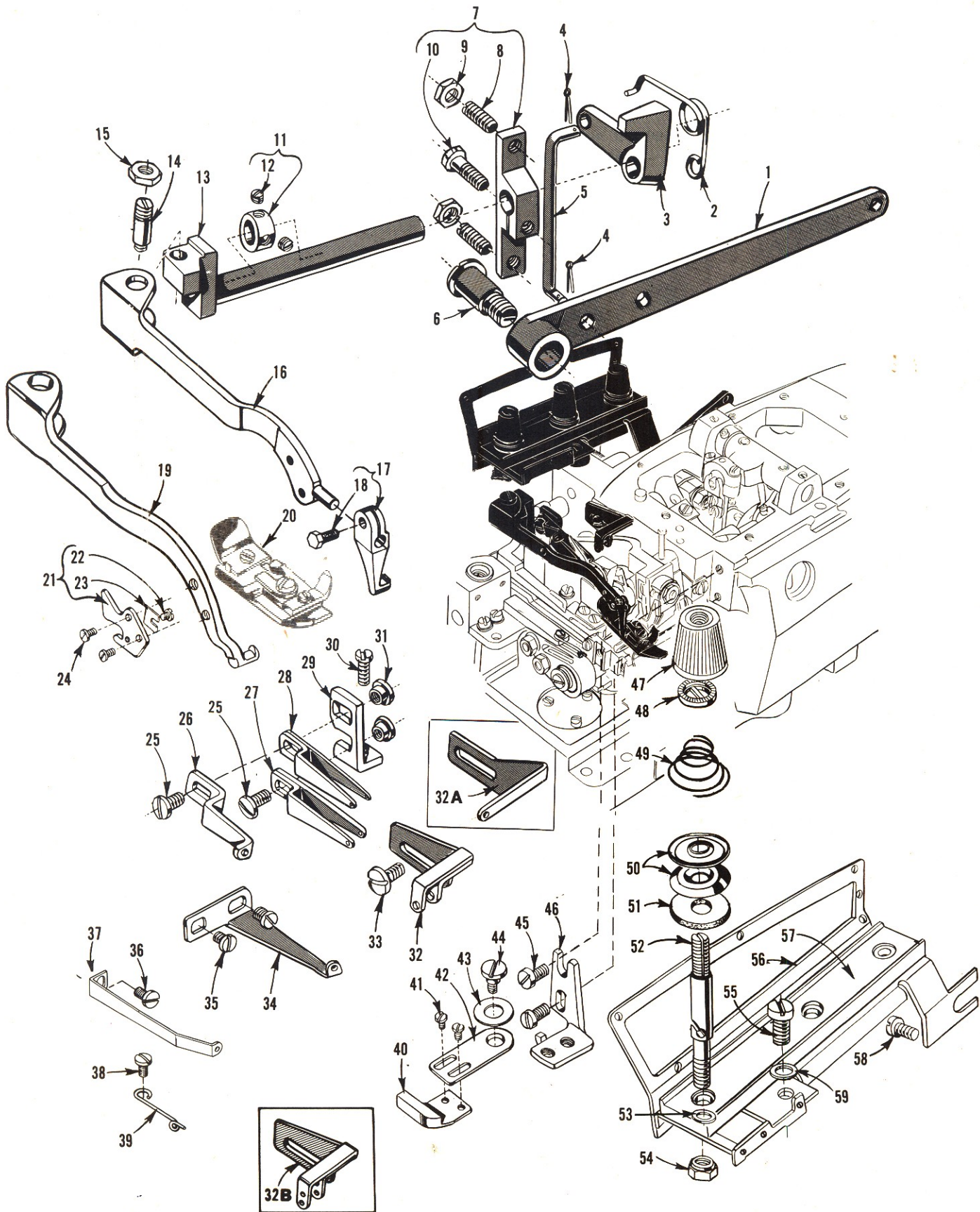
UPPER AND LOWER KNIFE MECHANISM

Ref. No.	Part No.	Description	Amt. Req.
1	39573 J	Connecting Rod, upper knife driving -----	1
2	22587 J	Screw -----	2
3	39573 E	Lever, upper knife driving -----	1
4	55235 E	Nut -----	1
5	6042 A	Washer -----	1
6	55235 D	Stud, locking -----	1
7	39573 A	Washer, upper knife driving arm -----	1
8	39573 H	Arm, upper knife driving -----	1
9	39571 D	Stud, clamp, all Styles except XQJ, CXQJ -----	1
-	39571 C	Stud, clamp, Styles XQJ, CXQJ -----	1
10	39572	Block, upper knife holder, Styles XQA, XQB, CXQA, CXQB, XSQB, CXSQB -----	1
-	39772	Block, upper knife holder, Styles XRB, XRC, XRN, XSD, XTA, CXRN, CXSD -----	1
-	39872	Block, upper knife holder, Styles XQJ, CXQJ -----	1
11	22738	Screw, clamp stud -----	1
12	39570 C	Knife, upper, all Styles except XQJ, CXQJ -----	1
12A	39570 CJ	Knife, upper, Styles XQJ, CXQJ -----	1
13	39571 F	Clamp, upper knife -----	1
14	39571 B	Guard, chain -----	1
15	14077	Nut, clamp stud -----	1
16	39525 R	Guard, needle, front, Styles XQA, XQB, XTA, CXQA, CXQB, XSQB, CXSQB -----	1
-	39525 H	Guard, needle, front, Styles XRB, XRC-045 -----	1
-	39525 L	Guard, needle, front, Styles XQJ, XRC-060, CXQJ -----	1
17	GA39525 N	Guard, needle, rear, all Styles except XRB, XRC, XRN, XSD, CXRN, CXSD -----	1
-	39525 J	Guard, needle rear, Styles XRB, XRC -----	1
18	22585 A	Screw, needle guard, all Styles except XRN, XSD, CXRN, CXSD -----	2
19	660-824	Bumper, cloth plate, all Styles except XRN, XSD, CXRN, CXSD -----	1
20	39580 A	Bracket, throat plate and lower knife support, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	1
-	39580 AE	Bracket, throat plate and lower knife support, Styles XQJ, CXQJ --	1
21	39880 N	Bumper, rubber, cloth plate isolation -----	1
22	39580 F	Washer -----	2
22A	39580 E	Shim, Styles XQJ, CXQJ -----	1
23	22653 B-12	Screw -----	2
24	660-459	Ball, nylon -----	1
25	78	Screw, set -----	1
26	22892 B	Screw, locking, lower knife holder, all Styles except XRN, XSD, CXRN, CXSD -----	1
27	14077	Nut, locking screw, all Styles except XRN, XSD, CXRN, CXSD -----	1
28	39550 C	Stud, locating -----	1
29	22729 B	Screw, locating stud, all Styles except XRN, XSD, CXRN, CXSD -----	1
30	39550 AF	Holder, lower knife, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	1
30A	39550 AB	Holder, lower knife, Styles XQJ, CXQJ -----	1
31	39549 C	Knife, lower, all Styles except XQJ, CXQJ -----	1
31A	39549 CJ	Knife, lower, Styles XQJ, CXQJ -----	1
32	39550 AC	Plate, lower knife guide, all Styles except XRN, XSD, CXRN, CXSD --	1
33	39550 AE	Spring, lower knife clamp, all Styles except XRN, XSD, CXRN, CXSD --	1
34	605 A	Screw, lower knife clamp spring, all Styles except XRN, XSD, CXRN, CXSD -----	1
35	22588 J	Screw, lower knife clamp -----	1
36	39550 AD	Clamp, lower knife, all Styles except XRN, XSD, CXRN, CXSD -----	1
37	39550 E	Spring, lower knife holder -----	1
38		Throat plate, (See pages 49 & 51) -----	1
39	22524	Screw, throat plate -----	1



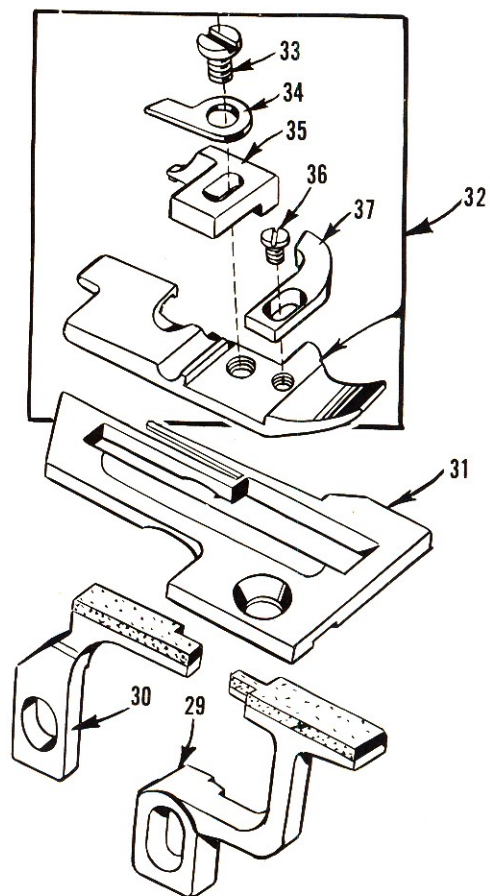
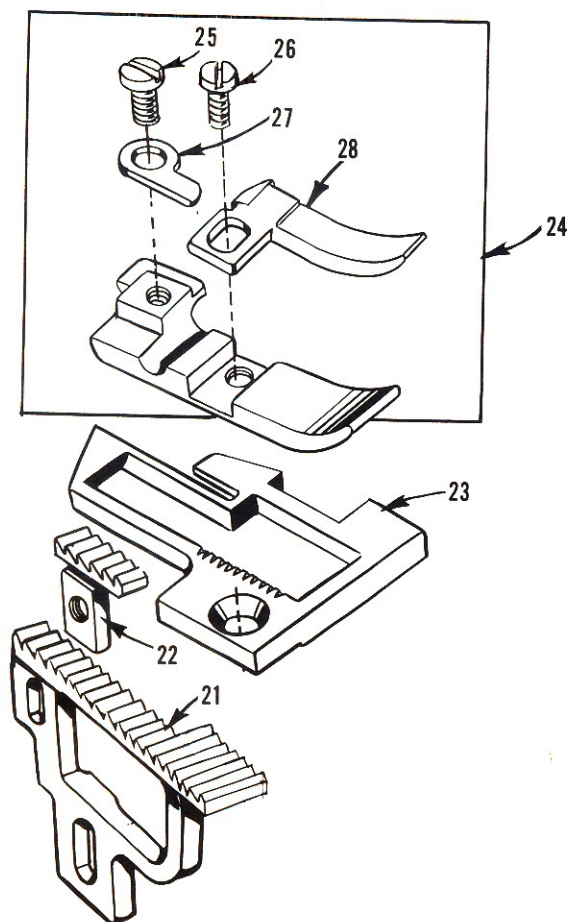
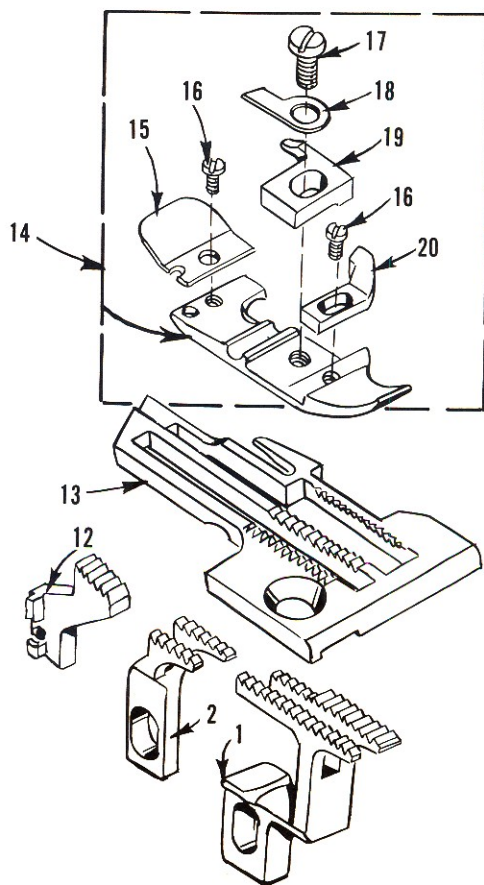
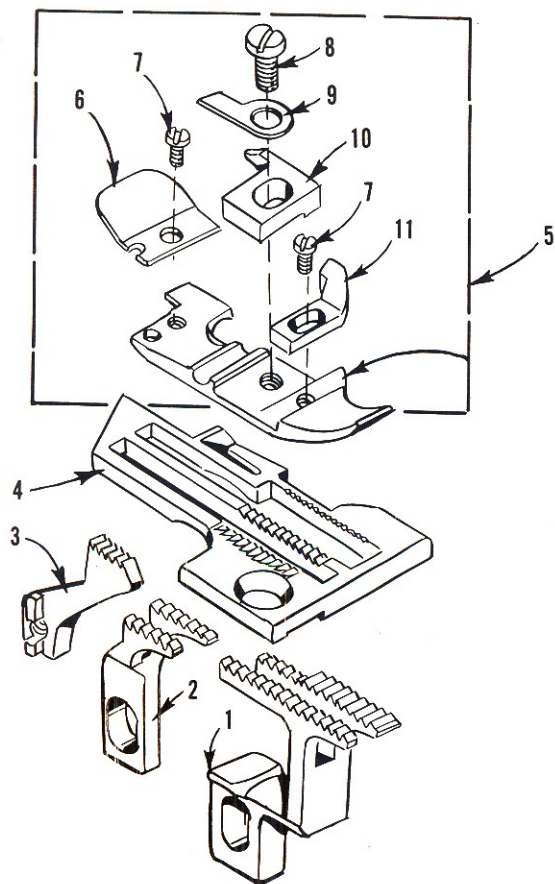
HEMMER GUIDE ASSEMBLY AND LOWER KNIFE PARTS
(STYLES XRN, XSD, CXRN, CXSD)

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	29481 L	Hemmer Guide Assembly -----	1
2	303	Screw, edge guide support -----	1
3	61303 D	Washer, cup -----	1
4	39589 AC	Base, hemming attachment -----	1
5	22873 C	Screw, adjusting, edge guide support -----	1
6	39589 AD	Support, edge guide -----	1
7	22799 B	Screw, hinge, overhanging guide hinge block -----	1
8	22743	Screw, edge guide tension spring -----	2
9	222 D	Screw, hemmer guide end plate -----	1
10	39589 AF	Plate, hemmer guide end -----	1
11	HA73 B	Screw, stop, overhanging guide hinge block -----	2
12	73 C	Screw, set, hemmer guide stop screw -----	1
13	39589 AB	Block, hinge -----	1
14	39589 AJ	Stop, hemmer guide -----	1
15	22729 A	Screw, hemmer guide stop -----	1
16	39503 L	Guide, edge -----	1
17	22513 C	Screw, edge guide -----	1
18	39589 AG	Sleeve, edge guide -----	1
19	39589 AA	Block, hinge, overhanging guide -----	1
20	39589 AH	Spring, holding -----	1
21	79077	Screw, stop, edge guide -----	1
22	39568 J	Spring, edge guide tension -----	1
23	39589 AL	Pin, edge guide tension spring -----	1
24	222 D	Screw, overhanging guide -----	1
25	39589 AK-1/2	Overhanging Guide, for 1/2 inch (12.7mm) hem, Styles XSD, CXSD -----	1
26	39589 AK-3/4	Overhanging Guide, for 3/4 inch (19.0mm) hem, Styles XSD, CXSD -----	1
27	39589 AK-1	Overhanging Guide, for 1 inch (25.4mm) hem, Styles XSD, CXSD -----	1
28	39589 AE-1/2	Overhanging Guide, for 1/2 inch (12.7mm) hem, Styles XRN, CXRN -----	1
29	39589 AE-3/4	Overhanging Guide, for 3/4 inch (19.0mm) hem, Styles XRN, CXRN -----	1
30	39589 AE-1	Overhanging Guide, for 1 inch (25.4mm) hem, Styles XRN, CXRN -----	1
31	22593	Screw, hemming guide assembly -----	1
32	39550 Z	Clamp, lower knife -----	1
33	39550 M	Spring, lower knife clamp -----	1
34	39550 T	Holder, lower knife -----	1
35		Throat Plate (See pages 49 & 51) -----	1
36	39525 K	Guard, needle, rear, Styles XRN, CXRN -----	1
-	39525 E	Guard, needle, rear, Styles XSD, CXSD -----	1
37	39582 BS	Shield, oil -----	1
38	22585 G	Screw, oil shield and locking side cover -----	1
39	39525 D	Guard, needle, front -----	1
40	90	Screw, needle guards -----	2
41	39580 BA	Bracket, throat plate and lower knife support -----	1
42	88 B	Screw, lower knife holder -----	1
43	39550 J	Spring, knife pressure equalizing -----	1
44	22559 H	Screw, adjusting -----	1
45	39550 K	Cover, spring -----	1



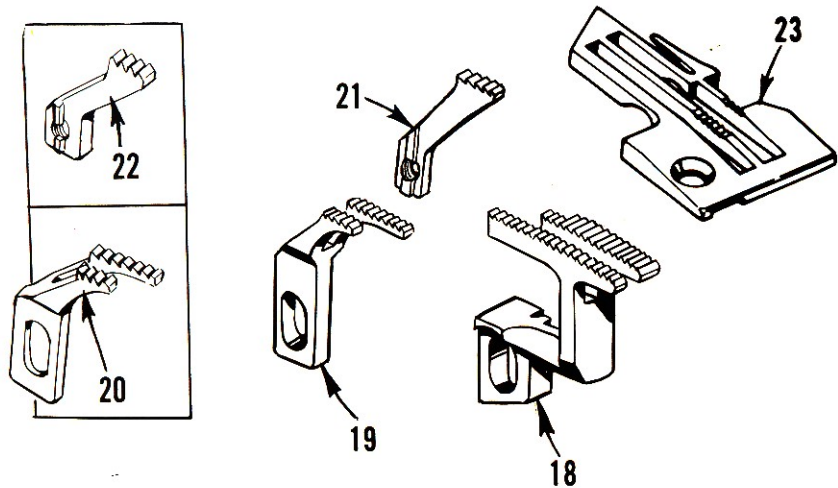
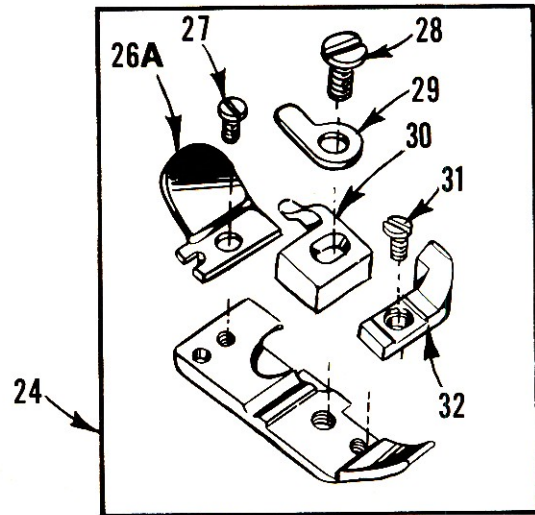
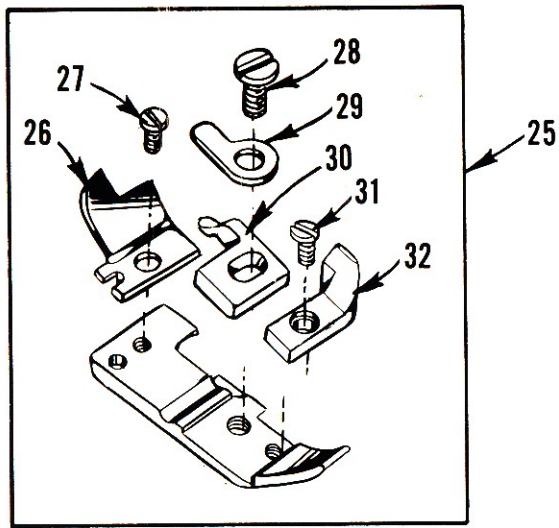
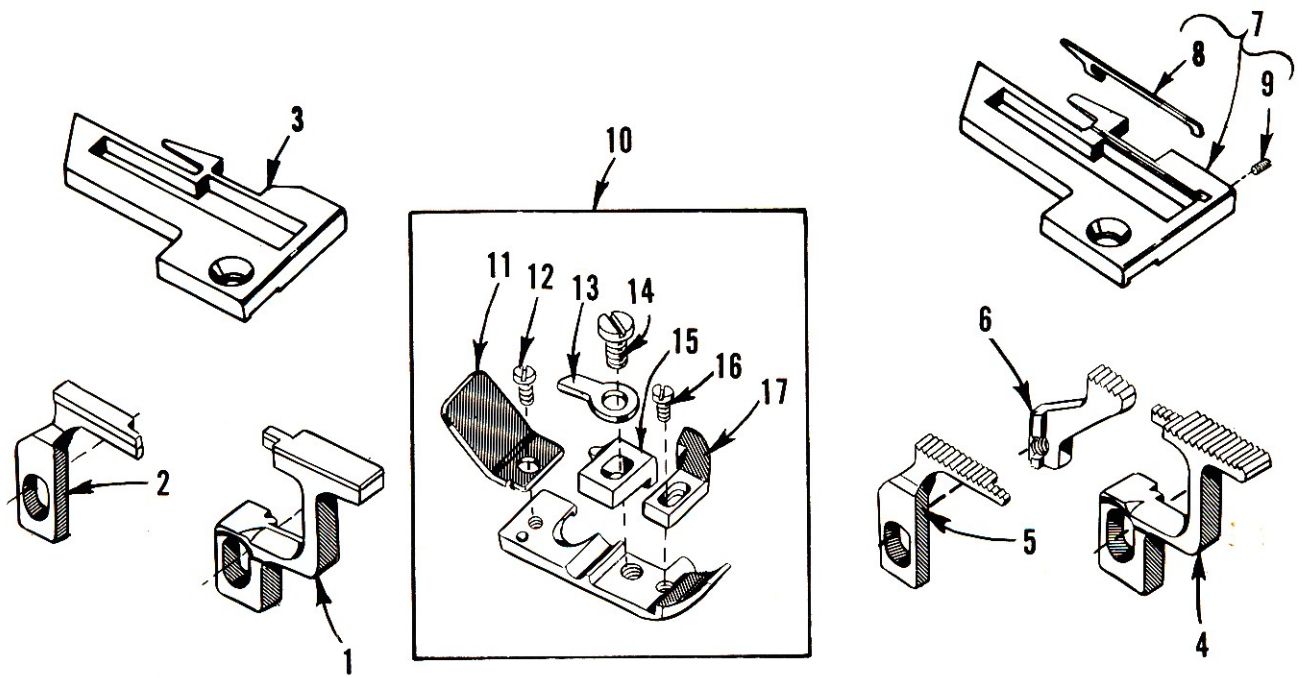
THREAD TENSIONS, FOOT LIFTER PARTS AND
MISCELLANEOUS EYELETS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	39855	Lever, foot lifter -----	1
2	39555 B	Spring, foot lifter lever -----	1
3	39555 D	Lever, intermediate, foot lever -----	1
4	660-142	Pin, cotter -----	2
5	39555 F	Link, lifter lever connecting -----	1
6	22566 B	Screw, lifter lever -----	1
7	39555 C	Arm, lifter lever -----	1
8	22597 E	Screw, set -----	2
9	12538	Nut, lock -----	2
10	627	Screw -----	1
11	12865	Collar, thrust -----	1
12	88	Screw -----	2
13	39555 AA	Shaft, foot lifter lever -----	1
14	22791 H	Pin, screw -----	1
15	258 A	Nut -----	1
16	39556 T	Arm, presser, all Styles except XQJ, XRB, XRC, CXQJ -----	1
17	39530 AH	Shank, presser foot, all Styles except XQJ, XRB, XRC, CXQJ -----	1
18	22781	Screw -----	1
19	39556 D	Arm, presser, Styles XQJ, CXQJ -----	1
-	39556 J	Arm, presser, Styles XRB, XRC -----	1
20		Presser Foot (See pages 49 & 51) -----	1
21	39556 M	Knife, chain cutting, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	1
22	22738 G	Screw -----	1
23	39556 L	Blade, chain cutter -----	1
24	605	Screw, chain cutting knife, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
25	376 A	Screw, looper thread eyelets, all Styles except XQJ, XRC-060, XSD, CXQJ, CXSD -----	2
-	376 A	Screw, looper thread eyelet, Styles XQJ, XRC-060, XSD, CXQJ, CXSD -----	1
26	39568 E	Eyelet, auxiliary looper thread, all Styles except XQJ, XRC-060, XSD, CXQJ, CXSD -----	1
27	39568 B	Eyelet, lower looper thread, all Styles except XQJ, XRB, XRC-045, XRN, CXQJ, CXRN -----	1
-	39568 L	Eyelet, lower looper thread, Styles XQJ, CXQJ -----	1
-	39568 B	Eyelet, upper looper thread, Styles XRB, XRN, XRC-045, CXRN -----	1
28	39568 L	Eyelet, upper looper thread, Styles XQA, XQB, XTA, CXQA, CXQB, XSQB, CXSQB -----	1
29	39568 D	Bracket, looper thread eyelet mounting -----	1
30	22569 B	Screw, looper thread eyelet mounting bracket -----	1
31	43139 A	Nut, looper thread eyelet screw, all Styles except XQJ, XRC-060, XSD, CXQJ, CXSD -----	2
-	43139 A	Nut, looper thread eyelet screw, Styles XQJ, XRC-060, XSD, CXQJ, CXSD -----	1
32	39563 H	Eyelet, needle thread, all Styles except XQJ, XRB CXQJ -----	1
32A	39563 D	Eyelet, needle thread, Styles XQJ, CXQJ -----	1
32B	39563 N	Eyelet, needle thread, Style XRB -----	1
33	22569 D	Screw, needle thread eyelet -----	1
34	39568 W	Guide, frame thread, Style XQJ -----	1
35	73 X	Screw, Style XQJ -----	2
36	22569 B	Screw, Style CXQJ -----	1
37	99664 A	Guide, frame thread, Style CXQJ -----	1
38	22726 A	Screw, all Styles except XQJ, CXQJ -----	1
39	39868 H	Eyelet, lower looper thread, Styles XQA, XQB, XRB, XRC, XRN, XSD, XTA, XSQB -----	1
-	53658 A	Eyelet, lower looper thread, Styles CXQA, CXQB, CXRN, CXSD, CXSQB -----	1
40	39503 A	Guide, edge, Styles XQJ, CXQJ -----	1
41	604	Screw, Styles XQJ, CXQJ -----	2
42	39503 D	Arm, edge guide swinging, Styles XQJ, CXQJ -----	1
43	12957 E	Washer, spring, Styles XQJ, CXQJ -----	1
44	22758 E	Screw, swinging arm, Styles XQJ, CXQJ -----	1
45	22569 C	Screw, edge guide mounting bracket, Styles XQJ, CXQJ -----	2
46	39503 C	Bracket, edge guide mounting, Styles XQJ, CXQJ -----	1
47	39592 AA	Nut (green) needle tension -----	1
-	39592 AB	Nut (blue) upper looper tension, all Styles except XQJ, XRC, XSD, CXQJ, CXSD -----	1
-	39592 AC	Nut (red) lower looper tension, all Styles except XRB, XRN, CXRN -----	1
-	39592 Z	Nut (yellow) needle tension, Styles XRB, XRC -----	1
48	39592 AK	Ferrule, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
-	39592 AK	Ferrule, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	3
49	39592 AR-1	Spring, needle thread tension, Styles XRB, XRC -----	2
-	39592 AR-1	Spring, looper thread tension, Style XRB -----	1
-	39592 AR-2	Spring, needle thread tension, Styles XQJ, CXQJ -----	1
-	39592 AR-2	Spring, looper thread tension, Style XRC -----	1
-	39592 AR-4	Spring, looper thread tension, Style XTA -----	2
-	39592 AR-4	Spring, looper thread tension, Styles XRN, CXRN -----	1
-	39592 AR-4	Spring, needle thread tension, Styles XQJ, XRN, XSD, XTA, CXQJ, CXRN, CXSD -----	1
-	39592 AR-5	Spring, looper thread tension, Styles XQA, XQB, CXQA, CXQB, XSQB, CXSQB -----	2
-	39592 AR-5	Spring, looper thread tension, Style XSD -----	1
-	39592 AR-8	Spring, needle thread tension, Styles XQA, XQB, CXQA, CXQB, XSQB, CXSQB -----	1
50	39592 AD	Disc, thread tension, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	4
-	39592 AD	Disc, thread tension, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	6
51	39592 AF	Felt, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
-	39592 AF	Felt, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	3
52	39592 AL	Post, thread tension, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
-	39592 AL	Post, thread tension, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	3
53	8372 A	Washer, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
-	8372 A	Washer, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	3
54	39592 AH	Nut, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
-	39592 AH	Nut, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	3
55	22806 A	Screw -----	1
56	39592 AG-3	Bracket, tension post mounting -----	1
57	39592 AM	Bar, tension post -----	1
58	22847 B	Screw -----	1
59	40-46	Washer, Styles XRB, XRC, XTA -----	1



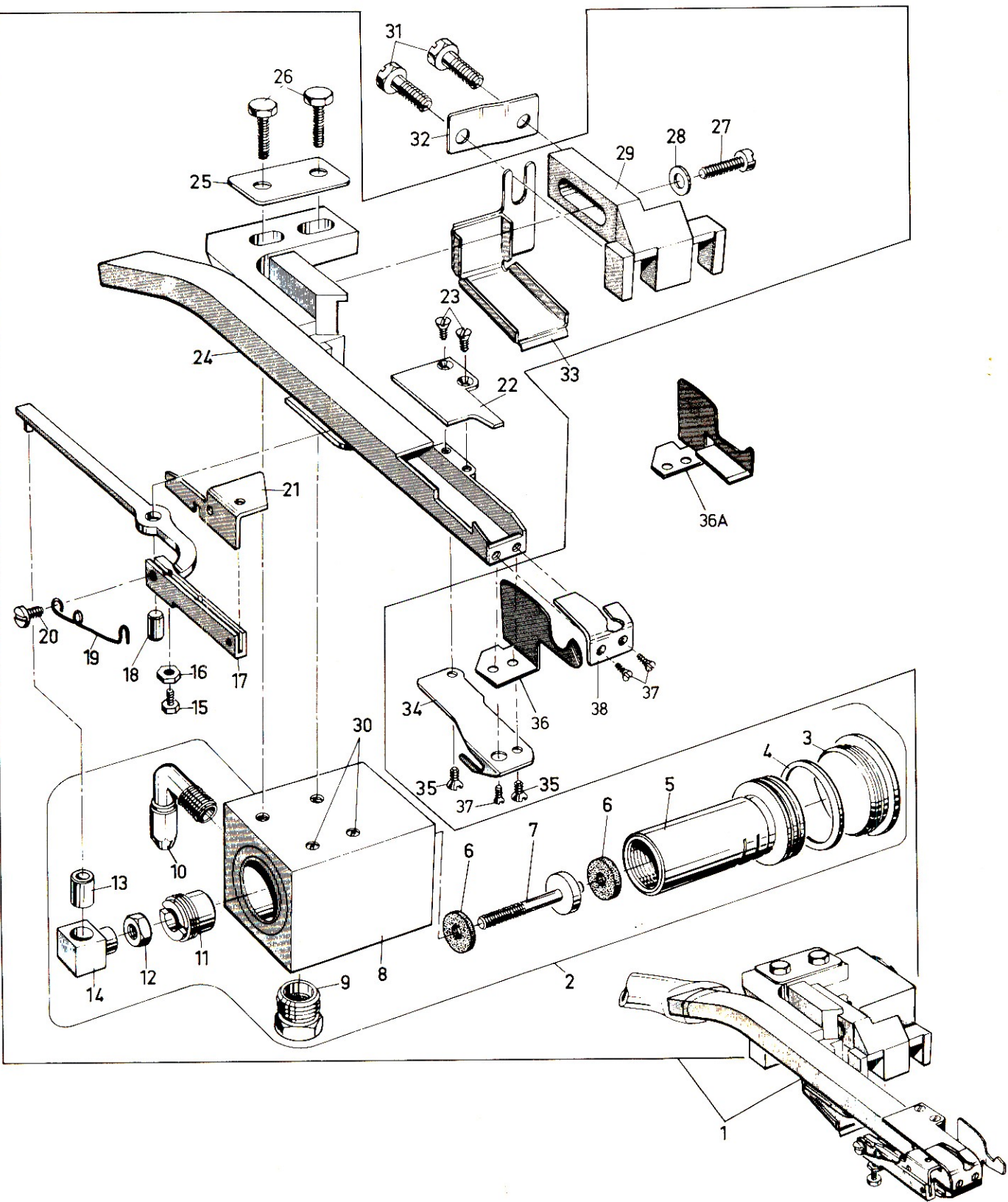
FEED DOGS, THROAT PLATES AND PRESSER FEET

Ref. No.	Part No.	Description	Amt. Req.
1	39526 B	Feed Dog, differential, 16 t.p.i., for Styles XQA, XQB, CXQA, CXQB, XSQB, CXSQB -----	1
2	39505 B	Feed Dog, main, marked "B", 16 t.p.i., for Styles XQA, XQB, CXQA, CXQB, XSQB, CXSQB -----	1
3	39505 C	Feed Dog, chaining, marked "C", 20 t.p.i., for Styles XQA, CXQA -----	1
4	39524 C-3/32	Throat Plate, marked "AC-3/32", for 3/32 inch (2.4mm) wide seam, Styles XQA, CXQA -----	1
-	39524 C-1/8	Throat Plate, marked "AC-1/8", for 1/8 inch (3.2mm) wide seam, Styles XQA, CXQA -----	1
5	39520 B	Presser Foot, Styles XQA, CXQA -----	1
6	39530 C	Shield, chain -----	1
7	22738 B	Screw, chain shield and chip guard -----	2
8	22768 B	Screw, stitch tongue and hinge spring -----	1
9	39530	Spring, hinge -----	1
10	39597 A	Tongue, stitch, marked "DS" -----	1
11	39530 P	Guard, chip -----	1
12	39505 E	Feed Dog, chaining, 20 t.p.i., Styles XQB, CXQB, XSQB, CXSQB -----	1
13	39524 B-3/32	Throat Plate, marked "V-3/32", for 3/32 inch (2.4mm) wide seam, Styles XQB, CXQB, XSQB, CXSQB -----	1
-	39524 B-1/8	Throat Plate, marked "V-1/8", for 1/8 inch (3.2mm) wide seam, Styles XQB, CXQB, XSQB, CXSQB -----	1
-	39524 B-5/32	Throat Plate, marked "BH", for 5/32 inch (4.0mm) wide seam, Styles XQB, CXQB, XSQB, CXSQB -----	1
14	39520 A	Presser Foot, Styles XQB, CXQB, XSQB, CXSQB -----	1
15	39530 C	Shield, chain -----	1
16	22738 B	Screw, chain shield and chip guard -----	2
17	22768 B	Screw, stitch tongue and hinge spring -----	1
18	39530	Spring, hinge -----	1
19	39597 A	Tongue, stitch, marked "DS" -----	1
20	39530 P	Guard, chip -----	1
21	39505 J	Feed Dog, main 16 t.p.i., Styles XQJ, CXQJ -----	1
22	39505 K	Feed Dog, chaining, marked "K", 16 t.p.i., Styles XQJ, CXQJ -----	1
23	39524 J	Throat Plate, Styles XQJ, CXQJ -----	1
24	39520 L	Presser Foot, Styles XQJ, CXQJ -----	1
25	22768 B	Screw, hinge spring -----	1
26	22819	Screw, stitch tongue -----	1
27	39530	Spring, hinge -----	1
28	39597 L	Tongue, stitch, marked "DW" -----	1
29	39526 AB	Feed Dog, differential, vulcanized rubber feed surface, Style XTA -----	1
30	39505 AB	Feed Dog, main, marked "AG", vulcanized rubber feed surface, Style XTA -----	1
31	39524 AV	Throat Plate, marked "BZ", 1/16 to 3/32 inch (1.6 to 2.9mm) wide seam, Style XTA -----	1
32	39520 AS	Presser Foot, Style XTA -----	1
33	22768 B	Screw, stitch tongue and hinge spring -----	1
34	39530	Spring, hinge -----	1
35	39597 AS	Tongue, stitch, marked "ES" -----	1
36	22738 B	Screw, chip guard -----	1
37	39530 P	Guard, chip -----	1



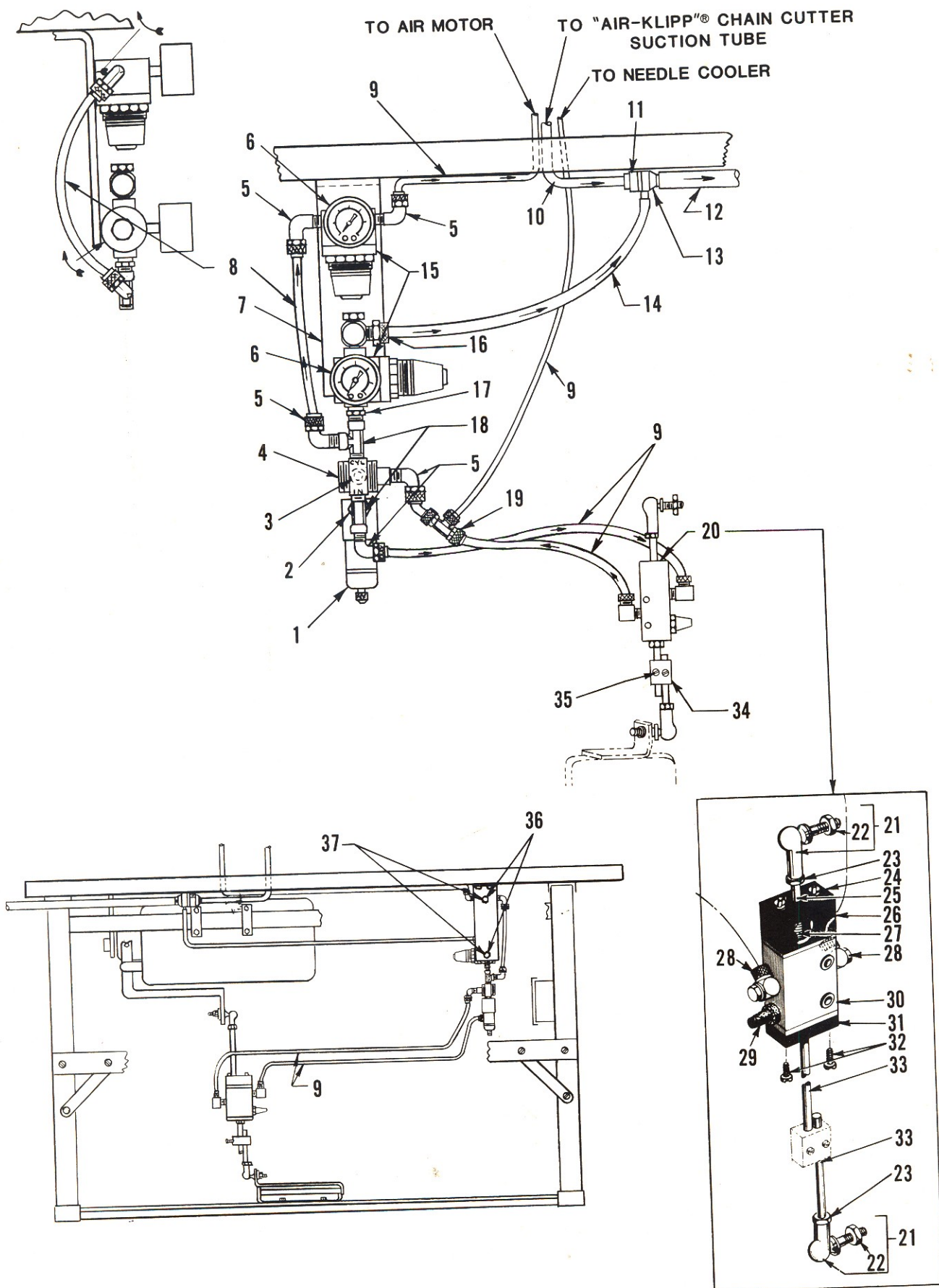
FEEDS DOGS, THROAT PLATES AND PRESSER FEET

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	39526 AB	Feed Dog, differential, vulcanized rubber feed surface, Style XRB -----	1
2	39505 AB	Feed Dog, main, marked "AG", vulcanized rubber feed surface, Style XRB -----	1
3	39524 AB-1/8	Throat Plate, marked "AX-1/8", for 1/8 inch (3.2mm) wide seam, Style XRB -----	1
-	39524 AB-5/32	Throat Plate, marked "AX-5/32", for 5/32 inch (4.0mm) wide seam, Style XRB -----	1
-	39524 AC	Throat Plate, marked "AV", Style XRC-045 -----	1
4	39526 AC	Feed Dog, differential, 22 t.p.i., Style XRC -----	1
5	39505 AC	Feed Dog, main, marked "AM", 22 t.p.i., Style XRC -----	1
6	39505 E	Feed Dog, chaining, 20 t.p.i., Style XRC -----	1
7	39528 AH	Throat Plate, marked "AY", Style XRC-060 -----	1
8	39531 AD	Tongue, stitch -----	1
9	22799 AE	Screw -----	1
10	39520 AB	Presser Foot, Style XRB -----	1
-	39520 AC	Presser Foot, Style XRC -----	1
11	39530 S	Shield, chain, for presser foot No. 39520 AB -----	1
-	39530 R	Shield, chain, for presser foot No. 39520 AC -----	1
12	22738	Screw, chain shield -----	1
13	39530 G	Spring, hinge -----	1
14	22768 B	Screw, stitch tongue and hinge spring -----	1
15	39597 AB	Tongue, stitch, marked "EK" -----	1
16	22738	Screw, chip guard -----	1
17	39530 P	Guard, chip -----	1
18	39526 H	Feed Dog, differential, 20 t.p.i., Styles XRN, XSD, CXRN, CXSD -----	1
19	39505 F	Feed Dog, main, marked "F" 20 t.p.i., Styles XSD, CXSD -----	1
20	39505 BH	Feed Dog, main, marked "CM", 16 t.p.i., Styles XRN, CXRN -----	1
21	39505 H	Feed Dog, chaining, marked "U", 20 t.p.i., Styles XSD, CXSD -----	1
22	39505 AL	Feed Dog, chaining, marked "CN", 16 t.p.i., Styles XRN, CXRN -----	1
23	39524 D	Throat Plate, marked "AM", Styles XRN, XSD, CXRN, CXSD -	1
24	39520 H	Presser Foot, Styles XSD, CXSD -----	1
25	39520 BH	Presser Foot, Styles XRN, CXRN -----	1
26	39530 E	Shield, chain, for presser foot No. 39520 H -----	1
26A	39530 U	Shield, chain, for presser foot No. 39520 BH -----	1
27	22738	Screw, chain shield -----	1
28	22768 B	Screw, stitch tongue and hinge spring -----	1
29	39530	Spring, hinge -----	1
30	39597 A	Tongue, stitch, marked "DS" -----	1
31	22738	Screw, chip guard -----	1
32	39530 B	Guard, chip -----	1



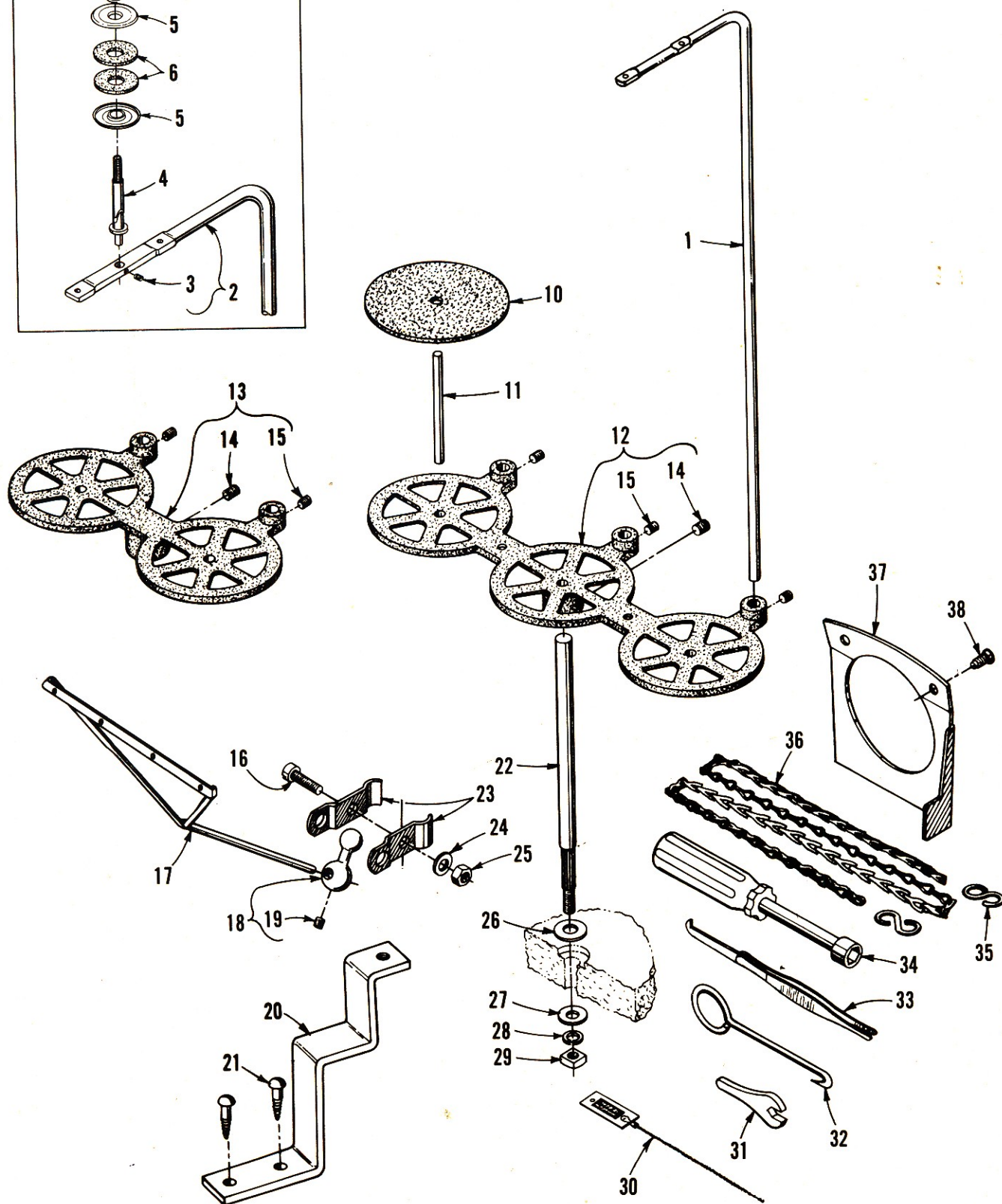
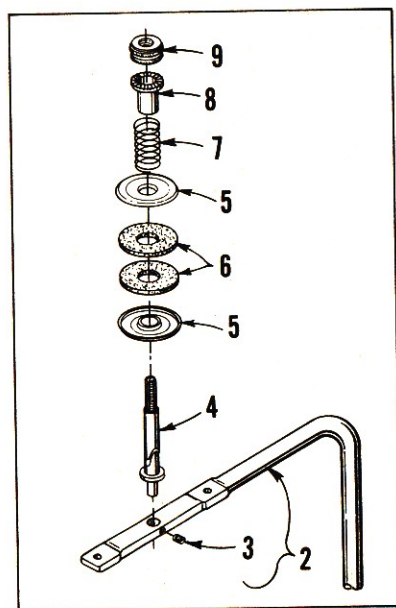
POWER "AIR-KLIPP"[®]CHAIN CUTTER
(STYLES CXQA, CXQB, CXQJ, CXRN, CXSD, CXSQB)

Ref. No.	Part No.	Description	Amt. Req.
1	V29941 A	Power "AIR-KLIPP" Chain Cutter Assembly -----	1
2	671 H-1	Air-Motor Assembly -----	1
3	671 H-1D	Screw, plug -----	1
4	671 H-1F	Bumper, rubber -----	1
5	671 H-1A	Vibrator -----	1
6	671 H-1H	Washer, shock -----	2
7	39536 DC	Stud -----	1
8	671 H-1B	Housing -----	1
9	660-763	Muffler -----	1
10	999-141	Elbow, union -----	1
11	671 H-1E	Screw, plug -----	1
12	41071 G	Nut -----	1
13	671 H-1G	Bushing -----	1
14	39573 AC	Link, drive -----	1
15	22588 K	Screw, lower knife adjusting -----	1
16	60078 Z	Nut -----	1
17	39573 AB	Lever, knife driving -----	1
18	39536 DB	Pin -----	1
19	99697 DA	Spring, torsion -----	1
20	22825	Screw -----	1
21	99669 K	Knife, lower -----	1
22	99670 L	Knife, upper -----	1
23	22716	Screw -----	2
24	99676 MA	Tube Assembly -----	1
25	95910 A	Plate, washer -----	1
26	906	Screw -----	2
27	22729 D	Screw -----	1
28	80265	Washer -----	1
29	99663 KA	Bracket -----	1
30	12935 A	Screw, set -----	2
31	99373 C	Screw, mounting -----	2
32	95910 B	Plate, washer -----	1
33	39534 RB	Shield, oil -----	1
34	99664 C	Guide, looper thread -----	1
35	22716	Screw -----	2
36	99665	Guard, fabric, Styles CXQA, CXQB, CXQJ, CXSQB -----	1
36A	99665 A	Guard, fabric, Styles CXRN, CXSD -----	1
37	22716 A	Screw, inlet part and fabric guard -----	3
38	99677 HA	Inlet Part, marked "GS", has a .028 inch (.7mm) slot and .169 inch (4.3mm) opening. For threads 60/3 up to 40/4 -----	1
-	99677 HB	Inlet Part, marked "GF", has a .020 inch (.5mm) slot and .138 inch (3.5mm) opening. For thin threads up to size 70/3 -----	1
-	99677 HD	Inlet Part, marked "GV", has a .039 inch (1.0mm) slot and .205 inch (5.2mm) opening. For heavy threads such as 30/6 -----	1



VENTURI TUBE, PNEUMATIC CONTROL DEVICE, TREADLE ROD VALVE

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	671 D-5	Filter, air line -----	1
2	RM3320-1	Nipple, reducing -----	1
3	660-403	Muffler -----	1
4	RM4098-1	Valve, pilot -----	1
5	660-401	Elbow, 90° -----	5
6	671 D-15	Gauge, pressure -----	2
7	99683 CC	Bracket, mounting -----	1
8	660-392	Tube, air, 1/4 inch O.D. x 6 1/2 inches (165.1mm) long -	1
9	RM2997 D	Tube, air, 1/4 inch O.D. (specify length) ----- as Req.	
10	671 B-12	Tube, suction -----	1
11	998-332	Holder, venturi -----	1
12	671 B-11	Tube, discharge -----	1
13	671 D-2	Venturi -----	1
14	99675-1500	Tube, venturi supply -----	1
15	671 D-9	Regulator, pressure -----	2
16	999-217	Connector -----	1
17	RM3287-2	Nipple, hex -----	1
18	RM2850 D	Tee, pipe -----	2
19	RM3384-1	Tee, union -----	1
20	99683 HC-155	Valve Assembly, treadle rod -----	1
21	999-146	Link -----	2
22	95250	Nut -----	1
23	95250	Nut -----	3
24	95073	Screw -----	2
25	99683 J	Stud -----	1
26	99683 K	Guide -----	1
27	110-4	Spring -----	1
28	999-127	Elbow, 90° -----	2
29	999-140	Muffler -----	1
30	999-139	Valve, cam, 3/2 way -----	1
31	99683 E	Connection -----	1
32	95151	Screw -----	2
33	99563 A-155	Rod -----	2
34	671-2	Block, mounting -----	1
35	91 D	Screw -----	2
36	671 C-16	Stud, mounting -----	2
37	11635 B	Nut -----	2
	RM2871 B	Tie, cable (Not Shown) -----	4
	660-870	Mount, cable tie (Not Shown) -----	4
	671 F-1	Fitting, barb, air filter inlet (Not Shown) -----	1
	671 F-6	Bushing, reducing, air filter inlet (Not Shown) -----	1



THREAD STANDS, ACCESSORIES AND MISCELLANEOUS TOOLS

Ref. No.	Part No.	Description	Amt. Req.
1	21113 F	Eyelet, thread stand, all Styles except XQJ, XRB, XRN, XSD, XTA, CXQJ, CXRN, CXSD -----	3
-	21113 F	Eyelet, thread stand, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD-	2
2	21113 C	Eyelet, thread stand, Styles XRB, XTA -----	3
3	22565 C	Screw, tension post -----	1
4	39592 D	Post, tension, Styles XRB, XTA -----	3
5	109	Disc, tension, Styles XRB, XTA -----	6
6	39592 E	Pad, felt, Styles XRB, XTA -----	6
7	51292 F-1	Spring, tension, Styles XRB, XTA -----	3
8	107	Ferrule, tension post, Styles XRB, XTA -----	3
9	108	Nut, tension post, Styles XRB, XTA -----	3
10	21104 V	Pad, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	3
-	21104 V	Pad, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
11	69 S	Pin, spool, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD	3
-	69 S	Pin, spool, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	2
12	21130 W-3	Support, cone, all Styles except XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	1
13	21130 W-2	Support, cone, Styles XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	1
14	22650 CE-6	Screw -----	1
15	22650 CB-4	Screw, for support No. 21130 W-3 -----	3
-	22650 CB-4	Screw, for support No. 21130 W-2 -----	2
16	22810	Screw -----	1
17	21114 S-4	Eyelet, lead -----	1
18	21114 T	Ball, lead eyelet socket -----	1
19	22651 CD-4	Screw -----	1
20	39592 W	Bracket, tension post, Styles XRB, XTA -----	1
21	SC333 A	Screw, Styles XRB, XTA -----	2
22	21104 AA	Rod, thread stand -----	1
23	21114 U	Split socket, ball -----	2
24	652-16	Washer -----	1
25	21104 H	Nut -----	1
26	652 J-24	Washer -----	1
27	652 J-16	Washer -----	1
28	WA9 A	Washer, lock -----	1
29	651 A-16	Nut -----	1
30	39899 A	Wire, threading -----	1
31	116	Wrench, open end -----	1
32	21227 DR	Extractor, cam -----	1
33	660-240	Tweezers, thread -----	1
34	21388 AU	Wrench, socket, 3/8 inch (9.5mm) hexagon -----	1
35	660-264	"S" Hook -----	2
36	421 D-34	Chain, presser foot lifter, 32 3/64 inch (812.8mm) long -----	1
37	21375 BB	Guard, belt -----	1
38	80	Screw -----	2
*	660-458	Cover, dust -----	1
*	28604 R	Container of Oil, 16 ounces (455 ml) Spec. 175 -----	1
*	21393 AC	Pan, oil drip -----	1
*	NA-12	Nail, oil drip pan -----	8
*	652-24	Washer, (shim) all Styles except XRC, XQJ, XRN, XSD, CXQJ, CXRN, CXSD -----	8
*	144-36	Isolators -----	6
*	650-24	Bolts with Nuts -----	3
*	22820 A	Screw, hexagon head -----	3

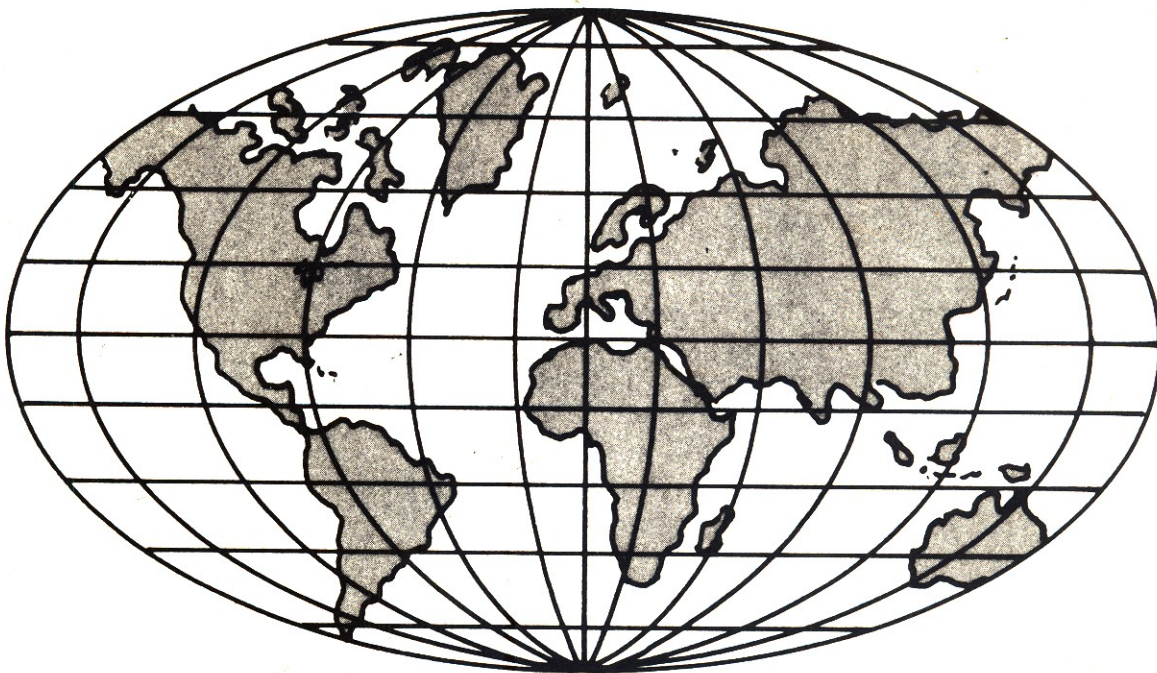
* Not shown on illustration.

NUMERICAL INDEX OF PARTS

Part No.	Page No.	Part No.	Page No.	Part No.	Page No.	Part No.	Page No.
WA9 A.....	57	660-764.....	33	21375 BB.....	57	22782 A.....	37,39
NA-12.....	57	660-824.....	43	21375 BR.....	31	22791 H.....	47
30-106 B1k.....	33	660-828.....	31	21388 AU.....	57	22797 A.....	35
40-46.....	47	660-835.....	33	21393 AC.....	57	22799 B.....	45
51-288 B1k.....	33	660-841.....	31	21695 AT.....	27	22799 AE.....	51
69 S.....	57	660-870.....	55	21695 AU.....	27	22806 A.....	47
73 C.....	45	666-94.....	33	22503 F.....	41	22810.....	57
73 X.....	47	666-295.....	31	22513.....	29	22819.....	49
HA73 B.....	45	667 D-8.....	27	22513 C.....	45	22820 A.....	57
77.....	41	671-2.....	55	22513 D.....	37,39	22825.....	53
78.....	43	671-17.....	27	22524.....	43	22847 B.....	47
79-33.....	31	671 B-11.....	55	22528.....	35,39	22873 C.....	45
80.....	57	671 B-12.....	55	22541.....	27	22892 B.....	43
86 X.....	29	671 C-13.....	27	22541 B.....	31,35,39	22894 C.....	41
87.....	35,39	671 C-16.....	55	22559 H.....	45	22894 AE.....	27,41
87 C.....	33,37,39,	671 D-2.....	55	22561.....	35	28604 R.....	57
41		671 D-5.....	55	22562 A.....	41	29126 DF.....	41
88.....	47	671 D-9.....	55	22564 D.....	27	29477 GW.....	27
88 B.....	37,39,45	671 D-15.....	55	22565.....	27,41	29477 MC.....	33
90.....	27,29,45	671 F-1.....	55	22565 C.....	57	29477 MS.....	33
91 D.....	55	671 F-4.....	27	22565 D.....	27	29481 L.....	45
93 A.....	35	671 F-6.....	55	22565 F.....	27,33,	V29941 A.....	53
97.....	41	671 F-62.....	27	35,39		39151.....	41
97 A.....	33	671 H-1.....	53	22565 H.....	41	39158 U.....	29
107.....	57	671 H-1A.....	53	22565 S.....	27,41	39501 D.....	29
108.....	57	671 H-1B.....	53	22566 B.....	47	39501 K.....	27,29
109.....	57	671 H-1D.....	53	22569.....	27	39501 M.....	29
110-4.....	55	671 H-1E.....	53	22569 B.....	27,29,35,	39501 AP.....	29
116.....	57	671 H-1F.....	53	39,47		39501 DC.....	29
138.....	29	671 H-1G.....	53	22569 C.....	47	39501 DD.....	29
144-36.....	57	671 H-1H.....	53	22569 D.....	29,39,47	39501 DG.....	29
154 GAS.....	37,39	906.....	53	22569 G.....	35,39	G39501 D.....	29
154 GDS.....	37	998-332.....	55	22569 K.....	27	39503 A.....	47
154 GFS.....	37	999-127.....	55	22569 T.....	31	39503 C.....	47
162 SAS.....	37	999-139.....	55	22569 X.....	33	39503 D.....	47
222 D.....	45	999-140.....	55	22571 E.....	27	39503 L.....	45
258 A.....	47	999-141.....	53	22585 A.....	43	39505 B.....	49
303.....	45	999-146.....	55	22585 G.....	45	39505 C.....	49
SC333 A.....	57	999-217.....	55	22585 R.....	27	39505 E.....	49,51
376 A.....	47	1025 L.....	41	22586 T.....	31	39505 F.....	51
421 D-34.....	57	RM2813-1.....	31	22587 J.....	43	39505 H.....	51
482 C.....	41	RM2813-4.....	31	22587 M.....	33	39505 J.....	39,49
604.....	47	RM2850 D.....	55	22588 J.....	43	39505 K.....	39,49
605.....	47	RM2871 B.....	55	22588 K.....	53	39505 AB.....	49,51
605 A.....	43	RM2997 D.....	55	22593.....	45	39505 AC.....	51
627.....	47	RM3287-2.....	55	22596 E.....	37,39	39505 AL.....	51
650-24.....	57	RM3320-1.....	55	22596 H.....	33	39505 BH.....	51
651 A-16.....	57	RM3384-1.....	55	22597 E.....	47	39508 A.....	41
652-16.....	57	RM4098-1.....	55	22635 C-12.....	31	39508 B.....	41
652-24.....	57	6042 A.....	43	22650 CB-4.....	31,57	39520 A.....	49
652 J-16.....	57	8372 A.....	35,39,47	22650 CD-4.....	33,57	39520 B.....	49
652 J-24.....	57	11635 B.....	55	22650 CE-6.....	57	39520 H.....	51
660-142.....	47	12538.....	47	22652 B-12.....	31	39520 L.....	49
660-206.....	41	12865.....	47	22652 D-6.....	31	39520 AB.....	51
660-207.....	37,39	12935 A.....	53	22653 B-12.....	43	39520 AC.....	51
660-210.....	29	12957 E.....	47	22657 D-12.....	29	39520 AS.....	49
660-240.....	57	14077.....	43	22716.....	53	39520 BH.....	51
660-243.....	27	14077 A.....	37,39	22716 A.....	53	39521 D.....	33
660-264.....	57	21104 H.....	57	22726 A.....	47	39521 H.....	33
660-372.....	27	21104 V.....	57	22729 A.....	45	39524 B-3/32.....	49
660-392.....	55	21104 AA.....	57	22729 B.....	43	39524 B-1/8.....	49
660-401.....	55	21113 C.....	57	22729 D.....	41,53	39524 B-5/32.....	49
660-403.....	55	21113 F.....	57	22729 E.....	41	29524 C-3/32.....	49
660-443.....	33	21114 S-4.....	57	22738.....	43,51	39524 C-1/8.....	49
660-458.....	57	21114 T.....	57	22738 B.....	49	39524 D.....	51
660-459.....	43	21114 U.....	57	22738 G.....	47	39524 J.....	49
660-550.....	31	21130 W-2.....	57	22743.....	27,45	39524 AB-1/8.....	51
660-695.....	31	21130 W-3.....	57	22747 B.....	33	39524 AB-5/32.....	51
660-700.....	31	21227 DR.....	57	22758 E.....	47	39524 AC.....	51
660-705.....	27	21237 CR.....	27	22768 B.....	39,41,49,	39524 AV.....	49
660-716.....	31	21237 CT.....	31	51		39525 D.....	45
660-717.....	31	21237 CW.....	31	22768 C.....	33	39525 E.....	45
660-726.....	31	21237 DK.....	27	22769 B.....	33	39525 H.....	43
660-731.....	31	21237 DM.....	31	22781.....	47	39525 J.....	43
660-763.....	53	21237 DN.....	31	22781 A.....	33,35,39	39525 K.....	45

NUMERICAL INDEX OF PARTS

Part No.	Page No.	Part No.	Page No.	Part No.	Page No.	Part No.	Page No.
39525 L.....	43	39544 S.....	41	39573 H.....	43	39592 AL.....	47
39525 R.....	43	39544 U.....	41	39573 J.....	43	39592 AM.....	47
GA39525 N.....	43	39544 V.....	41	39573 K.....	33	39592 AR-1.....	47
39526 B.....	49	39544 X.....	33	39573 AA.....	33	39592 AR-2.....	47
39526 H.....	51	39549 C.....	43	39573 AB.....	53	39592 AR-4.....	47
39526 AB.....	49, 51	39549 CJ.....	43	39573 AC.....	53	39592 AR-5.....	47
39526 AC.....	51	39550 C.....	43	39578 F.....	29	39592 AR-8.....	47
39528 AH.....	51	39550 E.....	43	39578 P.....	35, 39	39593 C.....	27
39530.....	49, 51	39550 J.....	45	39578 T.....	29	39593 D.....	27
39530 B.....	51	39550 K.....	45	39578 U.....	29	39593 H.....	27
39530 C.....	49	39550 M.....	45	39578 V.....	35	39594 G.....	29
39530 E.....	51	39550 T.....	45	39578 AL.....	29	39594 H.....	29
39530 G.....	51	39550 Z.....	45	39578 AX.....	29	39594 N.....	33, 37, 39, 41
39530 P.....	49, 51	39550 AB.....	43	39578 AY.....	29		
39530 R.....	51	39550 AC.....	43	G39578 M.....	35, 39	39594 R.....	27
39530 S.....	51	39550 AD.....	43	39580 A.....	43	39594 X.....	31
39530 U.....	51	39550 AE.....	43	39580 E.....	43	39594 Y.....	27
39530 AH.....	47	39550 AF.....	43	39580 F.....	43	39595.....	51
39531 AD.....	51	39551 H.....	37	39580 AE.....	43	39597 A.....	49, 51
39532 A.....	29	39551 J.....	37, 39	39580 BA.....	45	39597 L.....	49
39532 D.....	29	39552 P.....	33	39582 D.....	29	39597 AB.....	51
39534.....	35	39552 R.....	37, 39	39582 F.....	31	39597 AS.....	49
39534 G.....	35, 39	39552 U.....	33	39582 H.....	29	39743.....	41
39534 R.....	27	39552 Z.....	37, 39	39582 J.....	29	39772.....	43
39534 AF.....	35, 39	39552 AA.....	37	39582 K.....	29	39835 G.....	35, 39
39534 RB.....	27, 53	39552 AB.....	37	39582 BS.....	45	39843 H.....	41
39535 C.....	35, 39	39552 AD.....	37, 39	39582 BZ.....	27	39855.....	47
39535 D.....	35, 39	39552 AG.....	37, 39	39582 DP.....	31	39868 H.....	47
39535 F.....	39	39552 AJ.....	37	39582 DS.....	27	39878 C.....	29
39535 V.....	35, 39	39555 B.....	47	39582 DT.....	31	39880 N.....	43
39535 W.....	35	39555 C.....	47	39582 DU.....	31	39899 A.....	57
39536 D.....	39	39555 D.....	47	39582 DV.....	27	41071 G.....	29, 53
39536 E.....	35, 39	39555 F.....	47	39582 DY.....	31	43139 A.....	47
39536 CT.....	35	39555 P.....	33	39582 DZ.....	31	43443 Q.....	29
39536 CU.....	37, 39	39555 R.....	33	39582 EA.....	29	C50043 F.....	37, 39
39536 CV.....	35, 39	39555 AA.....	47	39582 EN.....	31	C50093 U.....	31
39536 CW.....	35	39556 A.....	27	39582 ES.....	31	51292 F-1.....	55
39536 CX.....	35	39556 D.....	47	39589 AA.....	45	51295 B.....	31
39536 CY.....	35, 39	39556 J.....	47	39589 AB.....	45	53634 C.....	35, 39
39536 CZ.....	31	39556 L.....	47	39589 AC.....	45	53658 A.....	47
39536 DA.....	31	39556 M.....	47	39589 AD.....	45	55235 D.....	43
39536 DB.....	53	39556 N.....	35	39589 AE-1/2.....	45	55235 E.....	43
39536 DC.....	53	39556 T.....	47	39589 AE-3/4.....	45	60078 Z.....	53
39538 A.....	35, 39	39557 A.....	27	39589 AE-1.....	45	61303 D.....	45
39540 M-5 1/2.....	39	39557 B.....	27	39589 AF.....	45	79077.....	45
39540 M-7.....	35	39557 C.....	27	39589 AG.....	45	80265.....	53
39540 M-8.....	35	39557 E.....	27	39589 AH.....	45	95073.....	55
39540 M-9.....	37	39557 F.....	27	39589 AJ.....	45	95151.....	55
39540 M-10.....	35	39557 H.....	27	39589 AK-1/2.....	45	95250.....	55
39540 M-12.....	37	39560 A.....	41	39589 AK-3/4.....	45	95910 A.....	53
39540 M-14.....	37	39560 B.....	41	39589 AK-1.....	45	95910 B.....	53
39540 M-18.....	35	39563 D.....	47	39589 AL.....	45	99373 C.....	53
39540 M-20.....	37	39563 H.....	47	39590 D.....	33	99563 A-155.....	55
39540 M-30.....	35, 37	39563 N.....	47	39590 H.....	33	99663 KA.....	53
39540 R.....	39	39563 P.....	37	39590 J.....	33	99664 A.....	47
39541 C.....	33	39563 AA.....	39	39590 N.....	33	99664 C.....	53
39541 D.....	31	39563 AC.....	37, 39	39590 T.....	33	99665.....	53
39542 A.....	31	39568 B.....	47	39590 Y.....	33	99665 A.....	53
39543 E.....	41	39568 D.....	47	39590 Z.....	33	99669 K.....	53
39543 M.....	41	39568 E.....	47	39590 AB.....	33	99670 L.....	53
39543 P.....	41	39568 G.....	27	39591 A.....	33	99675-1500.....	55
39543 S.....	41	39568 J.....	27, 45	39591 B.....	33	99676 MA.....	53
39543 T.....	41	39568 L.....	47	39591 K.....	33	99677 HA.....	53
39543 W.....	41	39568 W.....	47	39592 D.....	57	99677 HB.....	53
39543 X.....	41	39568 AC.....	37	39592 E.....	57	99677 HD.....	53
39543 Y.....	37, 39	39568 AH.....	37, 39	39592 W.....	57	99679.....	29
39543 Z.....	41	39570 C.....	43	39592 Z.....	47	99683 E.....	55
39543 AA.....	35, 39	39570 CJ.....	43	39592 AA.....	47	99683 J.....	55
39543 AC.....	41	39571 B.....	43	39592 AB.....	47	99683 K.....	55
39543 AF.....	41	39571 C.....	43	39592 AC.....	47	99683 CC.....	55
39544.....	41	39571 D.....	43	39592 AD.....	47	99683 HC-155.....	55
39544 B.....	41	39571 F.....	43	39592 AF.....	47	99697 DA.....	53
39544 D.....	41	39572.....	43	39592 AG-3.....	47		
39544 J.....	41	39573 A.....	43	39592 AH.....	47		
39544 N.....	41	39573 E.....	43	39592 AK.....	47		



WORLDWIDE SALES AND SERVICE

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

It is important to remember that LEWIS® and COLUMBIA® machines are also products of Union Special Corporation, thus offering the industry the most complete line of the Finest Quality sewing machines.

Norcross, GA
Chicago, IL
Dallas, TX
Commerce, CA
New York, NY
Philadelphia, PA
Opa-Locka, FL
Montreal, Quebec
Toronto, Ontario
Brussels, Belgium
Leicester, England
Paris, France
Stuttgart, W. Germany
Hong Kong
Osaka, Japan
Other Representatives throughout
all parts of the world


Finest Quality Industrial Sewing Equipment

Union Special Corporation, 400 N. Franklin Street, Chicago, IL 60610, U.S.A.
Union Special, GmbH, Schwabstrasse 33, D-7000 Stuttgart 1, West Germany.