

FINEST QUALITY

*Union Special*®

LEWIS • COLUMBIA

INDUSTRIAL  
SEWING  
MACHINES

STYLES

54200 A

54200 C

54200 E

54200 F

54200 G

54200 K

54200 N

54200 P

54400 A

54400 C

54400 E

54400 F

54400 G

54400 H

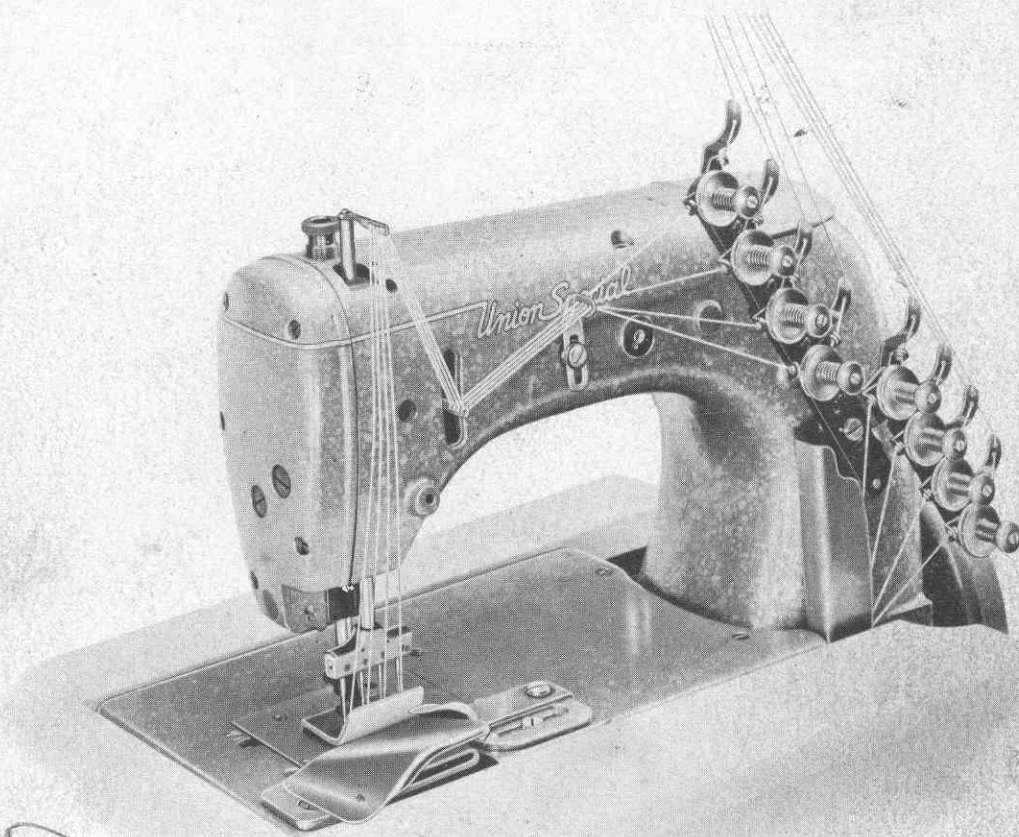
54400 J

CATALOG

No.

102 L

Third  
Edition



CLASSES

54200

54400

STREAMLINED  
MULTIPLE NEEDLE MACHINE

*Union Special* MACHINE COMPANY

CHICAGO

 - ORIGINAL

# 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<br>(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

 **Union Special**<sup>®</sup>  
FINEST QUALITY **MACHINE COMPANY**

Catalog No. 102 L

LIST OF PARTS

Classes 54200, 54400

STYLES

|         |         |         |         |
|---------|---------|---------|---------|
| 54200 A | 54200 G | 54400 A | 54400 G |
| 54200 C | 54200 K | 54400 C | 54400 H |
| 54200 E | 54200 N | 54400 E | 54400 J |
| 54200 F | 54200 P | 54400 F |         |

Third Edition

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*Union Special*  
**MACHINE COMPANY**  
INDUSTRIAL SEWING MACHINES  
**CHICAGO**

Printed in U. S. A.



## FOREWORD

The Classes 54200 and 54400 streamlined machines covered by this catalog, represent the latest design in Union Special's flat bed 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. A conveniently located throw-out device enables the operator to disengage the loopers from their driving mechanism, thus exposing the heel and eye of each looper for easy threading. Some styles are equipped with a close coupled puller, with the clutch mechanism in the upper roller, to insure a uniformly controlled feeding, and an elastic metering device to allow the required amount of elastic in each garment. All parts are made by precision methods insuring complete interchangeability.

It is our constant aim to furnish carefully prepared information which will enable our customers to secure all possible economies from the use of Union Specials. The following pages illustrate and describe the parts for styles in Classes 54200 and 54400.

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 cooperate with those who desire in planning and estimating their requirements.

*Union Special* MACHINE COMPANY

Engineering Department



## IDENTIFICATION OF MACHINES

Each Union Special carries a style number which is stamped in the name plate on the machine. Style numbers are classified as standard and special. Standard style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 54200 A". Special style numbers contain the letter "Z". When only minor changes are made in a standard machine, a "Z" is suffixed to the standard style number. Example: "54200 AZ".

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: "54200".

## APPLICATION OF CATALOG

This catalog applies specifically to the standard styles of machines as listed herein. It can also be applied with discretion to the special machines in Classes 54200 and 54400. All reference to direction, such as left and right, front and back, etc., are taken from the operator's position, while seated at the machine. Operating direction of handwheel is toward the operator.

## STYLES OF MACHINES

Streamlined, Enclosed Type, Flat Bed, Independent Row, Four, Nine and Twelve Needles Abreast, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Double Locked Stitch, Type 401. Loopers in Line With Feed, Looper Throw-out for Simplified Threading, Automatic Enclosed Type Oiling System, Filter Type Oil Return Pump, Oil Pan Base Plate and Head Oil Siphon Assembly.

54200 A-4 High Throw Machine, for attaching woven elastic to boxer type shorts, children's play suits, boys' trousers, swimming trunks, etc., on medium heavy to heavy weight materials. Body of garment turned downwardly, elastic not covered, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 4800 R.P.M.

54200 C-4 Same as 54200 A-4, except no attachment or elastic strip tension.

54200 E-4 High Throw Machine, for attaching woven elastic to swimming trunks, walking shorts, children's play suits, boys' trousers, hobby jeans, etc., on medium to heavy weight materials. Body of garment turned downwardly, elastic not covered, equipped with close coupled puller, upper roller driven, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 4800 R.P.M.

54200 F-4 Same as 54200 E-4, except no attachment or elastic strip tension.

54200 G-4 Same as 54200 E-4, except fitted with elastic metering device.

54200 K-4 High Throw Unequal Space Machine, for banding denim dungarees and overalls. Right angle folder, close coupled puller, upper roller driven. Standard gauges Nos. 12-56-12, 16-64-16. Seam Type BSc-4. Maximum recommended speed 4800 R.P.M.

54200 N High Throw Single Needle Machine equipped with close coupled puller with 3/4 inch wide rubber puller rollers, upper roller driven. For seaming trousers, skirts, jackets and similar garments made from Koratron and durable press materials; where seam is primarily straight. Seam Type 401-SSa-1. Maximum recommended speed 5500 R.P.M.

## STYLES OF MACHINES (Continued)

- 54200 P Same as Style 54200 N except equipped with compensatory presser foot with yielding section to the left of needle hole. Seam Type 401-SSa-1. Maximum recommended speed 5500 R.P.M.
- 54400 A-4 Low Throw Machine, for attaching woven elastic to boxer type shorts, children's play suits, boys' trousers, etc., on light to medium weight materials. Body of garment turned downwardly, elastic not covered, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 5000 R.P.M.
- 54400 C-4 Same as 54400 A-4, except no attachments or elastic strip tension.
- 54400 E-4 Low Throw Machine, for attaching woven elastic to boxer type shorts, pajamas, etc., on light to medium weight materials. Body of garment turned downwardly, close coupled puller, upper roller driven, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 4800 R.P.M.
- 54400 F-4 Same as 54400 E-4, except no attachments or elastic strip tension.
- 54400 G-4 Same as 54400 E-4, except fitted with elastic metering device.
- 54400 H-9, -12 Nine and Twelve Needle Machine, equally spaced, for decorative stitching operations on women's and children's dresses, blouses, coats, beachwear, and for similar operations on light to medium weight material. No attachment or thread stand. Standard gauge for nine needle No. 16; standard gauge for twelve needle No. 12. Maximum recommended speed 4000 R.P.M.
- 54400 J-9, -12 Same as 54400 H-9, -12, except equipped with close coupled puller, upper roller driven.

## NEEDLES

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

The standard needle for all Styles in Classes 54200 and 54400, is Type 113 GS, except Styles 54200 K, 54200 N and 54200 P which uses needle Type 133 GS. The descriptions of these needles and the sizes available are listed below.

| <u>Type No.</u> | <u>Description and Sizes</u>                                                                                                                                     |
|-----------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 113 GS          | Round shank, round point, extra short, double groove, spiral groove, struck groove, ball eye, spotted, chromium plated - sizes 029, 032, 036, 040, 044, 049, 054 |
| 133 GS          | Round shank, round point, short, double groove, spiral groove, struck groove, ball eye, spotted, chromium plated - sizes 032, 036, 040, 044, 049, 054            |

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 113 GS, Size 040".

## NEEDLES (Continued)

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

## 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 number, 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:

|          |                                       |   |
|----------|---------------------------------------|---|
| 29126 DE | Puller Drive Eccentric Assembly ----- | 1 |
| 95       | Screw-----                            | 2 |
| 22587    | Bearing Cap Screw -----               | 2 |

It will be noted in the above example that the eccentric 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.

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 Machine Company, 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.



## USE GENUINE NEEDLES AND REPAIR PARTS (Continued)

Genuine needles are packaged with labels marked *Union Special*. Genuine repair parts are stamped with the Union Special trademark. 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

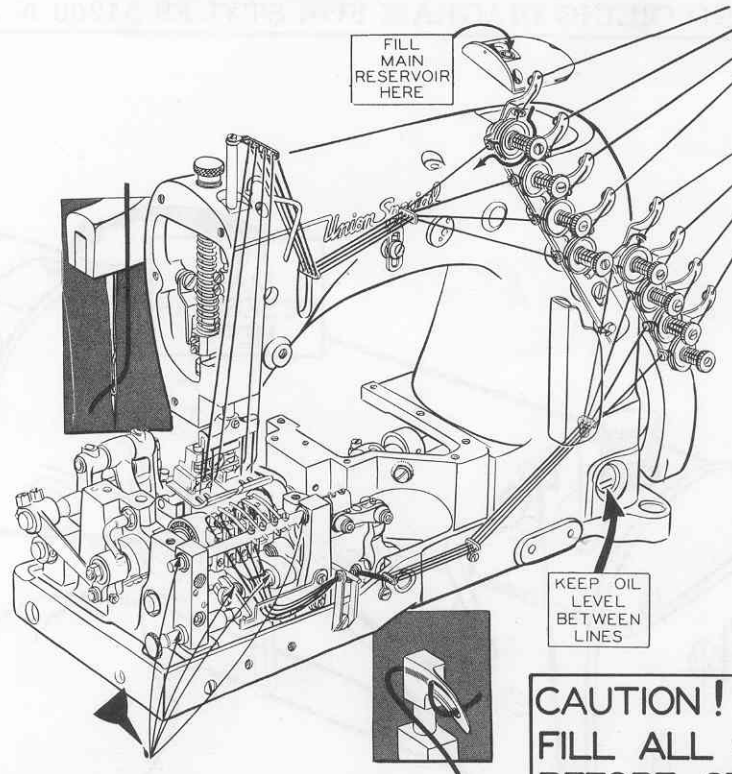
The oil has been drained from the machine before shipping, and the reservoir must be filled before beginning to operate. Use a straight mineral oil with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit.

Oil is filled at the spring cap in the top cover, and the oil level is checked at the sight gauge on the front of the machine. The capacity of the oil reservoir is twelve ounces.

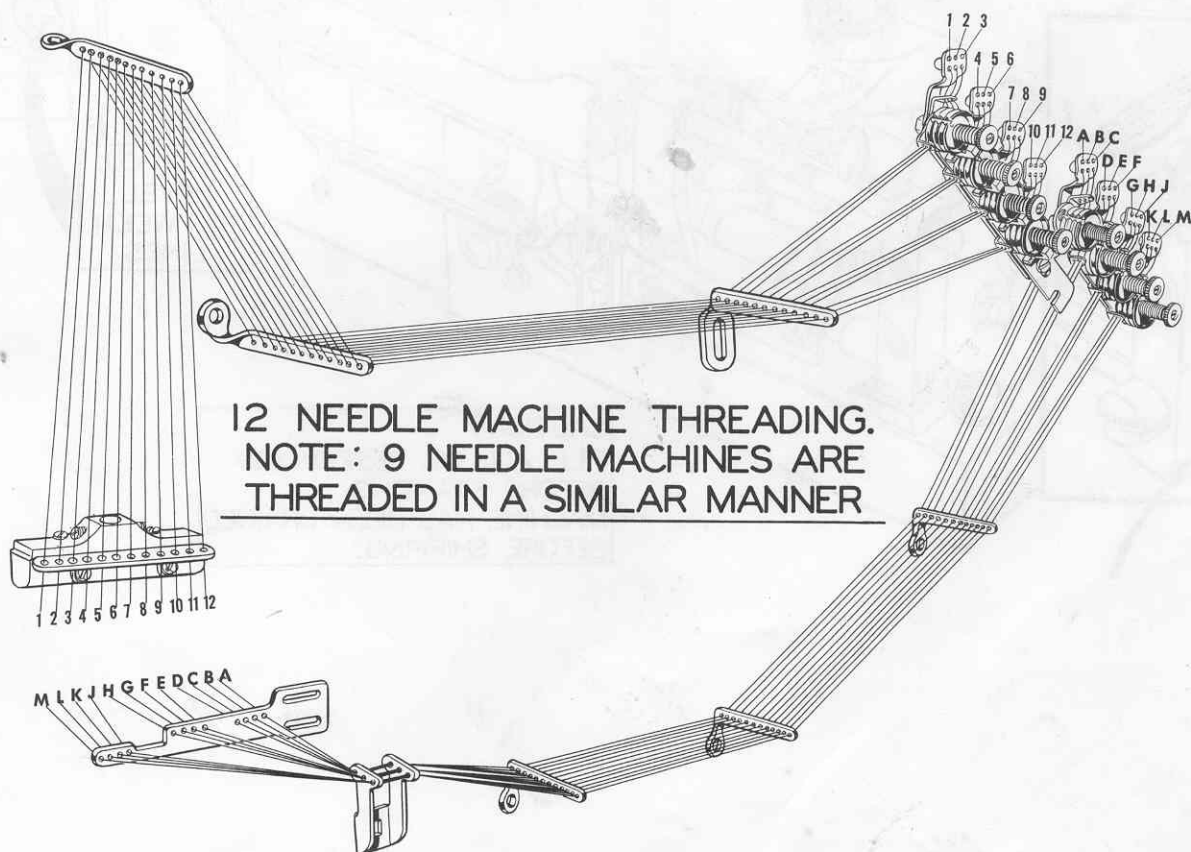
The machine is almost entirely automatically lubricated, and no oiling other than an occasional drop of oil at both bearings of the retainer holder, the looper throw-out pin, and looper holder frame locking pin, as indicated in the oiling diagram, are required.

A daily check before the morning start should be made, to see that the level of the oil in the main reservoir is kept between the two red lines on the gauge. 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 handwheel. After draining oil, wipe the hole and plug screw dry, paint hole and screw with a little gasket cement, and re-assemble screw.

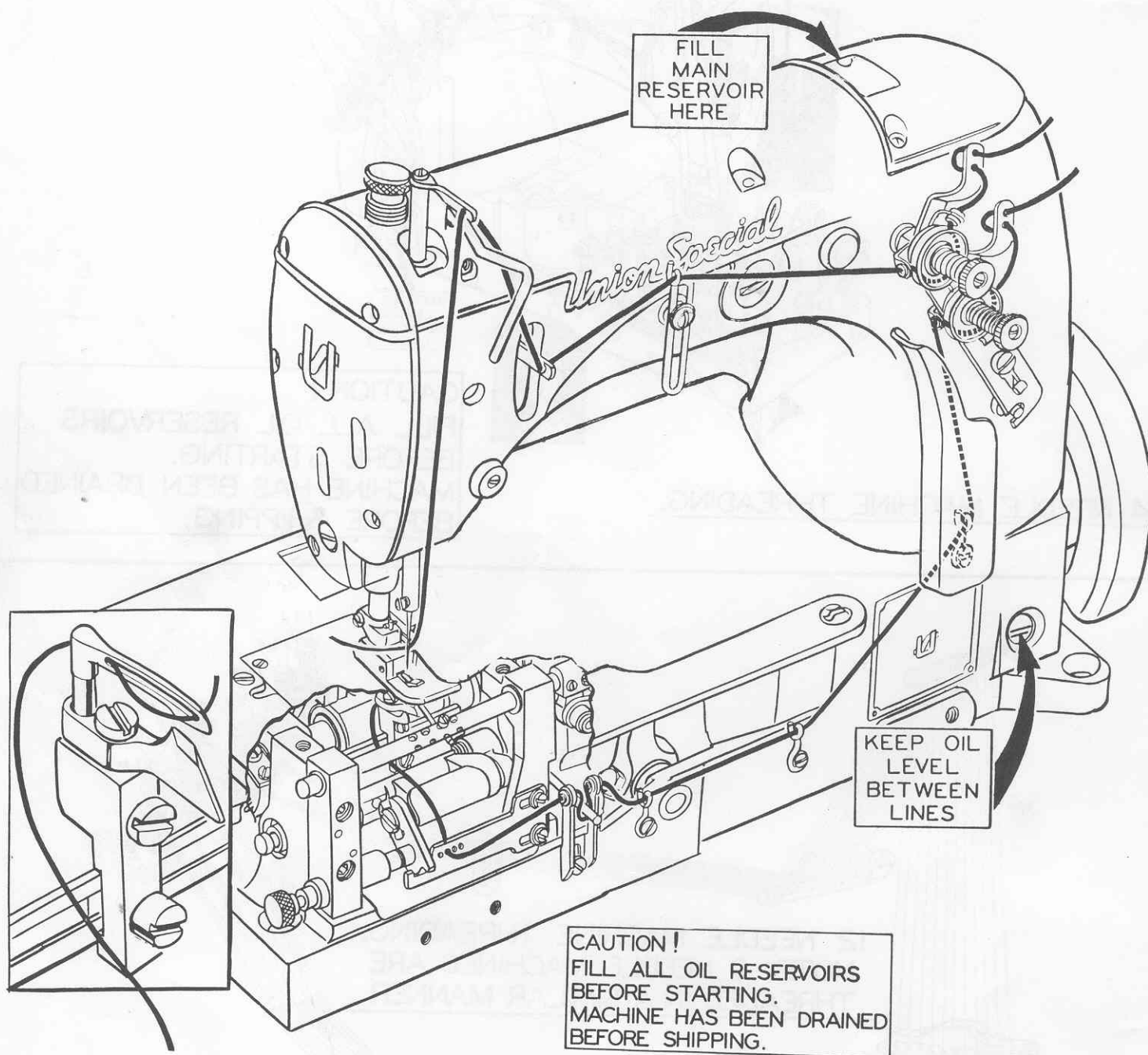
The accompanying drawings also show the manner in which the machine is threaded. Please note, that the needles are inserted in the needle holder with the eyes in a plane at right angles to the direction of line of feed, and are threaded from right to left.



#### 4 NEEDLE MACHINE THREADING.



THREADING AND OILING DIAGRAM FOR STYLES 54200 N AND 54200 P

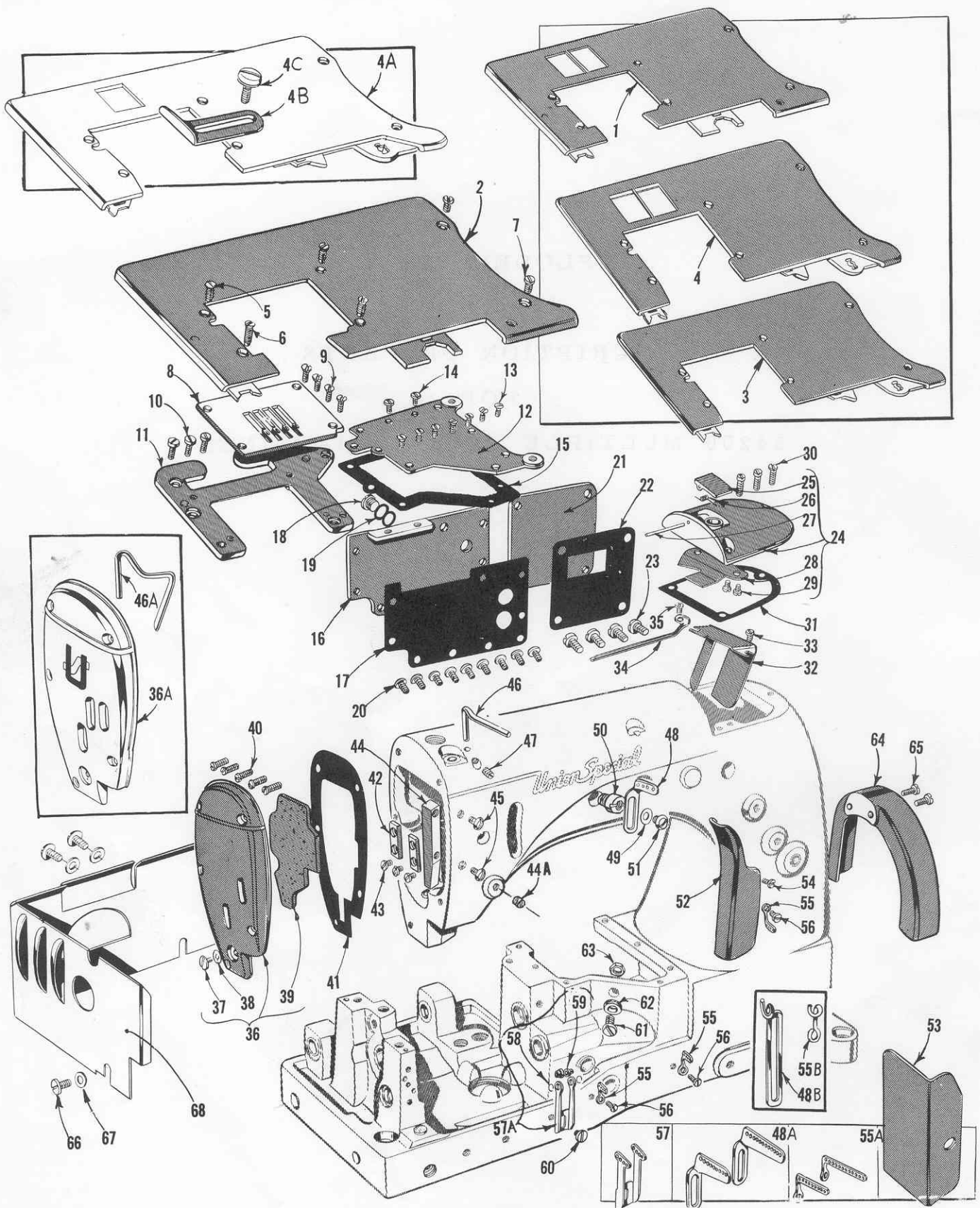




The background of the page features several faint, technical line drawings of mechanical components. These include what appear to be rectangular plates with various slots and holes, cylindrical parts, and other mechanical assemblies, all arranged in a way that suggests they are exploded views of a larger machine. The drawings are light and serve as a backdrop for the central text.

EXPLODED VIEWS  
AND  
DESCRIPTION OF PARTS  
FOR

54200 MULTIPLE NEEDLE MACHINES



MAIN FRAME, MISCELLANEOUS COVERS AND PLATES

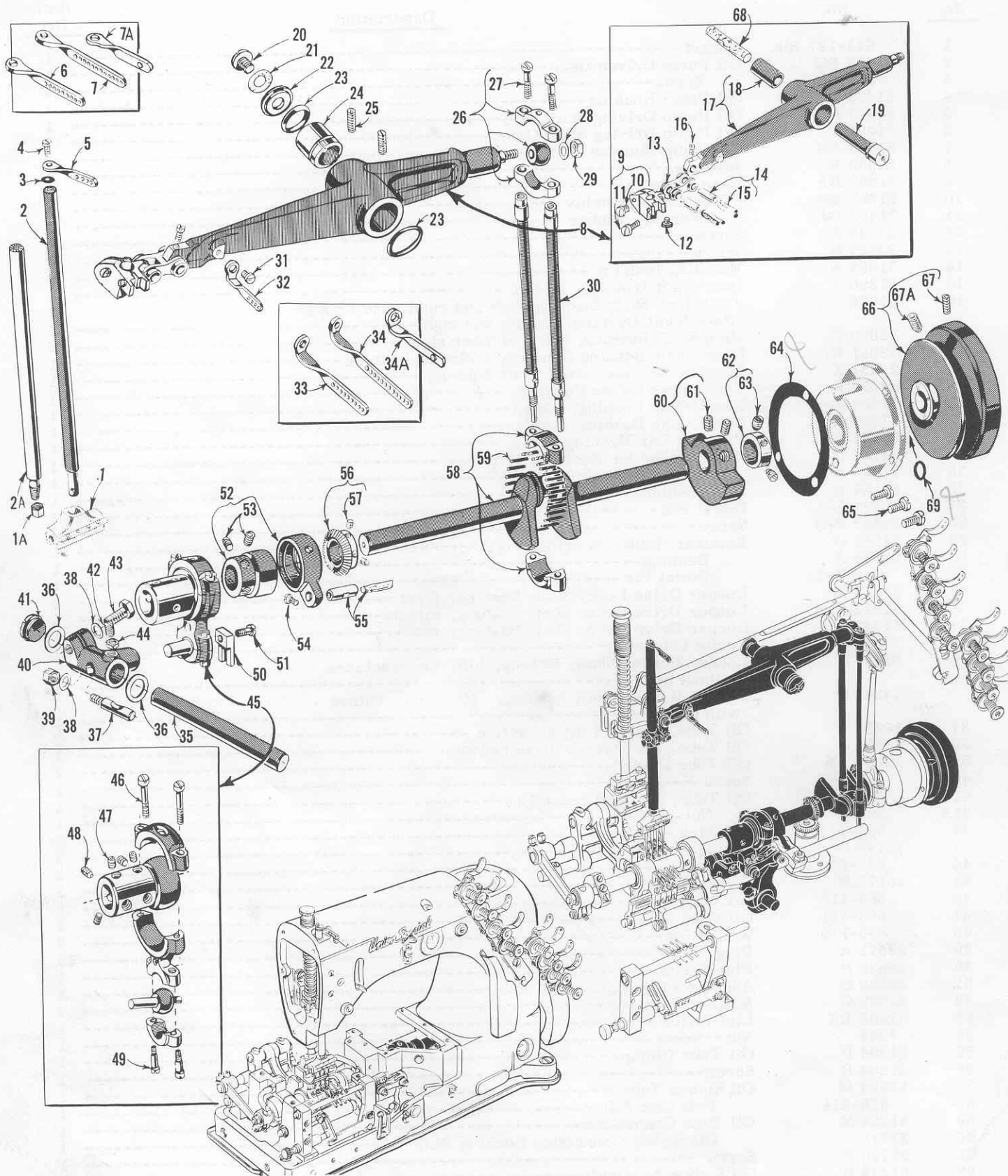
| Ref.<br>No. | Part<br>No. | Description                                                        | Amt.<br>Req. |
|-------------|-------------|--------------------------------------------------------------------|--------------|
| 1           | 54201 B     | Cloth Plate, for Styles 54200 E, F, G, K-4-12-56-12, 54400 E, F, G | 1            |
| 2           | 54201 C     | Cloth Plate, for Styles 54200 A, C, 54400 A, C                     | 1            |
| 3           | 54401       | Cloth Plate, for Style 54400 H                                     | 1            |
| 4           | 54401 A     | Cloth Plate, for Styles 54200 K-4-16-64-16, 54400 J                | 1            |
| 4A          | 54201 D     | Cloth Plate, for Styles 54200 N, P                                 | 1            |
| 4B          | 24 X        | Edge Guide, for Styles 54200 N, P                                  | 1            |
| 4C          | 22517 B     | Screw, for edge guide, on Styles 54200 N, P                        | 1            |
| 5           | 80          | Screw                                                              | 3            |
| 6           | 22574       | Screw                                                              | 1            |
| 7           | 22839 C     | Screw                                                              | 2            |
| 8           |             | Throat Plate (see pages 31, 33)                                    | 1            |
| 9           | 87          | Screw                                                              | 4            |
| 10          | 22839       | Screw                                                              | 3            |
| 11          | 54280       | Throat Plate Support, for machines without puller                  | 1            |
| 12          | 53782 B     | Oil Reservoir Top Cover                                            | 1            |
| 13          | 22524       | Screw                                                              | 7            |
| 14          | 22585 A     | Screw                                                              | 2            |
| 15          | 51382 A     | Gasket                                                             | 1            |
| 16          | 52882 L     | Oil Reservoir Back Cover                                           | 1            |
| 17          | 52882 M     | Gasket                                                             | 1            |
| 18          | 22733 B     | Plug Screw, for oil reservoir back cover                           | 1            |
| 19          | 41394 A     | Gasket                                                             | 2            |
| 20          | 22848       | Screw                                                              | 9            |
| 21          | 52882 AE    | Crank Chamber Cover                                                | 1            |
| 22          | 52882 U     | Gasket                                                             | 1            |
| 23          | 22548       | Screw                                                              | 4            |
| 24          | 52882 AD    | Crank Chamber Oil Cover                                            | 1            |
| 25          | 39582 L     | Oil Cap                                                            | 1            |
| 26          | 52882 AC    | Oil Cap Torsion Spring                                             | 1            |
| 27          | 50-789 Blk. | Oil Cap Hinge Pin                                                  | 1            |
| 28          | 52882 AA    | Oil Drip Plate                                                     | 1            |
| 29          | 90          | Screw                                                              | 2            |
| 30          | 22541 B     | Screw                                                              | 3            |
| 31          | 52882 P     | Gasket                                                             | 1            |
| 32          | 52882 Y     | Baffle Plate                                                       | 1            |
| 33          | 90          | Screw                                                              | 1            |
| 34          | 51282 AE    | Needle Lever Bearing Oiler                                         | 1            |
| 35          | 90          | Screw                                                              | 1            |
| 36          | 51282 Y     | Head Cover, for all Styles except 54200 N, P and 54400 H, J        | 1            |
| 36A         | 51782 A     | Head Cover, for Styles 54400 H, J                                  | 1            |
| 37          | 54282 A     | Head Cover, for Styles 54200 N, P                                  | 1            |
| 38          | 22542       | Plug Screw                                                         | 1            |
| 39          | 52882 W     | Gasket                                                             | 1            |
| 40          | 54282 B     | Felt Liner, for No. 54282 A                                        | 1            |
| 41          | 22569 B     | Screw                                                              | 5            |
| 42          | 51282 Z     | Head Cover Gasket                                                  | 1            |
| 43          | 35731 A     | Presser Bar Connection Guide Plate                                 | 2            |
| 44          | 22513       | Screw                                                              | 3            |
| 44A         | 51454 A     | Needle Bar Connection Guide Block                                  | 1            |
| 45          | 95          | Plug Screw                                                         | 1            |
| 46          | 22849       | Screw                                                              | 2            |
| 46A         | 54270       | Needle Thread Take-up Wire, for all Styles except 54200 N, P       | 1            |
| 47          | 51270 B     | Needle Thread Take-up Wire, for Styles 54200 N, P                  | 1            |
| 48          | 95          | Screw                                                              | 1            |
| 48A         | 51858       | Needle Thread Frame Eyelet, for four needle machines               | 1            |
|             | 54458 B-9   | Needle Thread Frame Eyelet, for nine needle machines               | 1            |
|             | 54458 B-12  | Needle Thread Frame Eyelet, for twelve needle machines             | 1            |
| 48B         | 539         | Needle Thread Frame Eyelet, for single needle machines             | 1            |
| 49          | 20          | Washer                                                             | 1            |
| 50          | 22889 A     | Adapter Screw                                                      | 1            |
| 51          | 22848       | Screw                                                              | 1            |
| 52          | 51291 A     | Looper Thread Guard, for four needle machines                      | 1            |
| 53          | 54491 A     | Looper Thread Guard, for nine and twelve needle machines           | 1            |
| 54          | 98 A        | Screw                                                              | 1            |
| 55          | 1068        | Thread Eyelet, for four needle machines                            | 3            |
| 55A         | 54459 A-9   | Thread Eyelet, for nine needle machines                            | 3            |
|             | 54459 A-12  | Thread Eyelet, for twelve needle machines                          | 3            |
| 55B         | 52 A        | Thread Eyelet, for single needle machines                          | 3            |
| 56          | 98 A        | Screw                                                              | 3            |
| 57          | 54459 B     | Looper Thread Pull-off Eyelet, for nine and twelve needle machines | 1            |
| 57A         | 39267       | Looper Thread Pull-off Eyelet, for four needle machines            | 1            |
| 58          | 668-28      | Locking Ring                                                       | 2            |
| 59          | 668-29      | Eyelet                                                             | 2            |
| 60          | 22585 C     | Screw                                                              | 1            |
| 61          | 22891       | Screw, for machines without puller                                 | 1            |
| 62          | 61394 AF    | Gasket, for machines without puller                                | 1            |
| 63          | 258 A       | Nut, for machines without puller                                   | 1            |
| 64          | B21375 AH   | Belt Guard                                                         | 1            |
| 65          | 93          | Screw                                                              | 2            |
| 66          | 22848       | Screw, for oil shield                                              | 3            |
| 67          | 20          | Washer, for No. 22848                                              | 3            |
| 68          | 54282       | Oil Shield                                                         | 1            |





MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

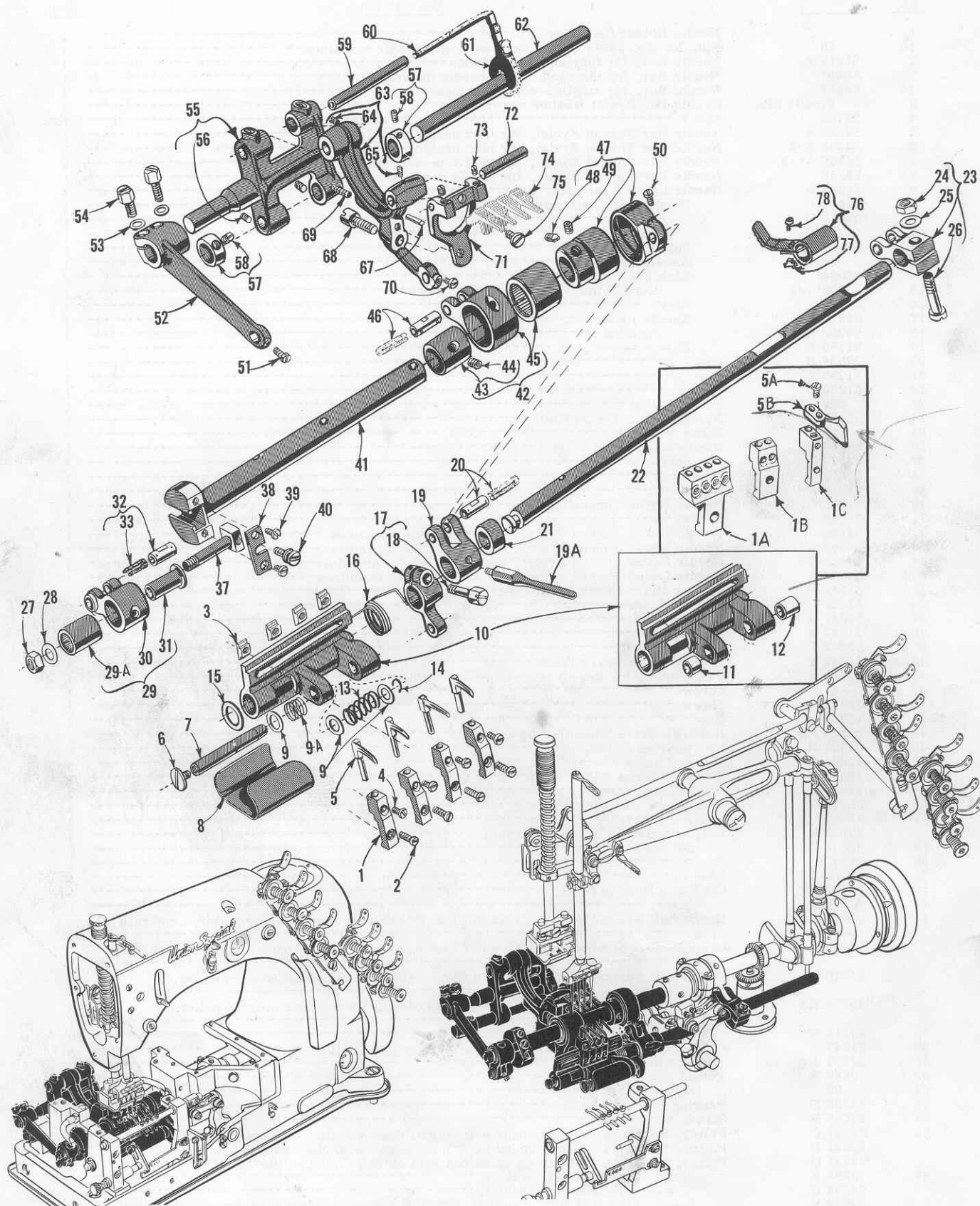
| Ref.<br>No. | Part<br>No.  | Description                                                                                       | Amt.<br>Req. |
|-------------|--------------|---------------------------------------------------------------------------------------------------|--------------|
| 1           | 643-127 Blk. | Gasket -----                                                                                      | 1            |
| 2           | 51493 BQ     | Oil Pump Driven Gear -----                                                                        | 1            |
| 3           | 531          | Screw -----                                                                                       | 2            |
| 4           | 51493 AG     | Oil Pump Housing -----                                                                            | 1            |
| 5           | 51493 D      | Oil Pump Driving Shaft -----                                                                      | 1            |
| 6           | 51493 E      | Oil Pump Driving Shaft Gear -----                                                                 | 2            |
| 7           | 51493 AH     | Oil Pump Housing Cover -----                                                                      | 1            |
| 8           | 22569 B      | Screw -----                                                                                       | 3            |
| 9           | 51493 BA     | Base Plate -----                                                                                  | 1            |
| 10          | 51493 BH     | Filter Cap Assembly -----                                                                         | 1            |
| 11          | 51493 BJ     | Washer, rubber -----                                                                              | 1            |
| 12          | 22823 A      | Screw -----                                                                                       | 2            |
| 13          | 22823 B      | Screw -----                                                                                       | 1            |
| 14          | 51295 A      | Mounting Isolator -----                                                                           | 4            |
| 15          | 51290 T      | Main Shaft Bushing, middle -----                                                                  | 1            |
| 16          | 52936        | Feed Rock Shaft Bushing, left and right, and Looper<br>Rock Shaft Bushing, middle and right ----- | 4            |
| 17          | 52890 C      | Main Shaft Bushing, left and inner right -----                                                    | 2            |
| 18          | 52891 B      | Crankshaft Bushing Housing, including bushing -----                                               | 1            |
| 19          | 21657 X      | Tension Release Lever Shaft Bushing -----                                                         | 1            |
| 20          | 52883 R      | Foot Lifter Lever Bushing -----                                                                   | 1            |
| 21          | 51854 F      | Needle Bar Bushing, upper -----                                                                   | 1            |
| 22          | 51854 E      | Needle Bar Bushing, lower -----                                                                   | 1            |
| 23          | 51257 AA     | Presser Bar Bushing, lower -----                                                                  | 1            |
| 24          | 54242 C      | Retainer Holder Bearing, left -----                                                               | 1            |
| 25          | 61354 A      | Bushing, upper -----                                                                              | 1            |
| 26          | 51254 A      | Bushing, Lower -----                                                                              | 1            |
| 27          | 667 B-12     | Dowel Pin -----                                                                                   | 4            |
| 28          | 22652 B-8    | Screw -----                                                                                       | 4            |
| 29          | 54242 D      | Retainer Holder Bearing, right -----                                                              | 1            |
| 30          | 61354 A      | Bushing -----                                                                                     | 1            |
| 31          | 667 B-12     | Dowel Pin -----                                                                                   | 1            |
| 32          | 51242 Z      | Looper Drive Lever Shaft Bushing, front -----                                                     | 1            |
| 33          | 51242 R      | Looper Drive Lever Shaft Bushing, middle -----                                                    | 1            |
| 34          | 51242 S      | Looper Drive Lever Shaft Bushing, rear -----                                                      | 1            |
| 35          | 50-648 Blk.  | Lucite Oil Gauge -----                                                                            | 1            |
| 36          | 52944 T      | Looper Rocker Shaft Bushing, left, for machines<br>without puller -----                           | 1            |
|             | 54244 N      | Looper Rocker Shaft Bushing, left, for machines<br>with puller -----                              | 1            |
| 37          | 54293        | Oil Tube, for feed lift eccentric -----                                                           | 1            |
| 38          | 54293 A      | Oil Tube, for take-up drive eccentric -----                                                       | 1            |
| 39          | 52894 AB     | Oil Tube Holder -----                                                                             | 2            |
| 40          | 90           | Screw -----                                                                                       | 2            |
| 41          | 660-136      | Oil Tube, for feed crank link -----                                                               | 1            |
| 41A         | 258 A        | Nut -----                                                                                         | 1            |
| 42          | 666-114      | Oil Wick -----                                                                                    | 2            |
| 43          | 35178 D      | Spring -----                                                                                      | 2            |
| 44          | 666-65       | Oil Wick -----                                                                                    | 2            |
| 45          | 35178 D      | Spring -----                                                                                      | 2            |
| 46          | 666-118      | Oil Wick -----                                                                                    | 2            |
| 47          | 666-111      | Oil Wick -----                                                                                    | 2            |
| 48          | 666-179      | Wedge Pin -----                                                                                   | 2            |
| 49          | 22571 A      | Plug Screw -----                                                                                  | 15           |
| 50          | 22539 H      | Plug Screw -----                                                                                  | 1            |
| 51          | 22889 D      | Adaptor Plug Screw, left end -----                                                                | 1            |
| 52          | 22889 C      | Adaptor Plug Screw, back -----                                                                    | 2            |
| 53          | 51493 BK     | Lint Filter Screen -----                                                                          | 1            |
| 54          | 7947         | Nut -----                                                                                         | 1            |
| 55          | 51294 P      | Oil Tube Clamp -----                                                                              | 1            |
| 56          | 51294 R      | Screw -----                                                                                       | 1            |
| 57          | 51294 M      | Oil Siphon Tube -----                                                                             | 1            |
| 58          | 666-214      | Felt Lint Filter -----                                                                            | 1            |
| 59          | 51294 N      | Oil Tube Connection -----                                                                         | 1            |
| 60          | 21212        | Oil Siphon Connection Locking Ring -----                                                          | 1            |
| 61          | 22729 A      | Screw -----                                                                                       | 1            |
| 62          | 51294 U      | Oil Siphon Assembly -----                                                                         | 1            |
| 63          | 51294 K      | Upper Clamp -----                                                                                 | 1            |
| 64          | 22729 B      | Screw -----                                                                                       | 1            |
| 65          | 666-209      | Felt Disc -----                                                                                   | 1            |
| 66          | 666-201      | Felt Plug -----                                                                                   | 1            |
| 67          | 51493 BG     | Base Plate Felt -----                                                                             | 1            |



CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS

| Ref.<br>No. | Part<br>No. | Description                                                                                        | Amt.<br>Req. |
|-------------|-------------|----------------------------------------------------------------------------------------------------|--------------|
| 1           |             | Needle Holder (See page 31) -----                                                                  | 1            |
| 1A          | 56          | Nut, for No. 54617 needle bar, on single needle machines -----                                     | 1            |
| 2           | 51817 A     | Needle Bar, for four needle machines -----                                                         | 1            |
|             | 54417       | Needle Bar, for nine and twelve needle machines -----                                              | 1            |
| 2A          | 54617       | Needle Bar, for single needle machines -----                                                       | 1            |
| 3           | 27-484 Blk. | Needle Bar Eyelet Washer -----                                                                     | 1            |
| 4           | 22768       | Screw -----                                                                                        | 1            |
| 5           | 54158 A     | Needle Bar Thread Eyelet, for four needle machines -----                                           | 1            |
| 6           | 54458 A-9   | Needle Bar Thread Eyelet, for nine needle machines -----                                           | 1            |
| 7           | 54458 A-12  | Needle Bar Thread Eyelet, for twelve needle machines -----                                         | 1            |
| 7A          | 56358       | Needle Bar Thread Eyelet, for single needle machines -----                                         | 1            |
| 8           | 29348 S     | Needle Lever Assembly -----                                                                        | 1            |
| 9           | 51454 B     | Needle Bar Connection -----                                                                        | 1            |
| 10          | 22516 B     | Screw -----                                                                                        | 1            |
| 11          | 75 C        | Screw -----                                                                                        | 1            |
| 12          | 77          | Screw -----                                                                                        | 1            |
| 13          | 54          | Needle Lever Link -----                                                                            | 1            |
| 14          | 51054       | Link Pin -----                                                                                     | 1            |
| 15          | 666-149     | Lubricating Felt -----                                                                             | 2            |
| 16          | 77          | Screw -----                                                                                        | 1            |
| 17          | 51215 J     | Needle Lever -----                                                                                 | 1            |
| 18          | 51250 A     | Bushing -----                                                                                      | 1            |
| 19          | 51250 E     | Needle Lever Stud -----                                                                            | 1            |
| 20          | 22586 R     | Screw -----                                                                                        | 1            |
| 21          | 51250 F     | Gasket -----                                                                                       | 1            |
| 22          | 51250 D     | Washer -----                                                                                       | 1            |
| 23          | 660-212     | Oil Seal Ring -----                                                                                | 2            |
| 24          | 51150       | Needle Lever Thrust Collar -----                                                                   | 1            |
| 25          | 719         | Screw -----                                                                                        | 2            |
| 26          | 29066 R     | Needle Lever Ball Joint -----                                                                      | 1            |
| 27          | 22559 G     | Screw -----                                                                                        | 1            |
| 28          | 51216 N     | Washer -----                                                                                       | 2            |
| 29          | 51216 P     | Nut -----                                                                                          | 1            |
| 30          | 51216 G     | Needle Lever Connecting Rod -----                                                                  | 2            |
| 31          | 22768       | Screw -----                                                                                        | 1            |
| 32          | 54158       | Needle Lever Thread Eyelet, for four needle machines -----                                         | 1            |
| 33          | 54458-9     | Needle Lever Thread Eyelet, for nine needle machines -----                                         | 1            |
| 34          | 54458-12    | Needle Lever Thread Eyelet, for twelve needle machines -----                                       | 1            |
| 34A         | 56358 A     | Needle Lever Thread Eyelet, for single needle machines -----                                       | 1            |
| 35          | 51242 P     | Looper Drive Lever Shaft -----                                                                     | 1            |
| 36          | 51242 L     | Thrust Washer -----                                                                                | 1            |
| 37          | 52841 G     | Locking Stud -----                                                                                 | 2            |
| 38          | 51242 M     | Washer -----                                                                                       | 1            |
| 39          | 52841 J     | Nut -----                                                                                          | 2            |
| 40          | 51242 Y     | Looper Drive Lever Rocker -----                                                                    | 1            |
| 41          | 22883 A     | Plug Screw, for looper drive lever shaft hole -----                                                | 1            |
| 42          | 81          | Screw -----                                                                                        | 1            |
| 43          | 22852 A     | Screw -----                                                                                        | 1            |
| 44          | 12982       | Nut -----                                                                                          | 1            |
| 45          | 29105 AD    | Retainer Drive Eccentric Assembly -----                                                            | 1            |
| 46          | 22559 B     | Bearing Screw, upper -----                                                                         | 2            |
| 47          | 22894 C     | Set Screw -----                                                                                    | 4            |
| 48          | 22894 D     | Spot Screw -----                                                                                   | 1            |
| 49          | 22559 A     | Bearing Screw, lower -----                                                                         | 2            |
| 50          | 51243 C     | Ball Stud Fork -----                                                                               | 1            |
| 51          | 22729       | Screw -----                                                                                        | 1            |
| 52          | 29133 K     | Looper Drive Eccentric Assembly -----                                                              | 1            |
| 53          | 22894 C     | Set Screw -----                                                                                    | 2            |
| 54          | 22768       | Screw -----                                                                                        | 1            |
| 55          | 51236 A     | Link Pin -----                                                                                     | 1            |
| 56          | 51493 BP    | Oil Pump Driving Gear -----                                                                        | 1            |
| 57          | 22560 B     | Screw -----                                                                                        | 2            |
| 58          | 29476 GH    | Crankshaft Assembly, for Styles in Class 54200 with close coupled puller, .990 inch throw -----    | 1            |
|             | 29476 GJ    | Crankshaft Assembly, for styles in Class 54200 with close coupled puller, .770 inch throw -----    | 1            |
|             | 29476 GZ    | Crankshaft Assembly, for styles in Class 54200 without close coupled puller, .990 inch throw ----- | 1            |
|             | 29476 HA    | Crankshaft Assembly, for styles in Class 54400 without close coupled puller, .770 inch throw ----- | 1            |
| 59          | 51216 M     | Needle Bearing -----                                                                               | 28           |
| 60          | 51247       | Counterweight, for machines without close coupled puller -----                                     | 1            |
| 61          | 22894 J     | Screw -----                                                                                        | 2            |
| 62          | 9660 B      | Thrust Collar -----                                                                                | 1            |
| 63          | 98          | Screw -----                                                                                        | 2            |
| 64          | 56390 E     | Bearing Housing Gasket -----                                                                       | 1            |
| 65          | 22569 B     | Screw -----                                                                                        | 3            |
| 66          | 51221 C     | Pulley, for No. 1 "V" and round belt on machines without close coupled puller -----                | 1            |
|             | 52921 B     | Pulley, for No. 1 "V" and round belt on machines with close coupled puller -----                   | 1            |
|             | 51321 G     | Pulley, for No. 2 "V" belt on machines with close coupled puller -----                             | 1            |
| 67          | 22894 F     | Screw, used with No. 51221 C -----                                                                 | 2            |
|             | 22894 G     | Screw, used with No. 52921 B -----                                                                 | 1            |
|             | 22894 E     | Screw, used with Nos. 51321 G, 52921 B -----                                                       | 1            |
| 67A         | 22894 H     | Screw, used with No. 51321 G -----                                                                 | 1            |
| 68          | 666-170     | Oil Wick, for needle lever stud -----                                                              | 1            |
| 69          | 660-202     | Oil Seal Ring -----                                                                                | 1            |



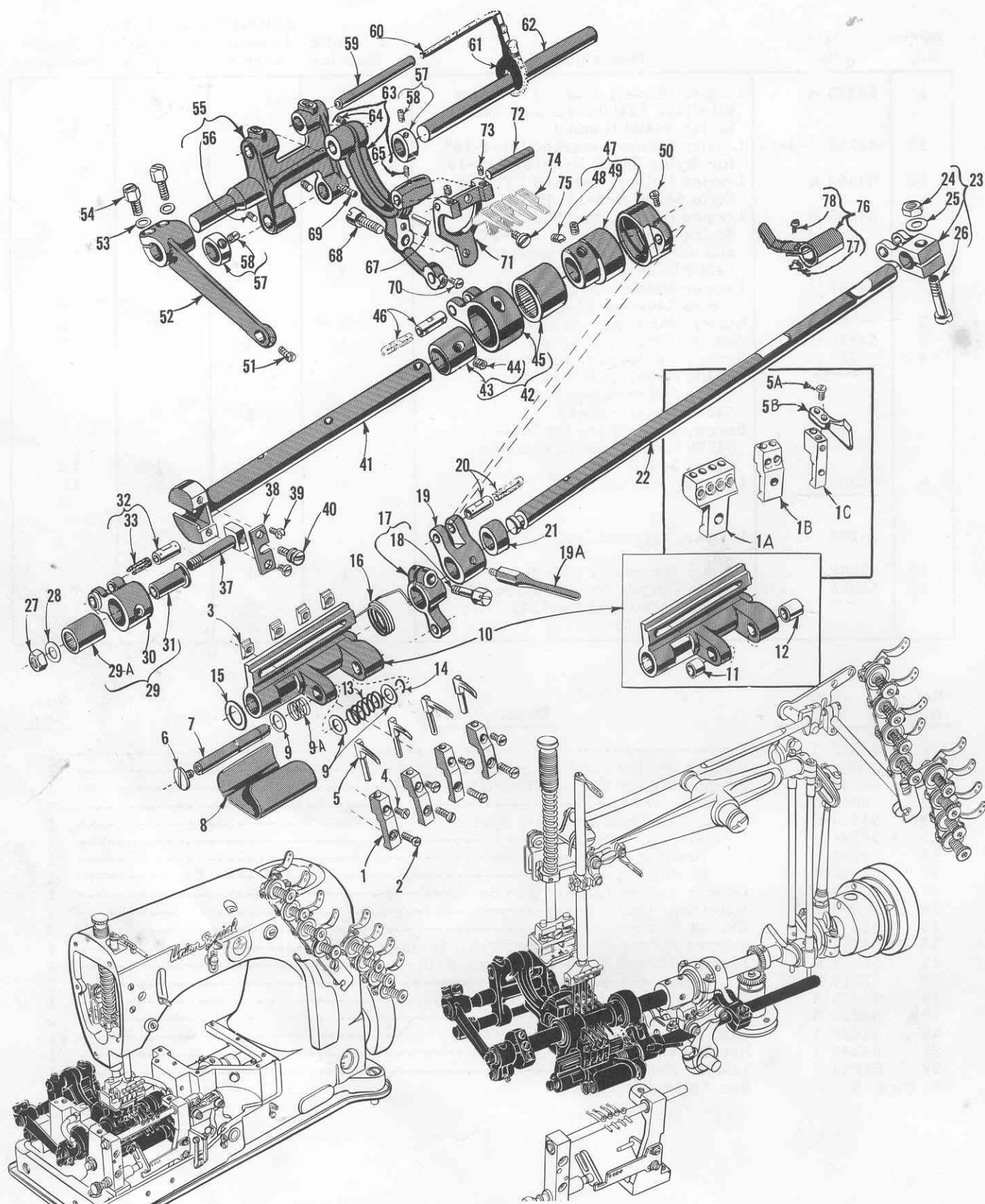




MAIN SHAFT, FEED DRIVING AND LOOPER DRIVING PARTS

| Ref.<br>No. | Part<br>No.  | Description                                                                                                   | AMOUNT REQUIRED     |                     |                     |                      |
|-------------|--------------|---------------------------------------------------------------------------------------------------------------|---------------------|---------------------|---------------------|----------------------|
|             |              |                                                                                                               | 1 Needle<br>Machine | 4 Needle<br>Machine | 9 Needle<br>Machine | 12 Needle<br>Machine |
| 1           | 54485 A      | Looper Holder, marked "S", for all Class 54400 machines except Styles 54400 H and J                           |                     | 4                   |                     |                      |
| 1A          | 54285 A-4-16 | Looper Holder, marked "H-4-16", for Styles 54400 H-9-16, J-9-16                                               |                     |                     | 2                   |                      |
| 1B          | 54485 B      | Looper Holder, marked "T" for Style 54200 K-4-12-56-12                                                        |                     | 2                   |                     |                      |
| 1C          | 54285 B      | Looper Holder, marked "M" for Styles 54400 H-9-16, J-9-16 and all Class 54200 except Style 54200 K-4-12-56-12 | 1                   | 4                   | 1                   |                      |
|             | 54485        | Looper Holder, marked "Q", for Styles 54400 H-12-12, J-12-12                                                  |                     |                     |                     | 3                    |
| 2           | 97 A         | Screw, for looper holder                                                                                      | 1                   | 4                   | 3                   | 3                    |
| 3           | 54285 C      | Nut, for No. 97 A screw                                                                                       | 1                   | 4                   | 3                   | 3                    |
| 4           | J87 J        | Screw, for looper, for Styles 54400 H-9-16, J-9-16 and all Class 54200 except Style 54200 K-4-12-56-12        | 1                   | 4                   | 8                   |                      |
|             | 77           | Screw, for looper, for Style 54200 K-4-12-56-12 and all Class 54400                                           |                     | 4                   | 1                   | 12                   |
| 5           | 54208 A      | Looper, marked "CB"                                                                                           | 1                   | 4                   | 9                   | 12                   |
|             | 54208        | Looper, marked "BZ"                                                                                           |                     |                     |                     |                      |
| 5A          | 22768        | Screw, for needle guard                                                                                       | 1                   | 4                   |                     |                      |
| 5B          | 54225        | Needle Guard, for all Styles in Class 54200 except 54200 K-4-12-56-12                                         | 1                   | 4                   |                     |                      |

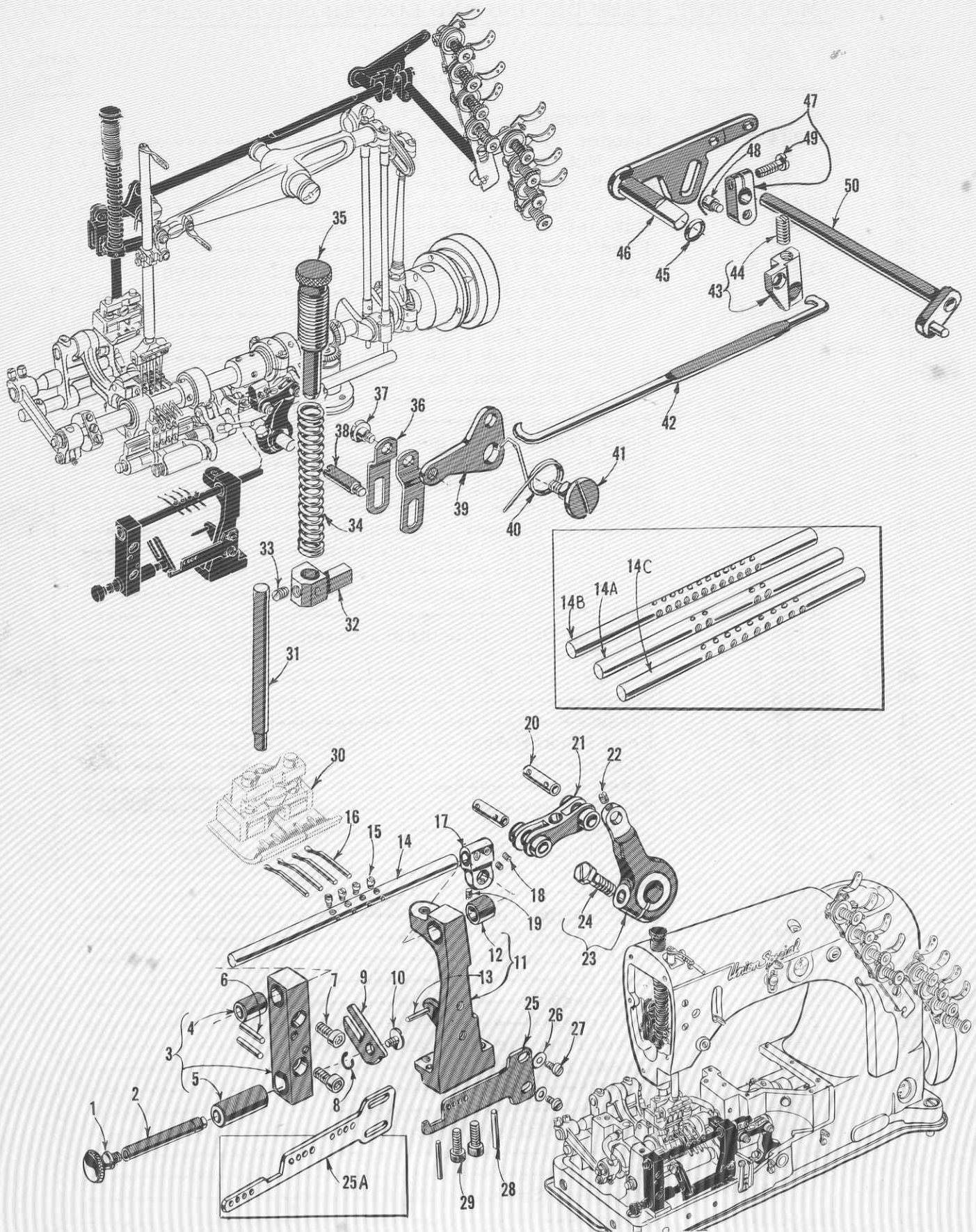
| Ref.<br>No. | Part<br>No. | Description                                | Amt.<br>Req. |
|-------------|-------------|--------------------------------------------|--------------|
| 6           | 22542 A     | Screw -----                                | 1            |
| 7           | 59444 J     | Looper Holder Frame Locking Pin -----      | 1            |
| 8           | 54244 M     | Looper Holder Frame Thread Shield-----     | 1            |
| 9           | 6042 A      | Washer-----                                | 3            |
| 9A          | 54244 H     | Throw-out Fork Pressure Spring-----        | 1            |
| 10          | 54244 P     | Looper Holder Frame-----                   | 1            |
| 11          | 54244 E     | Bushing, left-----                         | 1            |
| 12          | 54244 F     | Bushing, right -----                       | 1            |
| 13          | 39173 A     | Looper Frame Locking Pin Spring-----       | 1            |
| 14          | 660-215     | Retaining Ring -----                       | 1            |
| 15          | 51242 L     | Thrust Washer -----                        | 2            |
| 16          | 54244 C     | Looper Holder Frame Throw-out Spring ----- | 1            |
| 17          | 54244 B     | Looper Thread Take-up Driving Arm -----    | 1            |
| 18          | 22519 C     | Screw -----                                | 1            |
| 19          | 54245 A     | Looper Thread Take-up Driving Link -----   | 1            |
| 19A         | 54223 A     | Looper Thread Take-up -----                | 1            |
| 20          | 51236 A     | Link Pin-----                              | 1            |
| 21          | 54244 K     | Spacing Collar -----                       | 1            |
| 22          | 51244 K     | Looper Rocker Shaft -----                  | 1            |
| 23 thru 78  |             | See Following Page                         |              |



# MAIN SHAFT, FEED DRIVING AND LOOPER DRIVING PARTS

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                                          | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|-----------------------------------------------------------------------------|----------------------|
| 1 thru 22           |                     | See Preceding Page                                                          |                      |
| 23                  | 54244 A             | Looper Travel Drive Link -----                                              | 1                    |
| 24                  | 18                  | Nut, for locking stud-----                                                  | 1                    |
| 25                  | 20                  | Washer-----                                                                 | 1                    |
| 26                  | 55244 G             | Locking Stud -----                                                          | 1                    |
| 27                  | 269                 | Nut, left thread -----                                                      | 1                    |
| 28                  | 20                  | Feed Crank Stud Washer -----                                                | 1                    |
| 29                  | 51236 E             | Feed Crank Link Assembly, for all machines<br>except 54200 G, 54400 G ----- | 1                    |
| 29A                 | 660-169             | Needle Bearing -----                                                        | 1                    |
| 30                  | 51236 D             | Feed Crank Link -----                                                       | 1                    |
| 31                  | 51236 F             | Feed Crank Link Ferrule-----                                                | 1                    |
| 32                  | 51054               | Feed Crank Link Pin -----                                                   | 1                    |
| 33                  | 666-149             | Oil Wick-----                                                               | 1                    |
| 37                  | 51236 G             | Feed Crank Stud-----                                                        | 1                    |
| 38                  | 51236 B             | Feed Crank Stud Cap-----                                                    | 1                    |
| 39                  | 22768               | Screw -----                                                                 | 2                    |
| 40                  | 82                  | Stitch Regulating Stud -----                                                | 1                    |
| 41                  | 54222               | Main Shaft -----                                                            | 1                    |
| 42                  | 29476 KR            | Feed Lift Eccentric Assembly -----                                          | 1                    |
| 43                  | 51406               | Eccentric, .062 inch throw -----                                            | 1                    |
| 44                  | 22894 D             | Screw -----                                                                 | 1                    |
| 45                  | 54245 C             | Eccentric Bearing -----                                                     | 1                    |
| 46                  | 51236 A             | Link Pin-----                                                               | 1                    |
| 47                  | 29133 J             | Take-up Drive Eccentric Assembly-----                                       | 1                    |
| 48                  | 22894 L             | Eccentric Spot Screw -----                                                  | 1                    |
| 49                  | 22894 C             | Eccentric Set Screw -----                                                   | 1                    |
| 50                  | 22768               | Screw -----                                                                 | 1                    |
| 51                  | 77                  | Screw -----                                                                 | 1                    |
| 52                  | 51235 A             | Feed Rocker Arm -----                                                       | 1                    |
| 53                  | 51235 G             | Washer-----                                                                 | 2                    |
| 54                  | 22519 C             | Screw -----                                                                 | 2                    |
| 55                  | 51235               | Feed Rocker -----                                                           | 1                    |
| 56                  | 98                  | Screw -----                                                                 | 2                    |
| 57                  | 482                 | Feed Rocker Shaft Collar-----                                               | 2                    |
| 58                  | 98                  | Screw -----                                                                 | 1                    |
| 59                  | 51134 C             | Feed Bar Shaft -----                                                        | 1                    |
| 60                  | 51134 P             | Lubricating Felt-----                                                       | 1                    |
| 61                  | 51134 R             | Lubricating Felt Guard-----                                                 | 1                    |
| 62                  | 8                   | Feed Rocker Shaft -----                                                     | 1                    |
| 63                  | 54234 B             | Feed Bar -----                                                              | 1                    |
| 64                  | 22560 B             | Screw -----                                                                 | 1                    |
| 65                  | 22733               | Screw -----                                                                 | 1                    |
| 67                  | 667 B-20            | Dowel Pin, for feed bar -----                                               | 1                    |
| 68                  | 88 F                | Screw, for feed bar-----                                                    | 1                    |
| 69                  | 531                 | Screw -----                                                                 | 1                    |
| 70                  | 77                  | Screw -----                                                                 | 1                    |
| 71                  | 54234 C             | Feed Bar Tilting Extension -----                                            | 1                    |
| 72                  | 54134 N             | Pin -----                                                                   | 1                    |
| 73                  | 22560 B             | Screw -----                                                                 | 2                    |
| 74                  |                     | Feed Dog (See pages 31, 33)-----                                            | 1                    |
| 75                  | HA61 D              | Screw -----                                                                 | 1                    |
| 76                  | 54243 A             | Looper Drive Eccentric Oil Slinger-----                                     | 1                    |
| 77                  | 54135               | Nut-----                                                                    | 1                    |
| 78                  | J 87 J              | Screw -----                                                                 | 1                    |

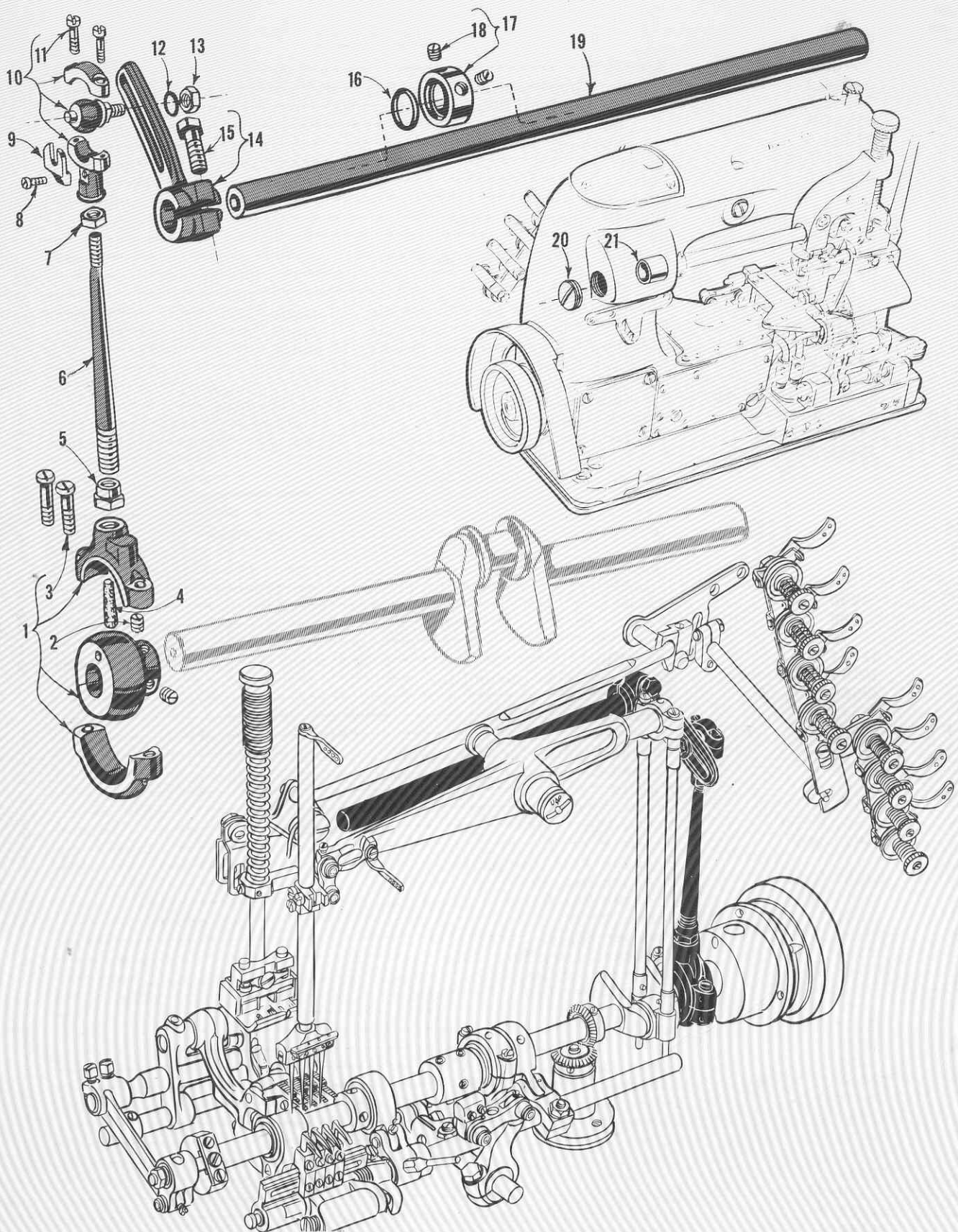






FOOT LIFTER AND RETAINER DRIVING PARTS

| Ref.<br>No. | Part<br>No.      | Description                                                        | Amt.<br>Req. |
|-------------|------------------|--------------------------------------------------------------------|--------------|
| 1           | 15489 B          | Screw -----                                                        | 1            |
| 2           | 54244 J          | Looper Throw-out Actuating Pin -----                               | 1            |
| 3           | 54242 C          | Retainer Holder Bearing, left -----                                | 1            |
| 4           | 61354 A          | Bushing, upper -----                                               | 1            |
| 5           | 51254 A          | Bushing, lower -----                                               | 1            |
| 6           | 667 B-12         | Dowel Pin -----                                                    | 2            |
| 7           | 22652 B-8        | Screw -----                                                        | 2            |
| 8           | 660-215          | Retaining Ring -----                                               | 1            |
| 9           | 54244 G          | Looper Throw-out Fork -----                                        | 1            |
| 10          | 22542 A          | Screw -----                                                        | 1            |
| 11          | 54242 D          | Retainer Holder Bearing, right -----                               | 1            |
| 12          | 61354 A          | Bushing -----                                                      | 1            |
| 13          | 667 B-12         | Dowel Pin -----                                                    | 1            |
| 14          | 54242 B-4-16     | Retainer Holder, for four needle, 16 gauge -----                   | 1            |
|             | 54242 B-4-21     | Retainer Holder, for four needle, 21 gauge -----                   | 1            |
|             | 54242 B-4-24     | Retainer Holder, for four needle, 24 gauge -----                   | 1            |
|             | 54242 B-4-32     | Retainer Holder, for four needle, 32 gauge -----                   | 1            |
| 14A         | K67664           | Retainer Holder, for four needle, 12-56-12 gauge -----             | 1            |
|             | 54242 B-16-64-16 | Retainer Holder, for four needle, 16-64-16 gauge -----             | 1            |
| 14B         | 54242 B-12-12    | Retainer Holder, for twelve needle, 12 gauge -----                 | 1            |
| 14C         | 54242 B-9-16     | Retainer Holder, for nine needle, 16 gauge -----                   | 1            |
| 15          | 22845 B          | Screw, for single needle machines -----                            | 1            |
|             |                  | Screw, for four needle machines -----                              | 4            |
|             |                  | Screw, for nine needle machines -----                              | 9            |
|             |                  | Screw, for twelve needle machines -----                            | 12           |
| 16          | 54211 A          | Retainer, marked "BF", for four needle machines -----              | 4            |
|             |                  | Retainer, for nine needle machines -----                           | 9            |
|             |                  | Retainer, for twelve needle machines -----                         | 12           |
|             |                  | Retainer, for single needle machines -----                         | 1            |
| 17          | 9650             | Connection -----                                                   | 1            |
| 18          | 88               | Screw -----                                                        | 2            |
| 19          | 78               | Screw -----                                                        | 1            |
| 20          | 51134 V          | Link Pin -----                                                     | 2            |
| 21          | HA54 A           | Retainer Drive Lever Link -----                                    | 1            |
| 22          | 22564            | Screw -----                                                        | 1            |
| 23          | 54242 E          | Retainer Drive Lever -----                                         | 1            |
| 24          | 22811 B          | Screw -----                                                        | 1            |
| 25          | 54259            | Thread Eyelet, for four needle machines -----                      | 1            |
| 25A         | 54459-12         | Thread Eyelet, for nine and twelve needle machines -----           | 1            |
| 26          | 41358            | Washer -----                                                       | 2            |
| 27          | J87 J            | Screw -----                                                        | 2            |
| 28          | 667 B-12         | Dowel Pin -----                                                    | 2            |
| 29          | 22652 B-8        | Screw -----                                                        | 2            |
| 30          |                  | Presser Foot (See pages 31, 33) -----                              | 1            |
| 31          | 51257 K          | Presser Bar -----                                                  | 1            |
| 32          | 51257 M          | Presser Bar Connection and Guide -----                             | 1            |
| 33          | 531              | Screw -----                                                        | 2            |
| 34          | 53787            | Presser Spring -----                                               | 1            |
| 35          | 56356            | Presser Spring Regulator -----                                     | 1            |
| 36          | 53783 S          | Lifter Lever Link, for machines with close coupled puller -----    | 2            |
|             | 53783 A          | Lifter Lever Link, for machines without close coupled puller ----- | 1            |
| 37          | 240              | Screw, for No. 53783 S -----                                       | 1            |
|             | 22758 C          | Screw, for No. 53783 A -----                                       | 1            |
| 38          | 22799 T          | Screw, for No. 53783 S -----                                       | 1            |
|             | 402              | Screw, for No. 53783 A -----                                       | 1            |
| 39          | 53783 L          | Lifter Lever Bell Crank -----                                      | 1            |
| 40          | 52883 S          | Lifter Lever Bell Crank Spring -----                               | 1            |
| 41          | 22557 B          | Screw -----                                                        | 1            |
| 42          | 53783 M          | Lifter Lever Connecting Rod -----                                  | 1            |
| 43          | 53783 N          | Foot Lifter Lever, internal -----                                  | 1            |
| 44          | 22537            | Screw -----                                                        | 1            |
| 45          | 660-207          | Oil Seal Ring -----                                                | 1            |
| 46          | 51283 H          | Foot Lifter and Tension Disc Release Lever -----                   | 1            |
| 47          | 21657 Y          | Tension Release and Foot Lifter Lever Connection -----             | 1            |
| 48          | 402              | Screw -----                                                        | 1            |
| 49          | 22596            | Screw -----                                                        | 1            |
| 50          | 21657 W          | Tension Release and Foot Lifter Lever Shaft -----                  | 1            |

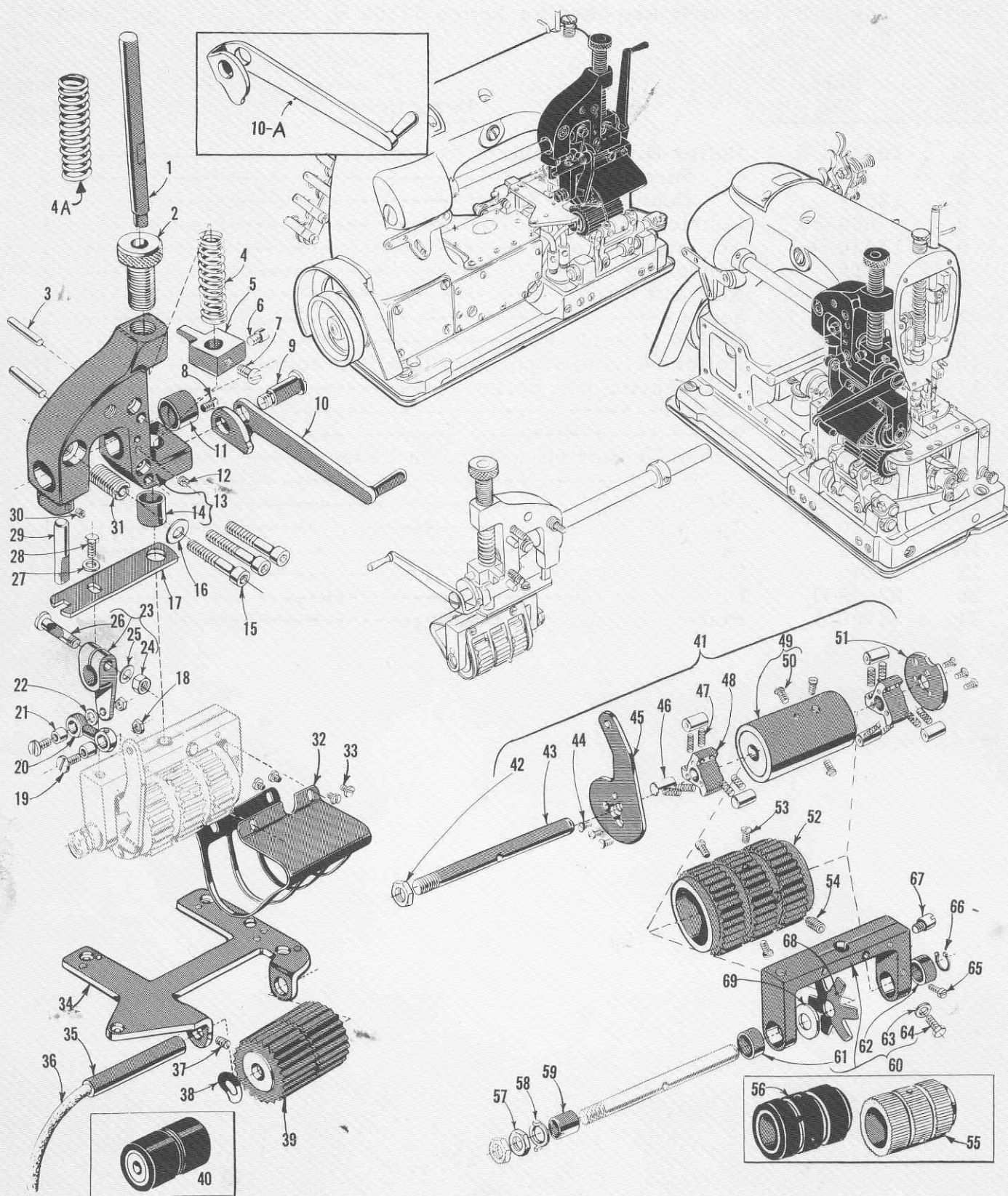




# PULLER DRIVING PARTS

NOTE: The following parts are used for Styles 54200 E, F, G, K, N, P, 54400 E, F, G, J only.

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                            | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|-----------------------------------------------|----------------------|
| 1                   | 29126 DE            | Puller Drive Eccentric Assembly -----         | 1                    |
| 2                   | 95                  | Screw -----                                   | 2                    |
| 3                   | 22587               | Bearing Cap Screw -----                       | 2                    |
| 4                   | 666-53              | Lubricating Felt-----                         | 1                    |
| 5                   | 15430 D             | Nut, right thread -----                       | 1                    |
| 6                   | 53716               | Connecting Rod-----                           | 1                    |
| 7                   | 269                 | Nut, left thread -----                        | 1                    |
| 8                   | 22747               | Screw -----                                   | 1                    |
| 9                   | 41255 B             | Ball Stud Guide Fork-----                     | 1                    |
| 10                  | 52854               | Puller Driving Connecting Rod Ball Joint----- | 1                    |
| 11                  | 97 A                | Bearing Cap Screw -----                       | 2                    |
| 12                  | 454 A               | Washer-----                                   | 1                    |
| 13                  | 258                 | Nut -----                                     | 1                    |
| 14                  | 53752               | Puller Driving Shaft Segment Lever -----      | 1                    |
| 15                  | 22811               | Screw -----                                   | 1                    |
| 16                  | 660-202             | Oil Seal Ring-----                            | 1                    |
| 17                  | 52849 C             | Thrust Collar-----                            | 1                    |
| 18                  | 95                  | Screw -----                                   | 2                    |
| 19                  | 54249               | Puller Driving Shaft -----                    | 1                    |
| 20                  | 22539 D             | Plug Screw -----                              | 1                    |
| 21                  | 53790 A             | Puller Driving Shaft Bushing-----             | 1                    |



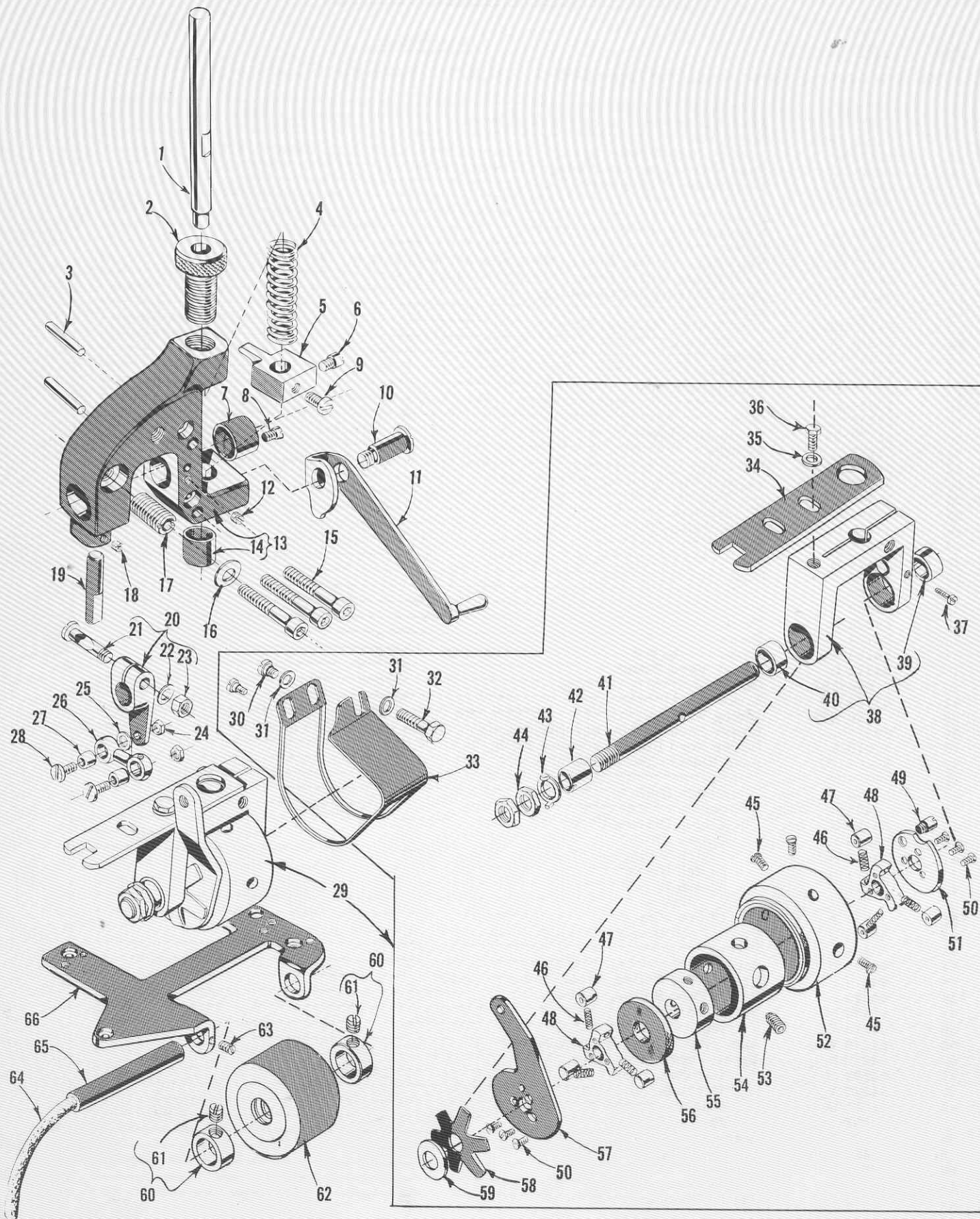


# FEED ROLLER AND PULLER CLUTCH PARTS

| Ref.<br>No.                                                                                  | Part<br>No. | Description                                                                     | Amt.<br>Req. |
|----------------------------------------------------------------------------------------------|-------------|---------------------------------------------------------------------------------|--------------|
| NOTE: The following parts are used for Styles 54200 E, F, G, K, N, P, 54400 E, F, G, J only. |             |                                                                                 |              |
| 1                                                                                            | 54277 J     | Feed Roller Presser Bar -----                                                   | 1            |
| 2                                                                                            | 54277 C     | Feed Roller Presser Spring Regulator -----                                      | 1            |
| 3                                                                                            | 667 D-24    | Dowel Pin -----                                                                 | 2            |
| 4                                                                                            | 54277 B     | Feed Roller Presser Spring, for Styles 54200 E, F, G, K, 54400 E, F, G, J ----- | 1            |
| 4A                                                                                           | 28633 L     | Feed Roller Presser Spring, for Styles 54200 N, P -----                         | 1            |
| 5                                                                                            | 54277 G     | Feed Roller Presser Bar Collar -----                                            | 1            |
| 6                                                                                            | 22845 C     | Screw -----                                                                     | 1            |
| 7                                                                                            | 22517       | Screw -----                                                                     | 1            |
| 8                                                                                            | 33174 B     | Stop Screw -----                                                                | 1            |
| 9                                                                                            | 22854 D     | Screw -----                                                                     | 1            |
| 10                                                                                           | 54277 K     | Feed Roller Lifter Lever, for Styles 54200 E, F, G, K, 54400 E, F, G, J -----   | 1            |
| 10A                                                                                          | 54277 L     | Feed Roller Lifter Lever, for Styles 54200 N, P -----                           | 1            |
| 11                                                                                           | 54249 B     | Clutch Driving Shaft Bushing, left -----                                        | 1            |
| 12                                                                                           | 89          | Screw -----                                                                     | 1            |
| 13                                                                                           | 54277 HA    | Feed Roller Mounting Bracket -----                                              | 1            |
| 14                                                                                           | 43245 N     | Bushing -----                                                                   | 3            |
| 15                                                                                           | 22653 D-24  | Screw -----                                                                     | 1            |
| 16                                                                                           | 43137 E     | Washer -----                                                                    | 1            |
| 17                                                                                           | 54278 T     | Feed Roller Yoke Guide -----                                                    | 2            |
| 18                                                                                           | 12934 A     | Nut -----                                                                       | 2            |
| 19                                                                                           | 22757       | Screw -----                                                                     | 1            |
| 20                                                                                           | 51770-56    | Connection Link -----                                                           | 2            |
| 21                                                                                           | 51771       | Ferrule -----                                                                   | 1            |
| 22                                                                                           | 54249 D     | Washer -----                                                                    | 1            |
| 23                                                                                           | 54249 C     | Clutch Driving Lever -----                                                      | 1            |
| 24                                                                                           | 55235 E     | Nut -----                                                                       | 1            |
| 25                                                                                           | 6042 A      | Washer -----                                                                    | 1            |
| 26                                                                                           | 55235 D     | Locking Stud -----                                                              | 1            |
| 27                                                                                           | 8372 A      | Washer -----                                                                    | 1            |
| 28                                                                                           | 22792 A     | Screw -----                                                                     | 1            |
| 29                                                                                           | 54278 B     | Guide Stud -----                                                                | 1            |
| 30                                                                                           | 89          | Screw -----                                                                     | 1            |
| 31                                                                                           | 22899       | Screw -----                                                                     | 1            |
| 32                                                                                           | 54278 X     | Feed Roller Guard -----                                                         | 4            |
| 33                                                                                           | 22704       | Screw -----                                                                     | 1            |
| 34                                                                                           | 54280 A     | Throat Plate and Lower Feed Roller Support -----                                | 1            |
| 35                                                                                           | 54276 L     | Lower Feed Roller Shaft -----                                                   | 1            |
| 36                                                                                           | 666-153     | Oil Wick -----                                                                  | 1            |
| 37                                                                                           | 22733       | Screw -----                                                                     | 1            |
| 38                                                                                           | 660-223     | Spring Washer -----                                                             | 1            |
| 39                                                                                           | 54276       | Lower Feed Roller, bakelite, on all machines except Style 54200 K -----         | 1            |
| 40                                                                                           | 54276 A     | Lower Feed Roller, rubber, for Style 54200 K -----                              | 1            |
| 41                                                                                           | 29476 GG    | Feed Roller Clutch Assembly -----                                               | 1            |
| 42                                                                                           | 11638 M     | Nut -----                                                                       | 1            |
| 43                                                                                           | 54274 G     | Clutch Shaft -----                                                              | 1            |
| 44                                                                                           | 605 A       | Screw -----                                                                     | 6            |
| 45                                                                                           | 54274 K     | Clutch Driving Lever -----                                                      | 1            |
| 46                                                                                           | 54274 L     | Roller -----                                                                    | 6            |
| 47                                                                                           | 29480 KP    | Clutch Spring and Wear Cap Assembly -----                                       | 12           |
| 48                                                                                           | 54274 H     | Clutch Disc -----                                                               | 2            |
| 49                                                                                           | 54274 F     | Clutch Barrel -----                                                             | 1            |
| 50                                                                                           | 538         | Screw -----                                                                     | 3            |
| 51                                                                                           | 54274 J     | Clutch Plate -----                                                              | 1            |
| 52                                                                                           | 54275 D     | Upper Feed Roller, bakelite, on all machines except Style 54200 K -----         | 1            |
| 53                                                                                           | 538         | Screw -----                                                                     | 3            |
| 54                                                                                           | 22894 H     | Screw -----                                                                     | 1            |
| 55                                                                                           | 54275 C     | Upper Feed Roller, steel, for Style 54200 K -----                               | 1            |
| *56                                                                                          | 54275 E     | Upper Feed Roller, rubber -----                                                 | 1            |
| 57                                                                                           | 11638 M     | Nut -----                                                                       | 1            |
| 58                                                                                           | 54278 Y     | Driving Washer -----                                                            | 1            |
| 59                                                                                           | 54278 W     | Feed Roller Yoke Bearing Sleeve -----                                           | 1            |
| 60                                                                                           | 54278 S     | Upper Feed Roller Yoke -----                                                    | 1            |
| 61                                                                                           | 54278 U     | Bushing, right -----                                                            | 1            |
| 62                                                                                           | 54278 V     | Bushing, left -----                                                             | 1            |
| 63                                                                                           | 51235 G     | Washer -----                                                                    | 1            |
| 64                                                                                           | T38         | Screw -----                                                                     | 1            |
| 65                                                                                           | 77 B        | Screw -----                                                                     | 1            |
| 66                                                                                           | 660-208     | Locking Ring -----                                                              | 1            |
| 67                                                                                           | 22892 D     | Screw -----                                                                     | 1            |
| 68                                                                                           | 54274 N     | Clutch Tension Spring -----                                                     | 1            |
| 69                                                                                           | 54274 P     | Thrust Washer -----                                                             | 1            |

\* Available as extra send and charge item.

NOTE: No. 54274 R - Brake Washer Spacer is required for rubber or steel rollers.

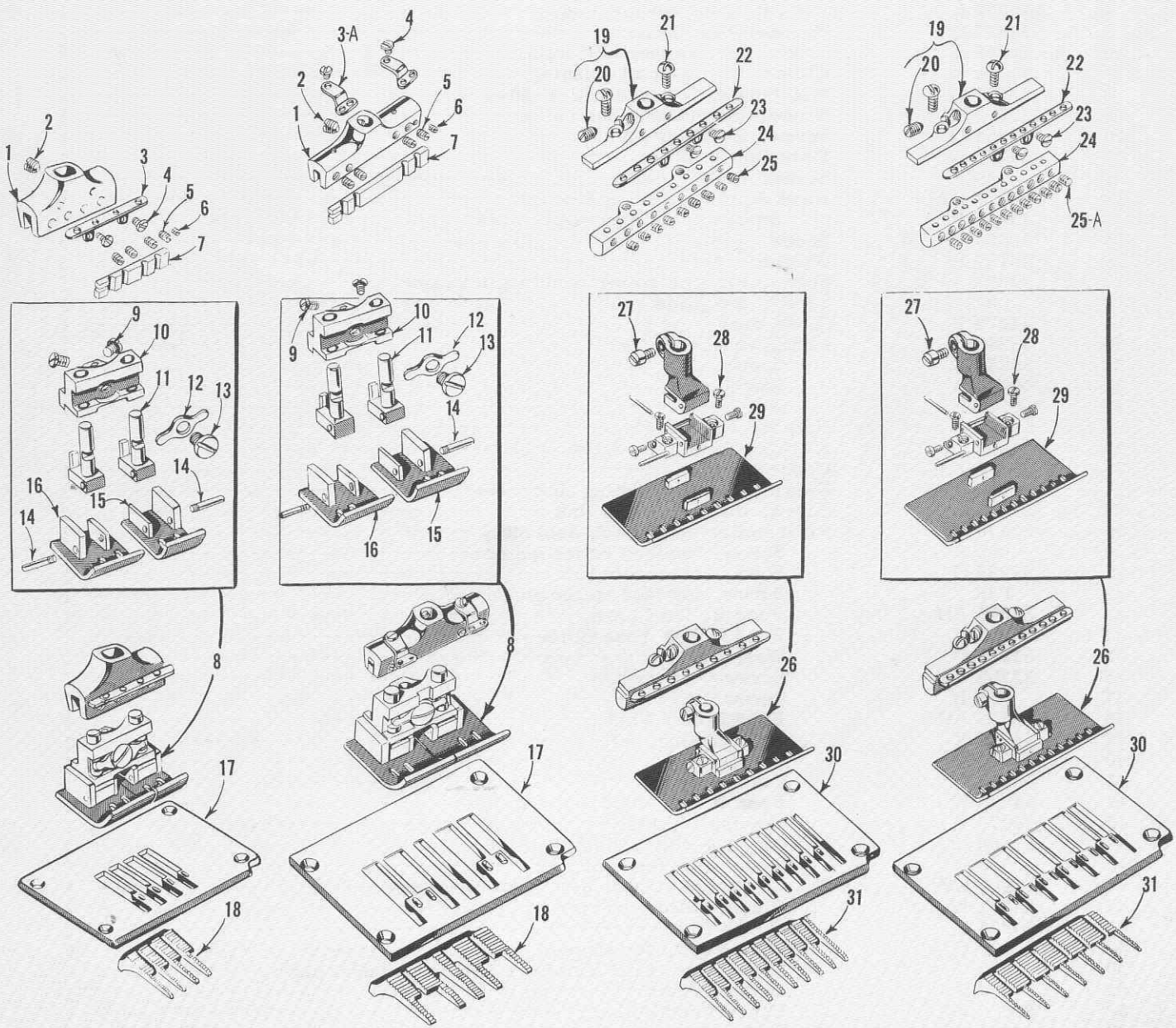




# FEED ROLLERS AND PULLER CLUTCH PARTS

| <u>Ref.<br/>No.</u>                                            | <u>Part<br/>No.</u> | <u>Description</u>                                     | <u>Amt.<br/>Req.</u> |
|----------------------------------------------------------------|---------------------|--------------------------------------------------------|----------------------|
| NOTE: The following parts are used for Styles 54200 N, P only. |                     |                                                        |                      |
| 1                                                              | 54277 J             | Feed Roller Presser Bar-----                           | 1                    |
| 2                                                              | 54277 C             | Presser Spring Regulating Screw-----                   | 1                    |
| 3                                                              | 667 D-24            | Dowel Pin-----                                         | 2                    |
| 4                                                              | 28633 L             | Feed Roller Presser Spring-----                        | 1                    |
| 5                                                              | 54277 G             | Presser Bar Collar-----                                | 1                    |
| 6                                                              | 22845 C             | Screw, for presser bar collar-----                     | 1                    |
| 7                                                              | 54249 B             | Clutch Driving Shaft Bushing, left-----                | 1                    |
| 8                                                              | 33174 B             | Stop Screw, for feed roller lifter lever-----          | 1                    |
| 9                                                              | 22517               | Screw, for presser bar collar-----                     | 1                    |
| 10                                                             | 22854 D             | Screw, for lifter lever-----                           | 1                    |
| 11                                                             | 54277 L             | Feed Roller Lifter Lever-----                          | 1                    |
| 12                                                             | 89                  | Screw, for left clutch driving shaft bushing-----      | 1                    |
| 13                                                             | 54277 HA            | Feed Roller Mounting Bracket-----                      | 1                    |
| 14                                                             | 43245 N             | Bushing, for feed roller presser bar-----              | 1                    |
| 15                                                             | 22653 CD-24         | Screw, for feed roller mounting bracket-----           | 3                    |
| 16                                                             | 43137 E             | Washer-----                                            | 1                    |
| 17                                                             | 22899               | Screw, for feed roller mounting bracket-----           | 1                    |
| 18                                                             | 89                  | Screw, for guide stud-----                             | 1                    |
| 19                                                             | 54278 B             | Guide Stud-----                                        | 1                    |
| 20                                                             | 54249 C             | Clutch Driving Lever-----                              | 1                    |
| 21                                                             | 55235 D             | Screw-----                                             | 1                    |
| 22                                                             | 6042 A              | Washer-----                                            | 1                    |
| 23                                                             | 55235 E             | Nut-----                                               | 1                    |
| 24                                                             | 12934 A             | Nut, for No. 22757-----                                | 2                    |
| 25                                                             | 54249 D             | Washer, for clutch drive lever-----                    | 1                    |
| 26                                                             | 51770-56            | Connecting Link-----                                   | 1                    |
| 27                                                             | 51771               | Ferrule, for connecting link-----                      | 2                    |
| 28                                                             | 22757               | Screw, for connecting link-----                        | 2                    |
| 29                                                             | 29476 MC            | Feed Roller and Clutch Assembly-----                   | 1                    |
| 30                                                             | 88 A                | Screw, for feed roller guard-----                      | 2                    |
| 31                                                             | 51235 G             | Washer-----                                            | 2                    |
| 32                                                             | T38                 | Screw, for feed roller guard-----                      | 1                    |
| 33                                                             | 54278 AD            | Feed Roller Guard-----                                 | 1                    |
| 34                                                             | 54278 T             | Feed Roller Yoke Guide-----                            | 1                    |
| 35                                                             | 51235 G             | Washer-----                                            | 1                    |
| 36                                                             | 22792 A             | Screw-----                                             | 1                    |
| 37                                                             | 77 B                | Screw-----                                             | 1                    |
| 38                                                             | 54278 AC            | Feed Roller Yoke-----                                  | 1                    |
| 39                                                             | 54278 V             | Bushing, left-----                                     | 1                    |
| 40                                                             | 54278 U             | Bushing, right-----                                    | 1                    |
| 41                                                             | 54274 U             | Clutch Shaft-----                                      | 1                    |
| 42                                                             | 54278 W             | Feed Roller Yoke Bearing Sleeve-----                   | 1                    |
| 43                                                             | 54278 Y             | Driving Washer-----                                    | 1                    |
| 44                                                             | 11638 M             | Nut, for clutch shaft-----                             | 2                    |
| 45                                                             | 538                 | Screw, for feed roller-----                            | 3                    |
| 46                                                             | 29480 KP            | Clutch Spring and Wear Cap Assembly-----               | 6                    |
| 47                                                             | 54274 W             | Clutch Roller-----                                     | 6                    |
| 48                                                             | 54274 T             | Clutch Disc-----                                       | 2                    |
| 49                                                             | 22892 C             | Stop Screw, for support plate-----                     | 1                    |
| 50                                                             | 605                 | Screw, for clutch driving lever and support plate----- | 6                    |
| 51                                                             | 54274 J             | Support Plate-----                                     | 1                    |
| 52                                                             | 54275 M             | Upper Feed Roller-----                                 | 1                    |
| 53                                                             | 22894 H             | Spot Screw, for upper feed roller-----                 | 1                    |
| 54                                                             | 51-297 Blk.         | Clutch Barrel-----                                     | 1                    |
| 55                                                             | 51-298 Blk.         | Clutch Barrel Core-----                                | 1                    |
| 56                                                             | 54274 X             | Clutch Brake Disc-----                                 | 1                    |
| 57                                                             | 54274 V             | Clutch Lever-----                                      | 1                    |
| 58                                                             | 54274 N             | Tension Spring-----                                    | 1                    |
| 59                                                             | 61351 C             | Washer-----                                            | 1                    |
| 60                                                             | 482                 | Collar, for lower puller roller shaft-----             | 2                    |
| 61                                                             | 98                  | Screw-----                                             | 1                    |
| 62                                                             | 54276 X             | Puller Roller, lower-----                              | 1                    |
| 63                                                             | 22733               | Screw, for puller roller shaft, lower-----             | 1                    |
| 64                                                             | 666-153             | Oil Wick-----                                          | 1                    |
| 65                                                             | 54276 L             | Puller Roller Shaft, lower-----                        | 1                    |
| 66                                                             | 54280 A             | Throat Plate Support-----                              | 1                    |





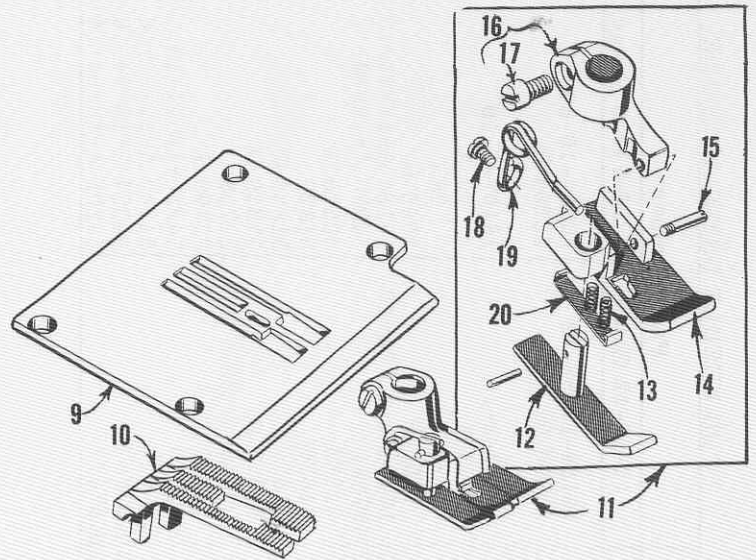
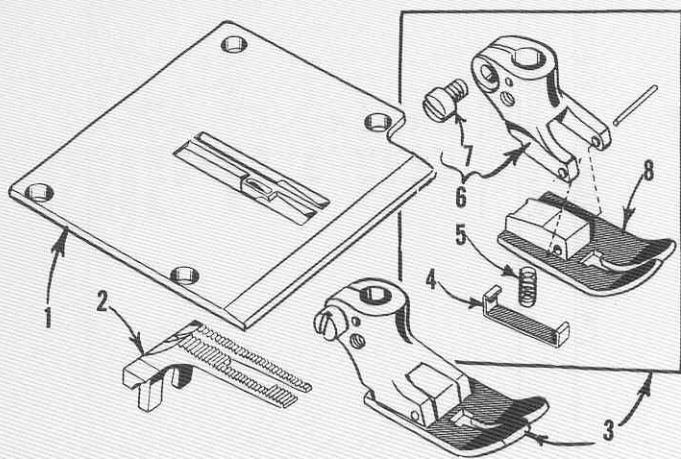
# SEWING PART COMBINATIONS FOR STYLES 54200 A, C, E, F, G, K, 54400 A, C, E, F, G

| FOUR NEEDLE EQUAL SPACE |                      |      |              |              |              | FOUR NEEDLE UNEQUAL SPACE |              |              |                  |                  |
|-------------------------|----------------------|------|--------------|--------------|--------------|---------------------------|--------------|--------------|------------------|------------------|
| Ref. No.                | Description          | Amt. | 1/4          | 5/16         | 3/8          | Part Number               | 24 Gauge     | 32 Gauge     | 12-56-12 Gauge   | 16-64-16 Gauge   |
| 1                       | Needle Holder        | 1    | 54218-4-16   | 54218-4-21   | 54218-4-24   | 54218-4-32                | 54218-4-32   | 54218-4-32   | 16154-12-56-12   | 16154-16-64-16   |
| 2                       | Screw                | 1    | 22894 P      | 22894 P      | 22894 P      | 22894 P                   | 22894 P      | 22894 P      | 22894 P          | 22894 P          |
| 3                       | Needle Holder Eyelet | 1    | 16197-4-16   | 16197-4-20   | 16197-4-24   | 54458 D-4-32              |              |              |                  |                  |
| 3A                      | Needle Holder Eyelet | 2    |              |              |              |                           |              |              | 16197-2-16       | 16197-2-16       |
| 4                       | Screw                | 2    | 73 A         | 73 A         | 73 A         | 73 A                      | 73 A         | 73 A         | 73 A             | 73 A             |
| 5                       | Screw                | 4    | 28 C         | 28 C         | 28 C         | 28 C                      | 28 C         | 28 C         | 28 C             | 28 C             |
| 6                       | Screw                | 1    | 1096 B       | 1096 B       | 1096 B       | 1096 B                    | 1096 B       | 1096 B       | 1096 B           | 1096 B           |
| 7                       | Needle Seat Block    | 1    | 54218 A-4-16 | 54218 A-4-21 | 54218 A-4-24 | 54218 A-4-32              | 54218 A-4-32 | 54218 A-4-32 | 16184 A-12-56-12 | 16184 A-16-64-16 |
| 8                       | Presser Foot         | 1    | 54220 A-4-16 | 54220 A-4-21 | 54220 A-4-24 | 54220 A-4-32              | 54220 A-4-32 | 54220 A-4-32 | 54220 A-16-64-16 | 54220 A-16-64-16 |
| 9                       | Screw                | 2    | 22570 A      | 22570 A      | 22570 A      | 22570 A                   | 22570 A      | 22570 A      | 22570 A          | 22570 A          |
| 10                      | Shank                | 1    | 51830        | 51830        | 51830        | 51830                     | 51830        | 51830        | 51830            | 51830            |
| 11                      | Plunger              | 2    | 51830 C      | 51830 C      | 51830 C      | 51830 C                   | 51830 C      | 51830 C      | 51830 C          | 51830 C          |
| 12                      | Equalizer            | 1    | 51830 D      | 51830 D      | 51830 D      | 51830 D                   | 51830 D      | 51830 D      | 51830 D          | 51830 D          |
| 13                      | Screw                | 1    | 22758        | 22758        | 22758        | 22758                     | 22758        | 22758        | 22758            | 22758            |
| 14                      | Screw                | 2    | 22799 S      | 22799 S      | 22799 S      | 22799 S                   | 22799 S      | 22799 S      | 22799 S          | 22799 S          |
| 15                      | Bottom, right        | 1    | 54230-16     | 54230-21     | 54230-24     | 54230-32                  | 54230-32     | 54230-32     | K67660           | 54230-16-64-16   |
| 16                      | Bottom, left         | 1    | 54230 A-16   | 54230 A-21   | 54230 A-24   | 54230 A-32                | 54230 A-32   | 54230 A-32   | K67659           | 54230 A-16-64-16 |
| 17                      | Throat Plate         | 1    | 54224 A-4-16 | 54224 A-21   | 54224 A-24   | 54224 A-32                | 54224 A-32   | 54224 A-32   | K67663           | 54224 A-16-64-16 |
| 18                      | Feed Dog             | 1    | 54205 A-4-16 | 54226 A-4-21 | 54205 A-4-24 | 54205 A-4-32              | 54205 A-4-32 | 54205 A-4-32 | K67662           | 54205 A-16-64-16 |

# SEWING PART COMBINATIONS FOR STYLES 54400 H, J

| NINE NEEDLE EQUAL SPACE |                      |      |              |              |              | TWELVE NEEDLE EQUAL SPACE |              |              |              |
|-------------------------|----------------------|------|--------------|--------------|--------------|---------------------------|--------------|--------------|--------------|
| Ref. No.                | Description          | Amt. | 16 Gauge     | 12 Gauge     | 10 Gauge     | Part Number               | 12 Gauge     | 10 Gauge     | 8 Gauge      |
| 19                      | Needle Stop Plate    | 1    | 54418 A      | 54418 A      | 54418 A      | 54418 A                   | 54418 A      | 54418 A      | 54418 A      |
| 20                      | Screw                | 1    | 22764 A      | 22764 A      | 22764 A      | 22764 A                   | 22764 A      | 22764 A      | 22764 A      |
| 21                      | Screw                | 2    | 22849        | 22849        | 22849        | 22849                     | 22849        | 22849        | 22849        |
| 22                      | Needle Holder Eyelet | 1    | 54458 C-9    | 54458 C-9    | 54458 C-9    | 54458 C-9                 | 54458 C-9    | 54458 C-9    | 54458 C-9    |
| 23                      | Screw                | 2    | 73 A         | 73 A         | 73 A         | 73 A                      | 73 A         | 73 A         | 73 A         |
| 24                      | Needle Holder        | 1    | 54418-9-16   | 54418-9-16   | 54418-9-16   | 54418-9-16                | 54418-9-16   | 54418-9-16   | 54418-9-16   |
| 25                      | Screw                | 9    | 28 C         | 28 C         | 28 C         | 28 C                      | 28 C         | 28 C         | 28 C         |
| 25A                     | Screw                | 12   | 54420-9-16   | 54420-9-16   | 54420-9-16   | 54420-9-16                | 54420-9-16   | 54420-9-16   | 54420-9-16   |
| 26                      | Presser Foot         | 1    | 91           | 91           | 91           | 91                        | 91           | 91           | 91           |
| 27                      | Screw                | 1    | 605 A        | 605 A        | 605 A        | 605 A                     | 605 A        | 605 A        | 605 A        |
| 28                      | Screw                | 4    | 54430-9-16   | 54430-9-16   | 54430-9-16   | 54430-9-16                | 54430-9-16   | 54430-9-16   | 54430-9-16   |
| 29                      | Bottom               | 1    | 54224 A-9-16 | 54224 A-9-16 | 54224 A-9-16 | 54224 A-9-16              | 54224 A-9-16 | 54224 A-9-16 | 54224 A-9-16 |
| 30                      | Throat Plate         | 1    | 54205 A-9-16 | 54205 A-9-16 | 54205 A-9-16 | 54205 A-9-16              | 54205 A-9-16 | 54205 A-9-16 | 54205 A-9-16 |
| 31                      | Feed Dog             | 1    |              |              |              |                           |              |              |              |

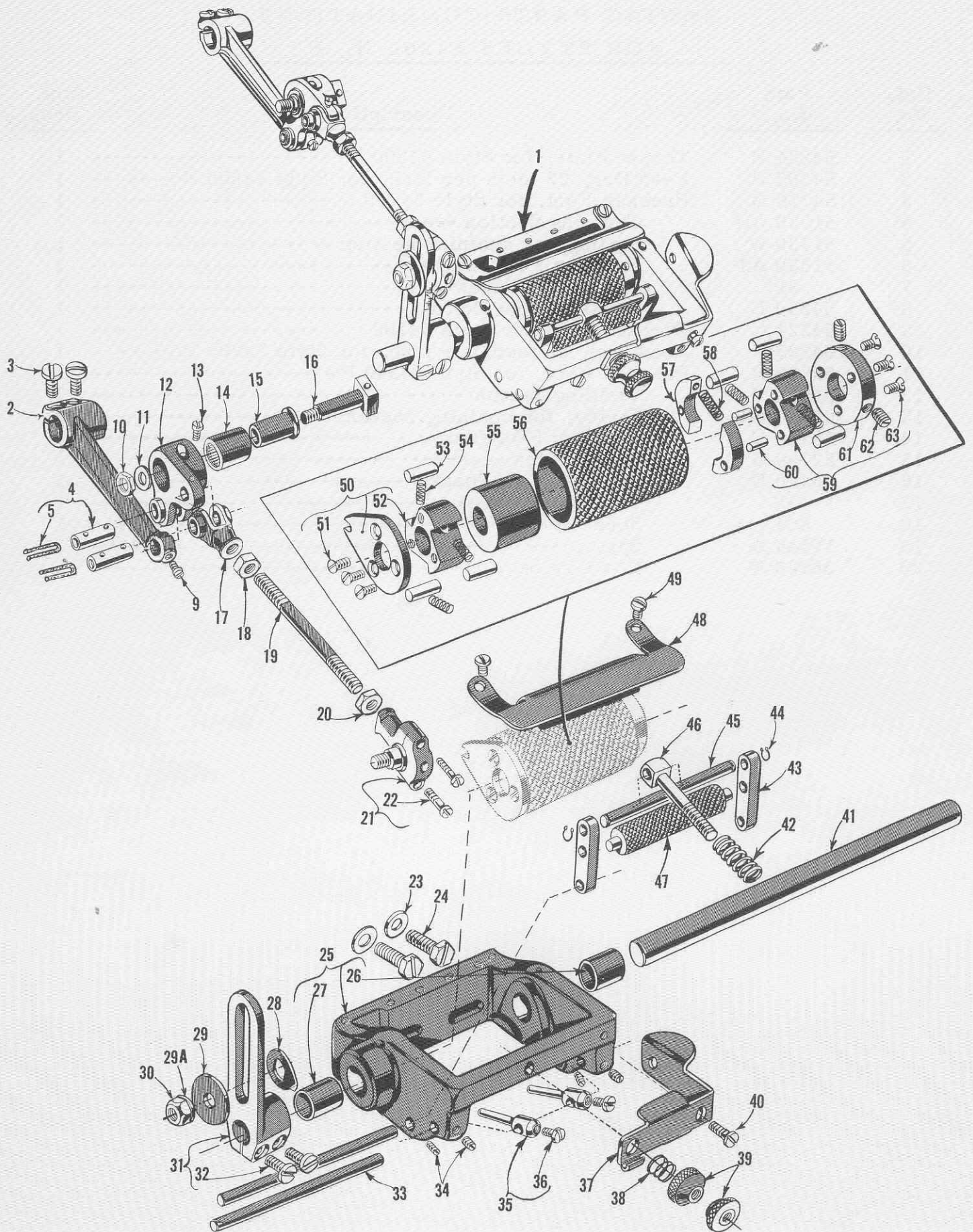






SEWING PARTS COMBINATIONS  
FOR STYLES 54200 N, P

| Ref.<br>No. | Part<br>No. | Description                                          | Amt.<br>Req. |
|-------------|-------------|------------------------------------------------------|--------------|
| 1           | 54224 B     | Throat Plate, for Style 54200 N -----                | 1            |
| 2           | 54205 B     | Feed Dog, 22 teeth per inch, for Style 54200 N ----- | 1            |
| 3           | 54220 B     | Presser Foot, for Style 54200 N -----                | 1            |
| 4           | 51330 AH    | Chaining Section -----                               | 1            |
| 5           | 51330 W     | Spring, for chaining section -----                   | 1            |
| 6           | 51330 AJ    | Presser Foot Shank-----                              | 1            |
| 7           | 91          | Clamp Screw-----                                     | 1            |
| 8           | 54230 E     | Presser Foot Bottom -----                            | 1            |
| 9           | 54224 C     | Throat Plate, for Style 54200 P -----                | 1            |
| 10          | 54205 C     | Feed Dog, 22 teeth per inch, for Style 54200 P ----- | 1            |
| 11          | 56320 R     | Presser Foot, for Style 54200 P -----                | 1            |
| 12          | 51230 N     | Yielding Section -----                               | 1            |
| 13          | 61430 BT    | Spring, for chaining section -----                   | 2            |
| 14          | 56330 C     | Presser Foot Bottom -----                            | 1            |
| 15          | 22799 G     | Hinge Screw -----                                    | 1            |
| 16          | 56330 D     | Presser Foot Shank-----                              | 1            |
| 17          | 91          | Clamp Screw-----                                     | 1            |
| 18          | 604         | Screw -----                                          | 1            |
| 19          | 19146 A     | Spring-----                                          | 1            |
| 20          | 56330 B     | Chaining Section-----                                | 1            |



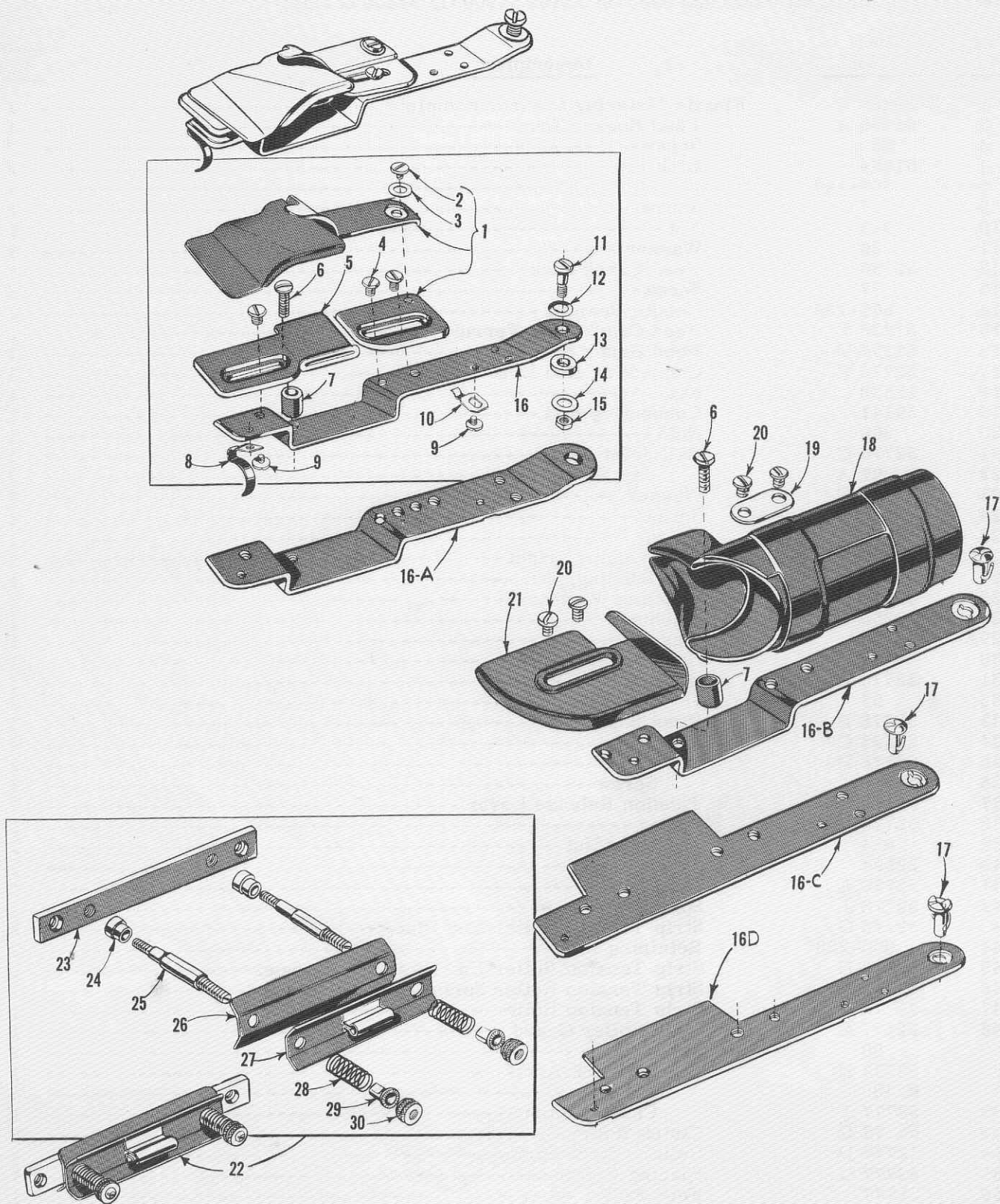


# ELASTIC METERING DEVICE

NOTE: The following parts are used on Styles 54200 G, 54400 G only.

| Ref.<br>No. | Part<br>No. | Description                                       | Amt.<br>Req. |
|-------------|-------------|---------------------------------------------------|--------------|
| 1           | 29486 F     | Elastic Metering Device, complete -----           | 1            |
| 2           | 51235 A     | Feed Rocker Arm -----                             | 1            |
| 3           | 93          | Screw -----                                       | 2            |
| 4           | 51054       | Link Pin -----                                    | 2            |
| 5           | 666-149     | Oil Wick -----                                    | 1            |
| 9           | 77          | Screw -----                                       | 1            |
| 10          | 269         | Nut -----                                         | 1            |
| 11          | 20          | Washer -----                                      | 1            |
| 12          | 52736       | Feed Crank Link -----                             | 1            |
| 13          | 77          | Screw -----                                       | 1            |
| 14          | 660-169     | Needle Bearing -----                              | 1            |
| 15          | 51236 F     | Feed Crank Link Ferrule -----                     | 1            |
| 16          | 51236 G     | Feed Crank Stud -----                             | 1            |
| 17          | 52776 F     | Connecting Rod Link -----                         | 1            |
| 18          | 12538       | Nut -----                                         | 1            |
| 19          | 39141       | Connecting Rod -----                              | 1            |
| 20          | 269         | Nut -----                                         | 1            |
| 21          | 52776 C     | Ball Joint -----                                  | 1            |
| 22          | 97 A        | Cap Screw -----                                   | 2            |
| 23          | 21657 E     | Washer -----                                      | 2            |
| 24          | 627 A       | Screw -----                                       | 2            |
| 25          | 52776       | Frame -----                                       | 1            |
| 26          | 80692       | Bushing, right -----                              | 1            |
| 27          | 80662       | Bushing, left -----                               | 1            |
| 28          | 52776 E     | Indicator Washer -----                            | 1            |
| 29          | 39258 C     | Washer -----                                      | 1            |
| 29A         | 20          | Washer -----                                      | 1            |
| 30          | 18          | Nut -----                                         | 1            |
| 31          | 52776 B     | Driving Arm -----                                 | 1            |
| 32          | 93          | Screw -----                                       | 2            |
| 33          | 52778 B     | Pivot Shaft -----                                 | 2            |
| 34          | 22565 C     | Screw -----                                       | 4            |
| 35          | 52778 D     | Guide -----                                       | 2            |
| 36          | 22562       | Screw -----                                       | 1            |
| 37          | 52778 L     | Tension Release Lever -----                       | 1            |
| 38          | 52778 M     | Spring -----                                      | 1            |
| 39          | 434         | Adjusting Nut -----                               | 2            |
| 40          | 22594       | Screw -----                                       | 1            |
| 41          | 52776 A     | Shaft -----                                       | 1            |
| 42          | 52778 J     | Spring -----                                      | 1            |
| 43          | 52778 G     | Strip Tension Roller End Plate -----              | 2            |
| 44          | 660-228     | Retaining Ring -----                              | 2            |
| 45          | 52778 H     | Strip Tension Roller End Plate Shaft, upper ----- | 1            |
| 46          | 52778 K     | Strip Tension Roller Spring Stud -----            | 1            |
| 47          | 52778 F     | Strip Tension Roller -----                        | 1            |
| 48          | 52777 K     | Feed Roller Guard -----                           | 1            |
| 49          | 90          | Screw -----                                       | 2            |
| 50          | 52777 H     | Check Clutch Arm -----                            | 1            |
| 51          | 22589       | Screw -----                                       | 3            |
| 52          | 52777 J     | Check Clutch -----                                | 1            |
| 53          | 52777 C     | Clutch Roller -----                               | 6            |
| 54          | 52777 D     | Roller Clutch Spring -----                        | 6            |
| 55          | 52777 G     | Spacing Collar -----                              | 1            |
| 56          | 52777       | Feed Roller -----                                 | 1            |
| 57          | 52777 E     | Brake Shoe -----                                  | 2            |
| 58          | 52777 F     | Brake Shoe Spring -----                           | 1            |
| 59          | 52777 A     | Driving Clutch -----                              | 1            |
| 60          | 51280 J     | Dowel Pin -----                                   | 2            |
| 61          | 52777 B     | Clutch Driving Collar -----                       | 1            |
| 62          | 531         | Screw -----                                       | 2            |
| 63          | 22589       | Screw -----                                       | 3            |

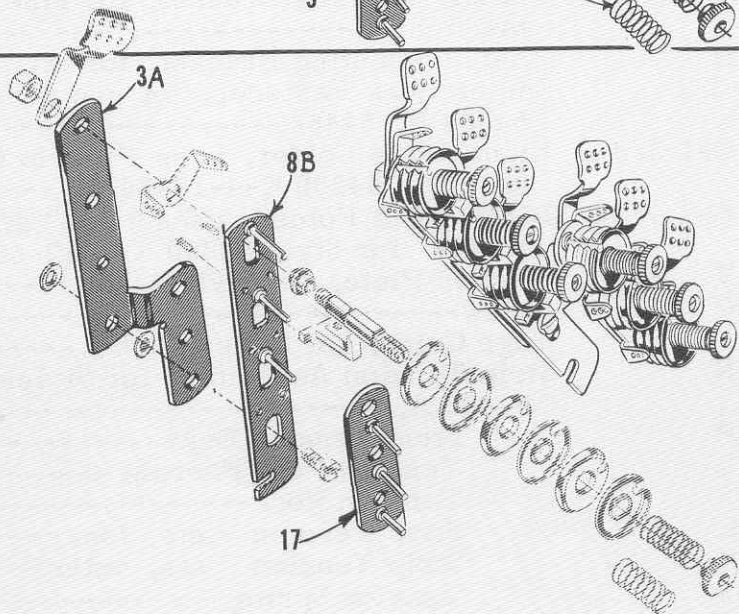
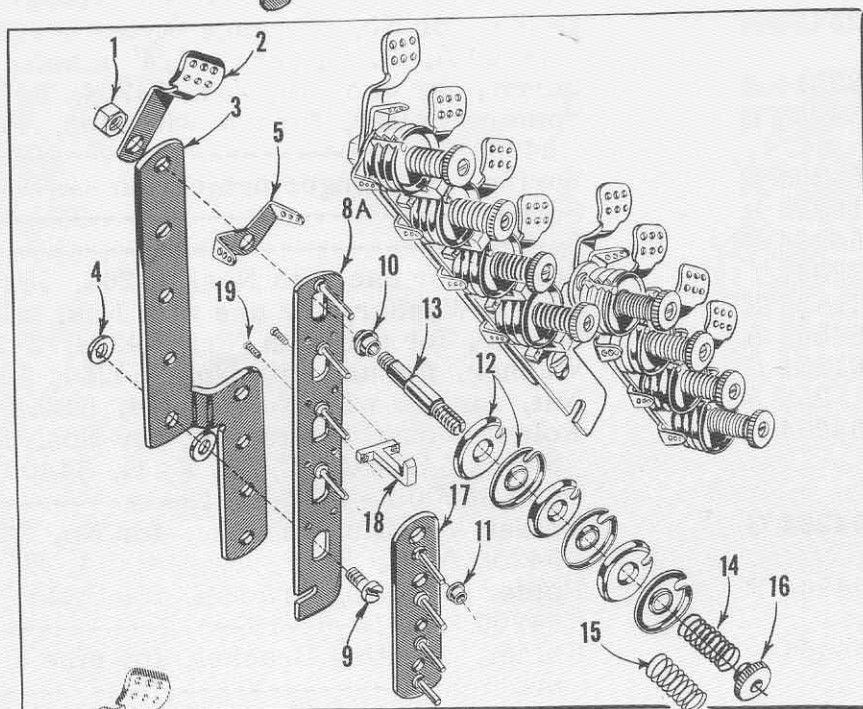
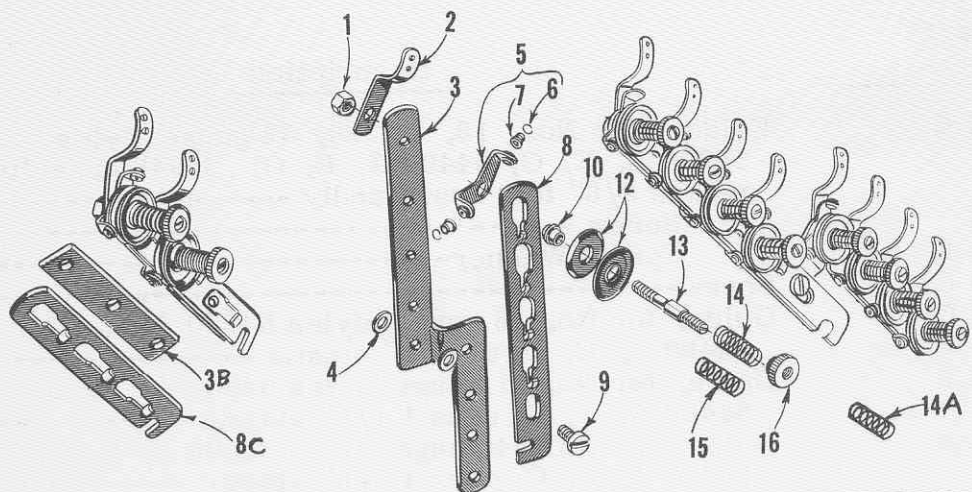




# ATTACHMENTS

| Ref.<br>No. | Part<br>No.    | Description                                                                                                                            | Amt.<br>Req. |
|-------------|----------------|----------------------------------------------------------------------------------------------------------------------------------------|--------------|
| 1           | 23405 R        | Folder, for Nos. 16, 21, 24, 32 gauge Styles<br>54200 A, E, G, 54400 A, E, G; .5/64" capacity,<br>makes 3/8" fold downwardly -----     | 1            |
| 2           | 22726          | Screw -----                                                                                                                            | 1            |
| 3           | 12957 E        | Spring Washer-----                                                                                                                     | 1            |
| 4           | 25 C           | Screw-----                                                                                                                             | 3            |
| 5           | 23404 G        | Guide, for No. 16 gauge Styles 54200 A, E, G,<br>54400 A, E, G; uses 1" elastic -----                                                  | 1            |
|             | 23404 F        | Guide, for No. 21 gauge Styles 54200 A, E, G,<br>54400 A, E, G; uses 1 1/4" elastic -----                                              | 1            |
|             | 23404 H        | Guide, for No. 24 gauge Styles 54200 A, E, G,<br>54400 A, E, G; uses 1 3/8" elastic -----                                              | 1            |
|             | 23404 K        | Guide, for No. 32 gauge Styles 54200 A, E, G,<br>54400 A, E, G; uses 1 3/4" elastic -----                                              | 1            |
| 6           | 22514 A        | Screw, for use with Nos. 54264, 54264 F, 54264 G --                                                                                    | 1            |
| 7           | 54264 D        | Spacing Collar, for use with Nos. 54264, 54264 F,<br>54264 G-----                                                                      | 1            |
| 8           | 54264 C        | Spring, with finger projection -----                                                                                                   | 1            |
| 9           | 12986 B        | Screw-----                                                                                                                             | 2            |
| 10          | 54264 B        | Spring -----                                                                                                                           | 1            |
| 11          | 22854          | Screw, for use with Nos. 54264, 54264 G -----                                                                                          | 1            |
| 12          | HA86 B         | Spring Washer, for use with Nos. 54264, 54264 G ---                                                                                    | 1            |
| 13          | 54264 A        | Spacer, for use with Nos. 54264, 54264 G -----                                                                                         | 1            |
| 14          | 61351 C        | Washer, for use with Nos. 54264, 54264 G -----                                                                                         | 1            |
| 15          | 258 A          | Nut, for use with Nos. 54264, 54264 G -----                                                                                            | 1            |
| 16          | 54264          | Folder Mounting Bracket, for Nos. 16, 21, 24 gauge<br>Styles 54200 A, C, E, F, G, 54400 A, C, E, F, G,<br>and 54200 K-4-12-56-12 ----- | 1            |
| 16A         | 54264 G        | Folder Mounting Bracket, for No. 32 gauge Styles<br>54200 A, C, E, F, G, 54400 A, C, E, F, G-----                                      | 1            |
| 16B         | 54264 F        | Folder Mounting Bracket, for Style<br>54200 K-4-16-64-16-----                                                                          | 1            |
| 16C         | 54464          | Folder Mounting Bracket, for nine and twelve needle<br>machines -----                                                                  | 1            |
| 16D         | 54264 H        | Folder Mounting Bracket, for Styles 54200 N, P-----                                                                                    | 1            |
| 17          | 660-237        | Spring Lock Fastener, for use with Nos. 54264 F,<br>54264 H, 54464-----                                                                | 1            |
| 18          | 23360 G-1 5/8  | Right Angle Folder, uses 4" strip finishes 1 5/8"<br>for Style 54200 K-4-16-64-16 -----                                                | 1            |
|             | 23360 G-1 7/16 | Right Angle Folder, uses 3 1/2" strip, finishes<br>1 7/16" for Style 54200 K-4-12-56-12 -----                                          | 1            |
| 19          | 23425 V        | Washer Plate, for Style 54200 K -----                                                                                                  | 1            |
| 20          | 25 C           | Screw-----                                                                                                                             | 4            |
| 21          | 23404 J        | Edge Guide, for Style 54200 K -----                                                                                                    | 1            |
| 22          | 21182 N        | Strip Tension Assembly, for Styles 54200 A, E,<br>54400 A, E-----                                                                      | 1            |
| 23          | 21182 P        | Strip Tension Base-----                                                                                                                | 1            |
| 24          | 16164          | Tension Post Ferrule -----                                                                                                             | 2            |
| 25          | 1346           | Tension Post -----                                                                                                                     | 2            |
| 26          | 21182 L        | Strip Tension Plate, inner -----                                                                                                       | 1            |
| 27          | 21182 K        | Strip Tension Plate, outer -----                                                                                                       | 1            |
| 28          | 110-3          | Tension Spring -----                                                                                                                   | 2            |
| 29          | 107            | Tension Spring Ferrule-----                                                                                                            | 2            |
| 30          | 108            | Tension Nut -----                                                                                                                      | 2            |

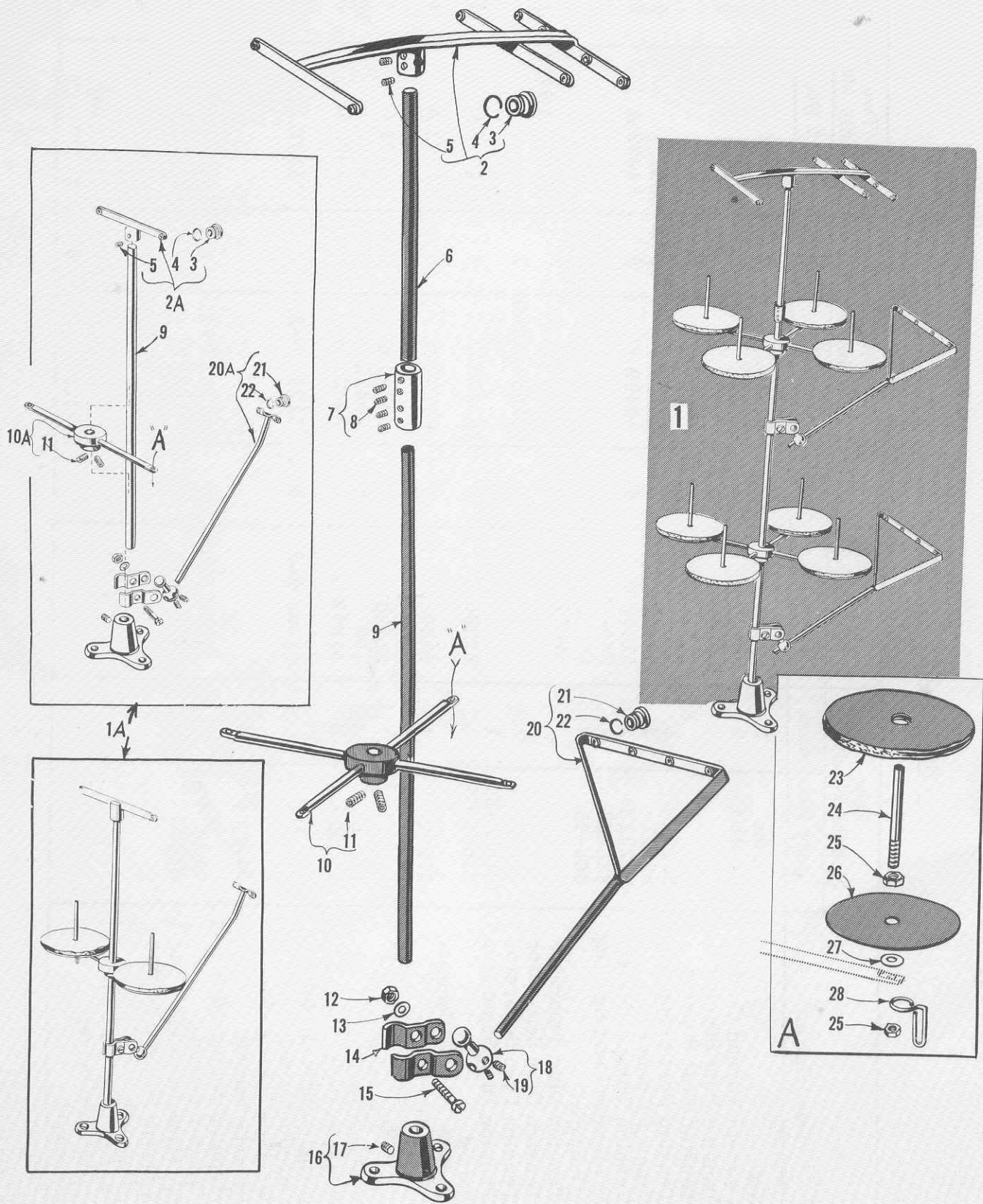






THREAD TENSION PARTS

| Ref. No. | Description                          | One Needle Machine |      | Four Needle Machine |      | Nine Needle Machine |      | Twelve Needle Machine |      |
|----------|--------------------------------------|--------------------|------|---------------------|------|---------------------|------|-----------------------|------|
|          |                                      | Part No.           | Amt. | Part No.            | Amt. | Part No.            | Amt. | Part No.              | Amt. |
| 1        | Nut                                  | 43266              | 1    | 43266               | 7    | 43266               | 5    | 43266                 | 7    |
| 2        | Lead-in Thread Guide                 | 51491 C            | 2    | 51491 C             | 8    | 54491               | 6    | 54491                 | 8    |
| 3        | Tension Post Support                 |                    |      | 51892               | 1    |                     |      | 51892                 | 1    |
| 3A       | Tension Post Support                 |                    |      |                     |      | 51992 A             | 1    |                       |      |
| 3B       | Tension Post Support                 |                    |      |                     |      |                     |      |                       |      |
| 4        | Spacing Washer                       | 52892              | 1    | 80557               | 2    | 80557               | 2    | 80557                 | 2    |
| 5        | Tension Thread Eyelet                | 51292 D            | 2    | 51292 D             | 8    | 54492 A             | 6    | 54492 A               | 8    |
| 6        | Eyelet Locking Ring                  | 668-28             | 2    | 668-28              | 2    |                     |      |                       |      |
| 7        | Eyelet                               | 668-25             | 2    | 668-25              | 2    |                     |      |                       |      |
| 8        | Tension Disc Separator               |                    |      | 21657 AA-4          | 1    |                     |      | 21657 AB-12           | 1    |
| 8A       | Tension Disc Separator               |                    |      |                     |      | 21657 AB-9          | 1    |                       |      |
| 8B       | Tension Disc Separator               |                    |      |                     |      |                     |      |                       |      |
| 8C       | Tension Disc Separator               |                    |      |                     |      |                     |      |                       |      |
| 9        | Screw                                | 21657-3            | 1    |                     |      | 22598 C             | 1    | 22598 C               | 1    |
| 10       | Needle Thread Tension Post Ferrule   | 22598 C            | 1    | 22598 C             | 1    |                     |      |                       |      |
| 11       | Looper Thread Tension Post Ferrule   | 51292 A            | 1    | 51292 A             | 4    | 51292 A             | 3    | 51292 A               | 4    |
| 12       | Tension Disc                         | 51292 A            | 1    | 51292 A             | 4    | 54492 C             | 3    | 54492 C               | 4    |
| 13       | Tension Post                         | 109                | 4    | 109                 | 16   | 54492               | 36   | 54492                 | 48   |
| 14       | Tension Spring, for needle thread    | 51292 G            | 2    | 51292 G             | 8    | 54492 B             | 6    | 54492 B               | 8    |
| 14A      | Tension Spring, for needle thread    |                    |      | 51292 F-5           | 4    | 51292 F-5           | 3    | 51292 F-5             | 4    |
| 15       | Tension Spring, for looper thread    | 51292 F-8          | 1    |                     |      |                     |      |                       |      |
| 16       | Tension Regulating Nut               | 51292 F-2          | 1    | 51292 F-2           | 4    | 51292 F-1           | 3    | 51292 F-1             | 4    |
| 17       | Looper Thread Tension Support        | 51292 C            | 2    | 51292 C             | 8    | 51292 C             | 6    | 51292 C               | 8    |
| 18       | Needle Thread Tension Release Finger |                    |      |                     |      | 54492 D             | 1    | 54492 E               | 1    |
| 19       | Screw                                |                    |      |                     |      | 21657 AC            | 3    | 21657 AC              | 4    |
|          |                                      |                    |      |                     |      | 22738               | 6    | 22738                 | 8    |





# THREAD STAND PARTS

NOTE: The following thread stand parts are furnished with all Styles in Class 54200 and 54400, except the nine and twelve needle machines, for which no thread stands are available.

| Ref.<br>No. | Part<br>No. | Description                                                                 | Amt.<br>Req. |
|-------------|-------------|-----------------------------------------------------------------------------|--------------|
| 1           | 21101 P-8   | Thread Stand, complete for all styles except<br>54200 N, P, 54400 H, J----- | 1            |
| 1A          | 21101 H-2   | Thread Stand, complete, for Styles 54200 N, P ----                          | 1            |
| 2           | 21114 H-4   | Eyelet Support, for No. 21101 P-8 -----                                     | 1            |
| 2A          | 21114 H-2   | Eyelet Support, for No. 21101 H-2 -----                                     | 1            |
| 3           | 21114 L     | Eyelet-----                                                                 | 2 or 8       |
| 4           | 21114 M     | Eyelet Locking Ring-----                                                    | 2 or 8       |
| 5           | 22651 CD-4  | Screw -----                                                                 | 1 or 2       |
| 6           | 21104 B-11  | Thread Stand Rod, upper, for No. 21101 P-8 --                               | 1            |
| 7           | 21127       | Coupling, for No. 21101 P-8-----                                            | 1            |
| 8           | 22651 CD-3  | Screw -----                                                                 | 4            |
| 9           | 21104 B-24  | Thread Stand Rod-----                                                       | 1            |
| 10          | 21114 D-4   | Spool Seat Support, for No. 21101 P-8 -----                                 | 2            |
| 10A         | 21114 D-2   | Spool Seat Support, for No. 21101 H-2 -----                                 | 1            |
| 11          | 22651 CD-5  | Screw -----                                                                 | 2            |
| 12          | 21104 H     | Nut-----                                                                    | 1 or 2       |
| 13          | 652-16      | Washer -----                                                                | 1 or 2       |
| 14          | 21114 U     | Lead Eyelet Ball Split Socket-----                                          | 2 or 4       |
| 15          | 22810       | Screw -----                                                                 | 1 or 2       |
| 16          | 21114 A     | Base -----                                                                  | 1            |
| 17          | 22651 CD-5  | Screw -----                                                                 | 1            |
| 18          | 21114 T     | Lead Eyelet Socket Ball -----                                               | 1 or 2       |
| 19          | 22651 CD-4  | Screw -----                                                                 | 2            |
| 20          | 21114 S-4   | Lead Eyelet, for No. 21101 P-8-----                                         | 2            |
| 20A         | 21114 S-2   | Lead Eyelet, for No. 21101 H-2-----                                         | 1            |
| 21          | 21114 L     | Eyelet-----                                                                 | 2 or 4       |
| 22          | 21114 M     | Eyelet Locking Ring-----                                                    | 2 or 4       |
| 23          | 21104 V     | Pad -----                                                                   | 2 or 8       |
| 24          | 21114 W     | Spool Pin -----                                                             | 2 or 8       |
| 25          | 258 A       | Nut-----                                                                    | 4 or 16      |
| 26          | 21114       | Spool Seat Disc-----                                                        | 2 or 8       |
| 27          | 652-16      | Washer -----                                                                | 2 or 8       |
| 28          | 21114 AF    | Eyelet, for No. 21101 P-8-----                                              | 4            |



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