

TEMPORARY

DESCANIBADO



SERIES

PARTS LIST

 **Union Special**
Finest Quality Industrial Sewing Equipment

20 folhas

 - ORIGINAL

This temporary illustrated parts list represents the basic single needle, plain feed machine.... plus additional component mechanisms incorporated in the multi-needle, differential feed, coverstitch and puller type machines.

Illustrations and parts lists shown are depicted as of April, 1987. Changes in design may incorporate part number changes or changes in illustrations.

TEMPORARY

PARTS LIST

for

600 SERIES

First Edition

Copyright 1987

By

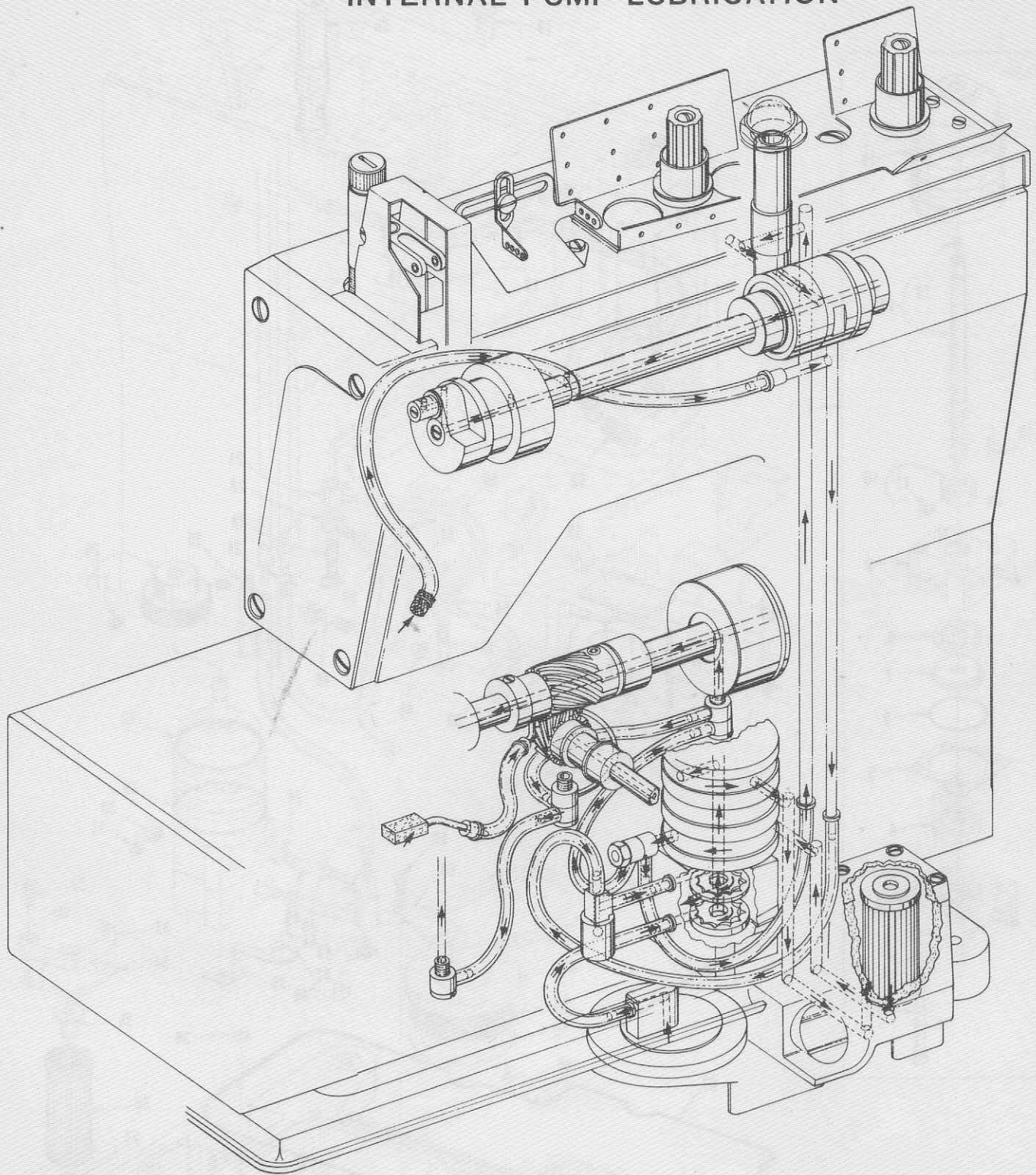
Union Special Corporation

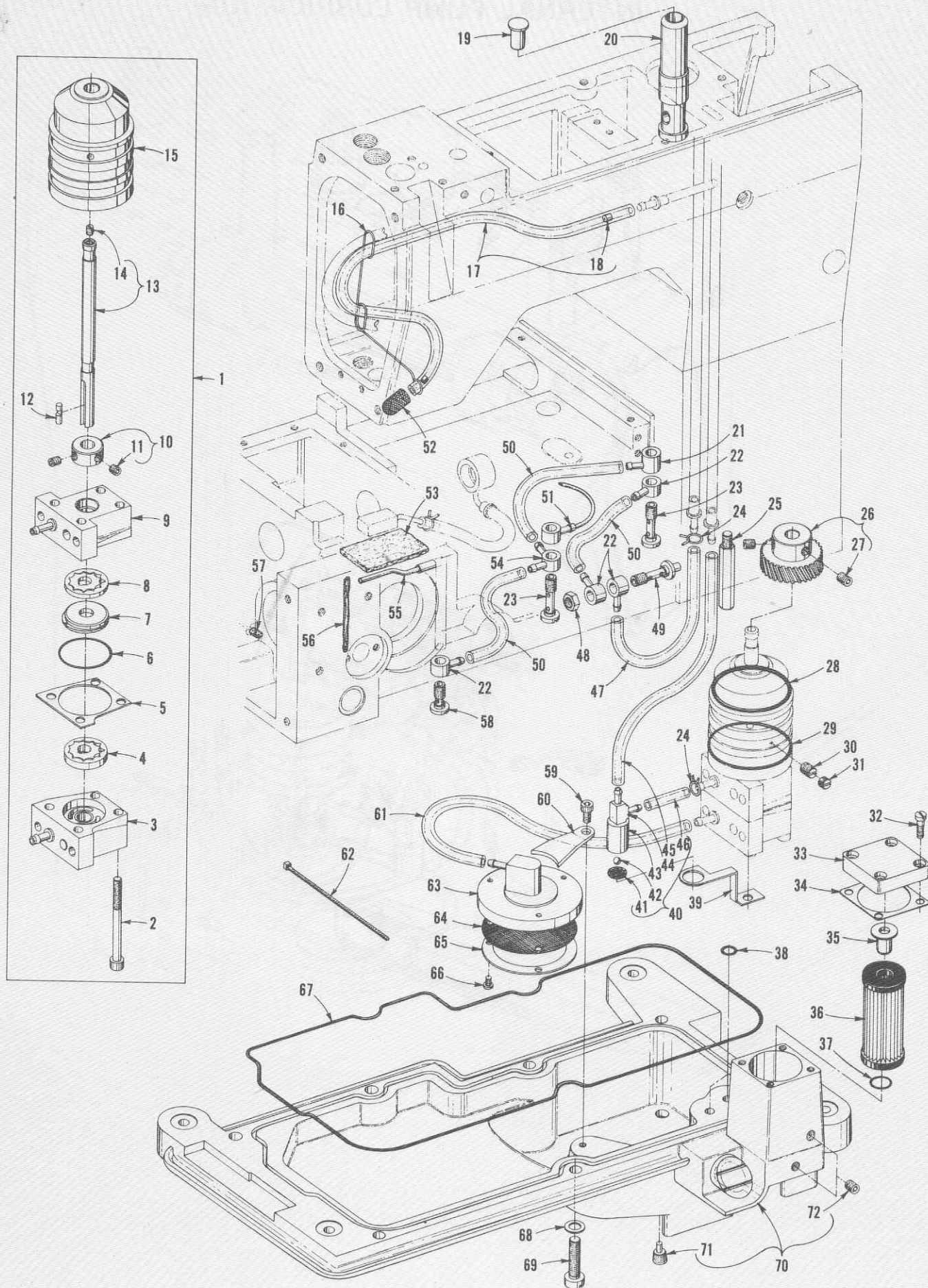
Rights Reserved In All Countries

Printed in U.S.A.

April, 1987

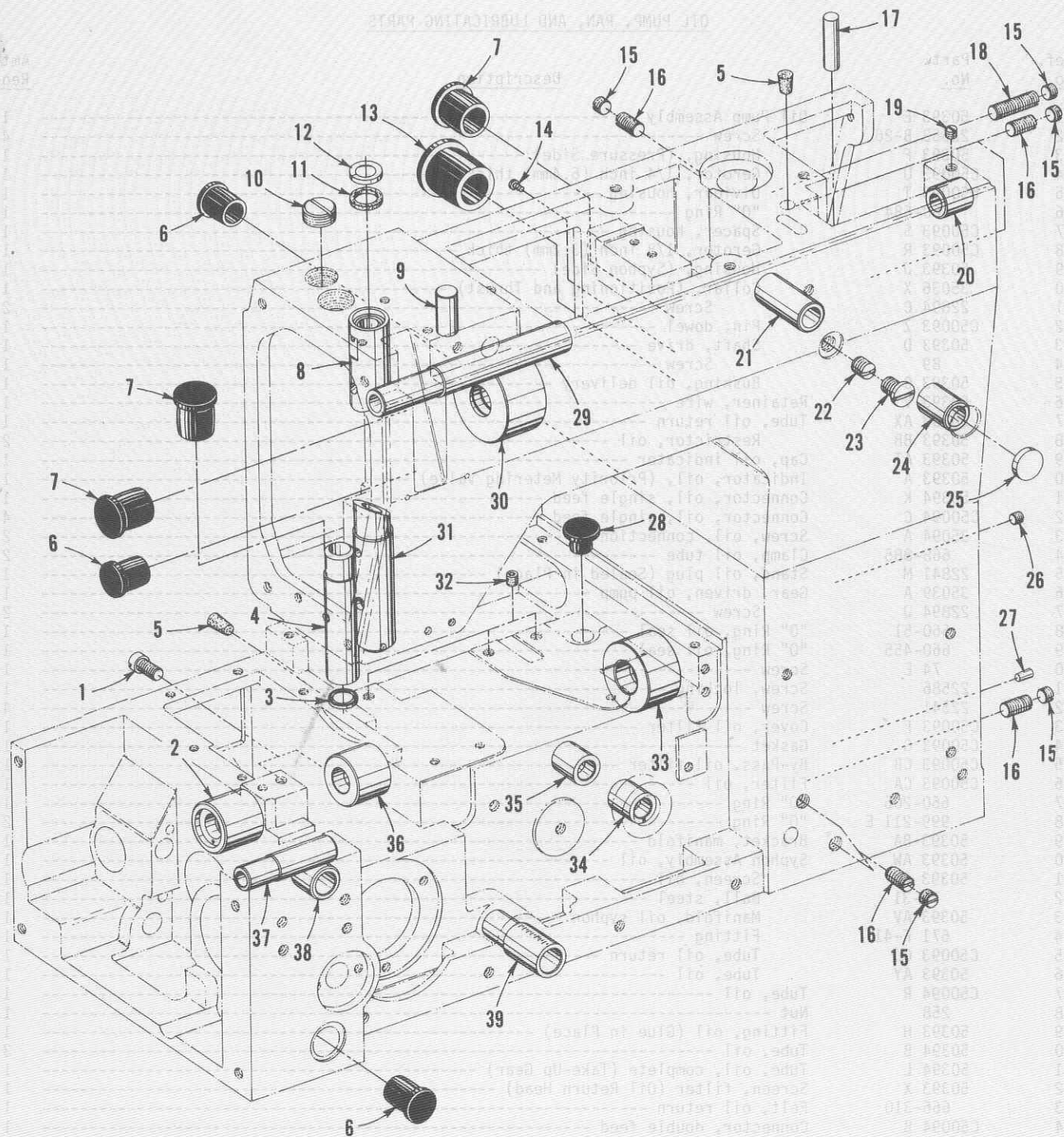
INTERNAL PUMP LUBRICATION





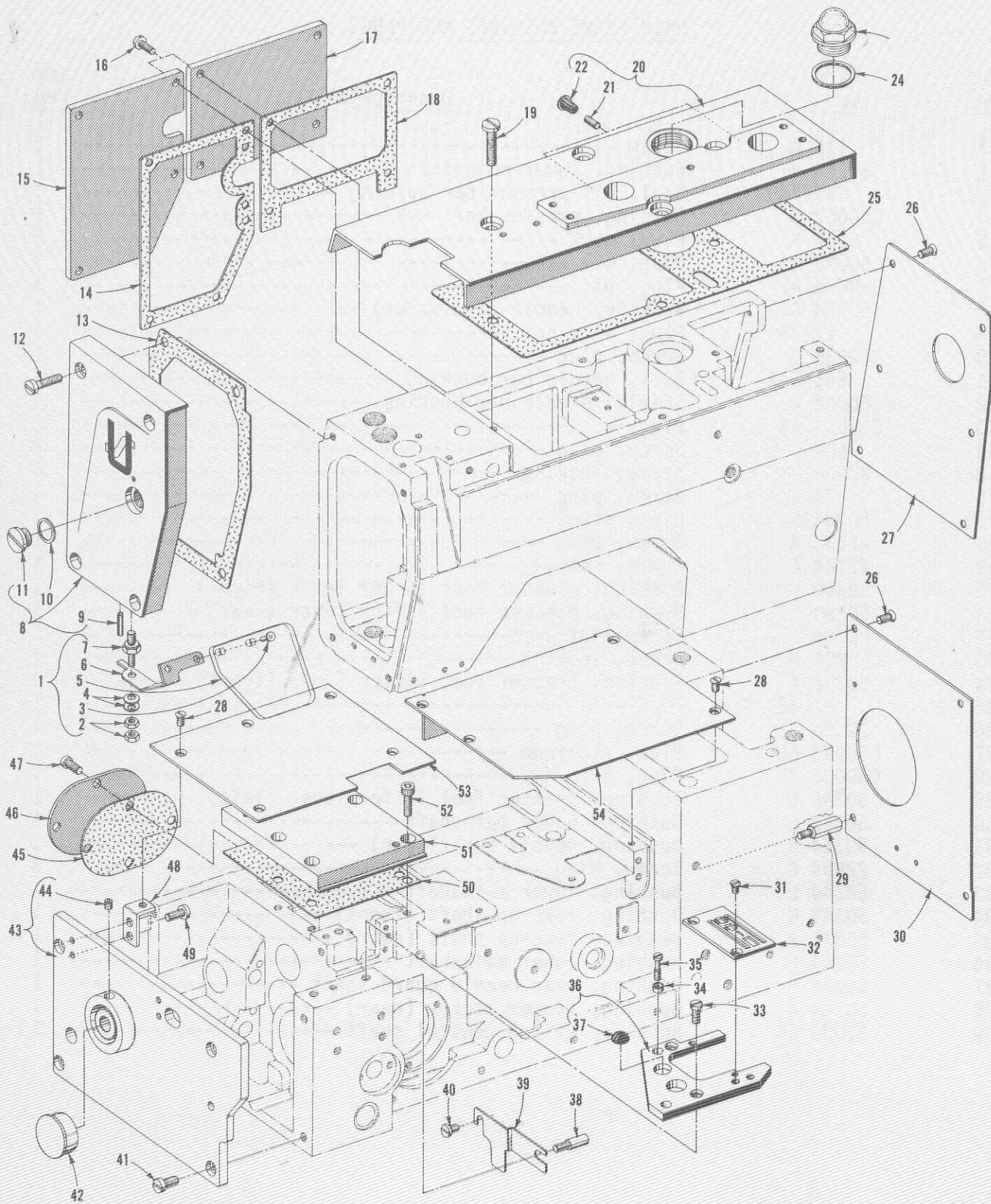
OIL PUMP, PAN, AND LUBRICATING PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	50393 E	Oil Pump Assembly -----	1
2	22653 B-26	Screw -----	4
3	50393 F	Housing, (Pressure Side) -----	1
4	C50093 U	Gerotor, 1/4 inch (6.4mm) thick -----	1
5	C50093 T	Divider, housing -----	1
6	660-684	"O" Ring -----	1
7	C50093 S	Spacer, housing -----	1
8	C50093 R	Gerotor, 1/8 inch (3.2mm) thick -----	1
9	50393 J	Housing, (Syphon Side) -----	1
10	35036 X	Collar, (Positioning and Thrust) -----	1
11	22894 C	Screw -----	2
12	C50093 Z	Pin, dowel -----	1
13	50393 D	Shaft, drive -----	1
14	89	Screw -----	1
15	50393 C	Bushing, oil delivery -----	1
16	50393 V	Retainer, wire -----	1
17	50393 AX	Tube, oil return -----	1
18	50393 BB	Restrictor, oil -----	2
19	50393 AT	Cap, oil indicator -----	1
20	50393 A	Indicator, oil, (Priority Metering Valve) -----	1
21	50394 K	Connector, oil, single feed -----	1
22	C50094 C	Connector, oil, single feed -----	4
23	35094 A	Screw, oil, connection -----	2
24	668-885	Clamp, oil tube -----	2
25	22841 M	Stand, oil plug (Sealed in Place) -----	1
26	35039 A	Gear, driven, oil pump -----	1
27	22894 J	Screw -----	2
28	660-51	"O" Ring, oil seal -----	1
29	660-455	"O" Ring, oil seal -----	1
30	74 E	Screw -----	1
31	22586	Screw, locking -----	1
32	22541	Screw -----	4
33	C50093 F	Cover, oil filter -----	1
34	C50093 G	Gasket -----	1
35	C50093 CB	By-Pass, oil filter -----	1
36	C50093 CA	Filter, oil -----	1
37	660-206	"O" Ring -----	1
38	999-211 E	"O" Ring -----	2
39	50393 BA	Bracket, manifold -----	1
40	50393 AW	Syphon Assembly, oil -----	1
41	50393 AU	Screen, oil -----	1
42	79-31	Ball, steel -----	1
43	50393 AV	Manifold, oil syphon -----	1
44	671 F-41	Fitting -----	1
45	C50093 CJ	Tube, oil return -----	1
46	50393 AY	Tube, oil -----	1
47	C50094 R	Tube, oil -----	1
48	258	Nut -----	1
49	50393 H	Fitting, oil (Glue in Place) -----	1
50	50394 B	Tube, oil -----	3
51	50394 L	Tube, oil, complete (Take-Up Gear) -----	1
52	50393 X	Screen, filter (Oil Return Head) -----	1
53	666-310	Felt, oil return -----	1
54	C50094 B	Connector, double feed -----	1
55	50394 G	Tube, oil (Looper Rocker) -----	1
56	WO-3	Yarn, Columbia, rear needle guard bushing (8 strands)-----	1
57	C50094 AK	Plug, felt, oil return -----	1
58	22720 A	Screw, oil connection -----	1
59	22652 A-4	Screw -----	1
60	50393 AR	Clamp, oil screen housing -----	1
61	C50094 Y	Tube, oil -----	1
62	670 E-2	Tie, cable, to secure Ref. No. 45 to Ref. No. 22 -----	1
63	35093 F	Housing, screen -----	1
64	35093 H	Screen -----	1
65	35093 J	Plate, retaining -----	1
66	97	Screw -----	3
67	50382 B	Gasket, oil pan -----	1
68	6042 A	Washer -----	7
69	820	Screw -----	7
70	50393 N	Pan, oil -----	1
71	22571 E	Screw, oil drain plug -----	1



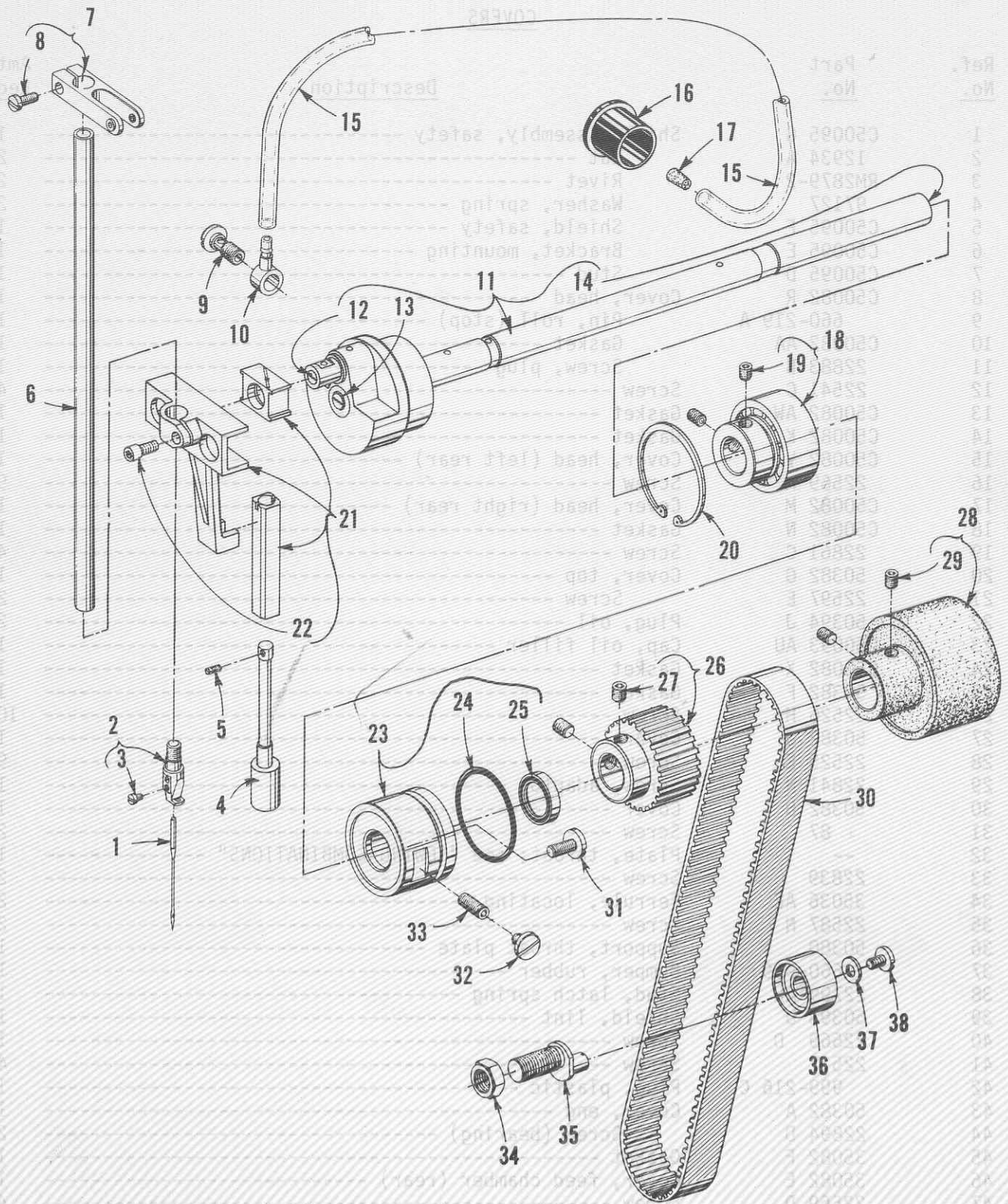
MAIN FRAME BUSHINGS AND PLUGS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	136 A	Screw -----	2
2	50344 K	Bushing, lower mainshaft -----	1
3	660-739	Seal, oil presser bar bushing -----	1
4	C50057 D	Bushing, presser bar -----	1
5	C067 B	Plug, cork -----	2
6	C50093 CT	Plug, oil -----	3
7	C50093 AY	Plug, oil -----	3
8	50354 C	Bushing, needle bar (upper) -----	1
9	51-794 BLK.	Plug, aluminum -----	1
10	22539 G	Screw, plug -----	1
11	666-311	Felt, needle bar bushing -----	1
12	C50054 D	Shield, needle bar bushing -----	1
13	C50093 AX	Plug, oil -----	1
14	604	Screw, plug -----	2
15	22586	Screw, locking -----	5
16	74 E	Screw, plug -----	4
17	50394 S	Plug, steel -----	1
18	22533 A	Screw, plug -----	1
19	22764 C	Screw, set -----	1
20	50390 C	Bushing, presser foot lifter lever (right) -----	1
21	50390	Bushing, presser foot lifter lever (rear) -----	1
22	22706 C	Screw, set -----	1
23	C50055 H	Screw, locking -----	1
24	50390 A	Bushing, presser foot lifter lever (front) -----	1
25	51-627 BLK.	Plug -----	1
26	22565	Screw, plug -----	1
27	C50093 CN	Plug, aluminum -----	1
28	C50035 Z	Plug, oil -----	1
29	50390 D	Bushing, presser foot lifter lever (left) -----	1
30	50355 L	Bushing, upper mainshaft -----	1
31	50354 B	Bushing, needle bar (lower) -----	1
32	22894 C	Screw, plug -----	3
33	50344 L	Bushing, lower mainshaft -----	1
34	50344 G	Bushing, take-up shaft (front) -----	1
35	50344 F	Bushing, take-up shaft (rear) -----	1
36	50344 B	Bushing, lower mainshaft -----	1
37	50368 B	Bushing, rear needle guard shaft -----	1
38	50344 E	Bushing, looper rocker (rear) -----	1
39	35036 AB	Bushing, stitch control shaft -----	1



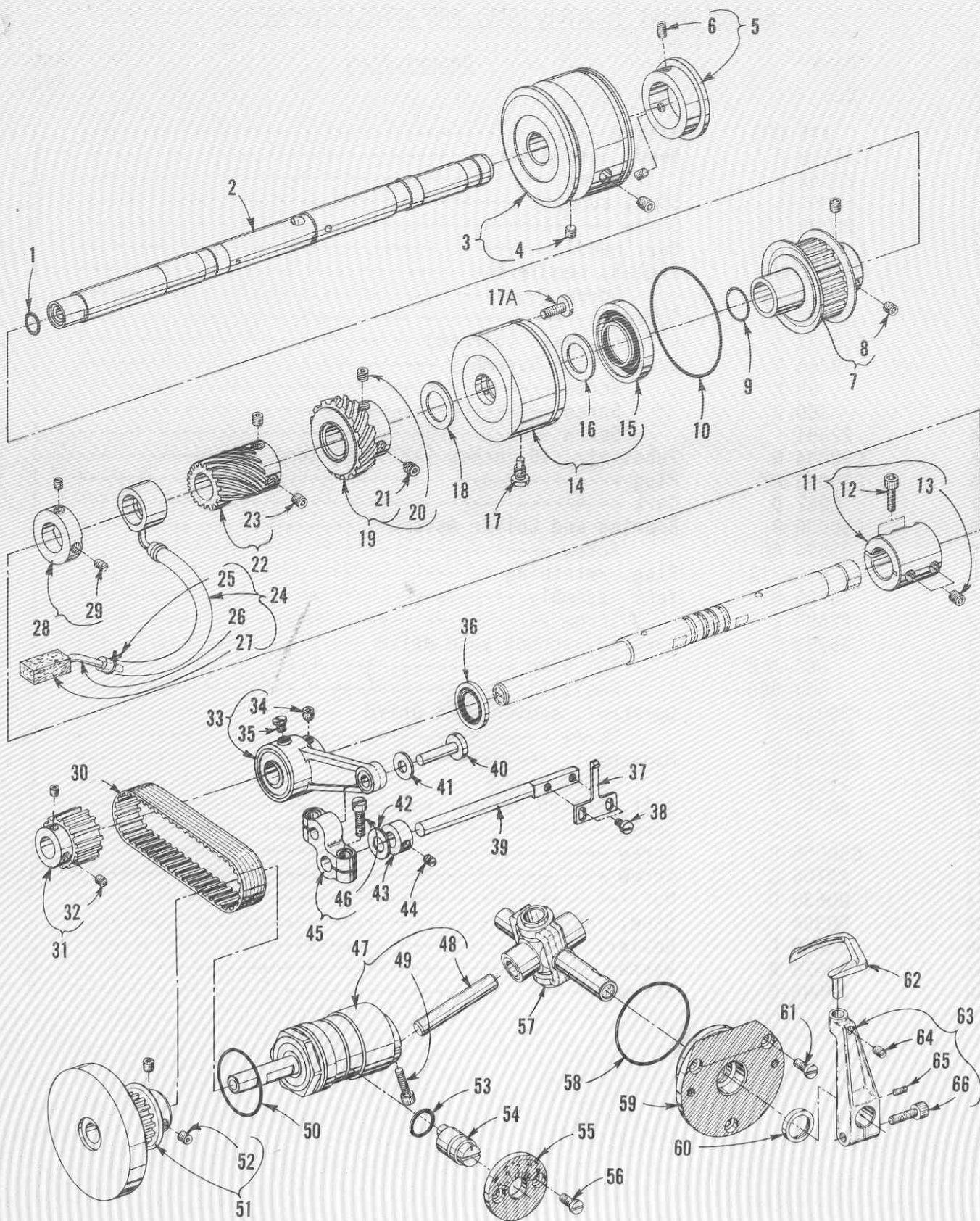
COVERS

Ref. No.	Part No.	Description	Amt. Req.
1	C50095 G	Shield Assembly, safety -----	1
2	12934 A	Nut -----	2
3	RM2879-2	Rivet -----	2
4	97127	Washer, spring -----	2
5	C50095 F	Shield, safety -----	1
6	C50095 E	Bracket, mounting -----	1
7	C50095 D	Stud -----	1
8	C50082 R	Cover, head -----	1
9	660-219 A	Pin, roll (stop) -----	1
10	C50082 AA	Gasket -----	1
11	22883 B	Screw, plug -----	1
12	22541 C	Screw -----	4
13	C50082 AW	Gasket -----	1
14	C50082 K	Gasket -----	1
15	C50082 V	Cover, head (left rear) -----	1
16	22569 M	Screw -----	9
17	C50082 M	Cover, head (right rear) -----	1
18	C50082 N	Gasket -----	1
19	22861 C	Screw -----	4
20	50382 G	Cover, top -----	1
21	22597 E	Screw -----	2
22	50394 J	Plug, oil -----	2
23	C50093 AU	Cap, oil filler -----	1
24	C50082 X	Gasket -----	1
25	50382 F	Gasket -----	1
26	22526 H	Screw -----	10
27	50382 J	Cover -----	1
28	22525 E	Screw -----	9
29	22841 N	Screw, adaptor -----	1
30	50382 H	Cover -----	1
31	87	Screw -----	2
32	--	Plate, throat; see "SEWING COMBINATIONS" -----	1
33	22839	Screw -----	2
34	35036 AE	Ferrule, locating -----	2
35	22587 N	Screw -----	2
36	50380	Support, throat plate -----	1
37	660-939	Bumper, rubber -----	1
38	22799 AH	Stud, latch spring -----	1
39	50393 U	Shield, lint -----	1
40	22569 D	Screw -----	1
41	22517	Screw -----	4
42	999-216 C	Plug, plastic -----	1
43	50382 A	Cover, end -----	1
44	22894 D	Screw (bearing) -----	2
45	35082 F	Gasket -----	1
46	35082 E	Cover, feed chamber (rear) -----	1
47	22569 D	Screw -----	4
48	50301 B	support, cloth plate -----	2
49	93	Screw -----	4
50	50382 D	Gasket -----	1
51	50382 E	Cover, feed chamber (top) -----	1
52	22653 B-8	Screw, cap -----	6
53	50301 A	Plate, cloth (left) -----	1
54	50301	Plate, cloth (right) -----	1



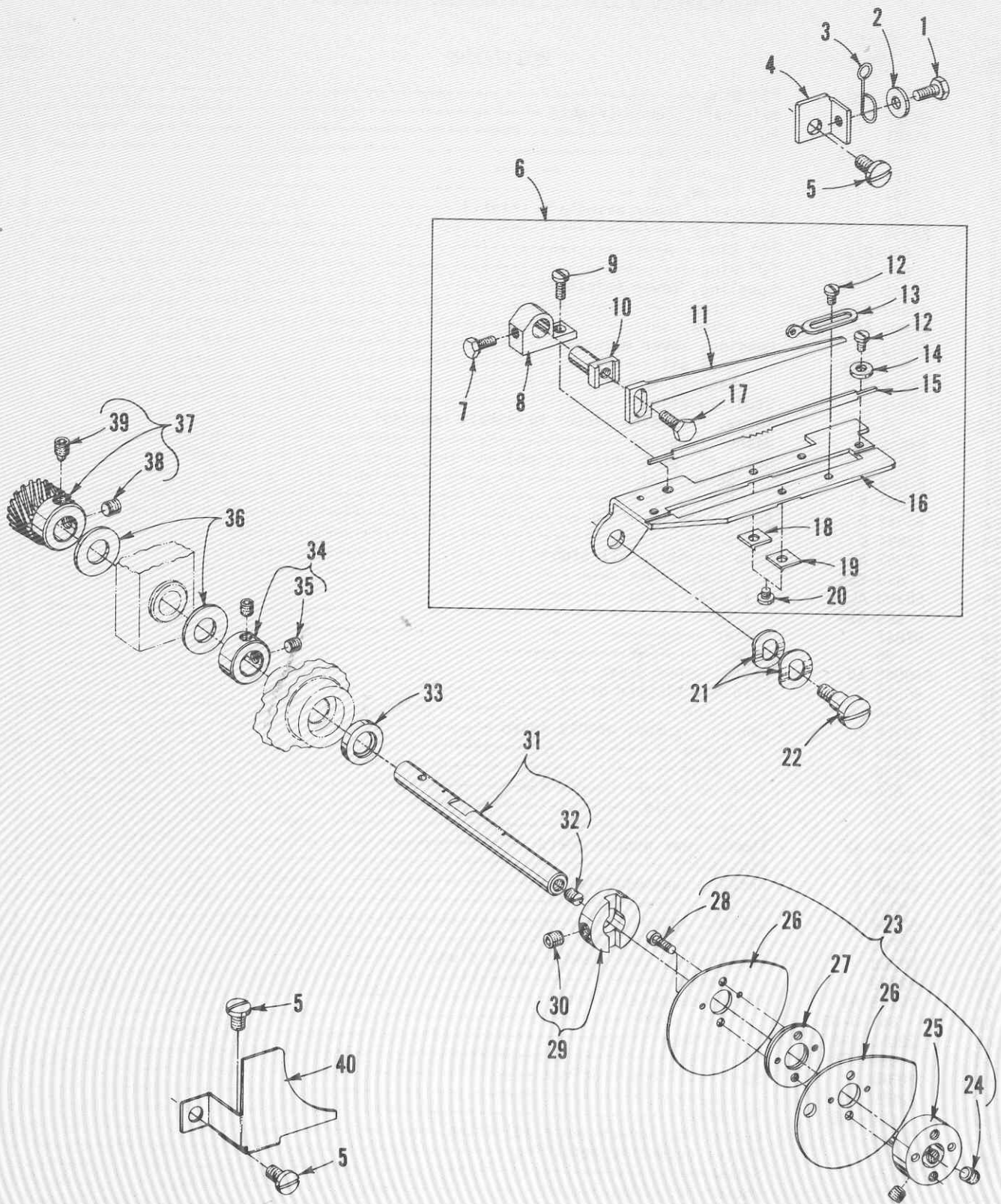
NEEDLE DRIVE (SCOTCH YOKE) AND ASSOCIATED PARTS

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	128 GBS	Needle -----	1
2	C50018 D	Head, needle bar -----	1
3	22768 A	Screw -----	1
4	50355 G	Stud, support -----	1
5	22799 AE	Screw -----	1
6	C50017 C	Bar, needle -----	1
7	C50058 H	Eyelet, needle bar -----	1
8	18-71	Screw -----	1
9	22720 A	Screw -----	1
10	C50094 X	Fitting, male (barbed) -----	1
11	50355 T	Scotch Yoke Assembly -----	1
12	88 B	Screw -----	1
13	J80 K	Screw -----	1
14	22591	Screw -----	1
15	C50094 N	Tube, air, 18 inches (457.0mm) long -----	1
16	C50093 AY	Plug -----	1
17	C067 D	Cork -----	1
18	C50036 P	Bearing and Collar Assembly -----	1
19	22894 AD	Screw -----	2
20	660-713	Ring, retaining -----	1
21	50355 H	Yoke Assembly -----	1
22	22596 E	Screw -----	1
23	35093 P	Housing, scotch yoke drive -----	1
24	660-708	"O" Ring -----	1
25	660-680	Seal, lip -----	1
26	35042 A	Sprocket, scotch yoke drive -----	1
27	22894 X	Screw -----	2
28	C50021 A	Handwheel -----	1
29	22894 C	Screw -----	2
30	50342 R	Belt, scotch yoke drive -----	1
31	25 S	Screw -----	2
32	C50055 H	Screw -----	1
33	22706 C	Screw -----	1
34	80630 D	Nut -----	2
35	50354	Stud, idler -----	2
36	35042 C	Roller, idler -----	2
37	53678 N	Washer -----	2
38	22585 C	Screw -----	2



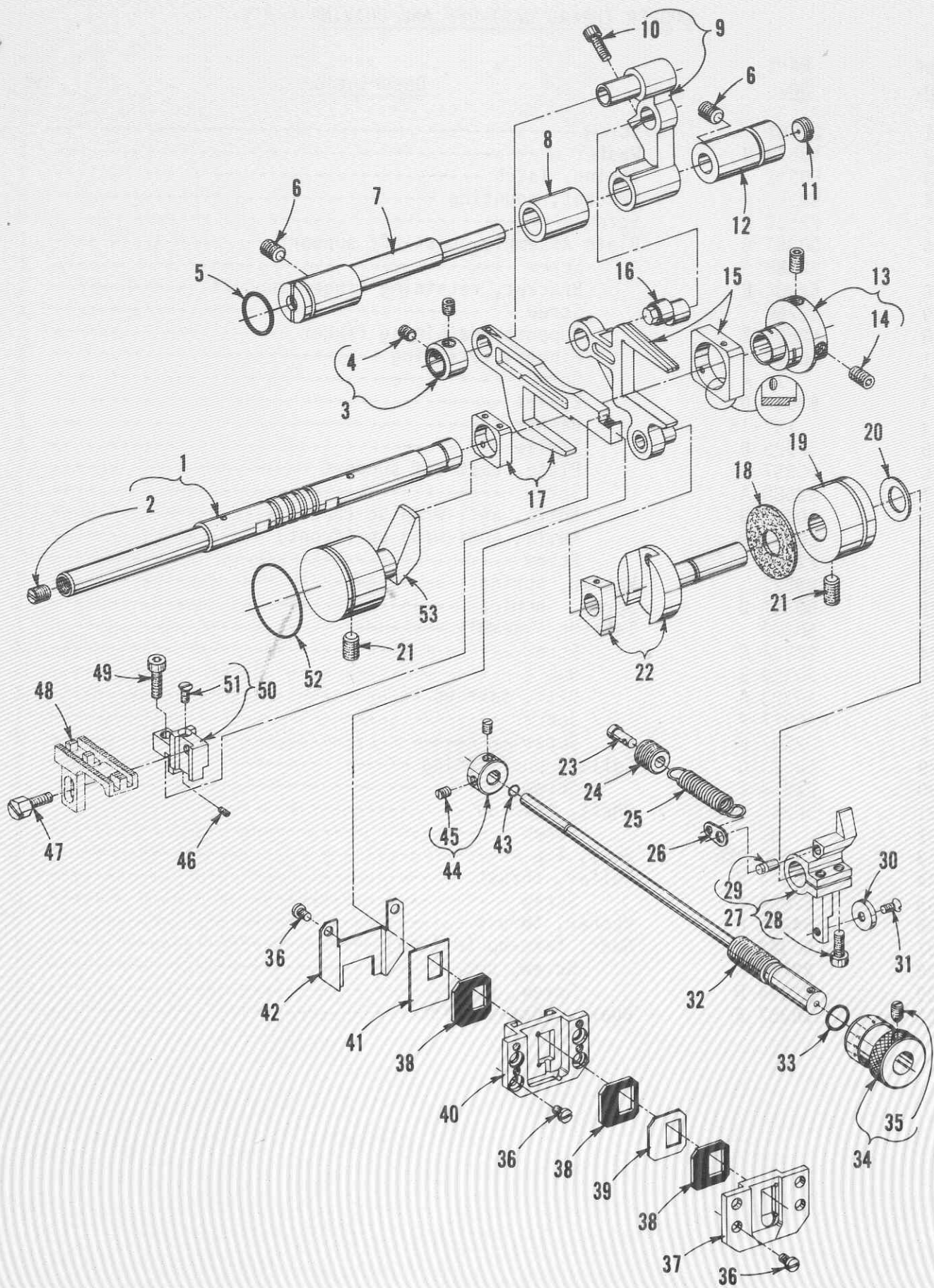
LOWER MAINSHAFT, LOOPER & REAR NEEDLE GUARD DRIVE

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	660-220	"O" Ring -----	1
2	50322 AA	Mainshaft, lower (right) -----	1
3	35021	Pulley -----	1
4	22650 CD-6	Screw, set -----	2
5	55021 B	Guard, pulley -----	1
6	22894 C	Screw, set -----	2
7	50342 H	Sprocket, lower mainshaft (right) -----	1
8	22894 X	Screw -----	2
9	660-212	"O" Ring -----	1
10	660-935	"O" Ring -----	1
11	50343	Coupling, lower mainshaft -----	1
12	22652 A-8	Screw -----	2
13	22894 AE	Screw, set -----	2
14	50393 S	Housing, lower mainshaft -----	1
15	660-998	Seal, oil -----	1
16	35055 V	Washer, thrust -----	1
17	62245 C	Stud, locating -----	1
17A	25 S	Screw, retaining (lower mainshaft housing) -----	2
18	35055 V	Washer (spacer) -----	1
19	50339	Gear, oil pump drive (nylon) -----	1
20	22894 AD	Screw, set -----	1
21	22894 K	Screw, spot -----	1
22	50342 D	Gear, take-up drive -----	1
23	22894 C	Screw -----	2
24	50393 AN	Pump Assembly, oil siphon -----	1
25	660-885	Clamp, tube -----	1
26	50393 AL	Tube, brass -----	1
27	666-214	Felt -----	1
28	57847	Collar -----	1
29	95	Screw -----	2
30	C50042 AD	Belt, looper drive -----	1
31	50342 B	Sprocket, looper drive -----	1
32	22894 AD	Screw -----	2
33	50368 C	Connecting Rod, needle guard -----	1
34	22894 AD	Screw -----	2
35	22830	Screw -----	1
36	660-934	Seal, oil -----	1
37	50325	Guard, needle -----	1
38	90	Screw -----	2
39	C50068 AR	Shaft, rear needle guard -----	1
40	50368 A	Pin, pivot -----	1
41	50368 E	Washer, non-metallic -----	1
42	6042 A	Washer -----	1
43	50368 D	Collar, thrust -----	1
44	22743	Screw, for 50368 D -----	1
45	50368	Connection, rear needle guard pivot -----	1
46	22729	Screw -----	2
47	29105 AT	Drive Assembly, looper -----	1
48	667 J-33	Pin, crank -----	1
49	22653 J-8	Screw -----	1
50	660-979	"O" Ring -----	1
51	50342 A	Sprocket, looper driven -----	1
52	22894 AD	Screw -----	2
53	660-206	"O" Ring -----	1
54	50314	Eccentric, looper avoid adjusting -----	1
55	50314 A	Plate, eccentric retaining -----	1
56	22569 G	Screw -----	2
57	29192 AE	Rocker Assembly, looper -----	1
58	660-455	"O" Ring -----	1
59	50344 C	Housing, looper rocker bearing -----	1
60	C50044 V	Seal, oil -----	1
61	22569 G	Screw -----	3
62	- - -	Looper, see "SEWING COMBINATIONS" -----	1
63	50313	Holder, looper -----	1
64	22565 X	Screw, set -----	1
65	22575 B	Screw, adjusting -----	1
66	22652 B-10	Screw, binder -----	1



LOOPER THREAD CAST-OFF AND DRIVING PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	22781	Screw -----	1
2	53678 N	Washer -----	1
3	50332	Spring, latch -----	1
4	50357 A	Bracket, mounting -----	1
5	22569 D	Screw -----	3
6	50357 B	Plate Assembly, cast-off support -----	1
7	22588 S	Screw -----	1
8	52904 E	Bracket, retaining finger support -----	1
9	22768	Screw -----	1
10	52804 E	Support, retaining finger -----	1
11	50304 A	Finger, retaining -----	1
12	73 A	Screw -----	4
13	52958 D	Eyelet -----	2
14	157-15	Washer -----	2
15	50323 D	Strike-off -----	1
16	50357	Plate, cast-off support -----	1
17	22588 A	Screw -----	1
18	50357 G	Knife, anti-wrap up (back) -----	1
19	50357 H	Knife, anti-wrap up (front) -----	1
20	22798	Screw -----	2
21	99521	Washer, spring -----	2
22	50357 D	Screw, shoulder -----	1
23	50323	Take-Up Assembly -----	1
24	22894 C	Screw -----	2
25	50323 B	Hub -----	1
26	50323 A	Disc, take-up -----	2
27	C50077 P	Spacer -----	1
28	22797 B	Screw -----	2
29	50323 C	Collar, positioning -----	1
30	22894 C	Screw -----	1
31	50342 F	Shaft, take-up -----	1
32	89	Screw -----	1
33	660-986	Seal, lip -----	1
34	50344 H	Collar, thrust -----	1
35	22894 C	Screw -----	2
36	54274 P	Washer, thrust -----	2
37	50342 E	Gear, take-up (driven) -----	1
38	22894 C	Screw, set -----	1
39	22894 D	Screw, spot -----	1
40	50357 F	Guard, take-up disc -----	1

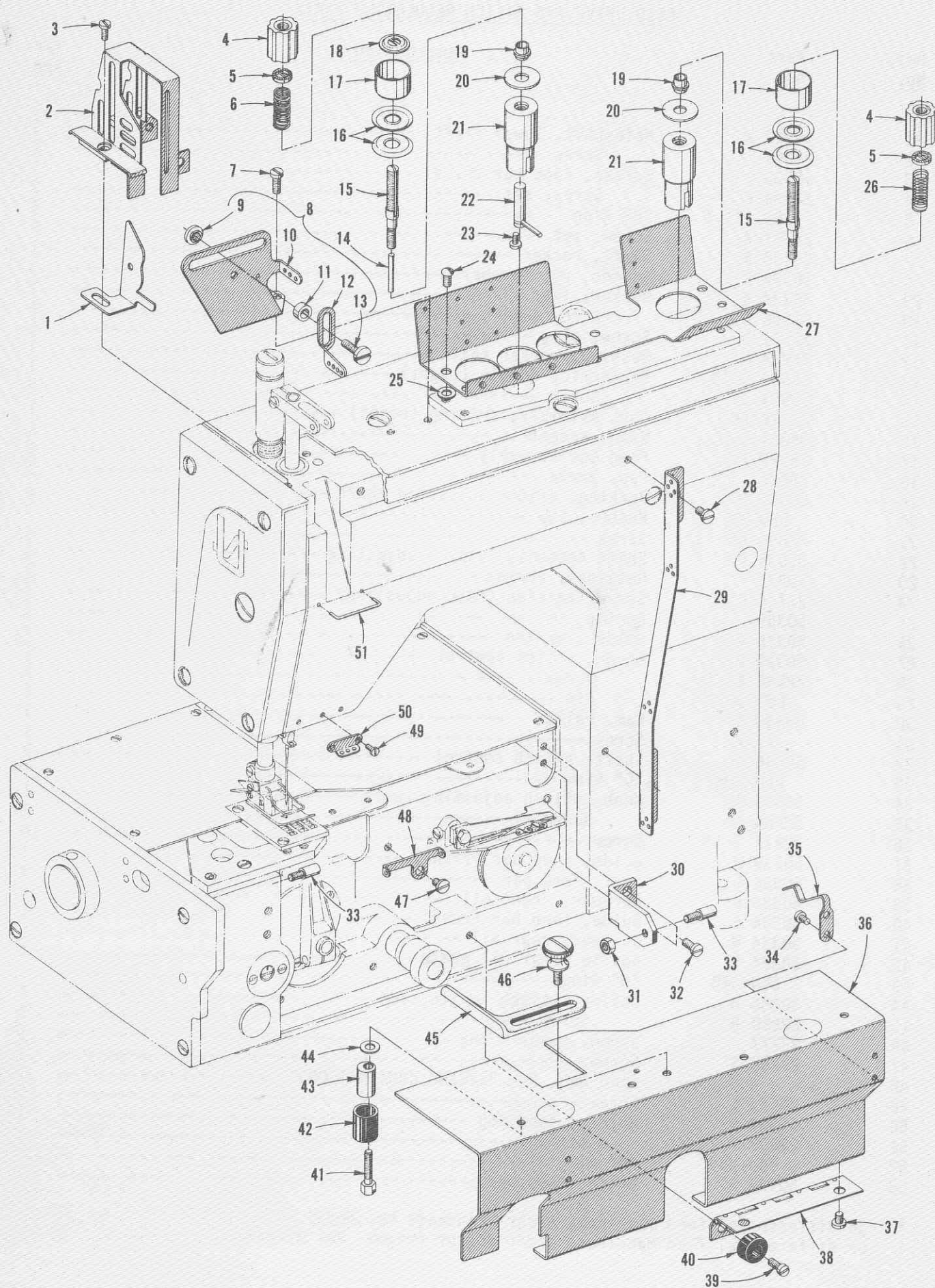


FEED DRIVE AND STITCH REGULATING PARTS

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
*1	50322 K	Mainshaft, lower (left) -----	1
2	22591	Screw -----	1
3	50335 L	Collar, feed bar thrust -----	1
4	22894 C	Screw, set -----	2
5	999-211 C	"O" Ring -----	1
6	22591 A	Screw, set -----	2
7	35034 N	Shaft, rocker -----	1
8	50336 C	Spacer, rocker shaft -----	1
#9	50334 K	Rocker, feed -----	1
10	22596 E	Screw -----	1
11	22571 D	Screw, plug -----	1
12	35034 M	Bushing, rocker shaft -----	1
13	35040 B-15	Eccentric, double (right) -----	1
14	22894 J	Screw -----	2
15	29126 FB	Fork Assembly, driving (right) -----	1
16	35034 J	Stud, eccentric -----	1
17	29126 EV	Feed Bar Assembly -----	1
18	35036	Pad, brake -----	1
19	35036 F	Bushing, stitch adjusting shaft -----	1
20	661-50	Washer, cup -----	1
21	22894 AB	Screw -----	1
22	35036 C	Shaft Assembly, stitch adjusting -----	1
23	50335	Retainer, spring -----	1
24	22714 C	Screw, tension (feed adjusting) -----	1
25	50355	Spring -----	1
26	50335 A	Holder, spring -----	1
27	50336 D	Lever, stitch control -----	1
28	22596 E	Screw -----	2
29	661-35	Pin -----	1
30	50335 C	Cam, roller -----	1
31	77 K	Screw -----	1
32	50335 E	Shaft, stitch control -----	1
33	660-206	"O" Ring -----	1
34	35036 AP	Knob, stitch adjusting shaft -----	1
35	22764 A	Screw -----	1
36	22617 J-16	Screw -----	10
37	50334 B	Guide, feed bar (front) -----	1
38	50334 E	Seal, feed bar -----	3
39	50334 D	Scraper, front oil -----	1
40	50334 C	Guide, feed bar (rear) -----	1
41	50334 W	Scraper, rear oil -----	1
42	50334 Y	Baffle, rear oil plate -----	1
43	660-980	"O" Ring -----	1
44	50335 D	Collar, stitch length stop -----	2
45	22560 B	Screw -----	2
46	99277	Screw, stabilizing -----	1
47	22758 S	Screw -----	1
48	- - -	Feed Dog, See "SEWING COMBINATIONS" -----	1
49	22729 L	Screw -----	1
50	50334 F	Holder, feed dog -----	1
51	22637 P-24	Screw -----	1
52	660-969	"O" Ring -----	1
53	50334 A	Guide, feed bar -----	1

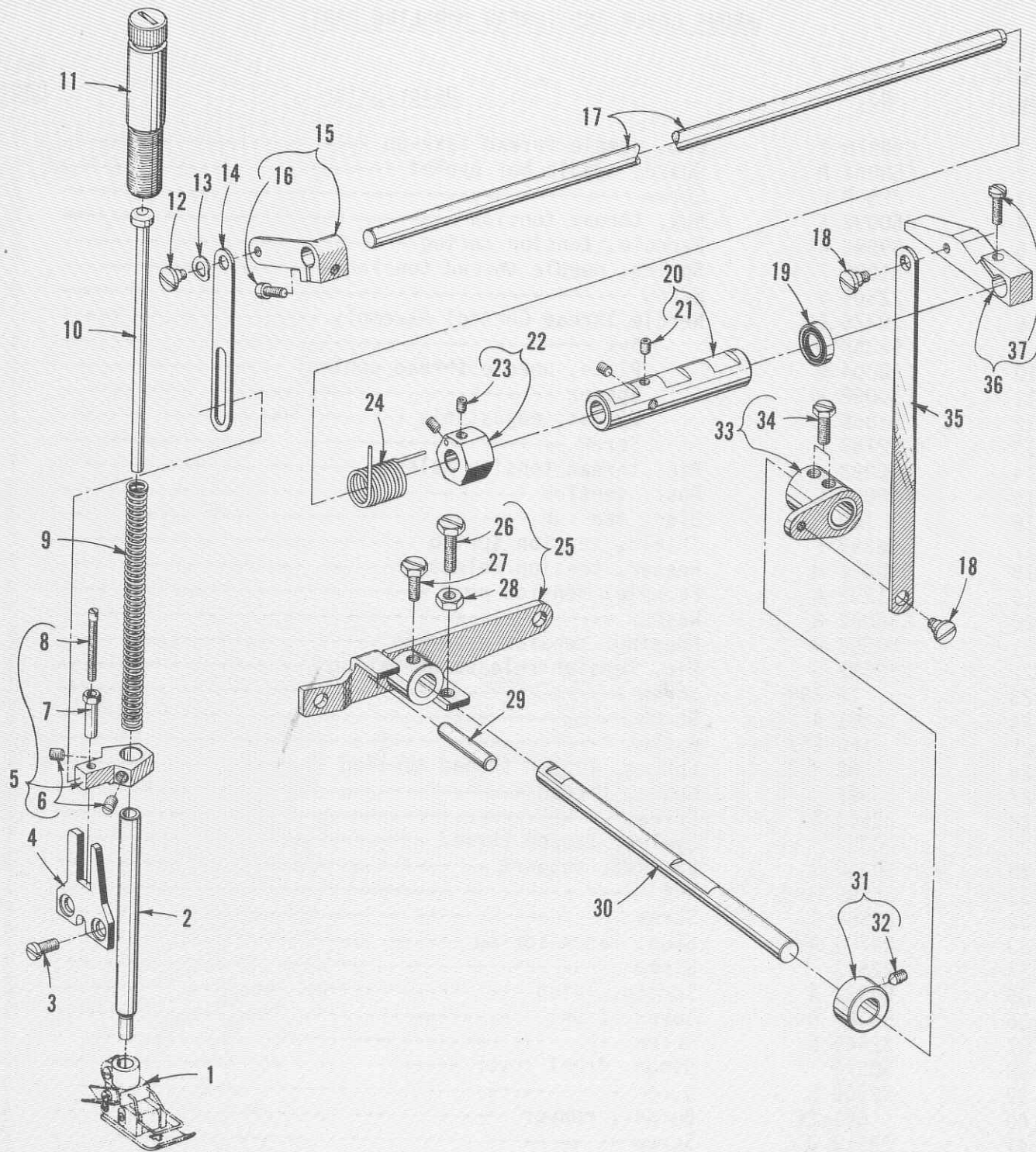
* On differential feed machines, order Mainshaft No. 50322.

On differential feed machines, order Rocker (right) No. 35034F.



FRONT COVER AND THREAD HANDLING PARTS

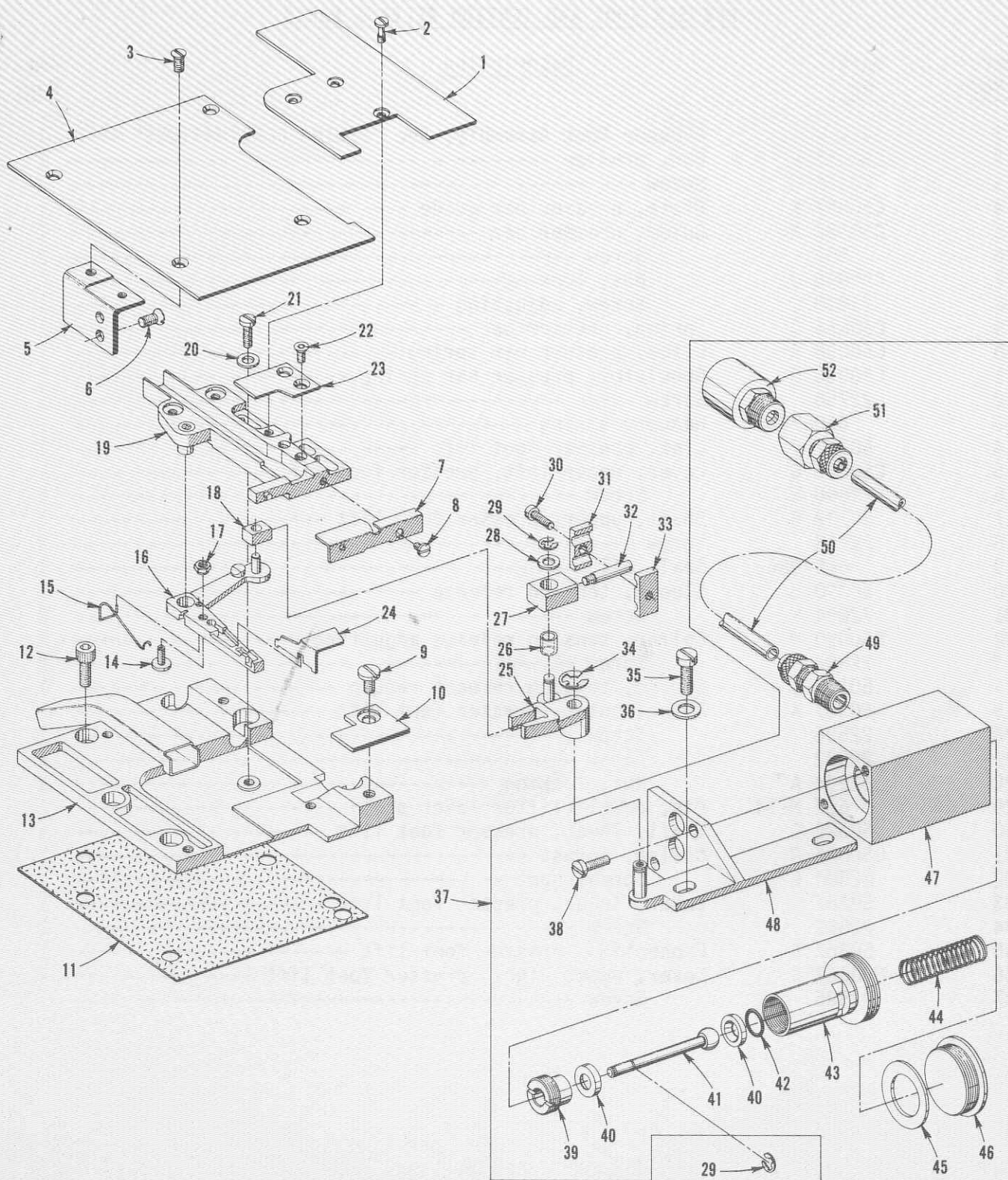
<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	C50070 E	Cam, needle thread take-up -----	1
2	C50054 M	Guard, needle bar eyelet -----	1
3	22569 C	Screw -----	3
4	C50092 S	Nut, thread tension -----	2
5	39592 AK	Ferrule, tension spring -----	2
6	51292 F-4	Spring, needle thread tension -----	1
7	22569 C	Screw -----	2
8	29476 PG	Needle Thread Control Assembly -----	1
9	56358 D	Nut -----	1
10	C50004 C	Plate, needle thread control -----	1
11	C50058 R	Spacer -----	1
12	51858	Eyelet, adjustable -----	1
13	22757	Screw -----	1
14	C50092 J	Pin, thread tension release -----	1
15	C50092 L	Post, tension -----	2
16	109	Disc, tension -----	4
17	56392 F	Shield, tension spring -----	2
18	C50092 M	Washer, tension release -----	1
19	51292 A	Ferrule, tension post -----	2
20	C50092 R	Washer -----	2
21	50392 B	Housing, tension assembly -----	2
22	C50092 G	Pin, tension release actuating -----	1
23	18-799	Screw -----	1
24	22501 A	Screw -----	5
25	660-257	Gasket -----	5
26	51292 F-2	Spring, looper thread tension -----	1
27	50392	Guide, thread -----	1
28	22569 D	Screw -----	2
29	50358	Eyelet, looper thread -----	1
30	50332 B	Bracket, support -----	1
31	35569 J	Nut -----	1
32	22569 C	Screw -----	2
33	22799 AH	Stud, latch spring -----	2
34	22513	Screw -----	4
35	50332 A	Spring, latch -----	2
36	50382 C	Cover, front -----	1
37	22569 D	Screw -----	4
38	50378	Hinge, front cover -----	2
39	22569 B	Screw -----	4
40	661-26	Bumper, rubber -----	4
41	22519 J	Screw -----	2
42	50393 W	Bumper, rubber -----	2
43	50382 T	Stop, adjustable -----	2
44	20	Washer -----	2
45	24	Guide, edge -----	1
46	25	Screw -----	2
47	22569 D	Screw -----	1
48	50392 A	Eyelet, looper thread -----	1
49	605 A	Screw -----	2
50	C50044 E	Guide, needle thread -----	1
51	C50058 F	Wire, rubbing, needle thread -----	1



P 100

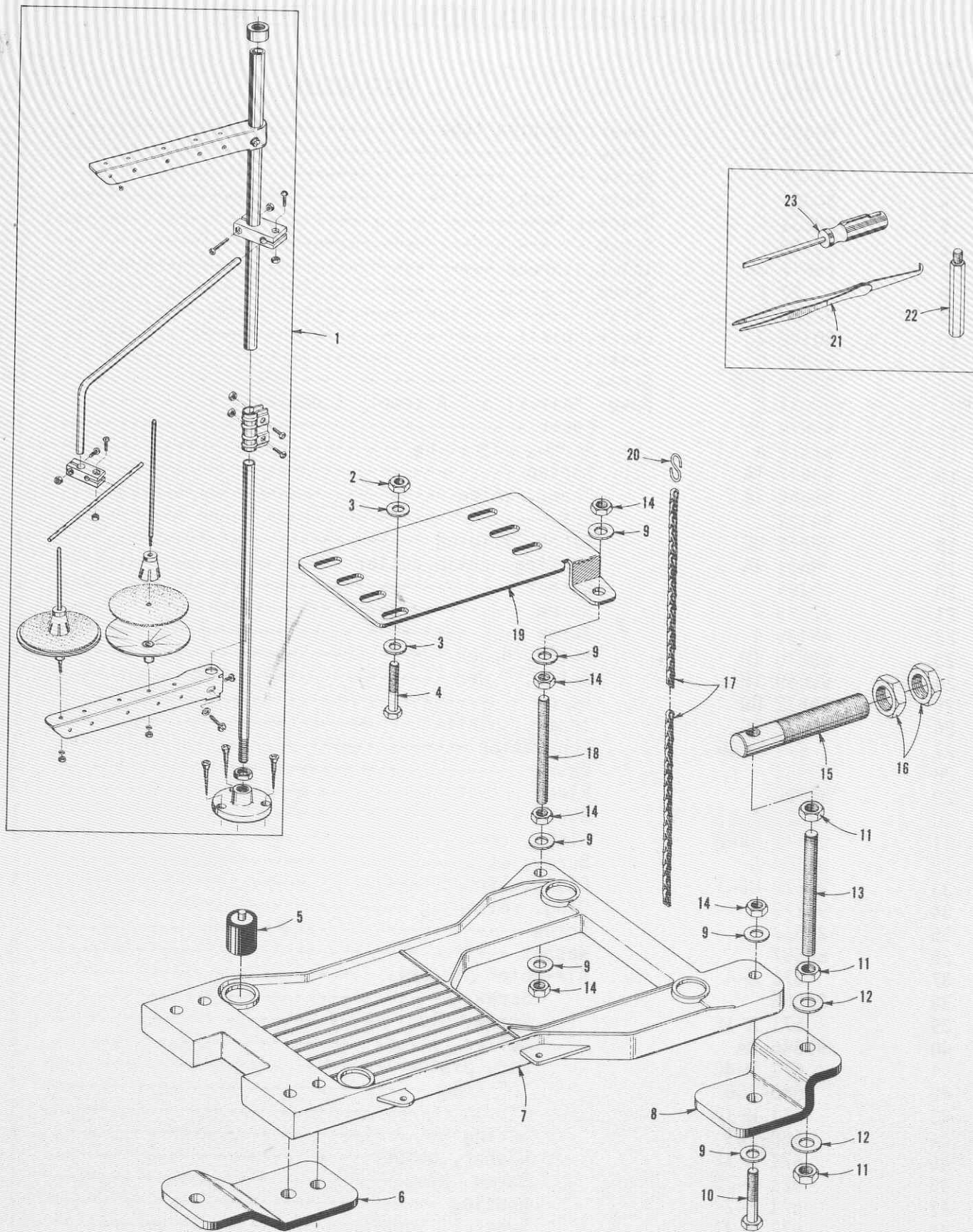
PRESSER FOOT AND TENSION RELEASE PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	- - -	Presser Foot Assembly, See "SEWING COMBINATIONS" ----	1
2	C50057 E	Bar, presser -----	1
3	22569 C	Screw -----	2
4	C50067 K	Plate, presser bar guide -----	1
5	C50056 K	Guide, presser bar -----	1
6	531	Screw -----	2
7	C50056 J	Nut, lock -----	1
8	22840 C	Screw, adjusting -----	1
9	C50056 C	Spring, presser bar -----	1
10	C50056 B	Guide, presser bar spring -----	1
11	C50056 D	Regulator, presser bar spring -----	1
12	22758	Screw -----	1
13	660-718	Washer, spring -----	1
14	50367 E	Link, presser foot lift -----	1
15	C50067 G	Lever, upper left, presser foot lift -----	1
16	22596 E	Screw -----	1
17	50322 B	Shaft, upper, presser foot lift -----	1
18	22758	Screw -----	2
19	660-986	Seal, oil -----	1
20	50390 B	Sleeve, tension release -----	1
21	22894 W	Screw -----	2
22	C50090 M	Collar, tension release adjusting -----	1
23	22894 P	Screw -----	2
24	50390 E	Spring, tension release return -----	1
25	50367 A	Lever, outer, presser foot lift -----	1
26	22596	Screw -----	1
27	22882	Screw -----	1
28	12934 A	Nut, locking -----	1
29	667 M-14	Pin, dowel (lifter lever stop) -----	1
30	50322 C	Shaft, lower, presser foot lift -----	1
31	C50036 R	Collar, thrust -----	1
32	22894 L	Screw, spot -----	1
33	50367	Lever, lower, presser foot lift -----	1
34	22882	Screw -----	2
35	50367 B	Connection, presser foot lift -----	1
36	C50067 B	Lever, upper right, presser foot lift -----	1
37	22596	Screw -----	1



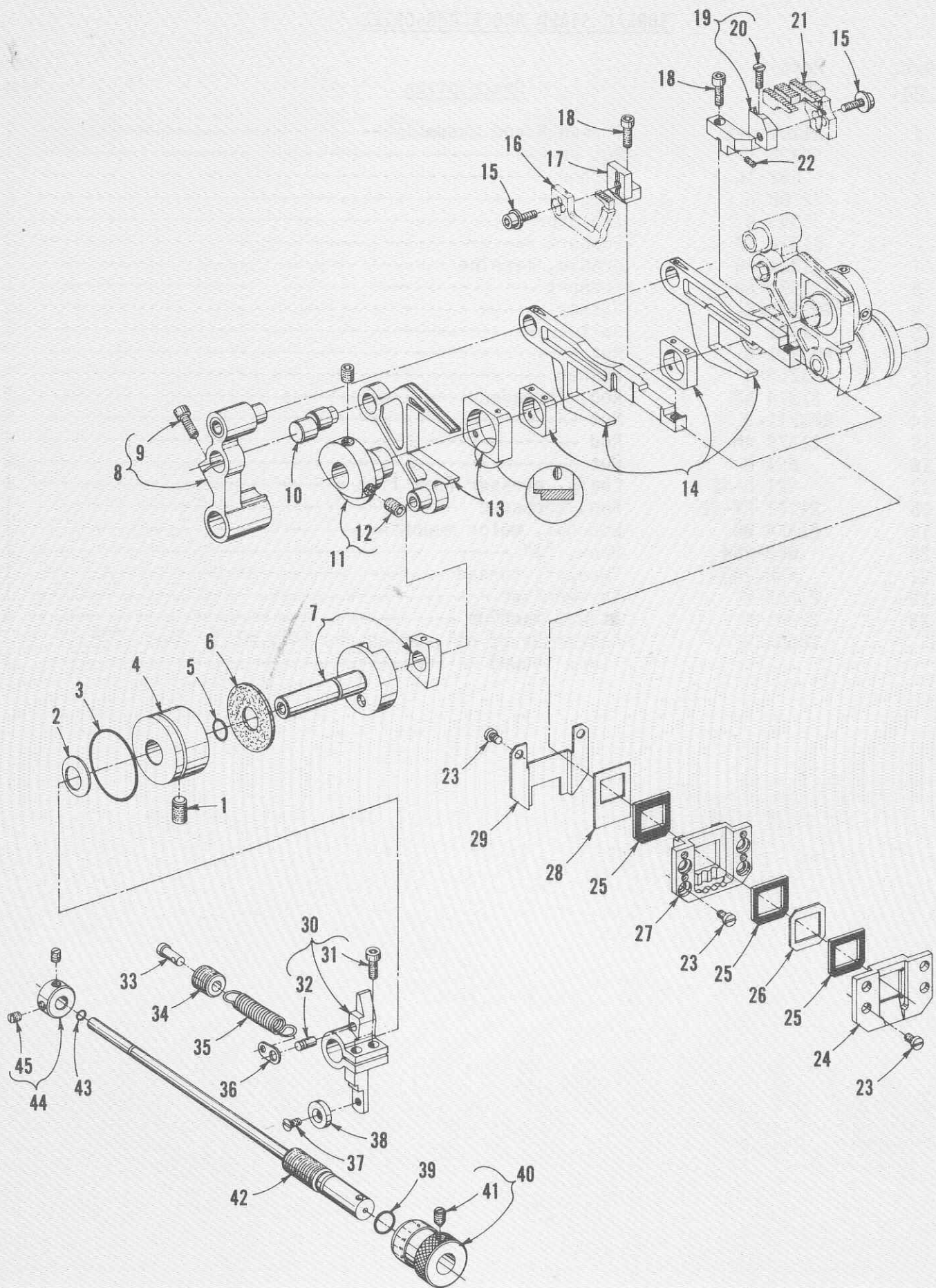
POWER "AIR-KLIPP"® CHAIN CUTTER AND RELATED PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	50382 Y	Cover, suction tube -----	1
2	99312 A	Screw -----	3
3	22525 E	Screw -----	4
4	50301 T	Plate, cloth, left -----	1
5	50332 E	Bracket -----	1
6	22526	Screw -----	2
7	99677 UA	Inlet, thread -----	1
8	77 F	Screw -----	1
9	22569 F	Screw -----	1
10	50382 Z	Cover, plate -----	1
11	50382 D	Gasket -----	1
12	22653 B-8	Screw -----	6
	V29944 C	Power "Air-Klipp" Assembly (complete) -----	1
13	99679 UA	Cover -----	1
14	99372 A	Screw, adjusting -----	1
15	99697 TA	Spring -----	1
16	99666 TA	Lever, knife -----	1
17	99322	Nut -----	1
18	99672 UE	Block, sliding -----	1
19	99691 TA	Housing, chain cutter -----	1
20	80265	Washer -----	2
21	22729 J	Screw -----	2
22	95435 A	Screw -----	2
23	99670 TH	Knife, upper -----	1
24	99669 TH	Knife, lower -----	1
25	99672 UD	Lever -----	1
26	99672 TC	Insert, plastic -----	1
27	671 H-4D	Connection -----	1
28	95954	Washer -----	1
29	96280	Ring, retaining -----	3
30	22562 A	Screw -----	1
31	99672 UB-2	Clamp, (rear) -----	1
32	HS100 D	Screw, stud -----	1
33	99672 UB-1	Clamp, (front) -----	1
34	96275	Ring, retaining -----	1
35	22517	Screw -----	2
36	80557	Washer -----	2
37	671 H-4	Air-Motor Assembly -----	1
38	22585	Screw -----	2
39	671 H-1E	Screw, plug -----	1
40	99646 BA	Collar, thrust -----	2
41	671 H-4C	Rod, piston -----	1
42	660-206	"O" Ring -----	1
43	671 H-1A	Piston -----	1
44	660-753	Spring -----	1
45	671 H-1F	Washer, bumper -----	1
46	671 H-1D	Screw, plug -----	1
47	671 H-2A	Housing -----	1
48	671 H-4A	Bracket, housing -----	1
49	660-400	Fitting, straight -----	2
50	99675 G 1000	Tubing, plastic -----	1
51	999-126 G	Connector, straight -----	1
52	999-140 C	Muffler -----	1



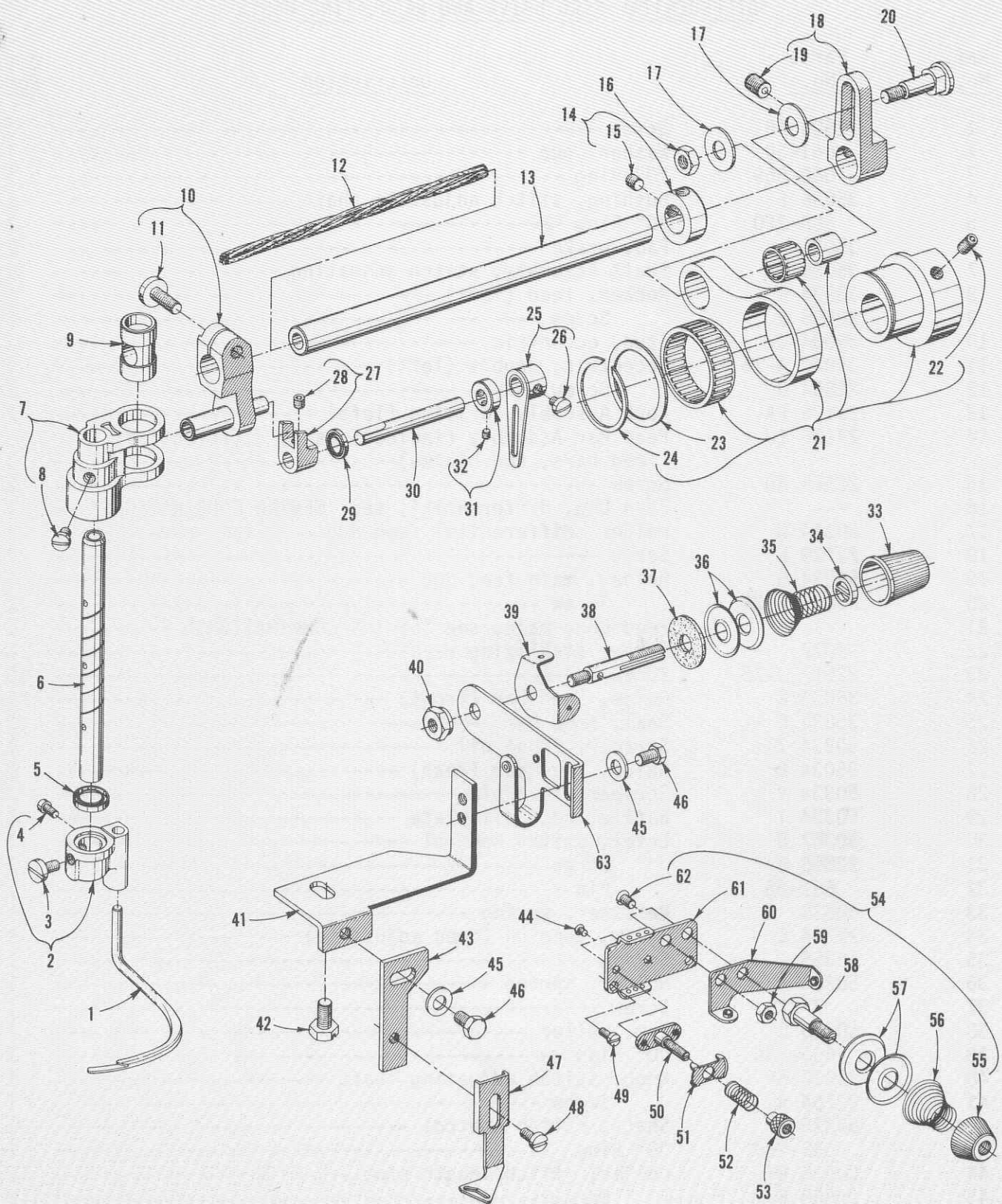
THREAD STAND AND ACCESSORIES

<u>Ref.</u> <u>No.</u>	<u>Part</u> <u>No.</u>	<u>Description</u>	<u>Amt.</u> <u>Req.</u>
1	21101 W-2	Thread Stand Assembly -----	1
2	50335 T	Nut -----	1
3	652-16	Washer -----	3
4	22788 H	Bolt -----	3
5	35095 B	Isolator -----	4
6	21374 AP	Support -----	2
7	21374 AG	Cradle, machine -----	1
8	21374 AU	Support -----	1
9	RM3293-3	Washer -----	16
10	22641	Bolt -----	5
11	RM3211-5	Nut -----	9
12	RM3293-4	Washer -----	4
13	21374 AT	Rod, threaded -----	3
14	RM3211-3	Nut -----	3
15	21374 AM	Rod -----	4
16	651 M	Nut -----	8
17	421 D-42	Chain, presser foot lift -----	1
18	21371 PY-32	Rod, threaded -----	1
19	21374 BB	Bracket, motor mounting -----	1
20	660-264	Hook, "S" -----	2
21	660-240	Tweezer, thread -----	1
22	21207 B	Screwdriver -----	1
23	22841 M	Stand, machine -----	4
	28604 R	Container of oil, 16 ounces (455 ml.), Spec. 175, (not shown) -----	1



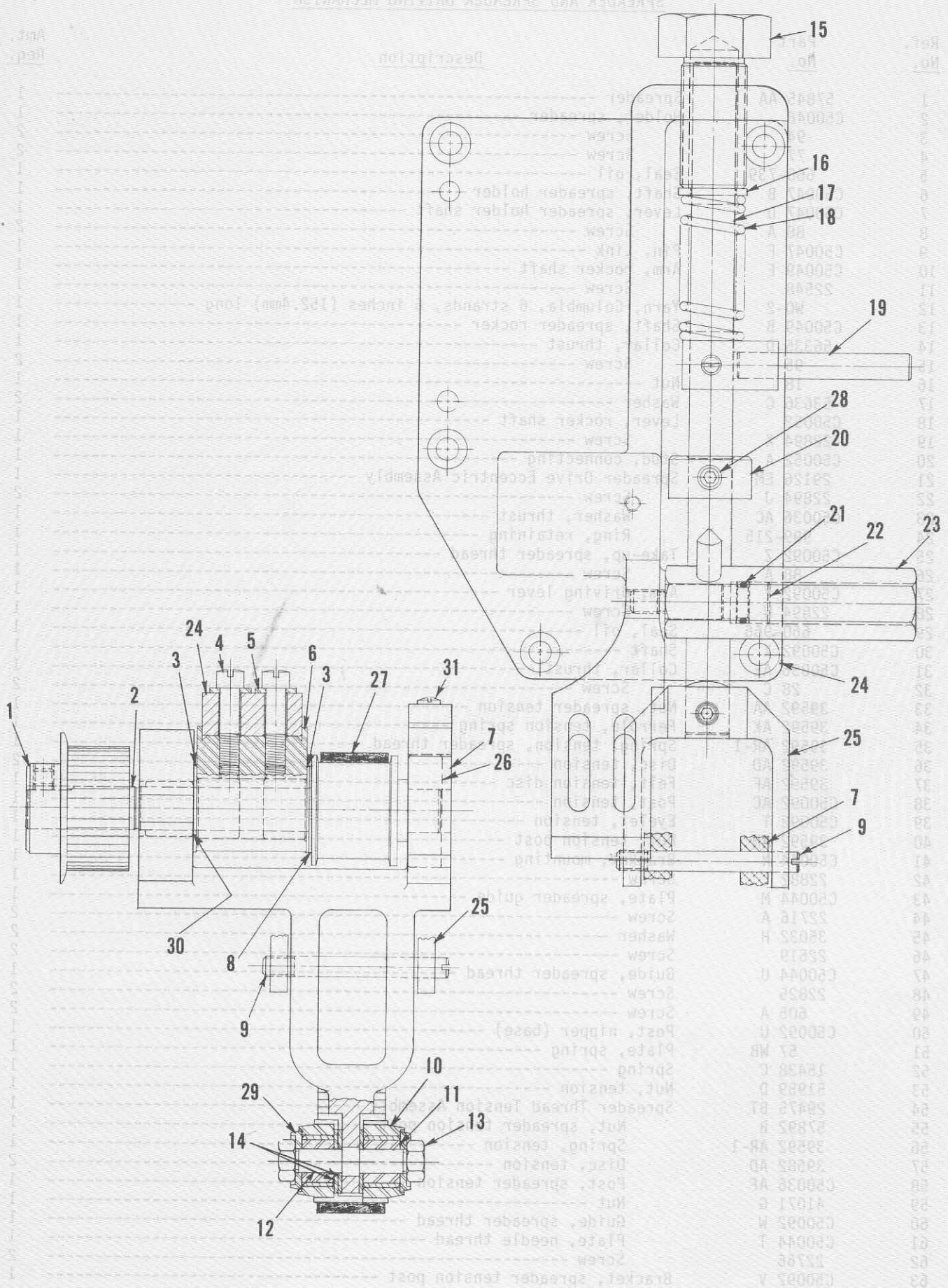
DIFFERENTIAL FEED DRIVE AND REGULATING PARTS

<u>Ref. No.</u>	<u>Parts No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	22894 AB	Screw -----	1
2	661-50	Washer, cup -----	1
3	660-969	"O" Ring -----	1
4	35036 F	Bushing, stitch adjusting shaft -----	1
5	660-220	"O" Ring -----	1
6	35036	Pad, brake -----	1
7	35036 C	Shaft Assembly, stitch adjusting -----	1
8	35034 G	Rocker, feed (left) -----	1
9	22596 E	Screw -----	1
10	35034 J	Stud, eccentric -----	1
11	35040 A-15	Eccentric, double (left) -----	1
12	22894 J	Screw -----	2
13	29126 FA	Fork Assembly, driving (left) -----	2
14	29126 EU	Feed Bar Assembly (includes main, differential feed bars, and blocks)-----	1
15	22569 AD	Screw -----	2
16	---	Feed Dog, differential, see "SEWING COMBINATIONS" --	1
17	50334 H	Holder, differential feed dog -----	1
18	22729 L	Screw -----	2
19	50334 G	Holder, main feed dog -----	1
20	22637 P-24	Screw -----	2
21	---	Feed Dog, main, see "SEWING COMBINATIONS" -----	1
22	99277	Screw, stablizing -----	1
23	22617 J-16	Screw -----	10
24	35034 E	Guide, feed bar (front) -----	1
25	35034 C	Seal, feed bar -----	3
26	50334 Z	Scraper, front oil -----	1
27	35034 D	Guide, feed bar (rear) -----	1
28	50334 V	Scraper, rear oil -----	1
29	50334 Y	Baffle, rear oil plate -----	1
30	50367 D	Lever, stitch control -----	1
31	22596 E	Screw -----	1
32	661-35	Pin -----	1
33	50335	Retainer, spring -----	1
34	22714 C	Screw, tension (feed adjusting) -----	1
35	50355	Spring -----	1
36	50335 A	Holder, spring -----	1
37	77 K	Screw -----	1
38	50335 C	Cam, roller -----	1
39	660-206	"O" Ring -----	1
40	35036 AP	Knob, stitch adjusting shaft -----	1
41	22764 A	Screw -----	1
42	50335 E	Shaft, stitch control -----	1
43	660-980	"O" Ring -----	1
44	50335 D	Collar, stitch length stop -----	2
45	22560 B	Screw -----	2



SPREADER AND SPREADER DRIVING MECHANISM

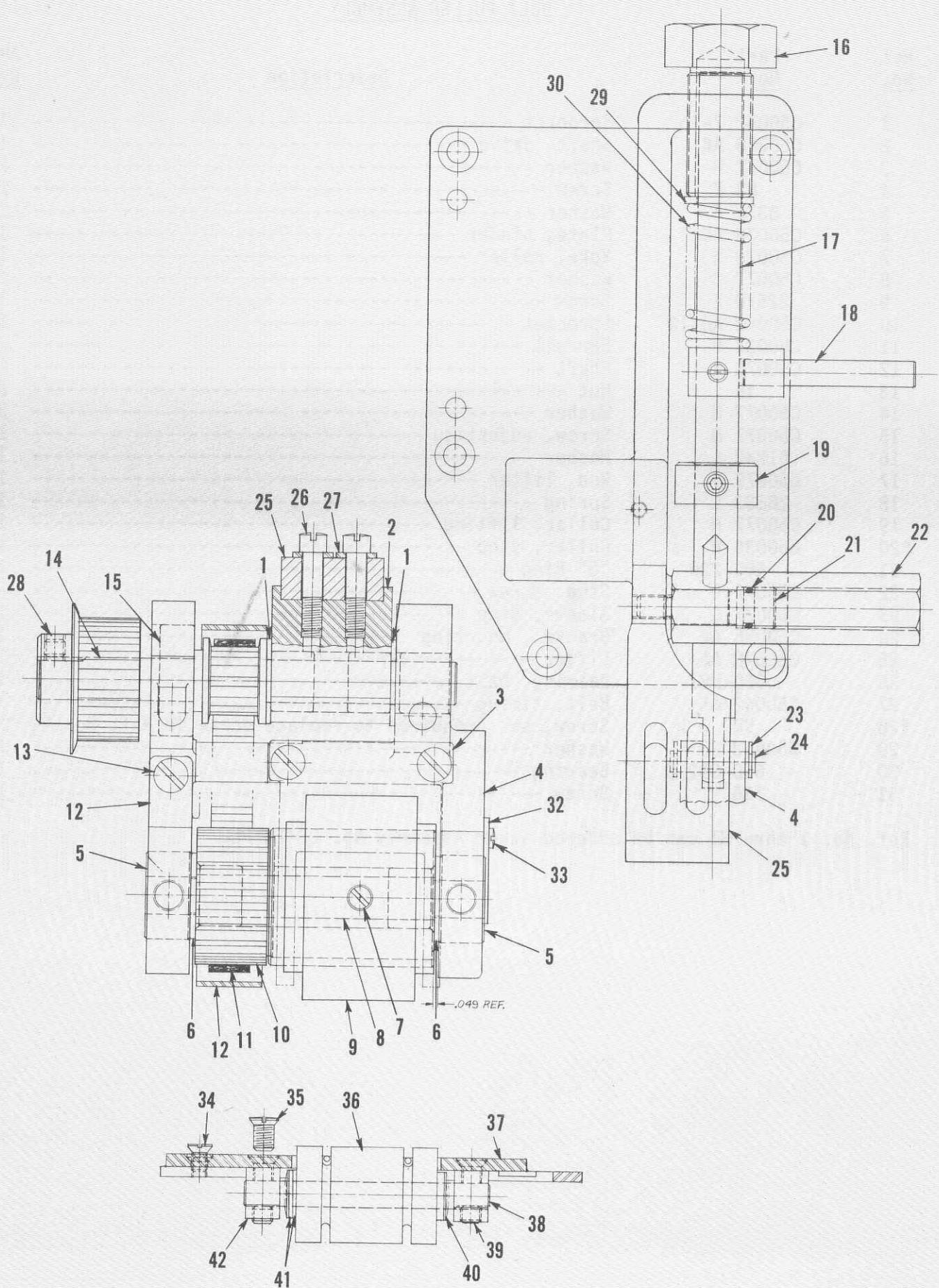
<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	57845 AA	Spreader -----	1
2	C50046	Holder, spreader -----	1
3	94	Screw -----	2
4	77	Screw -----	2
5	660-739	Seal, oil -----	1
6	C50047 B	Shaft, spreader holder -----	1
7	C50047 D	Lever, spreader holder shaft -----	1
8	88 A	Screw -----	2
9	C50047 F	Pin, Link -----	1
10	C50049 E	Arm, rocker shaft -----	1
11	22548	Screw -----	1
12	WO-2	Yarn, Columbia, 6 strands, 6 inches (152.4mm) long -----	1
13	C50049 B	Shaft, spreader rocker -----	1
14	56335 D	Collar, thrust -----	1
15	95	Screw -----	2
16	18	Nut -----	1
17	53636 C	Washer -----	2
18	C50052	Lever, rocker shaft -----	1
19	22894 X	Screw -----	1
20	C50052 A	Stud, connecting -----	1
21	29126 EM	Spreader Drive Eccentric Assembly -----	1
22	22894 J	Screw -----	2
23	C50036 AC	Washer, thrust -----	1
24	999-215	Ring, retaining -----	1
25	C50092 Z	Take-up, spreader thread -----	1
26	88 A	Screw -----	1
27	C50092 Y	Arm, driving lever -----	1
28	22894 W	Screw -----	1
29	660-966	Seal, oil -----	1
30	C50092 X	Shaft -----	1
31	C50036 AE	Collar, thrust -----	1
32	28 C	Screw -----	2
33	39592 AA	Nut, spreader tension -----	1
34	39592 AK	Ferrule, tension spring -----	1
35	39592 AR-1	Spring, tension, spreader thread -----	1
36	39592 AD	Disc, tension -----	2
37	39592 AF	Felt, tension disc -----	1
38	C50092 AC	Post, tension -----	1
39	C50092 T	Eyelet, tension -----	1
40	39592 AH	Nut, tension post -----	1
41	C50044 N	Bracket, mounting -----	1
42	22882	Screw -----	1
43	C50044 M	Plate, spreader guide -----	1
44	22716 A	Screw -----	2
45	35032 H	Washer -----	2
46	22519	Screw -----	2
47	C50044 U	Guide, spreader thread -----	1
48	22825	Screw -----	2
49	605 A	Screw -----	2
50	C50092 U	Post, nipper (base) -----	1
51	57 WB	Plate, spring -----	1
52	15438 C	Spring -----	1
53	51959 D	Nut, tension -----	1
54	29475 BT	Spreader Thread Tension Assembly -----	1
55	57892 B	Nut, spreader tension post -----	1
56	39592 AR-1	Spring, tension -----	1
57	39582 AD	Disc, tension -----	2
58	C50036 AF	Post, spreader tension -----	1
59	41071 G	Nut -----	1
60	C50092 W	Guide, spreader thread -----	1
61	C50044 T	Plate, needle thread -----	1
62	22766	Screw -----	2
63	C50092 V	Bracket, spreader tension post -----	1



BELT PULLER ASSEMBLY

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	C50042 Z-16	Sprocket -----	1
2	C50078 AB	Shaft, drive -----	1
3	C50077 M	Washer -----	2
4	88 F	Screw -----	2
5	8372 A	Washer -----	2
6	C50078 AC	Plate, binder -----	1
7	C50078 W	Yoke, roller -----	1
8	C50077 J	Washer -----	1
9	22570 E	Screw -----	1
10	C50042 AJ-12	Sprocket -----	2
11	C50037 D	Ferrule -----	2
12	C50078 X	Shaft -----	1
13	18	Nut -----	2
14	C50077 N	Washer -----	3
15	C50077 D	Screw, adjusting -----	1
16	51242 L	Washer -----	1
17	C50078 Y	Rod, lifter -----	1
18	28633 L	Spring -----	1
19	C50077 H	Collar, lifting -----	1
*20	C50036 R	Collar, stop -----	1
21	660-220	"O" Ring -----	1
22	C50077 B	Stud, screw -----	1
23	C50077 C	Sleeve, stop -----	1
24	C50078 AE	Bracket, mounting -----	1
25	C50078 AA	Lifter -----	1
26	660-887	Bearing, ball -----	1
27	C50042 AK	Belt, timing -----	1
*28	98	Screw, set (required to replace screw in Ref. No. 20)	1
29	C50063 Y	Washer -----	2
30	660-892 B	Bearing -----	1
31	136	Screw -----	1

Ref. No. 1 thru 31 can be ordered under Assembly No. 29476 PL.



UPPER AND LOWER PULLER ROLLERS

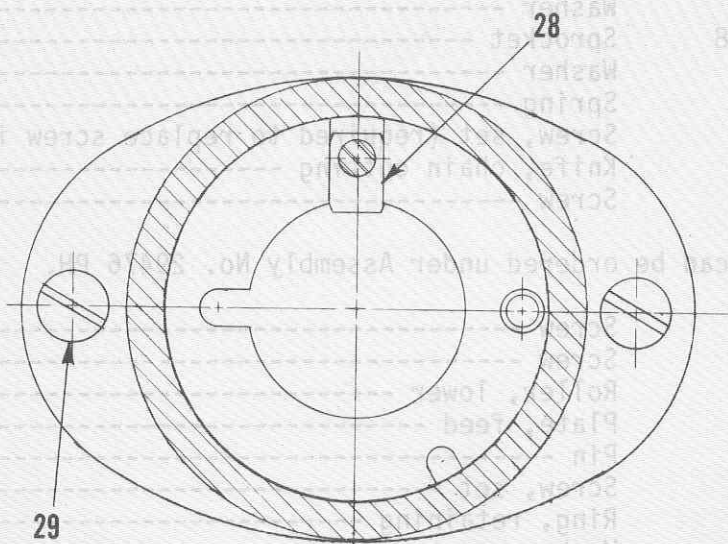
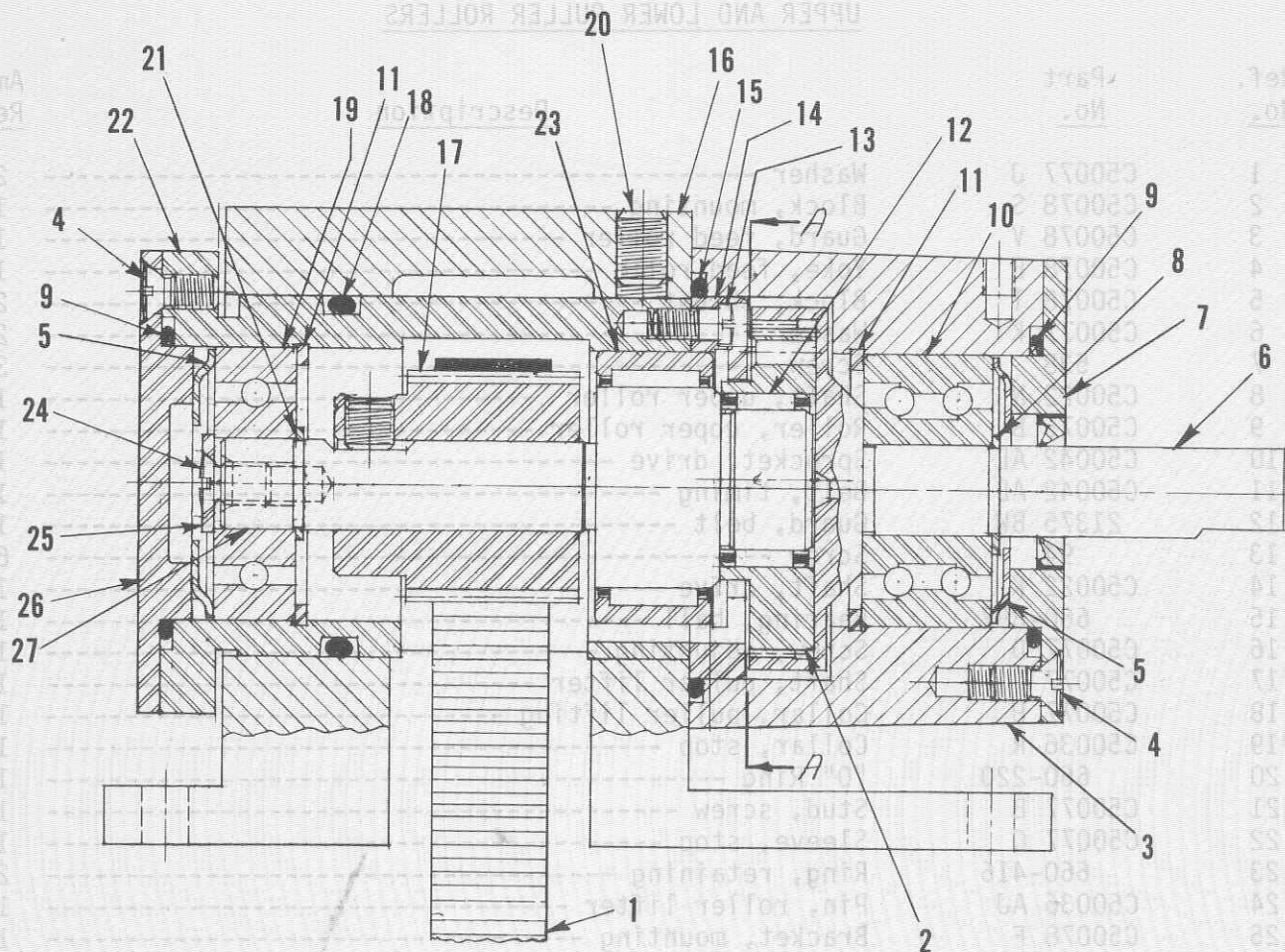
<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	C50077 J	Washer -----	2
2	C50078 S	Block, mounting -----	1
3	C50078 V	Guard, feed roller -----	1
4	C50078 E	Yoke, feed rolle -----	1
5	C50078 T	Block, thrust -----	2
6	C50077 K	Washer -----	2
7	538	Screw -----	3
8	C50022 N	Shaft, upper roller -----	1
9	C50075 B	Roller, upper roller -----	1
10	C50042 AL	Sprocket, drive -----	1
11	C50042 AE	Belt, timing -----	1
12	21375 BW	Guard, belt -----	1
13	94	Screw -----	6
14	C50022 K	Shaft, drive -----	1
15	660-887	Bearing, ball -----	1
16	C50077 D	Screw, adjusting -----	1
17	C50077	Shaft, puller lifter -----	1
18	C50077 H	Collar, puller lifting -----	1
#19	C50036 R	Collar, stop -----	1
20	660-220	"O" Ring -----	1
21	C50077 B	Stud, screw -----	1
22	C50077 C	Sleeve, stop -----	1
23	660-416	Ring, retaining -----	2
24	C50036 AJ	Pin, roller lifter -----	1
25	C50078 F	Bracket, mounting -----	1
26	88 F	Screw -----	2
27	8372 A	Washer -----	2
28	C50042 Z-18	Sprocket -----	1
29	51242 L	Washer -----	1
30	28633 L	Spring -----	1
#31	98	Screw, set (required to replace screw in Ref. No. 19)	1
32	39656 A	Knife, chain cutting -----	1
33	604	Screw -----	1

Ref. Nos. 1 thru 33 can be ordered under Assembly No. 29476 PH.

34	AS22 D	Screw -----	1
35	22526	Screw -----	4
36	C50076	Roller, lower -----	1
37	C50078 R	Plate, feed -----	1
38	C50074	Pin -----	1
39	22894 W	Screw, set -----	2
40	660-330	Ring, retaining -----	2
41	6042 A	Washer -----	3
42	C50078 U	Block, bearing -----	2
*	C50078 AF-5	Shim (not shown) -----	1
*	C50078 AF-10	Shim (not shown) -----	1

*Use as required between Ref. Nos. 37 and 42 if necessary to level roller.

Ref. Nos. 34 thru 42 and Shims can be ordered under Assembly No. 29476 PJ.



SECTION A-A

Use as required between Ref. Nos. 37 and 42 if necessary to level roller.
 Ref. Nos. 34 thru 42 and Shim can be ordered under Assembly No. 29475 P1.

PULLER DRIVE ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1	C50042 AF	Belt, timing -----	1
2	C50078 M	Gear -----	1
3	C50078 H	Housing, bearing -----	1
4	22524	Screw -----	6
5	660-914	Spring, finger -----	2
6	C50078 L	Gear, internal -----	1
7	C50082 AP	Cover -----	1
8	660-918	Ring, retaining -----	1
9	660-886 A	"O" Ring -----	2
10	660-890	Bearing, ball -----	1
11	660-891 B	Ring, snap -----	2
12	660-889	Bearing, cage -----	1
13	22593	Screw -----	1
14	C50078 N	Ring, guide -----	1
15	660-886 B	"O" Ring -----	1
16	C50078 G	Housing -----	1
17	C50042 AC-16	Sprocket -----	1
18	660-886 C	"O" Ring -----	1
19	660-888	Bearing, ball -----	1
20	22894 J	Screw, set -----	1
21	660-891 C	Ring, snap -----	1
22	C50078 P	Housing, eccentric -----	1
23	660-892 C	Bearing -----	1
24	22574 D	Screw -----	1
25	59451 F	Washer -----	1
26	C50082 AR	Cover -----	1
27	C50022 L	Shaft, eccentric drive -----	1
28	C50078 J	Block, slide -----	1
29	136	Screw -----	2

Ref. Nos. 1 thru 29 can be ordered under Assembly No. 29476 PK.

ADDITIONAL PARTS FOR PULLER

<u>Parts No.</u>	<u>Description</u>	<u>Amt. Req.</u>
22569	Screw -----	9
C50042 AG	Belt, timing -----	1
50382 V	Cover, feed chamber -----	1
50382 U	Gasket for 50382 V -----	1
37-70 BLK	Blank, trough -----	1
671 F-64	Fitting, extension -----	1
RM 3633-1	Fitting "L" adjustable -----	1
RM 2964 B	Washer for 671 F-64 -----	1
671 F-19	Connector, 10-32 to 1/8 -----	1
C50082 K	Gasket, for puller drive -----	1
670 E-2	Ties, cable -----	2
C50093 CS	Protector, tube -----	1
22824 B	Screw, for C50093 CS -----	1
53634 C	Washer -----	1
C50094 AG	Oil Tube Assembly -----	1
21375 BX	Guard, upper belt -----	1
22825	Screw -----	3
21375 BY	Cover for 21375 BX -----	1
604	Screw -----	4
50382 R	Cover, head -----	1
50322 F	Shaft, presser foot lift -----	1
C50077 E	Lever, lifter -----	1
C50077 F	Link, connecting -----	1
22758	Screw -----	2
660-718	Washer -----	2
C50077 G	Lever, roller lifter -----	1
C50078 AD	Spacer -----	1
22557 J	Screw -----	1
C50042 Z-17	Sprocket -----	1
660-885	Crimp, ring for oil tube -----	4
C50082 N	Gasket for 29476 PK -----	1

PULLER SPROCKETS COMBINATIONS

These charts show the stitch length produced by available sprocket combinations. Sprockets furnished in the machines produces approximately 9.2 S.P.I. If a different stitch length is required, refer to the chart for appropriate dash number when ordering sprockets-C500042-Z-().

ROLLER PULLER

DRIVEN SPROCKET	NUMBER OF STITCHES PER INCH								
	-18	-17	-16	-15	-14	-13	-12	-11	-10
-18	14.69SPI (1.73MM)	13.37SPI (1.90MM)	12.25SPI (2.07MM)	11.30SPI (2.25MM)	10.50SPI (2.42MM)	9.80SPI (2.59MM)	9.18SPI (2.77MM)	8.65SPI (2.94MM)	
-17	13.87SPI (1.83MM)	12.62SPI (2.01MM)	11.56SPI (2.20MM)	10.67SPI (2.38MM)	9.91SPI (2.56MM)	9.25SPI (2.75MM)	8.67SPI (2.93MM)	8.16SPI (3.11MM)	7.71SPI (3.30MM)
-16	13.06SPI (1.94MM)	11.88SPI (2.13MM)	10.89SPI (2.33MM)	10.05SPI (2.53MM)	9.34SPI (2.72MM)	8.71SPI (2.92MM)	8.16SPI (3.11MM)	7.69SPI (3.30MM)	7.26SPI (3.50MM)
-15		11.14SPI (2.28MM)	10.21SPI (2.49MM)	9.42SPI (2.70MM)	8.75SPI (2.90MM)	8.16SPI (3.11MM)	7.65SPI (3.32MM)	7.21SPI (3.52MM)	6.80SPI (3.73MM)
-14			9.52SPI (2.67MM)	8.76SPI (2.89MM)	8.16SPI (3.11MM)	7.62SPI (3.33MM)	7.14SPI (3.56MM)	6.72SPI (3.78MM)	6.35SPI (4.00MM)
-13				8.16SPI (3.11MM)	7.59SPI (3.35MM)	7.08SPI (3.59MM)	6.63SPI (3.83MM)	6.25SPI (4.07MM)	5.90SPI (4.31MM)
-12					7.00SPI (3.63MM)	6.53SPI (3.89MM)	6.12SPI (4.15MM)	5.76SPI (4.41MM)	5.44SPI (4.67MM)
-11						5.98SPI (4.24MM)	5.61SPI (4.53MM)	5.28SPI (4.81MM)	4.99SPI (5.09MM)
-10							5.10SPI (4.98MM)	4.81SPI (5.28MM)	4.54SPI (5.60MM)
	-10	-11	-12	-13	-14	-15	-16	-17	-18

BELT PULLER

DRIVEN SPROCKET	NUMBER OF STITCHES PER INCH								
	-18	-17	-16	-15	-14	-13	-12	-11	-10
-18	13.10SPI (1.94MM)	11.92SPI (2.13MM)	10.92SPI (2.33MM)	10.08SPI (2.52MM)	9.37SPI (2.71MM)	8.74SPI (2.91MM)	8.19SPI (3.10MM)	7.71SPI (3.29MM)	
-17	12.37SPI (2.05MM)	11.26SPI (2.26MM)	10.31SPI (2.46MM)	9.52SPI (2.67MM)	8.84SPI (2.87MM)	8.25SPI (3.08MM)	7.73SPI (3.28MM)	7.28SPI (3.49MM)	6.88SPI (3.69MM)
-16	11.65SPI (2.18MM)	10.60SPI (2.40MM)	9.71SPI (2.62MM)	8.96SPI (2.83MM)	8.33SPI (3.05MM)	7.77SPI (3.27MM)	7.28SPI (3.49MM)	6.86SPI (3.70MM)	6.48SPI (3.92MM)
-15		9.94SPI (2.56MM)	9.10SPI (2.79MM)	8.40SPI (3.02MM)	7.81SPI (3.25MM)	7.28SPI (3.49MM)	6.83SPI (3.72MM)	6.43SPI (3.95MM)	6.07SPI (4.19MM)
-14			8.49SPI (2.99MM)	7.84SPI (3.24MM)	7.28SPI (3.49MM)	6.79SPI (3.74MM)	6.37SPI (3.99MM)	6.00SPI (4.24MM)	5.66SPI (4.49MM)
-13				7.28SPI (3.49MM)	6.77SPI (3.75MM)	6.31SPI (4.02MM)	5.92SPI (4.29MM)	5.57SPI (4.56MM)	5.26SPI (4.83MM)
-12					6.24SPI (4.07MM)	5.83SPI (4.36MM)	5.46SPI (4.65MM)	5.14SPI (4.94MM)	4.86SPI (5.23MM)
-11						5.34SPI (4.76MM)	5.00SPI (5.08MM)	4.71SPI (5.39MM)	4.45SPI (5.71MM)
-10							4.55SPI (5.58MM)	4.29SPI (5.92MM)	4.05SPI (6.27MM)
	-10	-11	-12	-13	-14	-15	-16	-17	-18

SEWING COMBINATIONS

<u>Style</u>	<u>Presser Foot</u>	<u>Feed Dog</u>	<u>Throat Plate</u>	<u>Looper</u>
LF611K100MF	C50020 C	C50005 F	50324	G51409 C
LF611K100MG	G51320	51305 A	G51324	G51409 C
LF611K100MR	56320 H	51305 W	C51324 W	G51409 C
LF611K100MW	51220 W	51205 W	C56224 A	51208 W
LF611K100MAW	56320 E	56305 C	C56324 A	G51409 C
LF611K112MF	C50020	C50005 F	50324	G51409 C
LF611K112MG	G51320	C50005 F	C50024 D	G51409 C
LF611K101MF	C50020	C50005 F	50324	G51409 C
LF611K118MF	C50020	C50005 F	50324	G51409 C
LF611K151MF	C50020	C50005 F	50324	G51409 C
LF611K152MF	C50020	C50005 F	50324	G51409 C

* * * * *

<u>Style</u>	<u>Presser Foot</u>	<u>Feed Dog</u>	<u>Differential Feed Dog</u>	<u>Throat Plate</u>	<u>Looper</u>
LF632K200MV-8	52820 H-8	50305 E	50326 E	C57824A-8	50309
LF632K200MV-12	52820 H-12	50305 E	50326 E	C57824A-12	50309
LF633K200MM-16	57820-16	50305	50326	57824E-16	50309
LF633K200MN-16	57820-16	50305 E	50326 D	57824E-16	50309
LF633K200MW-16	52820 K-16	50305 D	50326 C	C52828K-16	50309

Notes: _____

39