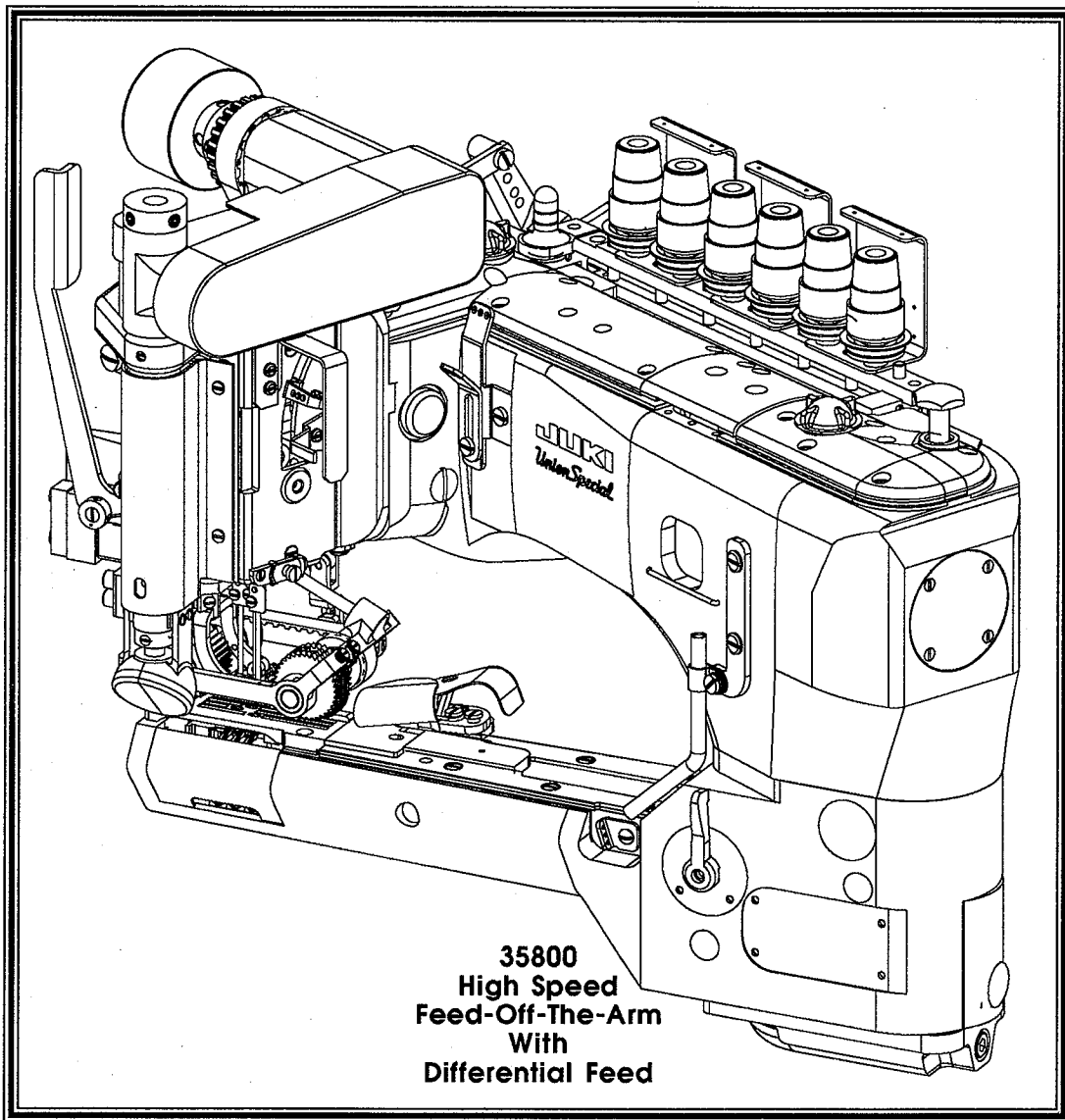




Union Special

INDUSTRIAL SEWING EQUIPMENT

OPERATOR'S / ILLUSTRATED PARTS MANUAL



MANUAL NO. PT9629

STYLES

**35800FPP
35800FP**

Manual No. PT9629 Operator's & Illustrated Parts Manual Supplement to Manual PT9640

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By

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Printed in U.S.A.

APPLICATION OF MANUALS

This parts manual has been prepared to assist you in locating individual parts or assemblies on machines.

It is the desire of Union Special that each machine run at its optimum performance. Parts listed in this manual are designed specifically for your machine and are manufactured with utmost precision to assure long lasting service.

IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine is identified by a style number, which is stamped into the style plate affixed to the middle of the machine under the tension assembly. The serial number is stamped into the serial number plate affixed to the right rear base of the machine.

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

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

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. As an example refer to the following text.

5.	29126EC	Upper Looper Drive Shaft Assembly	1
6.	22503F	Screw	1
7.	39543E	Cam Follower Locking Clamp	1

When a part is common to all machines covered in this manual, 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 description and, if necessary, the difference will be shown in the illustration.

*Ref. No. showing no Part No. is for location only. Part is not for sale separately.

A numerical index of all the parts shown in this manual is located at the back. This will facilitate locating the illustration and description when only a part number is known.



IDENTIFYING PARTS

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

PLEASE NOTE: Part numbers represent the same part, regardless of which manual they appear. On all orders please include part number, name and style of machine for which the part was ordered.

For optimum performance use only genuine Union Special replacement parts.

CLASS DESCRIPTION

High speed, Feed-off-the-arm high throw machines, three needle, left needle in front. Light weight presser bar mechanism. Presser and roller bars are equipped with double acting air cylinders, air is used to supply down pressure and lift foot and roller assemblies for style 35800FPP. Adjustable looper avoid, double disc looper thread take-up, automatic enclosed type oiling system and filter type oil pump, visual sight oil action and supply gauges, .529 (17/32, 13.4mm) wide rear roller.

STYLE OF MACHINES

35800FPP DOUBLE LAP SEAM. Three needle, high capacity, differential feed, high lift feed eccentric, with upper driven. Rear roller located behind needles and upper driven front roller located in front of needles. - Typical Application - For in and out seaming on heavy weight denim garments. Seam specifications 401 LSc-2 or LSc-3. Standard gauge 9 (9/64, 3.6mm). Recommended needle 130GS, size 140/054. Maximum recommended speed 4500 R.P.M.. .094 step sewing parts.

35800FP DOUBLE LAP SEAM. Same as 35800FPP except without air.

NEEDLES

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

TYPE

DESCRIPTION

130 GS Short, double groove, struck groove, ball eye, spotted, government point, chromium plated.
- Sizes available 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060.

When changing the needle, make sure it is fully inserted in the needle holder before the screw is tightened.

When ordering needles, please use the complete type and size numbers as printed on the package to ensure prompt and accurate processing of your order. A complete order should read as follows: "100 needles, type 130 GS, size 125/049".



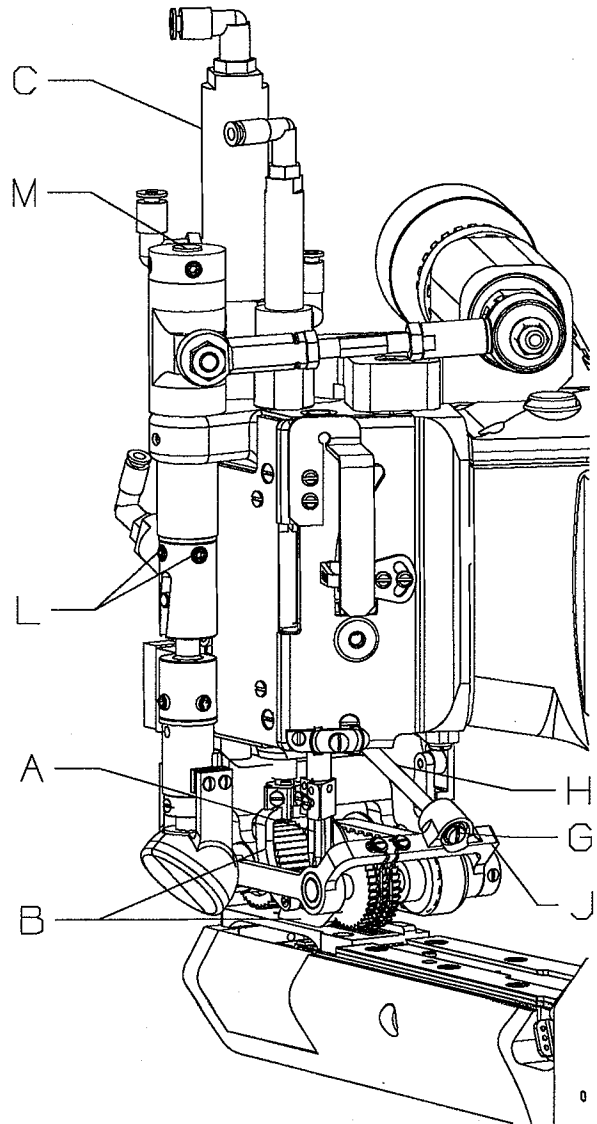
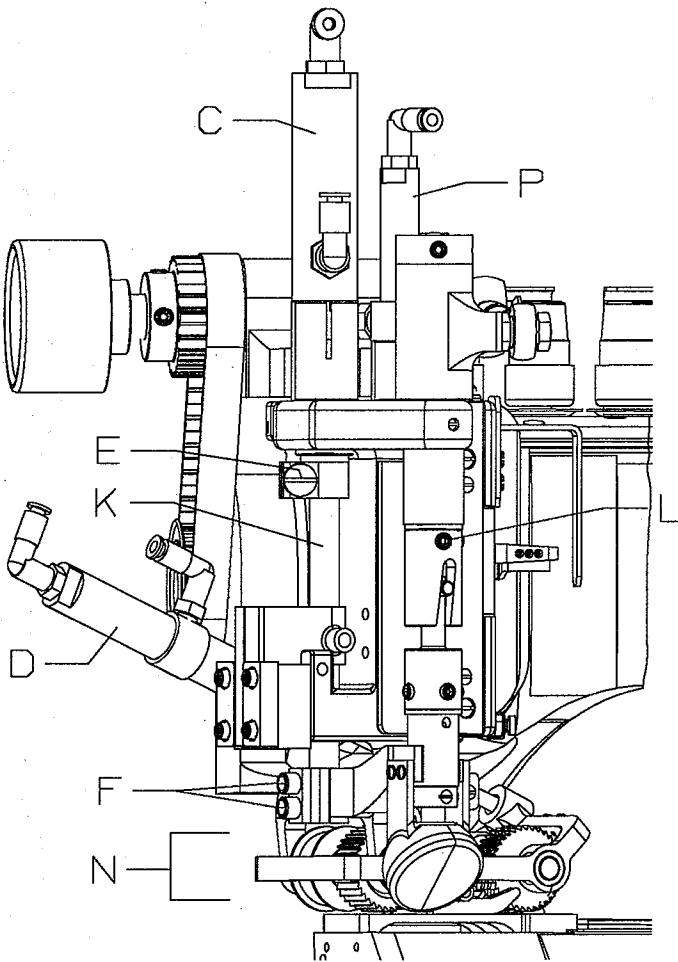
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FEED ROLLER MECHANISM REMOVAL

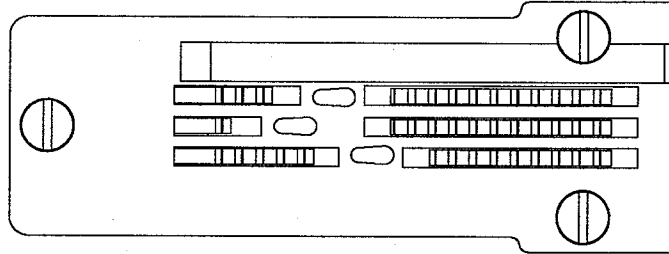
1. Remove needles (A)
2. Shut off air pressure to cylinder (C)
3. Shut off air pressure to cylinder (D)
4. Shut off air pressure to cylinder (P)
5. Remove presser foot & presser foot yoke (B)
6. Loosen screw (E)
7. Loosen two screws (F)
8. Remove screw (G) and washers (steel & rubber)
- *9. Slide cylinder shaft (H) out of roller bracket (J)
10. Raise cylinder puller shaft (K) up and out of bracket
11. Loosen upper coupling screws (L)
12. Remove drive puller shaft (M)
13. Remove entire mechanism (N)



* SEE CAT. PT9640 FOR INSTRUCTIONS

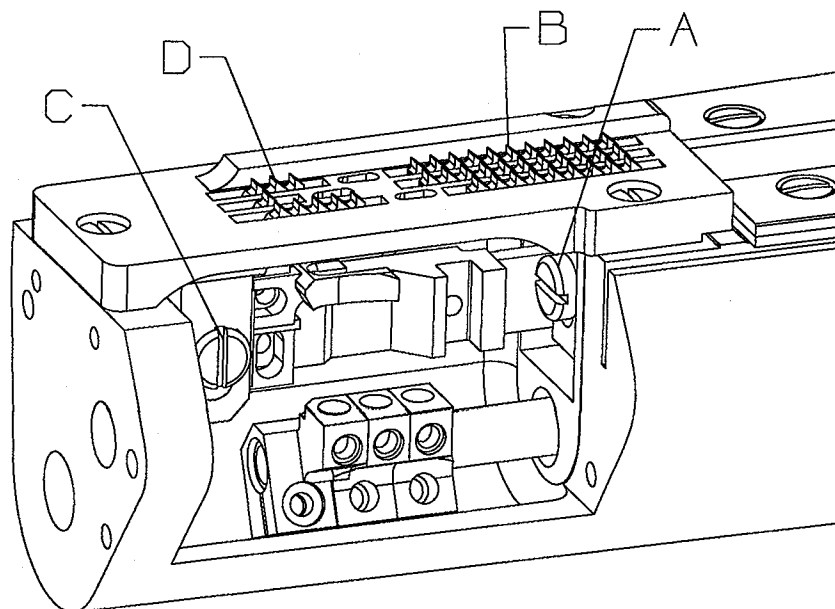
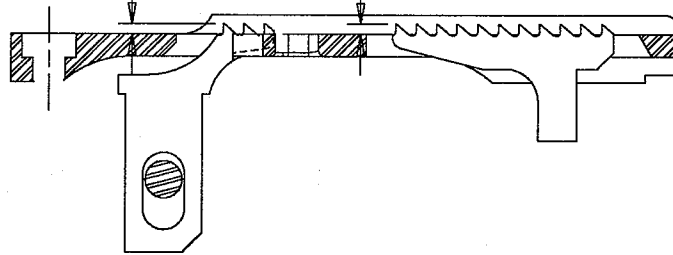
ADJUSTING FEED DOGS

1. To adjust feed dogs set needles at top of stroke.
2. Loosen screw (A) and move differential feed dog (B) up or down, so that top of feed dog is one full tooth above throat plate.
3. Retighten screw (A).
4. Loosen screw (C) and move main feed dog (D) up or down, so that top of feed dog is one full tooth above throat plate.
5. Retighten screw (C).



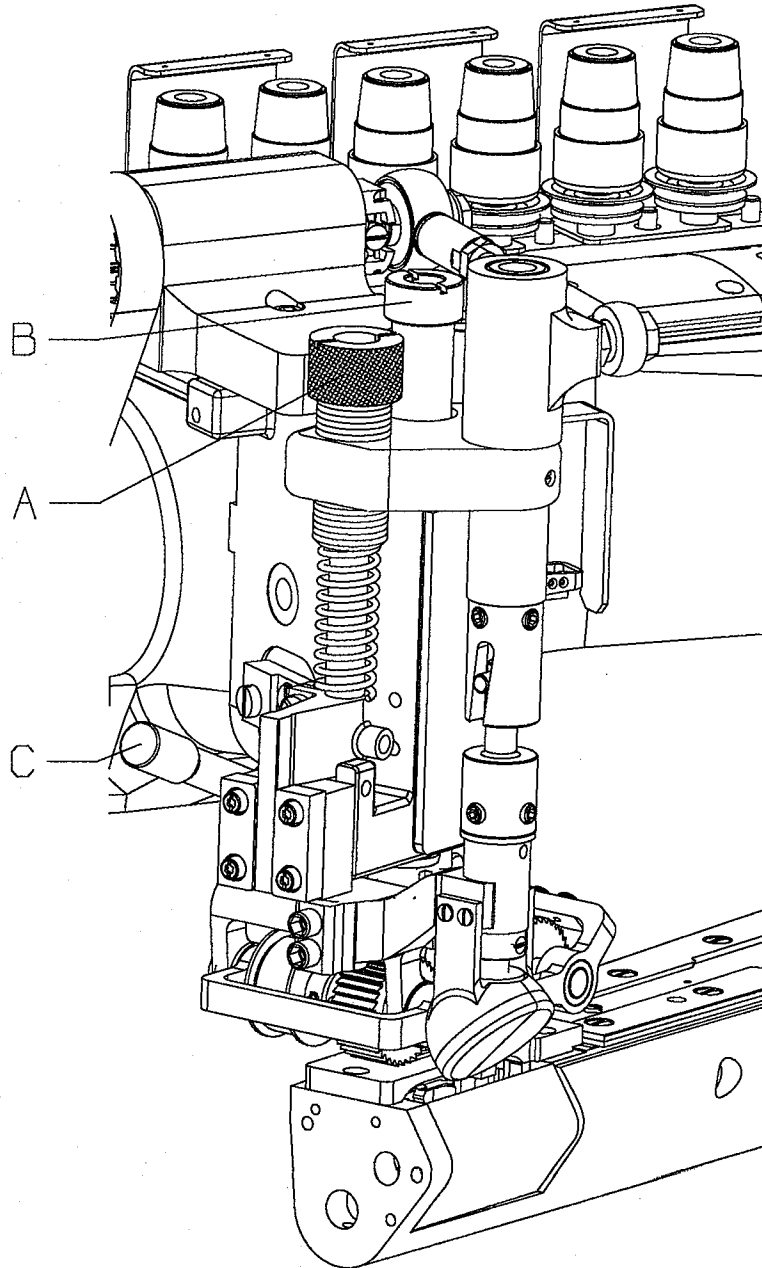
FULL TOOTH ABOVE THROAT PLATE

ONE TOOTH ABOVE THROAT PLATE



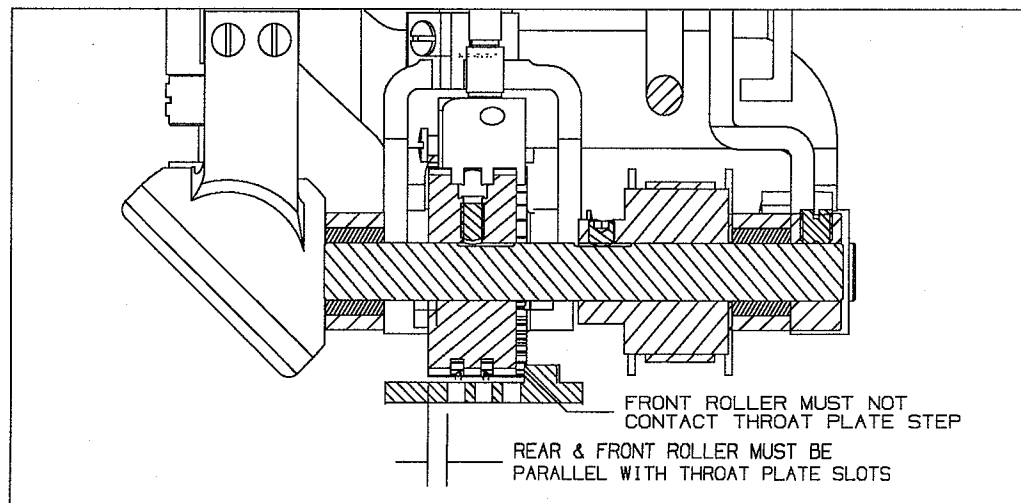
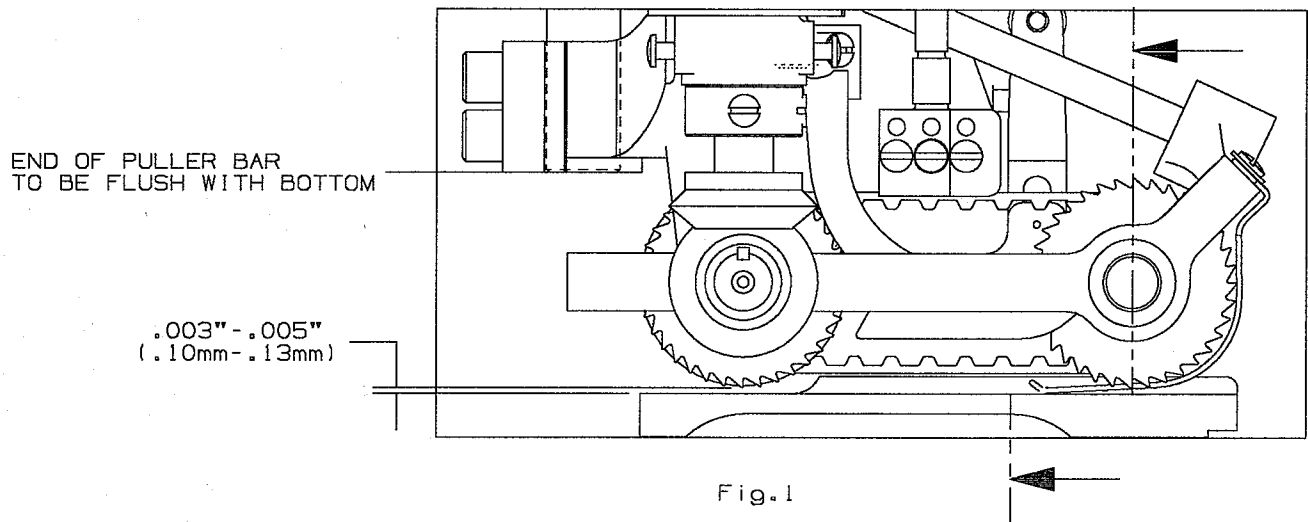
SETTING PRESSURE FOR FEED ROLLER AND PRESSER FOOT (ON NON PNEUMATIC MACHINES)

1. Regulate the pressure on the feed roller and presser foot so that it exerts only enough pressure on the fabric to feed the work uniformly.
2. Turning roller presser spring regulator knob (A) clockwise to increase or counterclockwise to decrease the pressure.
3. Turning presser foot spring regulator knob (B) clockwise to increase or counterclockwise to decrease the pressure.
4. Turning front roller spring regulator knob (C) clockwise to increase or counterclockwise to decrease the pressure.



ALIGNING AND ADJUSTING ROLLER MECHANISM

1. When feed roller mechanism (C, Fig. 3) has been removed or replaced, .003" (0.10mm) minimum to .005" (0.13mm) maximum clearance should be maintained between rear roller and throat plate, see (Fig. 1).
2. Rear roller and front roller must be parallel to slots on throat plate, see (Fig. 2).
3. Guide plates (F, Fig. 3) must be thrust against guide finger (B, Fig. 3) to secure feed roller mechanism (C, Fig. 3).



ALIGNING AND ADJUSTING ROLLER MECHANISM (CONT.)

1. Loosen two screws (A, Fig. 3). Using shim(s) adjust feed roller mechanism (C, Fig. 3) so that the rear roller is .003" (0.08mm) to .005" (0.13mm) above throat plate. Slide rear guide finger (B, Fig. 3) down so that it sits on top of rear guide support block (D, Fig. 3). Check to make sure rear and front rollers are parallel to throat plate slots. Tighten two screws (A, Fig. 3) to secure feed roller mechanism in place.
2. Thrust guide plates (F, Fig. 3) against guide finger (B, Fig. 3) with equal pressure. Tighten four screws (E, Fig. 3) to hold plates in place.

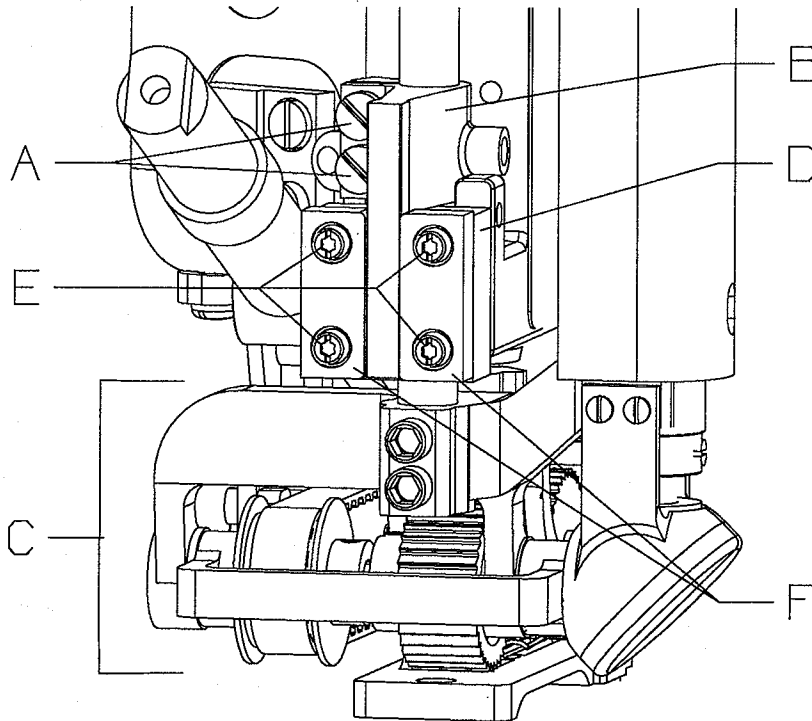


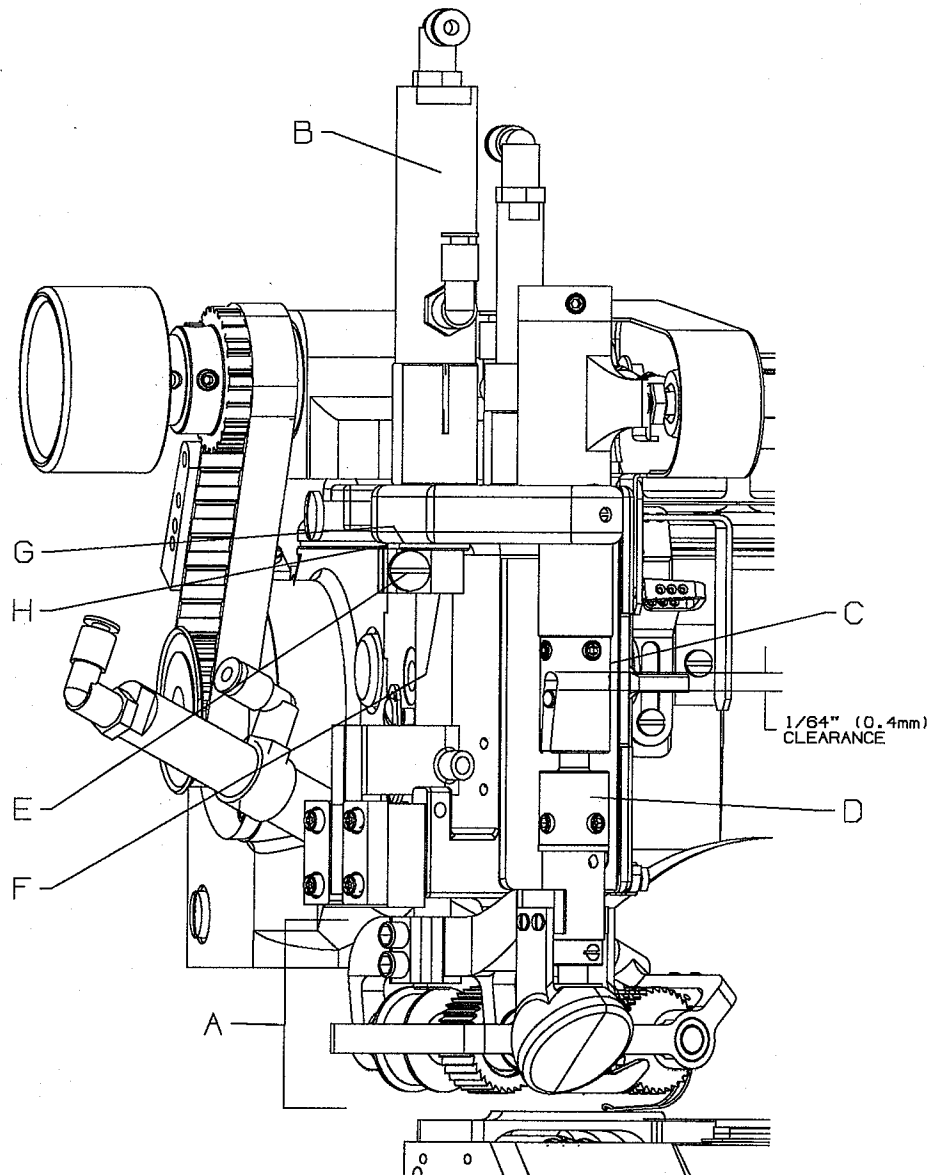
Fig.3

ADJUSTING STOP COLLAR ON FEED ROLLER FOR PNEUMATIC ROLLER IN FRONT OF NEEDLE MACHINES

(PNEUMATIC MACHINES ONLY)

When feed roller mechanism (A) and/or puller shaft cylinder assembly (B) has been removed or replaced, 1/64" (0.4mm) clearance should be maintained between upper connection (C) and lower feed roller connection (D) when feed roller mechanism is in up position.

Turn off air supply to puller shaft air cylinder assembly (B). Loosen screw (E). Lift feed roller mechanism (A) until there is 1/64" (0.4mm) clearance between upper connection (C) and lower feed roller connection (D). Slide roller stop collar (F) and rubber washer (H) up until they contact the underside of head assembly (G). Retighten screw (E).



SETTING PRESSER BAR STOP COLLAR

(PNEUMATIC MACHINES ONLY)

When presser bar air assembly (A, Fig. 2) and/or presser bar (B, Fig. 2) has been removed or replaced, presser bar stop collar (F, Fig. 2) must be reset. Stop collar must be set so that there is a minimum of $1/32"$ (0.8mm) clearance between top of presser foot (C) and needle bar head (D). The clearance setting must be done with needle bar at bottom of stroke.

Turn air supply off to presser foot air cylinder assembly (A). Loosen screw (E) on presser foot stop collar (F). Turn handwheel (G) until needle bar (D, Fig. 1) is at bottom of stroke. Lift presser foot (C, Fig. 1) up until there is $1/32"$ (0.8mm) clearance between needle bar (D, Fig. 1) and rubber washer (H) up until they contact underside of head. Retighten screw (E).

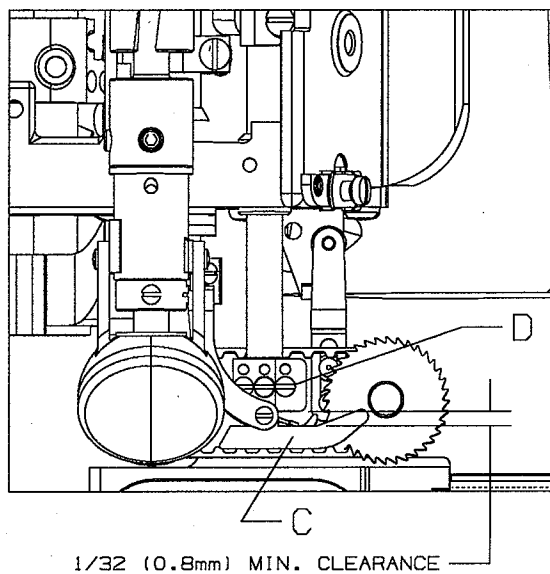


Fig. 1

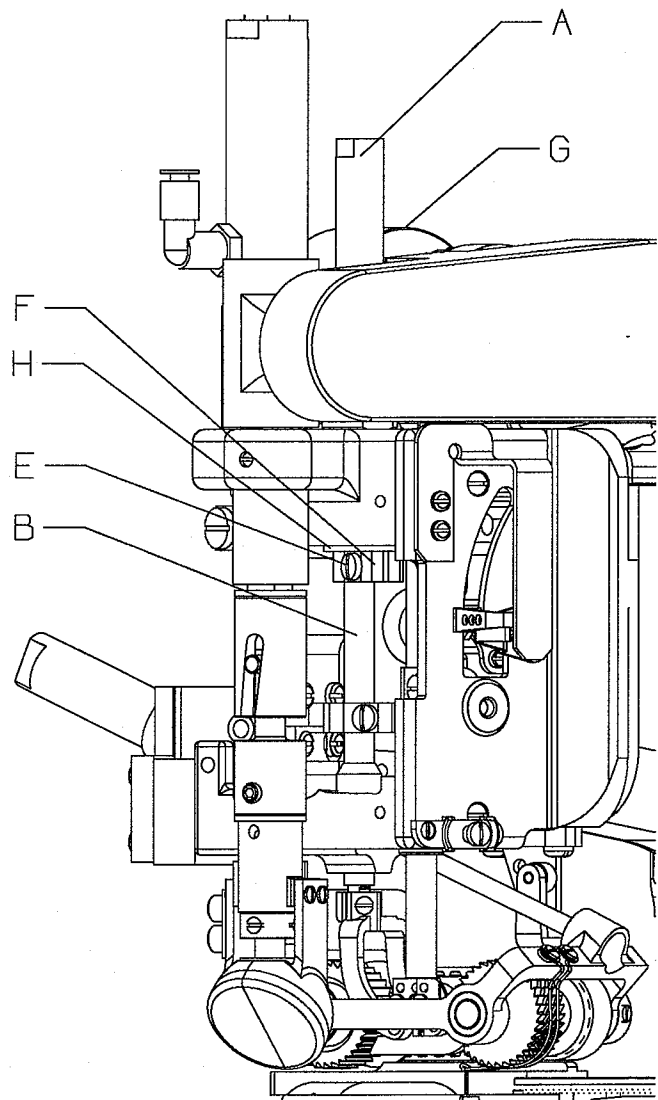


Fig. 2

FOLDER ADJUSTMENT

The suggested distance between the folder (A, Fig. 1) and the front roller (B, Fig. 1) is $3/16"$ (4.76mm) minimum or as needed depending on material thickness and/or application.

Slide folder (A, Fig. 1) until it contacts extension plate (C, Fig. 1). Adjust scroll support (D, Fig. 3) so there is a minimum of $3/16"$ (4.76mm) space between front roller (B, Fig. 1) and folder (A, Fig. 1).

To adjust scroll support (D, Fig. 3), remove scroll support screws (E, Fig. 3) and position scroll support (D, Fig. 3) in desired location. Replace screws (E, Fig. 3) in corresponding holes and retighten.

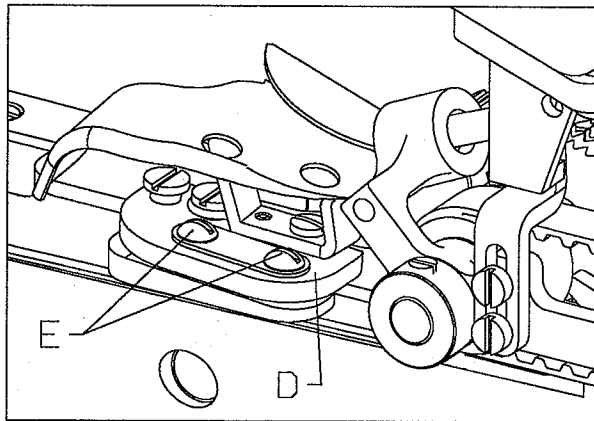


Fig. 3

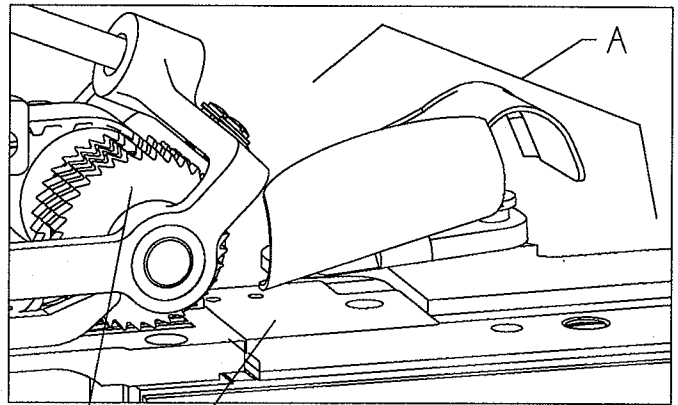


Fig. 1

$3/16"$ (4.76mm) minimum or as needed
depending on material thickness

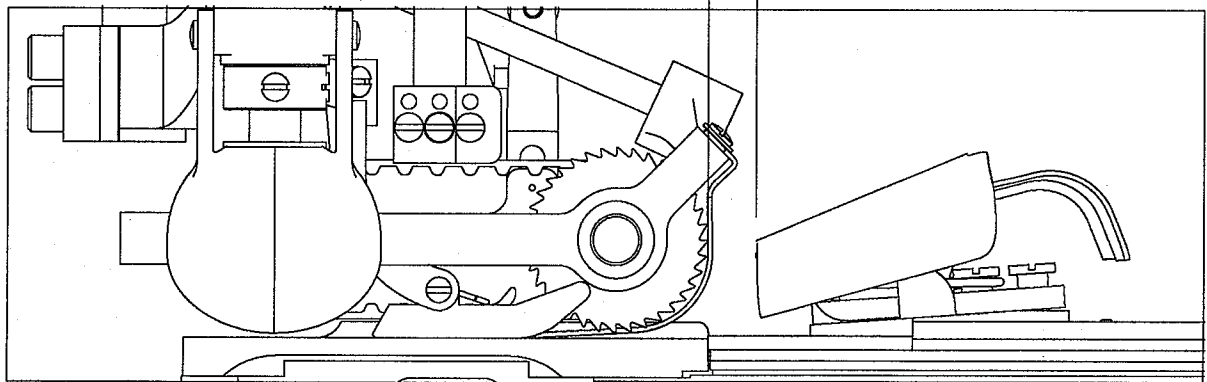


Fig. 2

PNEUMATIC SETTINGS AND HOOK UP

Pneumatic settings can vary between different sewing applications. For best results set all air lines and air pressure settings as in (Fig. 1a).

Air pressure settings should be set with air regulators as is shown in (Fig. 1a).

If air lines are disconnected follow connection as in (Fig. 1).

Air lines should be attached with each end of line to corresponding letter see (Fig. 1).

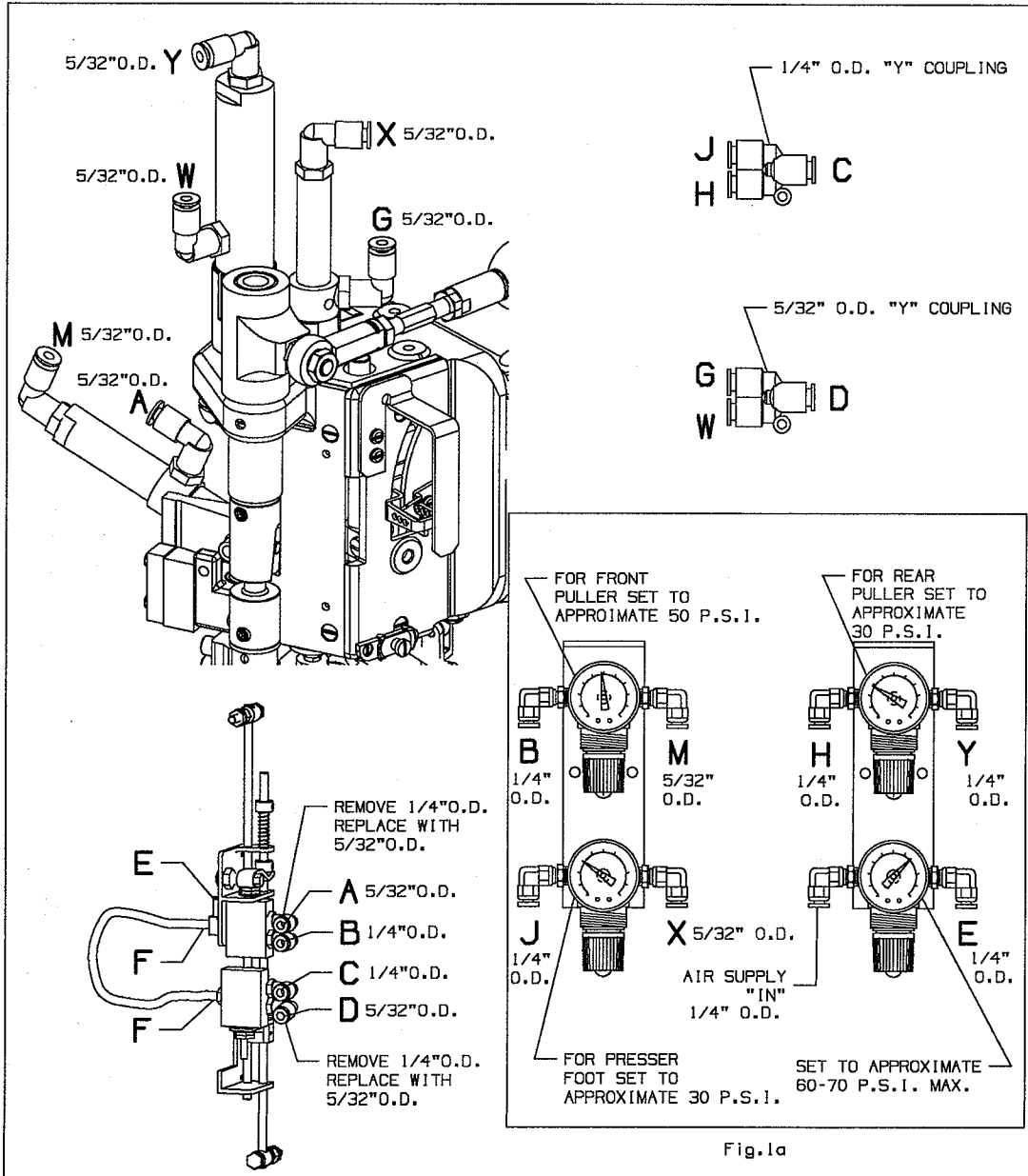
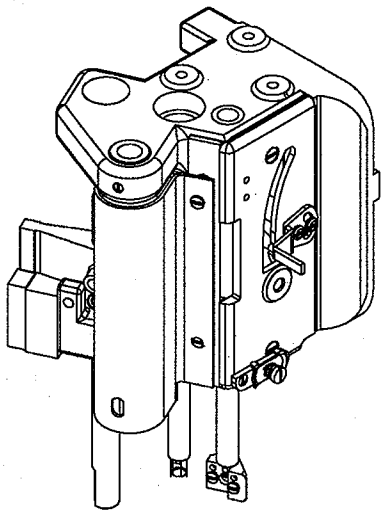
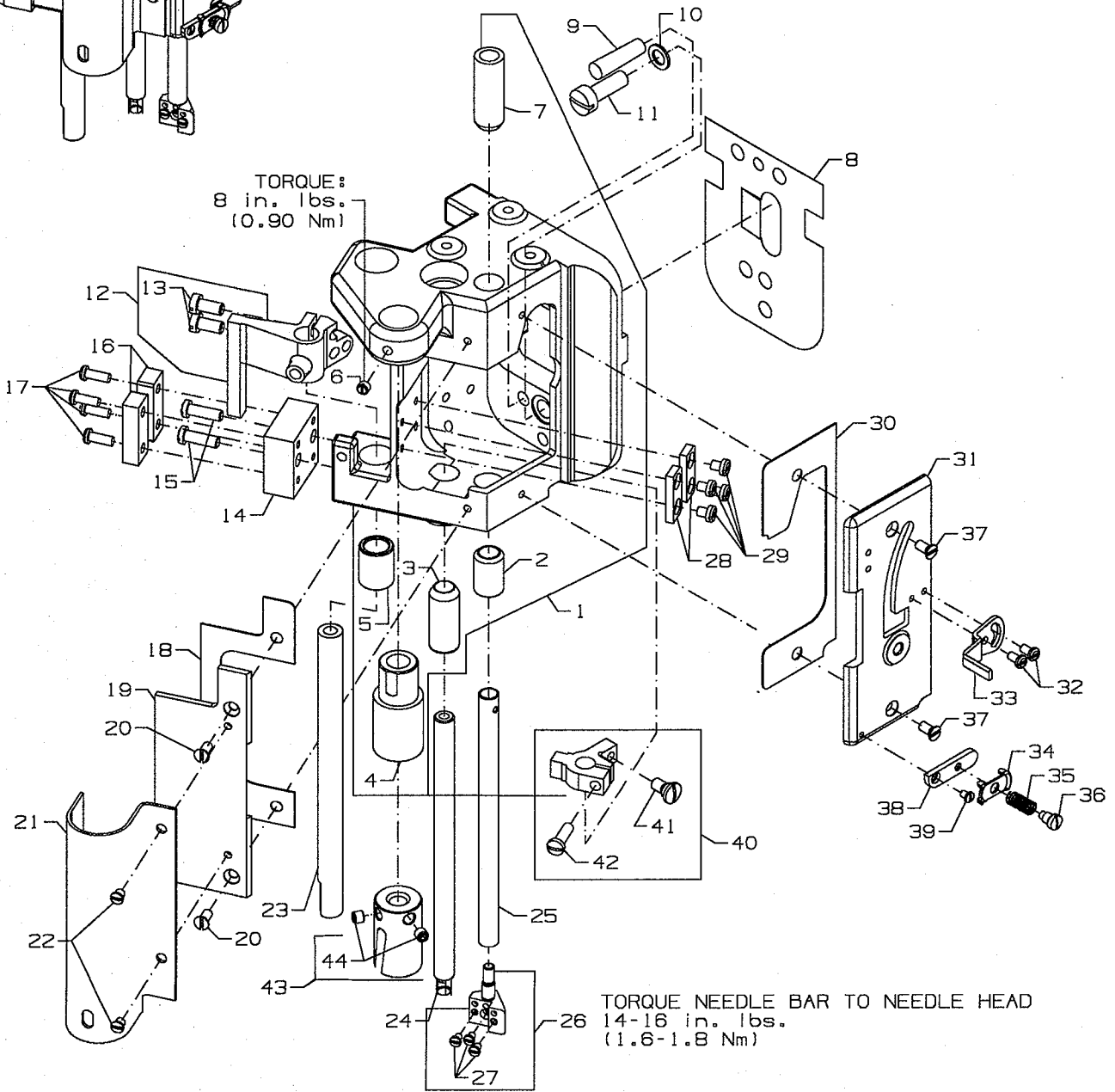


Fig.1





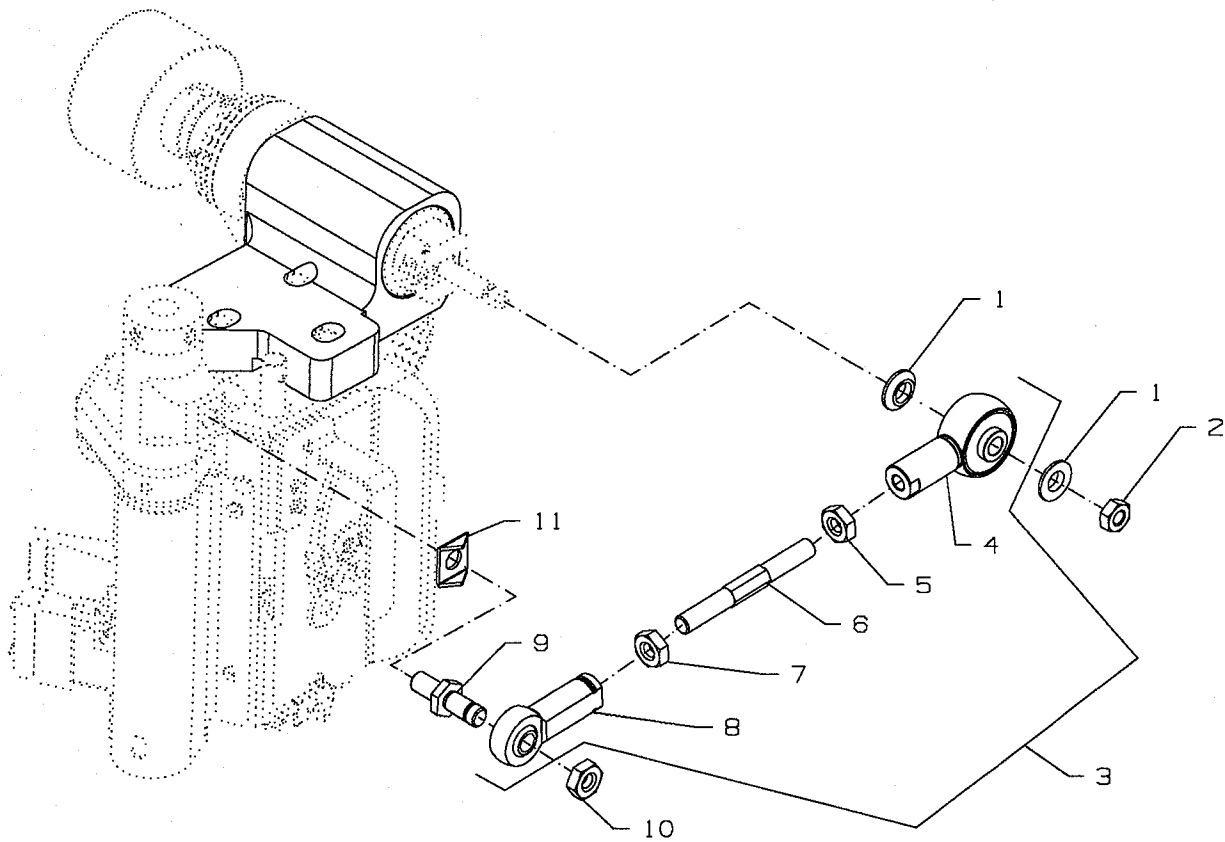
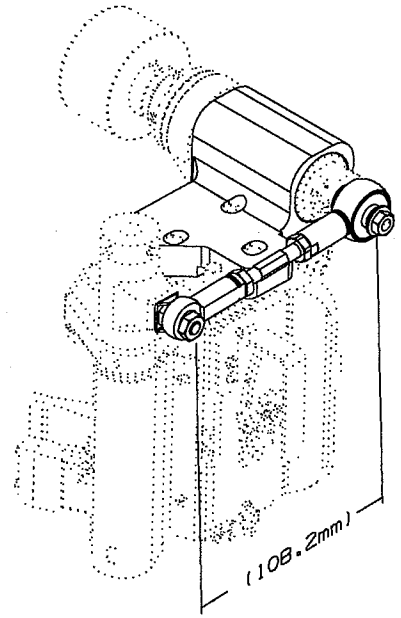
TORQUE:
8 in. lbs.
(0.90 Nm)



DETACHABLE HEAD ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	35829AN	Detachable Head Assembly	1
2.	35854B	Bushing	1
3.	35844N	Bushing	1
4.	35877AD	Bearing Sleeve Assembly	1
5.	35844T	Bushing	1
6.	SS8120410SP	Set screw	1
7.	35854A	Bushing	1
8.	35889G	Plate, baffle	1
9.	664F-16	Pin, taper	1
10.	6042A	Washer	1
11.	318	Screw	1
12.	35837P	Guide finger, rear	1
13.	SS6121010SP	Screw	2
14.	35838B	Block, support, rear guide	1
15.	SS7121410TP	Screw	2
16.	35838A	Plate, guide, roller bar	2
17.	SS4091015SP	Screw	4
18.	35884S	Gasket	1
19.	35882J	Cover, head, left	1
20.	22524	Screw	2
21.	35882H	Cover	1
22.	22564B	Screw	2
23.	35877AL	Roller Presser Bar	1
24.	35822AE	Presser Bar	1
25.	35817S	Needle Bar	1
26.	35818CB-9	Needle Head	1
27.	605	Screw	3
28.	35731A	Plate, guide, presser bar	2
29.	22513D	Screw	4
30.	35884T	Gasket	1
31.	35882K	Cover, head, front	1
32.	22768	Screw	2
33.	35870	Take-up, needle thread	1
34.	57WB	Nipper Plate, needle thread	1
35.	15438C	Spring	1
36.	57WD	Screw	1
37.	22524	Screw	2
38.	43296	Needle Thread Nipper Base	1
39.	605	Screw	1
40.	35843D	Presser Bar Lift Clamp	1
41.	SD0640241SP	Screw	1
42.	SS7111410TP	Screw	1
43.	35876AU	Connection, upper feed roller	1
44.	22894W	Screw	2

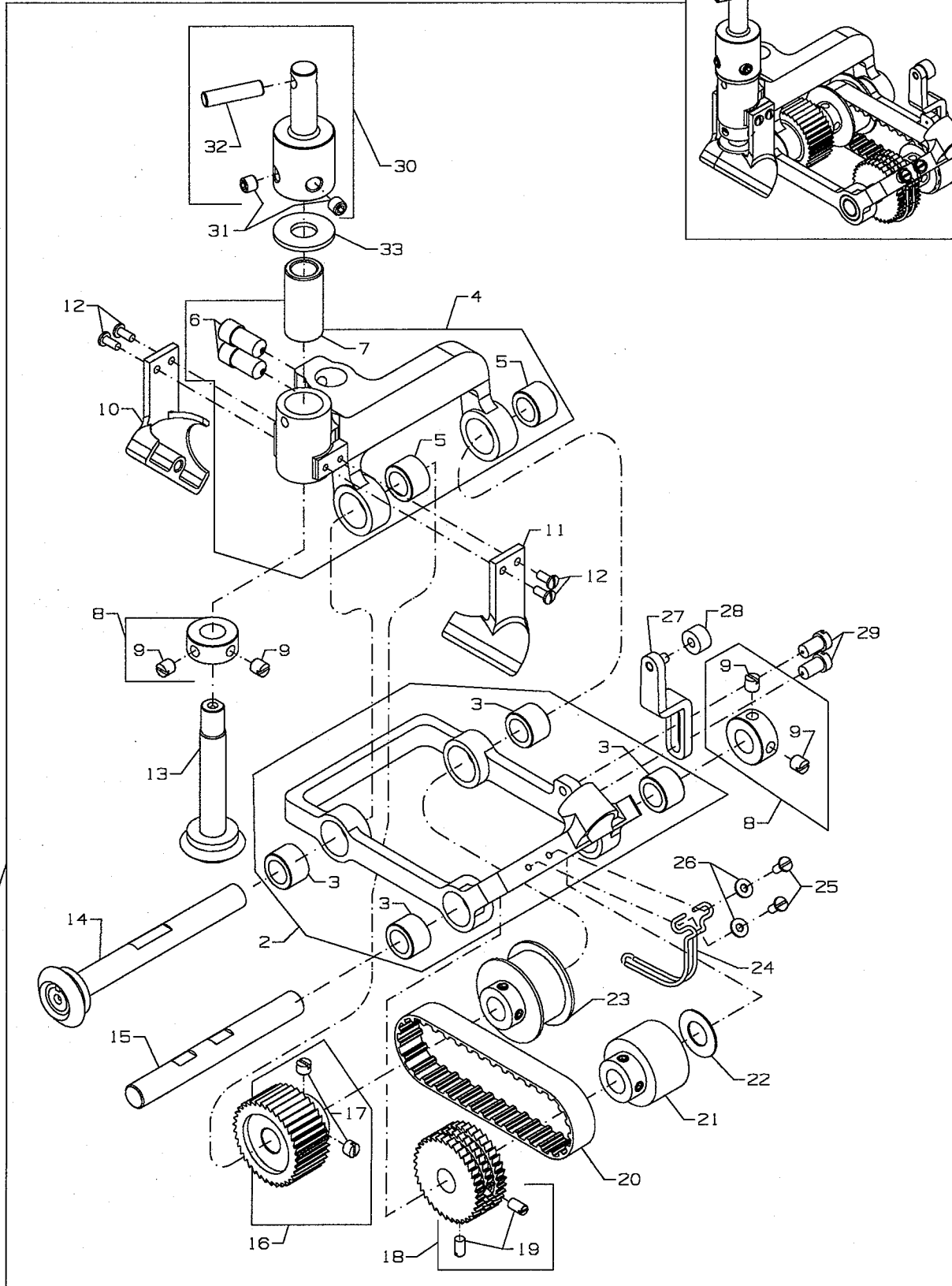




CONNECTING ROD ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	99622A	Washer	2
2.	18	Nut	1
3.	29478EM	Connecting Rod Assembly	1
4.	35844X	Bearing, rod end	1
5.	35887AK	Nut	1
6.	35845E	Connecting Rod	1
7.	35887AJ	Nut	1
8.	35844W	Rod End Bearing	1
9.	35837X	Stud	1
10.	35887AK	Nut	1
11.	35837W	Guide, Bearing	1

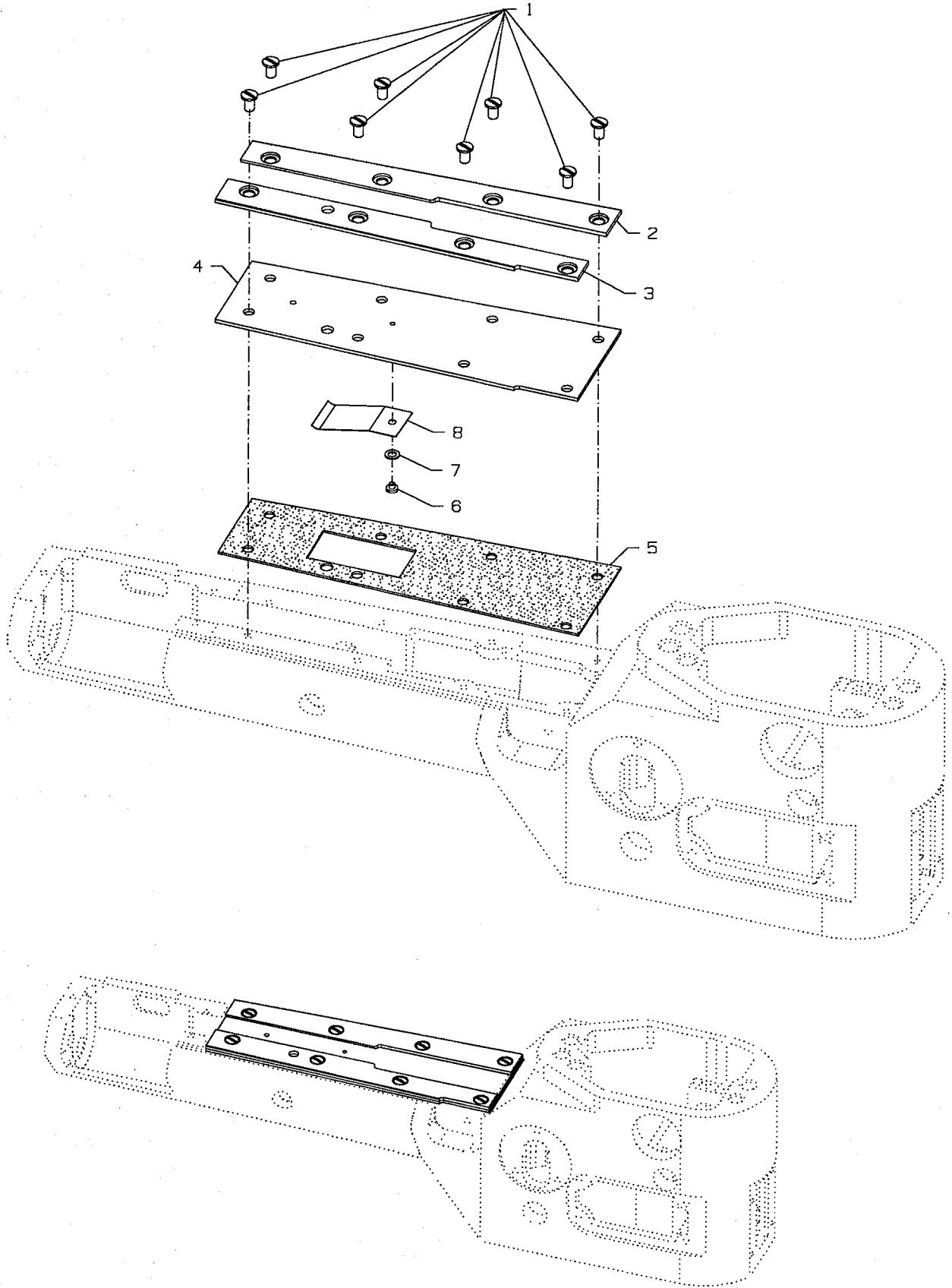




FEED ROLLER ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	29105BG	Feed Roller Assembly	1
2.	35883AD	Roller Frame	1
3.	35844M	Bearing	4
4.	35883AG	Roller Yoke	1
5.	35844M	Bearing	2
6.	SS6151142TP	Screw	1
7.	35844U	Bushing	3
8.	35883L	Thrust Collar	2
9.	SS8110520TP	Set Screw	4
10.	35882D	Gear Cover	1
11.	35882C	Gear Cover	1
12.	SS7060610SP	Screw	4
13.	35839D	Driver Miter Gear	1
14.	35839E	Driven Miter Gear	1
15.	35877AK	Shaft, front roller	1
16.	35876AR	Roller, rear	1
17.	SS8110410TP	Set Screw	2
18.	35876AS	Roller, front	1
19.	SS8080610SP	Set Screw	2
20.	35842N	Belt	1
21.	35876AN	Pulley, front	1
22.	61351C	Washer, thrust	1
23.	35876AP	Pulley, rear	1
24.	35878V	Guard, material	1
25.	SS7060610SP	Screw	2
26.	WP0250516SD	Washer	2
27.	35883AE	Bracket, height adjustment	1
28.	35837S	Bumper, nylon	1
29.	SS6090810TP	Screw	2
30.	35876AV	Feed Roller Driver Connection	1
31.	22894W	Screw	2
32.	667C12	Pin	1
33.	54274P	Washer	1

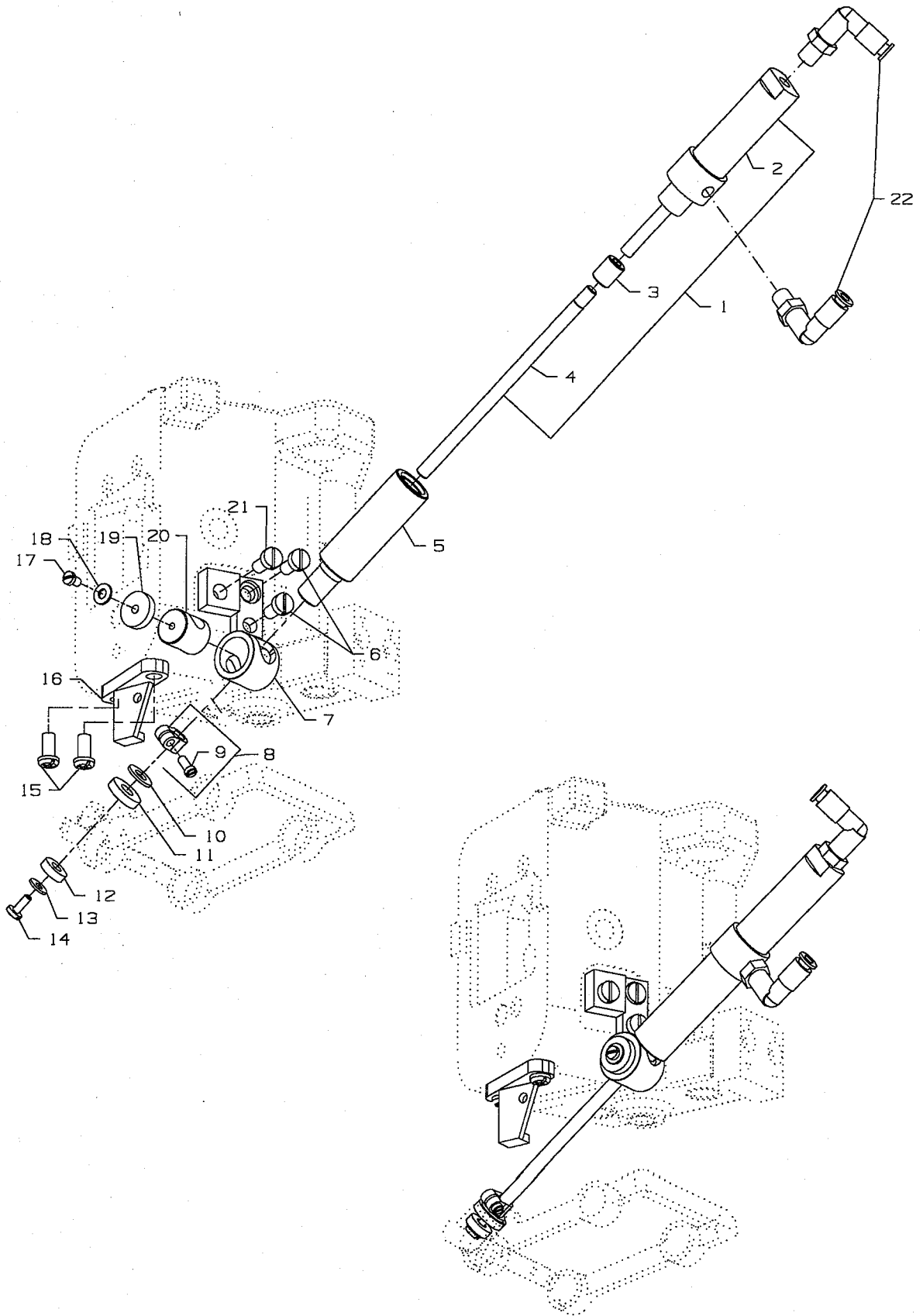




CYLINDER COVER, GASKET AND FOLDER GIBS

Ref. No.	Part No.	Description	Amt. Req.
1.	22564J	Screw	8
2.	35883PA	Folder Gib, right	1
3.	35883NA	Folder Gib, left	1
4.	35883TA	Cylinder Cover	1
5.	35883SA	Gasket	1
6.	22798	Screw	1
7.	27-435BLK	Washer	1
8.	36284E	Upper Lint Shield	1

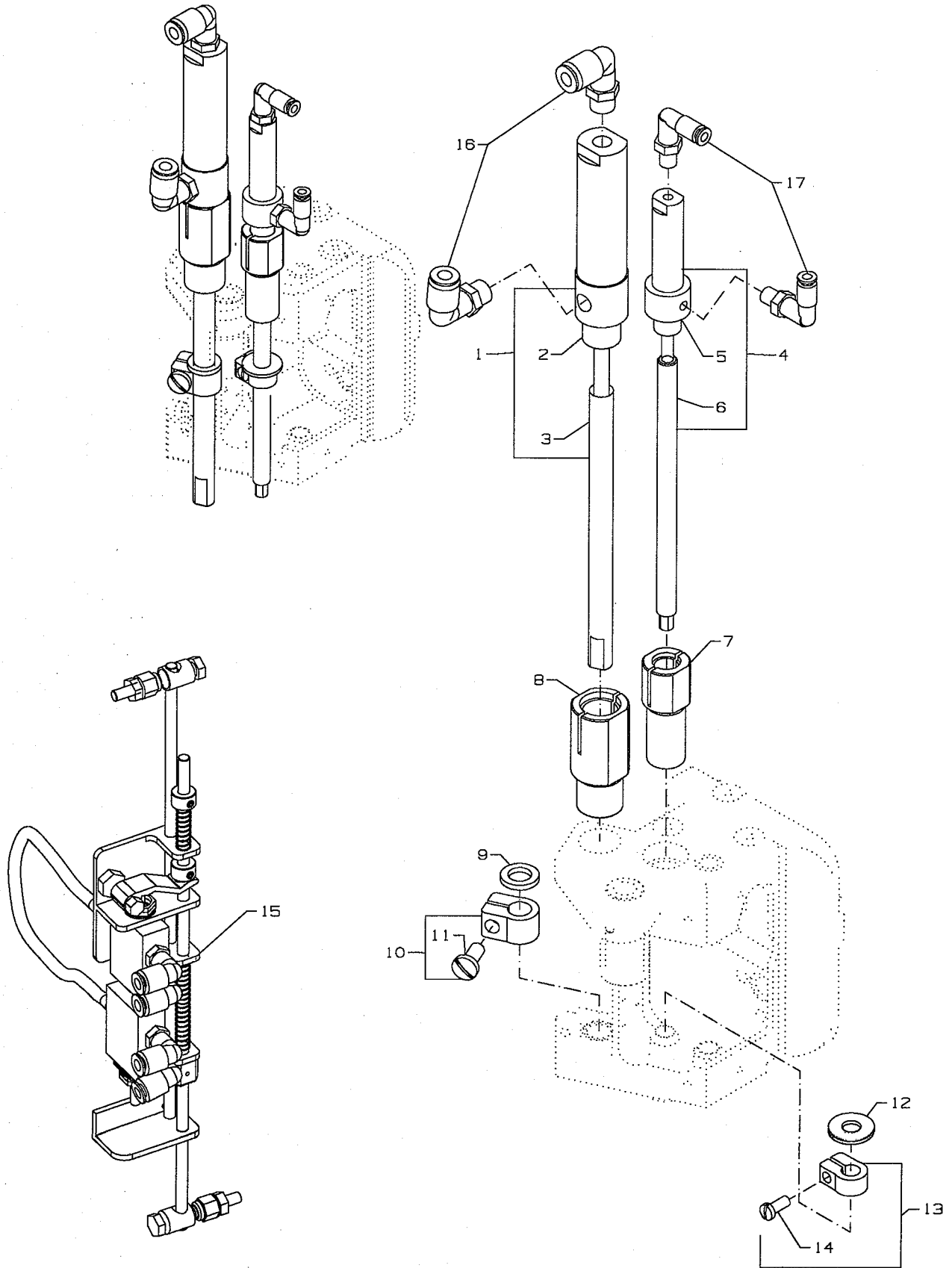




PNEUMATIC FRONT ROLLER ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	29476TD	Pneumatic Assembly	1
2.	671A358	Air Cylinder	1
3.	35883M	Coupling, air shaft	1
4.	35822AF	Front Air Shaft	1
5.	671A255	Front Air Adapter	1
6.	SS6121010SP	Screw	2
7.	35883AB	Bracket, spring pivot	1
8.	35883N	Clamp, front air	1
9.	SS6080720SP	Screw	1
10.	35875AK	Washer, thrust	1
11.	35875AC	Washer, neoprene	1
12.	35875AG	Washer, neoprene	1
13.	35875AJ	Washer, thrust	1
14.	18-799	Screw	1
15.	SS6121220TP	Screw	2
16.	35883AF	Bracket, height adjustment	1
17.	SS7080520SP	Screw	1
18.	35893F	Washer	1
19.	35893E	Felt	1
20.	35844L	Bushing, spring pivot	1
21.	SS7121410TP	Screw	1
22.	671F82F	Fitting	2

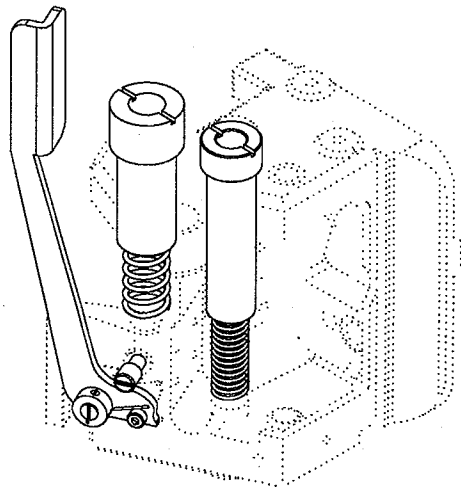
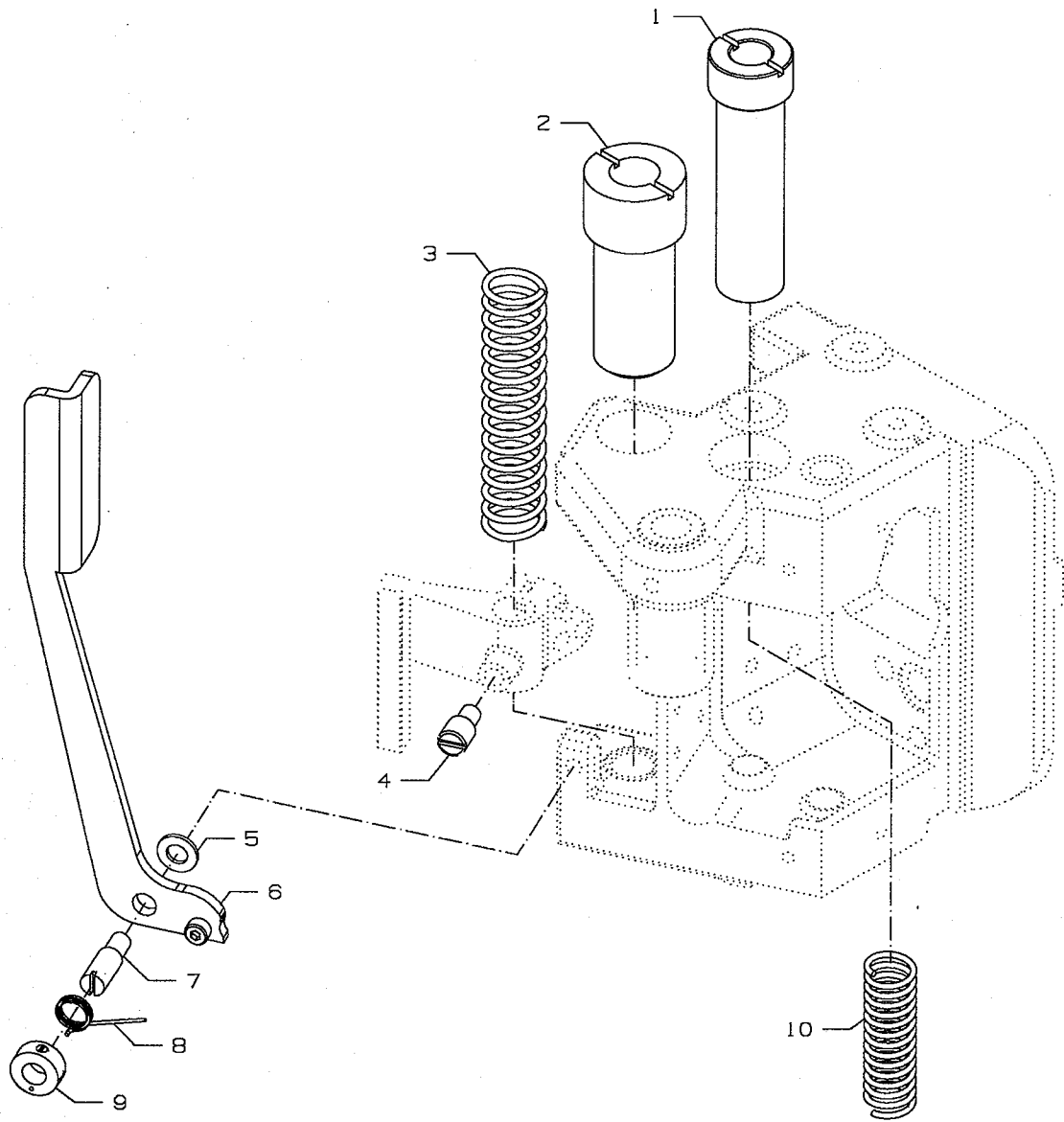




REAR ROLLER & PRESSER FOOT PNEUMATIC ASSEMBLY & TREADLE SWITCH

Ref. No.	Part No.	Description	Amt. Req.
1.	29476UD	Puller Shaft Air Cylinder Assembly	1
2.	671A35	Air Cylinder	1
3.	35877AL	Puller Shaft	1
4.	29476TE	Presser Bar Air Assembly	1
5.	671A253	Air Cylinder	1
6.	35822AE	Presser Bar Shaft	1
7.	671A256	Adapter, air cylinder	1
8.	671A254	Adapter, air cylinder	1
9.	35886H	Washer, neoprene	1
10.	35833R	Collar, clamp	1
11.	SS7151310TP	Screw	1
12.	35886J	Washer, neoprene	1
13.	35883S	Collar, clamp	1
14.	SS7111120TP	Screw	1
15.	29476SE	Treadle Switch	1
16.	671F82C	Elbow Fitting	2
17.	671F82F	Elbow Fitting	2

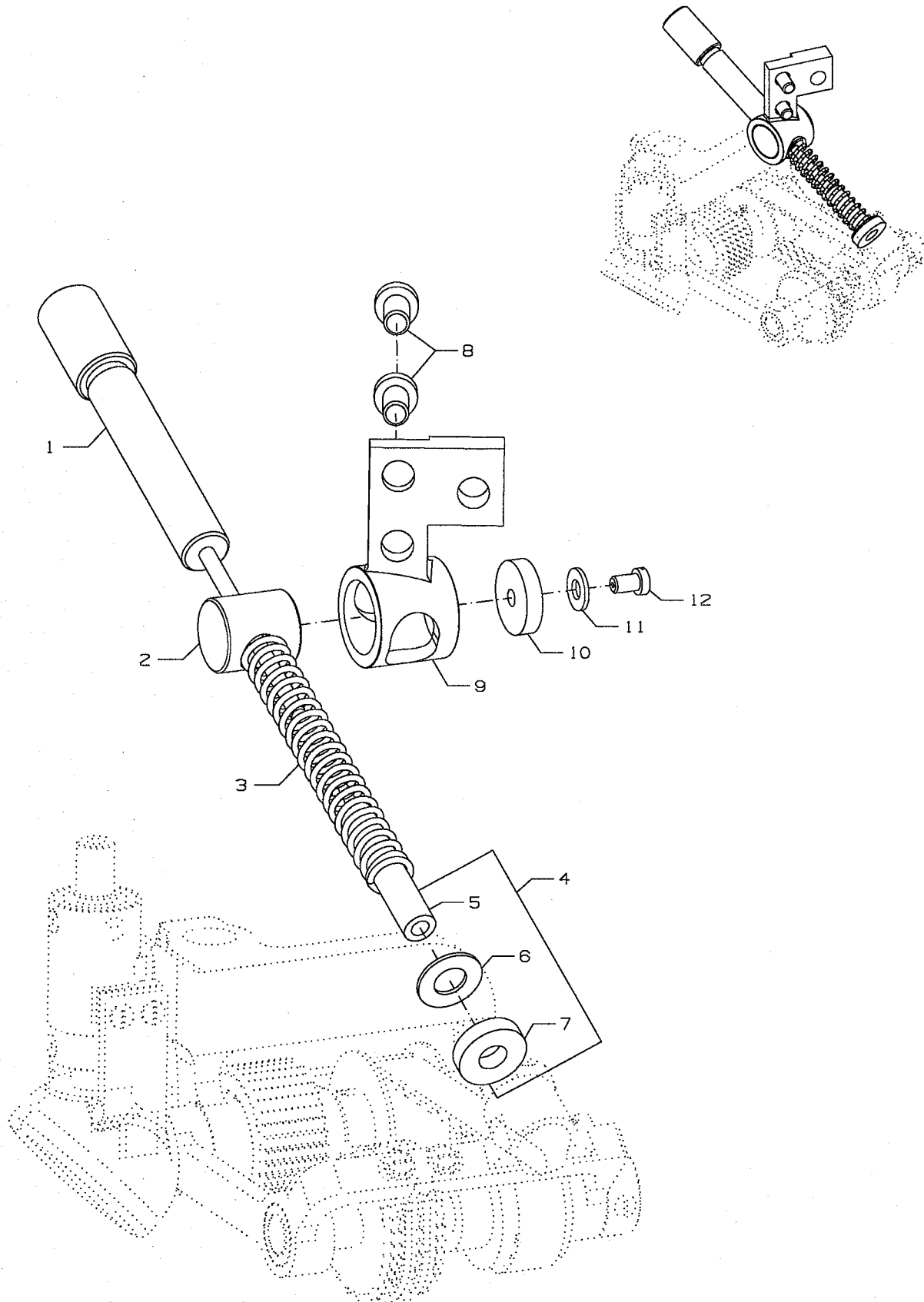




**MANUAL REAR ROLLER LIFT & PRESSURE SPRING REGULATOR FOR REAR ROLLER
& PRESSER FOOT**

Ref. No.	Part No.	Description	Amt. Req.
1.	35843C	Presser Bar Knob	1
2.	35892A	Puller Bar Knob, rear	1
3.	35832B	Spring, puller bar	1
4.	35847H	Lever Lift Pin, rear	1
5.	35875AD	Washer	1
6.	35867	Handle, roller lift	1
7.	35847W	Screw	1
8.	35832E	Spring, torsion	1
9.	35833P	Collar	1
10.	35832A	Spring, presser bar	1

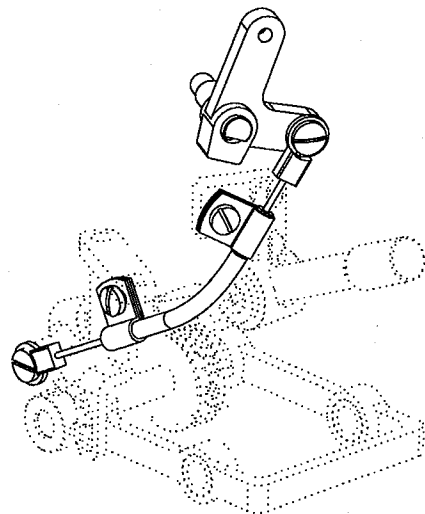
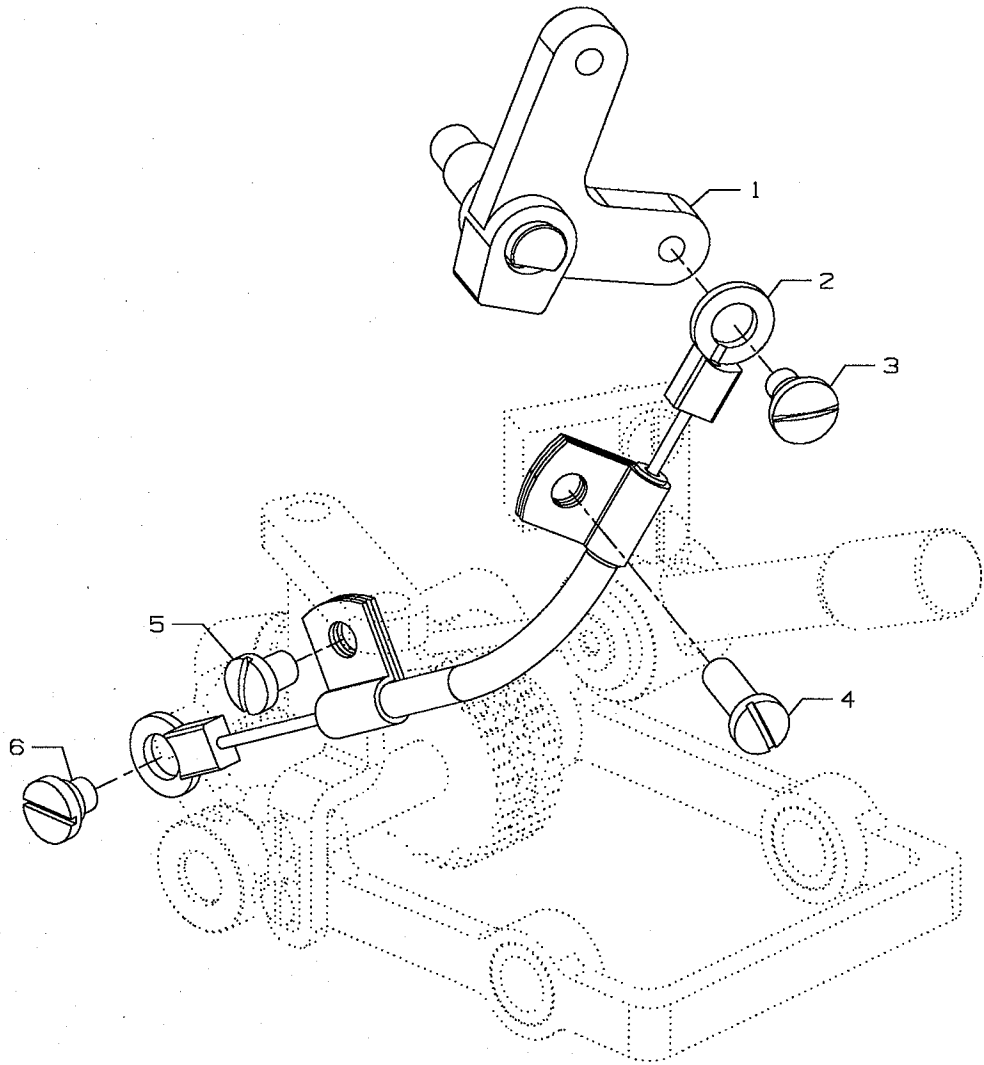




MANUAL FRONT ROLLER ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	35883AC	Front Spring Knob	1
2.	35844L	Bushing, spring pivot	1
3.	35832C	Spring, front roller	1
4.	29476TB	Tube Guide Assembly	1
5.	35837R	Tube, guide	1
6.	WP0650876SD	Washer, thrust	1
7.	35875AC	Washer, neoprene	1
8.	SS6121010SP	Screw	2
9.	35883AB	Bracket, spring pivot	1
10.	35893E	Felt	1
11.	35893F	Washer	1
12.	SS7080520SP	Screw	1

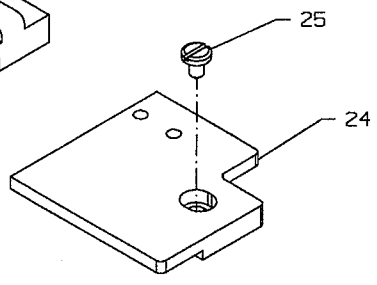
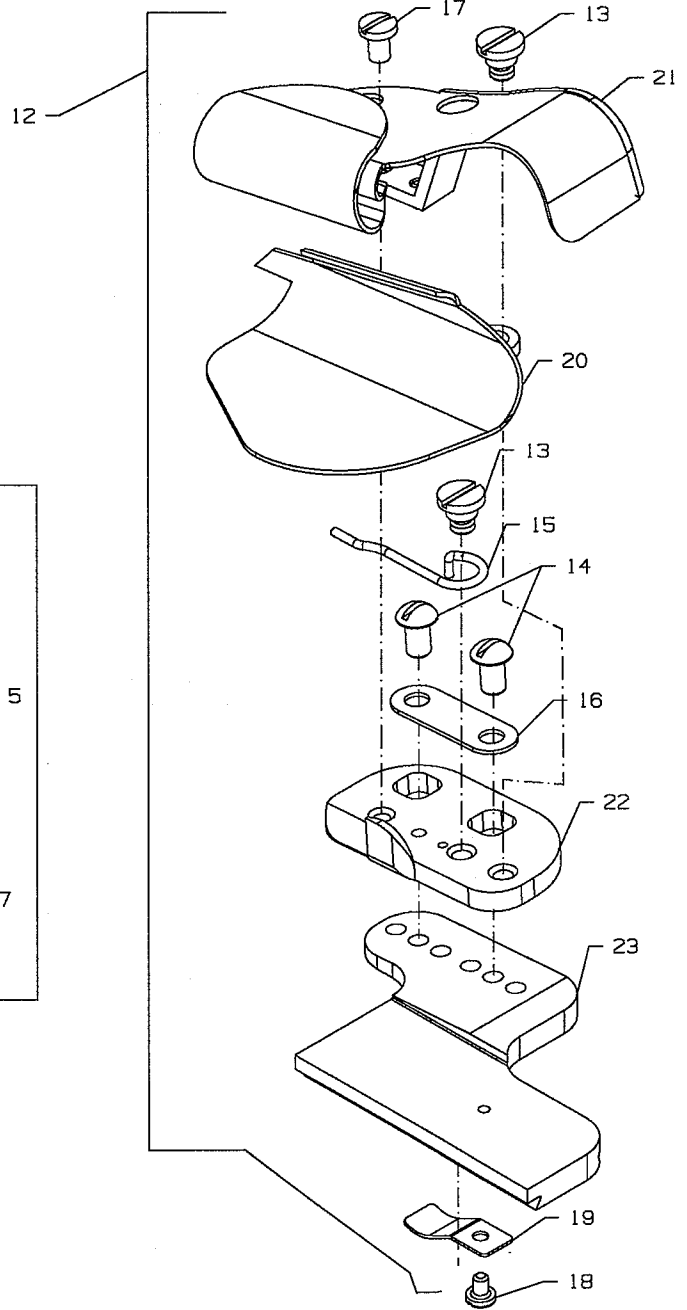
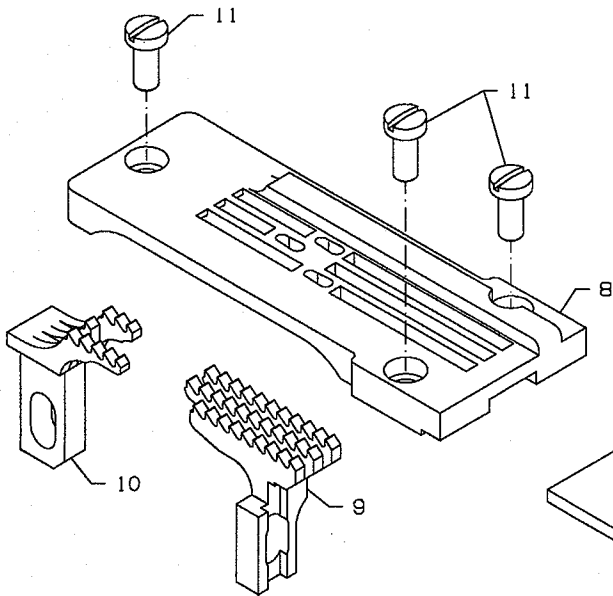
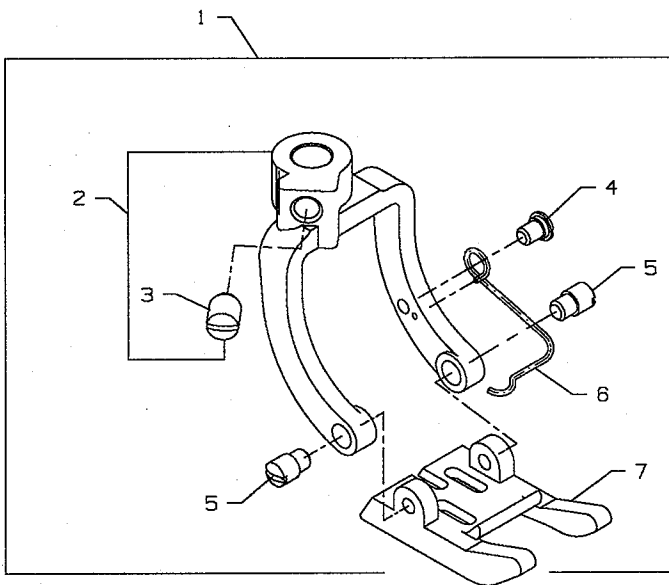
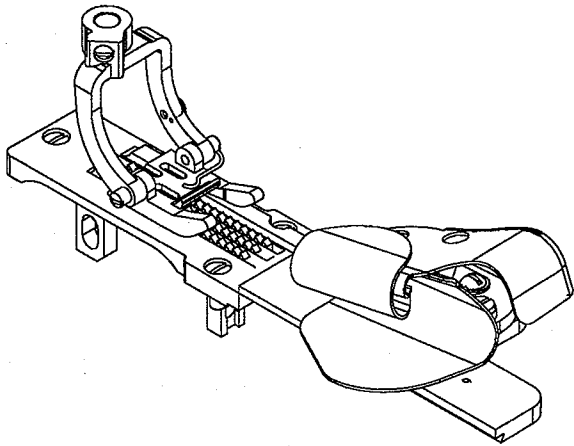




MANUAL LIFT CABLE FOR FRONT ROLLER FEED

Ref. No.	Part No.	Description	Amt. Req.
1.	35880P	Lifter Lever Bell Crank	1
2.	670E1301	Lifter Lever Assembly	1
3.	22758E	Screw	1
4.	SS7121410TP	Screw	1
5.	SS7120640SP	Screw	1
6.	SD0640211SP	Screw	1





PRESSER FOOT, THROAT PLATE & FEED DOGS

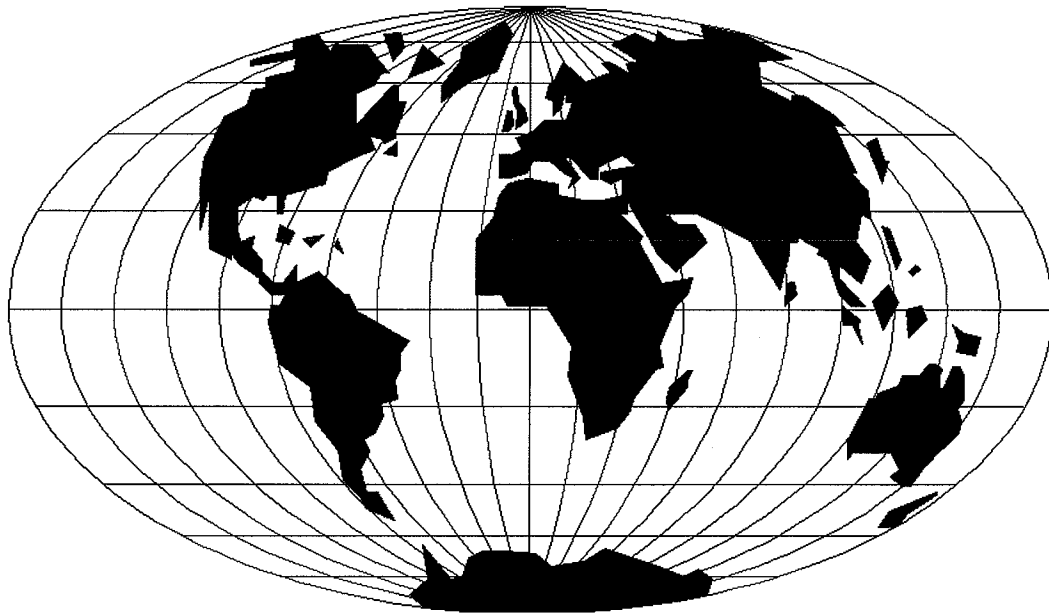
Ref. No.	Part No.	Description	Amt. Req.
1.	35820CA	Presser Foot Assembly	1
2.	35830DY	Presser Foot Fork	1
3.	SS8120740SP	Screw	1
4.	22599	Screw	1
5.	22865B	Screw	2
6.	35832H	Spring	1
7.	35830DZ	Presser Foot, for 35800FPP9, FP9	1
8.	35824EA9	Throat Plate, for 35800FPP9, FP9	1
9.	35826EB	Differential Feed Dog, for 35800FPP9, FP9	1
10.	35805EA	Main Feed Dog	1
11.	22585	Screw	3
12.	23420AA18-1/8	Folder Assembly	1
13.	22760A	Screw	2
14.	22849A	Screw	2
15.	23424S	Lower Scroll Spring	1
16.	23425T	Clamp Plate	1
17.	87U	Screw	1
18.	73A	Screw	1
19.	23424F	Folder Support Spring	1
20.	23422AY18-1/8	Lower Scroll	1
21.	23421AA18-1/8	Upper Scroll	1
22.	23424T	Lower Scroll Support	1
23.	23424AA	Folder Support Slide	1
24.	35862D	Stop Plate	1
25.	73A	Screw	1



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