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**INDUSTRIAL
SEWING
MACHINES**

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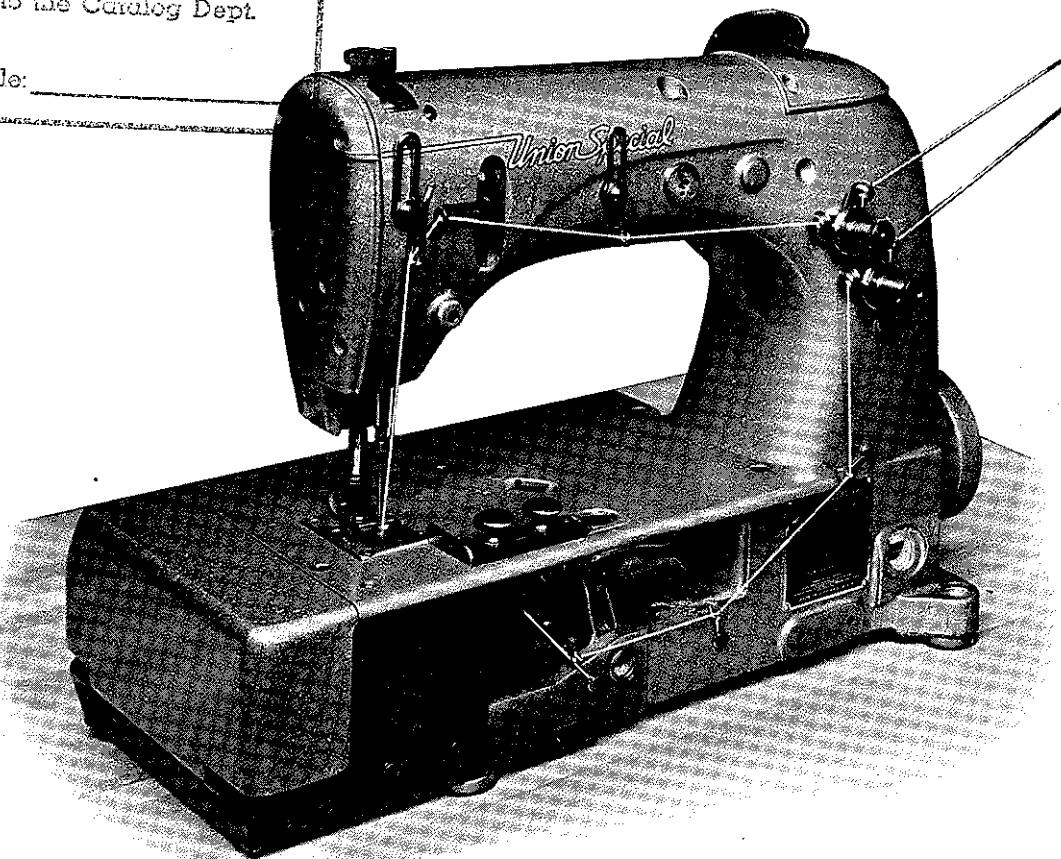
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Date received to file: _____

STYLES

51100BM

51100BP



CATALOG

No.

104M

CLASS 51100

STREAMLINED

FIFTY THOUSAND SERIES

UNION SPECIAL CORPORATION

CHICAGO

Catalog No. 104 M

LIST OF PARTS

Styles

51100 BM 51100 BP

First Edition

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UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES

CHICAGO

Printed in U.S.A.

November, 1978

FOREWORD

The 51100 streamlined machines covered by this catalog represent the latest design of the UNION SPECIAL flat bed bag seaming machine. Automatic lubrication, with a pump for returning filtered oil to the main reservoir, has made maintenance simple. All parts are made by precision methods insuring complete interchangeability.

It is our constant aim to furnish carefully prepared information that will enable the customer to secure all possible advantages from the use of UNION SPECIAL sewing machines. The following pages illustrate and describe the parts used in the 51100 bag seaming machines covered by this catalog.

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 CORPORATION

Engineering Department

IDENTIFICATION OF MACHINE

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 51100 BP". 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: 51100 BPZ".

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: "51100".

APPLICATION OF CATALOG

This catalog applies specifically to the standard styles of machines as listed herein.

It can also be applied with discretion to some special machines in Class 51100. 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.

DESCRIPTION OF MACHINE

Streamlined, Flat Bed, High Throw, One Needle, Lateral Looper Travel, Single Reservoir, Enclosed Automatic Lubricating System, Equipped With Filter Type Oil Return Pump, Seam Specification 401-SSa-1, Stitch Range 3 1/2 to 7 S. P. I.

51100 BM For seaming medium and large size cotton and light and medium weight burlap bags 1 5/16" needle bar travel. Light weight presser bar and needle bar driving mechanism.

51100 BP For seaming medium and large size bags, made from medium and light weight fabrics 1 1/2" needle bar travel.

NEEDLES

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

Standard needle for Styles 51100 BM, 51100 BP is Type 143 G. It is a number 2 bag, double groove, spotted, chromium plated needle and is available in sizes 185/073, 200/080, 230/090, 250/100.

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 143 G, Size 200/080".

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

Success in the operation of UNION SPECIAL machines can be secured only by use of needles packaged under our brand name, *Union Specials*, which is backed by a reputation for producing highest quality needles in materials and workmanship for more than three-quarters of a century.

ORDERING REPAIR PARTS

ILLUSTRATIONS

This catalog is arranged to simplify the ordering of repair parts. Exploded views of various sections of the mechanism are shown so parts may be seen in their actual position within the machine. Opposite the page of illustration is found a listing of parts shown, their part numbers, description and number of pieces required in the particular view shown.

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

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:

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|---------------------|---------------------|---------------------------------------|----------------------|
| 41 | 29105 Z | Looper Drive Eccentric Assembly ----- | 1 |
| 42 | 22559 B | Bearing Cap Screw, upper ----- | 2 |
| 43 | 22894 D | Spot Screw ----- | 1 |
| 44 | 22894 C | Set Screw ----- | 4 |
| 45 | 22559 A | Bearing Cap Screw, lower ----- | 2 |

It will be noted in this example that the eccentric and bearing are not listed. This is done for the reason that the replacement of the parts individually is not recommended and the complete sub-assembly should be ordered.

In those cases where a part is common to both Styles 51100 BM and 51100 BP, no specific usage will be mentioned in the descriptions. However, when the parts for both 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 parts shown in the illustrations, which will facilitate locating illustration and description when part number is known.

IDENTIFYING PARTS

Where construction permits, each part is stamped with its part number. Some smaller parts are stamped only with an identification letter to distinguish them from parts similar in appearance.

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 with genuine UNION SPECIAL Needles and Repair Parts as furnished by the Union Special Corporation, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles, and are made with utmost precision. Maximum efficiency and durability are assured.

Genuine needles are packaged with labels marked *Union Special*®. Genuine repair parts are stamped with the Union Special trademark, U S Emblem. Each trademark is your guarantee of the highest quality in materials and workmanship.

ORDERING REPAIR PARTS (Cont'd.)

TERMS

Prices are net cash and subject to change without notice. All shipments are forwarded f. o. b. shipping point. Parcel post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

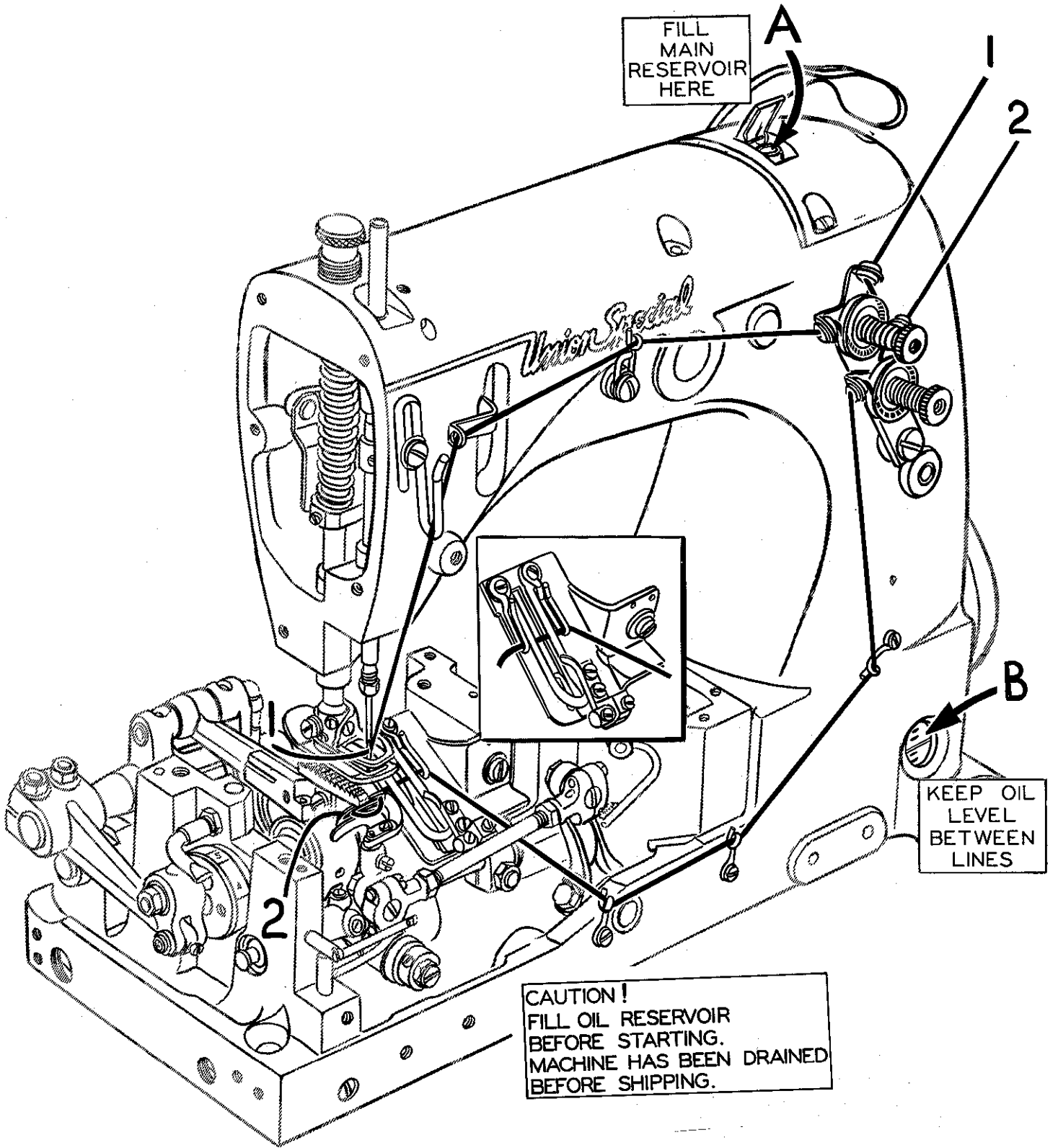
OILING AND THREADING INSTRUCTIONS

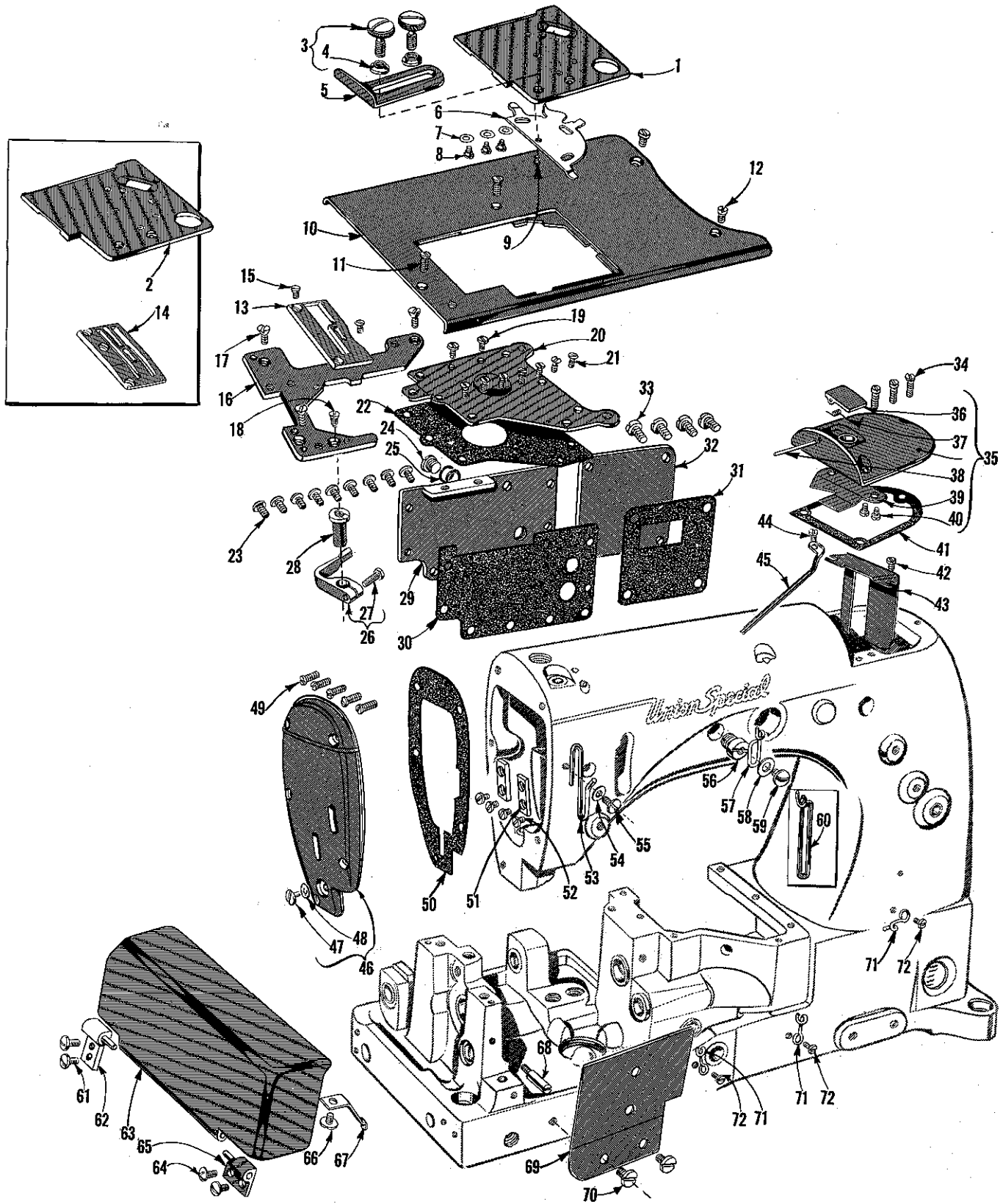
The oil has been drained from the machine before shipping and the reservoir must be filled before operation. Use a straight mineral oil with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit.

Oil is filled at the spring cap in the top cover (A) of the accompanying drawing and oil level is checked at the sight gauge (B) on front of the machine. Oil level should be maintained between red lines on the gauge. The capacity of the oil reservoir is twelve ounces.

A daily check before the morning start should be made and oil added as required. Oil which has gone thru 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 diagram also shows the threading of machine Styles 51100 BM and 51100 BP.

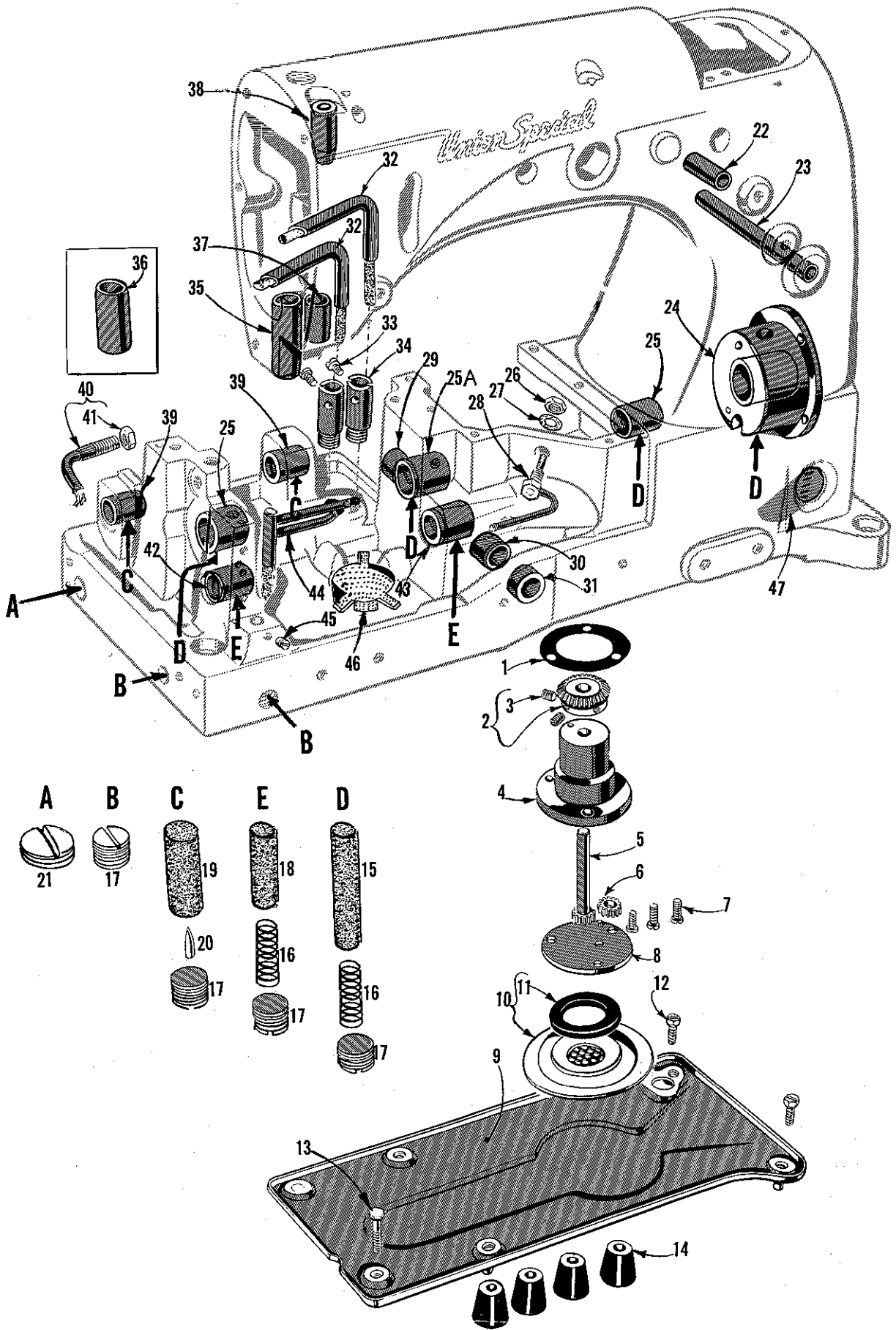




MAIN FRAME, MISCELLANEOUS COVERS AND PLATES

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-------------|--------------------------------------------------------------|-----------|
| 1 | 51281 T-212 | Cloth Plate Cover, for Style 51100 BP ----- | 1 |
| 2 | 51281 T-219 | Cloth Plate Cover, for Style 51100 BM ----- | 1 |
| 3 | 25 | Edge Guide Assembly Screw ----- | 2 |
| 4 | 25 D | Washer ----- | 2 |
| 5 | 24 X | Edge Guide ----- | 1 |
| 6 | 51281 AC | Cloth Plate Cover Spring ----- | 1 |
| 7 | 35772 H | Spring Washer ----- | 3 |
| 8 | 22760 A | Screw ----- | 3 |
| 9 | 22845 B | Screw ----- | 1 |
| 10 | 51101 R | Cloth Plate ----- | 1 |
| 11 | 80 | Screw ----- | 2 |
| 12 | 22839 C | Screw ----- | 2 |
| 13 | 51124 D | Throat Plate, for Style 51100 BM ----- | 1 |
| 14 | 6624 L | Throat Plate, for Style 51100 BP ----- | 1 |
| 15 | 87 | Screw ----- | 2 |
| 16 | 51180 J | Throat Plate Support ----- | 1 |
| 17 | 22839 | Screw ----- | 3 |
| 18 | 22570 A | Screw, for Style 51100 BM ----- | 1 |
| | 22584 | Screw, for Style 51100 BP ----- | 1 |
| 19 | 22585 A | Screw ----- | 2 |
| 20 | 53782 B | Oil Reservoir Top Cover ----- | 1 |
| 21 | 22524 | Screw ----- | 7 |
| 22 | 51382 A | Gasket ----- | 1 |
| 23 | 22848 | Screw ----- | 9 |
| 24 | 22733 B | Screw ----- | 1 |
| 25 | 41394 A | Gasket ----- | 2 |
| 26 | 51125 E | Needle Guard ----- | 1 |
| 27 | 906 | Clamp Screw ----- | 1 |
| 28 | 56168 | Needle Guard Holder ----- | 1 |
| 29 | 52882 L | Oil Reservoir Back Cover ----- | 1 |
| 30 | 52882 M | Gasket ----- | 1 |
| 31 | 52882 U | Gasket ----- | 1 |
| 32 | 52882 AF | Crank Chamber Cover ----- | 1 |
| 33 | 22548 | Screw ----- | 4 |
| 34 | 22541 B | Screw ----- | 3 |
| 35 | 52882 AD | Crank Chamber Cover, upper ----- | 1 |
| 36 | 39582 L | Oil Cap ----- | 1 |
| 37 | 52882 AC | Oil Cap Spring ----- | 1 |
| 38 | 50-789 Blk. | Oil Cap Hinge Pin ----- | 1 |
| 39 | 52882 AA | Oil Drip Plate ----- | 1 |
| 40 | 90 | Screw ----- | 2 |
| 41 | 52882 P | Gasket ----- | 1 |
| 42 | 90 | Screw ----- | 1 |
| 43 | 51182 L | Baffle Plate ----- | 1 |
| 44 | 90 | Screw ----- | 1 |
| 45 | 51282 AE | Needle Lever Bearing Oiler ----- | 1 |
| 46 | 51282 Y | Head Cover ----- | 1 |
| 47 | 22542 | Screw ----- | 1 |
| 48 | 52882 W | Gasket ----- | 1 |
| 49 | 22569 B | Screw ----- | 5 |
| 50 | 51282 Z | Gasket ----- | 1 |
| 51 | 35731 A | Presser Bar Connection Guide Plate ----- | 2 |
| 52 | 22513 | Screw, for Style 51100 BM ----- | 3 |
| | 22513 | Screw, for Style 51100 BP ----- | 4 |
| 53 | 51170 E | Frame Needle Thread Guide ----- | 1 |
| 54 | 20 | Washer ----- | 1 |
| 55 | 22848 | Screw ----- | 1 |
| 56 | 22889 A | Adapter Screw ----- | 1 |
| 57 | 51758 | Frame Thread Eyelet, for Style 51100 BM ----- | 1 |
| 58 | 20 | Washer ----- | 1 |
| 59 | 22848 | Screw ----- | 1 |
| 60 | 539 | Frame Thread Eyelet, for Style 51100 BP ----- | 1 |
| 61 | 22596 | Screw ----- | 2 |
| 62 | 57885 B | End Cover Hinge Bracket, rear ----- | 1 |
| 63 | 51182 C | End Cover ----- | 1 |
| 64 | 22848 | Screw ----- | 2 |
| 65 | 57885 | End Cover Hinge Bracket, front ----- | 1 |
| 66 | 22711 | Screw ----- | 1 |
| 67 | 52885 L | End Cover Spring ----- | 1 |
| 68 | 22799 M | End Cover Spring Pin ----- | 1 |
| 69 | 51482 A | Guard ----- | 1 |
| 70 | 25 S | Screw ----- | 2 |
| 71 | 52 A | Eyelet ----- | 3 |
| 72 | 98 A | Screw ----- | 3 |
| * | 7947 | Nut, for 51294 P, 51294 R, Style 51100 BM ----- | 1 |
| * | 51294 P | Oil Tube Clamp, for Style 51100 BM ----- | 1 |
| * | 51294 R | Screw, for 35731 A, 51294 P, Style 51100 BM ----- | 1 |
| * | 22848 | Plug Screw, for belt guard screw holes, Style 51100 BM ----- | 2 |

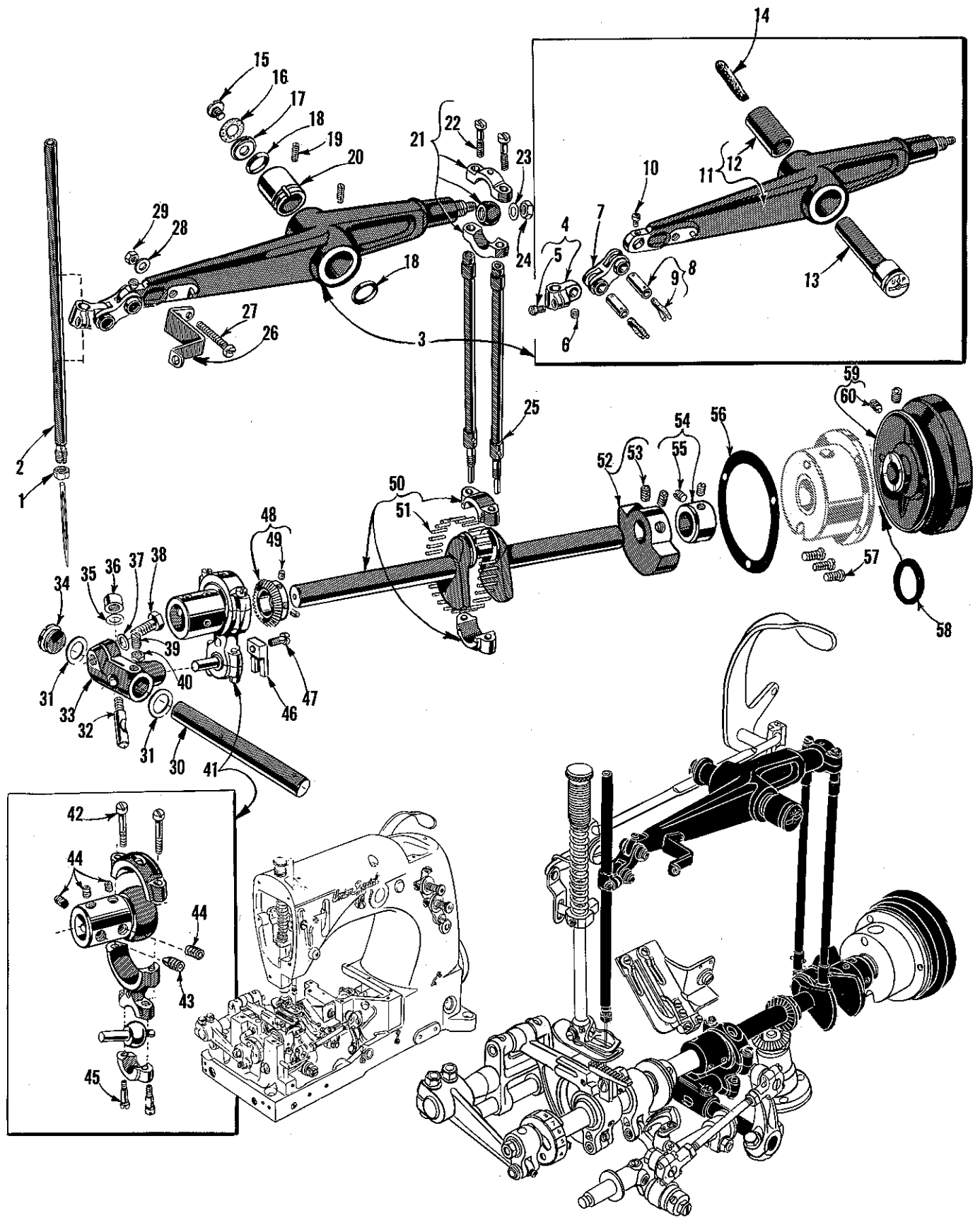
* Not shown on picture plate.



MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

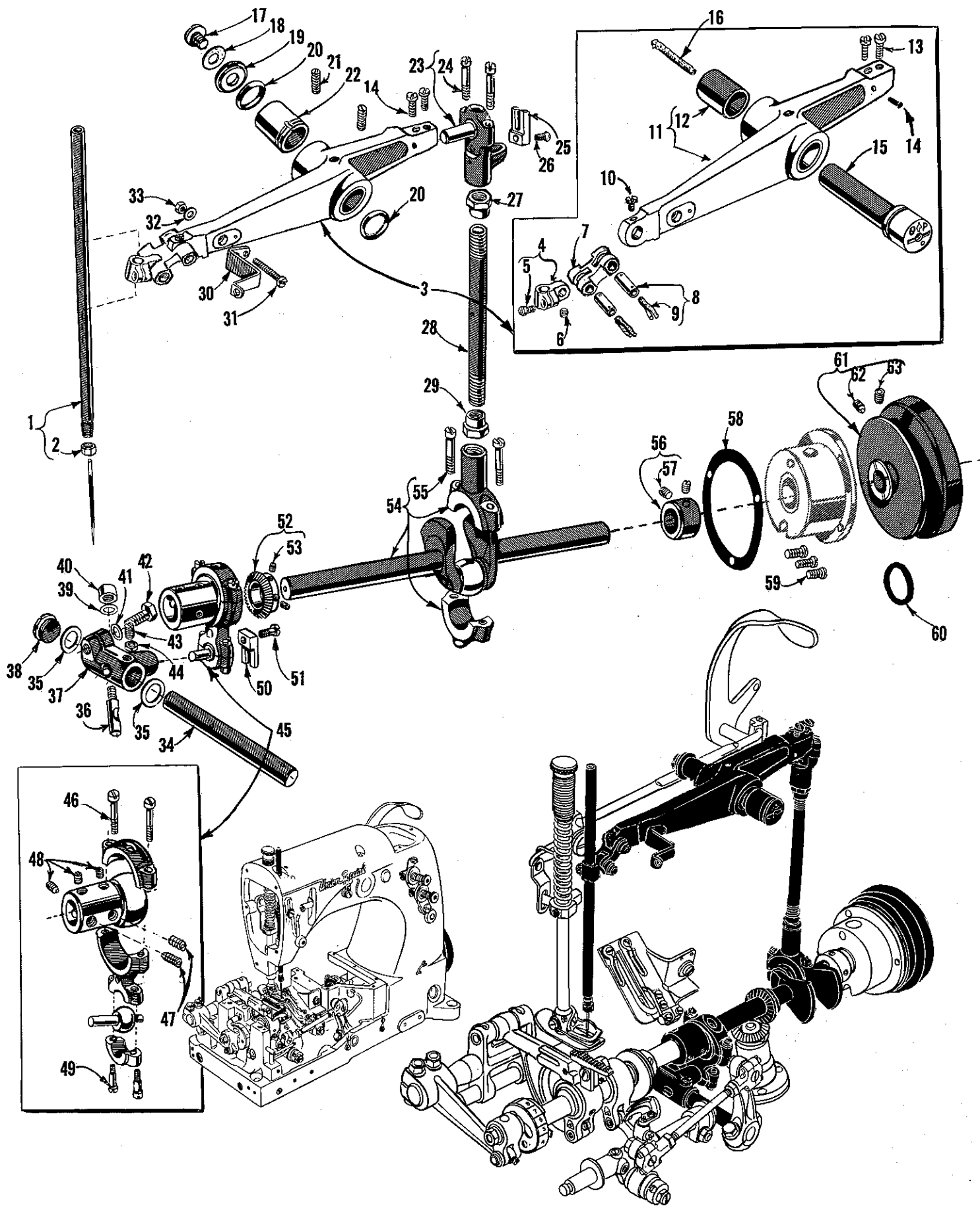
| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|----------------------------------------------------------------------------|------------------|
| 1 | 643-127 Blk. | Gasket----- | 1 |
| 2 | 51493 BQ | Oil Pump Driven Gear----- | 1 |
| 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 | 22569 B | Screw----- | 3 |
| 8 | 51493 AH | Oil Pump Housing Cover----- | 1 |
| 9 | 51493 AY | Base Plate----- | 1 |
| | *51493 BG | Base Plate Felt Pad----- | 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 | 666-114 | Oil Wick----- | 4 |
| 16 | 35178 D | Spring----- | 6 |
| 17 | 22571 A | Plug Screw----- | 18 |
| 18 | 666-65 | Oil Wick----- | 2 |
| 19 | 666-111 | Oil Wick----- | 2 |
| 20 | 666-179 | Wedge Pin----- | 2 |
| 21 | 22539 H | Plug Screw----- | 1 |
| 22 | 52883 R | Foot Lifter Lever Bushing----- | 1 |
| 23 | 21657 X | Tension Release Lever Shaft Bushing----- | 1 |
| 24 | 52891 B | Crankshaft Bushing Housing, including bushing----- | 1 |
| 25 | 52890 C | Main Shaft Bushing, left and inner right----- | 2 |
| 25A | 51290 T | Main Shaft Bushing, center----- | 1 |
| 26 | 258 A | Nut----- | 1 |
| 27 | 6042 A | Washer----- | 1 |
| 28 | 52894 AM | Oil Tube, for looper connecting rod ball joint, right----- | 1 |
| 29 | 51242 S | Rear Looper Drive Lever Shaft Bushing----- | 1 |
| 30 | 51242 R | Middle Looper Drive Lever Shaft Bushing----- | 1 |
| 31 | 51242 Z | Front Looper Drive Lever Shaft Bushing----- | 1 |
| 32 | 51193 S | Oil Tube, for feed lift eccentric; also for looper avoid eccentric----- | 2 |
| 33 | 90 | Screw----- | 2 |
| 34 | 52894 AB | Oil Tube Holder----- | 2 |
| 35 | 51257 AA | Lower Presser Bar Bushing, for Style 51100 BM----- | 1 |
| 36 | 53556 C | Lower Presser Bar Bushing, for Style 51100 BP----- | 1 |
| 37 | 51254 D | Lower Needle Bar Bushing----- | 1 |
| 38 | 51254 C | Upper Needle Bar Bushing----- | 1 |
| 39 | 52936 | Feed Rocker Shaft Bushing----- | 2 |
| 40 | 51193 U | Oil Tube, for feed crank link----- | 1 |
| 41 | 258 A | Nut----- | 1 |
| 42 | 52944 T | Looper Rocker Shaft Bushing, left----- | 1 |
| 43 | 52944 U | Looper Rocker Shaft Bushing, right----- | 1 |
| 44 | 52894 AK | Oil Tube, for looper rocker ball joint, left----- | 1 |
| 45 | 22560 B | Screw----- | 1 |
| 46 | 51493 BK | Lint Filter Screen----- | 1 |
| 47 | 50-648 Blk. | Lucite Oil Gauge----- | 1 |
| * | 51294 M | Oil Tube, for Style 51100 BM----- | 1 |
| * | 666-214 | Felt Lint Filter----- | 1 |
| * | 51294 Z | Oil Tube Connection, for Style 51100 BM----- | 1 |
| * | 21212 | Locking Ring----- | 1 |
| * | 22729 A | Screw, for No. 51294 U, for Style 51100 BM----- | 1 |
| * | 51294 U | Oil Siphon Assembly, for Style 51100 BM----- | 1 |
| * | 22729 B | Screw----- | 1 |
| * | 51294 K | Clamp, upper----- | 1 |
| * | 666-201 | Felt Plug, 5/8 inch long----- | 1 |
| * | 666-209 | Felt Plug, 3/32 inch long----- | 1 |

* Not shown on picture plate.



CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS
FOR STYLE 51100 BM

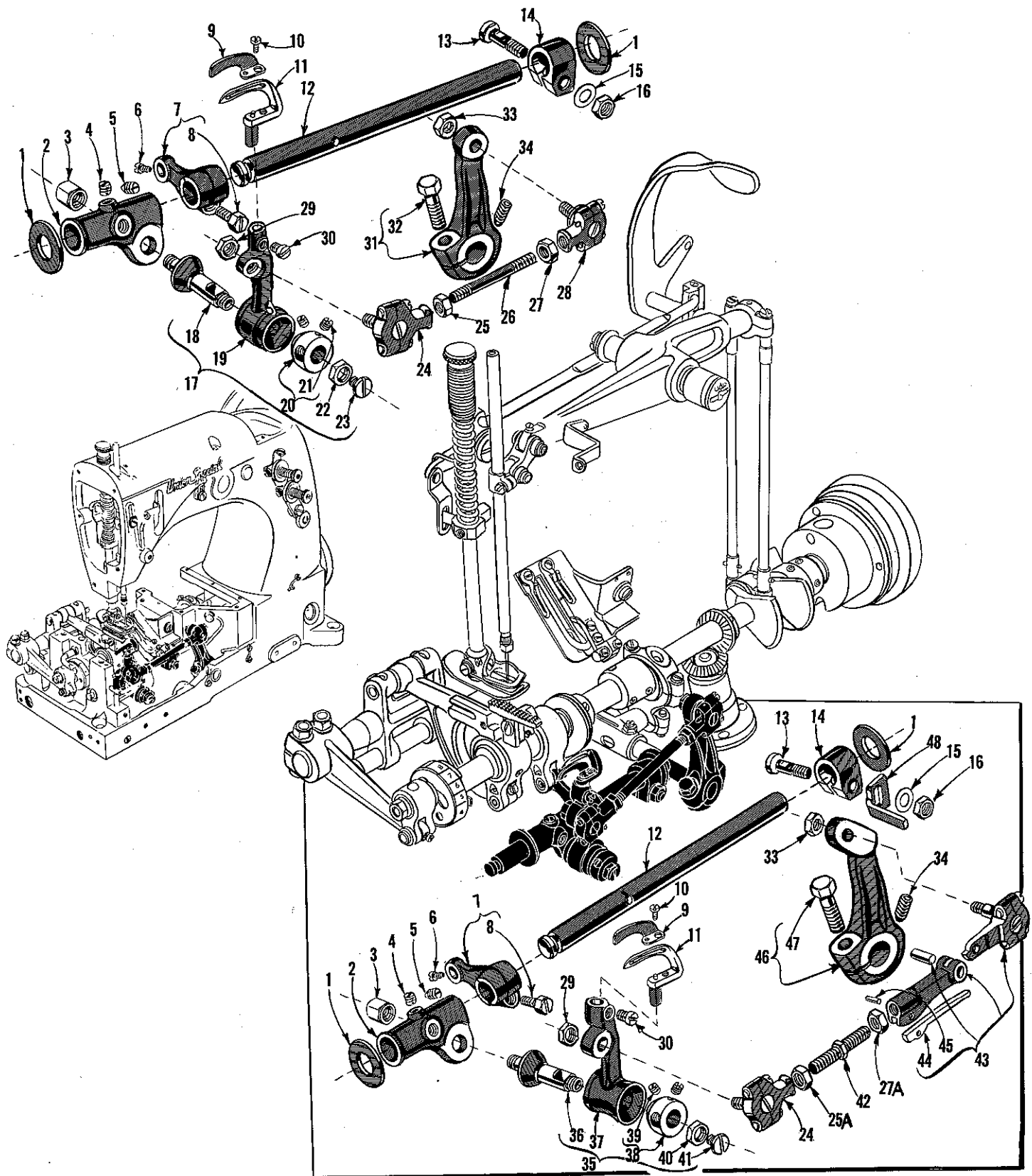
| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-------------|-------------------------------------------------------------|--------------|
| 1 | 56 | Needle Clamp Nut----- | 1 |
| 2 | 51217 C | Needle Bar----- | 1 |
| 3 | 29348 R | Needle Lever Assembly----- | 1 |
| 4 | 51254 J | Needle Bar Connection----- | 1 |
| 5 | 22562 A | Screw----- | 1 |
| 6 | 22564 | Screw, for link pin----- | 1 |
| 7 | 56354 A | Needle Bar Link----- | 1 |
| 8 | 51054 | Link Pin----- | 2 |
| 9 | 666-149 | Lubricating Felt----- | 1 |
| 10 | 77 | Screw, for upper link pin----- | 1 |
| 11 | 56115 | Needle Lever----- | 1 |
| 12 | 56350 B | Needle Lever Bushing----- | 1 |
| 13 | 56350 A | Needle Lever Stud----- | 1 |
| 14 | 666-170 | Wick----- | 1 |
| 15 | 22586 R | Screw----- | 1 |
| 16 | 51250 F | Gasket----- | 1 |
| 17 | 51250 D | Washer----- | 1 |
| 18 | 660-212 | Oil Seal Ring----- | 2 |
| 19 | 719 | Screw----- | 2 |
| 20 | 51150 | Needle Lever Thrust Collar----- | 1 |
| 21 | 29066 R | Needle Lever Ball Joint----- | 1 |
| 22 | 22559 G | Screw----- | 2 |
| 23 | 51216 N | Washer----- | 1 |
| 24 | 51216 P | Nut----- | 1 |
| 25 | 51216 G | Needle Lever Connecting Rod----- | 2 |
| 26 | 51158 E | Needle Lever Thread Eyelet----- | 1 |
| 27 | 22747 A | Screw----- | 1 |
| 28 | 652 D-8 | Lock Washer----- | 1 |
| 29 | 43443 Q | Nut----- | 1 |
| 30 | 51242 P | Looper Drive Lever Shaft----- | 1 |
| 31 | 51242 L | Thrust Washer----- | 2 |
| 32 | 52841 G | Locking Stud----- | 1 |
| 33 | 51242 Y | Looper Drive Lever Rocker----- | 1 |
| 34 | 22883 A | Plug Screw, for looper drive lever shaft hole----- | 1 |
| 35 | 51242 M | Washer----- | 1 |
| 36 | 52841 J | Nut----- | 1 |
| 37 | 51242 M | Washer----- | 1 |
| 38 | 22852 A | Clamp Screw----- | 1 |
| 39 | 81 | Spot Screw----- | 1 |
| 40 | 12982 | Lock Nut----- | 1 |
| 41 | 29105 Z | Looper Drive Lever Eccentric Assembly, .308 inch throw----- | 1 |
| 42 | 22559 B | Bearing Cap Screw, upper----- | 2 |
| 43 | 22894 D | Spot Screw----- | 1 |
| 44 | 22894 C | Set Screw----- | 4 |
| 45 | 22559 A | Bearing Cap Screw, lower----- | 2 |
| 46 | 51243 C | Ball Stud Guide Fork----- | 1 |
| 47 | 22729 | Screw----- | 1 |
| 48 | 51493 BP | Oil Pump Driving Gear----- | 1 |
| 49 | 22560 B | Screw----- | 2 |
| 50 | 29476 GZ | Crankshaft Assembly----- | 1 |
| 51 | 51216 M | Needle Bearing----- | 28 |
| 52 | 51247 | Counterweight----- | 1 |
| 53 | 22894 J | Screw----- | 2 |
| 54 | 51147 | Thrust Collar----- | 1 |
| 55 | 95 | Screw----- | 2 |
| 56 | 56390 E | Crankshaft Bushing Housing Gasket----- | 1 |
| 57 | 22569 B | Screw----- | 3 |
| 58 | 660-202 | "O" Ring, for pulley----- | 1 |
| 59 | 51221 C | Handwheel, for No. 1 "V" or round belt----- | 1 |
| 60 | 22894 F | Screw----- | 2 |



CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS FOR STYLE 51100 BP

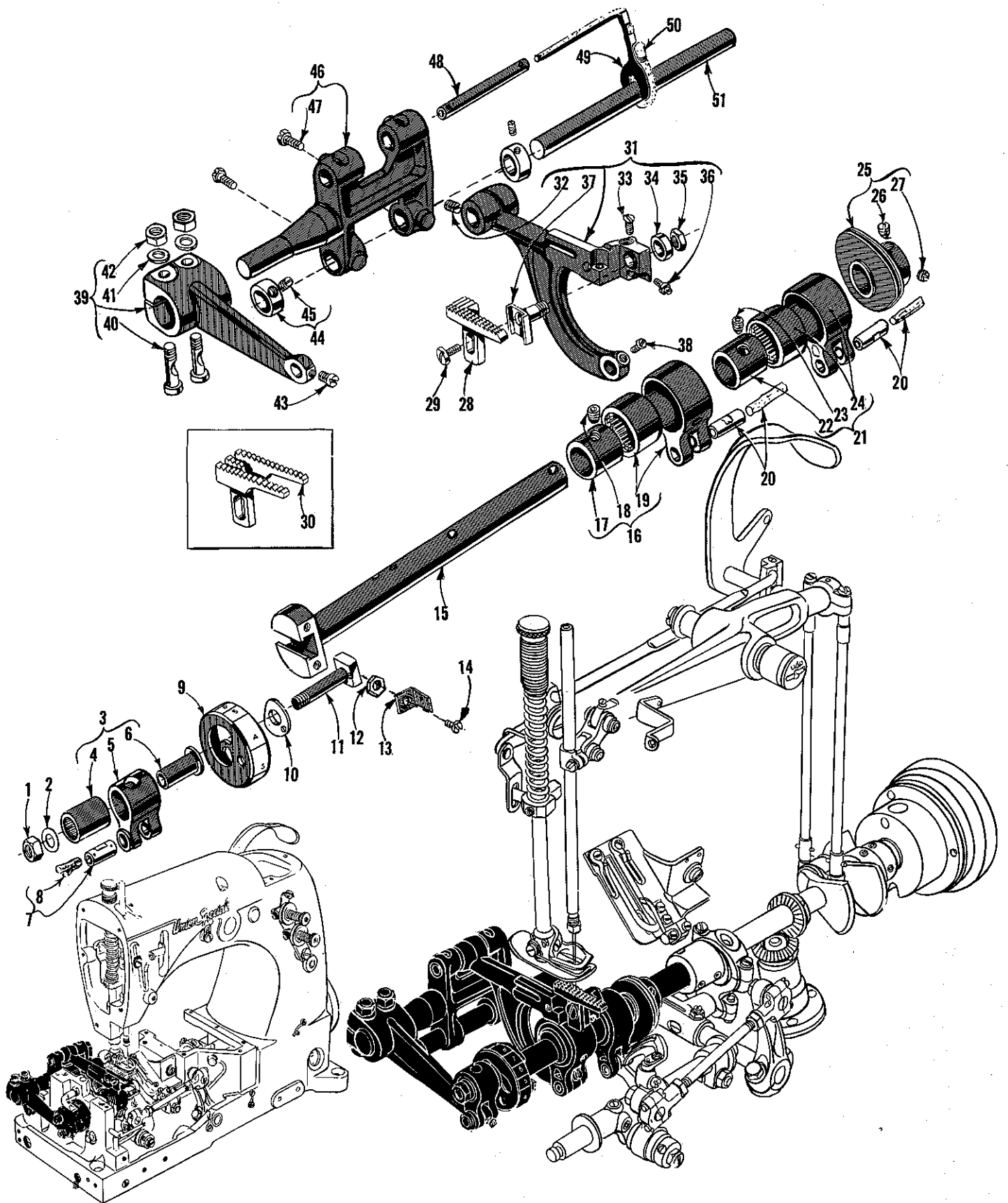
| Ref. No. | Part No. | Description | Amt. Req. |
|----------|----------|----------------------------------------------------|-----------|
| 1 | 51117 | Needle Bar----- | 1 |
| 2 | 39151 | Clamp Nut----- | 1 |
| 3 | 29348 D | Needle Lever Assembly----- | 1 |
| 4 | 51254 J | Needle Bar Connection----- | 1 |
| 5 | 22562 A | Screw----- | 1 |
| 6 | 22564 | Screw, for link pin----- | 1 |
| 7 | 56354 A | Needle Bar Link----- | 1 |
| 8 | 51054 | Link Pin----- | 2 |
| 9 | 666-149 | Lubricating Felt----- | 1 |
| 10 | 77 | Screw----- | 1 |
| 11 | 51115 B | Needle Lever----- | 1 |
| 12 | 51250 A | Bushing----- | 1 |
| 13 | 93 A | Screw----- | 2 |
| 14 | 660-203 | Rivet----- | 1 |
| 15 | 51250 E | Needle Lever Stud----- | 1 |
| 16 | 666-170 | Wick----- | 1 |
| 17 | 22586 R | Screw----- | 1 |
| 18 | 51250 F | Gasket----- | 1 |
| 19 | 51250 D | Washer----- | 1 |
| 20 | 660-212 | Oil Seal Ring----- | 2 |
| 21 | 719 | Screw----- | 2 |
| 22 | 51150 | Needle Lever Thrust Collar----- | 1 |
| 23 | 29066 N | Needle Lever Connecting Rod Assembly----- | 1 |
| 24 | 97 A | Screw----- | 2 |
| 25 | 51243 C | Ball Stud Guide Fork----- | 1 |
| 26 | 22729 | Screw----- | 1 |
| 27 | 15430 C | Nut, left hand thread----- | 1 |
| 28 | 51216 | Needle Lever Connection Rod Tube----- | 1 |
| 29 | 15430 D | Nut, right hand thread----- | 1 |
| 30 | 51158 E | Needle Lever Thread Eyelet----- | 1 |
| 31 | 22747 A | Screw----- | 1 |
| 32 | 652 D-8 | Lock Washer----- | 1 |
| 33 | 43443 Q | Nut----- | 1 |
| 34 | 51242 P | Looper Drive Lever Shaft----- | 1 |
| 35 | 51242 L | Thrust Washer----- | 2 |
| 36 | 52841 G | Locking Stud----- | 1 |
| 37 | 51242 Y | Looper Drive Lever Rocker----- | 1 |
| 38 | 22883 A | Plug Screw, for looper drive lever shaft hole----- | 1 |
| 39 | 51242 M | Washer----- | 1 |
| 40 | 52841 J | Nut----- | 1 |
| 41 | 51242 M | Washer----- | 1 |
| 42 | 22852 A | Clamp Screw----- | 1 |
| 43 | 81 | Spot Screw----- | 1 |
| 44 | 12982 | Lock Nut----- | 1 |
| 45 | 29105 Q | Looper Drive Eccentric Assembly----- | 1 |
| 46 | 22559 B | Bearing Cap Screw, upper----- | 2 |
| 47 | 22894 D | Spot Screw----- | 2 |
| 48 | 22894 C | Set Screw----- | 3 |
| 49 | 22559 A | Bearing Cap Screw, lower----- | 2 |
| 50 | 51243 C | Ball Stud Guide Fork----- | 1 |
| 51 | 22729 | Screw----- | 1 |
| 52 | 51493 BP | Oil Pump Driving Gear----- | 1 |
| 53 | 22560 B | Screw----- | 2 |
| 54 | 29476 DT | Crankshaft Assembly----- | 1 |
| 55 | 22559 E | Screw----- | 2 |
| 56 | 51147 | Thrust Collar----- | 1 |
| 57 | 95 | Screw----- | 2 |
| 58 | 56390 E | Crankshaft Bushing Housing Gasket----- | 1 |
| 59 | 22569 B | Screw----- | 3 |
| 60 | 660-202 | "O" Ring, for pulley----- | 1 |
| 61 | 52921 B | Handwheel, for #1 "V" or round belt----- | 1 |
| - | 51321 G | Handwheel, for #2 "V" belt----- | 1 |
| 62 | 22894 H | Spot Screw, for pulley No. 51321 G----- | 1 |
| *- | HA81 | Spot Screw, for pulley No. 52921 B----- | 1 |
| 63 | 22894 E | Set Screw, for pulley No. 51321 G----- | 1 |
| *- | HA95 | Set Screw, for pulley No. 52921 B----- | 1 |

* Not furnished with No. 52921 B.



LOOPER ROCKER AND CONNECTING ROD PARTS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|-------------------------------------------------------------------------|------------------|
| 1 | 51244 L | Thrust Washer----- | 2 |
| 2 | 51244 | Looper Rocker Frame----- | 1 |
| 3 | 51246 | Looper Rocker Stud Nut----- | 1 |
| 4 | 98 | Set Screw----- | 1 |
| 5 | 96 | Spot Screw----- | 1 |
| 6 | 22768 | Screw----- | 1 |
| 7 | 51244 B | Looper Rocker Shaft Arm----- | 1 |
| 8 | 22519 H | Screw----- | 1 |
| 9 | 51110 D | Looper Needle Guard----- | 1 |
| 10 | 73 A | Screw----- | 1 |
| 11 | 51108 DA | Looper----- | 1 |
| 12 | 51144 | Looper Rocker Shaft----- | 1 |
| 13 | 55244 G | Locking Stud----- | 1 |
| 14 | 51244 N | Looper Rocker Shaft Clamp Collar----- | 1 |
| 15 | 51216 N | Washer----- | 1 |
| 16 | 18 | Nut----- | 1 |
| 17 | 29192 | Looper Rocker Assembly, for Style 51100 BM----- | 1 |
| 18 | 51745 | Looper Rocker Cone Stud----- | 1 |
| 19 | 51213 | Looper Rocker----- | 1 |
| 20 | 15465 F | Looper Rocker Cone----- | 1 |
| 21 | 88 | Screw----- | 2 |
| 22 | 258 A | Lock Nut----- | 1 |
| 23 | 22829 | Screw----- | 1 |
| 24 | 55241 N | Looper Connecting Rod Ball Joint, left----- | 1 |
| 25 | 269 | Nut, left thread, for Style 51100 BM----- | 1 |
| 25A | 43242 P | Nut, left thread, for Style 51100 BP----- | 1 |
| 26 | 51141 | Looper Connecting Rod, for Style 51100 BM----- | 1 |
| 27 | 18 | Nut, right thread, for Style 51100 BM----- | 1 |
| 27A | 15037 A | Nut, right thread, for Style 51100 BP----- | 1 |
| 28 | 51741 C | Looper Connecting Rod Ball Joint, right, for Style 51100 BM----- | 1 |
| 29 | 18 | Nut----- | 1 |
| 30 | 73 | Looper Set Screw----- | 1 |
| 31 | 51242 W | Looper Drive Lever, for Style 51100 BM----- | 1 |
| 32 | 22811 B | Screw----- | 1 |
| 33 | 12538 | Nut----- | 1 |
| 34 | 22894 H | Screw----- | 1 |
| 35 | 29192 L | Looper Rocker Assembly, for Style 51100 BP----- | 1 |
| 36 | 51745 | Looper Rocker Cone Stud----- | 1 |
| 37 | 51113 | Looper Rocker----- | 1 |
| 38 | 15465 F | Looper Rocker Cone----- | 1 |
| 39 | 88 | Screw----- | 2 |
| 40 | 258 A | Lock Nut----- | 1 |
| 41 | 22829 | Screw----- | 1 |
| 42 | 59348 C | Looper Connecting Rod, for Style 51100 BP----- | 1 |
| 43 | 51241 K | Looper Connecting Rod and Ball Joint, right, for Style 51100 BP----- | 1 |
| 44 | 56341 G | Spring----- | 1 |
| 45 | 50-458 Blk. | Spring Pin----- | 1 |
| 46 | 52742 H | Looper Drive Lever, for Style 51100 BP----- | 1 |
| 47 | 22811 B | Screw----- | 1 |
| 48 | 52470 | Stop, for looper connection rod, for Style 51100 BP----- | 1 |

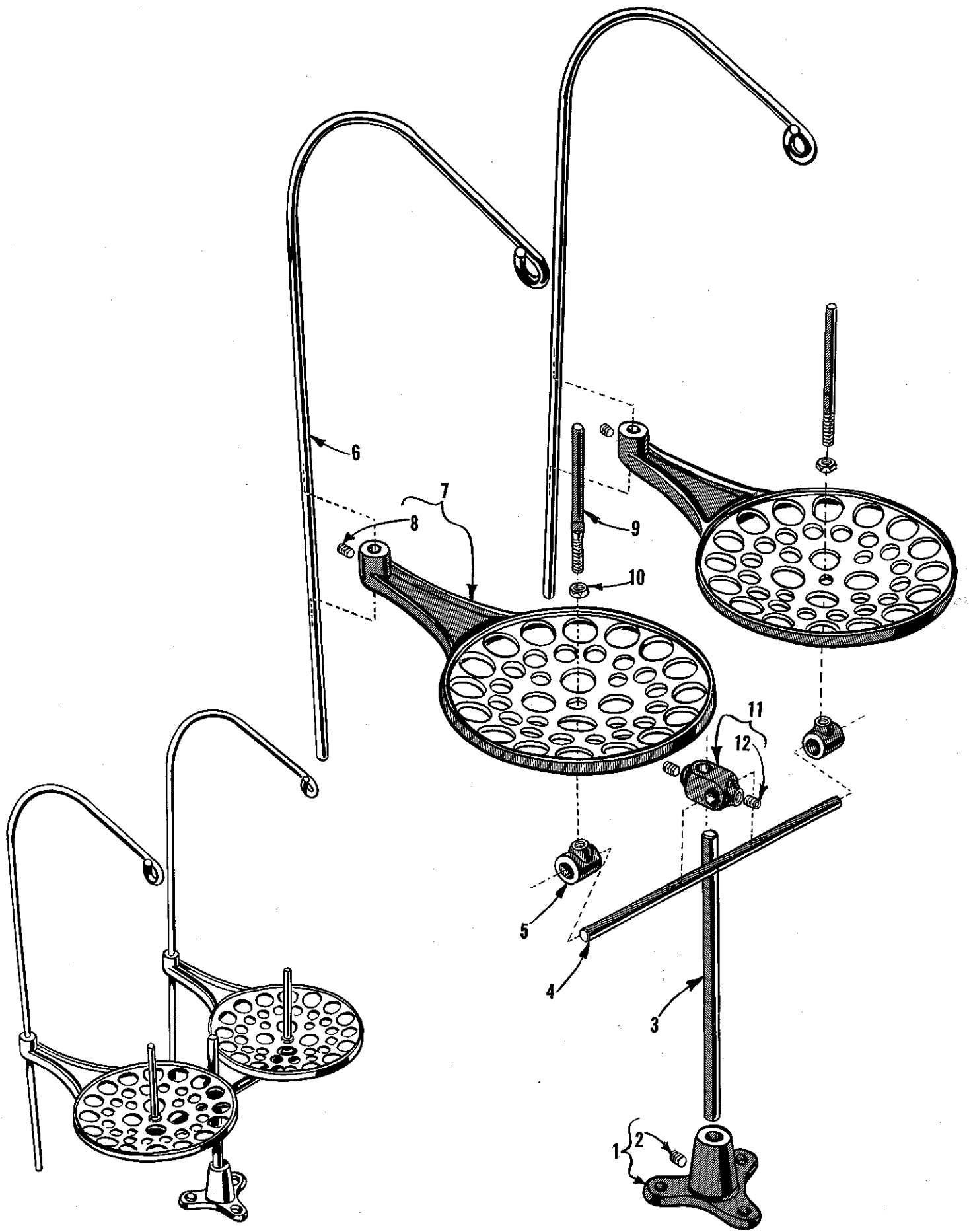


MAIN SHAFT AND FEED DRIVING PARTS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|-----------------|-----------------|-------------------------------------------------------------------------------|------------------|
| 1 | 269 | Nut, left thread ----- | 1 |
| 2 | 20 | Washer----- | 1 |
| 3 | 51236 E | Feed Crank Link Assembly----- | 1 |
| 4 | 660-169 | Needle Bearing----- | 1 |
| 5 | 51236 D | Feed Crank Link ----- | 1 |
| 6 | 51236 F | Ferrule ----- | 1 |
| 7 | 51054 | Feed Crank Pin ----- | 1 |
| 8 | 666-149 | Wick----- | 1 |
| 9 | 51185 D | Stitch Regulator End Cap----- | 1 |
| 10 | 51136 | Washer----- | 1 |
| 11 | 51136 F | Feed Crank Stud----- | 1 |
| 12 | 907 | Nut ----- | 1 |
| 13 | 51186 E | Stitch Regulator Indicator ----- | 1 |
| 14 | 22562 | Screw ----- | 1 |
| 15 | 51222 | Main Shaft ----- | 1 |
| 16 | 29476 DP | Feed Lift Eccentric Assembly, .140 inch throw----- | 1 |
| 17 | 51142 B | Feed Lift Eccentric----- | 1 |
| 18 | 22894 D | Screw ----- | 1 |
| 19 | 51145 A | Eccentric Bearing ----- | 1 |
| 20 | 51236 A | Link Pin (includes wick)----- | 2 |
| 21 | 29476 DR | Looper Avoid Eccentric Assembly, .080 inch throw, for Style 51100 BM ----- | 1 |
| 22 | 51142 C | Looper Avoid Eccentric ----- | 1 |
| 23 | 22894 D | Screw ----- | 1 |
| 24 | 51145 A | Eccentric Bearing ----- | 1 |
| 21 | 29476 DS | Looper Avoid Eccentric Assembly, .096 inch throw, for Style 51100 BP----- | 1 |
| 22 | 51142 E | Looper Avoid Eccentric ----- | 1 |
| 23 | 22894 D | Screw ----- | 1 |
| 24 | 51145 A | Eccentric Bearing ----- | 1 |
| 25 | 51123 G | Looper Thread Take-up ----- | 1 |
| 26 | 96 | Spot Screw----- | 1 |
| 27 | 22580 D | Screw ----- | 1 |
| 28 | 51105 G | Feed Dog, for Style 51100 BM ----- | 1 |
| 29 | 22528 | Screw ----- | 1 |
| 30 | 6605 L | Feed Dog, for Style 51100 BP----- | 1 |
| 31 | 51134 X | Feed Bar ----- | 1 |
| 32 | 22560 B | Screw ----- | 1 |
| 33 | 538 | Feed Dog Height Adjusting Screw----- | 1 |
| 34 | 6042 A | Feed Dog Holder Washer----- | 1 |
| 35 | 258 | Nut ----- | 1 |
| 36 | 22863 | Screw ----- | 1 |
| 37 | 56334 E | Feed Dog Holder ----- | 1 |
| 38 | 77 | Screw ----- | 1 |
| 39 | 51135 P | Feed Rocker Arm ----- | 1 |
| 40 | 55235 D | Screw ----- | 2 |
| 41 | 6042 A | Washer----- | 2 |
| 42 | 55235 E | Nut ----- | 2 |
| 43 | 77 | Screw ----- | 1 |
| 44 | 482 | Collar----- | 2 |
| 45 | 98 | Screw ----- | 1 |
| 46 | 51135 N | Feed Rocker ----- | 1 |
| 47 | 92127 | Screw ----- | 2 |
| 48 | 51134 C | Feed Bar Shaft ----- | 1 |
| 49 | 51134 R | Lubricating Felt Guard----- | 1 |
| 50 | 51134 P | Lubricating Felt----- | 1 |
| 51 | 8 | Feed Rocker Shaft ----- | 1 |

PRESSER FEET, LIFTER LEVER AND THREAD TENSION PARTS

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-------------|-----------------------------------------------------------------------|-----------|
| 1 | 43120 | Presser Foot, for Style 51100 BM ----- | 1 |
| 2 | 43130 | Presser Foot Bottom ----- | 1 |
| 3 | 15480 C | Spring ----- | 1 |
| 4 | 57 WD | Screw ----- | 1 |
| 5 | 43130 B | Finger Guard ----- | 1 |
| 6 | 22897 | Screw ----- | 1 |
| 7 | 88 | Screw ----- | 2 |
| 8 | 43130 A | Shank ----- | 1 |
| 9 | 187 A | Screw ----- | 1 |
| 10 | 22561 | Screw ----- | 1 |
| 11 | 198 X | Presser Foot, for Style 51100 BP ----- | 1 |
| 12 | 198 XA | Presser Foot Bottom ----- | 1 |
| 13 | 199 | Needle Guard ----- | 1 |
| 14 | 25 B | Screw ----- | 2 |
| 15 | 86 X | Screw ----- | 1 |
| 16 | 88 | Screw ----- | 2 |
| 17 | 65 XD | Shank ----- | 1 |
| 18 | 51257 K | Presser Bar, for Style 51100 BM ----- | 1 |
| 19 | 52888 A | Presser Bar, for Style 51100 BP ----- | 1 |
| 20 | 51257 M | Presser Bar Connection and Guide, for Style 51100 BM ----- | 1 |
| 21 | 53783 C | Presser Bar Connection and Guide, for Style 51100 BP ----- | 1 |
| 22 | 22560 B | Screw ----- | 2 |
| 23 | 402 | Screw ----- | 1 |
| 24 | 531 | Screw, for presser bar connection and guide, for Style 51100 BM ----- | 1 |
| 25 | 53787 | Presser Spring, for Style 51100 BP ----- | 1 |
| 26 | 53787 | Presser Spring, for Style 51100 BM ----- | 1 |
| 27 | 52889 A | Presser Spring Regulator, for Style 51100 BP ----- | 1 |
| 28 | 56356 | Presser Spring Regulator, for Style 51100 BM ----- | 1 |
| 29 | 53783 A | Lifter Lever Link (402) ----- | 1 |
| 30 | 22758 C | Screw ----- | 1 |
| 31 | 53783 L | Presser Foot Lifter Lever Bell Crank ----- | 1 |
| 32 | 52883 S | Presser Foot Lifter Lever Bell Crank Spring ----- | 1 |
| 33 | 22557 B | Screw ----- | 1 |
| 34 | 53783 M | Lifter Lever Connecting Rod ----- | 1 |
| 35 | 51183 B | Hand and Presser Foot Lifter Lever ----- | 1 |
| 36 | 22758 C | Screw ----- | 1 |
| 37 | 51183 C | Lifter Lever Latch ----- | 1 |
| 38 | 660-207 | Oil Seal Ring ----- | 1 |
| 38A | 39552 C | Washer ----- | 1 |
| 39 | 53783 N | Lifter Lever, internal ----- | 1 |
| 40 | 22537 | Screw ----- | 1 |
| 41 | 43266 | Nut ----- | 1 |
| 42 | 52892 | Tension Post Support ----- | 1 |
| 43 | 22872 | Screw ----- | 1 |
| 44 | 51192 G | Tension Post Eyelet ----- | 2 |
| 45 | 21114 M | Retaining Ring ----- | 2 |
| 46 | 668-27 | Eyelet ----- | 2 |
| 47 | 51192 B | Tension Post Ferrule ----- | 2 |
| 48 | 109 | Tension Disc ----- | 4 |
| 49 | 51292 | Tension Post ----- | 2 |
| 50 | 51292 F-8 | Needle Tension Spring, for Style 51100 BM ----- | 1 |
| | 51292 F-14 | Needle Tension Spring, for Style 51100 BP ----- | 1 |
| 51 | 51292 F-2 | Looper Tension Spring ----- | 1 |
| 52 | 51292 C | Tension Nut ----- | 2 |
| 53 | J87 J | Screw ----- | 2 |
| 54 | 77 | Screw ----- | 1 |
| 55 | 51204 C | Auxiliary Cast-off Support ----- | 1 |
| 56 | 51104 H | Auxiliary Cast-off ----- | 1 |
| 57 | 51204 A | Cast-off Wire Support ----- | 1 |
| 58 | 22798 A | Screw ----- | 1 |
| 59 | 51204 | Cast-off Wire ----- | 1 |
| 60 | 51157 H | Cast-off Wire Support ----- | 1 |
| 61 | 51104 F | Cast-off Wire ----- | 1 |
| 62 | 22593 | Screw ----- | 2 |
| 63 | 51158 D | Take-up Eyelet ----- | 2 |
| 64 | 21657 E | Washer ----- | 1 |
| 65 | 22528 | Screw ----- | 1 |
| 66 | 50-216 Blk. | Dowel Pin, for No. 51157 H ----- | 1 |



THREAD STAND PARTS

| <u>Ref. No.</u> | <u>Part No.</u> | <u>Description</u> | <u>Amt. Req.</u> |
|---------------------|---------------------|-------------------------------|----------------------|
| 1 | 21114 A | Thread Stand Base----- | 1 |
| 2 | 22651 CD-3 | Screw----- | 1 |
| 3 | 21104 B-9 | Thread Stand Rod----- | 1 |
| 4 | 21104 B-11 | Thread Stand Rod----- | 1 |
| 5 | 21104 E | Spool Support Connection----- | 2 |
| 6 | 21113 C | Guide Wire----- | 2 |
| 7 | 21130 S | Cone Support----- | 2 |
| 8 | 22650 CD-4 | Screw----- | 1 |
| 9 | 21104 G | Spool Pin----- | 2 |
| 10 | 21104 H | Nut----- | 2 |
| 11 | 21104 C | Rod Connection----- | 1 |
| 12 | 22650 CE-6 | Screw----- | 2 |

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| 25 S | 9 | 906 | 9 | 22729 A | 11 |
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| 50-458 Blk | 17 | 6042 A | 11, 19 | 22733 B | 9 |
| 50-648 Blk | 11 | 6605 L | 19 | 22747 A | 13, 15 |
| 50-789 Blk | 9 | 6624 L | 9 | 22758 C | 21 |
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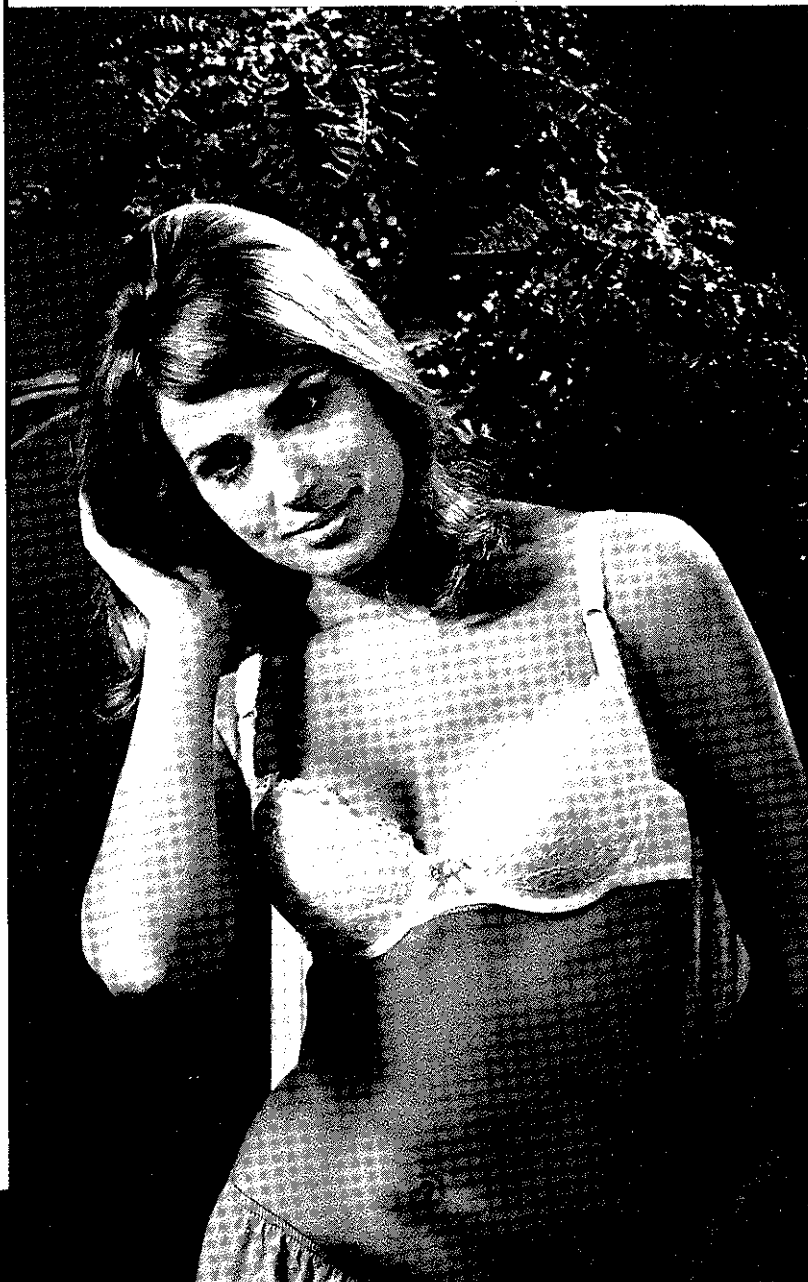


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