

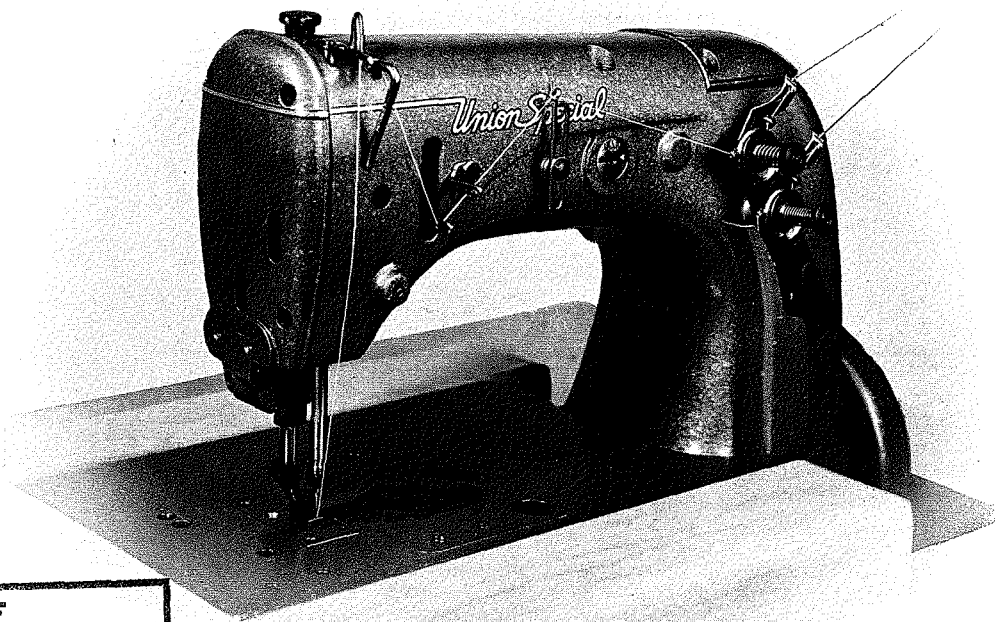
FINEST QUALITY

Union Special[®]

LEWIS • COLUMBIA

INDUSTRIAL
SEWING
MACHINES

STYLE
51200 BC



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CATALOG
No. T110 L

LIST OF PARTS
FOR
STYLE 51200 BC

Union Special MACHINE COMPANY
CHICAGO

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			
(D & D Min.)	85	85	85
Compounding	None	None	None
Copper Corrosion (Max.)	1A	1A	1A

*Online 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**[®]
FINEST QUALITY **MACHINE COMPANY**

Catalog No. T110 L

LIST OF PARTS

Style

51200 BC

First Edition

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Union Special
MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U.S.A.

February, 1973

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 51200 BC". 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: "51200 BCZ".

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 "51200".

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 51200. 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 away from the operator.

DESCRIPTION OF MACHINE

51200 BC Streamlined Low Throw Flat Bed Machine, for Seaming Women's Fancy Dress Gloves made from Rayon, Nylon, Cotton or Silk, and for Similar Operations on Light Weight Materials. Light Weight Presser Bar and Needle Bar Driving Mechanism. Single Reservoir Enclosed Automatic Lubricating System and Filter Type Oil Return Pump. Seam Type SSa-1, Stitch Type 401.

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 largest diameter of blade measured in thousandths of an inch midway between shank and eye. Collectively, type number and size number represent the complete symbol.

Standard needle for Style 51200 BC is Type 124 GCS. It is a short length, double groove, spotted, short blade, long point, struck groove, chromium plated needle with diameter of shank .080 inch, and is available in sizes 027, 029, 032. Unless otherwise specified, the machine will be equipped with size 027.

To have needle orders promptly and accurately filled, the empty package, a sample needle, or type and size number should be given. See description on label. A complete order would read "1000 Needles, Type 124 GCS, size 027".

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

USE GENUINE NEEDLES AND REPAIR PARTS

Success in the operation of this machine can be secured only with 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 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 trade mark. Each trade mark is your guarantee of the highest quality in materials and workmanship.

IDENTIFYING PARTS

Where the construction permits, each part is stamped with its part number. On some of the 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.

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

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 level is checked at the oil sight gauge on the front of the machine. The oil level should be maintained between the red lines on the oil gauge. The capacity of the oil reservoir is twelve ounces.

The machine is automatically lubricated and no oiling other than keeping the main reservoir filled is necessary.

A daily check before the morning start should be made and oil added if required.

Oil which has gone through the machine is filtered and pumped back into the main reservoir making too frequent oiling unnecessary.

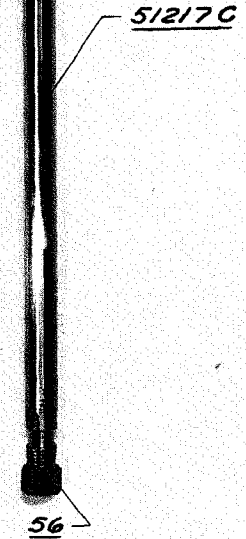
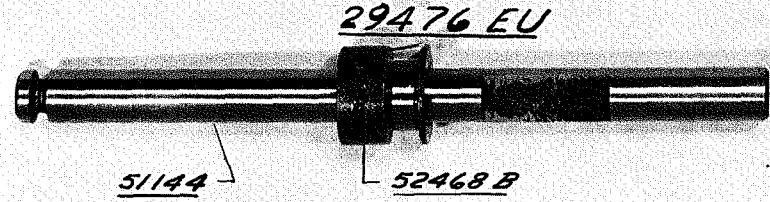
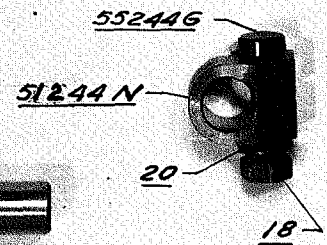
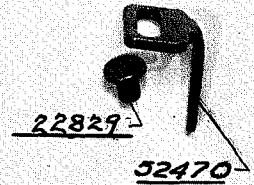
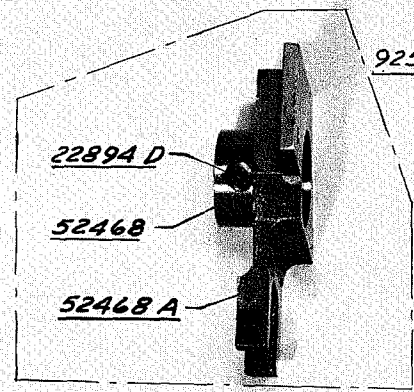
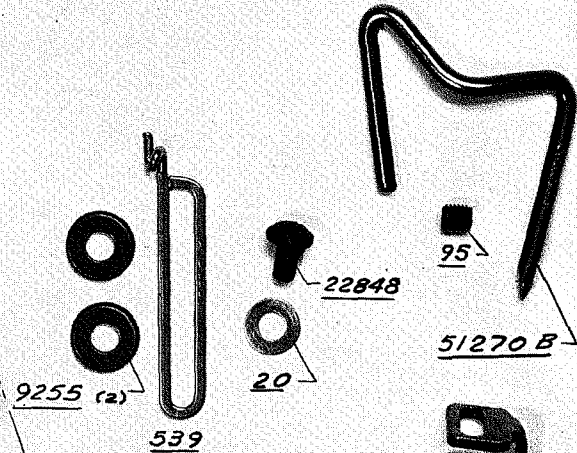
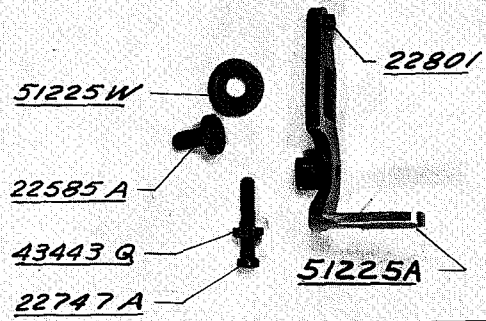
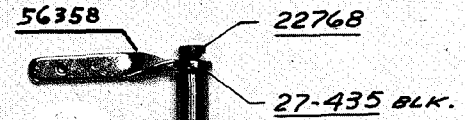
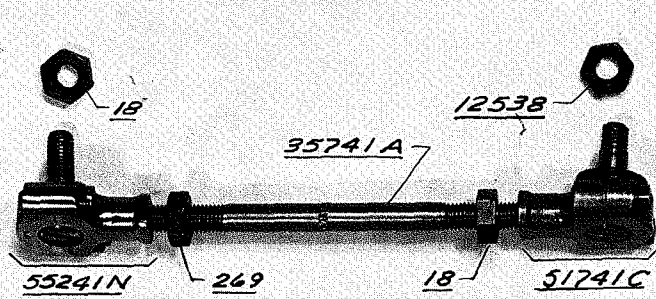
Excessive oil in the main reservoir, may be drained at the plug screw, in the main frame directly under the handwheel.

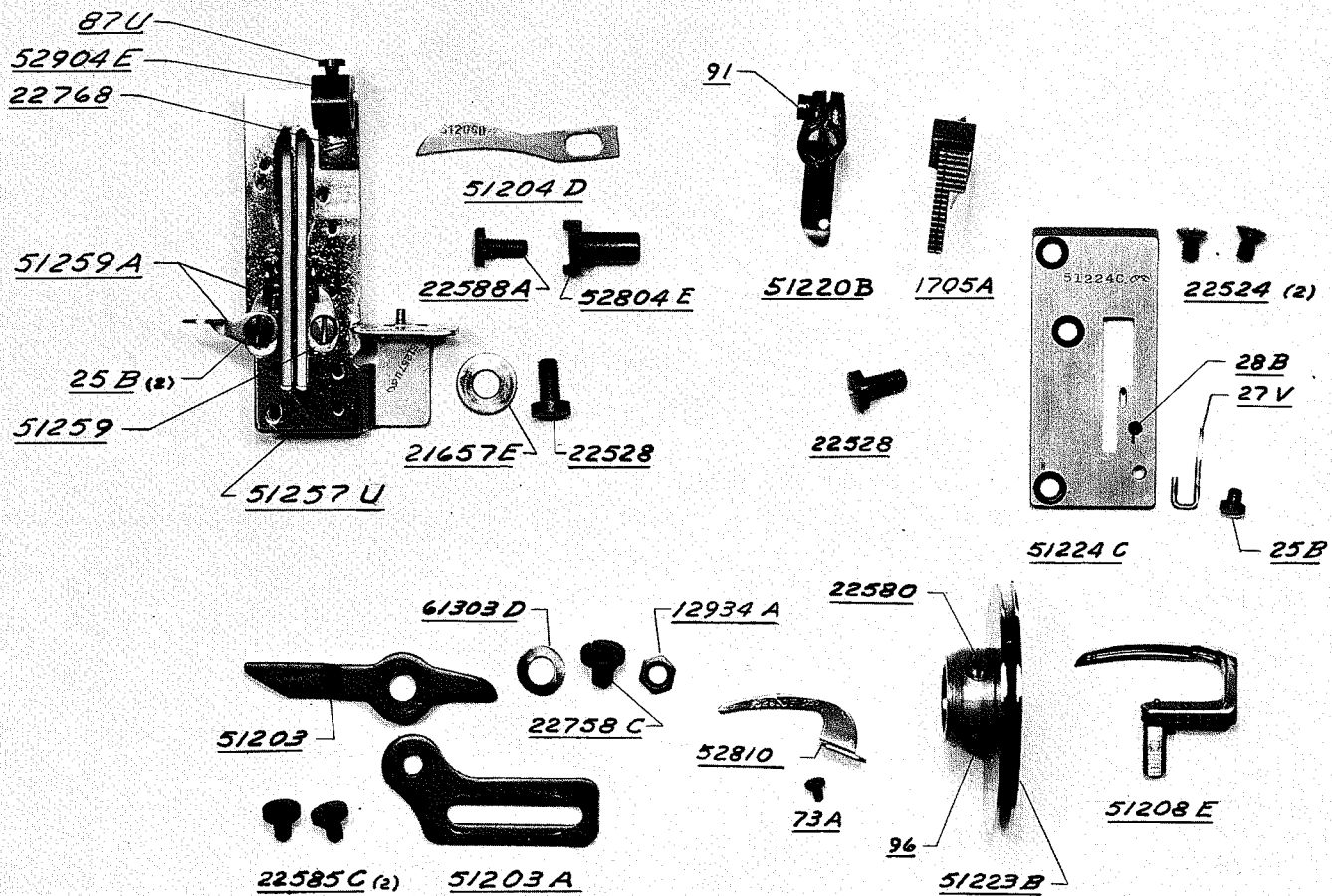
The following is a numerical list of the parts used in this machine. Quantities, part numbers, and descriptions are given. Following the parts list are photographs of some of the major parts.

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Feed Rocker Shaft	2	666-179	Wedge Pin for 666-111	1	22883 A	Plug Screw for looper
3	18	Nut for 35741 A, 55241 N, 55244 G	2	719	Screw for 51150, 51250 E	1	22889 A	Plug Screw for 539
3	20	Washer for 539, 51236 G, 55244 G	1	1705 A	Feed Dog (22528)	1	22894 D	Spot Screw for 52468
3	25 B	Screw for 51259, 51259 A	2	6042 A	Washer for 52894 AM	1	22894 D	Screw for feed lifter and looper avoid ecc.
1	25 B	Screw for 27 V	1	9255	Washer for 539	2	22894 F	Set Screw for pulley
1	27-435 Blk.	Needle Bar Eyelet Washer	1	12538	Nut for 51741 C	1	22894 H	Screw for 52942
1	27 V	Retainer for 51224 C (25 B, 28 B)	1	12934 A	Nut for 22758 C	2	22894 J	Screw for 51247
1	28 B	Regulating Screw for 27 V	1	12982	Lock Nut for 81	2	22894 W	Screw for 15465 F
1	50-648 Blk.	Needle Bar Eyelet Washer	1	15465 F	Looper Rocker Cone (22894 W)	1	29066 R	Needle Lever Con- necting Rod Assembly
1	50-648 Blk.	Needle Bar Eyelet Washer	1	B21375 AH	Belt Guard (93)	1	29105 R	Looper Drive Eccentric Assembly
1	50-648 Blk.	Needle Bar Eyelet Washer	1	21657-3	Tension Release Separator (22598 C)	1	29192	Looper Rocker Assembly
2	52 A	Thread Eyelet (98 A)	1	21657 E	Washer for 51257 U	1	29348 P	Needle Lever Assembly
1	54	Needle Lever Link	1	21657 W	Tension Release Lever Shaft	1	29476 DV	Feed Lifter Eccen- tric Assembly
1	56	Needle Clamp Nut	1	21657 X	Tension Release Lever Shaft Bushing	1	29476 DV	Looper Avoid Eccen- tric Assembly
1	73	Screw for looper	1	21657 Y	Tension Release Lever Shaft Connec- tion (22596)	1	29476 EU	Needle Guard Actua- ting Eccentric Assembly
1	73 A	Screw for 52810	4	22513	Screw for 35731 A	1	29476 FG	Crankshaft Assem- bly
3	77	Screw for 51054, 51236 A	2	22519 C	Screw for 51235 A	2	35178 D	Spring for 666-114
2	80	Screw for 51280 AA	1	22519 H	Screw for 51244 B	2	35178 D	Spring for 666-65
2	80	Screw for 51301 D	7	22524	Screw for 53782 B	2	35731 A	Presser Bar Connec- ting Guide Plate (22513)
1	81	Screw for 52742 K (12982)	2	22524	Screw for 51224 C	1	35741 A	Looper Connecting Rod (18, 269)
1	82	Screw for 51236 G	1	22528	Screw for 51257 U	3	35772 H	Washer for 51281 AC
1	87 U	Screw for 52804 E	1	22528	Screw for 1705 A	2	41394 A	Gasket for 22733 B
4	90	Screw for 52882 Y, 52894 AB	1	22537	Screw for 53783 N	1	43266	Nut for 51292 G
1	91	Clamp Screw for presser foot	1	22539 H	Plug Screw	1	43443 Q	Nut for needle guard regulating screw
2	93	Screw for B21375 AH	3	22541 B	Screw for 52882 AD	3	51054	Feed Crank and Needle Lever Link Pin (77, 22564)
2	95	Screw for 51147	4	22548	Screw for 52882 AE	1	51134	Feed Bar
1	95	Screw for 51270 B	1	22557 B	Screw for 53783 L	1	51134 C	Feed Bar Shaft (22560 B)
1	95	Plug Screw	2	22559 G	Screw for 51216 K	1	51134 J	Washer for 51134 H
1	96	Spot Screw for 51223 B	1	22560 B	Screw for 52494 A	1	51134 P	Oil Felt for 51134 C
1	96	Screw for 52444 B	1	22560 B	Screw for 51134 C	1	51134 R	Oil Felt Guard
1	98	Screw for 482	1	22562 A	Screw for 51254 J	1	51144	Looper Rocker Shaft
2	98	Screw for 52444 B	1	22564	Screw for 51054	2	51145 A	Feed Lift and Looper Avoid Eccentric Link
2	98 A	Screw for 51235	5	22569 B	Screw for 51782 A	1	51147	Main Shaft Collar (95)
1	98 A	Screw for 52 A	3	22569 B	Screw for bearing housing (52891 B)	1	51150	Needle Lever Shaft Stop Collar (719)
1	98 A	Screw for 51291 A	18	22571 A	Plug Screw	1	51203	Edge Guide (12934 A, 22758 C, 61303 D)
4	109	Tension Disc	1	22580	Set Screw for 51223 B	1	51203 A	Edge Guide Base (22585 C)
1	258	Nut for 660-136	1	22585 A	Screw for needle guard	1	51204 D	Looper Thread Retaining Finger (22588 A)
1	258 A	Nut for 56334 E	2	22585 A	Screw for 53782 B	1	51208 E	Looper
1	258 A	Nut for 52894 AM	2	22585 C	Screw for 51203 A	1	51213	Looper Rocker
1	258 A	Check Nut for 51745	1	22586 R	Screw for 660-212	1	51215 J	Needle Lever
2	269	Nut for 35741 A, 51236 G	1	22588 A	Screw for 51204 D	2	51216 G	Needle Lever Connecting Rod
1	402	Screw for 51283 H	1	22596	Screw for 21657 Y	1	51216 M	Needle Bearing
1	402	Screw for 53783 A	1	22598 C	Screw for 21657-3	28	51216 N	Washer for 51215 J
2	482	Feed Rocker Shaft Collar (98)	1	22729	Screw for 51243 C	1	51216 P	Nut for 51215 J
1	531	Screw for 51257 M	1	22733 B	Plug Screw for 52882 L	1	51217 C	Needle Bar
1	538	Feed Dog Height Adjusting Screw	1	22747 A	Needle Guard Regu- lating Screw	1	51220 B	Presser Foot
1	539	Frame Needle Thread Eyelet (20, 9255, 22848, 22889 A)	1	22758 C	Screw for 51203 (12538)	1	51221 C	Pulley (22894 F)
1	643-127 Blk.	Gasket for oil pump	3	22758 C	Screw for 53783 A	1	51222 E	Main Shaft
1	660-136	Feed Crank Link Oil Tube (258 A)	1	22760 A	Screw for 51281 AC	1	51223 B	Take-up (96, 22580)
1	660-207	Oil Seal Ring for foot lifter lever bushing	1	22768	Screw for 56358 A	1	51224 C	Throat Plate (22524)
2	660-212	Oil Seal Ring for needle lever stud (22586 R)	1	22768	Screw for 56358 A	1	51225 A	Needle Guard (22585 A)
2	666-65	Oil Wick for 51144	1	22768	Screw for 51244 B	1		
2	666-111	Oil Wick for 8	1	22768	Screw for 52904 E	1		
2	666-114	Oil Wick for right main shaft bearing	1	22801	Stud Screw for needle guard	1		
2	666-118	Oil Wick for left main shaft bearing	1	22807	Screw for 51301 D	1		
1	666-121	Oil Wick for 51293 T	2	22823 A	Screw for 51493 AD	1		
1	666-170	Felt Wick for 51250 E	1	22823 B	Screw for 51493 AD	1		
			2	22829	Scr. for 29192, 52470	1		
			1	22834	Needle Guard Ad- justing Screw	1		
			2	22839 C	Screw for 51301 D	1		
			1	22845 B	Screw for 51281 AC	1		
			1	22848	Screw for 539	1		
			9	22848	Screw for 52882 L	1		
			1	22852 A	Screw for 52742 K	1		
			1	22863	Feed Dog Holder Adjusting Screw	1		

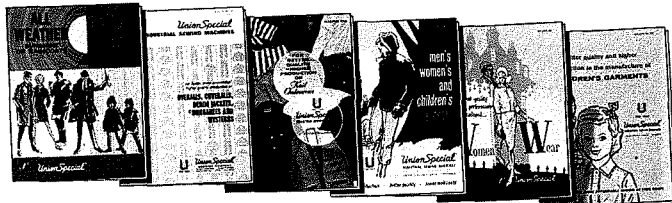
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51225 W	Washer for K68017	2	51292 A	Tension Post Ferrule	1	52892	Tension Post Support
1	51235	Feed Rocker (98)	2	51292 C	Tension Nut	2	52894 AB	Oil Tube Holder
1	51235 A	Feed Rocker Arm (22519 C)	2	51292 D	Tension Thread Eyelet	1	52894 AM	Oil Tube for right looper connecting rod ball joint (258 A, 6042 A)
2	51235 G	Washer for 22519 C	1	51292 F-1	Tension Spring (looper)	1	52904 E	Retaining Finger Support (22768)
2	51236 A	Feed Lift and Looper Avoid Eccentric Link Pin (77, 22768)	1	51292 F-5	Tension Spring (needle)	2	52936	Feed Rocker Shaft Bushing
1	51236 E	Feed Crank Link Assembly	2	51292 G	Tension Post (43266)	1	52942	Looper Drive Lever (22894 H)
1	51236 G	Feed Crank Stud (82)	4	51295 A	Isolator for base plate assembly	1	52944 T	Looper Rocker Shaft Bushing, left
2	51242 L	Thrust Washer	1	51301 D	Cloth Plate (80, 22837)	1	52944 U	Looper Rocker Shaft Bushing, right
1	51242 M	Washer for 22852 A	1	51382 A	Gasket for 53782 B	1	53782 B	Oil Reservoir Top Cover (22524, 22585 A, 51382 A)
1	51242 M	Washer for 52841 G	1	51406	Feed Lift Eccentric (22894 D)	1	53783 A	Lifter Lever Link (402, 22758 C)
1	51242 P	Looper Drive Lever Shaft	2	51491 C	Lead-in Thread Eyelet	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
1	51242 R	Looper Drive Lever Shaft Bushing (middle)	1	51493 D	Pump Driving Shaft	1	53783 M	Presser Foot Lifter Lever Connecting Rod
1	51242 S	Looper Drive Lever Shaft Bushing (rear)	1	51493 E	Pump Driving Shaft Gear	1	53783 N	Presser Foot Lifter Lever (22537)
1	51242 Z	Looper Drive Lever Shaft Bushing (front)	2	51493 AD	Base Plate Assembly (22823 A, 22823 B)	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
1	51243 C	Ball Stud Fork (22729)	1	51493 AG	Pump Housing (22569 B)	1	55244 G	Looper Shaft Collar Stud (18, 20)
1	51244 B	Looper Rocker Shaft Arm (22768)	1	51493 AH	Oil Pump Housing Cover	1	56334 E	Feed Dog Holder (258 A)
2	51244 L	Thrust Washer	1	51493 BH	Felt Pad	1	56356	Presser Spring Regulator
1	51244 N	Looper Rocker Shaft Collar 18, 20, 55244 G	1	51493 BP	Filter Cap Assembly	1	56358	Needle Bar Thread Eyelet (22768)
1	51246	Looper Rocker Stud Nut	1	51493 BQ	Pump Driving Gear	1	56358 A	Needle Lever Thread Eyelet (22768)
1	51247	Main Shaft Counter- weight (22894 J)	1	51741 C	Pump Driven Gear	1	56390 E	Crankshaft Bearing Housing Gasket
1	51250 D	Washer for 22586 R	1	51745	Looper Connecting Rod Ball Joint (right) (12538)	1	61303 D	Washer for 51203
1	51250 E	Needle Lever Stud (719)	1	51782 A	Looper Rocker Cone Stud (258 A)	2	80557	Spacing Washer for 21657-3, 52892
1	51250 F	Gasket for 22586 R	1	52444 B	Head Cover (22569 B)			
1	51254 C	Needle Bar Bushing (upper)	1	52468 B	Looper Rocker Frame (96, 98)			
1	51254 D	Needle Bar Bushing (lower)	1	52470	Needle Guard Collar			
1	51254 J	Needle Bar Connec- tion (22562 A)	1	52494	Needle Thread Pull- off (22829)			
1	51256 C	Presser Bar Spring	1	52494 A	Oil Tube			
1	51257 K	Presser Bar	1	52742 K	Oil Tube for looper rocker ball joint and needle guard eccentric (22560 B)			
1	51257 M	Presser Bar Connec- tor Guide (531)	1	52794 G	Looper Drive Lever Rocker (81, 22852 A)			
1	51257 U	Cast-off Support Plate (22528)	1	52804 E	Oil Tube, for feed lift and looper avoid eccentric			
1	51257 AA	Presser Bar Bushing (lower)	1	52810	Retaining Finger Holder (87 U)			
1	51259	Cast-off Plate Eyelet, right (25 B)	1	52810	Looper Needle Guard (73 A)			
2	51259 A	Cast-off Plate Eyelet, left (25 B)	1	52841 G	Locking Stud for 51242 Y			
1	51270 B	Needle Thread Take-up Wire (95)	1	52841 J	Nut for 52841 G			
1	51280 AA	Throat Plate Support (80)	1	52882 L	Oil Reservoir Back Cover (22848)			
1	51281 AC	Cloth Plate Cover Spring (22760 A, 22845 B)	1	52882 M	Gasket for 52882 L			
1	51281 AH- 227	Cloth Plate Cover Gasket for 51782 A	1	52882 P	Gasket for 52882 N			
1	51282 Z	Needle Lever Bearing Oiler (90)	1	52882 U	Gasket for 52882 T			
1	51282 AE	Presser Foot Lifter and Tension Disc Release Lever (402)	1	52882 Y	Baffle Plate (90)			
1	51283 H	Looper Thread Guard (98 A)	3	52882 AD	Chamber Cover (22541 B)			
1	51291 A		1	52882 AE	Crank Chamber Cover (22548)			
			1	52883 R	Foot Lifter Lever Bushing			
			1	52883 S	Presser Foot Lifter Lever Bell Crank Spring			
			1	52890 C	Main Shaft Bushing			
			1	52891 B	Crankshaft Bushing Housing includes bushing (22569 B)			

NOTE: Numbers in parentheses following parts' description indicate the screws, nuts, etc. used to attach or hold these parts.





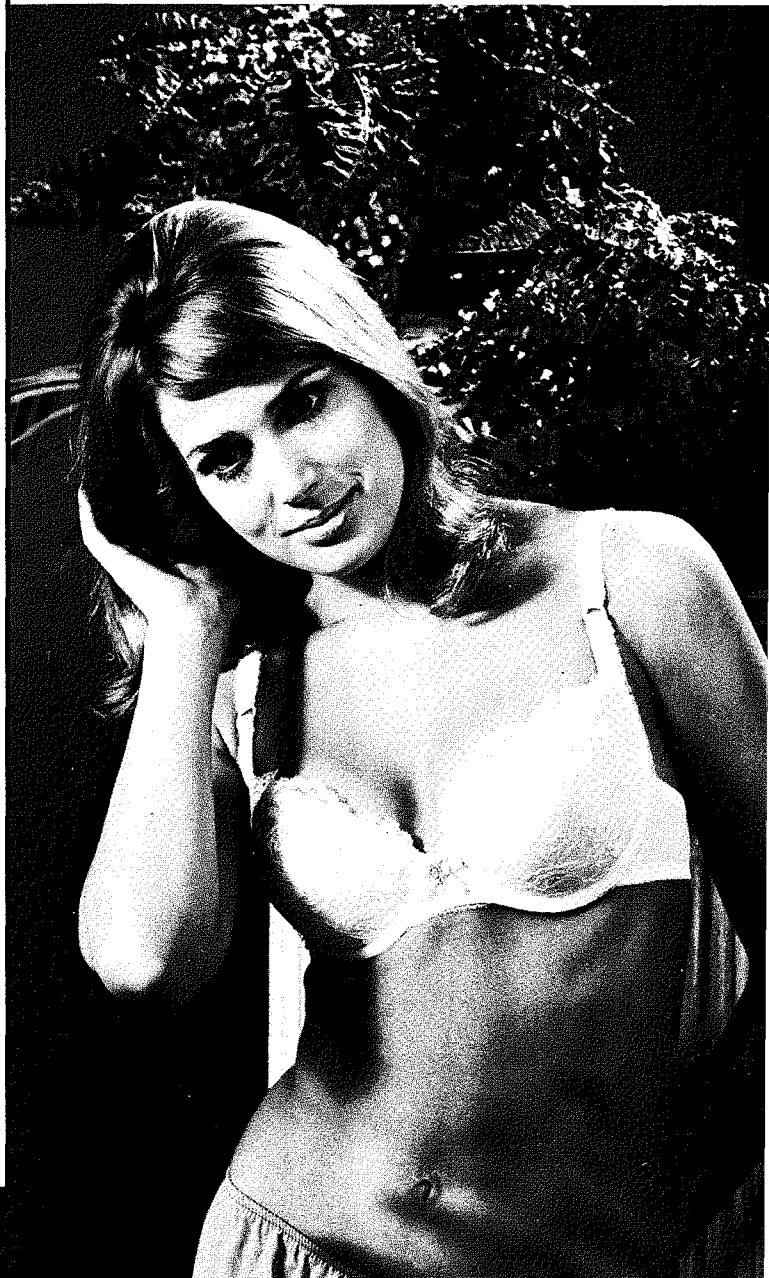
Helpful, authoritative information on the most efficient types of equipment for making virtually any machine sewed article is available from Union Special's Sales Promotion Department. Among the many interesting, illustrated bulletins that are available without obligation are the following:



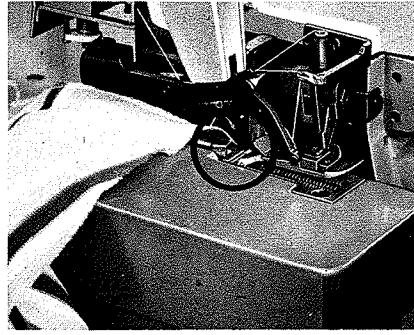
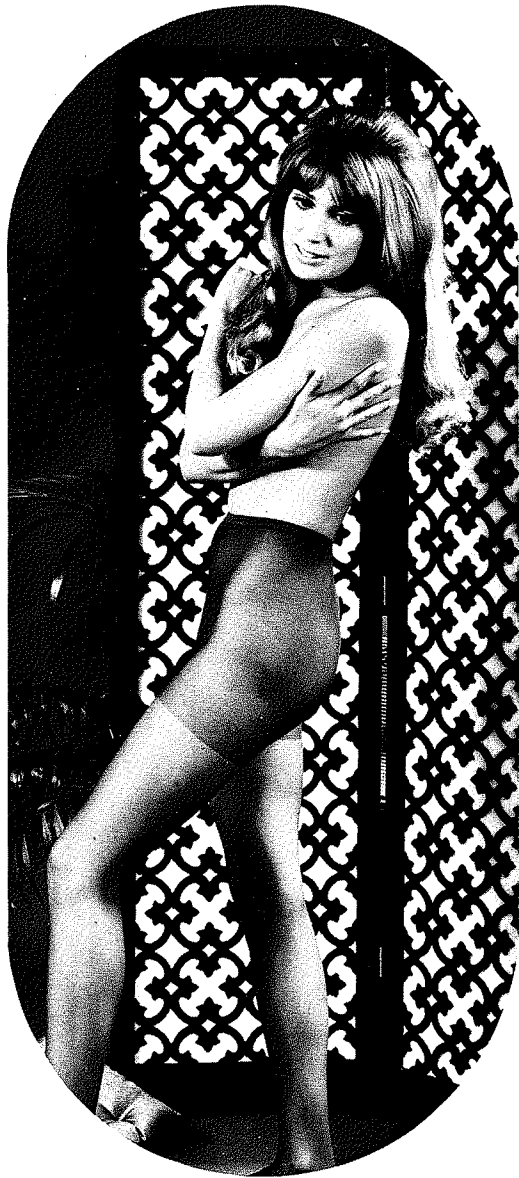
- No. 240, "Men's, Women's, Children's Footwear"
- No. 249, "Rainwear"
- No. 250, "Men's Dress Shirts"
- No. 251, "Service Shirts and Pants"
- No. 252, "Men's Shorts and Pajamas"
- No. 253, "Overalls, Coveralls, and Dungarees"
- No. 254, "Men's Knit Underwear"
- No. 256, "Knit Outerwear"
- No. 259, "Men's Sports Shirts"
- No. 260, "Work Gloves"
- No. 262, "Cotton, Burlap, Jute, and Multiwall Paper Bags"
- No. 263, "Men's Clothing"
- No. 264, "Men's Women's, Children's Jackets"
- No. 265, "Women's Wear"
- No. 266, "Women's Wear And High Fashion"
- No. 267, "Corsets, Girdles, Brassieres"
- No. 268, "Children's Wear"
- No. 269, "Mattresses, Slip Covers, Furniture Upholstery"
- No. 271, "Awnings, Canopies, Tents, Tarps"
- No. 273, "Curtains & Drapes"
- No. 610, "Klipp-it"
- No. 710, "MCS ForMation Unit"
- No. 730, "MCS Automatic Dual Underfront Shirt Hemmer"
- No. 740, "MCS Automatic Rib-Knit Cuff Machine"
- No. 750, "Fusing Presses"
- No. 1100, "Lewis Blindstitch, Chainstitch, Lockstitch, Machines"
- No. 1105, "Button Sewers—Ticket Tackers"
"Columbia Blindstitch, Saddle Stitch, and Tie Closing Machines"
- No. 1500, "Alteration Department Machines"

 **Union Special**[®]
FINEST QUALITY **MACHINE COMPANY**

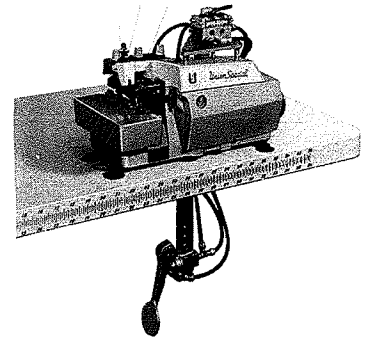
**HERE ARE HELPFUL
BULLETINS and CATALOGS
TO HELP YOU SOLVE
SEWING PROBLEMS**



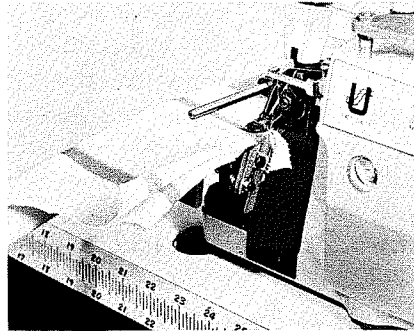
BOOST PRODUCTION WITH THESE WORK AIDS FROM UNION SPECIAL



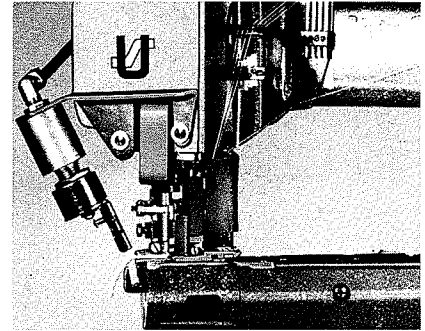
PNEUMATIC CHAIN-CUTTER—for use on conventional Class 39500 and 39600 is a durable scissor-action mechanism that makes a clean positive cut. Style 2899 A-1



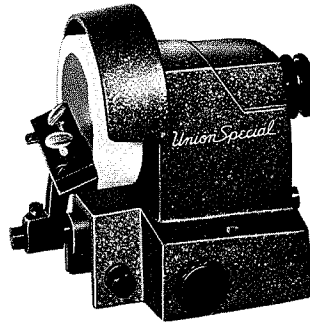
PNEUMATIC FOOT LIFTER—The air-operated foot lifter for use on Class 39500 machines allows the operator to raise the foot simply by knee-touching an actuating switch.



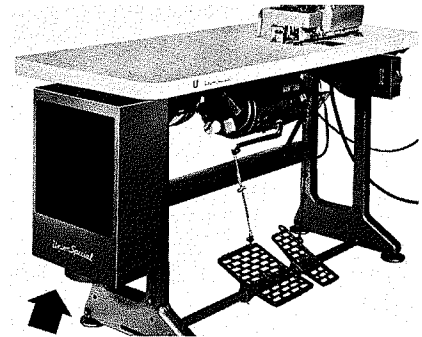
AIR FABRIC UNCURLER—This unit, designed for Class 39500 machines, uses air jets to remove curls from top and bottom plies of flat knit materials as fabric passes through sewing area. Style 2899 B-1



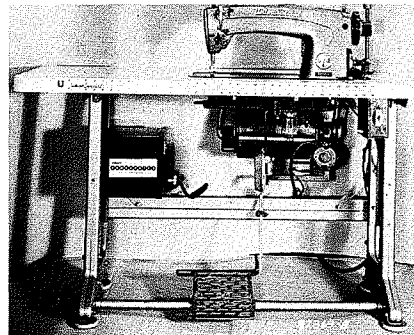
CHAIN CUTTER—The above photo shows the small pneumatic chain cutter that is available for installation as an accessory unit on Class 36200 Flatseamers. Style 2899 A-6



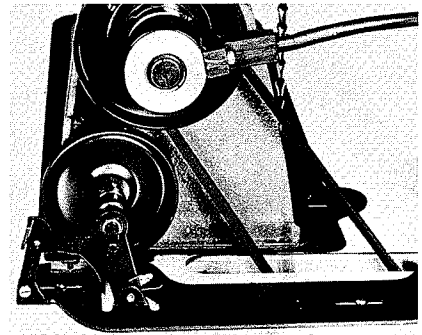
KNIFE GRINDER sharpens straight or angle type knives, is simple and easy to operate, eliminates defective garments caused by dull knives.



HEAT DISPELLER—Union Special's auxiliary unit (arrow) is an effective means for reducing oil temperature where heavy duty service requires it. Style 2899 E-1



AMCO ELECTRONIC NEEDLE POSITIONERS eliminate the necessity of reaching for the hand-wheel to move the needle up or down . . . this allows the operator to keep both hands on the work, insuring better control, uniform quality and increased production.



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