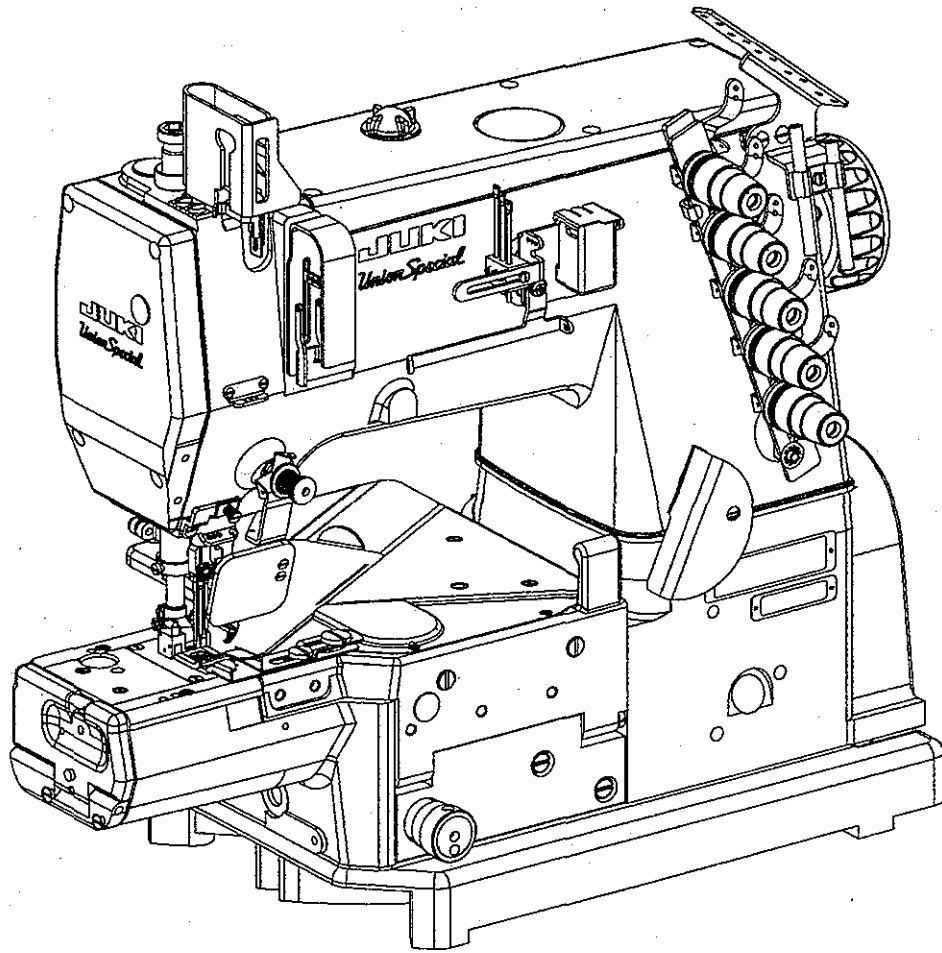




**JUKI**  
*Union Special*

**ILLUSTRATED PARTS MANUAL**



**CS100 SERIES, DIFFERENTIAL FEED,  
HIGH SPEED CYLINDER BED MACHINES**

**MANUAL NO. PT9425**

**STYLES**  
**CS122H01**  
**CS132H01**

# Manual No. PT9425 Illustrated Parts List for CS100 Series Machines

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By

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## PREFACE

This parts manual has been prepared to assist you in locating individual parts or assemblies on CS100 Series machines. It can be used in conjunction with Union Special Operator's Manual OP9423 and Engineer's Manual EN9424.

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.

This manual has been comprised on the basis of available information. Changes in design and/or improvements may incorporate a slight modification of configuration in illustrations or part numbers.

On the following pages are illustrations and terminology used in describing the parts used on CS100 Series machines.



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## SAFETY RULES

1. Before putting the machines described in this manual into service, carefully read the instructions. The starting of each machine is only permitted after taking notice of the instructions and by qualified operators.

**IMPORTANT!** Before putting the machine into service, also read the safety rules and instructions from the motor supplier.

2. Observe the national safety rules valid for your country.
3. The sewing machines described in this instruction manual are prohibited from being put into service until it has been ascertained that the sewing units which these sewing machines will be built into, have conformed with the EC Council Directives (89/392/EEC, Annex II B).

Each machine is only allowed to be used as foreseen. The foreseen use of the particular machine is described in paragraph "STYLES OF MACHINES" of this instruction manual. Another use, going beyond the description, is not as foreseen.

4. All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.
5. Wear safety glasses.
6. In case of machine conversions and changes all valid safety rules must be considered. Conversions and changes are made at your own risk.
7. The warning hints in the instructions are marked with one of these two symbols:



8. When doing the following the machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug:
  - 8.1 When threading needle(s), looper, spreader etc.
  - 8.2 When replacing any parts such as needle(s), presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, fabric guide etc.
  - 8.3 When leaving the workplace and when the workplace is unattended.
  - 8.4 When doing maintenance work.
  - 8.5 When using clutch motors without actuation lock, wait until the motor is stopped totally.
9. Maintenance, repair and conversion work (see item 8) must be done only by trained technicians or special skilled personnel under consideration of the instructions.
10. Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.
11. Work on parts and equipment under electrical power is not permitted. Permissible exceptions are described in the applicable sections of standard sheet DIN VDE 0105.
12. Before doing maintenance and repair work on the pneumatic equipment, the machine has to be disconnected from the compressed air supply. In case of existing residual air pressure after disconnecting from compressed air supply (i.e. pneumatic equipment with air tank), the pressure has to be removed by bleeding.

## 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.

## STYLES OF MACHINES

Precision three needle cylinder bed machines. Rotary mainshafts for smoother, quieter and faster operations. Equipped with quick change for main and differential feed. Independently driven rear needle guard, no adjustment necessary when changing stitch length. Adjustable looper avoid eccentric to adapt the looper avoid motion and the elliptic path of looper to the required needle size and type of sewing threads.

CS132H01-3B\_/\_UT5 HEMMER. Three needle, top cover thread, electro pneumatic under bed thread trimmer and pneumatic spreader thread trimmer. - Typical Application - For circular hemming on light, medium and heavy weight knitted fabrics and for hemming neck, leg, and arm holes on swimwear and underwear, also suitable for children's sizes. Seam Specification 605 EFa-1. Standard gauge numbers 056, (7/32", 5.6mm), 060, (15/64", 6.0mm). Recommended needle 121 GJS, needle range sizes 055/022 - 090/036. Maximum recommended speed, depending on application is up to 6500 R.P.M.

CS122H01-3B\_/\_UT4 HEMMER. Three needle, differential feed, bottom coverstitch, cylinder bed machine with electro-pneumatic under bed thread trimmer and blower type needle thread wiper. - Typical Application - For circular hemming operations on light, medium and heavy weight knit fabrics. Seam Specifications 605EFa-1. Standard gauge number 060, (15/64", 6.0mm). Recommended needle 121GJS, needle range sizes 055/022 - 090/036. Maximum recommended speed, depending on application is up to 6500 R.P.M.

## ILLUSTRATIONS

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.	50366B	Needle Thread Strike-Off Assembly .....	1
6.	50358V	Needle Thread Strike-Off .....	1
7.	50370F	Thread Strike-Off Componenty .....	1
8.	SS7060310SP	Screw, for plate strike-off .....	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.

\*NOTE: 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 stamped with its part number. On some of the smaller parts and on those where construction does not permit, an identification letter is stamped in 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.

## 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

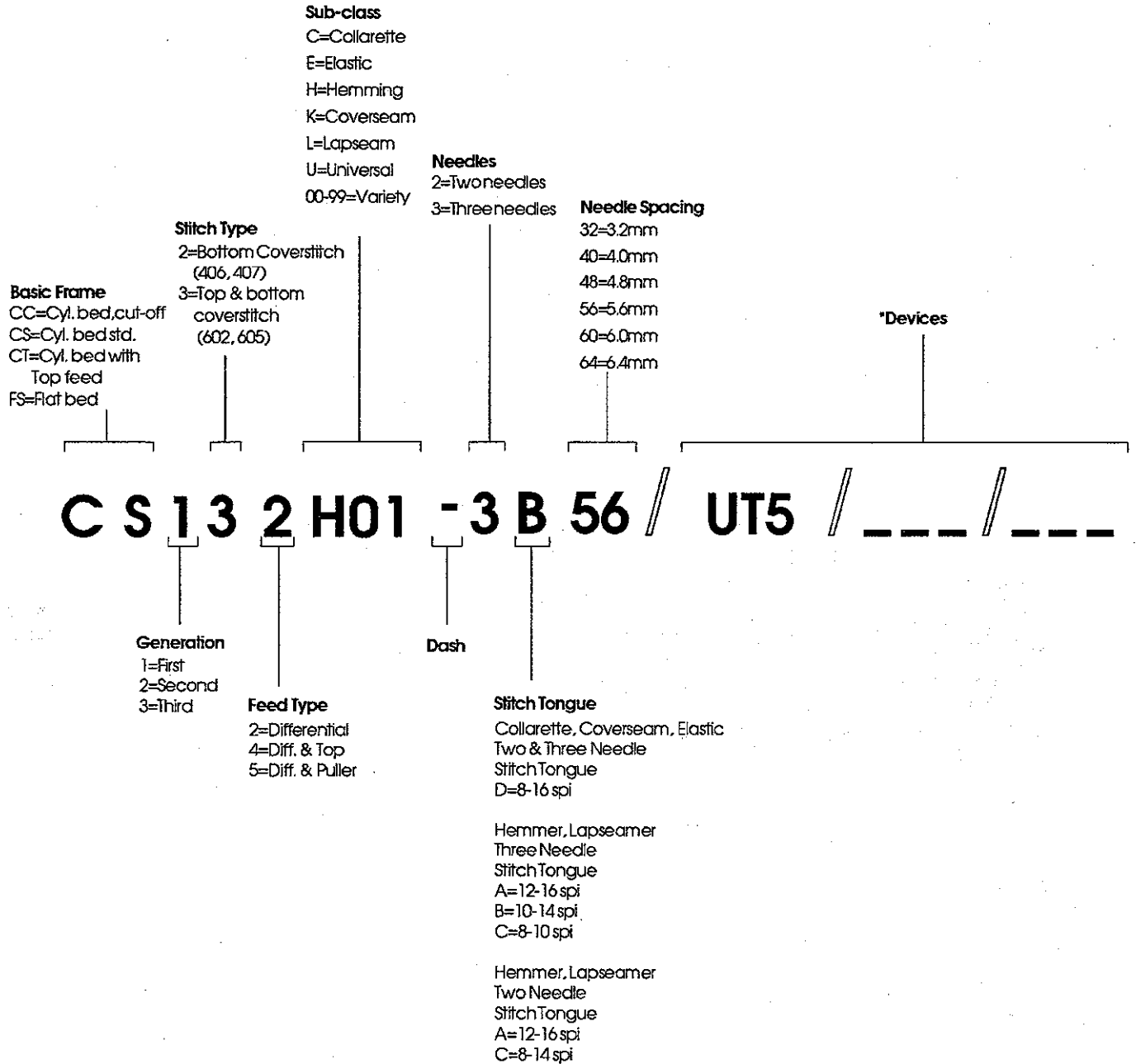
121 GJS Short, double groove, struck groove, ball eye, spotted, ball point, chromium plated- Sizes available 055/022, 065/025, 070/027, 075/029, 080/032, 090/036.

When changing the needle, make sure it is fully inserted in the 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 121 GJS, size 075/029".



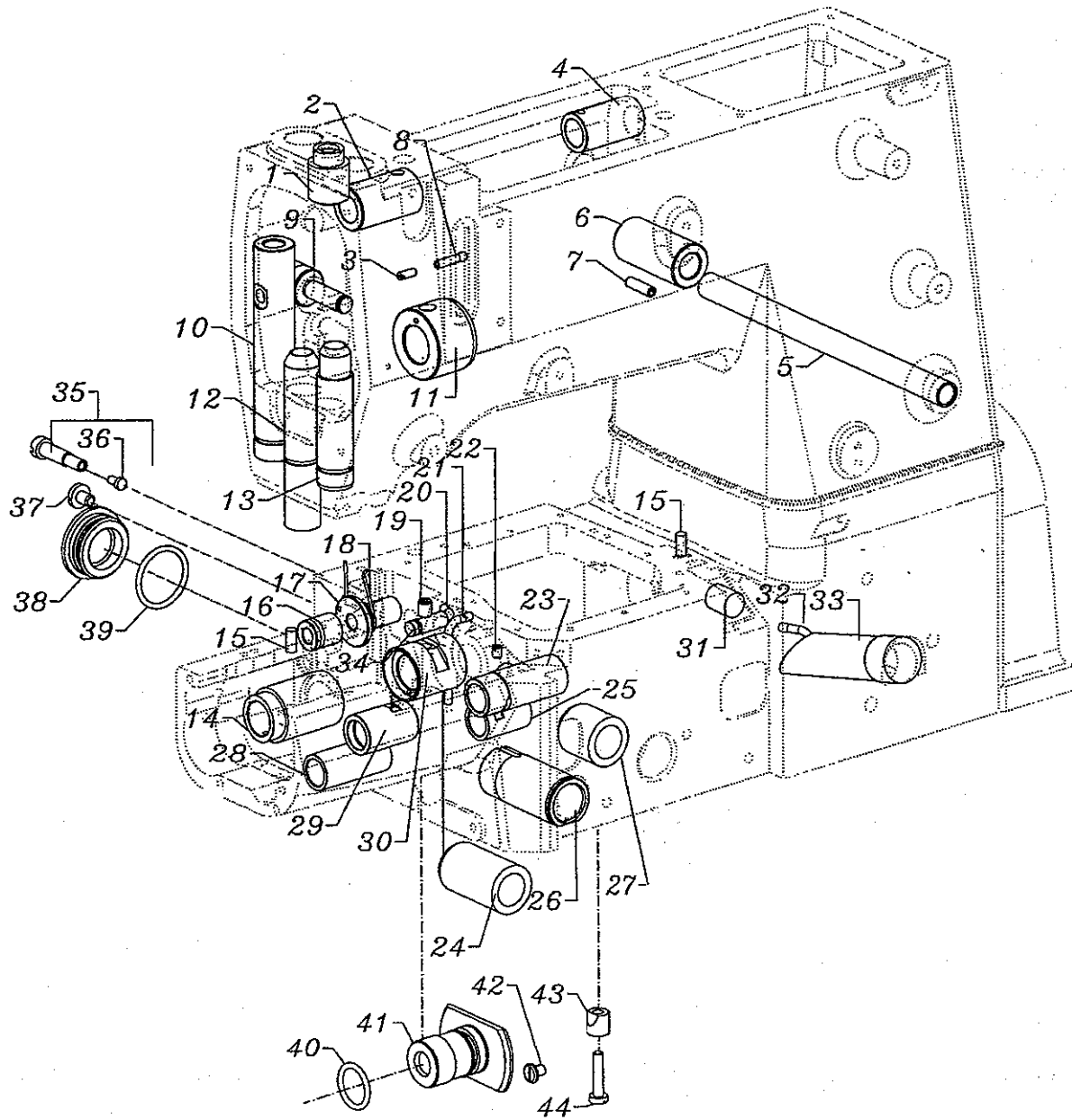
# CS100 SERIES BUILDING BLOCK STYLE DESIGNATION SYSTEM



**UT4 for use on CS122 Styles =** Pneumatic (air), thread trimmer, needle thread wiper (blower) and presser foot lift assist.

**UT5 for use on CS132 Styles =** Pneumatic (air), thread trimmer, top cover thread trimmer and presser foot lift assist.



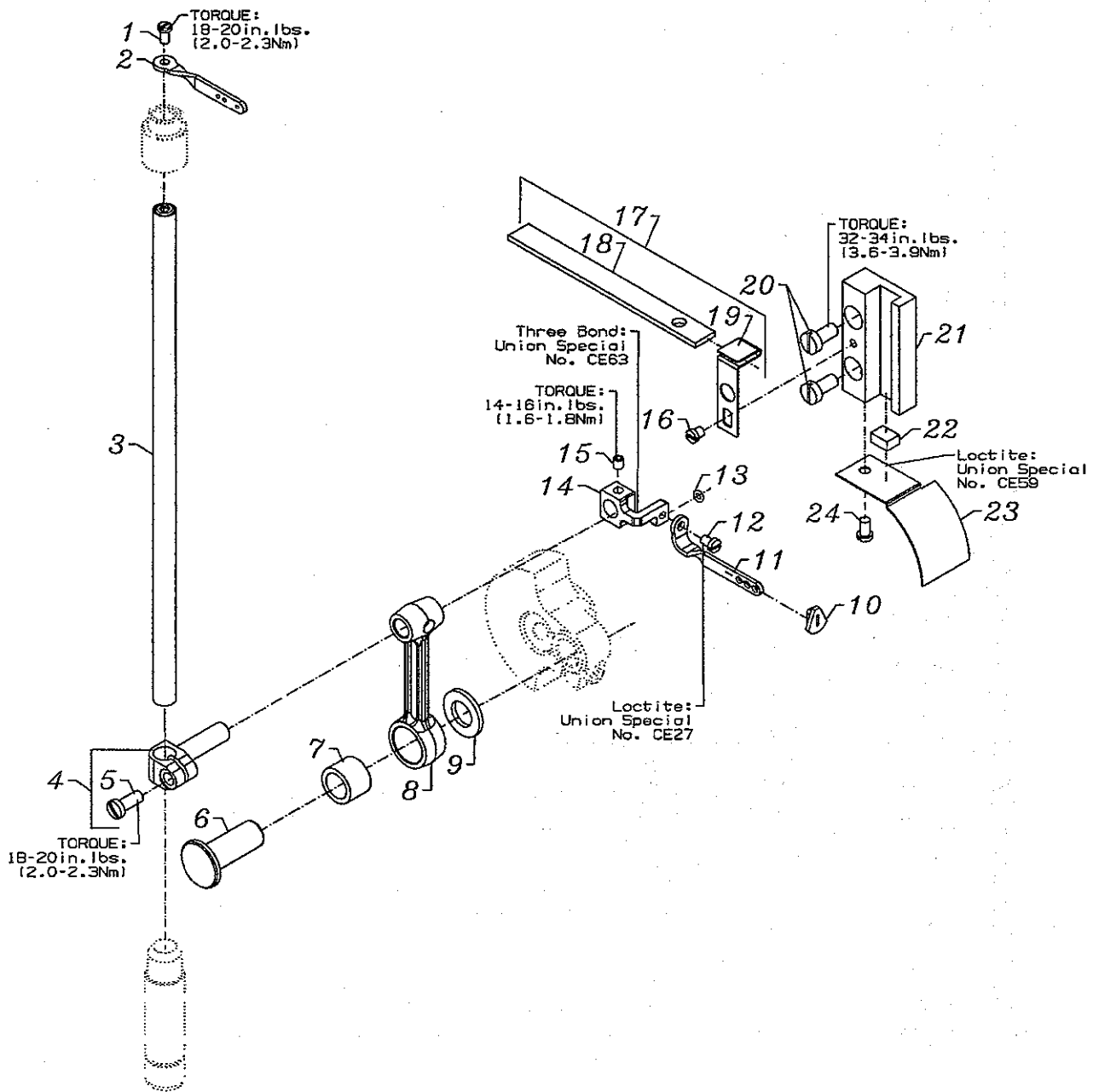




## BUSHINGS

Ref. No.	Part No.	Description	Amt. Req.
1.	50354J	Bushing, for needle bar, upper .....	1
2.	50347F	Bushing, for spreader, front .....	1
3.	SS8090710SP	Screw, for shaft .....	1
4.	50347E	Bushing, for spreader, rear .....	1
5.	50392AB	Bushing, for tension release .....	1
6.	50381E	Bushing, for lifter lever .....	1
7.	PS400142KH	Pin .....	1
8.	50393FL	Tube, front .....	1
9.	50332U	Pin .....	1
10.	50347L	Bushing, for spreader bar .....	1
11.	50393ET	Bushing .....	1
12.	50330CZ	Bushing, for presser bar .....	1
13.	50354H	Bushing, for needle bar, lower .....	1
14.	34390	Bushing, for main shaft, left .....	1
15.	96841	Pin .....	2
16.	50373DC	Bushing, for cast-off plate bracket .....	1
17.	50373DD	Bushing, for cast-off plate bracket .....	1
18.	50395K	Spring, for cast-off plate .....	1
19.	22894AD	Screw .....	1
20.	34394	Oil Tube .....	1
21.	34394A	Oil Tube .....	1
22.	22565C	Set Screw .....	1
23.	34336E	Bushing, for feed lifter shaft, right .....	1
24.	34342F	Bushing, for looper drive shaft, rear .....	1
25.	34336B	Bushing, for feed rocker shaft, right .....	1
26.	34336MB	Bushing .....	1
27.	34342G	Bushing, for looper drive shaft, front .....	1
28.	34336C	Bushing, for feed rocker, left .....	1
29.	34336D	Bushing, for feed lifter shaft, left .....	1
30.	50344AK	Bushing, for main shaft, middle .....	1
31.	22571F	Plug Screw .....	1
32.	34394B	Oil Tube .....	1
33.	50393GF	Oil Sight Gauge .....	1
34.	999-211B	"O" Ring .....	1
35.	99352	Stop Screw .....	1
36.	999-212-035	Stop .....	1
37.	25S	Screw .....	1
38.	34893A	Oil Seal Plug, rear .....	1
39.	661-254	"O" Ring .....	1
40.	999-211	"O" Ring .....	1
41.	34336F	Bushing .....	1
42.	22829	Screw .....	1
43.	34336G	Pressure Sleeve .....	1
44.	22874	Screw .....	1

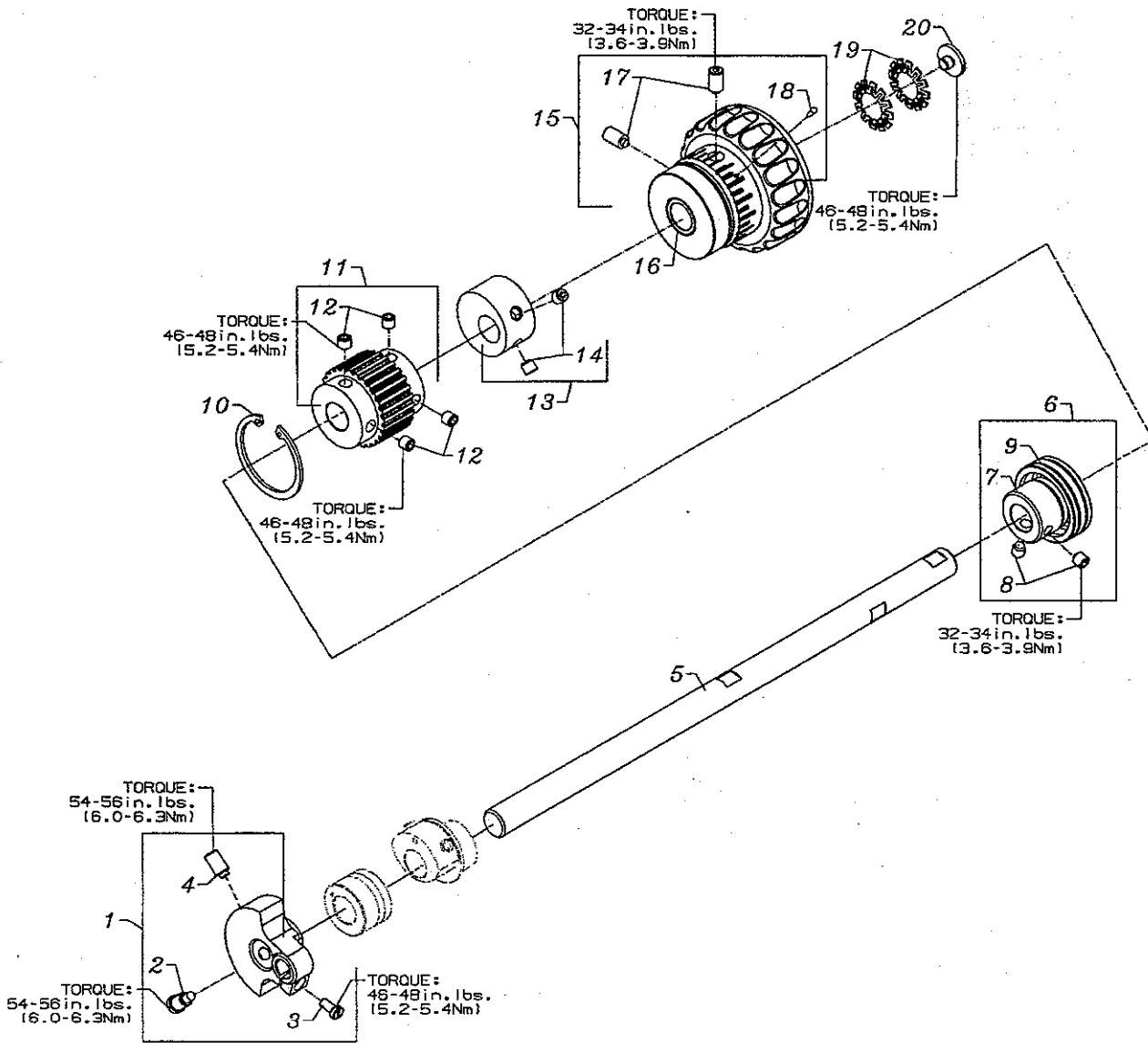




## NEEDLE BAR

Ref. No.	Part No.	Description	Amt. Req.
1.	SS4080620TP	Screw .....	1
2.	50323P	Needle Bar Eyelet .....	1
3.	50317B	Needle Bar .....	1
4.	50355AM	Needle Bar Clamp .....	1
5.	SS7111120TP	Screw .....	1
6.	50352	Pivot Pin .....	1
7.	661-259B	Needle Bearing Cage .....	1
8.	50355AN	Connecting Rod .....	1
9.	50351A	Washer .....	1
10.	50393JP	Eyelet Seal .....	1
11.	50358X	Needle Thread Eyelet .....	1
12.	SS7080520SP	Screw .....	1
-	CE27	Loctite Adhesive, (not shown), for screw .....	-
13.	660-980	"O" Ring .....	1
14.	50354F	Slide Block .....	1
-	CE63	Three Bond Adhesive, (not shown), for slide block .....	-
15.	SS8110422TP	Screw .....	1
16.	SS6090440SP	Screw, for support bracket .....	1
17.	50383M	Support Bracket Assembly .....	1
18.	50393HW	Felt, for slide block access hole .....	1
19.	50383L	Support Bracket .....	1
20.	SS6121010SP	Screw .....	2
21.	50354G	Slide Block Guide .....	1
22.	50393HS	Sponge .....	1
-	CE59	Loctite Adhesive, (not shown), for sponge .....	-
23.	50394AF	Slide Block Guide Cover .....	1
24.	SS6090620SP	Screw .....	1



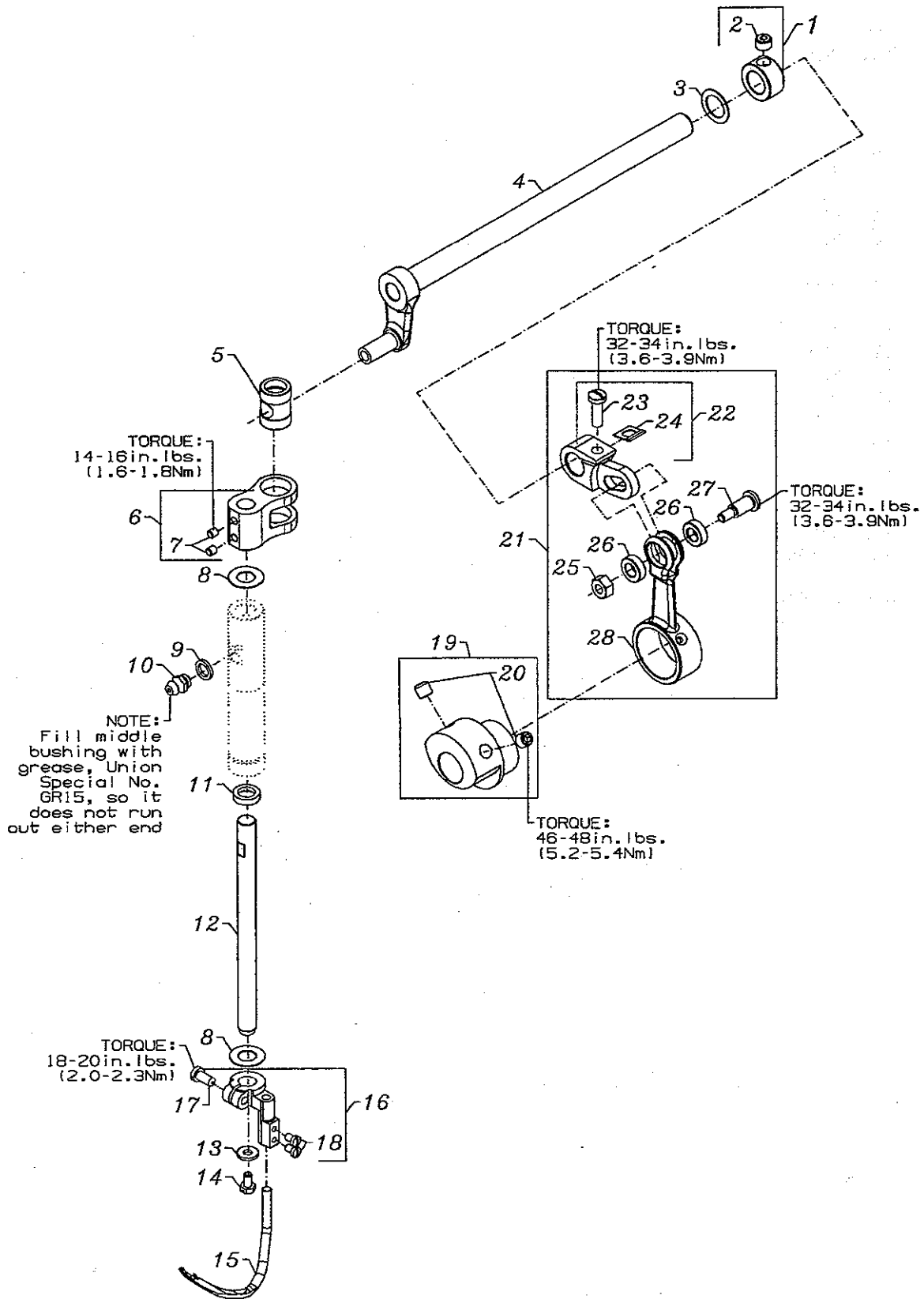


## UPPER MAIN SHAFT

Ref. No.	Part No.	Description	Amt. Req.
1.	50391	Counter Weight .....	1
2.	SS7681410TP	Screw, for counter weight .....	1
3.	SS7111120TP	Screw, for counter weight .....	1
4.	SS8681412TP	Screw, for counter weight .....	1
5.	50322AF	Upper Main Shaft .....	1
6.	50335BD	Bearing Adapter Assembly .....	1
*7.		Bearing Adapter .....	1
8.	SS8660612TP	Screw, for bearing adapter .....	2
*9.		Ball Bearing, for upper main shaft, middle .....	1
10.	661-262	Retaining Ring .....	2
11.	50342AY	Sprocket, for upper main shaft .....	1
12.	SS8661012TP	Set Screw, for sprocket .....	4
13.	50391A	Counterweight .....	1
14.	SS8660612TP	Screw .....	2
15.	50321H	Handwheel .....	1
*16.		Ball Bearing .....	1
17.	SS8681412TP	Set Screw, for handwheel .....	2
18.	660-1043	Tack Pin .....	1
19.	661-261	Load Ring, for lower main shaft .....	2
20.	SS7660520SP	Screw, for handwheel preload .....	1

\*NOTE: Not sold separately.

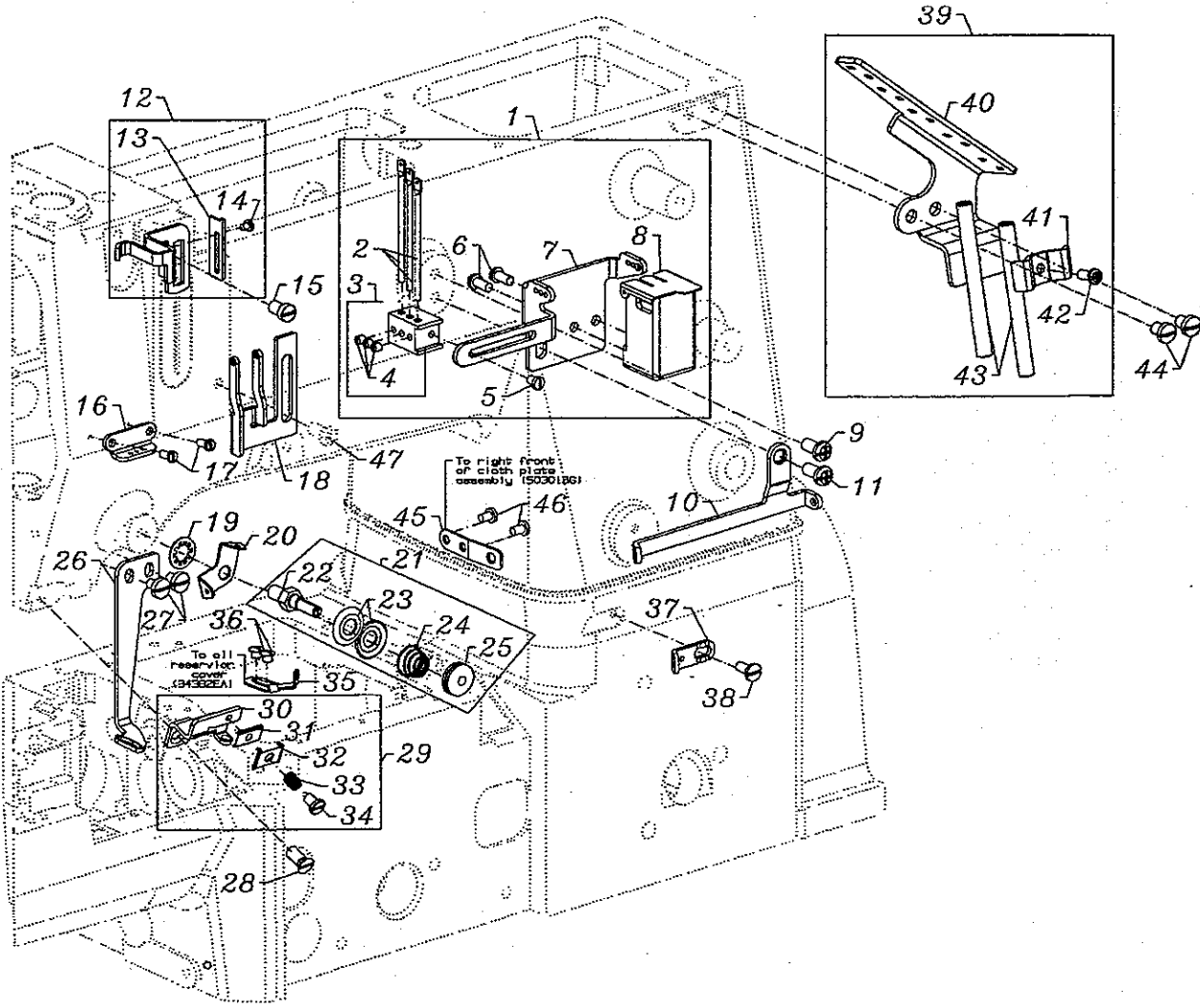




## SPREADER

Ref. No.	Part No.	Description	Amt. Req.
1.	50335AW	Collar, for spreader shaft .....	1
2.	SS8660512TP	Set Screw .....	1
3.	96162B	Washer .....	1
4.	50360B	Crankshaft, for spreader assembly .....	1
5.	50347J	Pin, for spreader rocker .....	1
6.	50347C	Lever, for spreader holder shaft .....	1
7.	SS8110422TP	Screw .....	2
8.	61351C	Washer .....	2
9.	50335AV	Collar .....	1
10.	50362	Grease Nipple .....	1
11.	660-739	Oil Seal .....	1
12.	50347G	Shaft, for spreader, vertical .....	1
13.	53678N	Washer .....	1
14.	SS9090640SP	Hex Screw, for vertical shaft .....	1
15.	50360E	Spreader .....	1
16.	50346A	Spreader Holder .....	1
17.	SS7110910TP	Screw .....	1
18.	SS7080510TP	Screw .....	2
19.	50360	Eccentric, for spreader drive .....	1
20.	SS8660612TP	Screw .....	2
21.	29126FL	Spreader Crank Rod Assembly .....	1
22.	50360C	Spreader Shaft Driving Arm .....	1
23.	SS7121410TP	Screw .....	1
24.	B2531704000	Bind Washer .....	1
25.	NS6110530SP	Nut .....	1
26.	50347K	Collar, for spreader driving arm .....	2
27.	SD0641103TP	Shoulder Screw .....	1
28.	50360D	Connecting Rod, for spreader drive .....	1
-	28604X	Grease Gun, (not shown, extra send charge) .....	1
-	GR15	Tube of Grease, 14oz. (not shown, extra send charge) .....	1



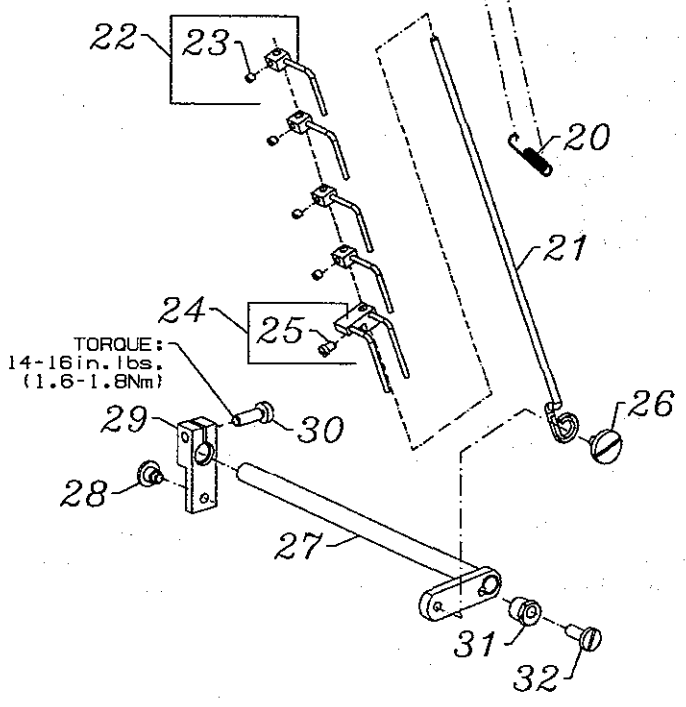
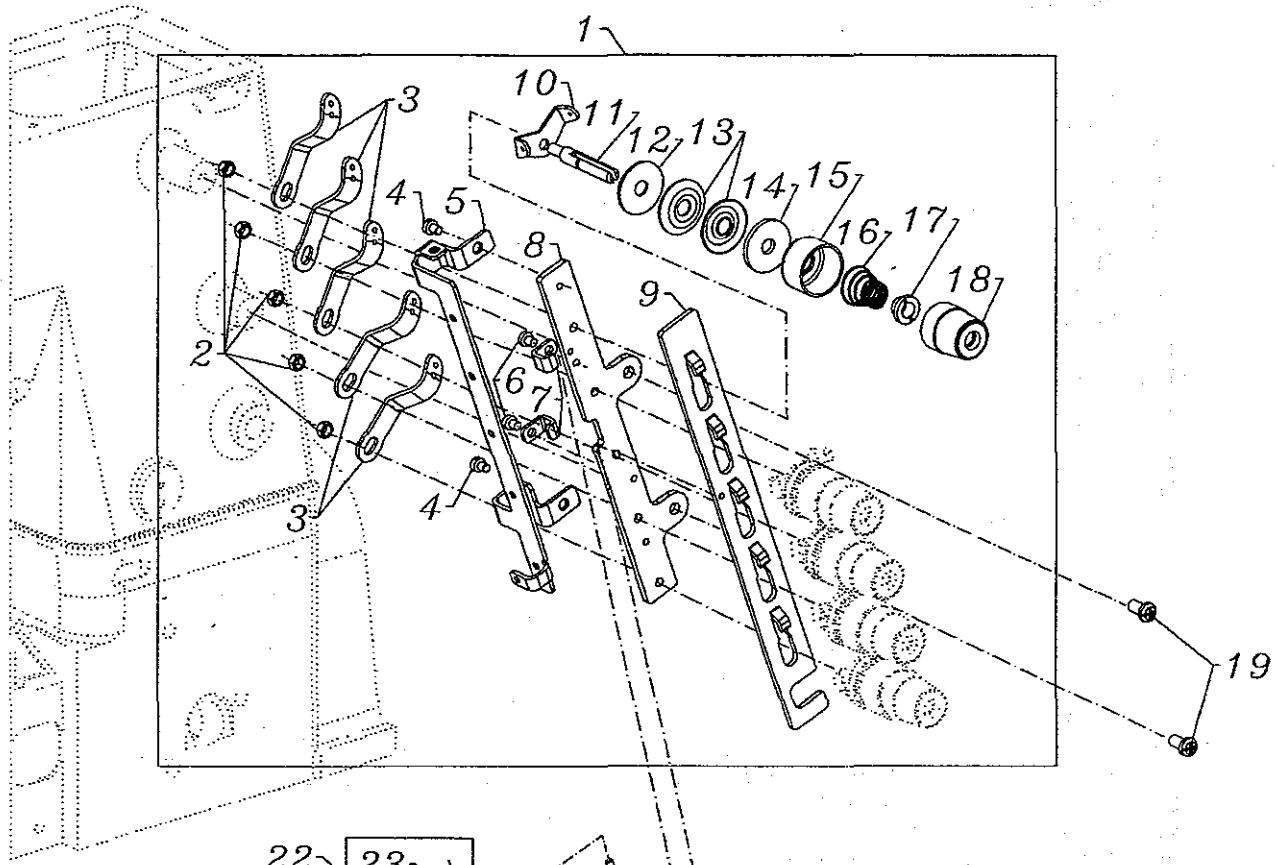




## THREAD GUIDE

Ref. No.	Part No.	Description	Amt. Req.
1.	50363CJ	Thread Lubricator Assembly .....	1
2.	36271A	Adjusting Needle Thread Eyelet .....	3
3.	50358W	Holder, for needle thread eyelet .....	1
4.	SS8080410TP	Screw .....	3
5.	SS7080510TP	Screw, for holder eyelet .....	1
6.	SS4090815SP	Screw, for silicone tank .....	2
7.	50392V	Needle Thread Guide .....	1
8.	50393HH	Silicone Thread Lubricator .....	1
9.	SS4120615SP	Screw, for spreader thread guide .....	1
10.	50358U	Thread Guide, for spreader .....	1
11.	SS4120915SP	Screw, for needle thread guide .....	1
12.	50366B	Needle Thread Strike-Off Assembly .....	1
13.	50370F	Thread Strike-Off Component .....	1
14.	SS7060310SP	Screw, for plate strike-off .....	1
15.	SS7120710SP	Screw, for strike-off .....	1
16.	C50044E	Needle Thread Guide .....	1
17.	605A	Screw, for needle thread guide .....	2
18.	50392T	Eyelet .....	1
19.	652C16	Star Washer .....	1
20.	57844	Eyelet .....	1
21.	29475CG	Spreader Thread Tension Assembly .....	1
22.	50392AW	Tension Post .....	1
23.	50392AX	Tension Disc .....	2
24.	50392AY	Tension Spring .....	1
25.	50392AZ	Tension Nut .....	1
26.	50346	Thread Guide Spreader .....	1
27.	SS7090610SP	Screw, for spreader thread guide .....	2
28.	SS1121010SP	Screw, for thread guide .....	1
29.	50357AD	Nipper Plate Assembly .....	1
30.	50392BA	Thread Guide .....	1
31.	50357V	Nipper Plate .....	1
32.	50357Y	Nipper Spring Plate .....	1
33.	B1135850000	Nipper Spring .....	1
34.	SD0380551SL	Shoulder Screw .....	1
35.	50392AG	Looper Thread Guide .....	1
36.	18C1471	Screw .....	2
37.	12124202	Looper Frame Eyelet .....	1
38.	98A	Screw .....	1
39.	50392AU	Thread Eyelet Assembly .....	1
40.	50392S	Lead-in Tension Eyelet .....	1
41.	50366A	Thread Eyelet Tube Bracket .....	1
42.	SS4090815SP	Screw, for tube bracket .....	1
43.	50366	Thread Eyelet Tube .....	2
44.	SS7120640SP	Screw, for lead-in eyelet .....	2
45.	34358F	Looper Thread Guide .....	1
46.	87U	Screw .....	2
47.	SS4120915SP	Screw, for thread take-up cover (see page 23) .....	1

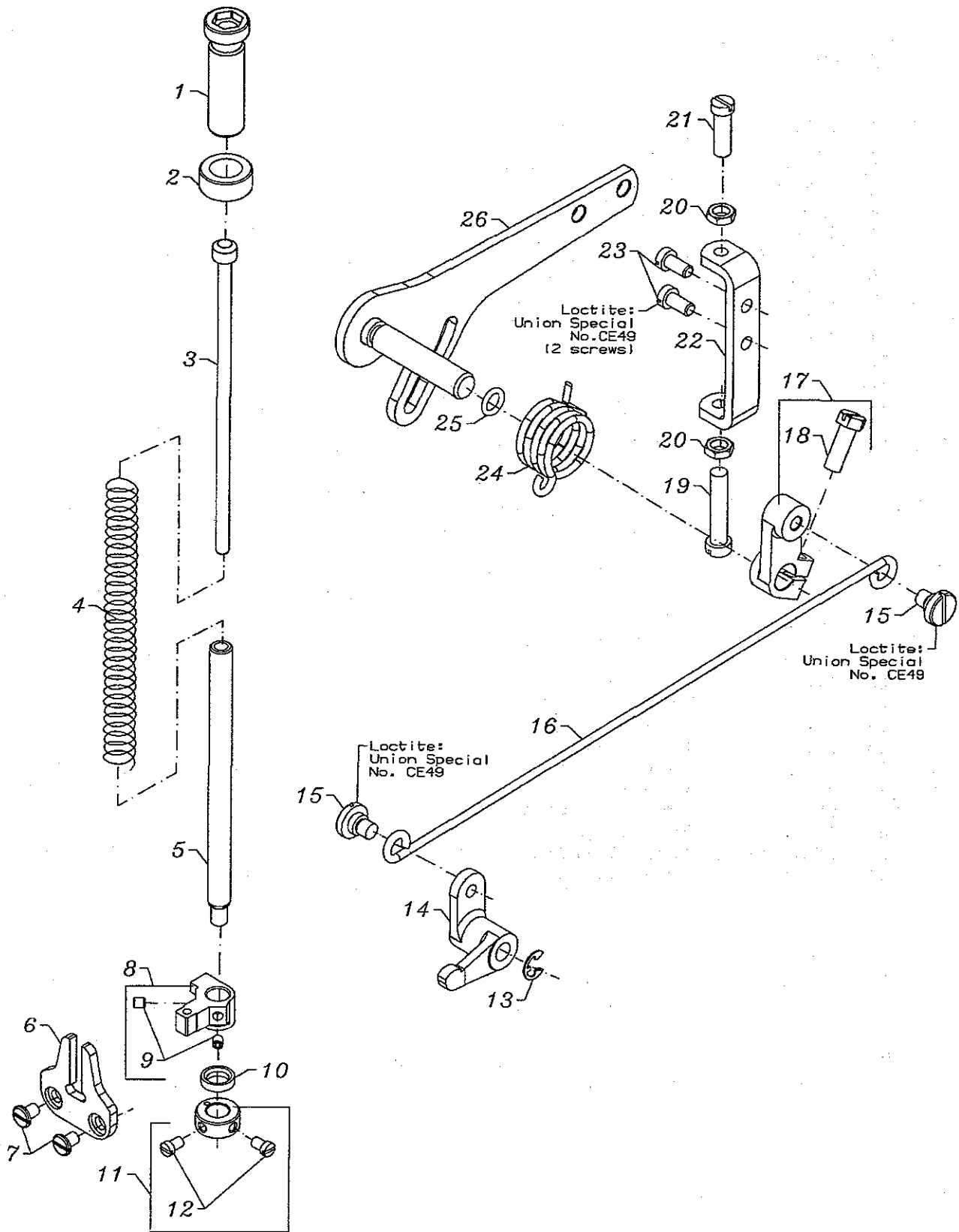




## THREAD TENSION

Ref. No.	Part No.	Description	Amt. Req.
1.	29477NL	5 Thread Tension Assembly .....	1
2.	NS6110420SP	Nut .....	5
3.	57865	Lead-in Thread Guide .....	5
4.	SS7090520SP	Screw .....	2
5.	50392AP	Thread Guide .....	1
6.	SS7090520SP	Screw .....	2
7.	50392AV	Guide, for tension disc separator .....	2
8.	50392X	Tension Bracket .....	1
9.	50392AR	Tension Disc Separator .....	1
10.	57892K	Thread Tension Eyelet .....	5
11.	56392G	Tension Post .....	5
12.	B3120352000	Tension Disc Felt .....	5
13.	B3126012000	Tension Disc .....	10
14.	B3120704000	Tension Disc Felt .....	5
15.	56392H	Spring Shield .....	5
16.	B3103804000	Spring, for spreader (blue) .....	1
-	B3101804000	Spring, for needle (red) .....	3
-	B3021804010	Spring, for looper (plain) .....	1
17.	B3112704000	Ferrule, for tension spring .....	5
18.	56392M	Knob, for spreader (blue) .....	1
-	56392L	Knob, for needle (red) .....	3
-	56392S	Knob, for looper (plain) .....	1
19.	SS4120615SP	Screw .....	2
20.	96711	Spring .....	1
21.	50392AS	Rod, for thread puller .....	1
22.	G51358KE	Thread Pull-off Hook .....	4
23.	28C	Screw .....	4
24.	A9858	Thread Pull-off Hook .....	1
25.	77A	Screw .....	1
26.	99296	Shoulder Screw .....	1
27.	50392AN	Tension Release Assembly .....	1
28.	22735	Shoulder Screw .....	1
29.	99620	Tension Release Lever .....	1
30.	22596	Screw .....	1
31.	G51346KA	Tension Release Eccentric .....	1
32.	22757	Screw .....	1

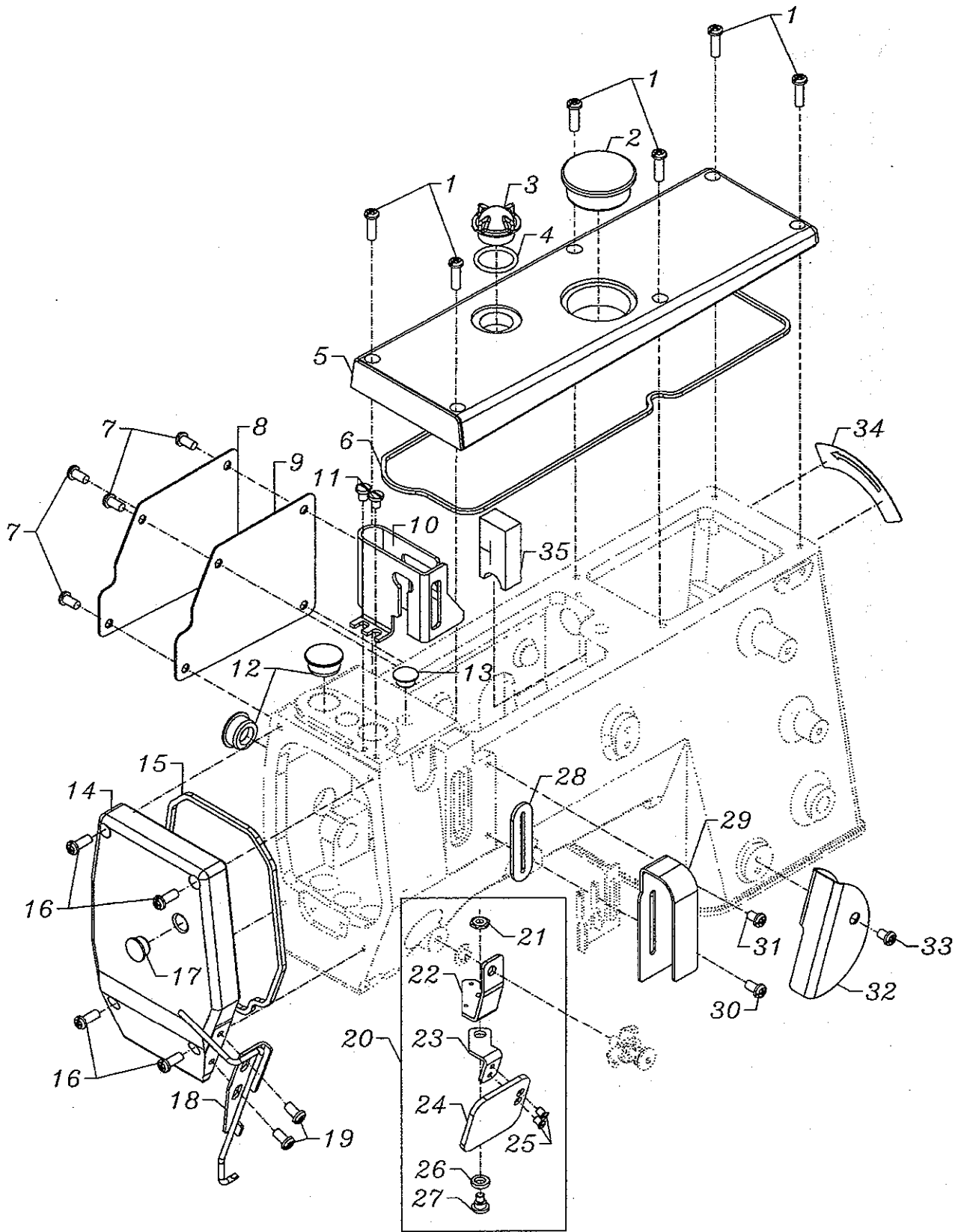




## PRESSER FOOT LIFT

Ref. No.	Part No.	Description	Amt. Req.
1.	11071602	Adjusting Screw, for spring .....	1
2.	11071701	Locking Nut .....	1
3.	C50056B	Spring Rod .....	1
4.	50357AA	Spring, for presser bar .....	1
5.	50335AF	Presser Bar .....	1
6.	50335AG	Guide Plate, for presser bar .....	1
7.	SS6110610TP	Screw, for guide plate .....	2
8.	50335AH	Presser Bar Guide .....	1
9.	SS8110422TP	Set Screw .....	2
10.	660-739	Oil Seal .....	1
11.	52888B	Collar .....	1
12.	22562	Screw .....	2
13.	RE0500000KO	Retaining Ring, for pin .....	1
14.	50381F	Lifter Lever, front .....	1
15.	SD0790303SP	Screw, for wire connector .....	2
-	CE49	Loctite Adhesive, (not shown), for screw .....	-
16.	50355AR	Wire Connector .....	1
17.	50381G	Lifter Lever, rear .....	1
18.	SS9151740CP	Hex Screw .....	1
19.	SS6153040SP	Screw, for adjusting stopper .....	1
20.	NS6150310SP	Hex Nut .....	2
21.	SS6151920SP	Screw, for adjusting stopper .....	1
22.	50332V	Positioning Bracket, for lifter lever .....	1
23.	SS6121010SP	Screw, for positioning bracket .....	2
-	CE49	Loctite Adhesive, (not shown), for screw .....	-
24.	50381	Spring, for lifter lever .....	1
25.	RO068190100	"O" Ring .....	1
26.	50381B	Lifter Lever Assembly .....	1

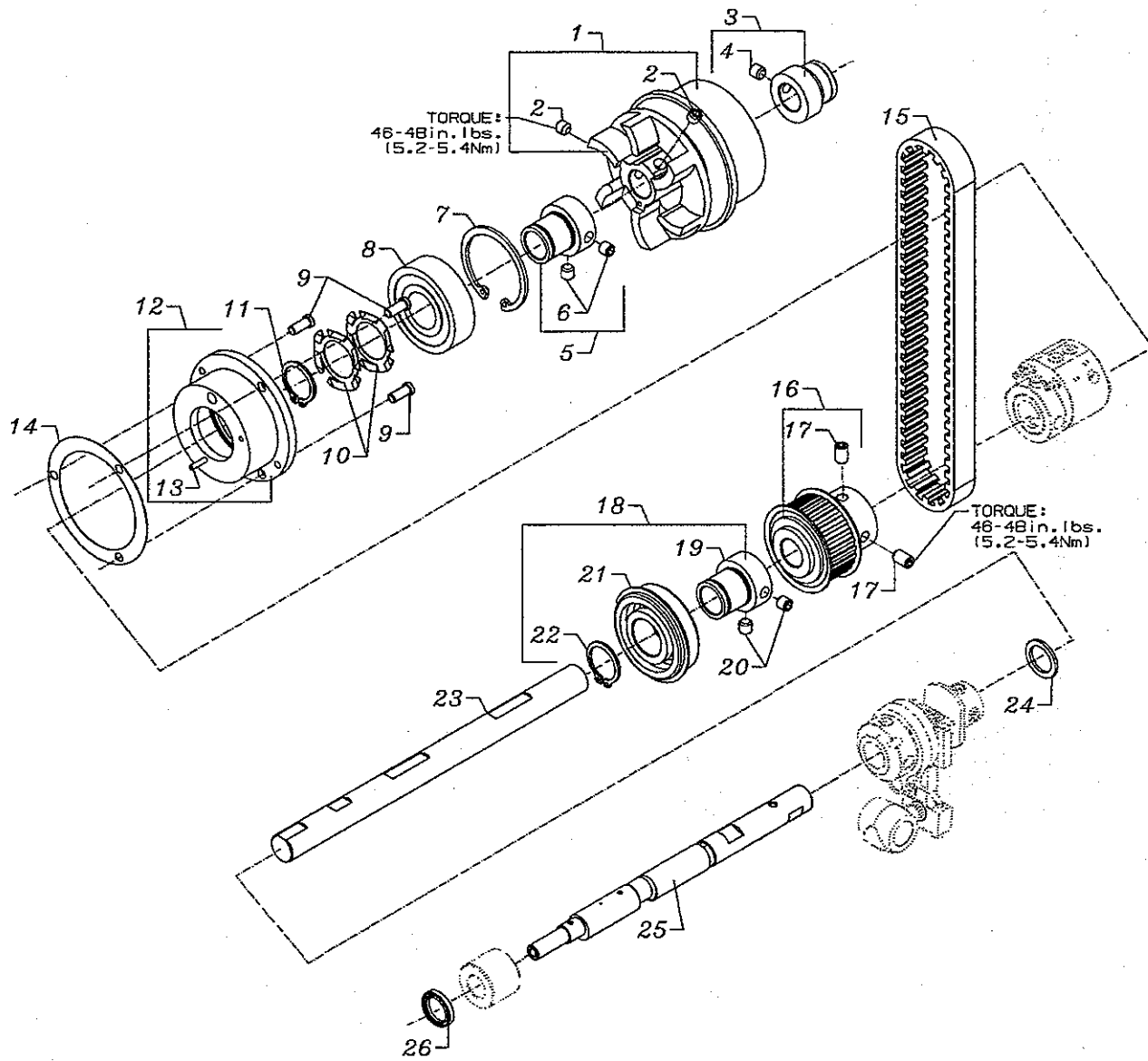




## COVERS UPPER ARM

Ref. No.	Part No.	Description	Amt. Req.
1.	SS4121615SP	Screw, for top cover .....	6
2.	50393EU	Plug, top .....	1
3.	B3530555000	Oil Sight Gauge, top .....	1
4.	RO195240100	"O" Ring, for oil sight gauge .....	1
5.	50382FW	Top Cover .....	1
6.	50382FZ	Quad Ring, for top cover .....	1
7.	SS4120915SP	Screw, for puller drive cover .....	4
8.	50382GB	Puller Drive Cover .....	1
9.	50382GC	Gasket, for puller drive cover .....	1
10.	50317C	Needle Bar Guard .....	1
11.	SS7120640SP	Screw, for needle bar guard .....	2
12.	50393HB	Plug .....	2
13.	TA1050504R0	Plug, for arm .....	1
14.	50382FX	Head Cover .....	1
15.	50382FY	Quad Ring, for head cover .....	1
16.	SS4121215SP	Screw, for head cover .....	4
17.	TA1100604R0	Plug .....	1
18.	50394AJ	Thread Blower Assembly, for Style CS122H01-3B_/_/UT4 .....	1
19.	SS4120615SP	Screw, for Style CS122H01-3B_/_/UT4 .....	2
20.	99682XCA	Sewing Guard Assembly .....	1
21.	14077	Nut .....	1
22.	99682XC1	Bracket .....	1
23.	99682XC2	Bracket .....	1
24.	99682XC	Sewing Guard .....	1
25.	22766	Counter Sunk Head Screw .....	2
26.	95978	Spring Washer .....	1
27.	22758E	Shoulder Screw .....	1
28.	50393EW	Rubber Gasket, for needle lever .....	1
29.	50382GA	Cover, for thread take-up .....	1
30.	SS4120915SP	Screw, for thread take-up cover .....	1
31.	SS4120615SP	Screw, for thread cover .....	1
32.	50382GM	Thread Cover .....	1
33.	SS4120615SP	Screw, for thread cover .....	1
34.	LA451	Label Direction of Rotation .....	1
35.	50393JV	Sponge, for oil protector .....	1





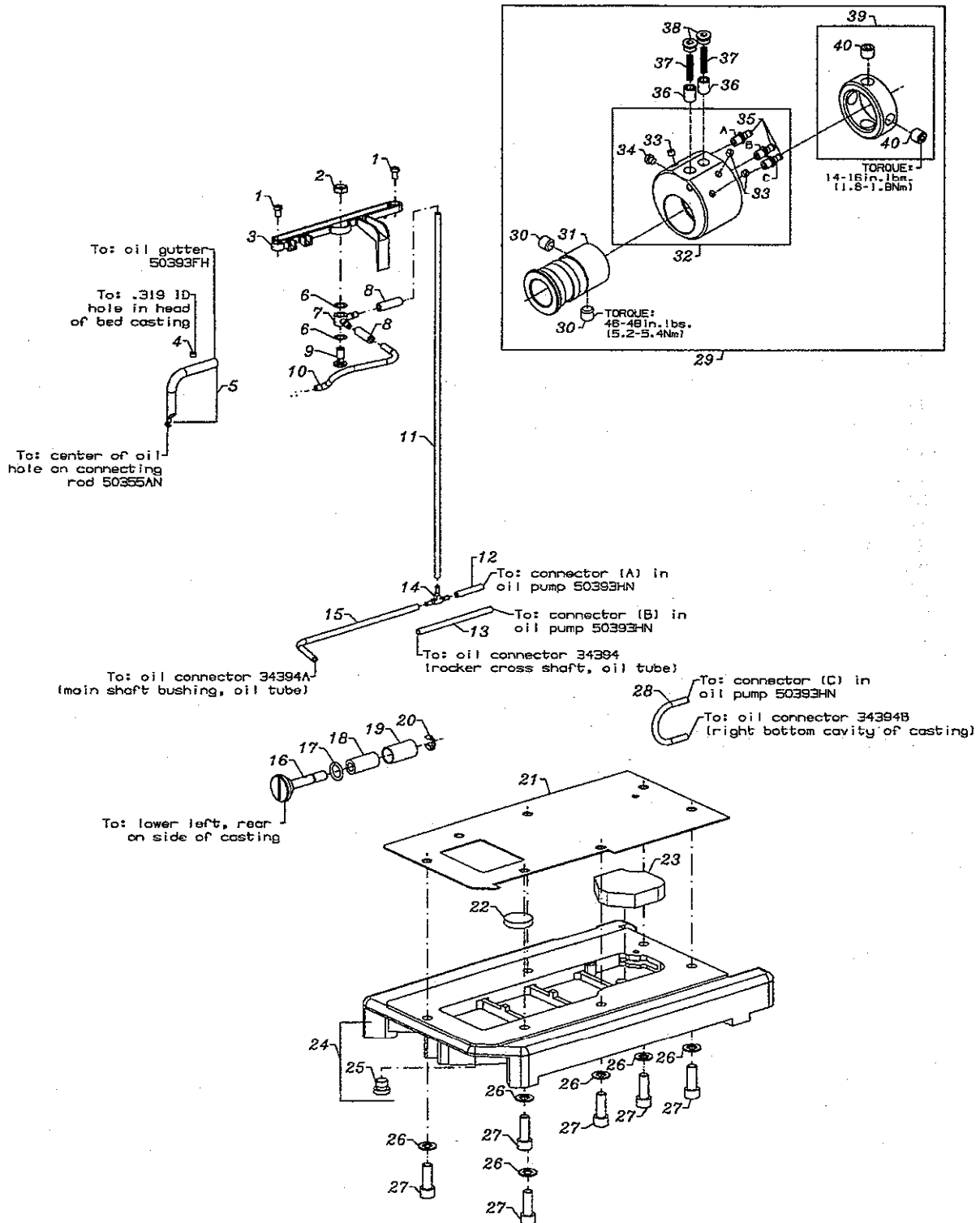


## LOWER MAIN SHAFT

Ref. No.	Part No.	Description	Amf. Req.
1.	34321CB	Pulley .....	1
2.	22651AA4	Set Screw .....	2
3.	34321CC	Flange, synchronizer.....	1
4.	95205	Screw .....	1
5.	50335AP	Adapter .....	1
6.	SS8660612TP	Screw, for adapter .....	2
7.	661-348	Retainer Ring .....	1
8.	50311C	Ball Bearing, for lower main shaft, right .....	1
9.	22569B	Screw, for housing .....	3
10.	661-261	Load Ring .....	2
11.	50322AN	Retainer, for sprocket .....	1
12.	50390L	Rear Bearing Housing .....	1
13.	99658	Housing Pin .....	1
14.	56390E	Housing Gasket .....	1
15.	50342BD	Timing Belt .....	1
16.	50342BH	Sprocket, for lower main shaft .....	1
17.	SS8660612TP	Set Screw .....	2
18.	50335BC	Bearing Adapter Assembly .....	1
*19.		Adapter .....	1
*20.		Screw .....	2
21.	50390P	Ball Bearing, for lower main shaft, middle .....	1
*22.		Retainer, for sprocket .....	1
23.	50322AH	Lower Main Shaft, right .....	1
24.	96162A	Washer .....	1
25.	34722A	Mainshaft, left .....	1
-	22560A	Screw (not shown).....	1
-	G50-928	Plug (not shown).....	1
-	34393V3480	Pin (not shown).....	2
26.	50393EZ	Oil Shield, for shielding take-up .....	1

\*NOTE: Not sold separately.



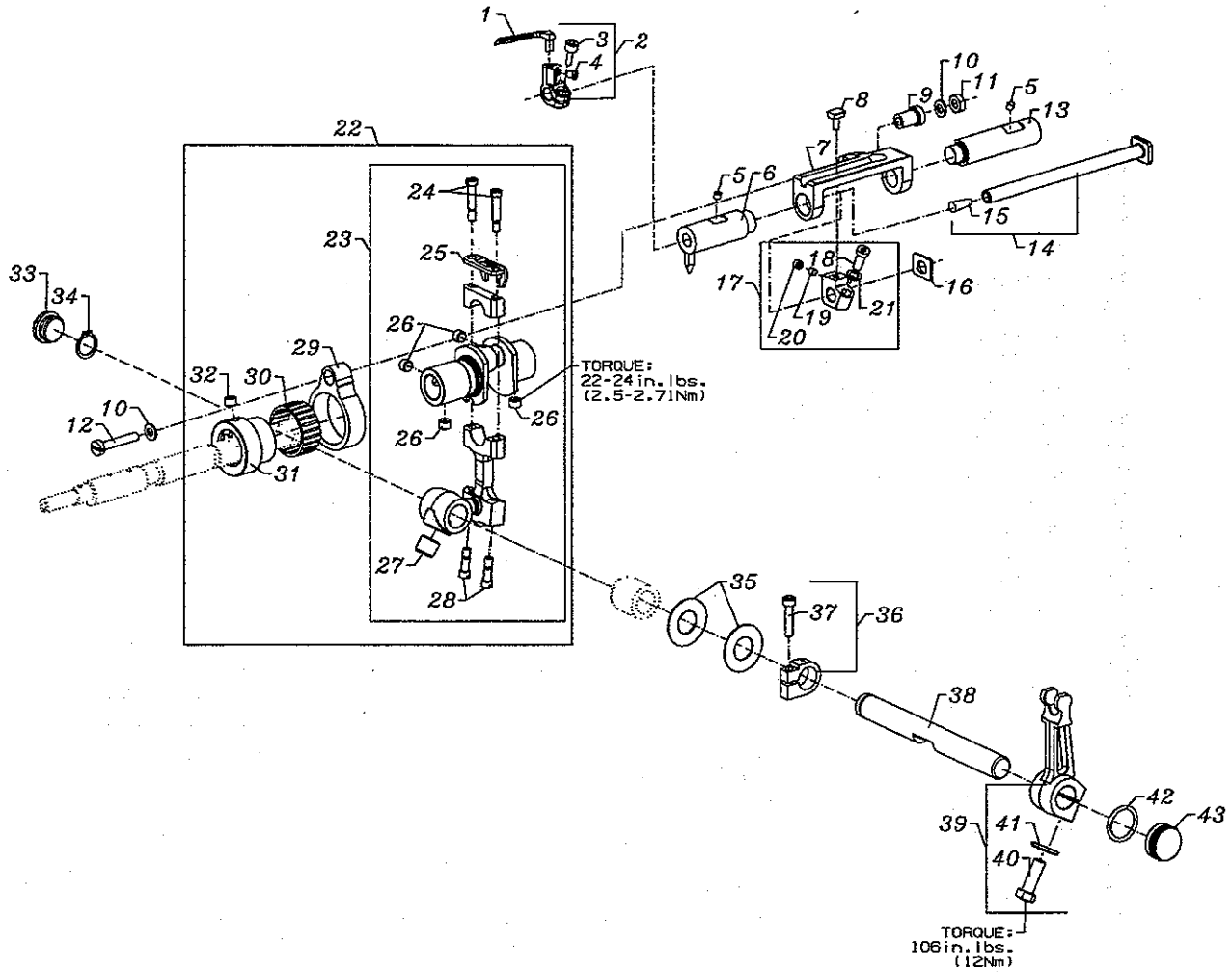


## LUBRICATION OIL TUBING & OIL PUMP

Ref. No.	Part No.	Description	Amt. Req.
1.	SS7120710SP	Screw .....	2
2.	258A	Nut .....	1
3.	50393FH	Oil Supply Trough .....	1
4.	SS8120410SP	Set Screw .....	1
5.	29476SB	Oil Tubing Assembly .....	1
6.	41350X	Washer .....	2
7.	C50094B	Connector Double Feed .....	1
8.	50393GT	Oil Tube Cover .....	2
9.	50393HE	Plug Screw .....	1
10.	50393FK	Tube .....	1
11.	50393FF	Oil Tube .....	1
12.	50393FD	Oil Tube .....	1
13.	50393FE	Oil Tube .....	1
14.	50393GU	"T" Connector .....	1
15.	50393FG	Oil Tube .....	1
16.	99349	Stud .....	1
17.	999-211G	"O" Ring .....	1
18.	34393M	Oil Screen Felt .....	1
19.	34393L	Oil Screen .....	1
20.	96276	Retaining Ring .....	1
21.	34682C	Gasket .....	1
22.	90710A	Magnet .....	1
23.	999-254J	Oil Filter .....	1
24.	50382GS	Base Plate .....	1
25.	999-196	Plug Screw .....	1
26.	95953	Washer .....	6
27.	95406	Screw .....	6
28.	50393HV	Oil Tube .....	1
29.	50393HN	Oil Pump Assembly, 2 stage (see page 24 for location) .....	1
30.	SS8660612TP	Screw .....	2
*31.		Oil Pump Bushing .....	1
*32.		Oil Pump Housing .....	1
*33.		Screw .....	3
*34.		Screw .....	1
*35.		Oil Connector .....	3
36.	34393D	Plunger .....	2
37.	50332S	Spring .....	2
38.	18-1470	Screw .....	2
*39.		Collar .....	1
40.	SS860612TP	Screw .....	2

\*NOTE: Not sold separately.



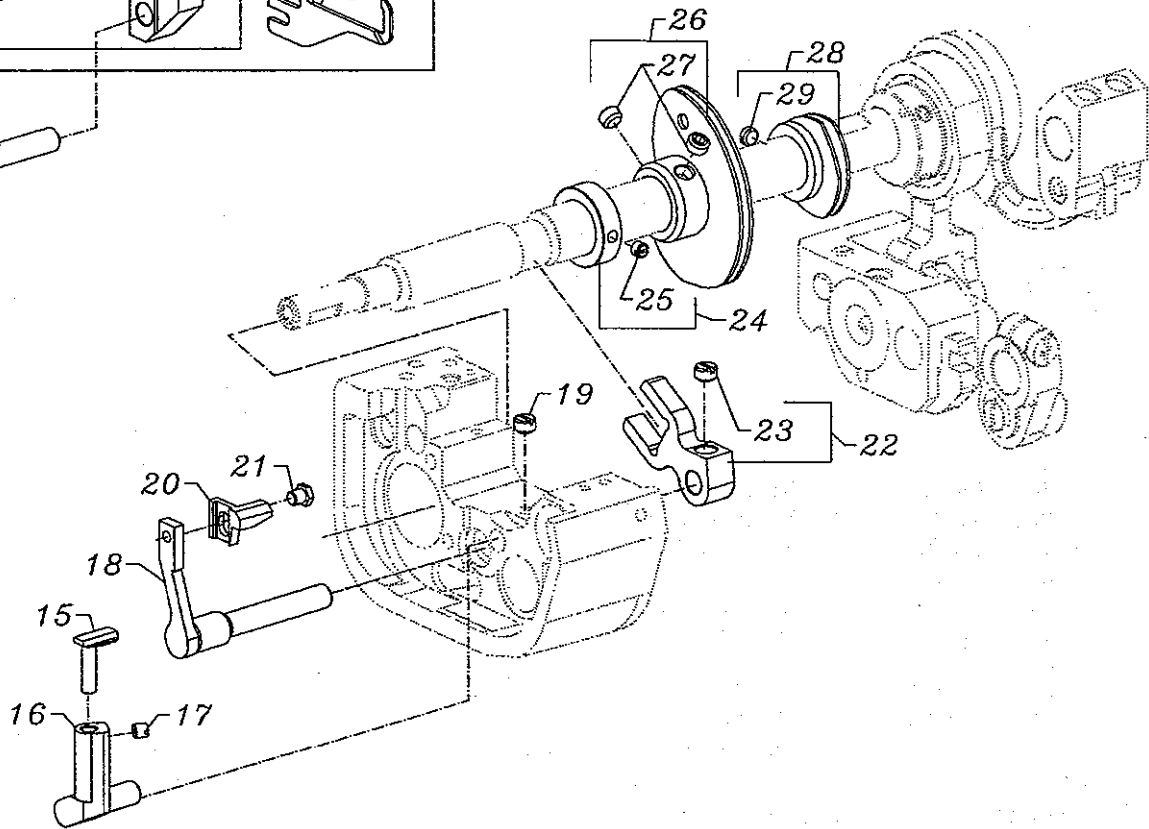
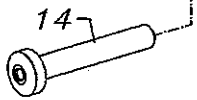
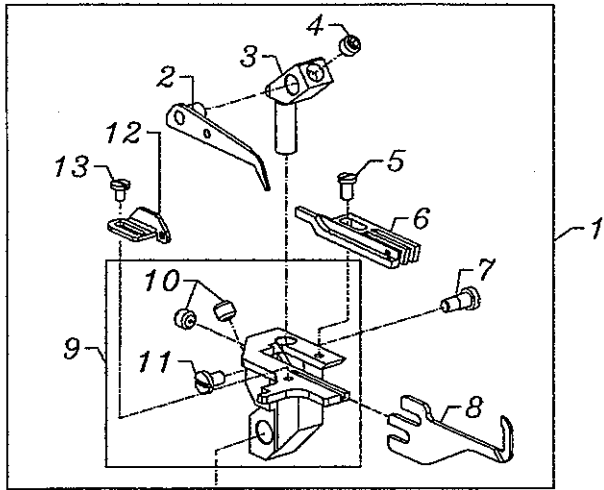


## LOOPER DRIVE

Ref. No.	Part No.	Description	Amt. Req.
1.	34709D	Looper .....	1
2.	50348	Holder, for looper .....	1
3.	SS6091022TP	Screw .....	1
4.	SS6090560TP	Screw .....	1
5.	22894C	Screw .....	2
6.	50344AF	Bushing, for looper shaft .....	1
7.	34344A	Cam Guide .....	1
8.	34344E	Cam Follower .....	1
9.	50344AG	Bushing .....	1
10.	99652A	Washer .....	2
11.	9937	Nut .....	1
12.	99343	Screw .....	1
13.	50343RC	Bushing, for looper bar, right .....	1
14.	50343B	Shaft, for looper .....	1
15.	CO67D	Cork .....	1
16.	34343C	Washer .....	1
17.	34344D	Cam Guide Holder .....	1
18.	22541B	Screw .....	1
19.	39543E	Locking Clamp .....	1
20.	88B	Screw .....	1
21.	51235G	Washer .....	1
22.	VG29105F	Looper Eccentric Assembly .....	1
23.	G29105F	Drive Lever Crank .....	1
24.	G22582	Screw .....	2
25.	34343B	Fork .....	1
26.	22894X	Screw .....	4
27.	99346	Set Screw .....	1
28.	G22559A	Screw .....	2
*29.		Looper Avoid Link .....	1
30.	999-213B	Bearing .....	1
*31.		Looper Avoid Eccentric .....	1
*32.		Screw .....	1
33.	22733C	Oil Seal Plug .....	1
34.	661-252	Retaining Ring .....	1
35.	56390H	Thrust Washer .....	2
36.	34342J	Binder Collar .....	1
37.	22652A12	Screw .....	1
38.	34342H	Looper Rocker Shaft .....	1
39.	34642A	Looper Rocker Lever .....	1
40.	22811B	Screw .....	1
41.	HA20B	Washer .....	1
42.	661-253	"O" Ring .....	1
43.	34893	Oil Seal Plug, front .....	1

\*NOTE: Not sold separately.

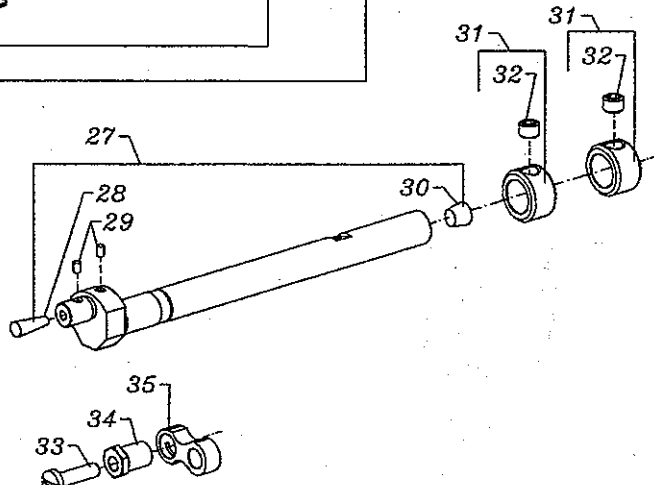
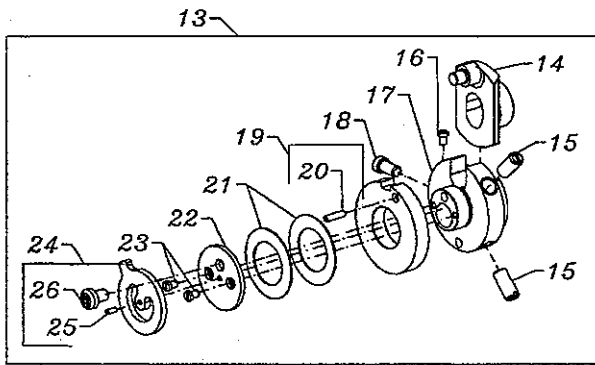
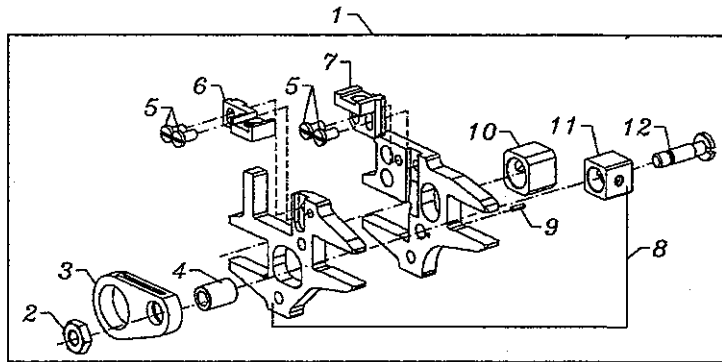




**LOOPER THREAD TAKE -UP & NEEDLE GUARD**

Ref. No.	Part No.	Description	Amt. Req.
1.	GB29389Q	Cast-Off Plate Assembly .....	1
2.	34304	Retaining Finger .....	1
3.	34304B	Support, for retaining finger .....	1
4.	22894W	Screw .....	1
5.	605C	Screw .....	1
6.	34304F	Thread Control Finger .....	1
7.	J86JR	Screw .....	1
8.	34304C	Cast-Off Finger .....	1
9.	34357A	Cast-Off Plate .....	1
10.	22894W	Screw .....	2
11.	87U	Screw .....	1
12.	34358BA	Thread Guide .....	1
13.	73A	Screw .....	1
14.	50368U	Shaft, for cast-off .....	1
15.	50325Z	Needle Guard, front .....	1
16.	50325AB	Holder, for needle guard, front .....	1
17.	SS8090540SP	Screw .....	1
18.	50325AA	Holder, for needle guard, rear .....	1
19.	22580	Screw .....	1
20.	50325AC	Needle Guard, rear .....	1
21.	SS9090410TP	Screw .....	1
22.	34368	Fork .....	1
23.	22894AD	Screw .....	1
24.	34366	Collar .....	1
25.	22743	Screw .....	1
26.	34323	Take Up .....	1
27.	22894T	Screw .....	2
28.	34323C	Cam, looper .....	1
29.	22560	Screw .....	1





TORQUE:  
20-22 in. lbs.  
(2.3-2.5 Nm)



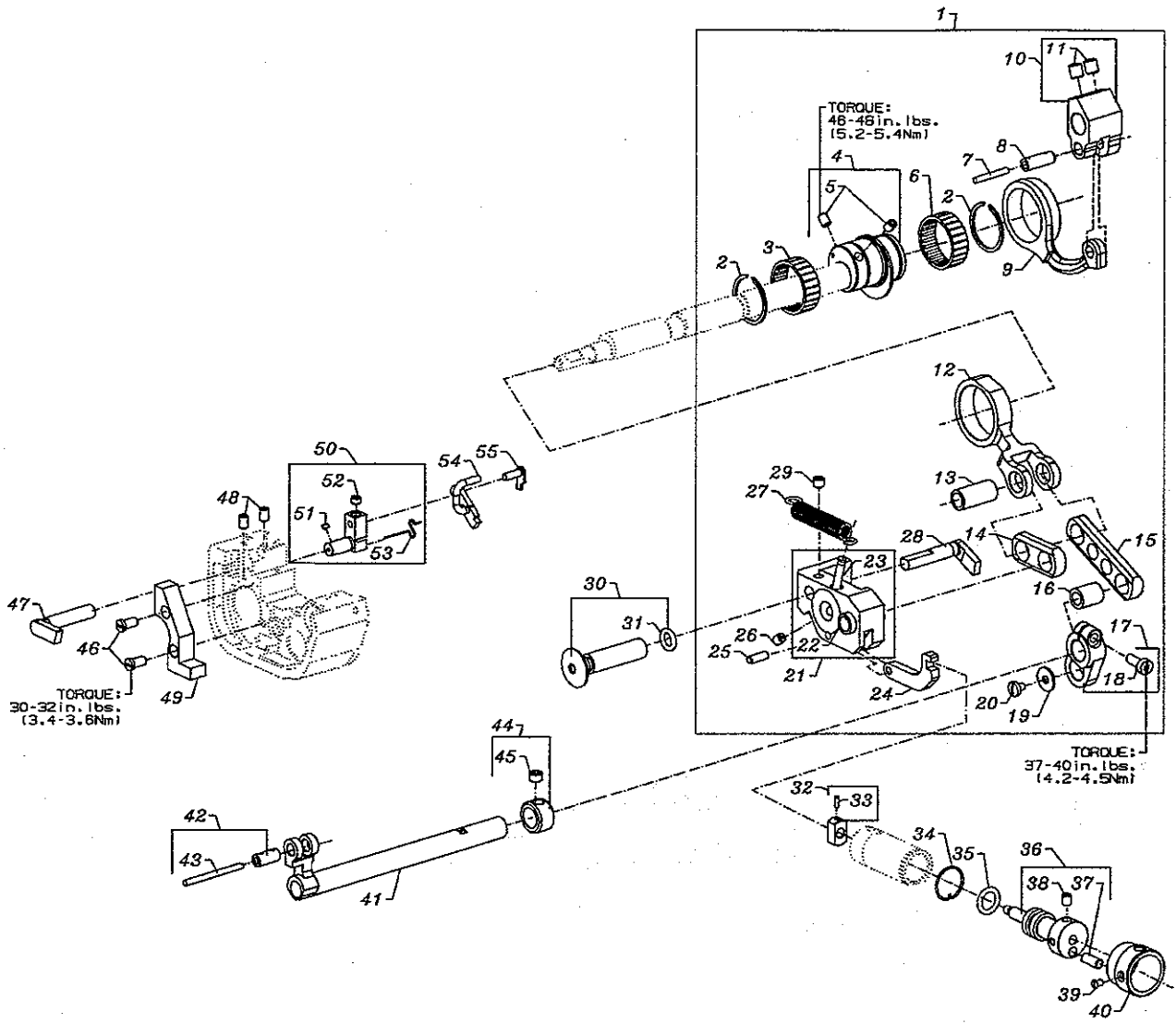


## FEED DRIVE MECHANISM

Ref. No.	Part No.	Description	Amt. Req.
1.	G29476BV	Feed Bar Assembly .....	1
2.	9937	Nut .....	1
3.	34336N	Drive Connection .....	1
4.	39536C	Bushing .....	1
5.	22768B	Screw .....	4
6.	34353A	Differential Feed Dog Holder .....	1
7.	34353	Main Feed Dog Holder .....	1
8.	34334S	Feed Bar Assembly .....	1
9.	96659	Pin .....	1
*10.		Sliding Block .....	1
*11.		Feed Lift Slide Block .....	1
12.	34336U	Stud .....	1
13.	GA29477AP	Eccentric Assembly .....	1
14.	34340A	Eccentric .....	1
15.	22503F	Screw .....	2
16.	22738B	Screw .....	1
17.	34336Q	Guide, for eccentric .....	1
18.	22562A	Screw .....	1
19.	34336V	Cam Disc .....	1
20.	96667	Roll Pin .....	1
21.	97137	Disc Spring .....	2
22.	34336RA	Washer .....	1
23.	22738B	Screw .....	2
24.	34336S	Spacing Stop .....	1
25.	96663	Roll Pin .....	1
26.	90	Screw .....	1
27.	34334E	Feed Lift Shaft .....	1
28.	CO67E	Cork .....	1
29.	30-167BLK	Plug .....	2
30.	CO67B	Cork .....	1
31.	34335J	Collar .....	2
32.	22894X	Set Screw .....	2
33.	22874C	Screw .....	1
34.	34337F	Eccentric Bushing .....	1
35.	34336A	Differential Feed Drive Link .....	1
36.	93	Screw .....	2
37.	34335G	Feed Bar Guide .....	1

\*NOTE: Not sold separately.



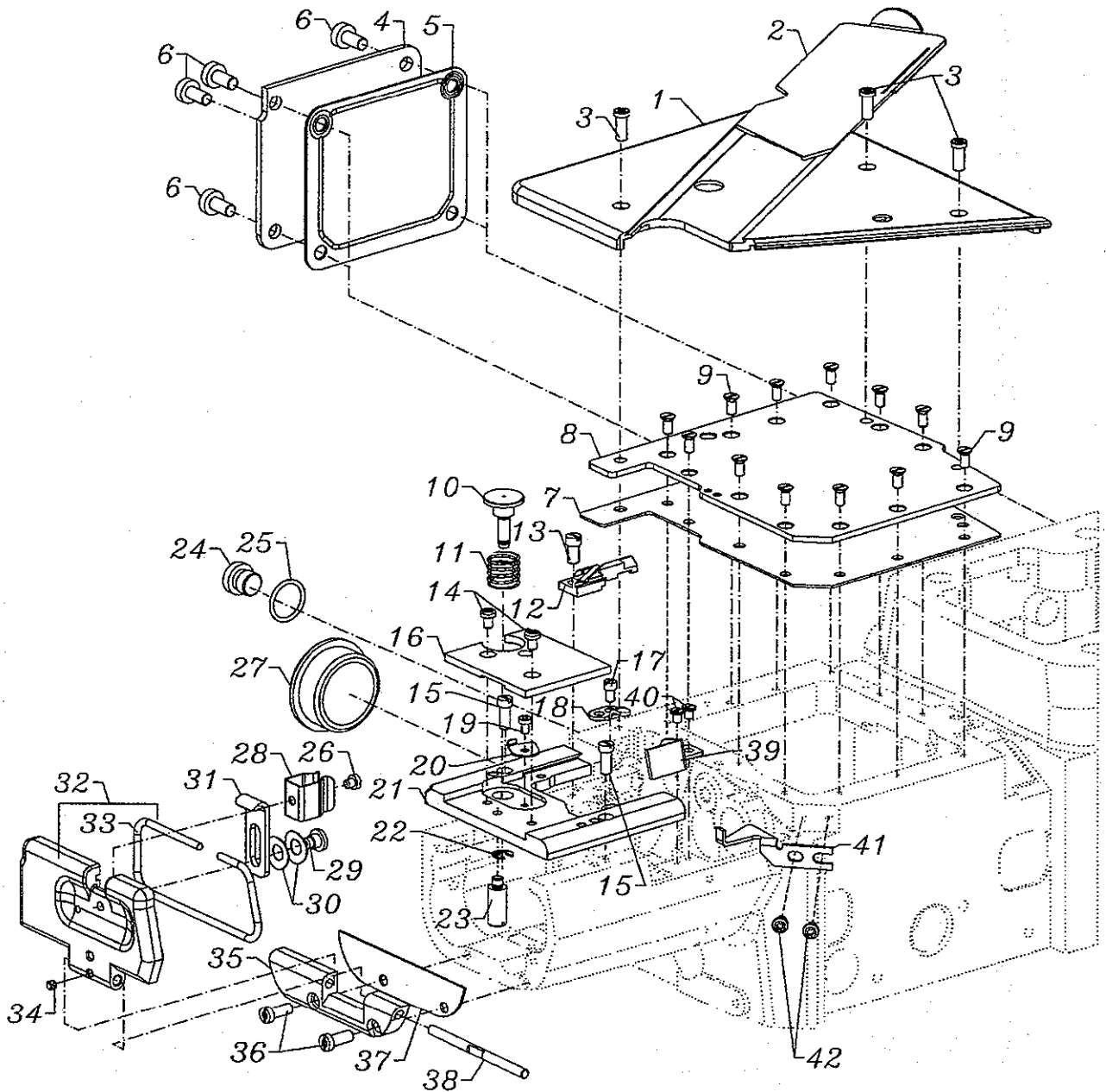


## FEED DRIVE MECHANISM

Ref. No.	Part No.	Description	Amt. Req.
1.	G29476BS	Feed Drive Assembly .....	1
2.	999-215	Snap Ring .....	2
*3.		Bearing .....	1
*4.		Double Eccentric .....	1
5.	22894AD	Screw .....	2
*6.		Bearing .....	1
7.	666-149	Felt Wick .....	1
8.	G51054	Link Pin .....	1
*9.		Connecting Rod, for feed link .....	1
*10.		Feed Lift Lever .....	1
11.	22894AE	Set Screw .....	2
*12.		Connecting Rod, for differential feed .....	1
*13.		Link Pin .....	1
*14.		Pitman Rod .....	1
*15.		Connecting Rod .....	1
*16.		Link Pin .....	1
*17.		Differential Feed Drive Lever .....	1
18.	93	Screw .....	1
19.	34337E	Shim Ring .....	1
20.	22585C	Screw .....	1
*21.		Bracket .....	1
22.	34337	Link Pin .....	1
23.	96865	Dowel Pin, Grooved .....	1
*24.		Lever .....	1
25.	G55241F	Hinge Pin .....	1
26.	22894AD	Set Screw .....	1
27.	96719	Spring .....	1
28.	34335D	Guide Stud .....	1
29.	22894C	Set Screw .....	1
30.	34335F	Stud .....	1
31.	999-211E	"O" Ring .....	1
32.	34336LA	Nut .....	1
33.	96653	Roll Pin .....	1
34.	34336MC	Retaining Ring .....	1
35.	999-211P	"O" Ring .....	1
36.	34336HB	Adjusting Screw .....	1
37.	96531	Pin .....	1
38.	22560B	Set Screw .....	1
39.	77K	Set Screw .....	1
40.	34336TA	Bushing .....	1
41.	34334A	Feed Drive Shaft .....	1
42.	34336P	Link Pin .....	1
43.	666-149	Oil Wick .....	1
44.	34335J	Collar .....	1
45.	22894X	Screw .....	1
46.	22569G	Screw .....	2
47.	34335D	Guide Stud .....	1
48.	22894R	Set Screw .....	2
49.	34335H	Feed Bar Guide .....	1
50.	34363	Pawl Support .....	1
51.	28B	Screw .....	1
52.	22894W	Screw .....	1
53.	34363A	Spring .....	1
54.	34363B	Pawl .....	1
55.	34363C	Stop .....	1

\*NOTE: Not sold separately.

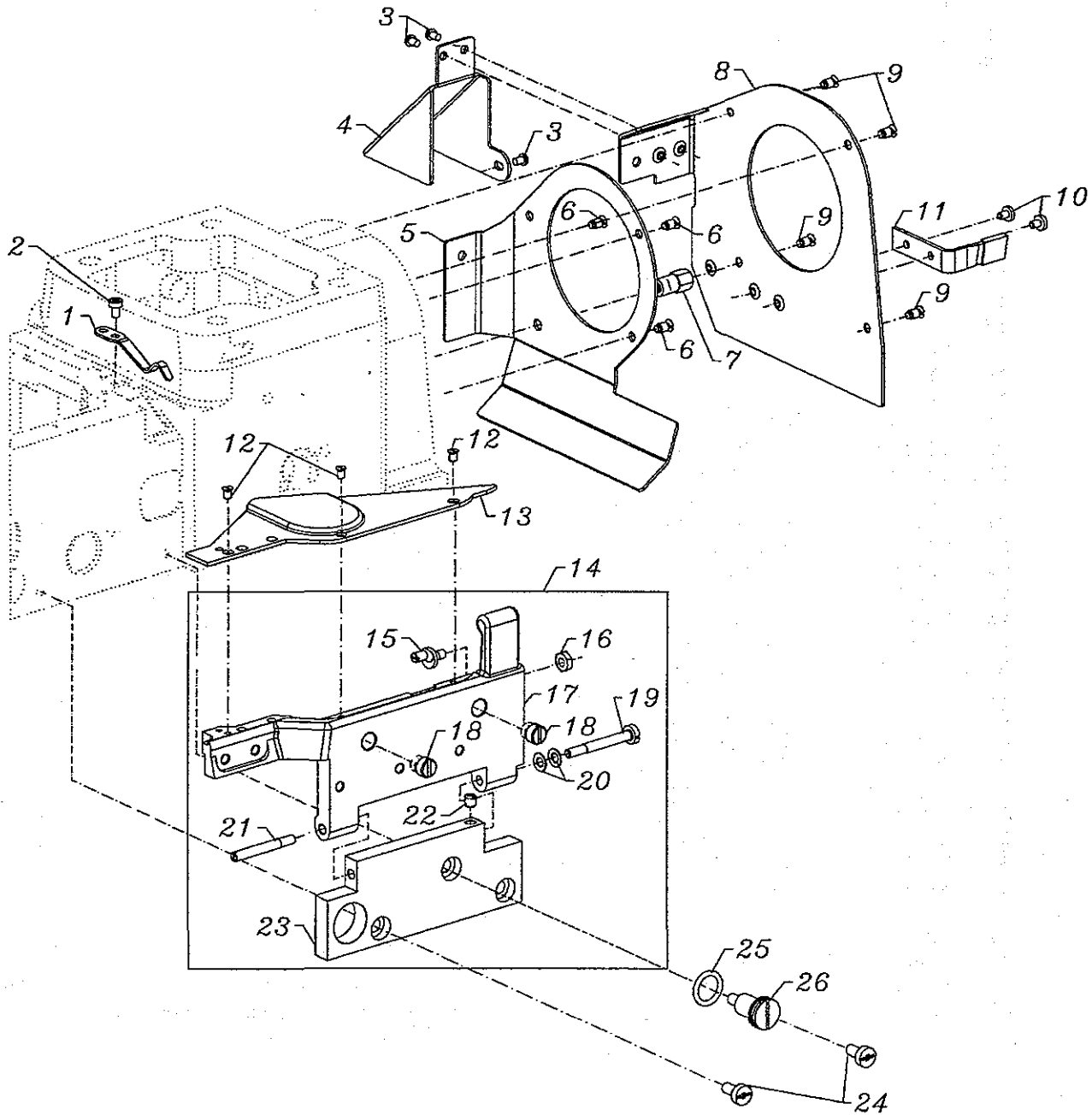




## COVERS LOWER BED

Ref. No.	Part No.	Description	Amt. Req.
1.	50301BG	Cloth Plate Assembly .....	1
2.	50382CN	Slide Cover .....	1
3.	22569B	Screw, for cloth plate .....	3
4.	56382D	Chamber Cover .....	1
5.	34782C	Chamber Cover Gasket .....	1
6.	22548	Screw, for chamber cover .....	4
7.	34382EA	Gasket, for oil reservoir cover .....	1
8.	34382J	Oil Reservoir Cover .....	1
9.	22524	Screw, for oil reservoir cover .....	12
10.	34367	Stop Bolt .....	1
11.	97014	Spring .....	1
12.	34381B	Rest for Slide .....	1
13.	79	Screw, for rest for slide .....	1
14.	90	Screw .....	2
15.	J79J	Screw .....	2
16.	34367A	Cover, for throat plate support .....	1
17.	91	Screw, for support for slide .....	1
18.	34367B	Safety Catch .....	1
19.	95685	Screw .....	1
20.	34381A	Support for Slide .....	1
21.	34380	Throat Plate Support .....	1
-	96527	Pin (not shown) .....	2
22.	96277	Retaining Ring .....	1
23.	99364L	Shank Screw .....	1
24.	99376	Plug Screw, for bed .....	1
25.	96390	Washer, for plug screw .....	1
26.	HS24C	Screw .....	1
27.	50393EU	Plug, for top .....	1
28.	99697J	Latch Spring .....	1
29.	22746	Screw, for handle .....	1
30.	39536AD	Spring Washer, for handle .....	2
31.	34382W	Handle .....	1
32.	50382FV	Cylinder Cover .....	1
33.	1266033	Sealing Cord (0.19m) .....	1
34.	22894Y	Screw .....	1
35.	50382FU	Hinge, for cylinder cover .....	1
36.	22541B	Screw, for hinge .....	2
37.	34382UA	Gasket, for hinge .....	1
38.	34382V	Pin, for hinge .....	1
39.	50382GV	Plate Cover .....	1
40.	SS6090420SP	Screw, for plate cover .....	2
41.	34750N	Thread Guide (included in under bed thread trimmer see page 47) .....	1
42.	90	Screw, for thread guide (included in under bed thread trimmer see page 47) ...	2



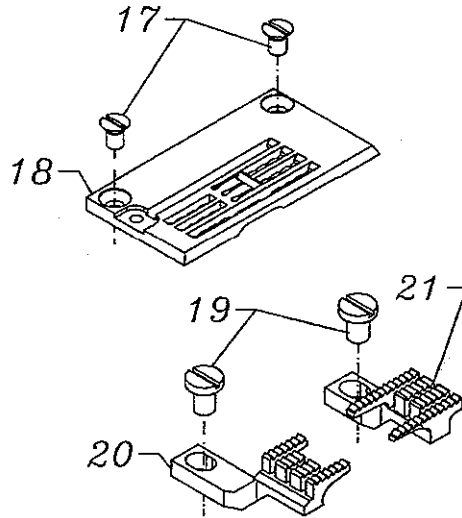
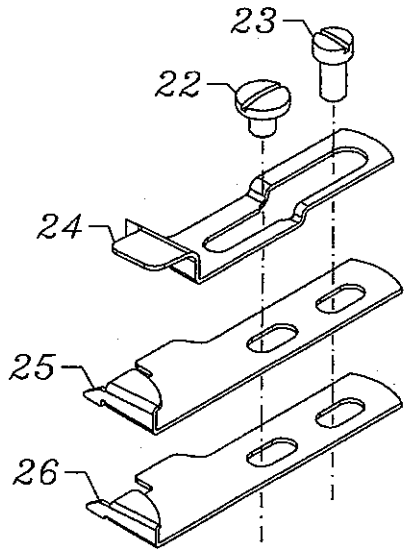
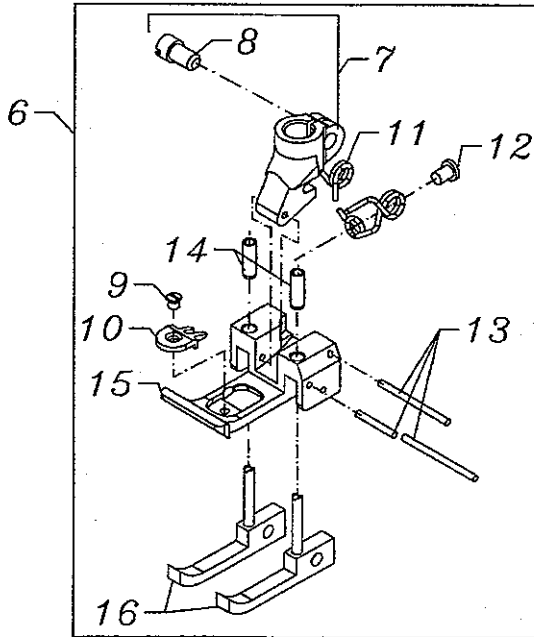
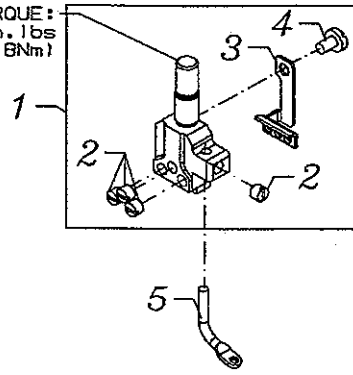


**COVERS LOWER BED - FRONT**

Ref. No.	Part No.	Description	Amt. Req.
1.	43281K	Latch Spring .....	1
2.	95860	Screw .....	1
3.	SS4090515SP	Screw .....	3
4.	50382GR	Belf Guard .....	1
5.	34382AD	Air Duct .....	1
6.	22757E	Screw .....	3
7.	99353A	Spacer Stud .....	1
8.	50395J	Belf Guard .....	1
9.	22757E	Screw .....	4
10.	22585C	Screw .....	2
11.	34767K	Synchronizer Stop .....	1
12.	22766	Screw .....	3
13.	50301BK	Cloth Plate Assembly .....	1
14.	29476SA	Swing-Out Cloth Plate Support .....	1
15.	99301A	Eccentric Screw .....	1
16.	9937	Nut .....	1
17.	50364R	Cloth Plate Support .....	1
18.	99356	Stop Screw .....	2
19.	99350	Shoulder Screw .....	1
20.	97127	Cup Spring .....	2
21.	99351	Shoulder Screw .....	1
22.	95	Set Screw .....	1
23.	50364S	Hinge Plate .....	1
24.	22548	Screw .....	2
25.	660-212	"O" Ring .....	1
26.	99620	Stop Screw .....	1



TORQUE:  
14-16in.lbs  
(1.6-1.8Nm)

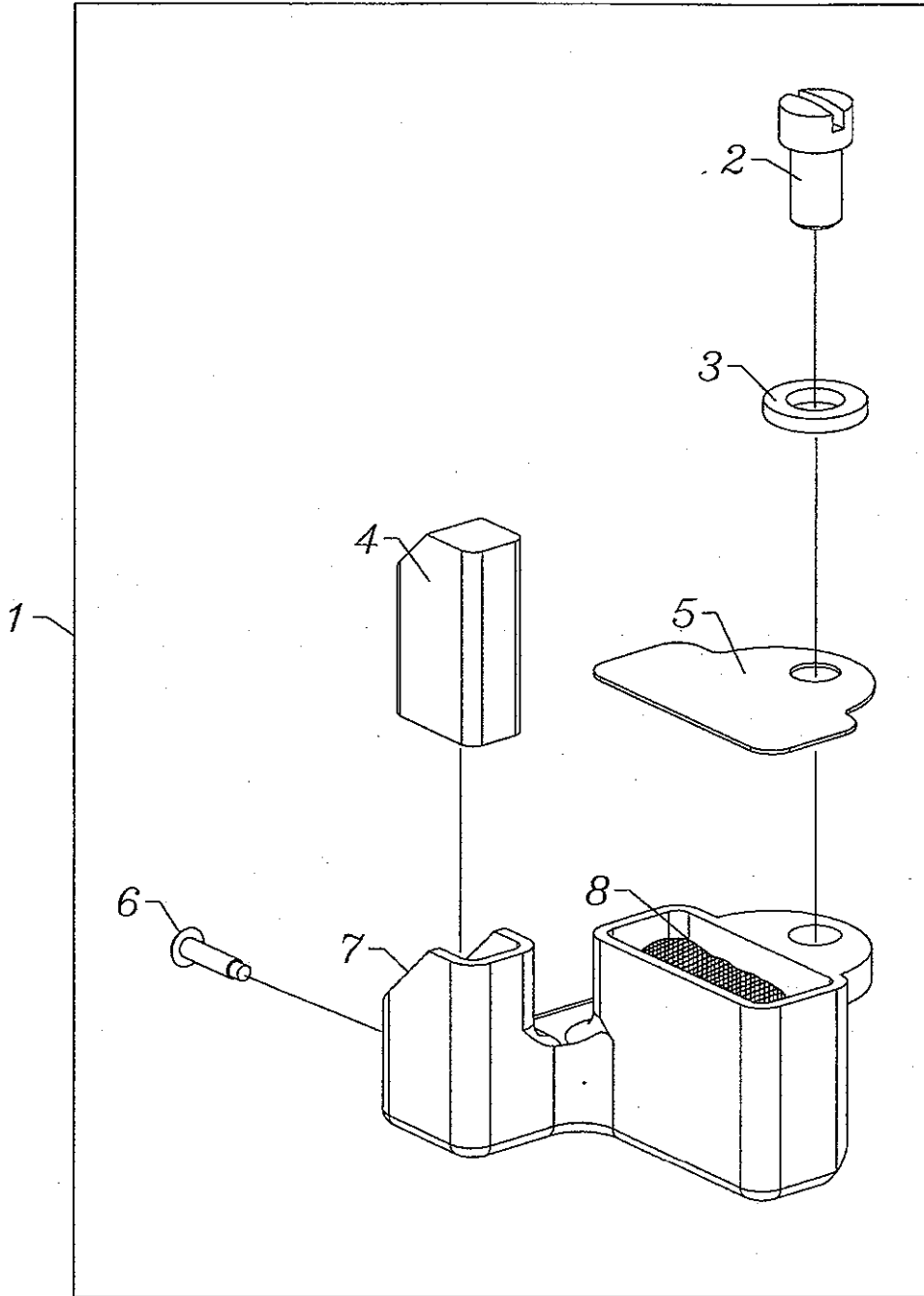




## SEWING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1.	50318AD56	Needle Head, for Style CS132H01-3B_/UT5 .056 gauge .....	1
-	50318AC60	Needle Head, for Styles CS122H01-3B_/UT5, CS132H01-3B_/UT5 .060 gauge .....	1
2.	SS8080310TP	Set Screw .....	4
3.	50318AE56	Eyelet .....	1
4.	SS6066440TP	Screw .....	1
5.	50392G	Needle Thread Eyelet .....	1
6.	50320T60	Presser Foot Assembly .....	1
7.	G65-134	Shank .....	1
8.	91	Screw .....	1
9.	22716A	Screw .....	1
10.	50397A16	Stitch Tongue .....	1
11.	79633	Spring .....	1
12.	605	Screw .....	1
13.	6-25-55	Drill Rod .....	3
14.	G50-266	Bushing .....	2
15.	50330BL16	Presser Foot Bottom .....	1
16.	57830A	Yielding Section .....	2
17.	87	Screw, for throat plate .....	2
18.	50324BS56	Throat Plate, for Style CS132H01-3B_/UT5 .056 gauge .....	1
-	50324BS60	Throat Plate, for Styles CS122H01-3B_/UT5, CS132H01-3B_/UT5 .060 gauge .....	1
19.	99293	Screw, for feed dogs .....	2
20.	34726F	Differential Feed Dog .....	1
21.	34705F	Main Feed Dog .....	1
22.	25S	Screw .....	1
23.	22715A	Screw .....	1
24.	34703F3	Hemmer, Upper .....	1
25.	34703F1	Hemmer, Lower .....	1
26.	34703FA1	Hemmer, Lower .....	1

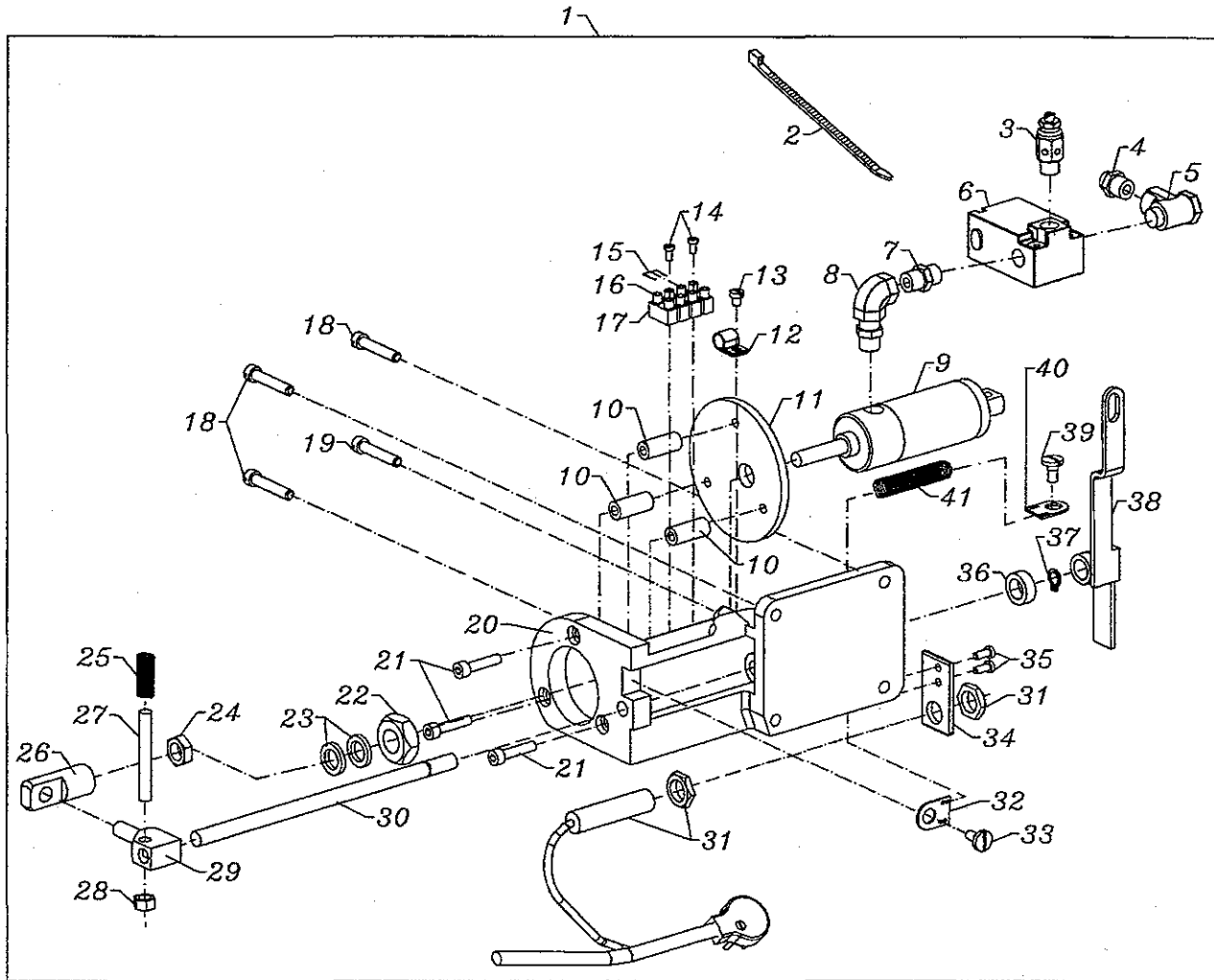




**NEEDLE DIPPER (EXTRA SEND CHARGE)**

Ref. No.	Part No.	Description	Amt. Req.
1.	29480ARS	Needle Dipper Assembly .....	1
2.	22562B	Screw, for needle dipper .....	1
3.	80265	Washer .....	1
4.	50393GW	Felt .....	1
5.	50382GJ	Needle Dipper Cover .....	1
6.	666-197	Pin, for oil wick .....	1
7.	50393GJ	Needle Dipper .....	1
8.	CQ200000000	Oil Wick .....	1

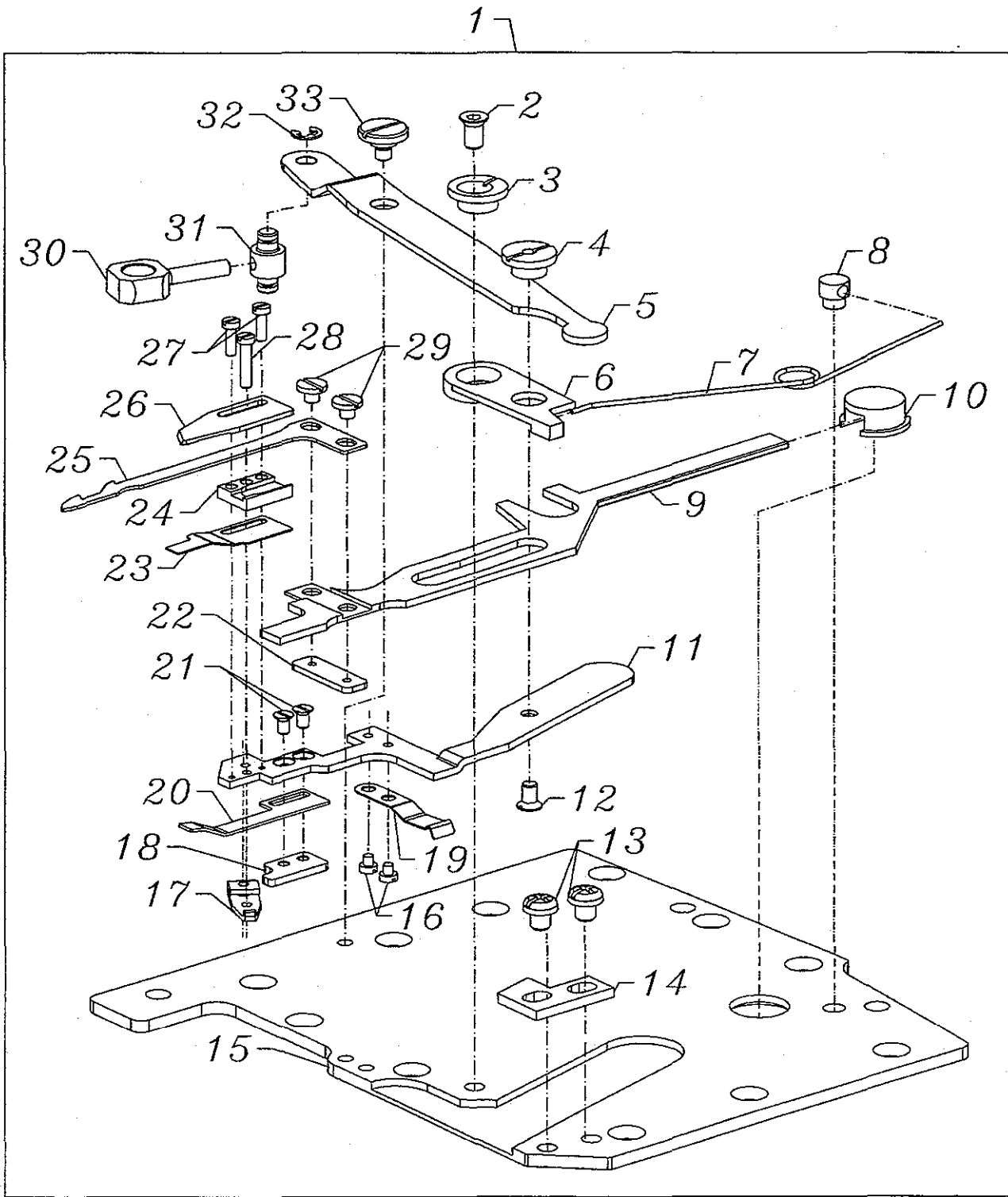




**PNEUMATIC DRIVE ASSEMBLY  
FOR UNDER BED THREAD TRIMMER ASSEMBLY**

Ref. No.	Part No.	Description	Amt. Req.
1.	29480ASP	Pneumatic Drive Assembly .....	1
2.	670-E2	Cable Tie .....	1
3.	671-198	Muffler Valve .....	1
4.	671F81D	Air Fitting .....	1
5.	671-102B	Needle Valve .....	1
6.	671-50	Mac Valve .....	1
7.	RM3287-2	Hex Nipple .....	1
8.	RM2881-1	Elbow .....	1
9.	660-397	Air Cylinder .....	1
10.	99617T	Spacer .....	3
11.	99591DH	Disk .....	1
12.	998-358E	Cable Clamp .....	1
13.	22542	Screw .....	1
14.	95179K	Screw .....	2
15.	1318001	Wire .....	1
16.	998-304	Terminal Block .....	1
17.	998-297A	Cable End Plate .....	1
18.	22852A	Screw .....	3
19.	22517A	Screw .....	1
20.	G52882KW	Support Bracket .....	1
21.	95411	Screw .....	3
22.	99327	Nut .....	1
23.	99615	Washer .....	2
24.	21233FB	Nut .....	1
25.	51292F2	Spring .....	1
26.	99616A	Connector .....	1
27.	99619	Clamping Screw .....	1
28.	55235E	Nut .....	1
29.	99614D	Cross Head .....	1
30.	99613D	Shaft .....	1
31.	99733	Switch Assembly .....	1
32.	80696RA	Retainer .....	1
33.	14076	Stud .....	1
34.	34762	Bracket .....	1
35.	22585	Screw .....	2
36.	99615	Washer .....	1
37.	96261	Retaining Ring .....	1
38.	50373DG	Lever .....	1
39.	22569C	Screw .....	1
40.	80696RA	Retainer .....	1
41.	96721	Spring .....	1

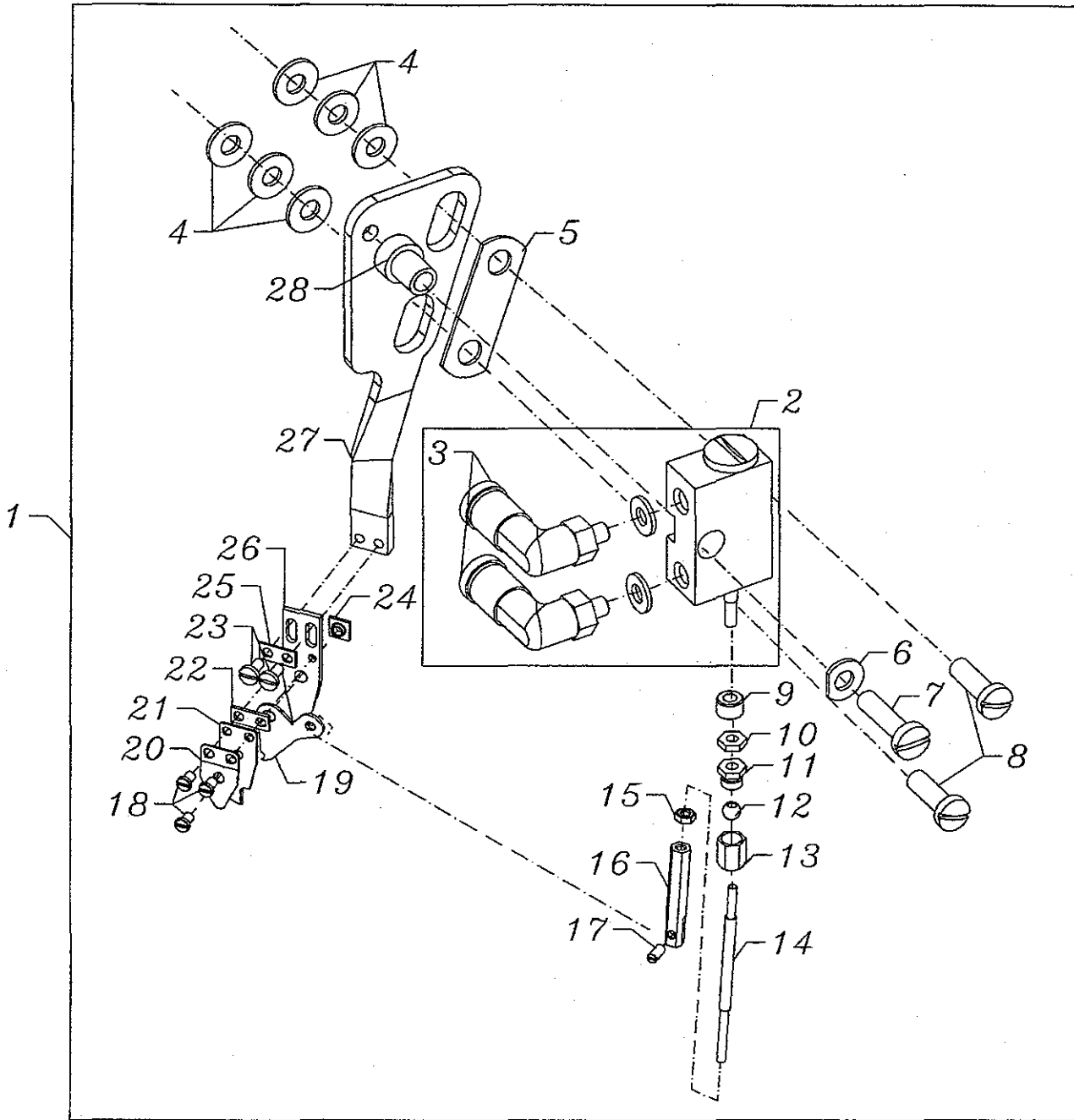




## UNDER BED THREAD TRIMMER ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	29480ARF	Looper Thread Undertrimmer Assembly .....	1
2.	18-1450	Screw .....	1
3.	34768A	Eccentric Guide .....	1
4.	34768B	Guide Washer .....	1
5.	34763P	Lever .....	1
6.	34750R	Lever .....	1
7.	34763N	Spring .....	1
8.	34751MS	Pin .....	1
9.	34750T	Lower Knife Holder .....	1
10.	34750U	Guide .....	1
11.	34750S	Upper Knife Holder .....	1
12.	18-1456	Screw .....	1
13.	18-1449	Screw .....	2
14.	34775H	Stop .....	1
15.	34382AC	Oil Reserve Cover .....	1
16.	SM6020250TP	Screw .....	2
17.	34751MT	Tension Lever .....	1
18.	34769B	Threaded Plate .....	1
19.	34773E	Leaf Spring .....	1
20.	34773D	Leaf Spring .....	1
21.	SM1020450TP	Screw .....	2
22.	34769C	Threaded Plate .....	1
23.	34773F	Leaf Spring .....	1
24.	34750P	Lower Knife Guide .....	1
25.	34749M	Lower Knife .....	1
26.	34770M	Upper Knife .....	1
27.	SM6020600TP	Screw .....	2
28.	SM6021000TP	Screw .....	1
29.	18-1453	Screw .....	2
30.	34752M	Driving Link .....	1
31.	34794A	Carrier Bolt .....	1
32.	RE0250000K0	E-Ring .....	1
33.	SD0600176SP	Screw .....	1
-	34750N	Thread Guide (see page 37) .....	1
-	90	Screw, for thread guide (see page 37) .....	2



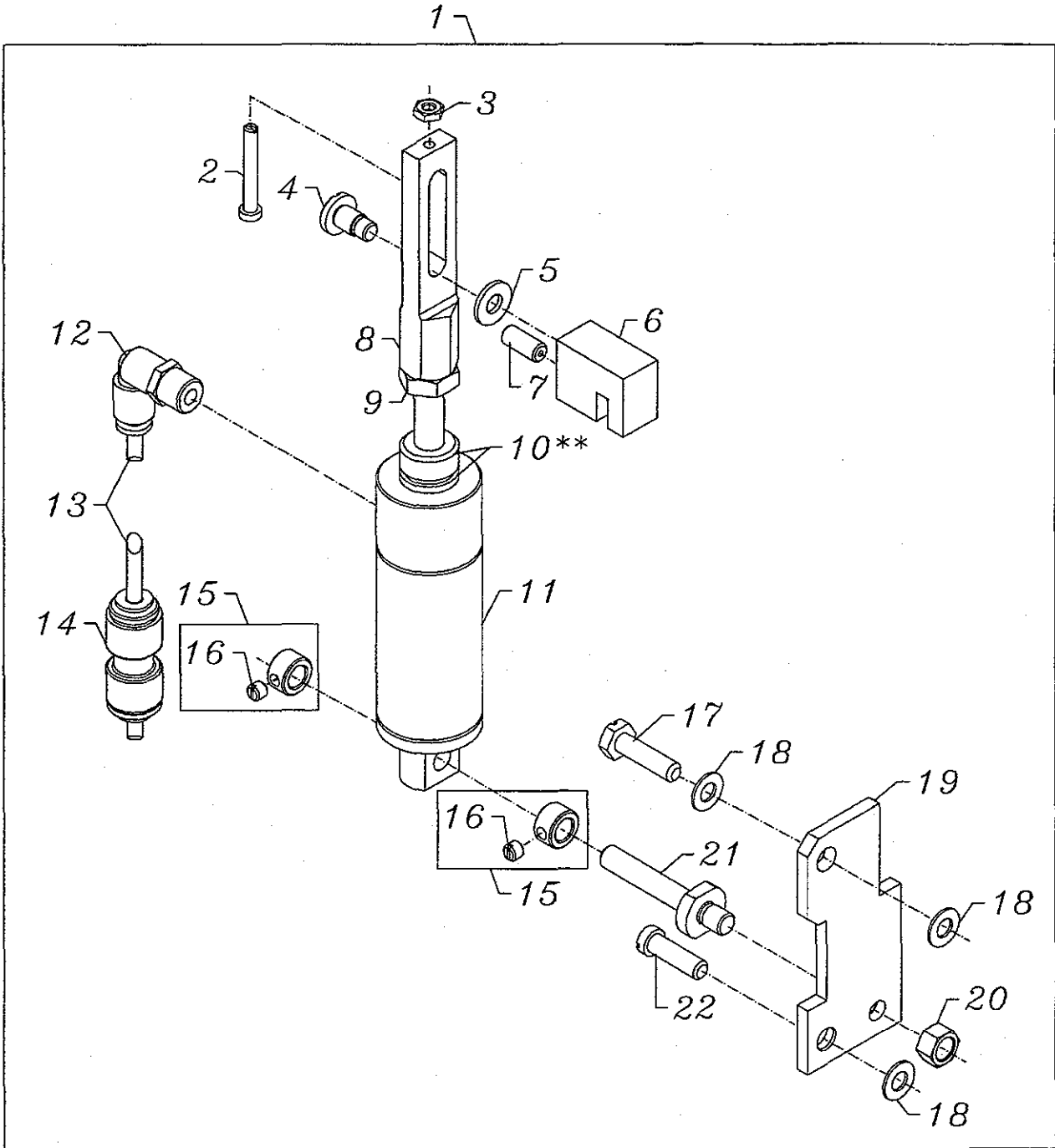




**COVER THREAD TRIMMER  
FOR STYLE CS132H01-3B\_ \_ / UT5**

Ref. No.	Part No.	Description	Amt. Req.
1.	50370G	Cover Thread Trimmer Assembly (mounts to head cover 50382FX) .....	1
2.	99683VG	Housing .....	1
3.	999-411M5-4	Coupling .....	2
4.	69H	Washer .....	6
5.	34751MF	Washer Plate .....	1
6.	39278C	Washer .....	1
7.	93B	Screw .....	1
8.	SS4121415SP	Screw .....	2
9.	34751MH	Spacer .....	1
10.	95259	Nut .....	1
11.	34751MJ	Coupling .....	1
12.	34751MK	Ball .....	1
13.	34751ML	Nut .....	1
14.	34751MP	Connecting Rod .....	1
15.	35875V	Nut .....	1
16.	34751MQ	Clevis .....	1
17.	79077	Screw .....	1
18.	22738B	Screw .....	3
19.	34770LB	Knife .....	1
20.	34751ME	Spring .....	1
21.	34749LB	Fixed Knife .....	1
22.	34751MC	Washer Plate .....	1
23.	22798A	Screw .....	2
24.	34751MD	Square Collar .....	1
25.	34751MR	Washer Plate .....	1
26.	34751MB	Support .....	1
27.	50372DG	Holder .....	1
28.	99683VF4	Bushing .....	1



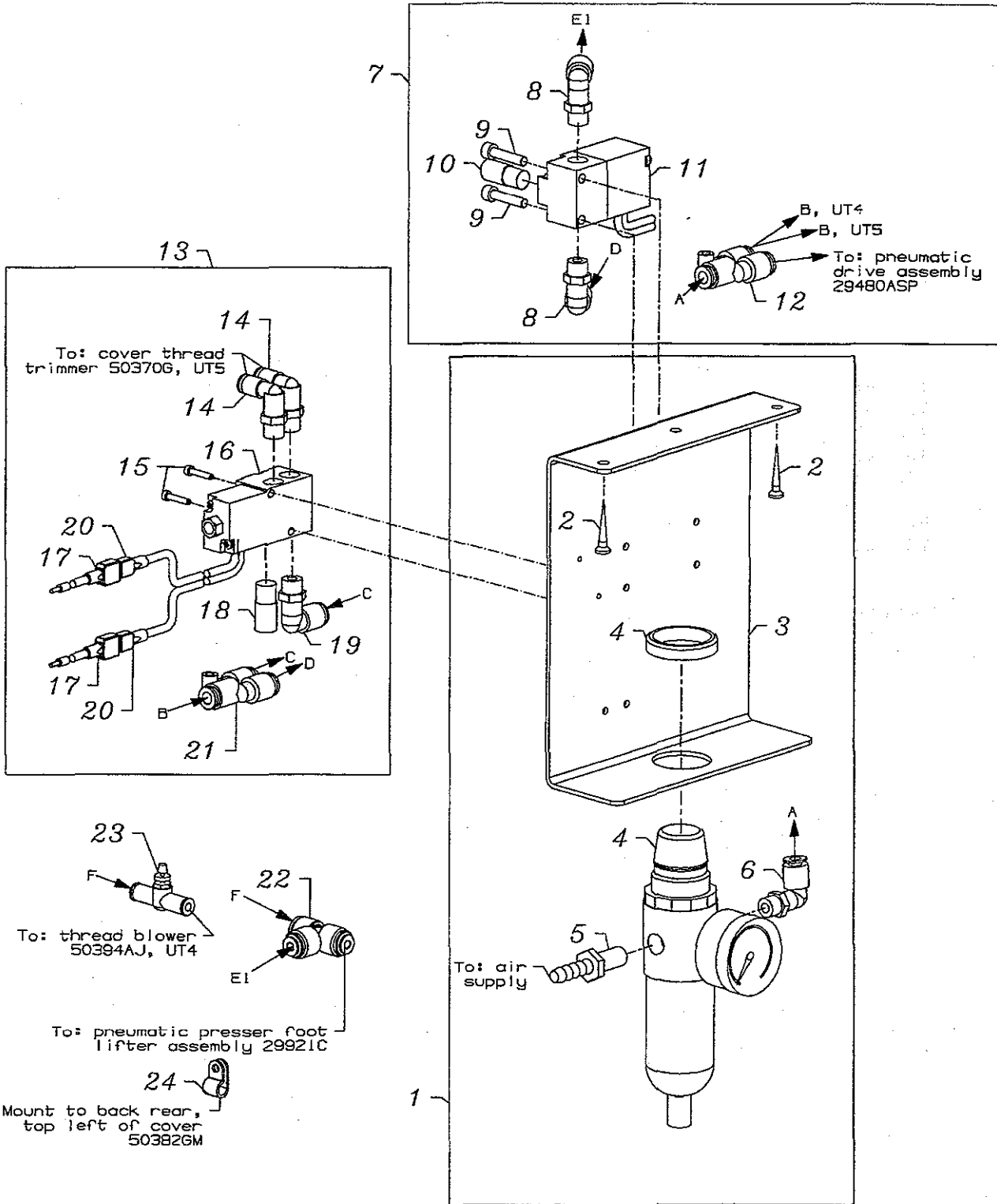


**PNEUMATIC PRESSER FOOT LIFTER  
FOR STYLE CS122H01-3B\_ \_ / UT4**

Ref. No.	Part No.	Description	Amt. Req.
1.	29921C	Pneumatic Presser Foot Lifter Assembly .....	1
2.	99372B	Regulating Screw .....	1
3.	41071G	Nut .....	1
4.	31137G	Shoulder Screw .....	1
5.	61434G	Washer .....	1
6.	34383E	Clamp Block .....	1
7.	22894E	Set Screw .....	1
8.	99590Q	Cylinder Rod .....	1
9.	21233FB	Nut .....	1
**10.	99590R	Stop Ring (see note) .....	2
11.	660-397	Air Cylinder .....	1
12.	999-412R1/8-4	Swivel Elbow .....	1
13.	1314003	PA-Tube .....	1
14.	999-292	Push-Pull Coupling .....	1
15.	6958	Collar .....	2
16.	88	Set Screw .....	2
17.	627A	Hex Head Cap Screw .....	1
18.	20	Washer .....	3
19.	99591S	Bracket .....	1
20.	55235E	Nut .....	1
21.	99391E	Stud Bolt .....	1
22.	22839E	Screw .....	1

\*\*Removal of one or both stop rings is required when presser foot lifting exceeds 2mm (5/64in.).



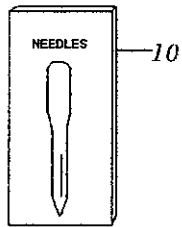
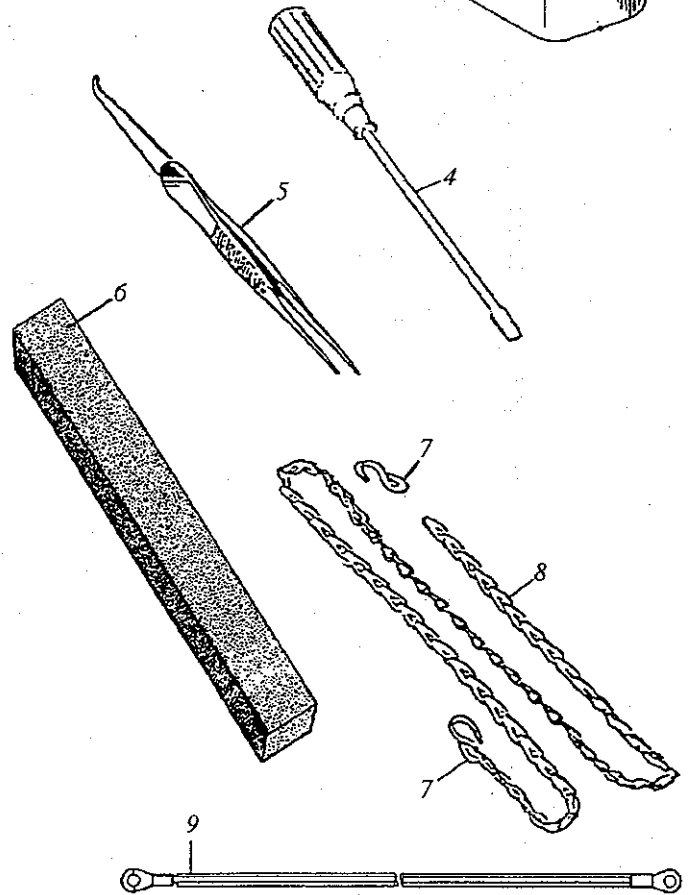
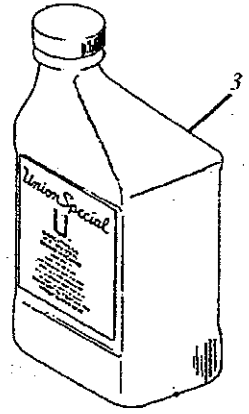
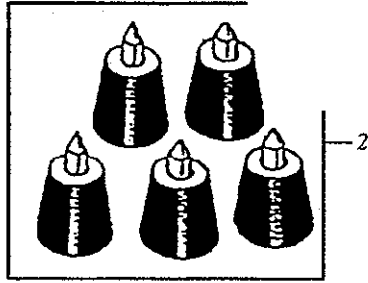
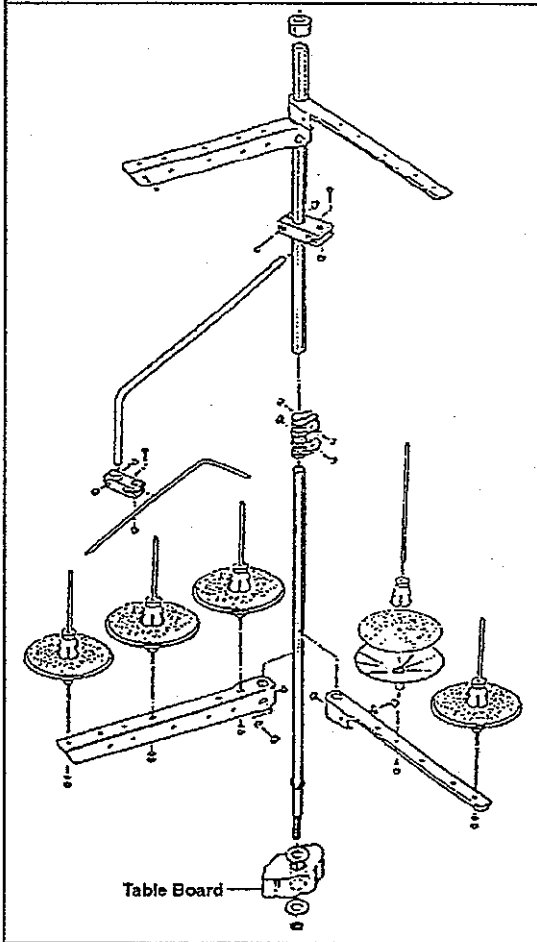


## PNEUMATIC CONTROL

Ref. No.	Part No.	Description	Amt. Req.
1.	29480ASU	Pneumatic Control Kit .....	1
2.	90561K	Wood Screw .....	2
3.	99683CP	Mounting Bracket .....	1
4.	671D31	Filter/ Regulator Assembly .....	1
5.	671F1	Barb Fitting .....	1
6.	671F81C	Elbow Fitting - 6mm x 1/2" NPT .....	1
-	1314001	Air Tubing - 6mm O.D. x 1m (not shown) .....	2
7.	29480AST	Presser Foot Lifter Kit .....	1
8.	671F81C	Elbow Fitting - 6mm x 1/8" NPT .....	2
9.	95415	Screw - 4mm .....	2
10.	660-403	Muffler .....	1
11.	671-50	Valve .....	1
*12.	671F86B	Splitter .....	1
-	670E673	Cable Harness (not shown) .....	1
-	RM2724A	Connector (male, not shown) .....	2
-	1314001	Air Tubing - 6mm O.D. x 1mm (not shown) .....	1
13.	29480ASN	Spreader Thread Trimmer Control Kit, for Style CS132H01-3B/UT5 .....	1
14.	671F82C	Elbow Fitting - 4mm x 1/8" NPT .....	2
15.	18-1471	Screw- 3mm .....	2
16.	671-109A	4 Way Valve .....	1
17.	670E8	Wire & Connector .....	2
18.	660-403	Muffler .....	1
19.	671-F81C	Elbow Fitting - 6mm x 1/8" NPT .....	1
20.	670G102	Connector .....	2
-	670E2	Wire Tie (not shown) .....	4
-	1314001	Air Tubing - 6mm O.D. x 1m (not shown) .....	1
-	1314003	Air Tubing - 4mm x 1m (not shown) .....	2
*21.	671F86B	Splitter .....	1
22.	671F82J	"T" Fitting .....	1
23.	671-168	Needle Valve .....	1
24.	998-358E	Tube Clamp .....	1

\* E on UT4 Style connect "E1" to "E2". On UT5 Style connect "E1" to presser foot lift 29921C.





F369-95



## ACCESSORIES

Ref. No.	Part No.	Description	Amt. Req.
1.	21101W5	Thread Stand .....	1
2.	51295B	Isolator .....	5
3.	28604R	Oil (1 pint) .....	1
4.	G21201	Screwdriver, for needle head .....	1
5.	660-240	Thread Tweezer .....	1
6.	34395	Profile Runner .....	1
7.	660-264	"S" Hook .....	2
8.	421D34	Chain .....	1
9.	90233EB	Ground Wire .....	1
10.	121GJS070/027	Needles, (package of 10) .....	1



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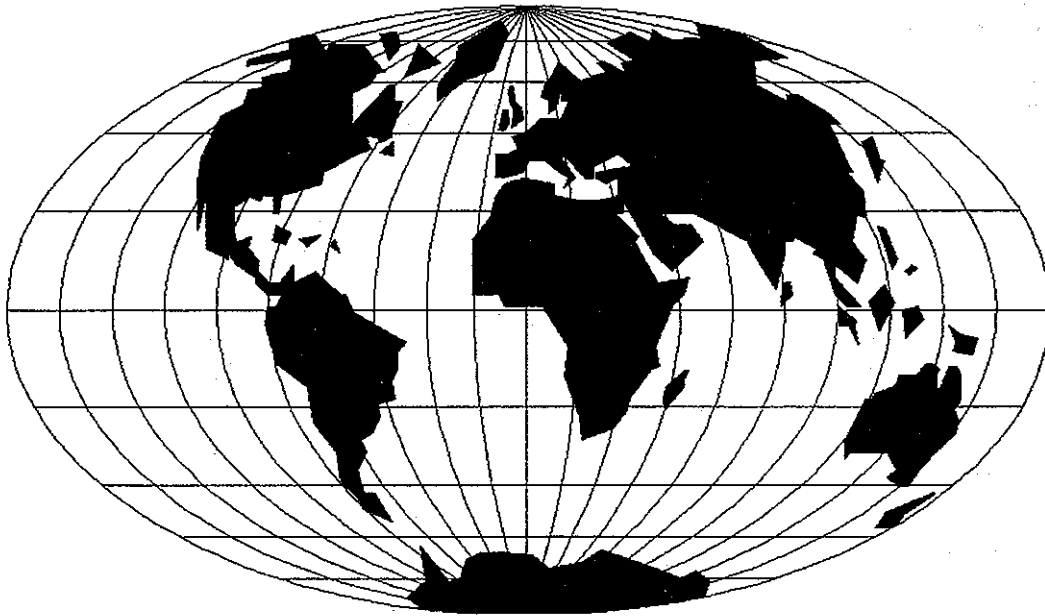
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