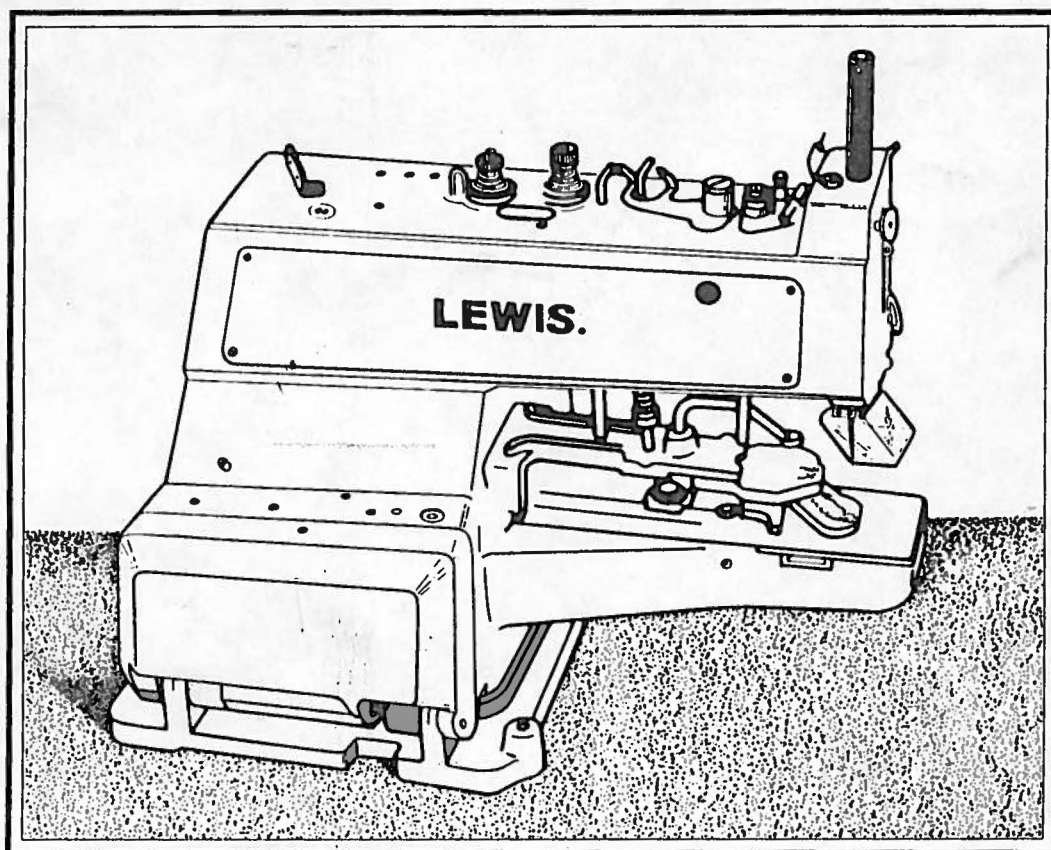


LEWIS®

220-1
220-15

Button Sewing Machines



Parts Manual
No. 9102

MANUAL NO. 9102

For Styles

220-1

220-15

**Second Edition
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**Printed in U.S.A.
September, 1991**

This parts manual has been prepared and can be used in conjunction with Union Special Form 357 adjusting instructions No. 9101. The Lewis Button Sewing Machine is based on available information, changes in design and/or improvements may incorporate a slight modification of configuration in illustrations or part numbers.

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

The following pages consist of the illustrations and terminology used in describing the parts used on machine styles 220-1 and 220-15.

SAFETY RULES



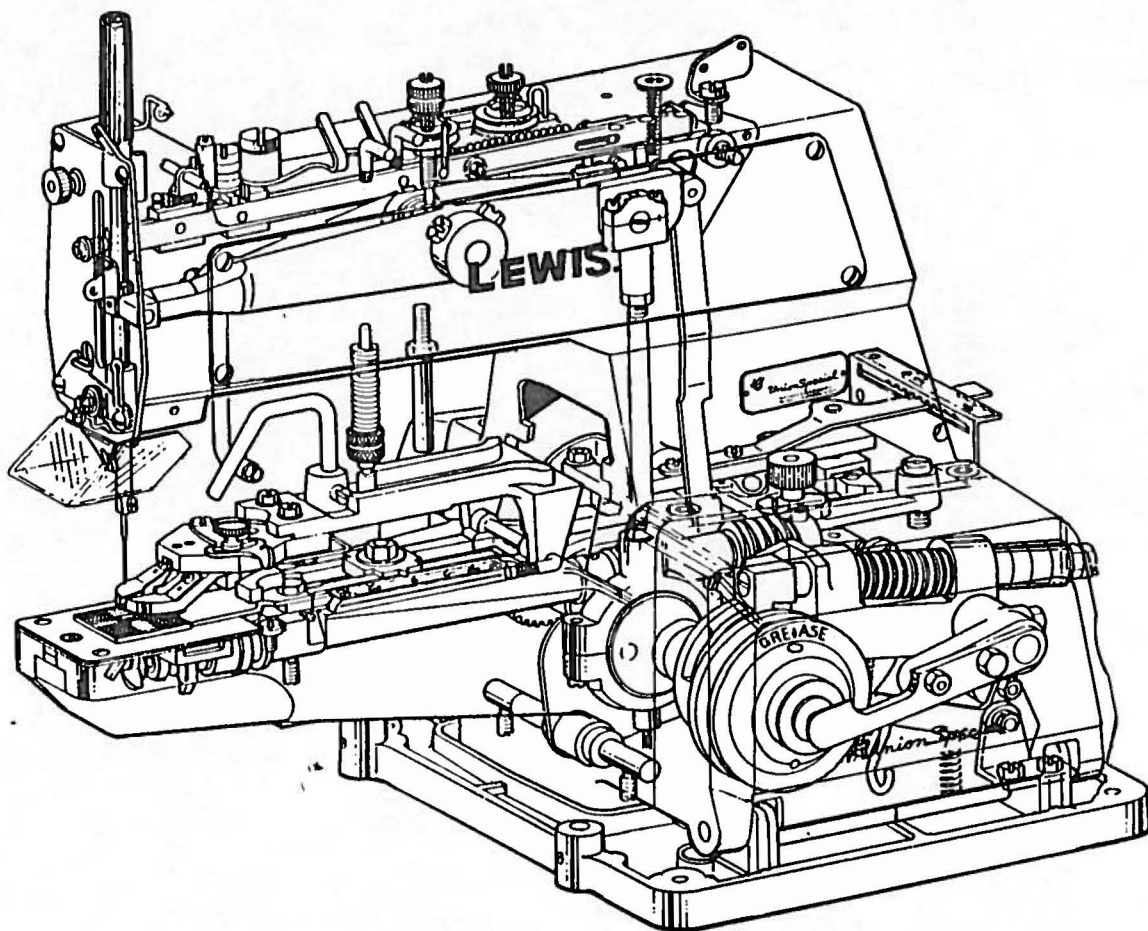
CAUTION!

THIS SYMBOL INDICATES YOUR PERSONAL SAFETY IS INVOLVED.

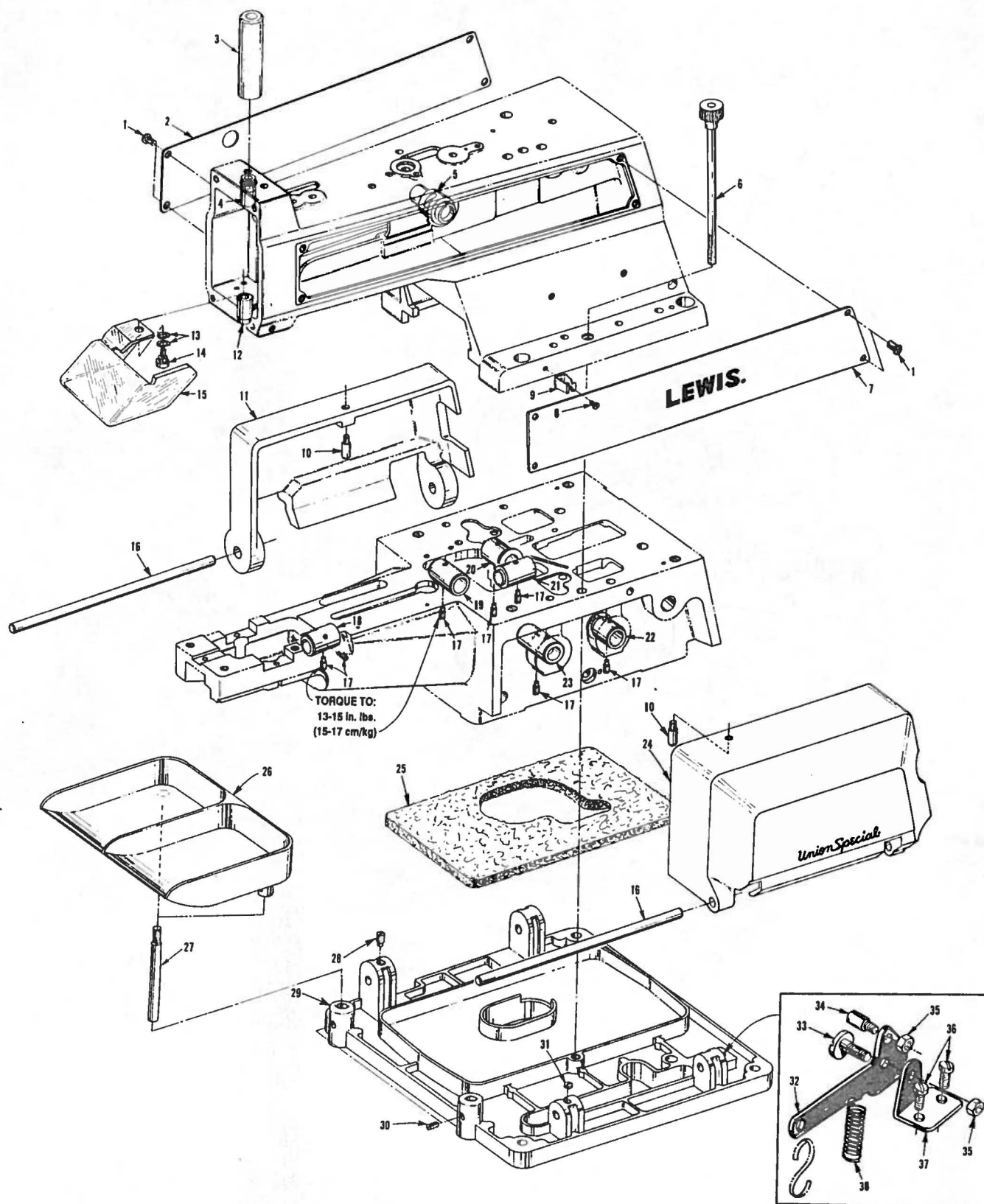
TO PREVENT PERSONAL INJURY:

- All power sources to the machine **MUST** be **TURNED OFF** before threading, oiling, adjusting, or replacing parts.
- Wear safety glasses
- All covers and guards **MUST** be in position before operating machine.
- **DO NOT** tamper with covers, guards, etc., while machine is in operation.

1. Stop Motion Trip Lever, Bushings & Covers	9
2. Needle Drive, Clutch & Stop Motion Parts	11
3. Needle Drive, Clutch & Stop Motion Parts	13
4. Knife Components, Cams & Looper Drive Parts	15
5. Knife Components, Cams & Looper Drive Parts	17
6. Stop Motion, Button Clamp Lifter, Knife Drive & Nipper Parts	19
7. Stop Motion, Button Clamp Lifter, Knife Drive & Nipper Parts	21
8. Feed Plate & Button Positioning Parts	23
9. Button Clamp Components	25
10. Miscellaneous Covers & Thread Tension Components	27
11. Standard Accessories	29
12. Index	30

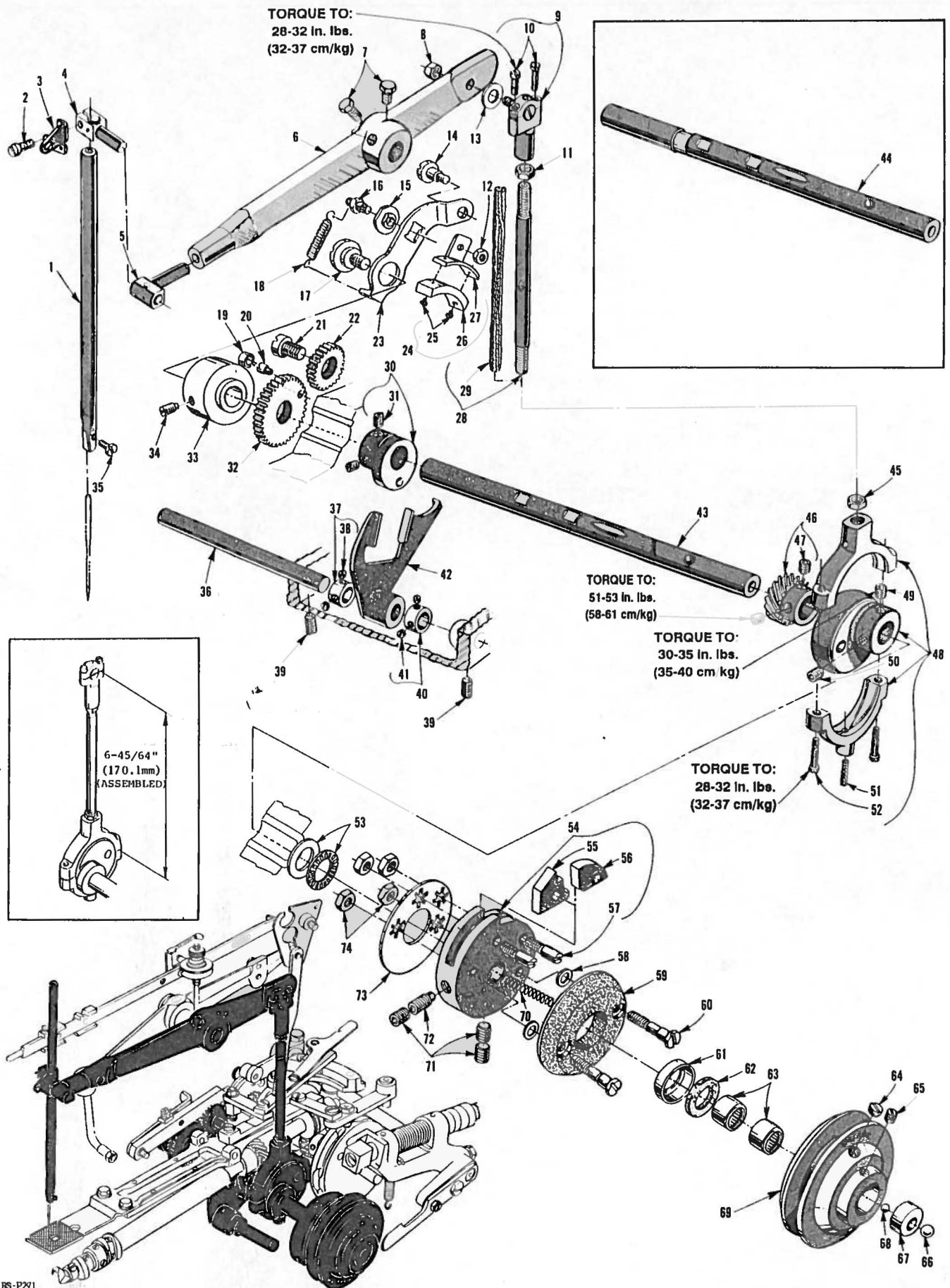


**EXPLODED VIEWS
AND
DESCRIPTION OF PARTS**



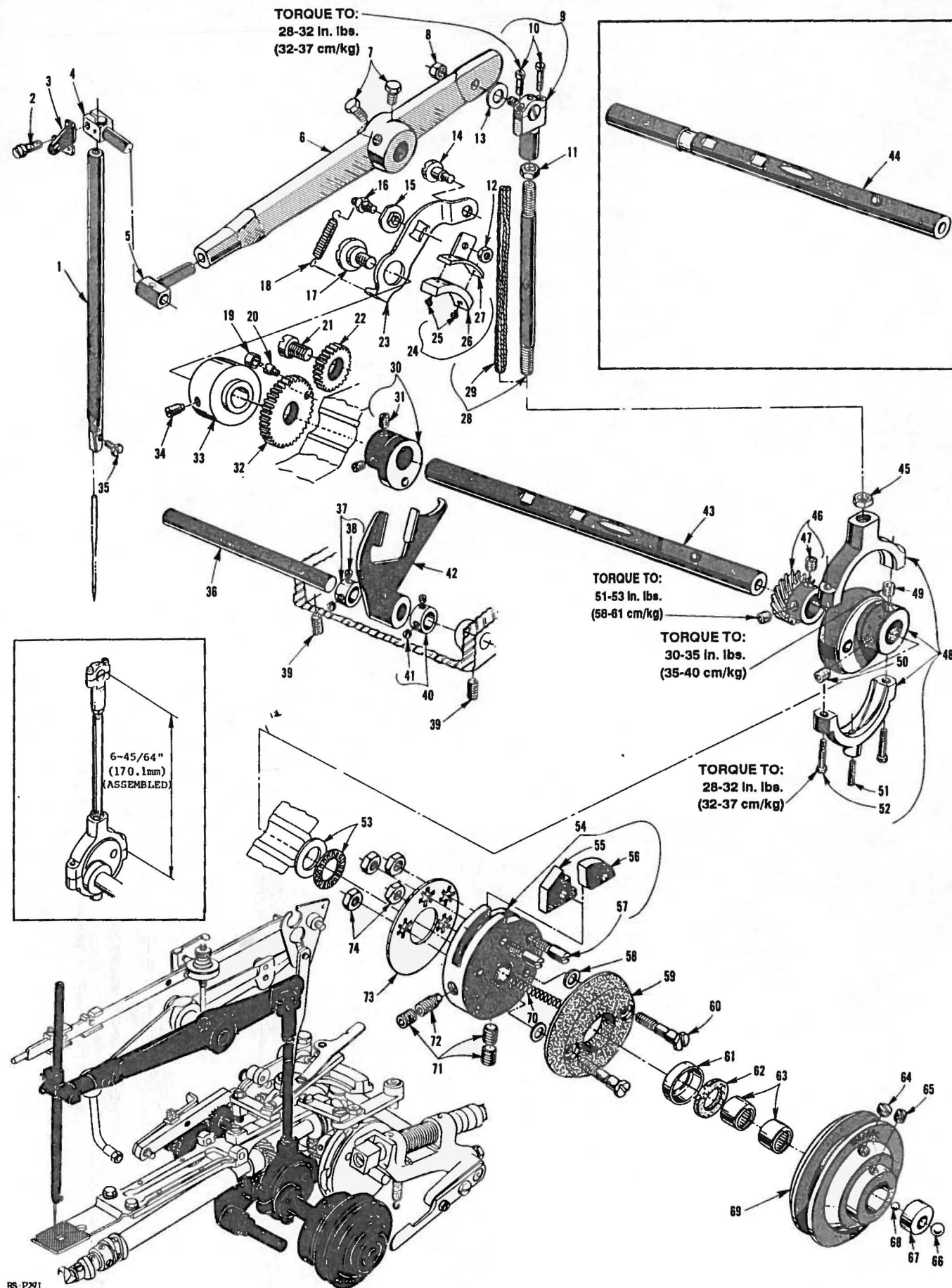
STOP MOTION TRIP LEVER, BUSHINGS & COVERS

REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	18-1264	Arm Cover Screw	4
2	32-316	Arm Cover, left	1
3	75-267	Needle Bar Guard	1
4	16-415	Needle Bar Bushing, upper	1
5	16-418	Needle Lever Shaft Bushing	1
6	18-1187	Screw	1
7	32-317	Arm Cover, right	1
8	18-1260	Screw, for ref. no 9	2
9	21-503	Stop Motion and Pulley Cover Spring	2
10	18-1251	Stud for Side Cover, left and right	2
11	32-318	Side Cover, left	1
12	16-419	Needle Bar Bushing, lower	1
13	660-718	Spring Washer	2
14	18-1249	Shoulder Screw, for sewing guard	1
15	8-151	Sewing Guard	1
16	14-543	Hinge Shaft	2
17	18-1247	Screw, for ref. no. 18, 19, 20, 21, 22, 23	7
18	16-420	Looper Shaft Bushing, front	1
19	16-422	Pulley Shaft Bushing, left	1
20	16-416	Cam Shaft Bushing, left	1
21	16-421	Looper Shaft Bushing, rear	1
22	16-417	Cam Shaft Bushing, right	1
23	16-423	Pulley Shaft Bushing, right	1
24	32-319	Side Cover, right	1
25	144-37	Felt Pad	1
26	186-17	Button Tray	1
27	22-361	Rod, for button tray, can be placed on either side for right or left handed operator	1
28	18-1247	Screw	1
29	141-5	Machine Sub-Base	1
30	18-1248	Screw	2
31	18-1199	Screw	1
32	45-305	Stop Motion Trip Lever	1
33	18-1163	Screw	1
34	18-1227	Stop Screw	1
35	20-176	Nut	2
36	18-1232	Screw	2
37	50-351	Bracket	1
38	21-491	Spring	1



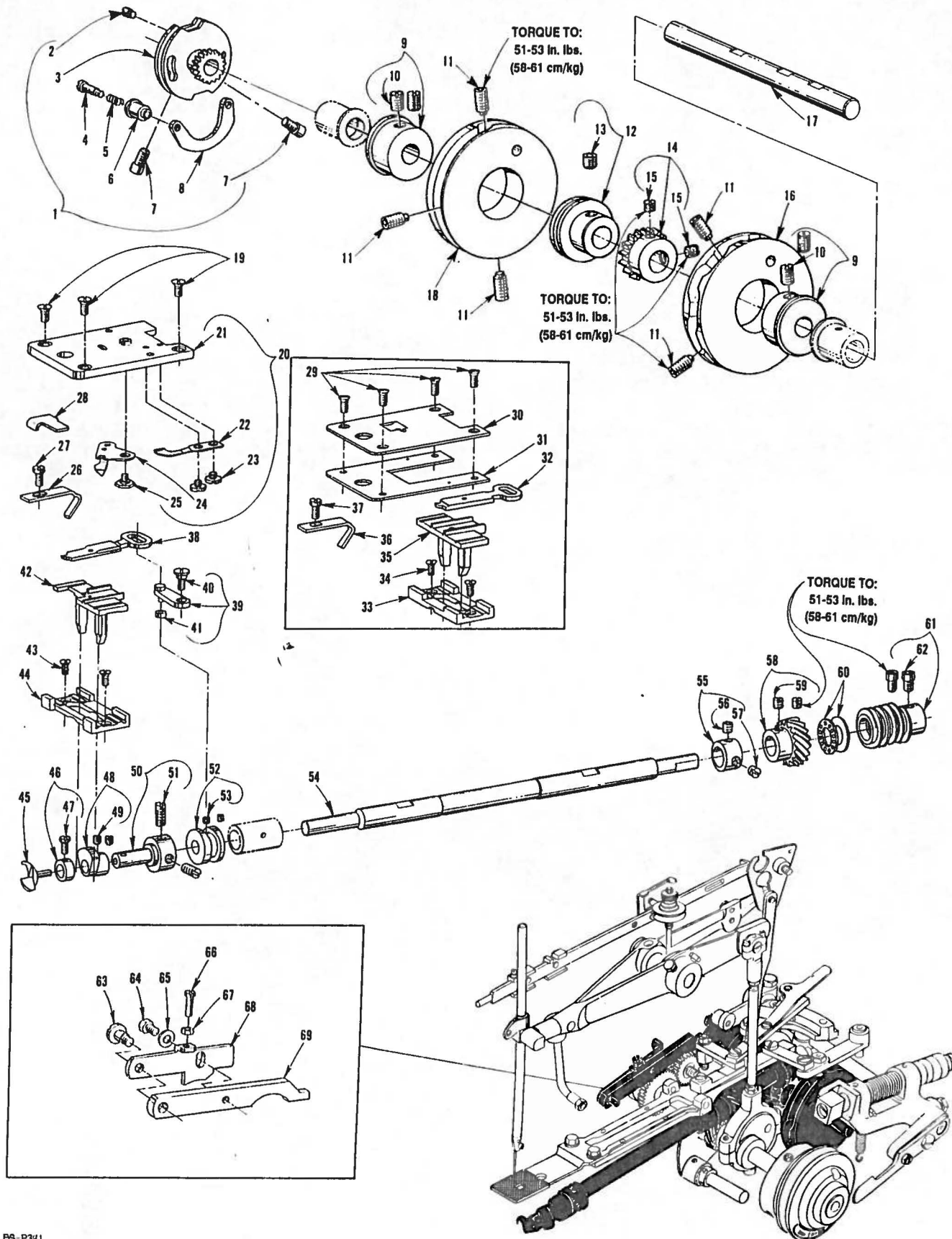
NEEDLE DRIVE, CLUTCH & STOP MOTION PARTS

REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	25-12	Needle Bar	1
2	18-1208	Screw, for needle bar bearing block clamp	1
3	41-66	Needle Bar Thread Guide	1
4	117-56	Needle Bar Bearing Block Clamp	1
5	117-54	Needle Bar Bearing Block	1
6	45-291	Needle Bar Lever	1
7	18-1233	Screw, for needle bar lever	2
8	20-189	Nut, for upper ball joint	1
9	4124-68	Ball Joint, upper, complete	1
10	18-1183	Screw, for upper ball joint	2
11	20-183	Nut, for connecting rod	1
12	20-172	Nut, for rotating stud	1
13	40-216	Washer	1
14	18-1159	Shoulder Screw	1
15	158-32	Friction Wheel Slide Block	1
16	17-185	Rotating Stud	1
17	18-1185	Shoulder Screw	1
18	21-492	Friction Plate Spring	1
19	35-40	Roller	1
20	18-1225	Screw, for spur gear	1
21	18-1226	Screw	1
22	27-5	Intermediate Spur Gear	1
23	45-307	Speed Slowing Lever	1
24	180-5	Friction Plate Holder Assembly	1
25	22-377	Friction Plate Pin	2
26	112-3	Speed Slowing Friction Plate	1
27	112-2	Friction Plate Holder	1
28	71-125	Connecting Rod	1
29	666-325-117/16	Oil Wick	1
30	33-170	Button Clamp Lifting Link Lever Driving	1
		Eccentric, complete	
31	18-1242	Screw	2
32	27-4	Spur Gear	1
33	112-1	Speed Slowing Friction Wheel	1
34	18-1197	Screw, for speed slowing friction wheel	2
35	18-1261	Screw, for needle bar	1
36	14-537	Lever Shaft	1
37	39-160	Collar	1
38	18-1201	Screw	2
39	18-1247	Screw	2
40	39-160	Collar	1
41	18-1201	Screw	2
42	45-308	Lever Engaging Button Clamp Lifting Link	1
43	14-544	Shaft, for Style 220-15	1
44	14-542	Shaft, for Style 220-1	1
45	20-185	Nut, for connecting rod	1
46	27-6	Driving Gear, for looper shaft	1
47	18-1242	Screw	2
48	4124-67	Ball Joint, eccentric, complete	1
49	18-1242	Screw	1
50	18-1241	Screw	1
51	666-102	Oil Wick	1
52	18-1182	Screw	2
53 thru 74		See Following Page	



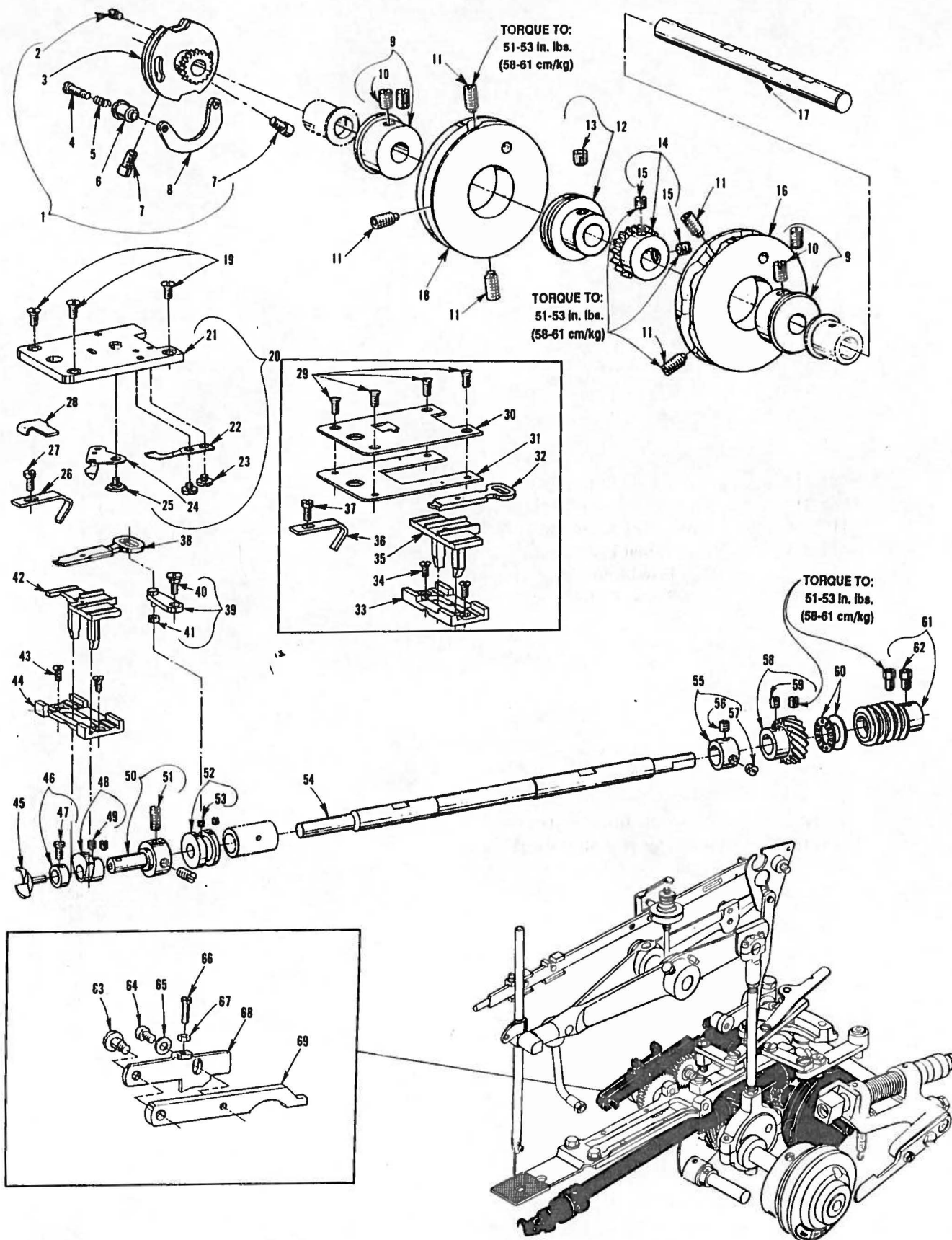
NEEDLE DRIVE, CLUTCH & STOP MOTION PARTS

REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
	1 thru 52	See Preceding Page	
53	478-29	Needle Thrust Bearing	1
54	44-339	Stop Motion Disc Assembly	1
55	166-15	Stop Motion Disc Pawl	1
56	51-1	Stop Motion Disc Latch	1
57	18-1184	Screw	2
58	40-232	Washer	2
59	44-338	Pulley Clutch Disc	1
60	18-1214	Screw	2
61	40-218	Retaining Washer	1
62	63-44	Grease Retaining Wick	1
63	478-30	Needle Bearing	2
64	18-1199	Screw, for pulley	1
65	18-1200	Screw, for pulley	1
66	79-45	Ball	1
67	190-7	Pulley Insert	1
68	79-44	Spring Ball	1
69	58-40	Pulley	1
70	21-486	Spring	1
71	18-1239	Screw	3
72	18-1238	Screw	1
73	40-229	Washer	1
74	20-178	Nut	4



KNIFE COMPONENTS, CAMS & LOOPER DRIVE PARTS

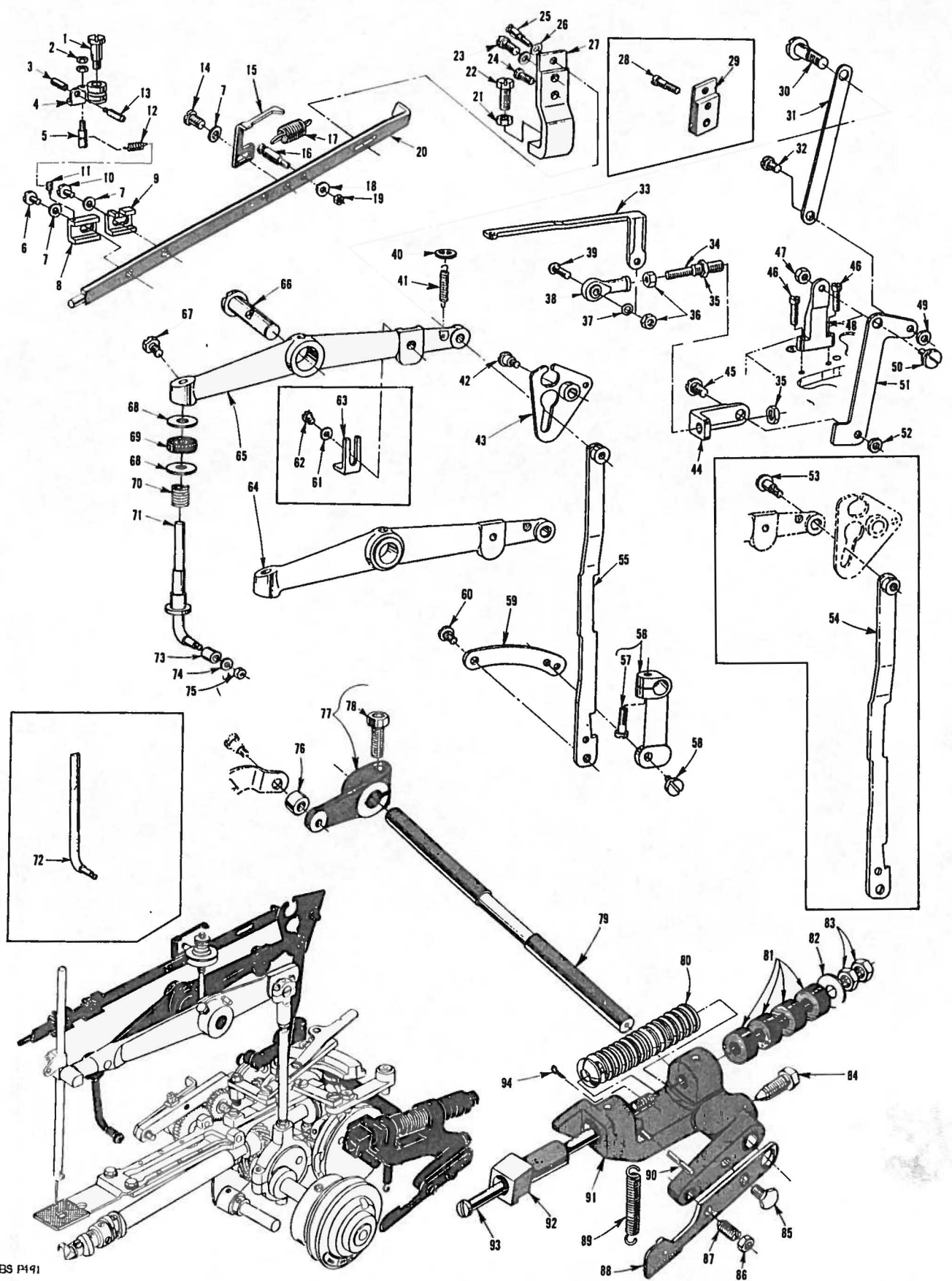
REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	434-106	Stop Motion Cam and Gear	1
2	18-1271	Screw	1
3	34-116	Stitch Adjusting Cam Assembly	1
4	18-1174	Shoulder Screw	1
5	21-509	Spring	1
6	142-7	Cam Knob	1
7	18-1274	Screw	2
8	180-6	Cam Shoe	1
9	184-19	Feed Cam Boss Assembly	2
10	18-1273	Screw	4
11	18-1240	Screw	5
12	39-158	Collar	1
13	18-1242	Screw	1
14	27-8	Camshaft Driven Gear	1
15	18-1242	Screw	2
16	34-112	Cam, right side, Style 220-1	1
-	34-115	Cam, right side, Style 220-15	1
17	14-545	Camshaft	1
18	34-111	Cam, left side, Style 220-1	1
-	34-114	Cam, left side, Style 220-15	1
19	18-1196	Screw, for throat plate, Style 220-15	3
20	110-466	Throat Plate Assembly, Style 220-15	1
21	110-468	Throat Plate	1
22	119-91	Fixed Knife	1
23	18-1212	Screw, for fixed knife	2
24	4119-87	Moving Knife Assembly	1
25	18-1166	Shoulder Screw, for moving knife assembly	1
26	8-99	Needle Guard, Style 220-15	1
27	18-1258	Screw, for needle guide	1
28	7-17	Moving Knife Positioning Gauge	1
29	18-1196	Screw, for throat plate, Style 220-1	4
30	110-462	Throat Plate, Style 220-1	1
31	110-463	Spacer Plate, Style 220-1	1
32	122-64	Positioning Finger, Style 220-1	1
33	190-8	Yoke Slide Insert, Style 220-1	1
34	18-1186	Screw, for yoke slide insert	2
35	49-47	Positioning Finger Yoke Slide, Style 220-1	1
36	8-101	Needle Guard, Style 220-1	1
37	18-1258	Screw, for needle guide	1
38	122-65	Positioning Finger, Style 220-15	1
39	445-509	Loop Positioning Finger Lever Assembly	1
40	18-1169	Shoulder Screw	1
41	35-38	Lever Roll	1
42	49-46	Positioning Finger Yoke Slide, Style 220-15	1
43	18-1186	Screw, for yoke slide insert	2
44	190-6	Yoke Slide Insert, Style 220-15	1
45 thru 69		See Following Page	



KNIFE COMPONENTS, CAMS & LOOPER DRIVE PARTS

REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
	1 thru 44	See Preceeding Page	
45	36-24	Looper	1
46	39-161	Collar	1
47	18-1209	Looper Clamping Screw	1
48	434-105	Looper Positioning Finger Cam, complete	1
49	18-1201	Screw	2
50	70-80	Cam and Looper Sleeve	1
51	18-1198	Screw	2
52	34-113	Looper Positioning Finger Cam	1
53	18-1202	Screw	2
54	14-541	Looper Shaft	1
55	39-159	Collar, for looper shaft	1
56	18-1255	Screw	1
57	18-1237	Screw	1
58	27-9	Looper Shaft Driven Gear	1
59	18-1242	Screw	2
60	478-28	Needle Thrust Bearing	1
61	27-7	Driving Gear, for camshaft	1
62	18-1213	Screw	2
63	18-1173	Shoulder Screw	1
64	18-1254	Screw	1
65	40-221	Washer	1
66	18-1220	Screw	1
67	20-170	Nut	1
68	51-2	Latch	1
69	45-306	Lever	1

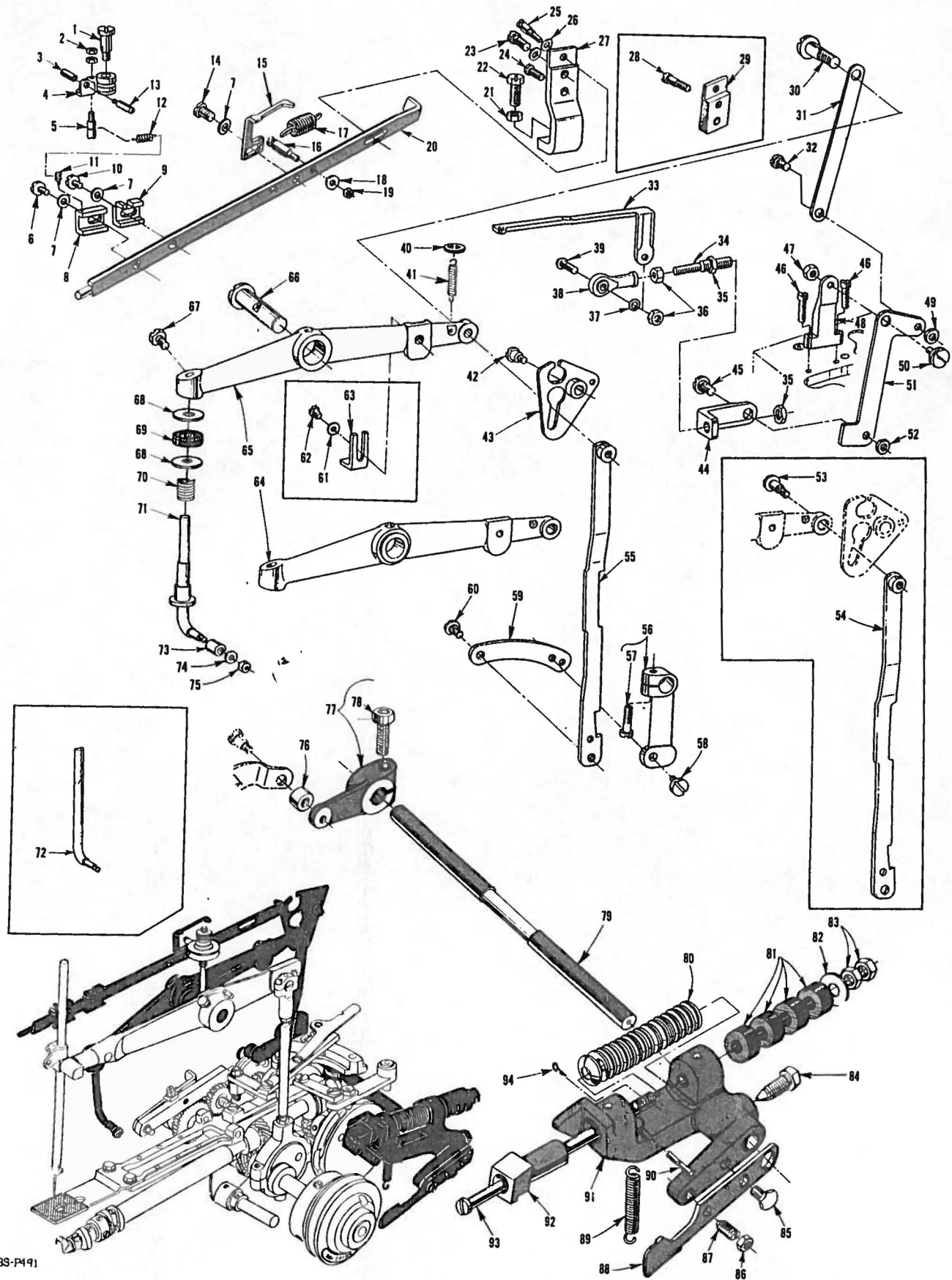
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BS P491

STOP MOTION, BUTTON CLAMP LIFTER, KNIFE DRIVE & NIPPER PARTS

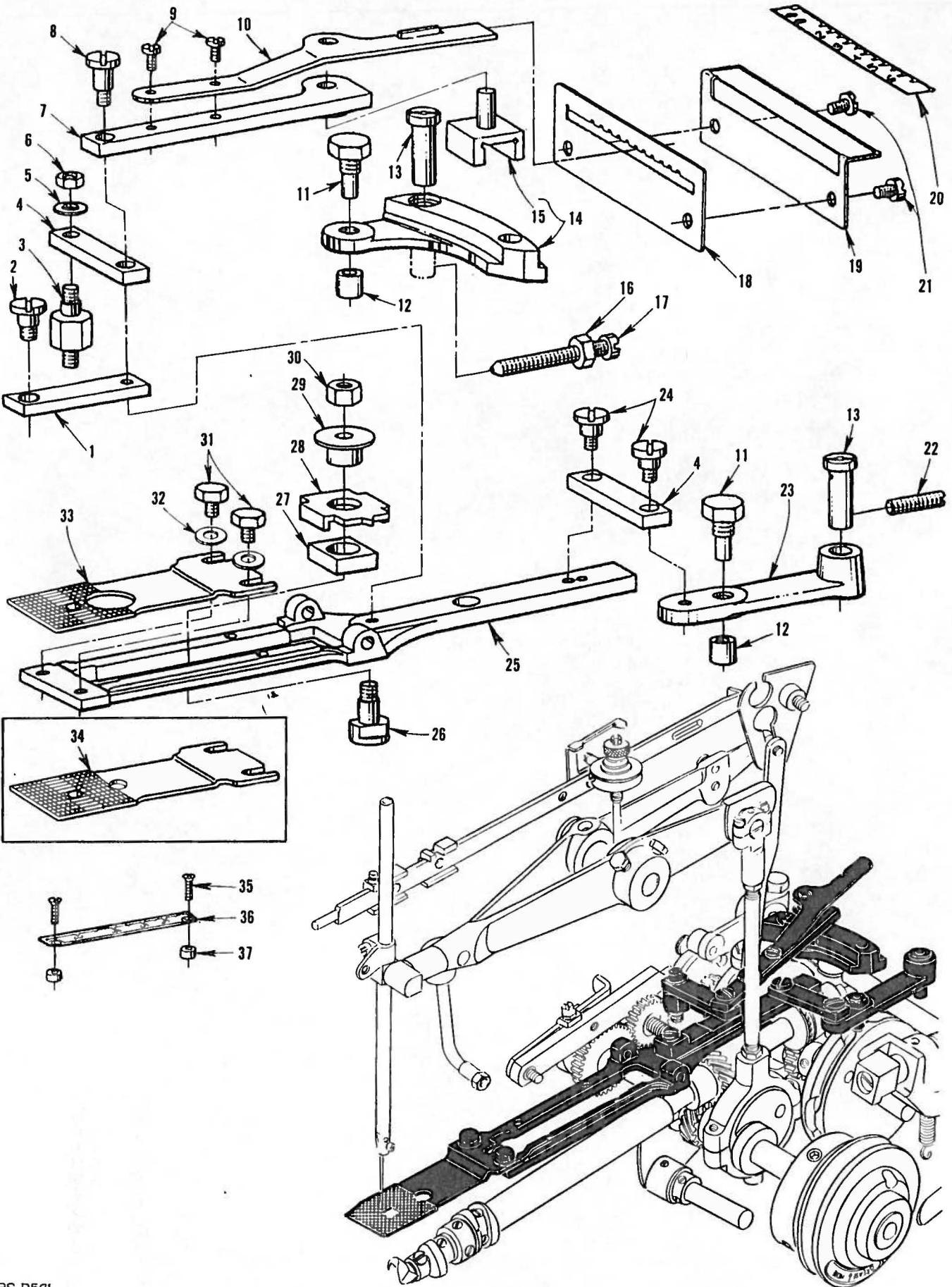
REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	18-1158	Shoulder Screw	1
2	20-170	Nut	2
3	20-162	Nut	1
4	4187-4	Thread Nipper Assembly	1
5	17-187	Stud	1
6	18-1218	Screw, for front nipper bar block	1
7	40-225	Washer	3
8	115-192	Nipper Bar Block, front	1
9	115-193	Nipper Bar Block, rear	1
10	18-1219	Screw, for rear nipper bar block	1
11	22-374	Nipper Bar Block Spring Pin	1
12	21-481	Nipper Bar Block Spring	1
13	22-366	Pin	1
14	18-1219	Screw	1
15	45-293	Thread Tension Release Lever	1
16	18-1180	Spring Screw	1
17	21-499	Nipper Bar Spring	1
18	40-236	Washer	1
19	20-171	Nut, for spring screw	1
20	138-26	Nipper Bar	1
21	20-176	Nut	1
22	18-1235	Screw, for nipper bar bearing block	1
23	18-1216	Screw, Style 220-15	1
24	18-1217	Screw	1
25	18-1181	Screw	1
26	40-233	Washer	2
27	115-191	Nipper Bar Bearing Block, Style 220-15	1
28	18-1216	Screw, Style 220-1	1
29	115-74	Nipper Bar Bearing Block, Style 220-1	1
30	18-1177	Shoulder Screw, Style 220-15	1
31	46-217	Link	1
32	18-1170	Shoulder Screw	1
33	46-211	Connecting Link, front, Style 220-15	1
34	18-1194	Connecting Screw, Style 220-15	1
35	20-187	Nut	2
36	20-169	Nut	2
37	40-225	Washer	1
38	124-67	Joint	1
39	18-1252	Joint Stud	1
40	40-213	Washer	1
41	21-505	Spring	1
42	18-1157	Shoulder Screw	1
43	45-292	Nipper Bar Actuating Lever	1
44	46-210	Connecting Link, rear, Style 220-15	1
45	18-1161	Shoulder Screw	1
46	18-1206	Screw, for thread trimming lever base	2
47	20-174	Nut	1
48	45-297	Thread Trimming Lever Base, Style 220-15	1
49 thru 94		See Following Page	



BS-P491

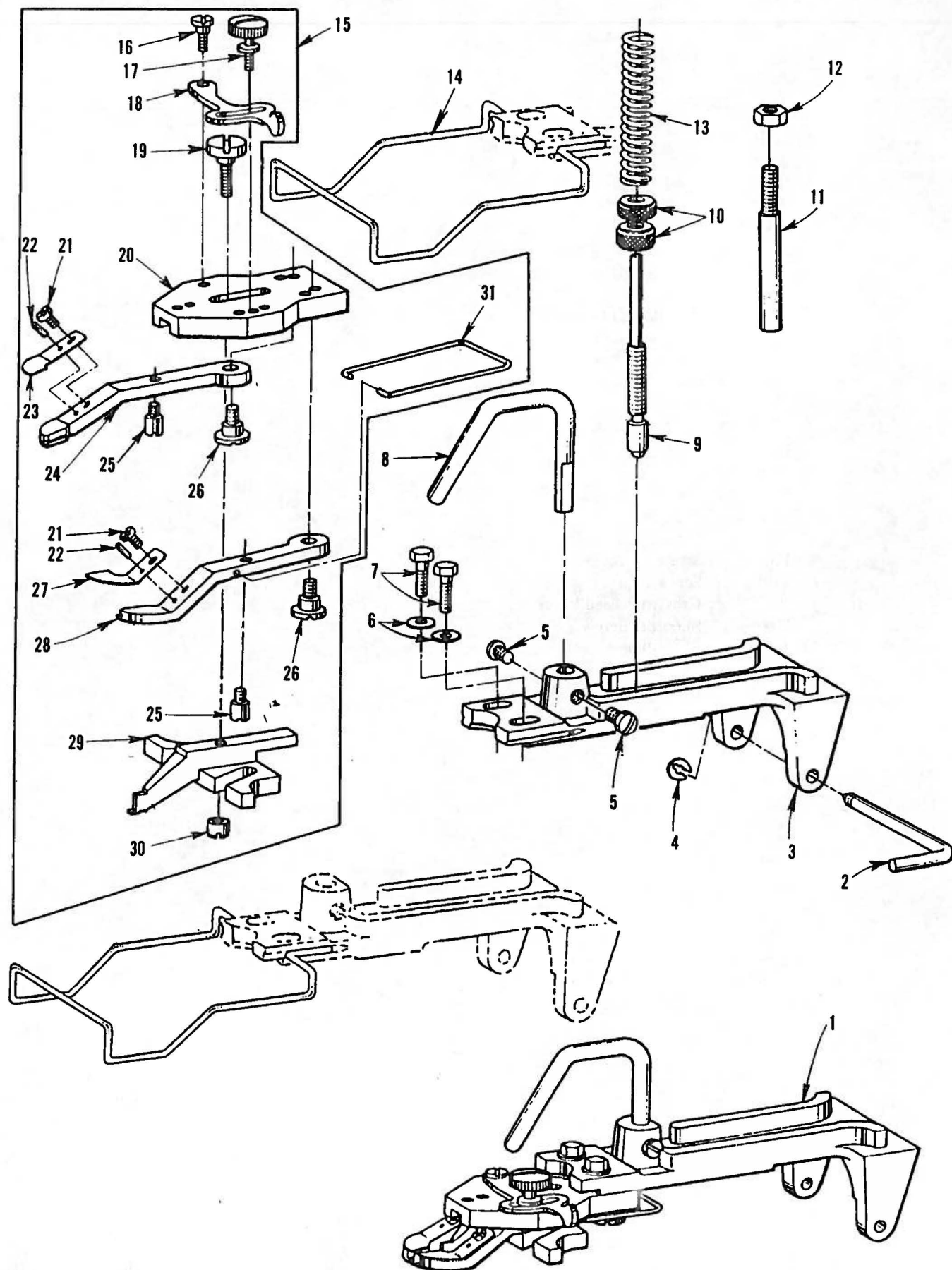
STOP MOTION, BUTTON CLAMP LIFTER, KNIFE DRIVE & NIPPER PARTS

REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
	1 thru 48	See Preceding Page	
49	20-181	Nut	1
50	18-1250	Shoulder Screw	1
51	45-295	Thread Trimmer Lever, Style 220-15	1
52	20-176	Nut	1
53	18-1175	Shoulder Screw	1
54	46-219	Button Clamp Lifting Link, Style 220-1	1
55	46-216	Button Clamp Lifting Link, Style 220-15	1
56	45-309	Lever, complete, engaging button clamp lifting link	1
57	18-1216	Clamp Screw	1
58	18-1267	Shoulder Screw	1
59	46-215	Link	1
60	18-1168	Shoulder Screw	1
61	40-237	Washer	1
62	18-1256	Screw	1
63	42-36	Lifting Lever Stopper Plate	1
64	45-512	Button Clamp Lifting Lever, Style 220-1	1
65	45-310	Button Clamp Lifting Lever, Style 220-15	1
66	14-540	Button Clamp Lifting Lever Shaft	1
67	18-1253	Screw	1
68	40-231	Washer, Style 220-15	2
69	144-38	Cushion, Style 220-15	1
70	21-498	Spring, Style 220-15	1
71	71-128	Button Clamp Lifting Rod, Style 220-15	1
72	71-130	Button Clamp Lifting Rod, Style 220-1	1
73	71-129	Button Clamp Lifting Rod Roller	1
74	40-235	Washer	1
75	20-190	Nut	1
76	35-37	Stitch Adjusting Cam Roller	1
77	445-510	Lever Assembly	1
78	18-1231	Screw	1
79	14-538	Lever Shaft	1
80	21-497	Disc Spring	30
81	40-228	Rubber Cushion	4
82	40-212	Washer	1
83	20-183	Nut	2
84	18-1228	Set Screw	1
85	18-1234	Screw	1
86	20-176	Nut	1
87	18-1245	Spot Screw	1
88	45-304	Pressure Applying Lever	1
89	21-490	Stop Motion Lever Restoring Spring	1
90	22-371	Stop Motion Lever Restoring Spring Pin	1
91	45-303	Stop Motion Plunger Lever	1
92	26-186	Stop Motion Plunger	1
93	71-127	Stop Motion Plunger	1
94	108-10	Cotter Pin	1



FEED PLATE & BUTTON POSITIONING PARTS

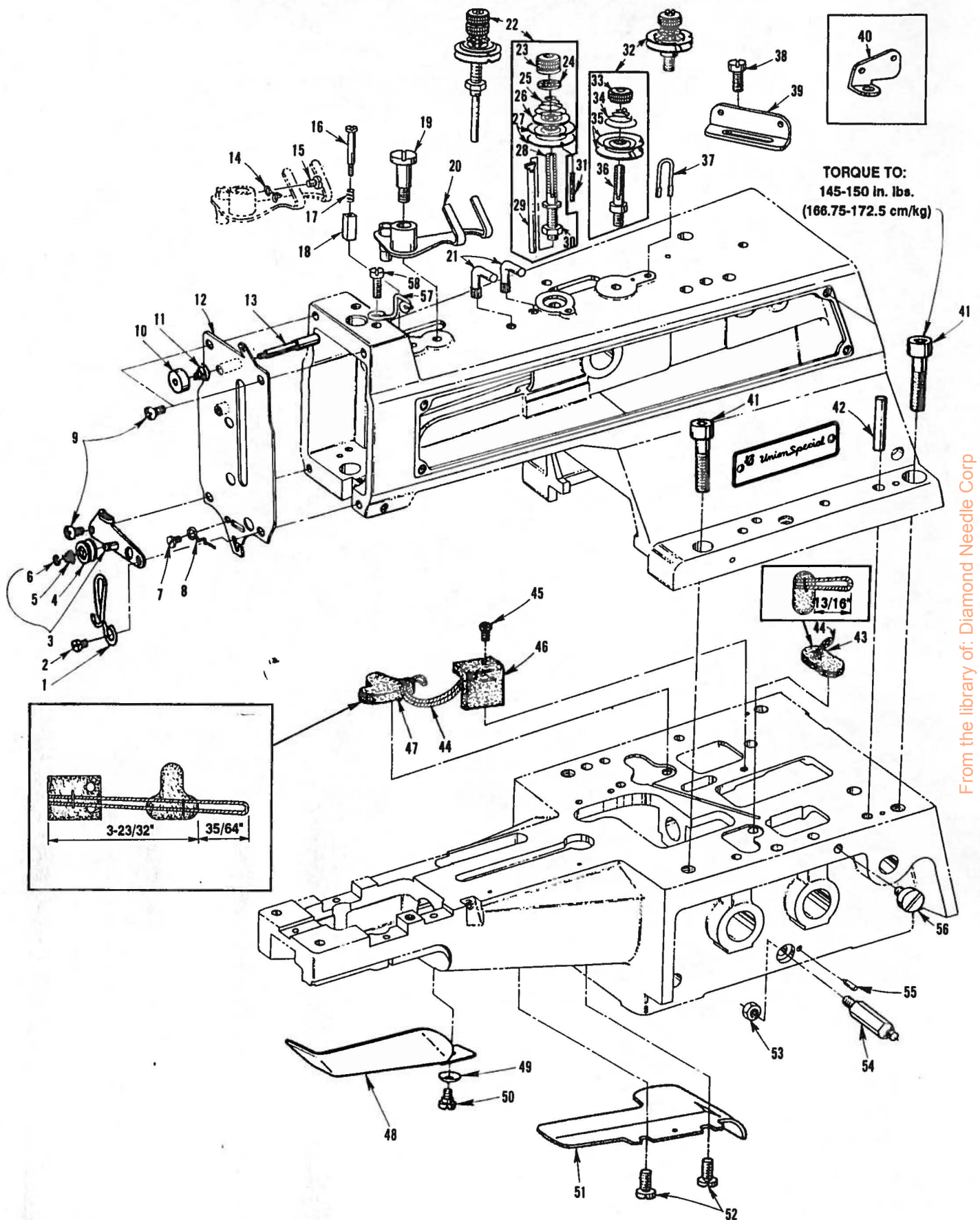
REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	46-218	Slide Plate Connecting Link	1
2	18-1173	Shoulder Screw	1
3	17-186	Stud	1
4	46-213	Connecting Link	2
5	40-221	Washer	1
6	20-173	Nut	1
7	46-212	Lever Base	1
8	18-1173	Shoulder Screw	1
9	18-1224	Screw	2
10	21-482	Handle and Indicator Spring	1
11	18-1193	Stud, for feed cam roller	2
12	35-39	Feed Cam Roller	2
13	22-373	Pin	2
14	45-299	Lengthwise Feed Lever Assembly	1
15	69-28	Slide Block	1
16	20-179	Nut	1
17	18-1191	Screw	1
18	110-470	Underplate	1
19	110-469	Base Plate	1
20	110-471	Lengthwise Feed Graduated Plate	1
21	18-1263	Screw	2
22	18-1246	Screw	1
23	45-298	Crosswise Feed Lever	1
24	18-1266	Shoulder Screw	2
25	158-33	Slide Plate	1
26	18-1192	Shoulder Screw	1
27	69-27	Indicator Pin Bearing Block	1
28	155-22	Crosswise Feed Indicator	1
29	157-28	Spacer	1
30	20-180	Nut	1
31	18-1236	Screw	2
32	40-221	Washer	2
33	24-346	Feed Plate, Style 220-15	1
34	24-347	Feed Plate, Style 220-1	1
35	18-1262	Screw	2
36	110-464	Crosswise Feed Graduated Plate	1
37	115-190	Crosswise Feed Graduated Plate Block	2



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BUTTON CLAMP COMPONENTS

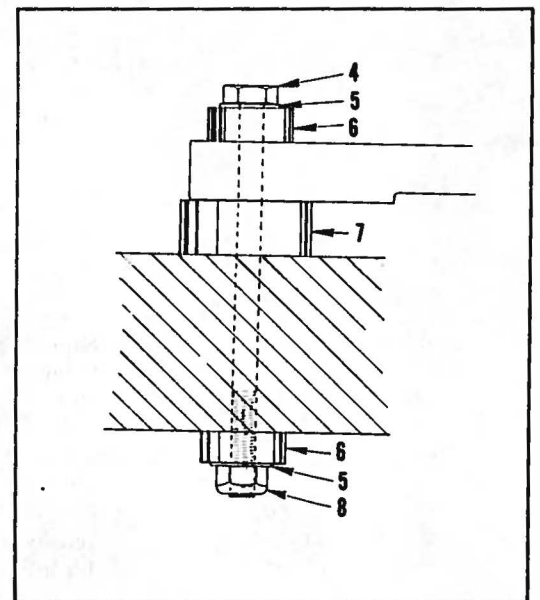
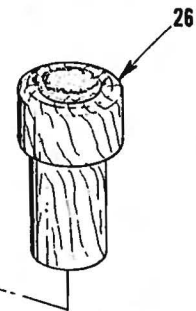
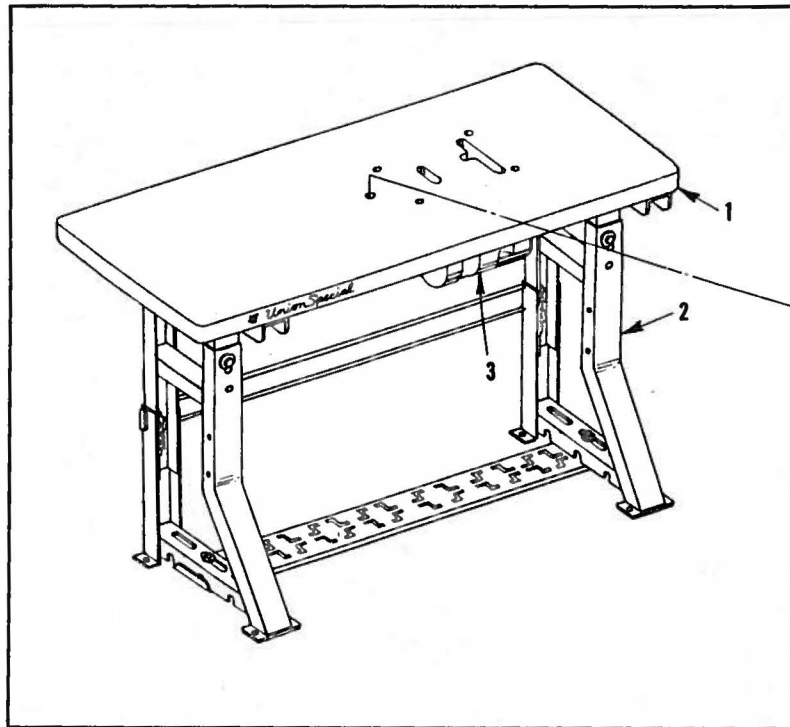
REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	430-99	Button Clamp, complete	1
2	22-369	Hinge Pin	1
3	99-373	Button Clamp Holder	1
4	21-483	"E" Ring	1
5	18-1204	Screw	2
6	40-221	Washer	2
7	18-1230	Screw	2
8	71-126	Button Clamp Lifting Rod	1
9	18-1190	Pressure Adjusting Bar	1
10	20-188	Nut	2
11	22-375	Button Clamp Stopper Pin	1
12	20-180	Nut	1
13	21-484	Spring	1
14	8-100	Sewing Guard	1
15	430-98	Button Clamp Jaw Assembly	1
16	18-1164	Shoulder Screw	1
17	18-1189	Clamp Screw	1
18	45-300	Stop Lever	1
19	18-1165	Shoulder Screw	1
20	99-372	Button Clamp Lever Jaw Holder	1
21	18-1270	Screw	2
22	22-370	Guide Pin	2
23	21-507	Spring, left	1
24	45-311	Button Clamp Lever Jaw, left	1
25	18-1229	Screw	2
26	18-1171	Shoulder Screw	2
27	21-488	Spring, right	1
28	45-301	Button Clamp Lever Jaw, right	1
29	158-31	Slide Guide	1
30	20-165	Nut	1
31	21-489	Button Clamp Spring	1



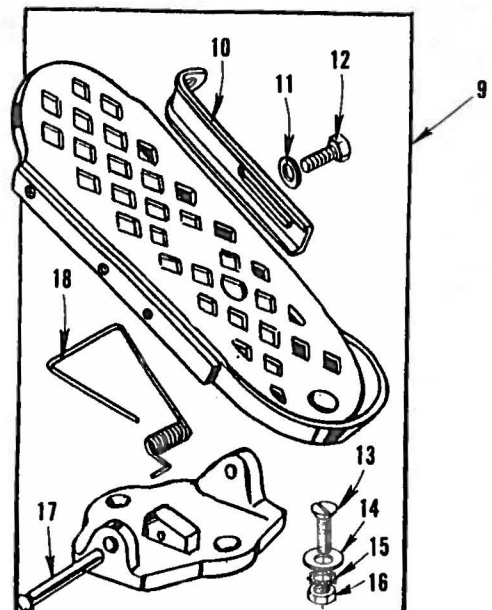
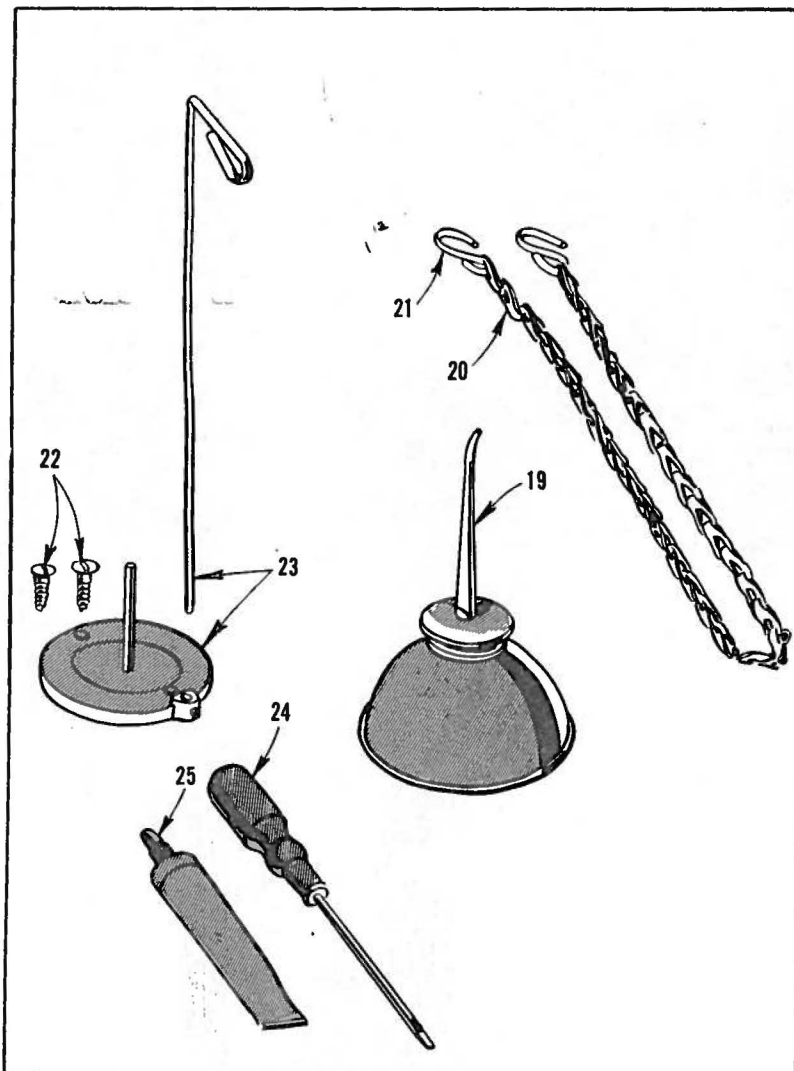
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MISCELLANEOUS COVERS & THREAD TENSION COMPONENTS

REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	41-63	Thread Guide	1
2	18-1222	Screw	1
3	99-371	Needle Thread Nipper Holder Assembly	1
4	44-340	Tension Disc	2
5	21-494	Spring	1
6	21-508	"E" Ring	1
7	18-1259	Screw	1
8	41-68	Thread Guide	1
9	18-1264	Screw, for machine arm front cover	3
10	20-167	Knurled Thumb Nut	1
11	21-494	Spring, for nipper releasing plunger	1
12	32-315	Machine Arm Front Cover	1
13	26-188	Nipper Releasing Plunger	1
14	41-61	Thread Guide	1
15	18-1210	Screw, for thread guide	1
16	18-1268	Shoulder Screw, for nipper block	1
17	21-480	Nipper Block Spring	1
18	115-194	Nipper Block	1
19	18-1160	Shoulder Screw, for thread pull-off lever	1
20	45-294	Thread Pull-off Lever	1
21	41-69	Thread Guide	2
22	468-28	Thread Nipper Staff, complete	1
23	20-188	Thread Tension Nut	1
24	149-34	Stopper	1
25	21-500	Tension Spring	1
26	40-214	Lifting Washer	1
27	44-337	Tension Disc	2
28	68-30	Nipper Staff	1
29	22-376	Release Pin	1
30	20-180	Nut	1
31	22-365	Tension Disc Pin	1
32	468-27	Thread Tension Staff, complete	1
33	20-188	Thread Tension Nut	1
34	21-502	Tension Spring	1
35	44-337	Tension Disc	2
36	68-31	Tension Staff	1
37	41-58	Thread Guide	1
38	18-1269	Screw, for thread guide	1
39	41-62	Thread Guide, Style 220-15	1
40	41-67	Thread Guide, Style 220-1	1
41	18-1265	Connecting Screw	4
42	22-363	Guide Pin	2
43	666-100	Felt, right	1
44	666-325-9/8	Oil Wick	1
-		2 ¹⁹ / ₃₂ ", for ref. no. 43	-
-		7 ⁹ / ₃₂ ", for ref. no. 46 and 47	-
45	18-1258	Screw, for left, rear felt	1
46	144-39	Felt, left, rear	1
47	666-110	Felt, left, front	1
48	32-320	Looper Cover	1
49	40-217	Washer	1
50	18-1167	Shoulder Screw	1
51	32-321	Bed Oil Shield, Style 220-15	1
52	18-1257	Screw, for bed oil shield	2
53	20-176	Nut, for spring pin	1
54	22-372	Spring Pin	1
55	22-367	Timing Pin	2
56	18-1215	Screw	1
57	41-60	Thread Guide	1
58	18-1203	Screw, for thread guide	1



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STANDARD ACCESSORIES

REF. NO.	PART NO.	DESCRIPTION	AMT. REQ.
1	21374 CC48	Table Board	1
2	21374 BF	Table Legs	1 set
3	28741 AK	Motor, 110V-115V 60 cycle, 1 phase	1
		1725 r.p.m., ½ HP, continuously running motor with fused switch box	
-	28471 AJ	Motor, 220V, 50-60 cycle, 3 phase	1
		1725 r.p.m., ½ HP, continuously running motor with fused switch box	
-	21281 M310	Belt	1
-	28602 AS19	Pulley, 1500 r.p.m.	1
4	22640 H-224	Bolt	4
5	40-181	Washer	8
6	40-198	Isolator Washer	8
7	661-32	Isolator	4
8	660-415	ESNA Stop Nuts	4
9	4135-9	Foot Treadle, complete	1
10	45-424	Lever	1
11	40-181	Washer	1
12	18-1033	Screw	1
13	22637 H48	Screw	2
14	652-16	Washer	2
15	652 B-16	Lock Washer	2
16	RM2791-3	Nut	2
17	43-27	Rivet	1
18	21-408	Spring	1
19	413 D	Oil Can	1
20	421 D-34	Chain	1
21	660-264	"S" Hook	2
22	SC299	Wood Screw	2
23	403-11	Thread Stand	1
24	21201	Screwdriver, ¼" blade, 7" overall	1
25	28604 P	Grease Tube	1
26	22-362	Machine Standoff	1

NUMERICAL INDEX OF PARTS

Part No.	Page No.	Part No.	Page No.	Part No.	Page No.
108-10	21	18-1158	19	18-1224	23
110-462	15	18-1159	11	18-1225	11
110-463	15	18-1160	27	18-1226	11
110-464	23	18-1161	19	18-1227	9
110-468	15	18-1163	9	18-1228	21
110-469	23	18-1164	25	18-1229	25
110-470	23	18-1165	25	18-1230	25
110-471	23	18-1166	15	18-1231	21
112-1	11	18-1167	27	18-1232	9
112-2	11	18-1168	21	18-1233	11
112-3	11	18-1169	15	18-1234	21
115-190	23	18-1170	19	18-1235	19
115-191	19	18-1171	25	18-1236	23
115-192	19	18-1173	17	18-1237	17
115-193	19	18-1173	23	18-1238	13
115-194	27	18-1174	15	18-1239	13
115-74	19	18-1175	21	18-1240	15
115-74	16	18-1177	19	18-1241	11
117-54	11	18-1180	19	18-1242	11
119-91	15	18-1181	19	18-1242	15
122-64	15	18-1182	11	18-1242	21
122-65	15	18-1183	11	18-1245	21
124-67	19	18-1184	13	18-1246	23
138-26	19	18-1185	11	18-1247	9
14-537	11	18-1186	15	18-1247	11
14-538	21	18-1187	9	18-1248	9
14-540	21	18-1189	25	18-1249	9
14-541	17	18-1190	25	18-1250	21
14-542	11	18-1191	23	18-1251	9
14-543	9	18-1192	23	18-1252	19
14-544	11	18-1193	23	18-1253	21
14-545	15	18-1194	19	18-1254	17
141-5	9	18-1196	15	18-1255	17
142-7	15	18-1197	11	18-1256	21
144-37	9	18-1198	17	18-1257	27
144-38	21	18-1199	9	18-1258	15
144-39	27	18-1199	13	18-1259	27
149-34	27	18-1200	13	18-1260	9
155-22	23	18-1201	11	18-1261	11
157-28	23	18-1201	17	18-1262	23
158-31	25	18-1202	17	18-1263	23
158-32	11	18-1203	27	18-1264	9
158-33	23	18-1204	25	18-1264	27
16-415	9	18-1206	19	18-1265	27
16-416	9	18-1208	11	18-1266	23
16-417	9	18-1209	17	18-1267	21
16-418	9	18-1210	27	18-1268	27
16-419	9	18-1212	15	18-1269	27
16-420	9	18-1213	17	18-1270	25
16-421	9	18-1214	13	18-1271	15
16-422	9	18-1215	27	18-1273	15
16-423	9	18-1216	19	18-1274	15
166-15	13	18-1216	21	180-5	11
17-185	11	18-1217	19	180-6	15
17-186	23	18-1218	19	184-19	15
17-187	19	18-1219	19	186-17	9
18-1033	29	18-1220	17	190-6	15
18-1157	19	18-1222	27	190-7	13

NUMERICAL INDEX OF PARTS

Part No.	Page No.	Part No.	Page No.	Part No.	Page No.
190-8	15	22-366	19	40-221	19
20-165	25	22-367	27	40-221	23
20-167	27	22-369	25	40-221	25
20-169	19	22-370	25	40-228	21
20-170	17	22-371	21	40-229	13
20-170	19	22-372	27	40-231	21
20-171	19	22-373	23	40-232	13
20-172	11	22-374	19	40-233	19
20-173	23	22-375	25	40-235	21
20-174	19	22-376	27	40-236	19
20-176	9	22-377	11	40-237	21
20-176	19	22637 H-48	29	403-11	29
20-176	21	22640 H-224	29	41-58	27
20-176	27	24-346	23	41-60	27
20-178	13	24-347	23	41-61	27
20-179	23	25-12	11	41-62	27
20-180	23	26-186	21	41-63	27
20-180	25	26-188	27	41-66	11
20-180	27	27-4	11	41-67	11
20-181	21	27-5	11	41-68	27
20-183	11	27-6	11	41-69	27
20-183	21	27-7	17	4119-87	15
20-185	11	27-8	15	4124-67	11
20-187	19	27-9	17	4124-68	11
20-188	25	28604 P	29	413 D	29
20-188	27	28741 AJ	29	4135-9	29
20-189	11	28741 AK	29	4187-4	19
20-190	21	32-315	27	42-36	21
21-408	29	32-316	9	421 D-34	29
21-480	27	32-317	9	43-27	29
21-481	19	32-318	9	430-98	25
21-482	23	32-319	9	430-99	25
21-483	25	32-320	27	434-105	17
21-484	25	32-321	27	434-106	15
21-486	13	33-170	11	44-337	27
21-488	25	34-111	15	44-338	13
21-489	25	34-112	15	44-339	13
21-490	21	34-113	17	44-340	27
21-491	9	34-114	15	445-509	15
21-492	11	34-115	15	445-510	21
21-494	27	34-116	15	45-291	11
21-497	21	35-37	21	45-292	19
21-498	21	35-38	15	45-293	19
21-499	19	35-39	23	45-294	27
21-500	27	35-40	11	45-297	19
21-502	27	36-24	17	45-298	23
21-503	9	39-158	15	45-299	23
21-505	19	39-159	17	45-300	25
21-507	25	39-160	11	45-301	25
21-508	27	40-181	29	45-303	21
21-509	15	40-198	29	45-304	21
21201	29	40-212	21	45-305	9
21374 BF	29	40-213	19	45-306	17
21374 CC-48	29	40-214	27	45-307	11
22-361	9	40-216	11	45-308	11
22-362	29	40-217	27	45-309	21
22-363	27	40-218	13	45-310	21
22-365	27	40-221	17	45-311	25

NUMERICAL INDEX OF PARTS

Part No.	Page No.	Part No.	Page No.
45-424	29	SC299	29
45-512	21		
46-210	19		
46-211	19		
46-212	23		
46-213	23		
46-215	21		
46-216	21		
46-217	19		
46-217	21		
46-218	23		
46-219	21		
468-27	27		
468-28	27		
478-28	17		
478-29	13		
478-30	13		
49-46	15		
49-47	15		
50-351	9		
51-1	13		
51-2	17		
58-40	13		
63-44	13		
652-16	29		
652B-16	29		
660-264	29		
660-415	29		
660-718	9		
661-32	29		
666-100	27		
666-102	11		
666-110	27		
666-325-11 ⁷ / ₁₆	11		
666-325-9 ⁷ / ₁₆	27		
68-30	27		
68-31	27		
69-27	23		
69-28	23		
7-17	15		
70-80	17		
71-125	11		
71-126	25		
71-127	21		
71-128	21		
71-129	21		
71-130	21		
75-267	9		
79-44	13		
79-45	13		
8-100	25		
8-101	15		
8-151	9		
8-99	15		
99-371	27		
99-372	25		
99-373	25		
RM2791-3	29		