



*Union Special*  
INDUSTRIAL SEWING EQUIPMENT

**STYLES      ADJUSTING INSTRUCTIONS AND  
ILLUSTRATED PARTS LIST**

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**51500**

**PARTS LIST FOR 51500BT**

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**CATALOG  
NO. T107M**

**FIRST  
EDITION**



**FIRST EDITION**  
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**PRINTED 1996 IN USA**

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## IDENTIFICATION OF MACHINE

Each UNION SPECIAL machine is identified by a Style number which is stamped into 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 51500 BT". 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: "Style 51500 BTZ".

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: "51500".

## APPLICATION OF CATALOG

This catalog applies specifically to the Standard Style of machine as listed herein. It can also be applied with discretion to some Special Styles of machines in this class. Reference to direction, such as right, left, front, back, etc., are given from the operator's position while seated at the machine. Operating direction of handwheel is toward the operator.

## STYLE OF MACHINE

Streamlined Flat Bed, High Throw, Top Feed Machine With Spring Pressed Throw-out Knife, With Front Disposal of Trimmings, Two Needles, Left Needle in Front, Independent Row, Two Loopers, Light Weight Presser Bar and Needle Bar, Needle Bearing Driving Mechanism, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump With Base Plate, Oil Siphon Assembly, Lateral Looper Travel, 3/16 Inch Spacing Between Needles in Line With Feed.

51500 BT For seaming and binding women's quilted robes, housecoats, jackets, sack and sport coats and similar garments. Seam specification 401-BSe-2. Standard gauge No. 10 and standard width of binding 1 1/4 inches.

## NEEDLES

Each UNION SPECIAL needle has both a type number 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 blade measured in thousandths of an inch, midway between the shank and the eye. Collectively, the type number and the size number is the complete symbol.

Standard needle for Style 51500 BT is Type 128 GAS. It has a round shank, round point, short, double groove, struck groove, ball eye, is spotted and chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060, 170/067.

To have needle orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. Use description on label. A complete order would read: "1000 Needles, Type 128 GAS, Size 090/036".

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

For best results, use only genuine UNION SPECIAL needles in the operation of these machines. They are packaged under our brand name, *Union Special*®, which is backed by a reputation for producing highest quality needles for more than three-quarters of a century.

## 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.

Part numbers represent the same part, regardless of catalog in which they appear.

**IMPORTANT! ON ALL ORDERS, PLEASE INCLUDE PART NAME AND STYLE OF MACHINE FOR WHICH PART IS ORDERED.**

## TERMS

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

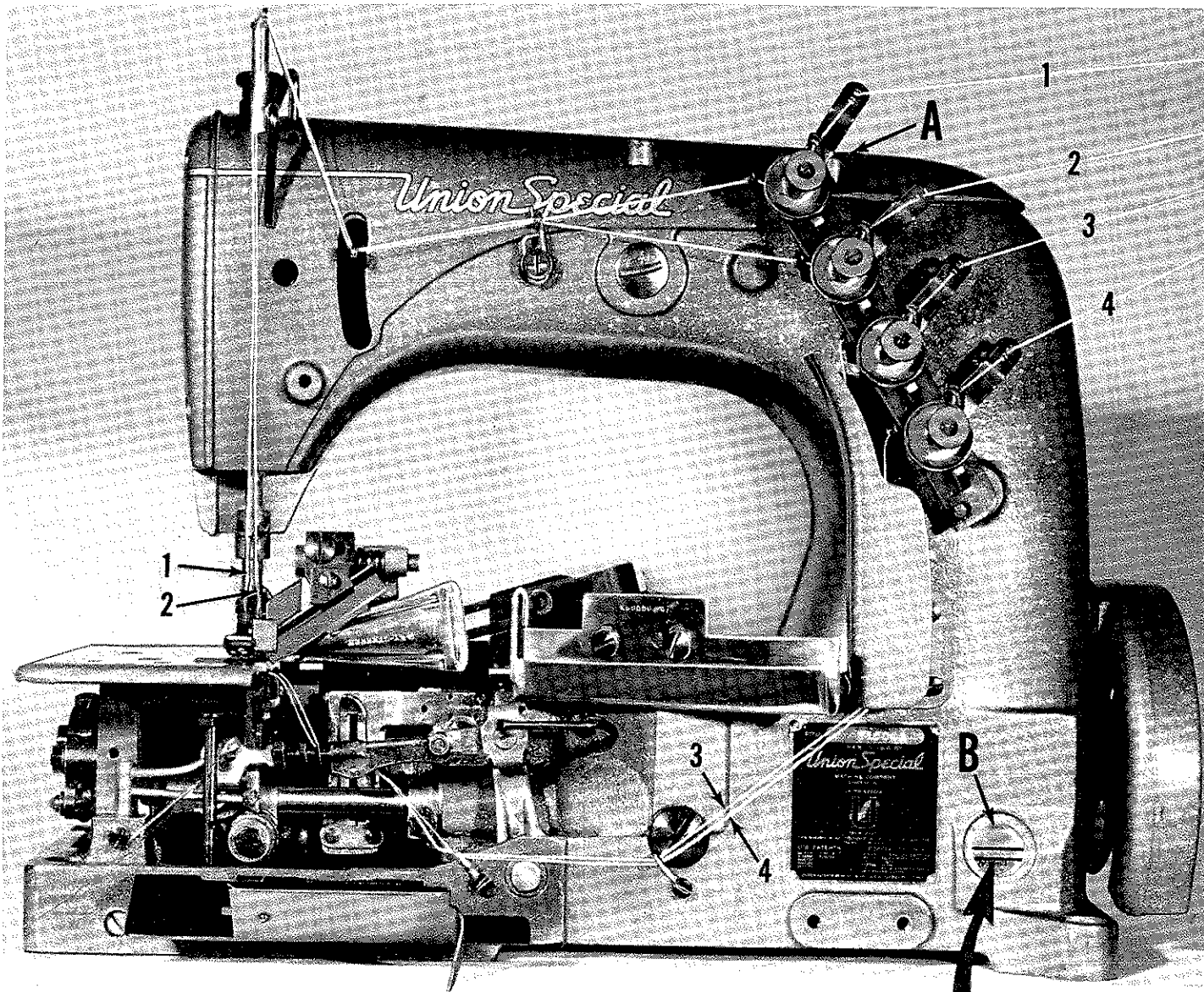
## OILING

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.

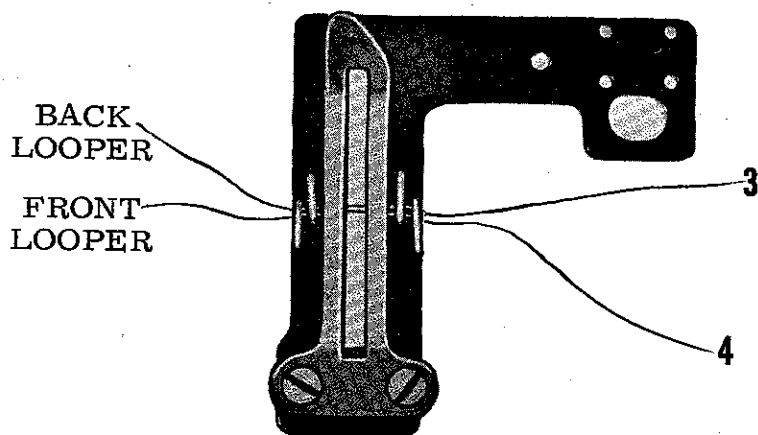
Oil is filled at the spring cap in the top cover and the level is checked at the sight gauge on the front of the machine. The oil level should be maintained between the red lines on the gauge. The capacity of the oil reservoir is 12 ounces.

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



From the library of: Diamond Needle Corp



KEEP OIL  
LEVEL  
BETWEEN  
LINES

CAUTION!  
FILL OIL RESERVOIR  
BEFORE STARTING  
MACHINE HAS BEEN DRAINED  
BEFORE SHIPPING

THREADING AND OILING DIAGRAM FOR STYLE 51500 BT

Thread as indicated. The looper threading has been enlarged for clarity. Use a straight mineral oil of a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit. Fill oil cup "A" until oil level is visible between lines of gauge "B". Maintain oil level between the lines of gauge "B". Drain excess oil from the machine by removing the plug screw located directly beneath handwheel.

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

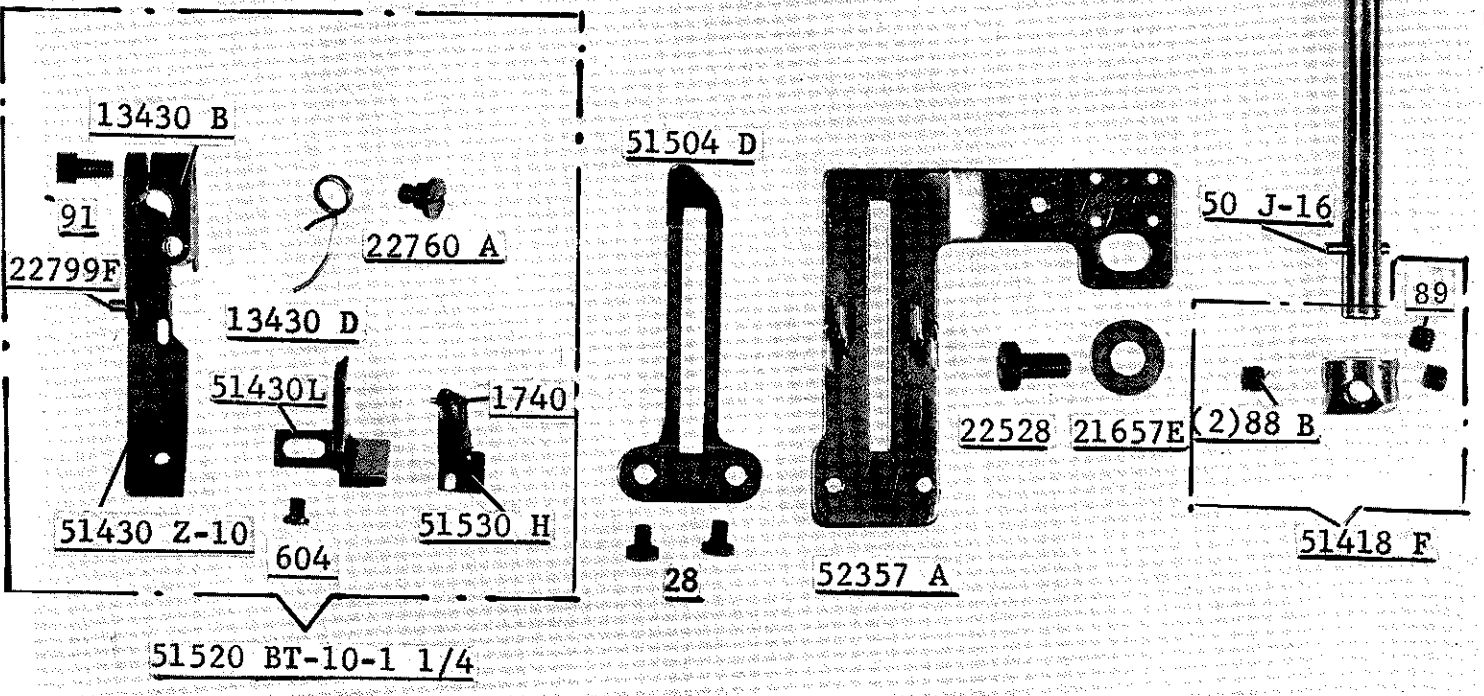
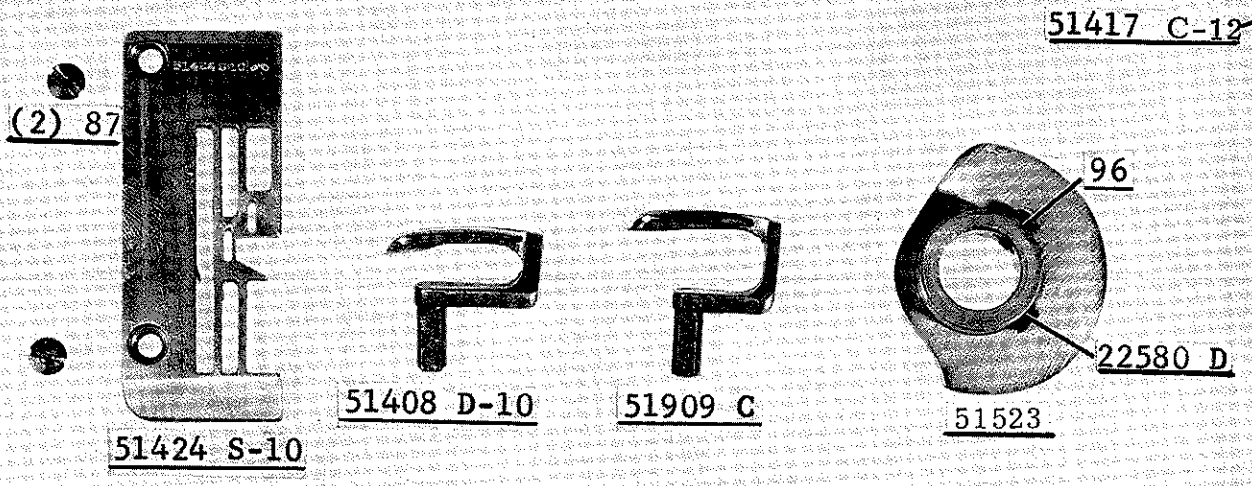
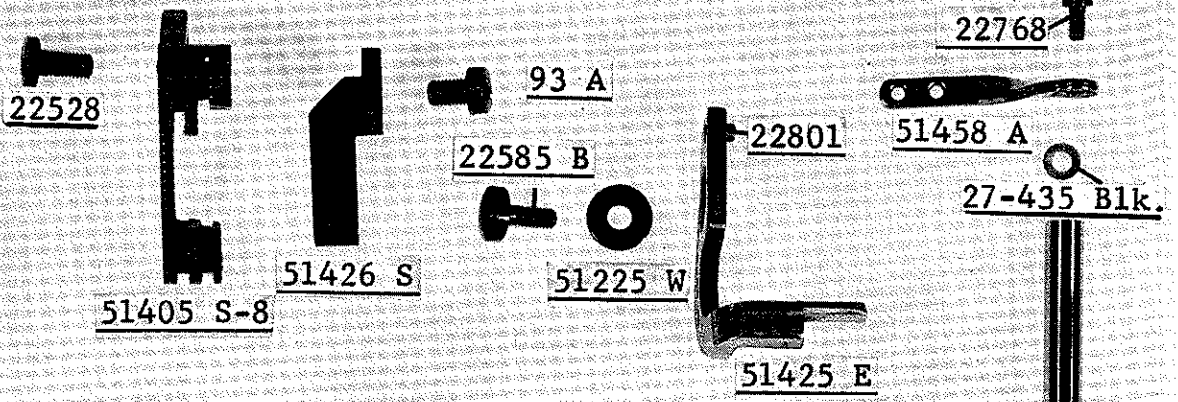
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Feed Rocker Shaft	1	643-263	Siphon	1	22547 C	Screw for 51478
3	18	Nut for 51240 E, 55241 N, 55244 G	1	660-136	Blk. Feed Crank Link	2	22548	Screw for 23437 V
2	20	Washer for 539, 51236 G, 51758	1	660-169	Oil Tube (258 A) Needle Bearing for	4	22548	Screw for 52882 AE
2	25 C	Screw for 23223 T	1	660-202	51236 E	1	22557 B	Screw for 53783 L
	27-435		1	660-207	"O" Ring for pulley	2	22559 A	Bearing Cap Screw, lower, for 29105 Q
	Blk.	Needle Bar Eyelet	1	660-212	Oil Seal Ring for	2	22559 B	Bearing Cap Screw, upper, for 29105 Q
		Washer	2	666-65	Oil Seal Ring for	2	22560 B	Screw for 51216 K
2	28	Screw for 51504 D	2	666-111	51150, 51250 E	1	22560 B	Screw for 51493 BP
1	50 J-16	Needle Stop Pin	2	666-114	(22586 R)	1	22564	Set Screw for 52934
2	50-216		2	666-118	Oil Wick for	1	22564	Screw for needle lever
	Blk.	Pin for 52357 A	2	666-170	Oil Wick for	1	22568	link pin, lower
1	50-458		2	666-179	51244 K	3	22569 B	Screw for 51450
	Blk.	Pin for 51241 K	2	666-201	Oil Wick for 8	5	22569 B	Screw for bearing
1	50-648	Lucite Oil Gauge	1	666-209	Oil Wick for right main shaft bearing	3	22569 B	housing
1	50-789		1	667 B-10	Oil Wick for left main shaft bearing	1	22570 B	Screw for 51282 Y
	Blk.	Oil Cap Hinge Pin	1	668-25	Felt for 52934 A	15	22571 A	Screw for 51493 AH
2	73	Screw for looper	3	666-149	(90)	1	22571 B	Screw for 51278 D
1	77	Screw for needle lever link pin, upper	1	666-170	Lubricating Felt for 51054	1	22571 B	Plug Screw
1	77	Screw for 51054	1	666-170	Oil Wick for needle lever	1	22580 D	Plug Screw
3	77	Screw for 51236 A	1	666-170	Oil Wick for	1	22585 A	Set Screw for 51523
3	80	Screw for cloth plate	1	666-170	51134 V	1	22585 A	Screw for 51282 AF
2	80	Screw for 52980 A	1	666-179	Wedge Pin for	1	22585 B	Screw for 51425 E
1	81	Screw for 51242 Y (12982)	2	666-111	666-111	1	22586 R	Screw for 660-212
1	82	Screw for 51236 G	1	666-201	Felt Plug	1	22588 A	Screw for 52350 A
2	87	Screw for throat plate	1	666-209	Felt Siphon Cup Disc	1	22596	Screw for 21657 Y
6	88	Screw for 14649	1	666-214	Felt Lint Filter	1	22711	Screw for 52372 A
2	88	Screw for 15465 F	2	667 B-10	Dowel Pin for	1	22729	Screw for 51243 C
1	88	Screw for 52894 AK	1	668-25	51273 A	1	22729	Screw for 51472 B
2	88 B	Screw for needle	1	719	Eyelet for 51292 D	1	22729 A	Screw for 51294 U
2	88 B	Screw for 51034 A	2	1740	Screw for 51150, 56350 A	1	22729 B	Screw for 51294 U
1	89	Screw for 51418 F	1	6042 A	Stop Pin for	1	22729 C	Screw for 51294 U
1	90	Screw for 666-138	2	6042 A	51530 H	2	22730	Screw for 55241 N
2	90	Screw for 23322 AL-1 1/4	1	7947	Washer for 51135 P	1	22730	Screw for 51278
2	90	Screw for 52882 AA	1	12538	Washer for 52894 AM	1	22733 B	Plug Screw for 52882 L (41394 A)
5	90	Screw for 52882 Y, 52894 AB	1	12982	Nut for 51294 R	1	22758 C	Screw for 53783 A
1	91	Screw for 13430 B	1	13430 B	Nut for 51241 K	1	22760 A	Screw for 13430 D
2	93	Screw for B21375 AH	1	13430 D	Lock Nut for 81	2	22768	Screw for 51236 B
1	93 A	Screw for upper feed dog	1	14649	Presser Foot Shank for 51520 BT-10- 1 1/4 (91)	1	22768	Screw for 51244 B
1	95	Plug Screw	1	15465 F	Yielding Section	1	22768	Screw for 56458 A
2	95	Screw for 51147	1	21212	Spring for	1	22768	Screw for 56458
1	95	Screw for 51270 B	1	21212	51520 BT-10-1 1/4 (22760 A)	1	22798	Screw for 51472 A
1	HA95	Adjusting Screw for 51134 N	3	14649	Nut for 51294 R	1	22799 F	Hinge Screw for 51520 BT-10-1 1/4
1	96	Screw for 51244	1	15465 F	Lock Nut for 81	1	22801	Screw for 51425 E
1	96	Spot Screw for 51523	1	21212	Presser Foot Shank for 51520 BT-10- 1 1/4 (91)	1	22811 B	Screw for 51242 W
1	98	Screw for 51244	1	13430 D	Oil Siphon	1	22829	Lock Nut Screw for 51745
3	98 A	Screw for 158 B	1	B21375 AH	Connection Locking Ring	1	22834	Needle Guard
1	98 A	Screw for 51291 A	1	21657-4	Adjusting Section	1	22839	Adjusting Screw
8	109	Tension Disc	1	21657 E	51520 BT-10-1 1/4 (22760 A)	2	22839 C	Screw for 52980 A
3	158 B	Thread Eyelet (98 A)	1	21657 W	Collar for 8 (88)	1	22848	Screw for cloth plate
1	258	Nut for 51134 HA	1	21657 X	Looper Rocker Cone for 29192 D (88)	9	22848	Screw for 539, 51758
1	258	Nut for 51280 E	1	21657 Y	Oil Siphon	1	22852	Screw for 52882 L
1	258 A	Nut for 660-136	1	22513	Connection Locking Ring	1	22852	Screw for 52934 D (51216 N)
1	258 A	Lock Nut for 51745	1	22517	Belt Guard (93)	1	22852 A	Screw for 51242 Y
1	258 A	Lock Nut for 51745	1	22519 H	Tension Release	1	22863	Feed Dog Holder
1	258 A	Nut for 52894 AM	1	22524	Separator	1	22883 A	Adjusting Screw
2	269	Nut for 51236 G, 51240 E	1	22528	Washer for 52357 A	1	22889 A	Plug Screw
2	402	Screw for 51283 H, 53783 A	3	22528	Tension Release	2	22889 C	Adaptor Screw for 539, 51758
1	531	Screw for 51257 M	2	22537	Lever Shaft	1	22889 D	Plug Screw
2	531	Screw for 51493 BQ	1	22539 H	Tension Release	3	22894 C	Plug Screw
1	538	Feed Dog Height Adjusting Screw	1	22539 R	Lever Shaft Bushing	1	22894 C	Eccentric Set Screw for 29105 Q
1	539	Frame Thread Eyelet (20, 22848, 22889 A)	1	22541 B	Tension Release	2	22894 C	Screw for 51273 B
1	604	Screw for 51430 L	1	22541 B	Lever Connection (22596)	1	22894 C	Set Screw for 52372 A
1	643-127		3	22541 B	Screw for 35731 A	2	22894 D	Eccentric Spot Screw for 29105 Q
	Blk.	Oil Pump Gasket	3	22541 B	Screw for 51273 A	2	22894 D	Spot Screw for 51142 C, 52375
			3	22541 B	Screw for 51244 B	2	22894 F	Screw for pulley
			3	22541 B	Screw for 51282 AF	1	22894 H	Screw for 51242 W
			3	22541 B	Screw for lower feed dog	2	22894 J	Screw for 51247
			3	22541 B	Screw for 52357 A	2	22894 T	Set Screw for 51406, 52375
			3	22541 B	Screw for 53783 N	1	23223 T	Strip Guide (25 C)
			3	22541 B	Plug Screw	1	23322 M	Washer for 23322 AL-1 1/4
			3	22541 B	Plug Screw	1	23322 M	
			3	22541 B	Screw for 52882 AD	1	23322 M	



Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	23322 AL-1 1/4	Binder (90, 23322 M)	28	51216 M	Needle Bearing Roller for 29476 KU	1	51257 K	Presser Bar
1	23437 U	Binder Mounting Bracket (23437 W, 43139 A)	3	51216 N	Washer fo 22852, 55244 G, 56315	1	51257 M	Presser Bar Connection and Guide (531)
1	23437 V	Binder Slide Block (22548)	1	51216 P	Nut for 51215 J	1	51257 AA	Presser Bar Bushing, lower
1	23437 W	Lock Screw for 23437 U(43139 A)	1	51221 C	Pulley (22894 F)	1	51270 B	Needle Thread Take-up Wire (95)
1	29066 R	Needle Lever Connecting Rod Ball Joint Assembly (22559 G)	2	51225 W	Washer for 22585 B	1	51272 C	Block Guide Collar Shaft
1	29105 Q	Looper Drive Eccentric Assembly (22559 A, 22559 B, 22894 C, 22894 D)	1	51236 A	Feed Lift Eccentric Link Pin (77)	1	51272 D	Block Guide Collar Shaft Spring
1	29192 D	Looper Rocker Assembly	1	51236 A	Looper Avoid Eccentric Link Pin (77)	1	51273 A	Upper Knife Holder Bracket
1	29348 Y	Needle Lever Assembly	1	51236 B	Link Pin for 51273 (77)	1	51273 B	Upper Knife Rocker Bearing Stud (22894 C)
1	29476 DR	Feed Lift Eccentric Assembly, lower, .080 inch throw	1	51236 D	Feed Crank Stud Cap (22768)	1	51273 D	Upper Knife Holder Rocker Arm
1	29476 JN	Looper Avoid Eccentric Assembly, .062 inch throw	1	51236 E	Feed Crank Link for 51236 E	1	51278	Chip Guard Assembly (22730)
1	29476 KS	Knife Drive Eccentric Assembly, .158 inch throw	1	51236 F	Feed Crank Link Assembly	1	51278 A	Chip Guard for 51278
1	29476 KT	Feed Lift Eccentric Assembly, upper, .158 inch throw	1	51236 G	Feed Crank Stud (20, 82, 269)	1	51278 D	Spring (22570 B)
1	29476 KU	Crankshaft Assembly, .990 inch throw	1	51240 E	Looper Connecting Rod (18, 269)	1	51278 G	Hinge Pin for 51278
2	35178 D	Spring for 666-65	1	51241 K	Looper Connecting Rod and Ball Joint, right (12538)	1	51280 E	Throat Plate Support Pin (258)
2	35178 D	Spring for 666-114	2	51242 L	Looper Drive Lever Rocker Thrust Washer	2	51280 J	Dowel Pin for 52980 A
2	35731 A	Presser Bar Connection Guide Plate (22513)	1	51242 M	Washer for 22852 A	1	51282 Y	Head Cover (22569 B)
1	35766	Screw for 51450	1	51242 M	Washer for 52841 G	1	51282 Z	Head Cover Gasket
1	39158 G	Hinge for 51278	1	51242 P	Looper Drive Lever Shaft	1	51282 AE	Needle Lever Bearing Oiler (90)
1	39158 U	Spring for 51278	1	51242 R	Looper Drive Lever Shaft Bushing, middle	1	51282 AF	Oil Reservoir Top Cover (22524)
1	39582 L	Oil Cap	1	51242 S	Looper Drive Lever Shaft Bushing, rear	1	51283 H	Presser Foot Lifter and Tension Disc Release Lever (402)
2	41394 A	Gasket for 22733 B	1	51242 W	Looper Drive Lever (22811 B, 22894 H)	1	51290 T	Main Shaft Bushing, middle
1	43139 A	Lock Nut for 23437 W	1	51242 Y	Looper Drive Lever Rocker (81, 22852 A, 51242 M)	1	51291 A	Looper Thread Guard (98 A)
2	43266	Nut for 51292 G	1	51242 Z	Looper Drive Lever Shaft Bushing, front	4	51292 A	Tension Post Ferrule
1	51034 A	Feed Bar Shaft (88 B)	1	51243 C	Ball Stud Fork (22729)	4	51292 C	Tension Nut
2	51054	Link Pin for needle lever (77, 22564)	1	51244	Looper Rocker Frame (96, 98)	4	51292 D	Tension Thread Eyelet
1	51054	Feed Crank Link Pin (77)	1	51244 B	Looper Rocker Shaft Arm (22519 H, 22768)	2	51292 F-4	Tension Spring, looper
1	51134 C	Feed Bar Shaft Washer	1	51244 K	Looper Rocker Shaft	2	51292 F-8	Tension Spring, needle
1	51134 J	Feed Dog Holder	2	51244 L	Looper Rocker Shaft Thrust Washer	4	51292 G	Tension Post
1	51134 N	Spring (HA95)	1	51244 N	Looper Rocker Shaft Clamp Collar (18, 20, 55244 G)	1	51294 K	Upper Clamp
1	51134 V	Taper Pin	1	51246	Looper Rocker Stud Nut	1	51294 M	Oil Siphon Tube
1	51134 HA	Feed Dog Holder for 52934 (258, 51134 J)	1	51247	Main Shaft Counterweight (22894 J)	1	51294 P	Oil Tube Clamp (7947, 51294 R)
1	51135 P	Feed Rocker Arm (6042 A, 55235 D, 55235 E)	1	51250 C	Nut for 22547 C	1	51294 R	Screw for 51294 P (7947)
1	51142 C	Eccentric for 29476 DR(22894 D)	1	51250 D	Washer for 22586 R	1	51294 U	Oil Siphon Assembly (22729 A, 22729 B)
4	51145 A	Eccentric Bearing Assembly for 29476 DR, JN, KS, KT	1	51250 F	Gasket for 22586 R	1	51294 W	Oil Tube for 51273 D
1	51147	Main Shaft Collar (95)	1	51254 C	Needle Bar Bushing, upper	1	51294 Z	Oil Siphon Tube Conn.
1	51150	Needle Lever Shaft Stop Collar (719)	1	51254 D	Needle Bar Bushing, lower	1	51382 A	Gasket for 51282 AF
1	51193 X	Oil Tube for upper feed bar pin	1	51254 J	Needle Bar Connection	1	51405 S-8	Lower Feed Dog (22528)
2	51216 G	Needle Lever Connecting Rod	1	51256 C	Presser Bar Spring	1	51406	Eccentric for 29476 JN (22894 T)
						1	51408 D-10	Looper, front
						1	51417 C-12	Needle Bar
						1	51418 F	Needle Clamp Collar (88 B, 89)
						1	51422 E	Main Shaft
						1	51424 S-10	Throat Plate (87)
						1	51425 E	Needle Guard (22585 B, 22801)
						1	51426 S	Upper Feed Dog (93A)
						1	51430 L	Knife Guard for 51520 BT-10-1 1/4 (604)
						1	51430 Z-10	Presser Foot Bottom for 51520 BT-10-1 1/4

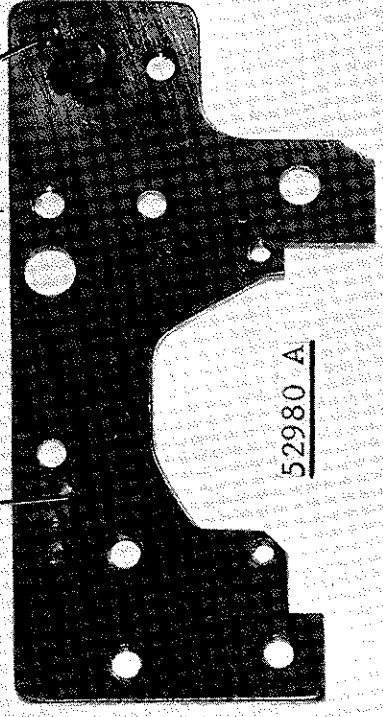
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51449	Lower Knife	1	51758	Frame Thread Eyelet (20, 22848, 22889 A)	3	52894 AB	Oil Tube Holder (90)
1	51450	Lower Knife Holder Block (22568, 35766)	1	51909 C	Looper, back	1	52894 AK	Oil Tube for looper rocker and left ball joint (88)
			1	52350 A	Knife Holder Plate (22588 A)	1	52894 AM	Oil Tube for right ball joint (258 A, 8042 A)
			1	52357 A	Cast-off Support Plate (21657 E, 22528)	1	52934	Main Feed Bar (22560 B)
1	51470	Upper Knife	1	52372	Upper Knife Holder Block	1	52934 A	Upper Feed Bar
1	51472 A	Upper Knife Shield (22798)	1	52372 A	Upper Knife Holder Block Guide Collar (22711, 22894 C)	1	52934 B	Upper Feed Bar Arm
1	51472 B	Upper Knife Clamp (22729)	2	52373 A	Bushing for 51273 A	1	52934 C	Upper Feed Bar Stop
1	51478	Front Cover and Chip Guard Latch (22547 C, 51250 C)				1	52934 D	Top Feed Holder (22852, 51216 N)
4	51491 C	Lead-in Thread Eyelet				1	52934 E	Lubricating Felt
1	51493 D	Oil Pump Driving Shaft				1	52934 F	Lubricating Felt Guard
2	51493 E	Driving Shaft Gear				1	52935	Feed Rocker (92127)
1	51493 AG	Oil Pump Housing (22569 B)	1	52841 G	Locking Stud for 51242 Y (52841 J)	2	52936	Feed Rocker Shaft Bushing
1	51493 AH	Oil Pump Housing Cover (22569 B)	1	52841 J	Nut for 52841 G	2	52944 T	Looper Rocker Shaft Bushing, right and left
1	51493 BK	Lint Filter Screen	1	52882 L	Oil Reservoir Back Cover (22733 B, 22848, 41394 A)	1	52944 U	Looper Rocker Shaft Bushing, middle
1	51493 BP	Pump Driving Gear (22560 B)	1	52882 M	Gasket for 52882 L	1	52980 A	Throat Plate Support (80, 22839)
1	51493 BQ	Pump Driven Gear (531)	1	52882 P	Gasket for 52882 AD	1	53783 A	Lifter Lever Link (402, 22758 C)
1	51494 E	Oil Tube for upper and lower feed lift eccentric	1	52882 U	Gasket for 52882 AE	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
1	51501 A	Cloth Plate (80, 22839 C)	1	52882 Y	Baffle Plate (90)	1	53783 M	Presser Foot Lifter Lever Connecting Rod
1	51504 D	Cast-off Plate (28)	1	52882 AA	Oil Drip Plate	1	53783 N	Presser Foot Lifter Lever, internal (22537)
1	51513	Looper Rocker for 29192 D	1	52882 AC	Spring for 52882 AD	2	55235 D	Screw for 51135 P
1	51520 BT-10-1 1/4	Presser Foot	1	52882 AD	Chamber Cover (22541 B)	2	55235 E	Nut for 51135 P
1	51523	Take-up (96, 22580 D)	1	52882 AE	Crank Chamber Cover (22548)	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
1	51530 H	Yielding Section for 51520 BT-10-1 1/4	1	52883 R	Crank Chamber Cover (22548)	1	55244 G	Looper Shaft Collar Stud (18, 51216 N)
1	51530 H	Yielding Section for 51520 BT-10-1 1/4	1	52883 S	Presser Foot Lifter Lever Bushing	1	56315	Needle Lever
1	51745	Looper Rocker Cone Stud for 29192 D (258 A, 22829, 51246)	1	52883 S	Presser Foot Lifter Lever Bushing	1	56341 G	Spring for 51241 K
			2	52890 C	Main Shaft Bushing, left and right	1	56350 A	Needle Lever Stud (719)
			1	52891 B	Crankshaft Housing, includes bushing (22569 B)	1	56354 A	Needle Lever Link
						1	56356	Presser Spring
						1	56382 X	Regulator
						1	56390 E	Tension Post Support
						1	56458	Crankshaft Bearing Housing Gasket
						1	56458 A	Needle Lever Thread Eyelet (22768)
						1	92127	Needle Bar Thread Eyelet
								Set Screw for 52935

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

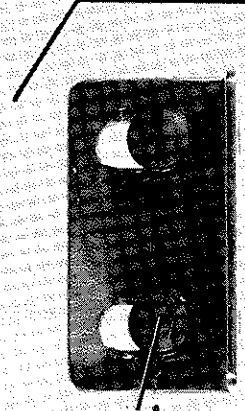


(2) 51280 J

(2) 80



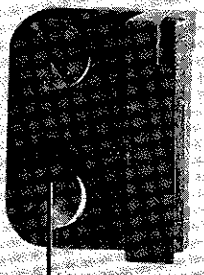
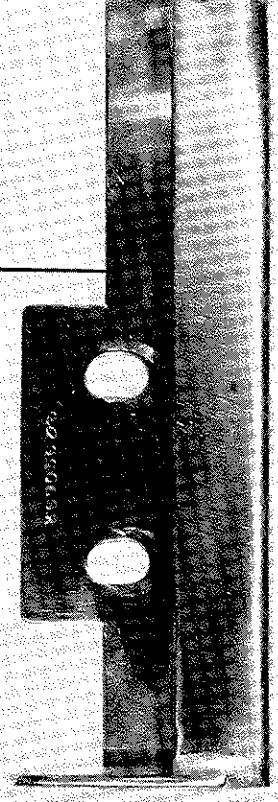
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23223 T

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(2) 22548

23437 V



23437 W

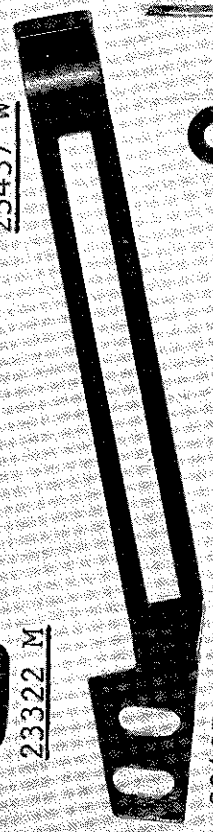


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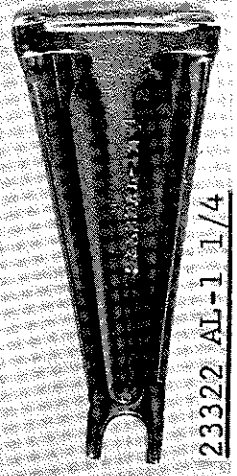
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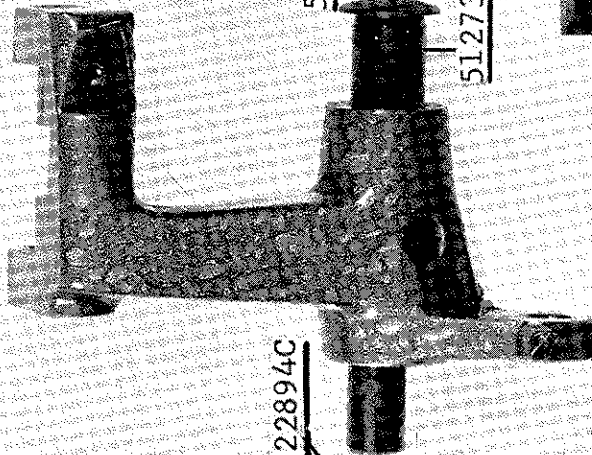


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23322 AL-1 1/4

51273 D



22894 C



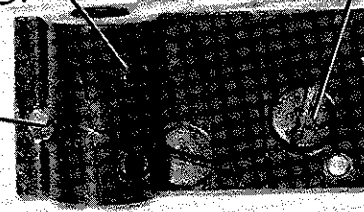
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51272 C

51272 D

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(2) 22894C



51273 A

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51273 B



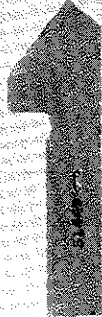
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51472 A

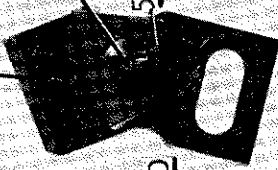


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51449

52372



22729

51472 B



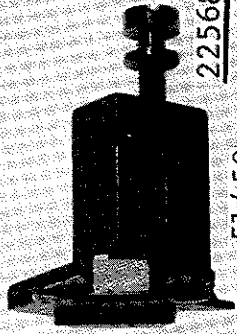
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22568

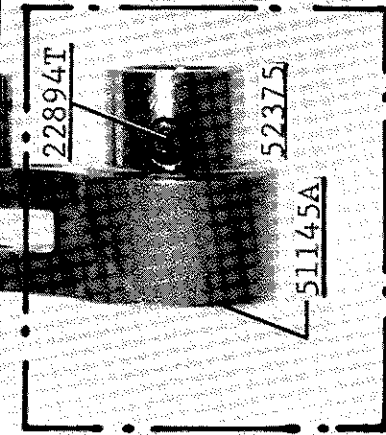


51450



52350 A

51236 A



22894T

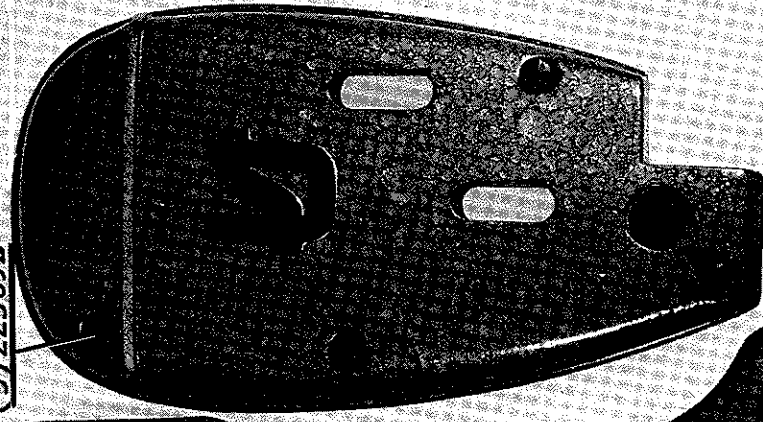
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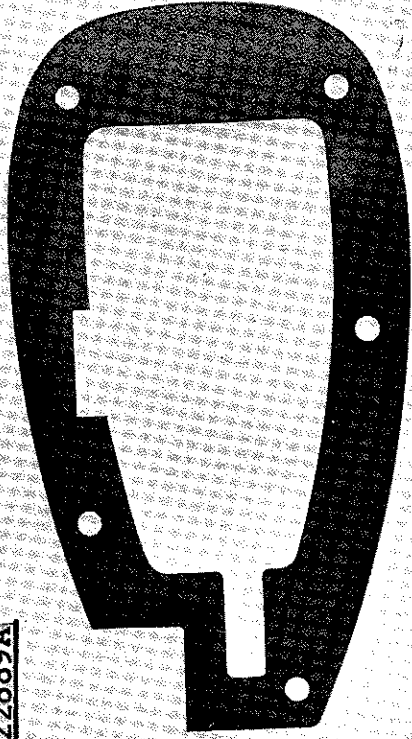
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51501 A

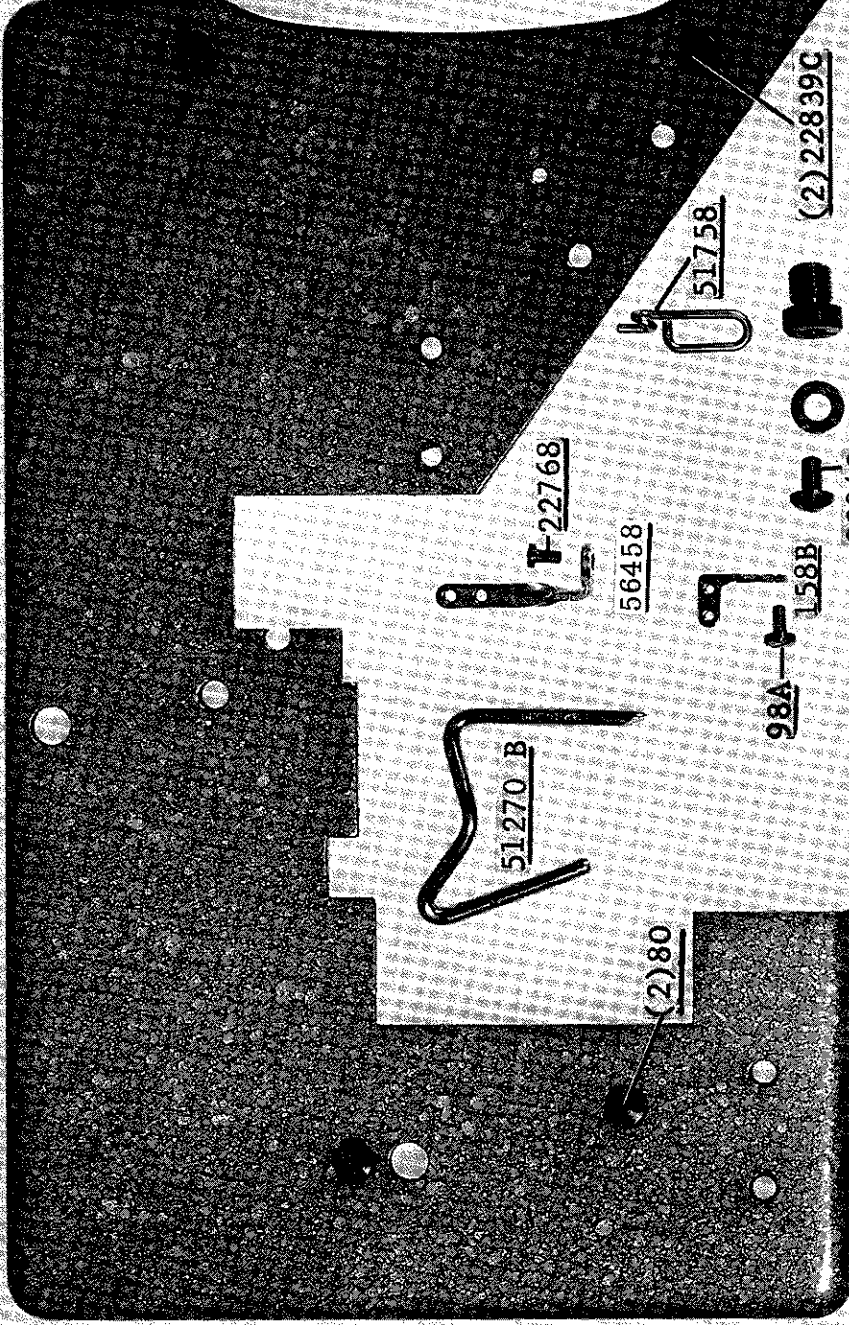
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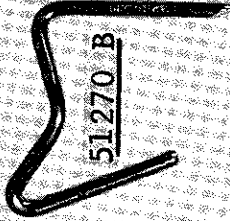
51282 Y



51282 Z



51270 B



56458



22768



51758



(2) 22839C



22889A



22848 20



158B



98A



(2) 80



51250C



51478



22547C



22570B



51278D



51278A



39158U



39158G



(2) 22730

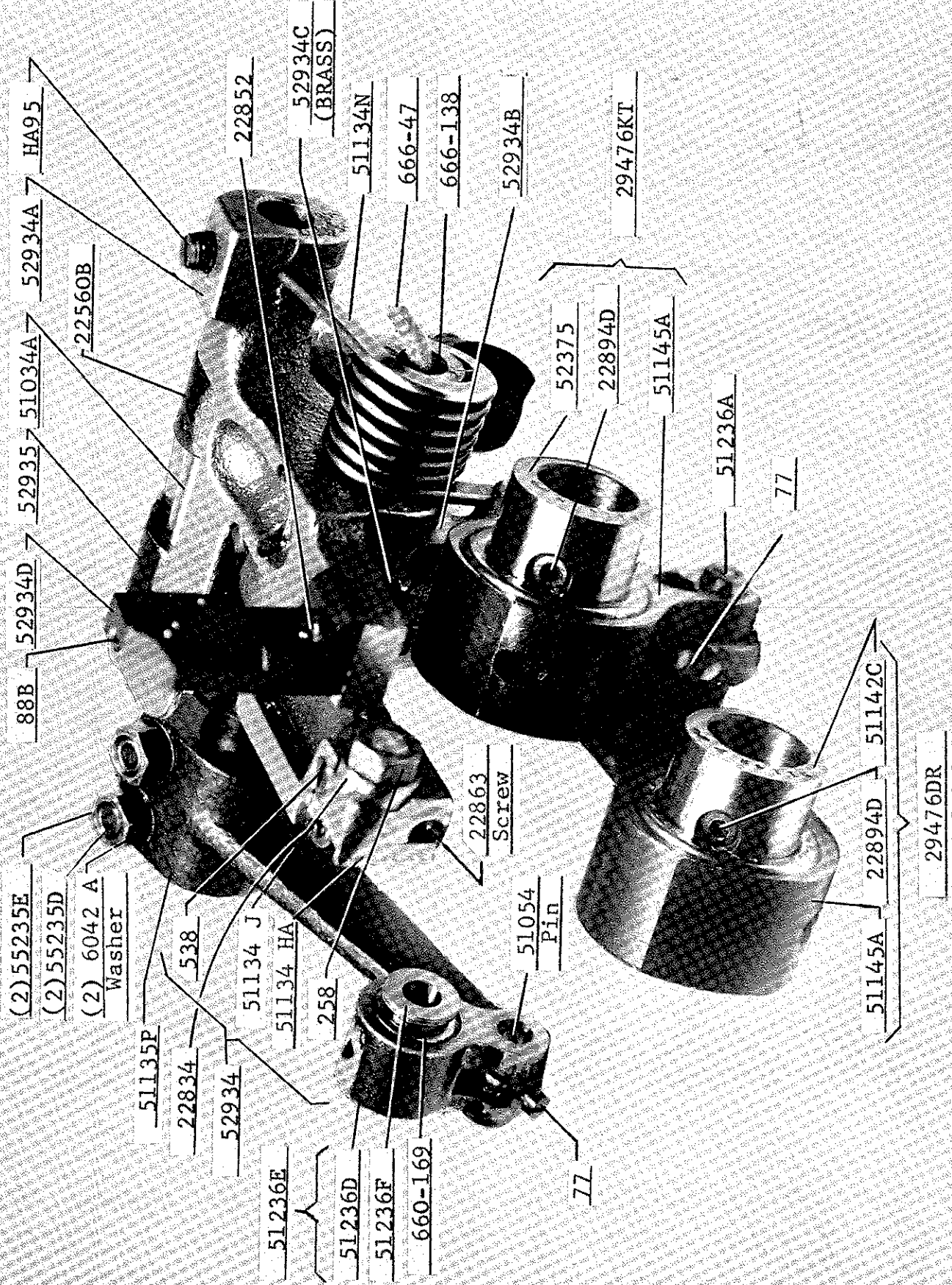


51278G



51278





# Union Special Wants to Help You Cut Sewing Machine Maintenance Costs

Union Special is offering two practical systems to help pinpoint and reduce your sewing machine maintenance costs: a record keeping system to help spot machines requiring abnormally high maintenance, and a parts inventory system to speed routine repairs.

## Machine Maintenance Records

Repair-prone machines or inexperienced competent operators can eat up your maintenance dollars in short order. To help spot these problems, Union Special suggests two variations of a simple maintenance record keeping system using cards provided by Union Special.

The first system utilizes a "Machine Maintenance Record" card (Form 237) for each sewing machine in a plant. When a repair is required, the card is pulled from the file and the repair date, parts used, and their cost are entered in the spaces provided and the card is refiled.

The second system is normally used when more detailed information on repair costs is desired. Two record cards are used: a "Repair Request Card" (Form 234), and a "Machine Repair Record" (Form 233). When a machine requires service, the forelady or foreman fills out the top of a "Repair Request Card" and gives it to a mechanic. He fills in the time the repair work is started, the parts used and their cost,

and the completion time. This data is then transferred to the permanent "Machine Repair Record" kept in the office.

Whichever system is used, management now has an invaluable tool to reduce needless maintenance costs.

## Repair Part Inventories

While record keeping tells management which machines require abnormally high maintenance, it does little to help reduce the downtime caused by routine repairs. To alleviate this situation, Union Special recommends that manufacturers establish a formal parts inventory system for each type of sewing machine they operate.

Excessive machine downtime and wasted hours by mechanics can be eliminated with an orderly in-plant inventory of the most commonly needed parts. There is no longer a need to cannibalize other machines for spare parts. Long waits for deliveries are avoided and machine downtime is kept to a minimum. The cost of a parts inventory is small when the overall savings are considered.

For free sample copies of the machine record cards and spare part inventory lists for a variety of the most popular machines, contact your local Union Special Representative or write direct to Union Special.

**U Union Special**  
FINEST QUALITY

**Style 51500 BT-10-1 1/4**

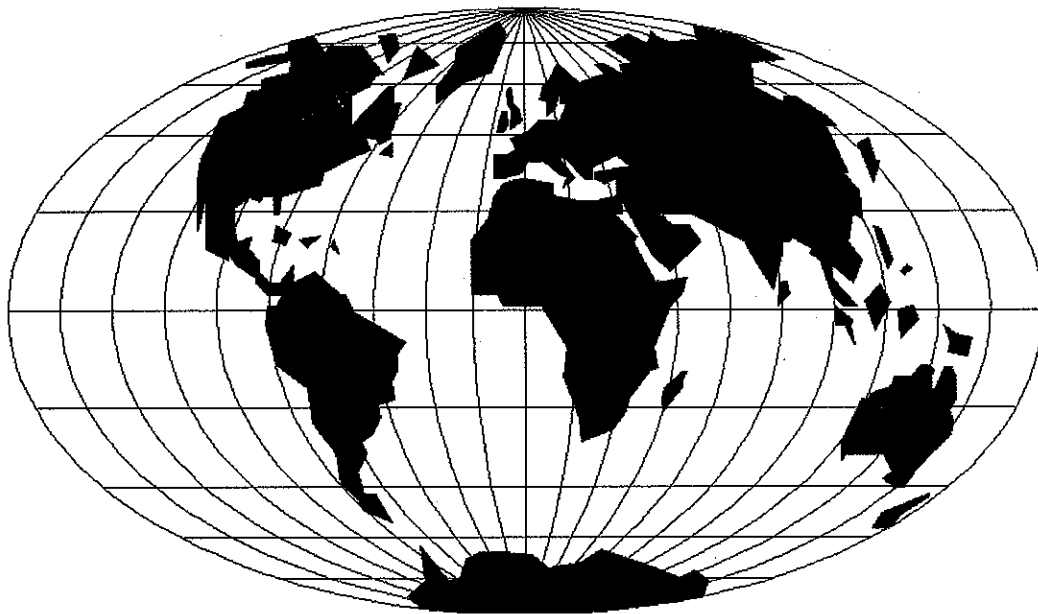
### Suggested Minimum Spare Parts List\*

Part Number	Description	Minimum Quantity Per 5 Machines	Part Number	Description	Minimum Quantity Per 5 Machines
51520 BT-10			51909 C	Looper, rear	1
1 1/4	Presser foot	1	51449	Knife, lower	4
51405 S-8	Lower feed dog	1	51470	Knife, upper	4
22528	Screw for lower feed dog	2	73	Looper set screw	6
51426 S	Upper feed dog	1	88 B	Needle clamp screw	6
93 A	Screw for upper feed dog	2	22564	Needle bar clamp screw	2
51424 S-10	Throat plate	1	22729	Upper knife clamp screw	2
87	Screw for throat plate	4	22588 A	Lower knife clamp screw	2
128 GAS	Needles (specify size)	200	21225-1/8	Looper gauge	1
51408 D-10	Looper, front	1	29484	Screw assortment	1

\*The parts and quantities listed above are intended to assist you in setting up the initial inventory of spare parts. An efficient inventory can only be established according to actual usage. The nature of the sewing operation will determine actual usage.







## WORLDWIDE SALES AND SERVICE

Union Special Corporation maintains sales and service facilities throughout the world. These offices will aid you in the selection of the right sewing equipment for your particular operation. Union Special Corporation representatives and service technicians are factory trained and are able to serve your needs promptly and efficiently. Whatever your location, there is a qualified representative to serve you.

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**Corporate Office:** One Union Special Plaza  
Huntley, IL 60142  
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Fax: 847•669•1096

**European Distribution Center:** Union Special GmbH  
Raiffeisenstrasse 3  
D-71696 Möglingen, Germany  
Tel: 49•07141•247•0  
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Milan, Italy  
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Other Representatives throughout  
all parts of the world.



*Union Special*  
INDUSTRIAL SEWING EQUIPMENT