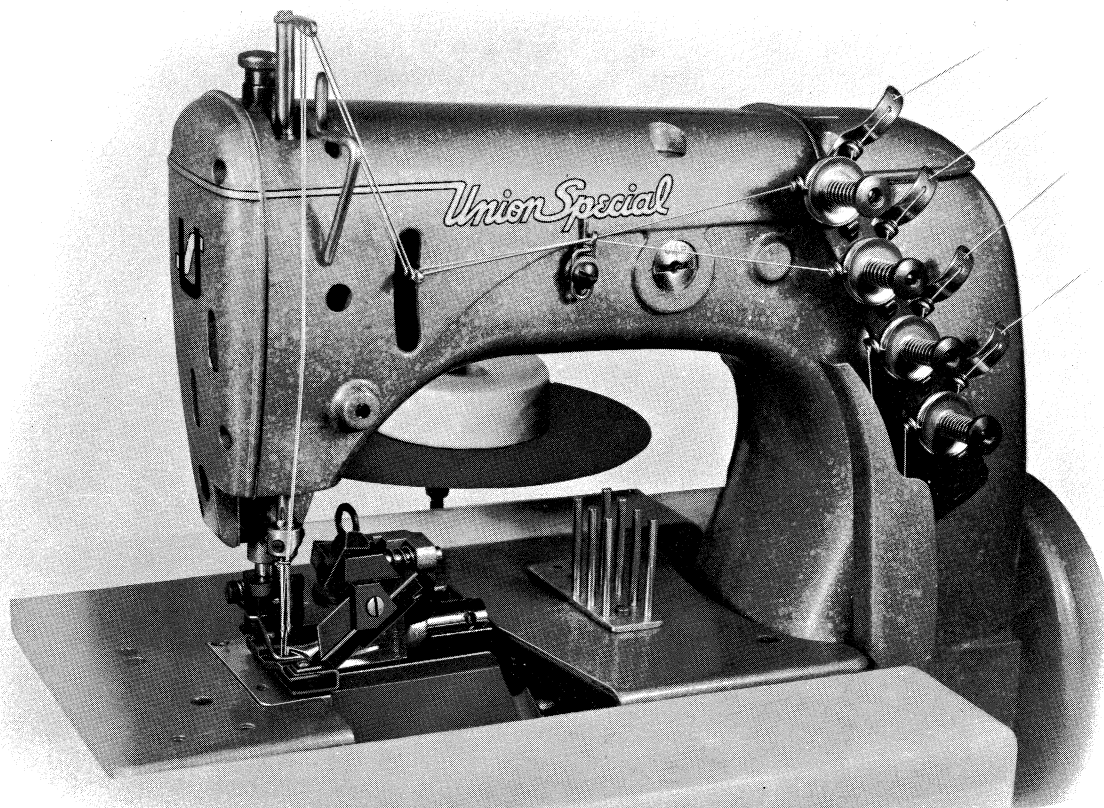


FINEST QUALITY

Union Special[®]
LEWIS[®] • COLUMBIA[®]

INDUSTRIAL
SEWING
MACHINES

STYLE
51400 BK



From the library of: Diamond Needle Corp

Catalog
No.

T109 L
Second
Edition

LIST OF PARTS
FOR
STYLE 51400 BK

UNION SPECIAL CORPORATION

CHICAGO

Catalog No. T109 L

LIST OF PARTS

Style

51400 BK

Second Edition

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UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES

CHICAGO

Printed in U. S. A.

June, 1976

IDENTIFICATION OF MACHINE

Each UNION SPECIAL machine is identified by a Style number which is stamped into the name plate on the front of 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 51400 BK". 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 51400 BKZ".

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: "51400".

APPLICATION OF CATALOG

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

It can also be applied with discretion to some special styles of machines in Class 51400. All reference to direction, such as left and right, front and back, etc., are taken from the operator's position while seated at the machine. Operating direction of handwheel is toward the operator.

DESCRIPTION OF MACHINE

51400 BK Streamlined Flat Bed, Two Needle, Two Loopers, Intermittent Differential Feed, Medium Duty Machine, With Double Disc Take-up, Needle Bearing Needle Drive, Light Weight Presser Bar and Pulley, Automatically Lubricated, Filter Type Oil Return Pump, Front Disposal of Trimmings for Binding Operations on Medium Weight Materials. Seam Type BSc-2. Stitch Type 401. Standard Gauge No. 10.

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

Standard needle for Style 51400 BK is type 108 GKS. It has a round shank, round point, extra short, double groove, struck groove, oversize ball eye, spotted, chromium plated and available in sizes 080/032, 090/036, 100/040.

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 108 GKS, size 090/036".

Selection of 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.

Success in the operation of this machine can be secured only with genuine UNION SPECIAL needles, which are put up in packages marked *Union Special*. This trademark is your guarantee of needles of the highest quality in materials and workmanship.

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 twelve ounces.

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

A daily check before the morning start should be made, and oil added if required. Excessive oil in the main reservoir may be drained at the plug screw in the main frame, directly under the handwheel.

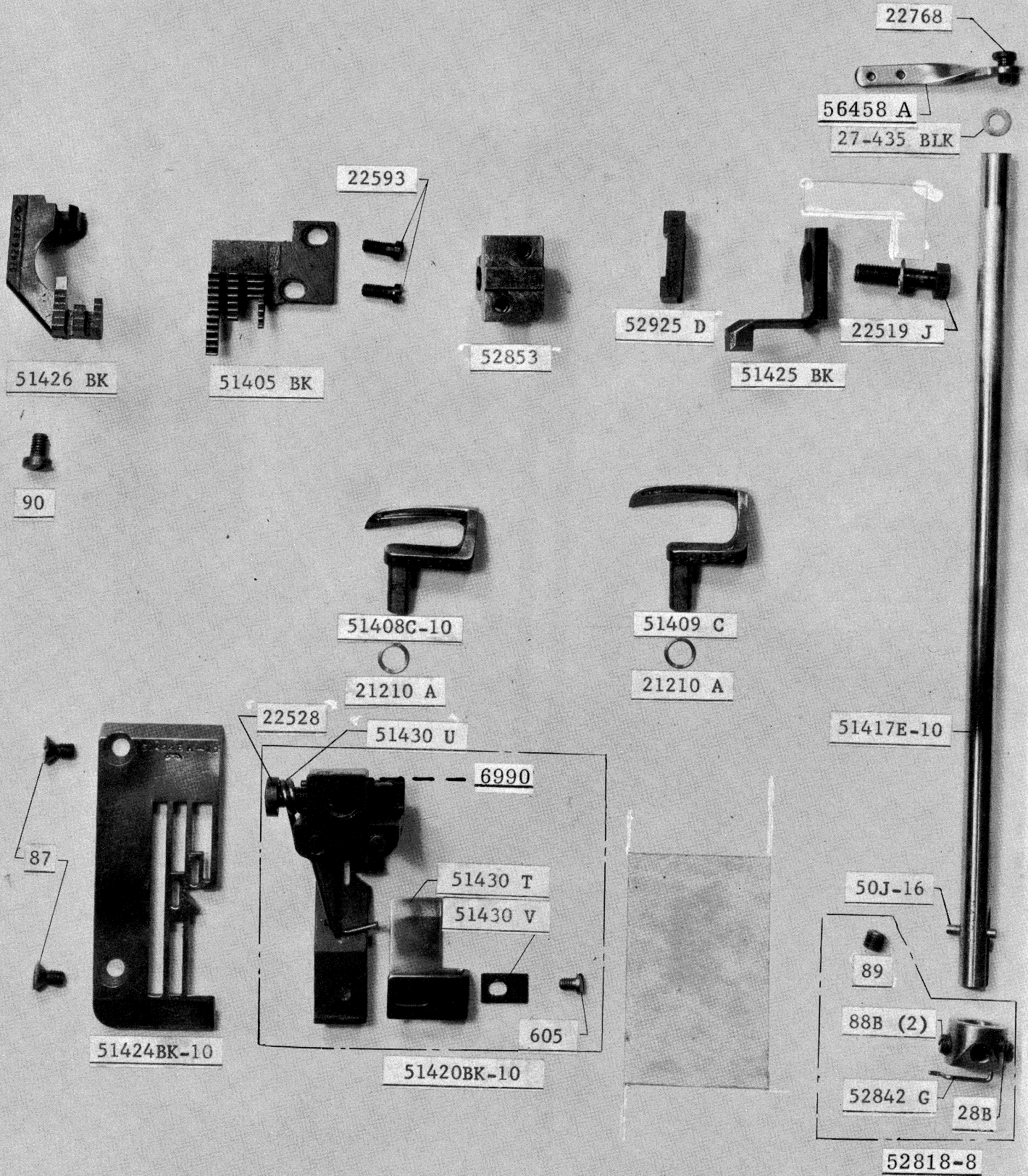
The following is a numerical list of the parts used in this machine. Quantities, part numbers, and descriptions are given. Following the parts list are photographs of some of the major parts.

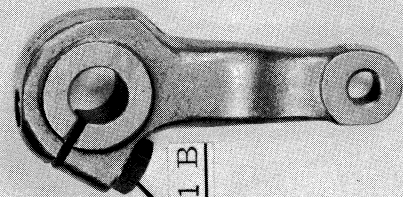
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Feed Rocker Shaft	1	660-169	Feed Crank Link	2	22559 G	Screw for 29066 R
3	18	Nut for 51240 E, 55241 N, 55244 G	1	660-202	Needle Bearing	2	22560 B	Screw for 51493 BP
1	20	Washer for 51435	1	660-207	Oil Seal Ring for 51221 C	1	22560 B	Screw for 52834
2	20	Washer for 51236 G, 51758	1	660-212	Oil Seal Ring for 51250 E (22586 R)	1	22562 A	Screw for 51254 H
2	CL21	Oil Wick for 52834 H, 52835 N	2	666-65	Oil Wick for 51144	2	22565 C	Screw for 39237
2	25 C	Screw for 23223 T	2	666-111	Oil Wick for 8	1	22568	Screw for 51450
2	25 CC	Screw for 43139 A	2	666-114	Oil Wick for right main shaft bushing	5	22569 B	Screw for 51282 Y
1	27-435 Blk.	Needle Bar Eyelet Washer	2	666-118	Oil Wick for left main shaft bushing	3	22569 B	Screw for 51493 AG
1	28 B	Screw for 52842 G	1	666-170	Oil Wick for 51250 E	3	22569 B	Screw for 52891 B
2	50-216 Blk.	Pin for 51257 T	2	666-179	Wedge Pin for 666-111	1	22570 B	Screw for 51278 D
1	50-648 Blk.	Lucite Oil Gauge	1	666-201	Felt for 51294 U	18	22571 A	Plug Screw
1	50-789 Blk.	Hinge Pin for 39582 L	1	666-209	Felt for 51294 U	1	22580 D	Screw for 51223 A
1	50 J-16	Stop Pin for 51417 E-10	1	666-214	Lint Filter for 51294 M	2	22585 A	Screw for 52882 L
1	54	Needle Lever Con- necting Link	1	666-214	Lint Filter for 51294 M	1	22586 R	Screw for 660-212
2	73	Screw for looper	2	667 B-10	Dowel Pin for 51273 A	1	22588 A	Screw for 52350 A
2	77	Screw for 51054	3	719	Screw for 51150, 51250 E, 52835 U	4	22593	Screw for 39237 D
1	77	Screw for 51204 A	1	907	Nut for 22868 A	2	22593	Screw for 51405 BK
2	77	Screw for 51236 A	1	6042 A	Washer for 52894 AM	1	22595	Screw for 51472 B
1	78	Screw for 51054	2	6990	Spring for 51430 W, 51430 X	1	22596	Screw for 21657 Y
2	80	Screw for 51501 A	1	7947	Nut for 51294 R	2	22597	Screw for 51435 B, 52835 U
2	80	Screw for 52980 A	2	8372 A	Washer for 43139 A	1	22598 C	Screw for 21657-4
1	81	Screw for 51242 Y (12982)	2	9937	Nut for 51435	1	22711	Screw for 52372 A
1	82	Stitch Regulating Screw	1	12538	Nut for 51241 K	1	22729	Screw for 51243 C
2	87	Screw for 51424 BK- 10	2	12934 A	Nut for 22758 B	1	22729 A	Screw for 51294 U
2	J87 J	Screw for 51204 C	1	12957 E	Spring Washer for 23437 W	2	22729 B	Screw for 51294 U
2	88	Screw for 15465 F	1	12982	Lock Nut for 81	1	22730	Screw for 51278
1	88	Screw for 52894 AK	1	15465 F	Looper Rocker Cone for 29192 D (88)	1	22733 B	Screw for 52882 L (41394 A)
2	88 B	Needle Set Screw	2	21210 A	Looper Collar	1	22747	Screw for 52834
1	89	Set Screw for 52818-8	1	21212	Locking Ring for 51294 N	1	22758 B	Screw for 51435
2	90	Screw for 23322 AL- 1	1	B21375 AH	Belt Guard (93)	2	22758 B	Screw for 52835 G (12934 A)
1	90	Screw for 51426 BK	1	21657-4	Tension Release Separator (22598 C)	1	22758 C	Screw for 53783 A
2	90	Screw for 51282 AE, 52882 Y	1	21657 E	Washer for 51257 T	2	22768	Screw for 51236 B
3	90	Screw for 52794 G, 52894 AD, 52894 AE	1	21657 W	Tension Release Lever Shaft	3	22768	Screw for 51244 B, 56458, 56458 A
2	90	Screw for 52882 AA	1	21657 X	Tension Release Lever Shaft Bushing	2	22798	Screw for 51472 A
2	93	Screw for B21375 AH	1	21657 Y	Tension Release Lever Shaft Connection (402, 22596)	1	22798 A	Screw for 51204
2	95	Screw for 51147	3	22513	Screw for 35731 A	1	22799 N	Screw Pin for 61130 F
1	95	Screw for 51270 B	3	22516	Screw for 52836 H	2	22799 U	Screw for 51430 W, 51430 X
1	95	Plug Screw	2	22517	Screw for 51273 A	1	22811 B	Screw for 51242 W
2	96	Screw for 51223 A, 51244	2	22519 C	Screw for 52836 C (51235 G)	2	22823 A	Screw for 51493 AY
1	98	Screw for 482	1	22519 H	Screw for 51244 B	1	22823 B	Screw for 51493 AY
1	98	Screw for 51244	1	22519 J	Screw for 51425 BK, 52925 D	1	22829	Screw for 51745 (258 A)
3	98 A	Screw for 158 B	6	22524	Screw for 51282 AF	2	22839 C	Screw for 51501 A
1	98 A	Screw for 51291 A	1	22528	Screw for 51257 T	1	22848	Screw for 51758 (20)
8	109	Tension Disc	1	22528	Screw for 51430 U	2	22848	Screw for 52835 N
3	158 B	Thread Eyelet (98 A)	1	22537	Screw for 53783 N	9	22848	Screw for 52882 L
1	258	Nut for 51280 E	1	22539 H	Plug Screw	1	22852 A	Screw for 51242 Y (51242 M)
1	258 A	Nut for 660-136	3	22541 B	Screw for 52882 AD	1	22868 A	Screw for 52835 S (907, 39236 A)
1	258 A	Nut for 22829	1	22542	Plug Screw for 51282 Y (52882 W)	1	22883 A	Plug Screw
1	258 A	Nut for 52894 AM	1	22547 C	Screw for 51478 (51250 C)	1	22889 A	Adaptor Plug Screw
2	269	Nut for 51236 G, 51240 E	4	22548	Screw for 52882 AE	4	22894 C	Screw for 29105 Z
2	402	Screw for 21657 Y, 53783 A	2	22548	Screw for 23437 V	2	22894 C	Screw for 51273 A
2	482	Feed Rocker Shaft Collar (98)	1	22557 B	Screw for 53783 L	1	22894 C	Screw for 52372 A
1	531	Screw for 51257 M	2	22559 A	Bearing Cap Screw, lower, for 29105 Z	1	22894 D	Screw for 29015 Z
2	531	Screw for 51493 BQ	2	22559 B	Bearing Cap Screw, upper, for 29105 Z	1	22894 D	Screw for 51406
1	605	Screw for 51430 T	1	22559 B	Bearing Cap Screw, upper, for 29105 Z	2	22894 F	Screw for 51221 C
1	643-127 Blk.	Gasket for 51493 AG	2	22559 B	Bearing Cap Screw, upper, for 29105 Z	1	22894 H	Screw for 51242 W
1	660-136	Feed Crank Oil Tube	2	22559 B	Bearing Cap Screw, upper, for 29105 Z	2	22894 J	Screw for 51247
						2	22894 P	Screw for 52836
						1	22894 T	Screw for 51142 B
						1	23223 T	Strip Guide (25 C)
						1	23322 M	Washer for 23322 AL-1
						1	23322 AL-1	Binder for 1 inch width binding (90, 23322 M)
						1	23437 U	Binder Mounting Bracket (23437 E)
						1	23437 V	Binder Slide Block (22548)
						1	23437 W	Screw for 23437 U (12957 E, 43139 A)

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	29066 R	Needle Lever Connecting Rod Assembly (22559 G)	2	51236 A	Feed Lift and Looper Avoid Eccentric Link Pin (77)	1	51272 D	Block Guide Collar Shaft Spring
1	29105 Z	Looper Drive Eccentric Assembly (22894 C, 22894 D)	1	51236 B	Feed Crank Stud Cap (22768)	1	51273 A	Upper Knife Lever Stud Support Bracket (22517, 22894 C)
1	29192 D	Looper Rocker Assembly	1	51236 D	Feed Crank Link	1	51273 B	Upper Knife Rocker Bearing Stud
1	29348 P	Needle Lever Assembly	1	51236 E	Feed Crank Link Assembly; one each 660-169, 41236 D, 51236 F	1	51273 D	Knife Holder Rocker Arm (77)
2	29476 DV	Feed Lifter and Looper Avoid Eccentric Assembly	1	51236 F	Feed Crank Link Ferrule	1	51278	Front Cover and Chip Guard Assembly (22730)
1	29476 FF	Crankshaft Assembly, 910 inch throw	1	51236 G	Feed Crank Stud (20, 269)	1	51278 A	Chip Guard for 51278
1	29476 HZ	Knife Driving Eccentric Assembly	1	51240 E	Looper Connecting Rod (18, 269)	1	51278 D	Chip Guard Tension Spring (22570 B)
4	35178 D	Spring for 666-65, 666-114	1	51241 K	Looper Connecting Rod and Ball Joint, right (12538)	1	51278 G	Hinge Pin for 51278 A
2	35731 A	Presser Bar Connecting Guide Plate (22513)	2	51242 L	Thrust Washer for 51242 Y	1	51280 E	Throat Plate Support Pin (258)
1	35766	Screw for 51450	2	51242 M	Washer for 22852 A, 52841 G	1	51282 Y	Head Cover (22542, 22569 B)
1	39158 G	Front Cover Hinge	1	51242 P	Looper Drive Lever Shaft	1	51282 Z	Head Cover Gasket
1	39158 U	Front Cover Hinge Spring	1	51242 R	Looper Drive Lever Shaft Bushing, middle	1	51282 AC	Felt Liner for 51282 Y
1	39236	Differential Feed Bar Driving Link Slide Block	1	51242 S	Looper Drive Lever Shaft Bushing, rear	1	51282 AE	Needle Lever Bearing Oiler (90)
2	39236 A	Differential Feed Bar Regulating Stud Washer for 22868 A	1	51242 W	Looper Drive Lever (22811 B, 22894 H)	1	51282 AF	Oiler Reservoir Top Cover (22524)
1	39237	Differential Feed Bar Guide (22565 C)	1	51242 Y	Looper Drive Lever Rocker (81, 22852 A)	1	51283 H	Presser Foot Lifter and Tension Disc Release Lever
2	39237 D	Differential Feed Bar Guide Plate (22593)	1	51242 Z	Looper Drive Lever Shaft Bushing, front	1	51290 T	Main Shaft Bushing, center
2	39237 G	Bushing for 52834	1	51243 C	Ball Stud Fork (22729)	1	51291 A	Looper Thread Guard (98 A)
1	39582 L	Oil Cap for 52882 AD	1	51244	Looper Rocker Frame (96, 98)	4	51292 A	Tension Post Ferrule
2	41394 A	Gasket for 22733 B	1	51244 B	Looper Rocker Shaft Arm (22519 H, 22768)	4	51292 C	Tension Nut
2	43139 A	Differential Feed Index Stop (25 CC, 8372 A)	1	51244 L	Looper Rocker Shaft Thrust Washer	4	51292 D	Tension Thread Eyelet
1	43139 A	Lock Nut for 23437 W	2	51244 M	Looper Rocker Shaft Bushing, right	2	51292 F-4	Tension Spring (looper)
2	43266	Nut for 51292 G	1	51244 N	Looper Rocker Shaft Clamp Collar (18, 51216 N, 55244 G)	2	51292 F-8	Tension Spring (needle)
1	51054	Feed Crank Link Pin (77)	1	51246	Looper Rocker Stud Nut	4	51292 G	Tension Post (43266)
2	51054	Needle Lever Link Pin (77, 78)	1	51247	Main Shaft Counterweight (22894 J)	1	51294 M	Oil Siphon Tube
1	51134 C	Feed Bar Shaft	1	51250 A	Needle Lever Bushing for 51215 J	1	51294 N	Oil Siphon Tube Connection (21212)
1	51142 B	Knife Drive Eccentric (22894 T)	1	51250 C	Nut for 22547 C	1	51294 P	Oil Tube Clamp (51294 R)
1	51144	Looper Rocker Shaft Bearing for 29476 DV	1	51250 D	Washer for 22586 R	1	51294 R	Screw for 51294 P (7947)
1	51145 A	Bearing for 29476 HZ	1	51250 E	Needle Lever Stud for 29348 P (719)	1	51294 U	Oil Siphon Assembly
1	51147	Main Shaft Collar (95)	1	51250 F	Gasket for 22586 R	4	51295 A	Isolator for base plate assembly
1	51150	Needle Lever Shaft Stop Collar (719)	1	51254 C	Upper Needle Bar Bushing	1	51382 A	Gasket for 51282 AF
1	51204	Looper Thread Retaining Finger (22798 A)	1	51254 D	Lower Needle Bar Bushing	1	51405 BK	Main Feed Dog (22593)
1	51204 A	Looper Thread Retaining Finger Holder (77)	1	51254 H	Needle Bar Connection (22562 A)	1	51406	Feed Lift and Looper Avoid Eccentric (22894 D)
1	51204 B	Cast-off	1	51256 C	Presser Spring	1	51408 C-10	Looper, front (73)
1	51204 C	Cast-off Finger Support Bracket (J87 J)	1	51256 N	Presser Spring Regulator	1	51409 C	Looper, back (73)
1	51215 J	Needle Lever	1	51257 K	Presser Bar	1	51417 E-10	Needle Bar
2	51216 G	Needle Lever Connecting Rod	1	51257 M	Presser Bar Connector and Guide (531)	1	51420 BK-10	Presser Foot
28	51216 M	Crankshaft Needle Bearing Roller	1	51257 T	Cast-off Plate Support (21657 E, 22528)	1	51422 H	Main Shaft
1	51216 N	Washer for 51215 J				1	51424 BK-10	Throat Plate (87)
1	51216 N	Washer for 55244 G				1	51425 BK	Needle Guard (22519 J)
1	51216 P	Nut for 51215 J				1	51426 BK	Differential Feed Dog (90)
1	51221 C	Pulley (22894 F)	1	51257 AA	Lower Presser Bar Bushing	1	51430 T	Presser Foot Bottom, front section (605)
1	51223 A	Take-up (96, 22580 D)	1	51270 B	Needle Thread Take-up Wire (95)	1	51430 U	Spring for 51430 W (22528)
1	51230 U	Presser Foot Shank	1	51272 C	Knife Holder Block	1	51430 V	Washer for 605
2	51235 G	Washer for 22519 C				1	51430 W	Presser Foot Bottom, left (22799 U)
1	51236 A	Link Pin for 51273 D (77)				1	51430 X	Presser Foot Bottom, right (22799 U)
						1	51430 Y	Presser Foot Lower Plunger, left
						1	51435	Differential Feed Control Lever rear (20, 9937, 22758 B)

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51435 B	Differential Feed Control Lever Bushing (22597)	1	52470	Stop for looper connecting rod	1	52883 R	Foot Lifter Lever Bushing
1	51449	Lower Knife	1	52794 G	Feed Lifter & Looper Avoid Eccentric Oil Tube (90)	1	52883 S	Presser Foot Lifter Lever Bell Crank Spring
1	51450	Lower Knife Holder Block (22568, 35766)	1	52818-8	Needle Holder (88, 89)	2	52890 C	Main Shaft Bushing, left, and crank shaft bushing, left
			1	52834	Main Feed Bar (22560 B, 22747)	1	52891 B	Main Shaft Housing, including bushing (22569 B)
			1	52834 H	Differential Feed Bar	3	52894 AB	Oil Tube Holder (90)
1	51470	Knife, upper	1	52835	Differential Feed Control Lever (9937)	1	52894 AD	Oil Tube for differential feed bar shaft (90)
1	51472 A	Upper Knife Shield (22798)	1	52835 G	Control Lever Link (22758 B)	1	52894 AE	Oil Tube for differential feed bar guide (90)
1	51472 B	Upper Knife Clamp (22595)	1	52835 K	Control Lever Spring (61267 G)	1	52894 AK	Oil Tube for looper rocker and left ball joint (88)
1	51478	Front Cover and Chip Guard Latch (22547 C, 51250 C)	1	52835 N	Control Lever Stop Plate (22848)	1	52894 AM	Oil Tube for right looper connecting rod ball joint (258 A, 6042 A)
2	51491 C	Lead-in Thread Eyelet	1	52835 Q	Differential Feed Fork	1	52925 D	Needle Guard Holder (22519 J)
1	51493 D	Oil Pump Driving Shaft	1	52835 S	Differential Feed Fork Block (22868 A)	1	52980 A	Throat Plate Support (80)
2	51493 E	Oil Pump Driving Shaft Gear	1	52835 U	Pivot Stud Insert (719, 22597)	1	53592	Tension Post Support
1	51493 AG	Oil Pump Housing (22569 B)	1	52835 V	Differential Feed Bar Driving Link	1	53690 E	Bearing Housing Gasket
1	51493 AH	Oil Pump Housing Cover	1	52836	Feed Rocker (22894 P)	1	53783 A	Presser Foot Lifter Lever Link (402, 22758 C)
1	51493 AY	Base Plate Assembly (22823 A, 22823 B)	1	52836 C	Feed Rocker Arm (22519 C)	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
1	51493 BH	Oil Filter Cap Assembly	1	52836 H	Feed Rocker Segment Plate (22516)	1	53783 M	Presser Foot Lifter Lever Connecting Rod
1	51493 BK	Lint Filter Screen	2	52836 P	Feed Rocker Shaft Bushing	1	53783 N	Presser Foot Lifter Lever, internal (22537)
1	51493 BP	Oil Pump Driving Gear (22560 B)	1	52836 R	Looper Rocker Shaft Bushing, left	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
1	51493 BQ	Oil Pump Driven Gear (531)	1	52841 G	Locking Stud for 51242 Y (51242 M, 52841 J)	1	55244 G	Looper Shaft Collar Stud (18, 51216 N)
1	51494 F	Oil Tube for feed rocker and knife lever	1	52841 J	Nut for 52841 G	*	61130 D	Presser Foot Lower Plunger, right
1	51501 A	Cloth Plate (80, 22839 C)	1	52842 G	Needle Holder Thread Guide (28 B)	1	61130 F	Presser Foot Equalizer (22799 N)
1	51513	Looper Rocker for 29192 D	1	52853	Feed Dog Holder (22519 J, 22519 C)	1	61267 G	Pin for 52835 K
1	51745	Looper Rocker Cone Stud (258 A, 22829)	1	52882 L	Oil Reservoir Back Cover (22585 A, 22733 B, 22848)	1	80557	Spacing Washer for 21657-4, 53592
1	51758	Frame Needle Thread Eyelet (20, 22848, 22889 A)	1	52882 M	Gasket for 52882 L	*1	56458	Needle Lever Thread Eyelet (22768)
			1	52882 P	Gasket for 52882 AD	*1	56458 A	Needle Bar Thread Eyelet (22768)
			1	52882 U	Gasket for 52882 AE			
			1	52882 W	Gasket for 22542			
			1	52882 Y	Baffle Plate (90)			
1	52350 A	Lower Knife Holder Plate (22588 A)	1	52882 AA	Oil Drip Plate for 52882 AD (90)			
1	52372	Upper Knife Holder Block	1	52882 AC	Torsion Spring for 52882 AD			
1	52372 A	Knife Holder Block Guide (22711, 22894 C)	1	52882 AD	Crank Chamber Cover, upper (22541 B)			
1	52373 A	Bushing for 51273 D	1	52882 AF	Crank Chamber Cover, lower (22548)			

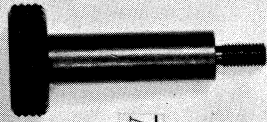
NOTE: Numbers in parenthesis following parts' description indicate the screws, nuts, etc., used to attach these parts.





22811 B

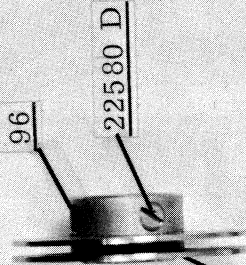
51242 W



23437 W

96

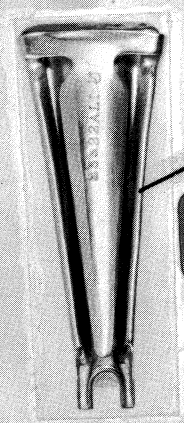
22580 D



51223 A



23437 U



23322 AL-1

90

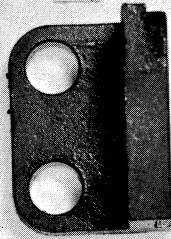
23322 M



43139 A



22548



23437 V



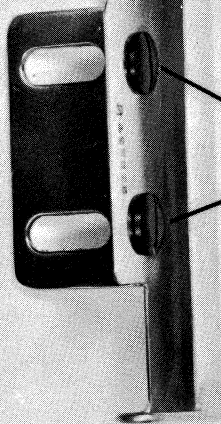
25 C



21657 E

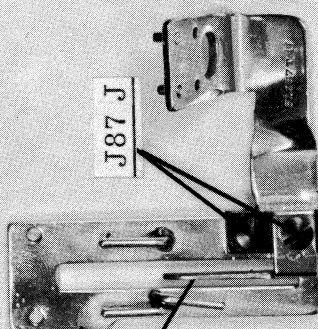


22528



22730

23223 T



J87 J

77

51204 C

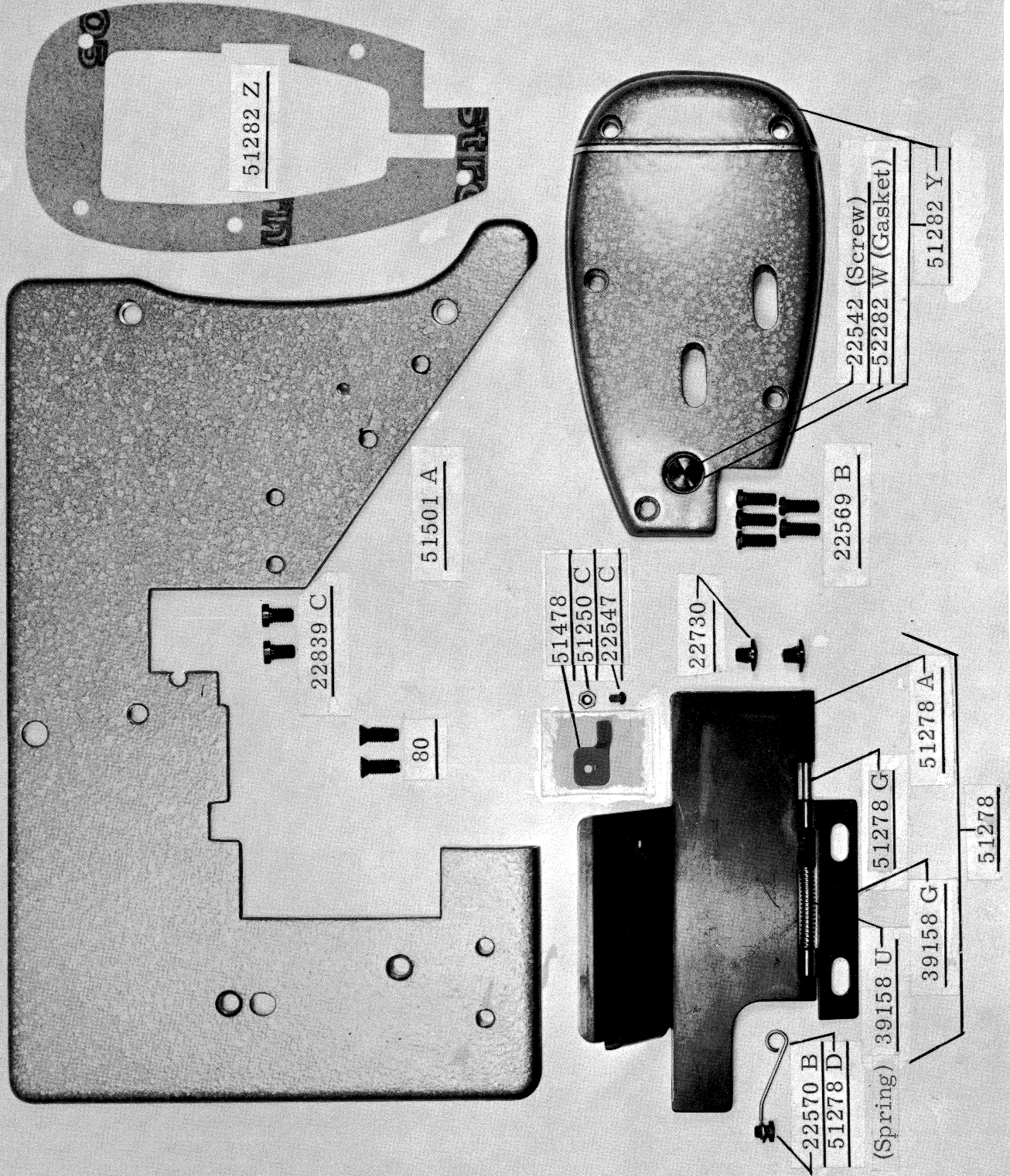
51257 T

51204 B

51204

51204 A

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