

**THIRD  
EDITION**



*Union Special*  
INDUSTRIAL SEWING EQUIPMENT

**CATALOG NO. T105L**

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**STYLES**

**53600**

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**LIST OF PARTS FOR STYLES**

**53600 A**

**53600 H**

Catalog No. T105 L

LIST OF PARTS

CLASS 53600

Styles

53600 A

53600 H

Streamlined Flat Bed Bag Closing Machines

Third Edition

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**UNION SPECIAL CORPORATION**

INDUSTRIAL SEWING MACHINES

**CHICAGO**

Printed in U.S.A.

August, 1978

## 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 53600 A". 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 53600 AZ".

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: "53600".

## 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 this class. Reference to direction, such as right, left, front, back, etc., are given from the operator's position while standing at the machine. Operating direction of handwheel is toward the left.

## STYLES OF MACHINES

Streamlined Flat Bed, High Throw, 1 1/2 Inch Needle Travel, Single Needle Machine, Enclosed Automatic Lubricating System From Two Reservoirs, Lateral Looper Travel, Mechanical Chain Cutter, Distance From Center Line of Needle to Lower Edge of Throat Plate Support 5/8 Inch.

53600 A For closing bags made from medium and heavy weight cotton, osnaburg, or burlap. Seam Specification 401-SSa-1 or 401-SSn-1. Stitch range 3 to 6 per inch.

53600 H For closing bags made from medium and heavy weight burlap and single ply or multi-wall paper. Seam Specification 401-SSa-1 or 401-SSn-1. Stitch range 3 to 5 per inch.

## 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 is the complete symbol.

Standard needle for Style 53600 A is Type 144 G. It has a round shank, round point, No. 2 bag, double groove, spotted, short point, chromium plated - sizes 054, 200/080, 230/080, 230/090.

Standard needle for Style 53600 H is Type 943 G. It has a round shank, spear point, No. 2 bag, double groove, spotted, chromium plated - sizes 170/067, 185/073, 200/080, 230/090, 250/100.

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 as follows: "1000 Needles, Type 144 G, Size 200/080".

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.

## USE GENUINE NEEDLES AND REPAIR PARTS

Success in the operation of these machines can be secured only with genuine UNION SPECIAL Needles and Repair Parts as furnished by the Union Special Corporation, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles, and are made with utmost precision. Maximum efficiency and durability are assured.

Genuine needles are packaged with labels marked *Union Special*<sup>®</sup>. Genuine repair parts are stamped with the Union Special trademark, U S Emblem. Each trademark is your guarantee of the highest quality in materials and workmanship.

### 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 reservoirs 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 on the left side of the machine just below the pulley, and is checked at the sight gauge in front of the spring cap. The oil level should be kept near the top of this sight gauge. The oil cup, located on the left side of machine in back of the needle lever stud, should be filled twice daily.

The following is a numerical list of parts used in Styles 53600 A, 53600 H. Quantities, part numbers and descriptions are given. Unless otherwise specified, the parts listed are for both machines. Following the parts list are photographs of some of the major parts.

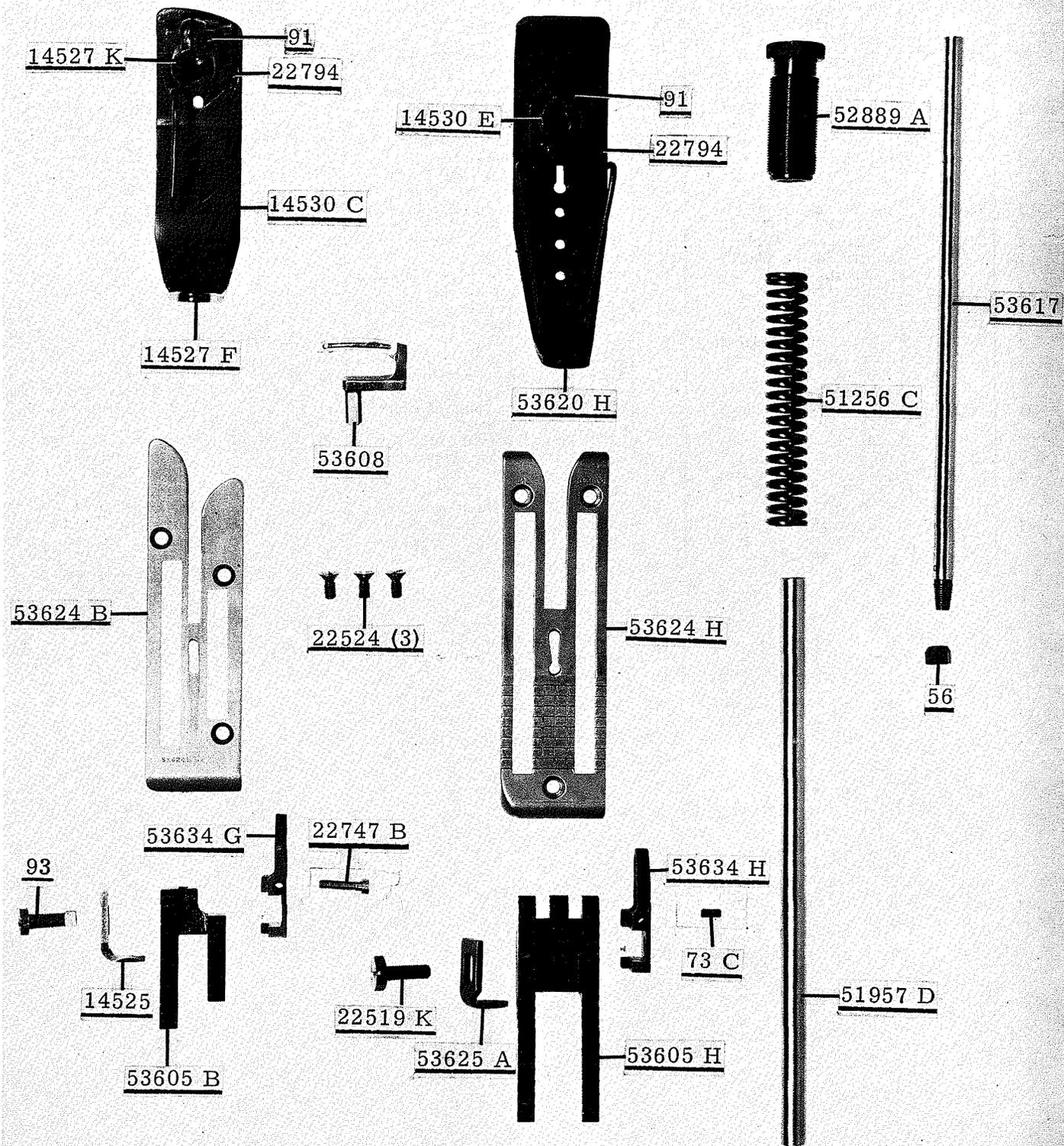
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Looper Drive Lever Shaft	1	666-47	Felt Oil Wick for 29126 CK	1	15430 D	Nut for needle lever connecting rod tube 51216, right thread
3	18	Nut for 29132 V, 51240 E, 51741 C	2	666-82	Felt for 51145, 51145 C	1	15465 F	Looper Rocker Cone for 29192P(22894W)
2	PI18	Pin for 666-82	2	666-120	Oil Wick for upper looper rocker shaft bushing and right looper drive lever shaft bushing	1	20162 G	Sewing Head A dapter (22642, 22637 F)
3	20	Washer for 539, 53659 H, 53758				2	21114 M	Eyelet Locking Ring for 51192 G
1	20	Washer for 51170 E				2	21114 M	Locking Ring for 53659 H
1	22 KH	Screw for 51204 A	5	666-148	Oil Tube Fitting	1	21382 G-26	Pulley Rim (22569)
1	50-703 Blk.	Lifter Lever Stop Pin for 53683	1	666-150	Felt Wick for 53693 G	4	22513	Screw for 35731 A
1	50-760 Blk.	Oil Gauge for 53694	1	666-152	Oil Wick for upper crankshaft bushing	1	22519 H	Screw for 51244 B
1	50-864 Blk.	Crankshaft Plug for 29476 FV	1	666-154	Felt Wick for 53693 B	1	22519 K	Screw for 53625 A Style 53600 H
			1	666-157	Main Oil Wick, 4 5/16 inches long	3	22524	Screw for throat plate
			2	666-158	Main Oil Wick, 1 15/32 inches long	1	22537	Screw for 53783 N
1	56	Needle Bar Nut	1	666-159	Main Oil Wick, 4 1/8 inches long	5	22539 L	Plug Screw
10	CO67 D	Oil Hole Plug	1	666-160	Oil Wick for upper mainshaft bushing	2	22541	Screw for 53682 S
1	CO67 H	Cork for bed	1	666-162	Main Oil Wick, 1 3/4 inches long	3	22541 B	Screw for 53682 R
1	CO67 H	Cork for filler cap	1	666-163	Oil Wick for upper & lower feed rocker shaft and lower main shaft bushing	1	22542	Screw for 51282 Y
1	73	Screw for looper	3	666-164	Oil Wick for right and left knife lever shaft and right looper drive lever shaft bushing	2	22542	Screw for 53682 H
1	73	Screw for 53659 G	1	666-165	Oil Wick for right looper drive shaft bushing	1	22557 B	Screw for 53783 L
1	73 C	Feed Dog Adjusting Screw Style 53600 H	1	666-170	Felt Wick for needle lever	2	22559 A	Bearing Cap Screw, lower, for 29105AB
1	75 C	Screw for 80675	1	666-175	Oil Wick for 29476 FV	2	22559 B	Bearing Cap Screw, upper, for 29105AB
1	77	Screw for 51236 A	1	666-176	Oil Wick for lower looper rocker shaft	2	22559 E	Screw for 29476 FV
1	77	Screw for 51054	1	666-178	Oil Wick	2	22560 B	Screw for 53783 C
2	80	Screw for 53680 F	1	666-205	Oil Wick for lower crankshaft bushing	1	22562 A	Screw for 51254 J
2	80	Screw for 53680 G	1	666-206	Oil Wick for lower crankshaft bushing	1	22564	Screw for 51054
1	87 U	Screw for 53659 J	1	667 B-12	Pin for 53642	3	22569	Screw for 21382G-26
2	J87 J	Screw for 51104 K	1	667 B-12	Pin for 53642 B	5	22569 B	Screw for 51282 Y
2	88	Screw for 14649	4	667 C-12	Dowel Pin for 53680 D, 56380 E	3	22569 B	Screw for 53690 A
1	88	Set Screw for 29132V	2	668-27	Eyelet for 51192 G	1	22571 B	Plug Screw
2	88	Screw for 53682 F	2	668-27	Eyelet for 53659 H	10	22571 D	Plug Screw
1	91	Screw for 14527 K	2	719	Screw for 51150, 51250 E	2	22580	Plug Screw for oil reservoir
1	91	Screw for 14530 E	1	1280	Nut for 53636 A	1	22580 D	Set Screw for 52423
1	93	Screw for 14525	1	1280	Nut for 53657 A	1	22585	Screw for 53657
1	93	Screw for 53634 A	1	9939 AA	Feed Rocker Shaft	1	22585 A	Screw for 53670
2	93 A	Screw for 51115 B	1	12982	Nut for 51241 D	1	22585 B	Screw for 53634 G, 53634 H
2	95	Plug Screw	1	14525	Needle Guard for Style 53600 A(93)	1	22586	Plug Screw for bed
2	95	Screw for 51147	1	14527 F	Presser Foot for Style 53600 A	2	22587 E	Screw for 29132 V (large ball end)
1	95	Screw for 53694	1	14527 K	Presser Foot Shank for 14527 F (91)	2	22593	Screw for 51104 L, 53658 A
1	96	Spot Screw for 52423	1	14530 C	Presser Foot Bottom for 14527 F	1	22597	Spot Screw for 53621
2	97 A	Screw for 29066 V	1	14530 E	Presser Foot Shank for 53620 H (91)	1	22597 A	Set Screw for 53621
2	97 A	Screw for 29132 V (small ball end)	3	14649	Collar for 8, 9939 AA (88)	2	22637 F	Screw for 20162 G
2	98	Screw for 53634	1	15430 C	Nut for needle lever connecting rod tube 51216, left thread	1	22642	Screw for 20162 G
2	98	Screw for 53635				4	22653 D-8	Socket Head Cap Screw for 53680 D, 53680 E
2	98	Screw for 53642 A				2	22704	Screw for 53659 A
1	98	Screw for 53678 G				1	22726 A	Screw for 53659 J
4	109	Tension Disc				2	22729	Screw for 51243 C
1	258 A	Nut for 666-28				2	22729 C	Screw for 51241 D
1	258 A	Lock Nut for 51745				2	22729 C	Screw for 51741 C
1	269	Nut for 51240 E				1	22747	Screw for 41255 B
1	402	Stud for 53783 A				1	22747 A	Screw for 51158 E (652 D-8)
1	482 C	Collar for 53644 (22894 C)				1	22747 B	Feed Dog Adjusting Screw Style 53600 A
1	539	Frame Ndl. Thread Eyelet (20, 22848)				1	22758 C	Screw for 53783 A
4	605 A	Screw for 53694 A				1	22764	Spot Screw for 29132 V
1	652 D-8	Washer for 22747 A				1	22768	Screw for 51244 B
1	660-212	Oil Seal Ring				1	22794	Hinge Screw for 14527 F
1	660-219 F	Cloth Plate Cover Spring Pin				1	22794	Hinge Screw for 53620 H
1	660-232	Ball Bearing for 53694				1	22798 A	Screw for 51204
1	666-28	Oil Cup for 51250 E, (258 A)						
1	666-29	Oil Wick for 666-28						
1	666-29	Oil Wick for 53693 A						
1	666-29	Oil Wick for 53693 F						
1	666-47	Felt Oil Wick for 53693 E						

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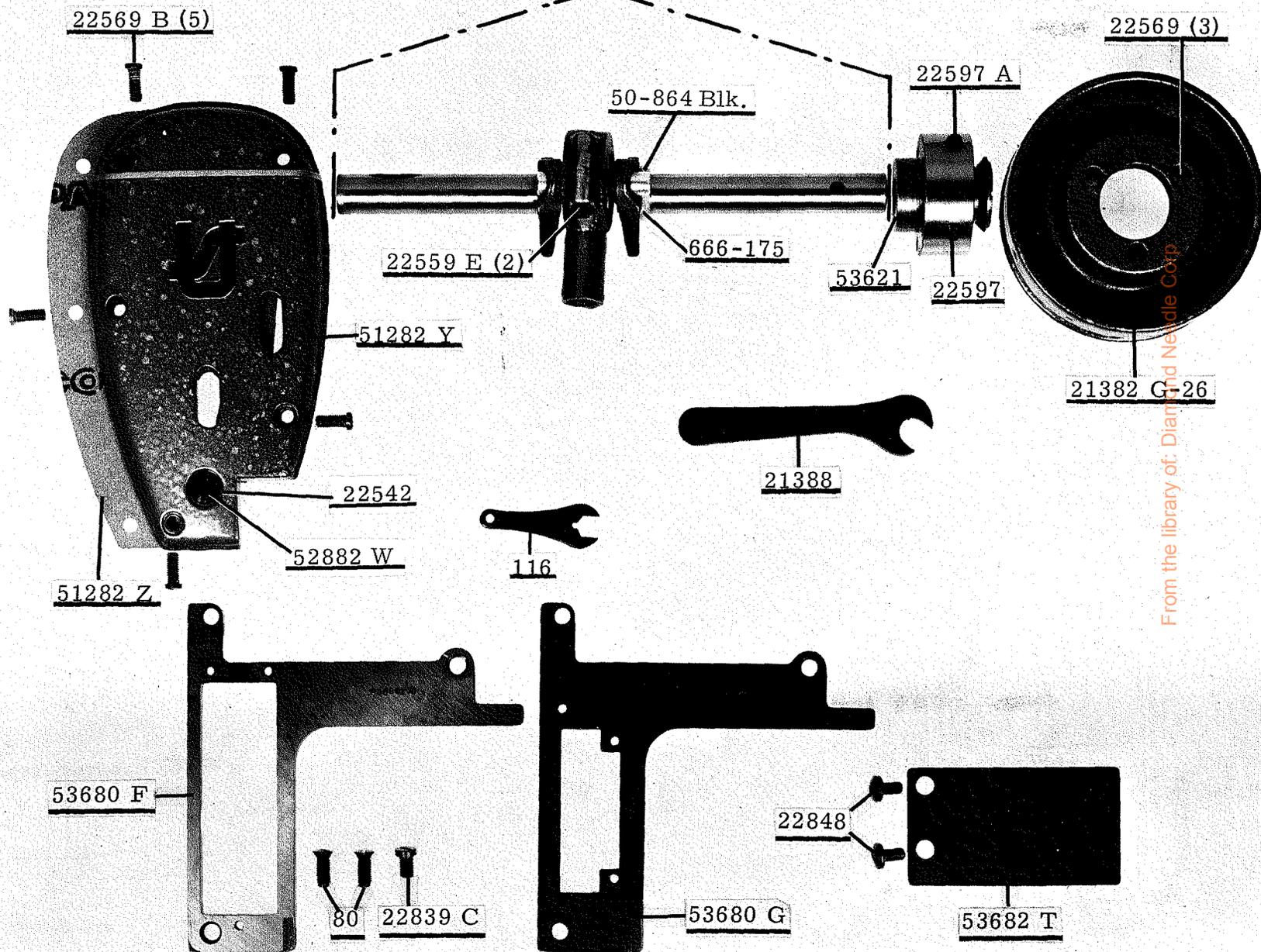
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	22829	Lock Nut Screw for 51745 (258 A)	1	51142 A	Feed Lift Eccentric for 29476 BL for Style 53600 A, .112 inch throw (22894D)	1	52882 P	Gasket for 53682 R
3	22839	Screw for 53694				1	52883 R	Presser Foot Lifter Lever Bushing
1	22839 C	Screw for 53680 F, 53680 G	1	51142 D	Feed Lift Eccentric for 29476 DM for Style 53600 H, .140 inch throw (22894D)	1	52883 S	Spring for 53783 L
1	22848	Screw for 539				1	52889 A	Presser Spring Regulator
1	22848	Screw for 51170 E				1	53556 C	Presser Bar Bushing, lower
2	22848	Screw for 53657				1	53605 B	Feed Dog for Style 53600 A (22596)
1	22848	Screw for 53659	1	51145	Feed Lift Eccentric Link for 29476 BL	1	53605 H	Feed Dog for Style 53600 H (22519 K)
1	22848	Screw for 53659 H				1	53608	Looper (73)
2	22848	Screw for 53682 C	1	51145	Feed Lift Eccentric Link for 29476 DM	1	53613	Looper Rocker for 29192 P
2	22848	Screw for 53682 T				1	53616 A	Needle Lever Connecting Rod Bearing, lower
2	22848	Screw for 53682 V	1	51145 C	Looper Avoid Eccentric Link for 29476 LT	1	53617	Needle Bar, marked "DS" (56)
1	22883 H	Adapter Plug Screw				1	53620 H	Presser Foot for Style 53600 H
1	22889 A	Adapter Screw for 539	1	51147	Crankshaft Collar (95)	1	53621	Pulley Hub (22597, 22597 A)
2	22894 C	Screw for 482 C	1	51150	Needle Lever Thrust Collar (719)	1	53622	Main Shaft
3	22894 C	Eccentric Set Screw for 29105 AB	1	51158 E	Needle Lever Thread Eyelet (652 D-8, 22747 A, 43443 Q)	1	53624 B	Throat Plate for Style 53600 A (22524)
2	22894 D	Eccentric Spot Screw for 29105 AB	1	51170 E	Frame Needle Thread Guide (20, 22848)	1	53624 H	Throat Plate for Style 53600 H (22524)
1	22894 D	Spot Screw for 51142 A	1	51170 E	Filler Cord Guide for Style 53600 H (20, 22848)	1	53625 A	Needle Guard for Style 53600 H (22519 K)
1	22894 D	Spot Screw for 51142 D	1	51192 B	Tension Post Ferrule	1	53634	Feed Bar (98)
1	22894 J	Set Screw for 53636 H	2	51192 G	Tension Eyelet	1	53634 A	Feed Bar Arm (93, 53634 C)
1	22894 K	Spot Screw for 53636 H	1	51204	Cast-off Wire for Style 53600 A (22798 A)	1	53634 B	Feed Bar Shaft
1	29066 V	Needle Lever Connecting Rod Upper Bearing Assembly	1	51204 A	Cast-off Wire Support for Style 53600 A (22 KH)	1	53634 C	Washer for 75 C, 53634 A
1	29105 AB	Looper Drive Eccentric Assembly, .374 inch throw	1	51216	Needle Lever Connecting Rod Tube (15430 C, 15430 D)	1	53634 G	Feed Dog Holder for Style 53600 A (22585 B, 22747 B)
1	29126 CK	Feed Driving Eccentric Assembly, .200 inch throw (eccentric No. 53636 H)	1	51236 A	Pin for 51145 (77)	1	53634 H	Feed Dog Holder for Style 53600 H (73 C, 22585 B)
1	29132 V	Knife Lever Eccentric Assembly, .160 inch throw (18)	1	51236 A	Pin for 51145 C (22768)	1	53635	Feed Rocker (98)
1	29192 P	Looper Rocker Assembly	1	51240 E	Connecting Rod (18, 269)	1	53636	Connecting Rod for 29126 CK
1	29348 D	Ndl. Lev. Assm.	1	51241 D	Looper Connecting Rod Ball Joint, left (12982)	1	53636 A	Feed Rocker Stud (1280)
1	29476 BL	Feed Lift Eccentric Assembly, .112 inch throw for Style 53600 A	1	51242 M	Washer for 52841 G	1	53636 B	Feed Drive Bushing for 29126 CK
1	29476 DM	Feed Lift Eccentric Assembly, .140 inch throw for Style 53600 H	2	51243 C	Ball Stud Fork (22729)	1	53636 C	Thrust Washer
1	29476 FV	Crankshaft Assembly 1,132 inch throw	1	51244 B	Looper Rocker Shaft Arm (22768, 22519 H)	1	53636 H	Feed Drive Eccentric, .200 inch throw for 29126 CK (22894 J, 22894 K)
1	29476 LT	Looper Avoid Eccentric Assembly, .112 inch throw	1	51246	Nut for 29192 P	1	53642	Looper Drive Lever for Style 53600 A (667 B-12)
2	35731 A	Presser Bar Connecting Guide Plate (22513)	1	51250 E	Needle Lever Stud for 29348 D (719)	1	53642 A	Looper Drive Lever Rocker (98)
1	39552 C	Washer for 53783 N	1	51254 D	Needle Bar Bushing, lower	1	53642 B	Looper Drive Lever for Style 53600 H (667 B-12)
1	41255 B	Fork for 29132 V (22747)	1	51254 J	Needle Bar Conn. for 29348 D (22562 A)	1	53642 G	Looper Drive Plunger
1	43443 Q	Nut for 22747 A	1	51256 C	Presser Bar Spring	1	53642 H	Plunger Spring
1	51004	Auxiliary Cast-off for Style 53600 A	1	51282 Y	Head Cover (22569B)	1	53642 J	Looper Drive Lever Lock Plunger Stud
2	51054	Link Pin for 29348 D (77, 22564)	1	51282 Z	Gasket for 51282 Y	4	53642 N	Looper Drive and Feed Rocker Bushing
1	51104 K	Auxiliary Cast-off Support for Style 53600 A (J87 J)	2	51292	Tension Post	1	53644	Looper Rocker Shaft
1	51104 L	Cast-off Wire for Style 53600 A (22593)	2	51292 C	Tension Nut	2	53644 A	Looper Rocker Shaft Bushing
1	51115 B	Needle Lever for 29348 D (77, 93 A, 22564)	1	51292 F-2	Tension Spring for looper Style 53600 A	1	53654	Needle Bar Bushing, upper
1	51134 P	Lubricating Felt	1	51292 F-5	Tension Spring for looper Style 53600 H	1	53657	Cast-off Support Plate for Style 53600 A (22585, 22848)
1	51134 R	Lubricating Felt Guard	1	51292 F-8	Tension Spring, needle	1	53657 A	Supp. Plate Stud for Style 53600 A (1280)
1	51142 A	Looper Avoid Eccentric for 29476 LT, .112 inch throw (22894 D)	1	51741 C	Looper Connecting Rod Ball Joint, right (18)			
			1	51741 E	Washer for 51741 C			
			1	51745	Looper Rocker Cone Stud for 29192 D (258 A, 22829, 51246)			
			1	51957 D	Presser Bar			
			1	52423	Take-up for Style 53600 A (96, 22580 D)			
			1	52841 G	Locking Stud for 53642 A (51242 M, 52841 H)			
			1	52841 H	Nut for 52841 G			

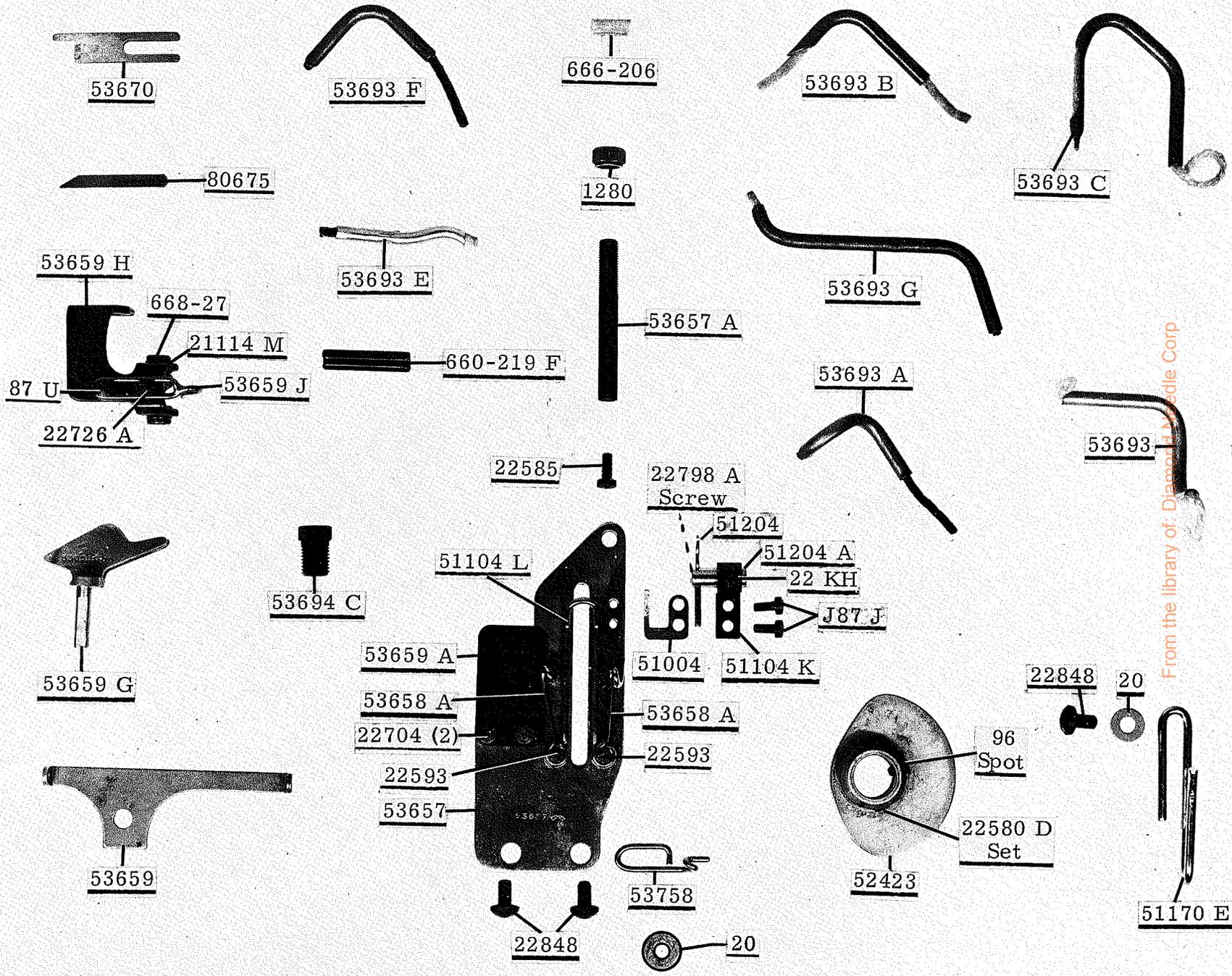
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
2	53658 A	Cast-off Plate Eyelet for Style 53600 A (22593)	1	53682 C	Hinge for cloth plate cover, right (22848)	1	53693 E	Oil Tube for crankshaft
1	53659	Thread Eyelet for Style 53600 A (22848)	1	53682 E	End Cover, bottom	1	53693 F	Oil Tube for knife eccentric
1	53659 A	Thread Guard for Style 53600 A (22704)	2	53682 F	End Cover Hinge Pin (88)	1	53693 G	Oil Tube for looper drive eccentric
1	53659 G	Looper Thread Pull-off for Style 53600 H (73)	1	53682 H	Cloth Plate Cover Spring (22542)	3	53693 H	Oil Seal Washer
1	53659 H	Looper Thread Pull-off Eyelet for Style 53600 H (20, 22848)	1	53682 J	Latch Pin	1	53694	Oil Reservoir (22839)
1	53659 J	Looper Thread Pull-off Wire for Style 53600 H (22726 A)	1	53682 K	Cloth Plate Cover Spring Clamp Plate	1	53694 A	Oil Reservoir Cover (605 A)
1	53670	Knife, upper (22585 A, 53678 N)	1	53682 L	Cloth Plate Cover Hinge Pin, right	1	53694 B	Oil Reservoir Cover Gasket
1	53678 C	Knife Lever Spring	1	53682 P	End Cover Latch Pin Spring	2	53694 C	Oil Tube Coupling
2	53678 D	Knife Rocker Shaft Bushing	1	53682 R	Chamber Cover (22541 B)	1	53694 D	Oil Filter for 53694
1	53678 F	Knife Arm Shaft	1	53682 S	End Cover Hinge Pin Bar (22541)	1	53694 E	Bushing for 53694
1	53678 G	Knife Lever (98)	1	53682 T	Cover Plate for Style 53600 H (22848)	2	53694 F	Gasket for 53694
1	53678 N	Washer for 22585 A	1	53682 U	Cloth Plate Cover, right	1	53694 G	Oil Reservoir Wick
1	53680 D	Throat Plate Support Bracket, left (667 C-12, 22653 D-8)	1	53682 V	Cloth Plate Cover, left (22848)	1	53694 H	Elbow for 53694
1	53680 E	Throat Plate Support Bracket, right (667 C-12, 22653 D-8)	1	53683	Presser Foot Lifter	1	53758	Thread Eyelet (20, 22848)
1	53680 F	Throat Plate Support for Style 53600 H (80, 22839 C)	1	53690 A	Main Shaft Housing (22569 B)	1	53783 A	Presser Foot Lifter Lever Link (402, 22758 C)
1	53680 G	Throat Plate Support for Style 53600 A (80, 22839 C)	1	53690 B	Bushing for 53690A	1	53783 C	Presser Bar Connection and Guide (22560 B)
			3	53690 C	Main Shaft Bushing, lower	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)
			1	53693	Oil Tube for main oil wick	1	53783 M	Presser Foot Lifter Lever Connecting Rod
			1	53693 A	Oil Tube for looper connecting rod ball joint, left	1	53783 N	Presser Foot Lifter Lever, internal (22537, 39552 C)
			1	53693 B	Oil Tube for looper avoid eccentric	1	56354 A	Needle Lever Link for 29348 D
			1	53693 C	Oil Tube for feed eccentric connecting rod	1	56390 E	Crankshaft Bearing Housing Gasket
						1	61351 C	Washer for 53678 C
						1	80675	Knife, stationary (75 C, 53634 C)

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

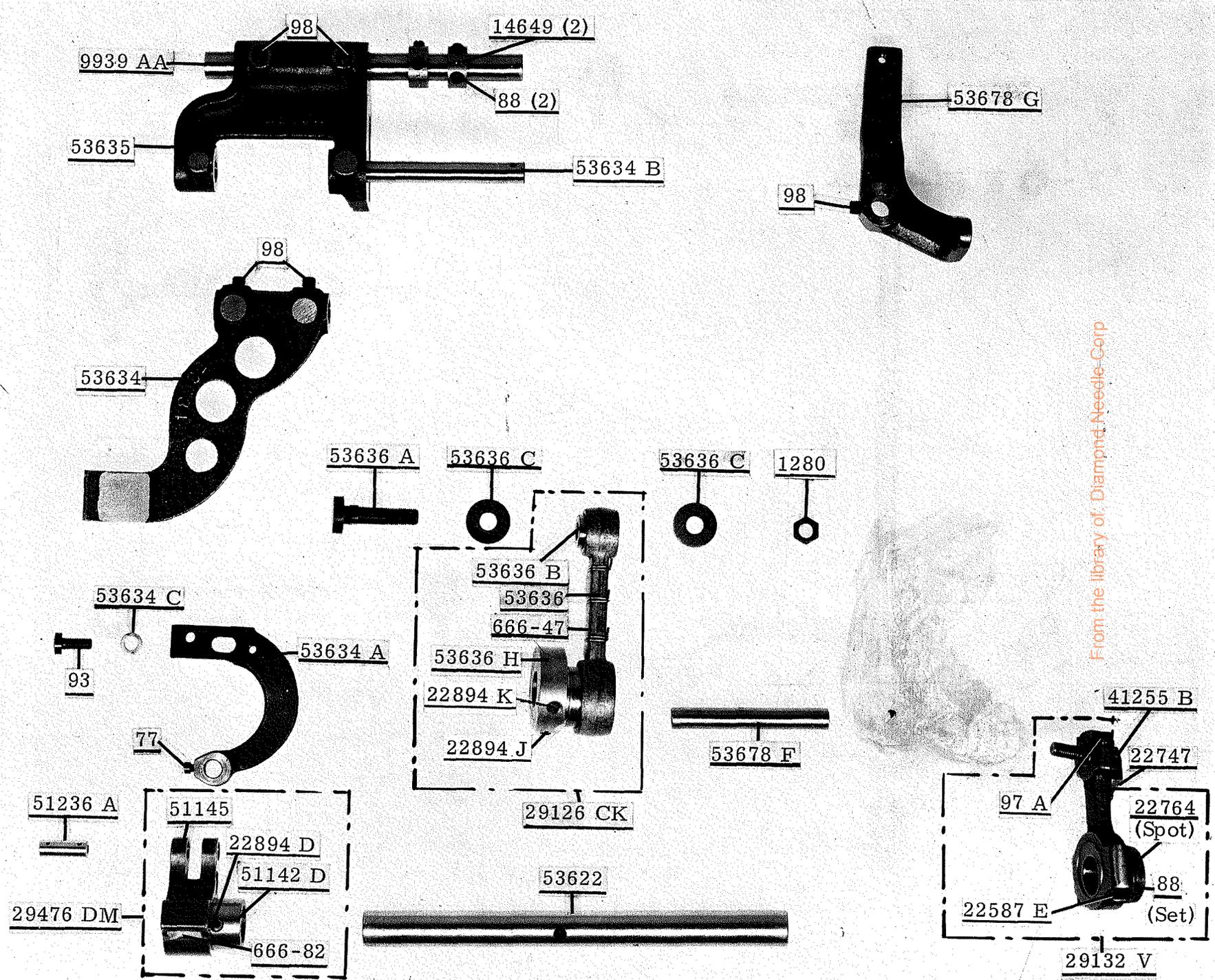


29476 FV Crankshaft Complete

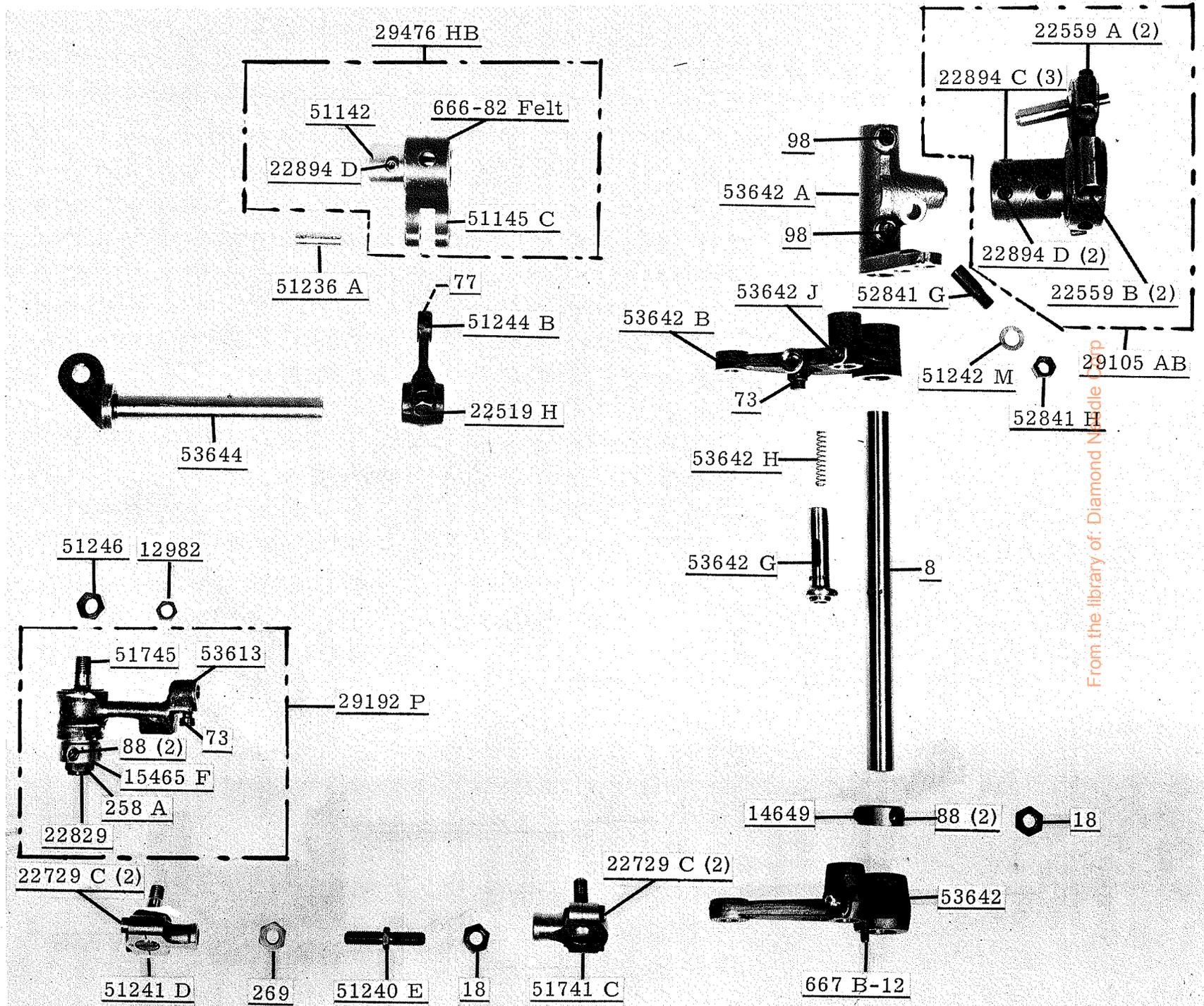


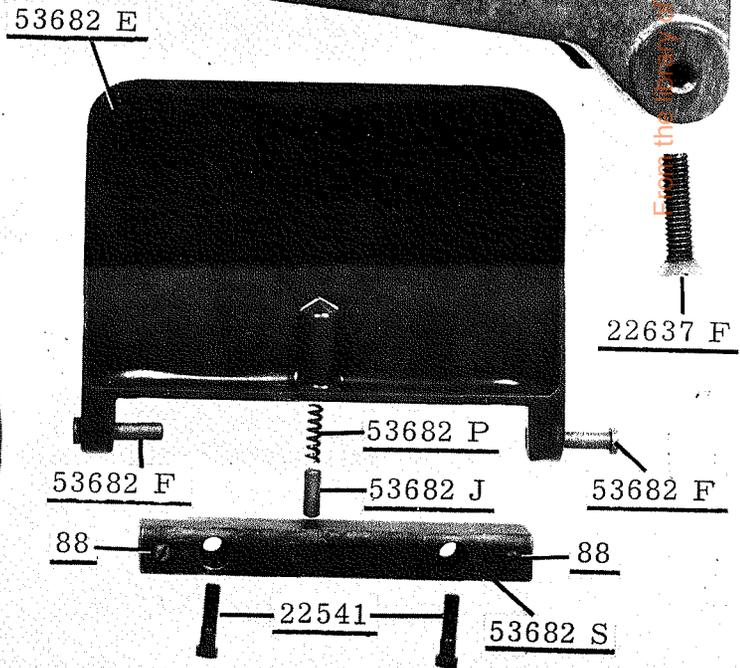
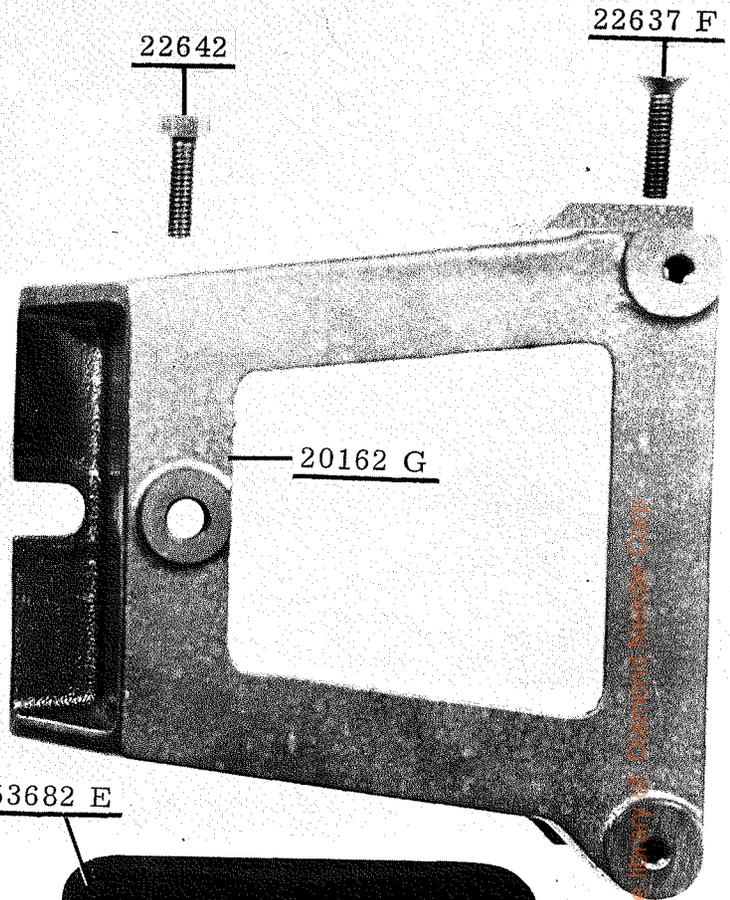
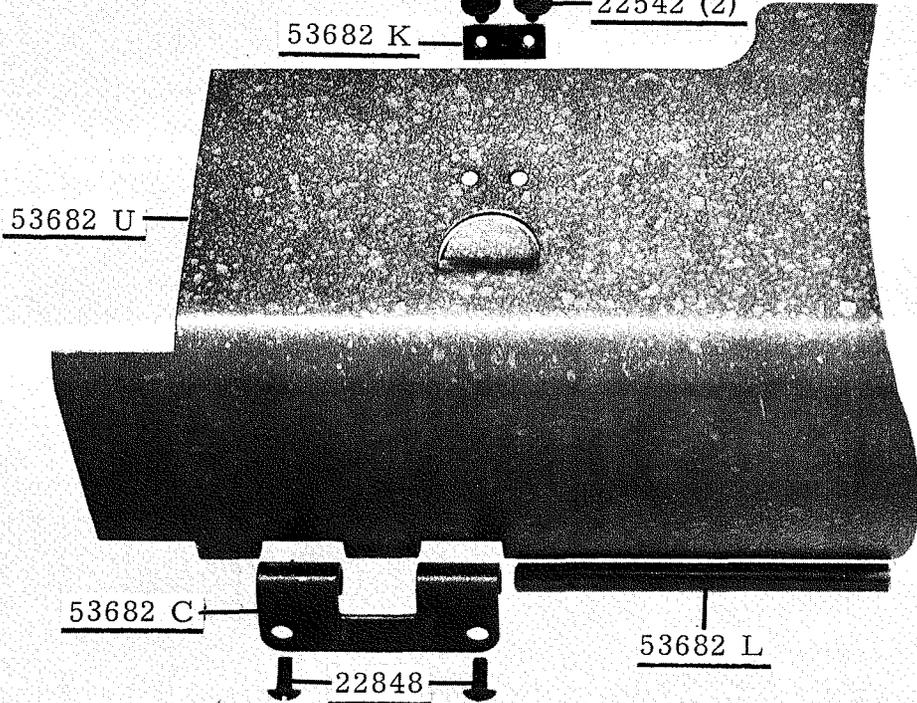
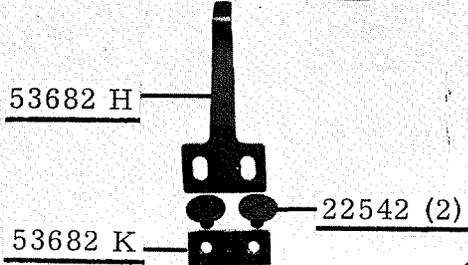
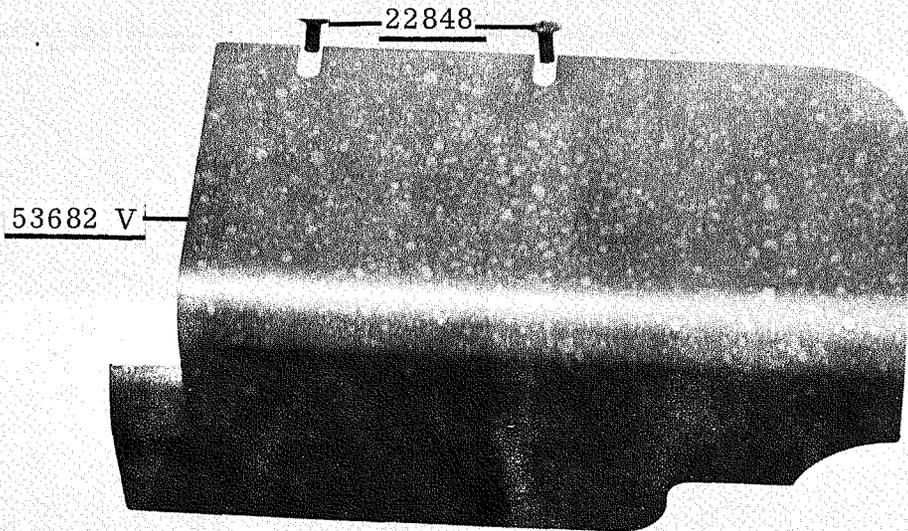


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From the library of: Diamond Needle Corp





From the Library of Diamond Aircraft Corp

# Here are Oil Specifications for Union Special Sewing Machines



From the library of: Diamond Needle Corp

**Specification 174** specifies a high quality petroleum oil, viscosity 100 seconds at 100°F. Recommended for all oiling applications on high speed machines.

**Specification 175** specifies a high quality petroleum oil, viscosity 100 seconds at 100°F., water white or with a maximum A.S.T.M. color number of 1. *For use where freedom from oil staining is paramount.*

**Specification 87** specifies a high quality petroleum oil, viscosity 300 seconds at 100°F.

**Specification 100** specifies a general purpose high quality grease for use in ball bearings and transmitters. It is similar to commercial N.L.G.I., grease No. 3. Where No. 3 grease is not obtainable, No. 2 may be used.

## UNION SPECIAL

SPECIFICATION NO.	174	175	87
Viscosity S.S.U. at 100°F	90-125	90-125	300-350
Flash (Min.)	350	350	350
Pour (Max.)	20	20	20
Color A.S.T.M. (Max.)	3	1	3
Neutralization No. (Max.)	0.10	0.10	0.10
Viscosity Index			
(D & D Min.)	85	85	85
Compounding	None	None	None
Copper Corrosion (Max.)	1A	1A	1A

\*Anline No. 175-225 175-225 175-225

\*Used with Buna N Rubber "O" Retainers

**NOTE 1:** The use of non-corrosive additives in oils meeting above classification is desirable but not essential. These may include:

1. Oxidation inhibitors
2. Rust inhibitors
3. Lubricity additives
4. Anti-oxidants
5. Film strength additives

These additives must be completely soluble in the oil and not removable by wick feeding nor shall they separate.

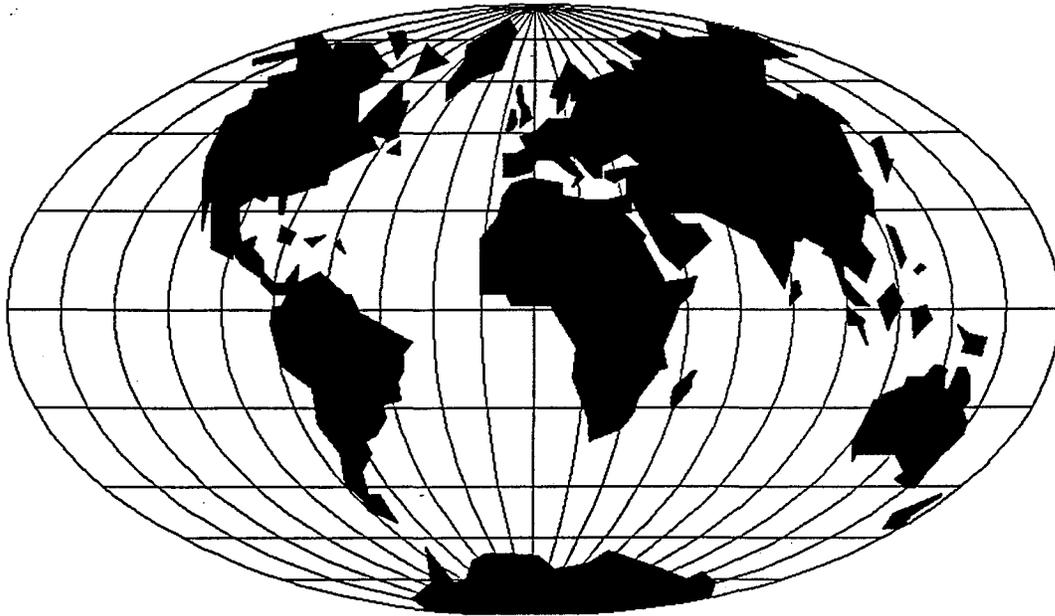
**NOTE 2:** Oils containing the following type additives shall not be used at any time:

1. Extreme pressure additives—corrosive
2. Tackiness or adhesive additives
3. Lead soap additives
4. Detergents



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