

**THIRD
EDITION**



Union Special
INDUSTRIAL SEWING EQUIPMENT

CATALOG NO. T83T

STYLES
61400M
61400T
61400W

Catalog No. T83 T

LIST OF PARTS

Styles

61400 M 61400 T
 61400 W

Top and Bottom Roller Feed Machines

Third Edition

Copyright 1957
by
Union Special Corporation
Rights Reserved in All Countries

UNION SPECIAL CORPORATION
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U.S.A.

February, 1977

IDENTIFICATION OF MACHINES

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 61400 M". 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 61400 MZ".

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: "61400".

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 61400. Catalog No. 83 R may prove helpful for illustrations not shown in this catalog. 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 the handwheel is toward the operator.

STYLES OF MACHINES

61400 M Streamlined, modified lockstitch machine, for circular work, automatically synchronized power driven, top and bottom roller feed, 1 13/64 inch needle bar travel, automatic lubrication for lower mechanism, visible oil supply, equipped with hemmer for making 3/8 to 1/2 inch turned down hem on overalls, dungarees and similar garments. Seam specification 301-EFb-1, inverted. Type 180 GYS needle.

61400 T Streamlined, modified lockstitch machine, for circular work, automatically synchronized power driven top and bottom roller feed, 1 13/64 inch needle bar travel, automatic lubrication for lower mechanism, visible oil supply, for making a hand turned hem from 1/2 to 2 1/2 inches wide on children's wear, men's dress pants, semi-work pants and work pants. Seam specification 301-EFb-1 or EFa-1. Type 180 GXS needle.

61400 W Streamlined, modified lockstitch machine, automatically synchronized power driven top and bottom roller feed, 1 13/64 inch needle bar travel, automatic lubrication for lower mechanism, visible oil supply, for topstitching waistbands on twill and woolen pants. Seam specification 301-SSa-1. Type 180 GYS needle.

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 the blade, measured in thousandths of an inch, across the eye. Collectively, type and size number represents the complete symbol.

NEEDLES (Continued)

The type numbers of the needles recommended for each style of machine covered by this catalog are given in the machine style description. Other needles are available, but the ones indicated are those recommended to produce the most satisfactory results. The type numbers of the recommended needles together with their descriptions, and the sizes available are listed below:

<u>Type No.</u>	<u>Description and Sizes</u>
180 GXS	Round shank, round point, lockstitch, short length, ball eye, single groove, wide angle groove, struck groove, deep spot, ball point, chromium plated - sizes 075/029, 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060
180 GYS	Round shank, round point, lockstitch, short length, ball eye, single groove, wide angle groove, struck groove, deep spot, chromium plated - sizes 075/029, 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060

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 180 GXS, Size 140/054".

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

Where the 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 the catalog in which they appear.

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

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*. 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.

TERMS

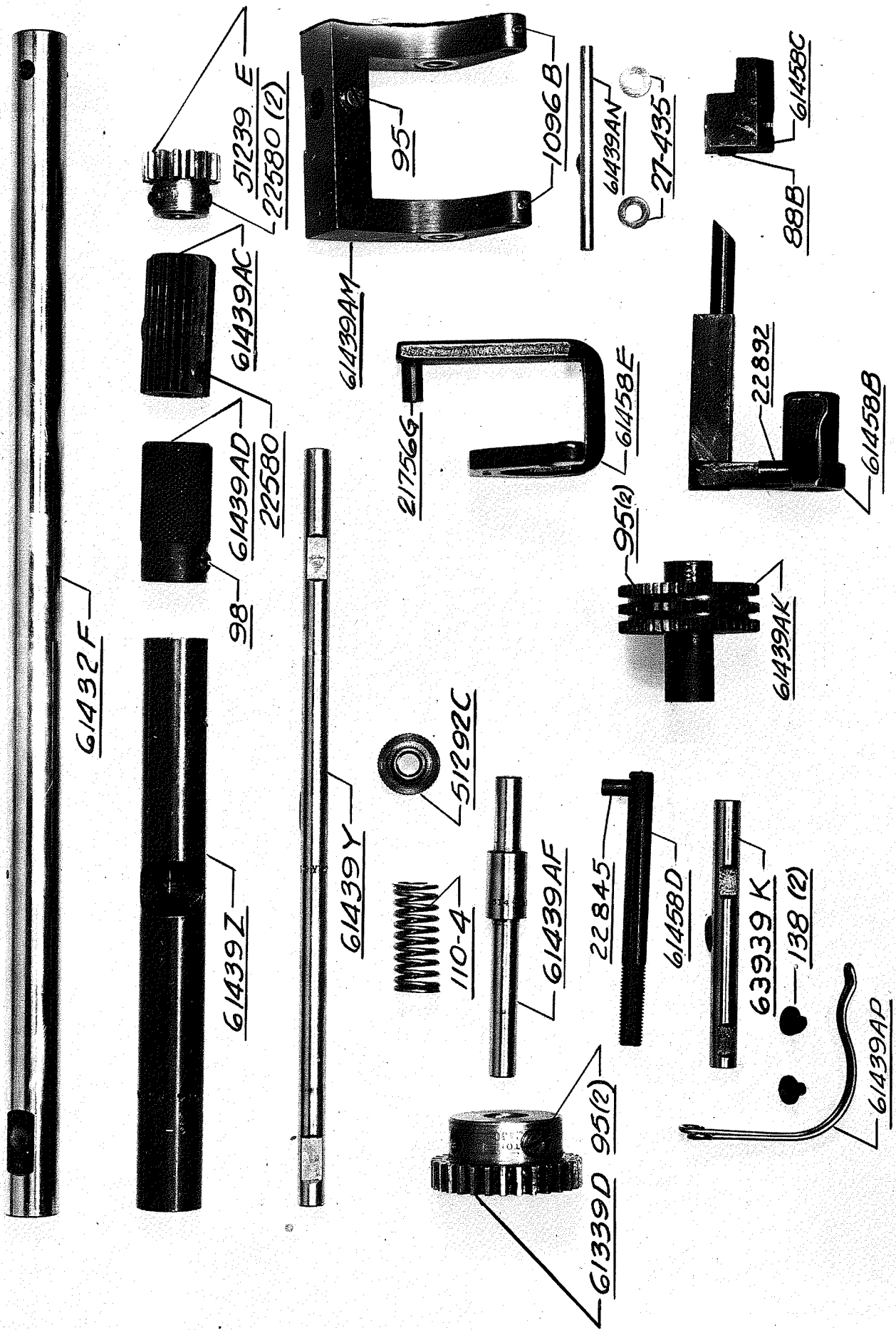
Prices are net cash and subject to change without notice. All shipments are forwarded f.o.b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

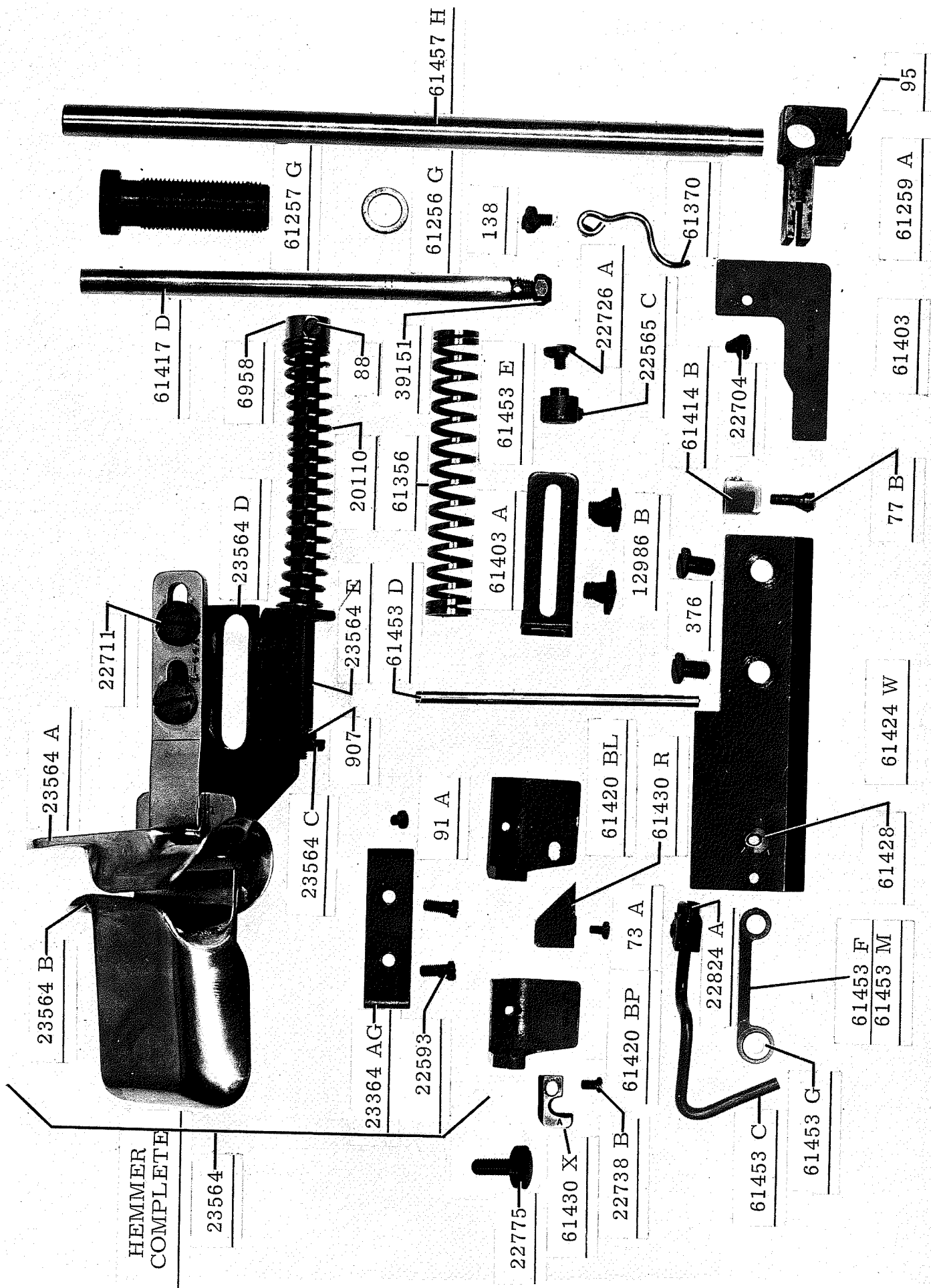
The following is a numerical list of the parts used in this machine. Quantities, part numbers, and descriptions are given. Following the parts list are photographs of some of the major parts.

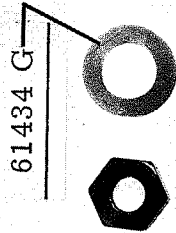
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	18	Nut for 22832 G	2	22565 C	Screw for 51239 T	1	29126 CV	Top Roller Feed Drive
4	27-435	Blk. Washer for 61439 AN	1	22565 C	Screw for 61453 E			Eccentric Assembly
3	28-95	Blk. Spring Stop on 61339 R	2	22569 B	Screw for head cover			(22832 G)
1	28 C	Needle Clamp Screw for 61417 C	3	22569 C	Screw for 61494 A	1	29474 G	Rotating Hook
1	50-223	Blk. Rivet for 61351 L	3	22569 H	Hook Set Screw			Assembly
1	50-567	Blk. Oil Sight Gauge on 61494	1	22570 A	Screw for 61271	1	29475 AA	Tension Assembly
1	50-568	Blk. Oil Gauge	6	22570 A	Screw for 61382 L			(22597 E, 22863 B)
4	HA61 D	Screw for 61264, 61264 A	4	22570 A	Screw for 61382 M	1	39151	Needle Clamp Nut for 61417 D
1	73 A	Screw for 61430 R	4	22570 A	Screw for 61439 AB	6	41258	Feed Clutch Roller
1	77 B	Screw for 61414 B	1	22570 B	Screw for 61391 D	1	41358 M	Clutch Barrel (22597 B)
1	88	Screw for 6958	3	22574	Screw for 61321 J	1	41358 N	Clutch Block, right (22747)
2	88	Screw for 61242	4	22580	Screw for 51239 E			
1	88 B	Screw for 61458 C	1	22580	Screw for 61439 AC	1	41358 P	Clutch Block, left (22747)
2	89	Screw for 61244	2	22585 A	Screw for 61351 J	6	41358 Q	Feed Clutch Roller
1	89	Screw for 61449 AA	2	22593	Screw for 23564 B			Spring
1	89	Screw for 61492	2	22596 D	Adjusting Screw for 61391 D (8372 A)	6	41358 S	Clutch Spring Support Pin
1	91 A	Screw for 23564 D	1	22597 A	Screw for 61251 D	6	41358 T	Support Pin Washer
2	93	Screw for 23564 G	1	22597 B	Screw for 62262	1	41390 E	Bushing for 61439 G
2	93	Screw for 61482	3	22597 E	Screw for 61358 M	1	51239 B	Feed Clutch Check Plate Pin (22729)
1	93	Screw for 61482 L	1	22704	Set Screw for tension assembly			15 tooth Gear (22580)
1	95	Screw for 61259 A	2	22711	Screw for 61403	2	51239 E	Universal Joint (22894 T)
4	95	Screw for 61339 D	2	22711	Screw for 23564	2	51239 G	Roller Feed Clutch Shaft
2	95	Screw for 61439 AK	1	22712 F	Screw for 23564 A	1	51239 S	Roller Feed Clutch
2	95	Screw for 61439 AM	4	22716 A	Screw for 61368 F			Shaft
1	96	Screw for 61454 D	1	22716 B	Screw for 61210 B	1	51239 T	Roller Feed Clutch Brake (22565 C)
1	96 A	Screw for 61341 C	3	22716 H	Screw for 61414 C	1	51239 U	Roller Feed Clutch Brake Washer
2	98	Screw for 2339 F	2	22560 A	Screw for 61411 A	1	51292 C	Presser Foot Tension Regulating Nut
1	98	Screw for 61439 AD	1	22562 B	Screw for 61437 A	1	61149 G	Stitch Eccen., .078 inch throw, for 29126 CV
2	109	Tension Disc for 29475 AA	3	22564 B	Screw for 61255	1	61149 H	Friction Disc for 61149 G
1	110-4	Presser Foot Tension Regulating Spring	1	22726 A	Screw for 61437 C	1	61208 B	Rotating Hook for 29474 G
1	138	Screw for 61370	1	22729	Screw for 61453 F, M	1	61210 B	Hook Thread Guard for 29474 G (22716 A)
2	138	Screw for 61439 AP	1	22730	Screw for 61267	1	61212	Bobbin for 29474 G
2	376	Screw for 61424 W	1	22738 B	Screw for 61430 X	1	61216	Hinge Pin for 61415
2	454 A	Washer for 22891	1	22738 F	Screw for 61430 BX	1	61216 N	Bobbin Case Spring
1	652 B-20	Lock Washer for lifter lever stud	1	22747	Screw for 41358 N, P	1	61236	Bushing for 61261 A
1	660-142	Spring Cotter Pin for 61368 A	1	22757 C	Screw for 61255 H	1	61242	Hook Shaft Collar (88)
1	660-205	Retaining Ring for 61251 D	1	22758 B	Screw for 61267	1	61244	Hook Shaft Pinion Gear (89)
1	660-226	Needle Bearing for 61439 AJ	1	22775	Screw for presser foot on 61400 M, T	1	61251 D	Take-up Lever Pin (660-205, 22597 A)
2	660-249	Needle Bearing for 61439 AM	1	22775	Screw for 61430 U	1	61252 J	Take-up Lever Link
1	660-257	Washer for 22730	1	22775	Stud for 61468	1	61255	Take-up Lever Crank Pin
2	666-20	Oil Wick	1	22775	Screw for 61453 C	1	61255 H	Needle Bar Connecting Stud (22562 B)
1	666-104	Oil Wick for main shaft housing	2	22824 A	Screw for 61482 A	1	61256 G	Needle Bar Link (22757 C)
2	666-126	Oil Wick for 61293	1	22829	Screw for 29126 CV (18, 61434 G)	1	61257 G	Presser Spring Washer
1	666-127	Felt Oil Wick for 61393 C	1	22832 G	Screw for 61458 D	1	61259 A	Presser Bar Bushing, upper
1	907	Adjusting Screw Nut for 23564	1	22845	Adjusting Screw for tension assembly	1	61260 A	Presser Bar Guide (95)
2	1096 B	Screw for 61439 AN	1	22863 B	Screw for 61439 G (9937, 80557)	1	61261 A	Feed Driving Shaft Gear (22884)
1	2339 F	Thrust Collar for lower main shaft	1	22874	Screw for 61468 (9937)	1	61264	Feed Driving Shaft Intermediate Gear
1	6958	Collar for 23564 E (88)	1	22874 F	Spot Screw for 61391 D	1	61264 A	Intermediate Gear Shaft Collar, right (HA61 D)
2	8372 A	Washer for 61391 D	1	22880	Screw for 61439 F	1	61267	Intermediate Gear Shaft Collar, left (HA61 D)
2	9937	Nut for 22874	1	22882	Screw for 61260 A	1	61267 G	Lifter Lever Link (22758 B)
1	9937	Nut for 22874 F	2	22884	Screw for 61360	1	61271	Spring Pin for release lever
2	12986 B	Screw for 61403 A	1	22884	Screw for 61360 G	1	61282 D	Frame Needle Thread Eyelet (22570 A)
1	15872 F	Spring for release lever	1	22890	Screw for 61466 A	2	61282 E	Gasket for 61382 L
1	20110	Spring for 23564 E	2	22891	Screw for 61439 G (454 A)	1	61292 C	Gasket for 61382 M
1	21629	Stud for 61430 BW	1	22892	Screw for 61458 B	1	61292 G	Nut for 61492
1	21756 G	Stud for 61458 E	2	22894 J	Screw for 61443			Tension Release Pin
1	21756 G	Stud for 61458 H	2	22894 T	Screw for 51239 G			
2	22539 D	Plug Screw for base	2	22894 V	Screw for 61391 D			
2	22564 E	Screw for 61414 C, 61415 A	1	23364 AG	Hemmer Scroll Slide Spring			
1	22564 F	Screw for 61413 G	1	23564	Hemmer, comp., for 61400 M (907, 22711)			
			1	23564 A	Hemmer Scroll, right (22711)			
			1	23564 B	Hemmer Scroll, left (22593)			
			1	23564 C	Hemmer Scroll Slide			
			1	23564 D	Hemmer Base (91 A)			
			1	23564 E	Operating Rod (20110)			
			1	23564 G	Hemmer Mounting Bracket for 61400 M (93)			

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	61292 H	Release Washer for 29475 AA	1	61403 A	Edge Guide Mounting Bracket for 61400 T (12986 B)	1	61439 AJ	Connecting Rod for 29126 CV (660-226)
2	61293	Oil Tube (666-126)	1	61411 A	Thread Retainer for 29474 G (22716 H)	1	61439 AK	Top Feed Roller (95)
2	61293 N	Plug for inside of arm	1	61413 E	Bobbin Case Assembly for 29474 G	1	61439 AM	Presser Bar Roller Bracket (95, 660-249)
1	61321 J	Handwheel for 61421 (22574)	1	61413 F	Bobbin Case	1	61439 AN	Presser Foot Shank Pin (1096 B)
1	61321 L	Washer for 61421	1	61413 G	Bobbin Case Eyelet	1	61439 AP	Upper Roller Cloth Stripper (138)
1	61322 B	Main Shaft	1	61414	Bobbin Case Holder for 29474 G	1	61439 AT	Bushing for 61439 Z
1	61339 B	Ball Washer for 29126 CV	1	61414 B	Bobbin Case Holder Position Finger (77 B)	1	61443	Hook Shaft Driving Gear (22894 J)
2	61339 D	Top and Bottom Roller Feed Driving Gear (95)	1	61414 C	Bobbin Case Tension Spring (22564 E, 22716 B)	1	61449 B	Spring for 29126 CV
1	61339 E	Feed Driving Shaft, right	1	61415	Bobbin Case Latch (61216)	1	61449 AA	Stitch Regulating Collar (98)
1	61339 R	Feed Driving Clutch Lever	1	61415 A	Bobbin Case Latch Lever (22564 E)	1	61451 C	Thrust Washer for 61351 L
1	61339 S	Feed Clutch Check Plate	1	61417 C	Needle Bar for 61400 W (28 C)	1	61453	Spring for 29475 AA
1	61340 C	Hook Shaft	1	61417 D	Needle Bar for 61400 M, T (39151)	1	61453 C	Take-up Spring Thread Wire (22824 A)
1	61341 C	Hook Shaft Bushing, left (96 A)	1	61420 BL	Presser Foot for 61400 T (22775)	1	61453 D	Thread Control Shaft
1	61341 D	Hook Shaft Bushing, right	1	61420 BP	Presser Foot for 61400 M (22775)	1	61453 E	Thread Control Shaft Block (22565 C)
1	61341 G	Oil Seal Washer	1	61420 CF	Presser Foot for 61400 W	1	61453 F	Thread Control Link, for 61400 M, T (22726 A)
2	61341 J	Thrust Washer for hook shaft	1	61421	"V" Belt Pulley Assembly	1	61453 G	Thread Control Link Spacer
1	61351 C	Thrust Washer	1	61421 A	Pulley Hub for 61421	1	61453 L	Thread Controller Shaft Bushing
1	61351 J	Frame Take-up Thread Eyelet (22585 A)	1	61424 W	Throat Plate (376)	1	61453 M	Thread Controller Link for 61400 W (22726 A)
38	61351 K	Needle Bearing Roller	1	61428	Needle Hole Insert for 61424 W	1	61454	Needle Bar Bushing, lower
1	61351 L	Take-up Lever (61451 C)	1	61430 R	Guide for 61420 BL (73 A)	1	61454 D	Needle Bar Bushing, upper
1	61351 M	Eyelet for 61351 L	1	61430 U	Presser Foot Bottom for 61420 CF (22775)	1	61457 D	Presser Bar Bushing, lower
1	61351 Q	Take-up Lever Assembly	1	61430 V	Yielding Spring for 61420 CF (22798 A)	1	61457 H	Presser Bar
1	61356	Presser Spring	1	61430 X	Needle Guard for 61420 BP (22738 B)	1	61458 B	Presser Bar Connection (22892)
1	61360	Main Shaft Driving Gear (22884)	1	61430 BW	Edge Guide for 61420 CF (21629)	1	61458 C	Presser Foot Lifter Block (88 B)
1	61360 G	Feed Driving Shaft Collar (22884)	1	61430 BX	Edge Guide Block for 61420 CF (22738 F)	1	61458 D	Presser Foot Tension Bar (22845)
1	61366 C	Lifter Lever Extension Stud for 61368 A	1	61432 B	Feed Driving Shaft Bushing, right	1	61458 E	Presser Foot Shank for 61400 M, T (21756 G)
1	61368	Lifter Lever Connecting Rod for 61368 A	1	61432 C	Feed Driving Shaft Bushing, left	1	61458 H	Presser Foot Shank for 61420 CF (21756 G)
1	61368 A	Lifter Lever Extension Stud and Lifter Lever Connecting Rod, complete (660-142)	1	61432 F	Lower Main Shaft	1	61466 A	Lifter Lever (22890)
1	61368 F	Bell Crank Roller (22712 F)	1	61434 G	Washer for 29126 CV	1	61468	Lifter Lever Bell Crank (22817 A, 22874 F)
1	61370	Needle Thread Guide (138)	1	61437 A	Eccentric Timing Collar for 29126 CV (22560 A)	1	61482	Hook Guard for 61400 M, T (93)
1	B61382 H	Head Cover for 61400 M, T (22569 B)	1	61437 B	Pivot Pin for 29126 CV	1	61482 A	Cloth Guard (22829)
1	61382 L	Housing Cover, right (22570 A)	1	61437 C	Eccentric Housing for 29126 CV (22564 B)	1	61482 B	Hook Shaft Gear Case Cover (660-257, 22570 A, 22730)
1	61382 M	Housing Cover, left (22570 A)	1	61439 F	Top Roller Feed Clutch Housing Support Bracket (22882)	1	61482 L	Cloth Plate Extension for 61400 W (93)
1	61391 D	Main Shaft Counterweight (22570 B, 22596 D, 22880, 22894 V)	1	61439 G	Feed Clutch Housing (22874, 22891)	1	61482 N	Head Cover for 61400 W
1	61392 F-14	Tension Spring for 29475 AA	1	61439 Y	Lower Feed Drive Shaft	1	61490	Main Shaft Bearing Housing and Bushing, right
1	61393 B	Oil Tube for upper main shaft (666-20)	1	61439 Z	Lower Feed Driving Shaft Housing	1	61490 A	Main Shaft Bushing, left
1	61393 C	Oil Tube (666-127)	1	61439 AA	Bushing for 61439 Z	1	61492	Tension Post for 29475 AA (89, 61292 C)
1	61394 L	Oil Reservoir Securing Screw (61494 U)	1	61439 AB	Shaft Housing Clamp Plate (22570 A)	1	61492 A	Tension Post Socket for 29475 AA
1	61394 M	Gasket for 61394 AC	1	61439 AC	Feed Roller, lower, for 61400 M (22580)	1	61494	Hook Oil Reservoir
1	61394 AC	Filler Hole Plug Screw	1	61439 AD	Feed Roller, lower, for 61400 T, W (98)	1	61494 A	Reservoir End Cover (22569 C)
1	61394 AE	Oil Cup	1	61439 AE	Top Roller Feed Shaft Guard	1	61494 B	End Cover Gasket
2	61394 AF	Reservoir Gasket, left	1	61439 AF	Top Roller Feed Shaft Guard	1	61494 U	Washer for 61394 L
1	61396 F	Hook Shaft Oil Metering Insert	1			1	62262	Intermediate Gear Shaft (22597 A)
1	61403	Edge Guide for 61400 T (22704)	1			1	63939 K	Top Feed Roller Shaft
						1	80557	Washer for 22874

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



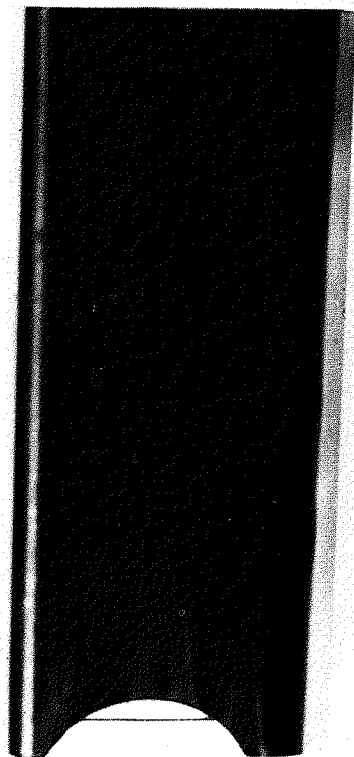




61434 G



18

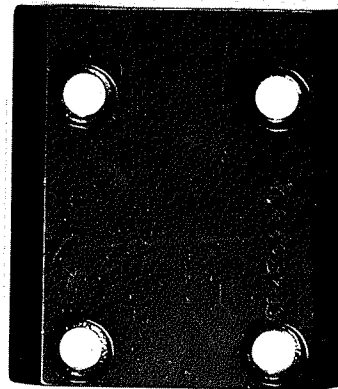


61482

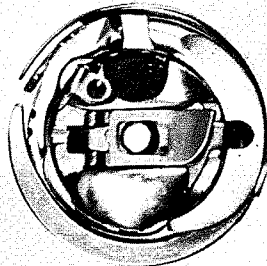


93

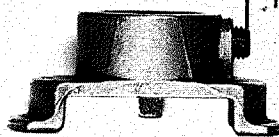
61439 AB



22570 A



29474 G



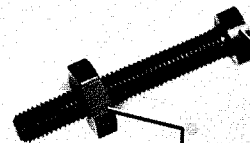
89

61449 AA



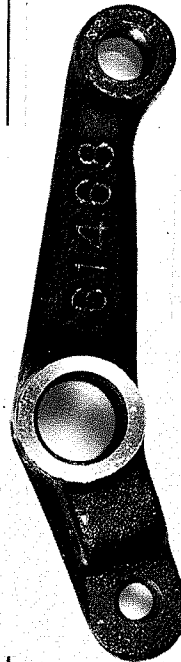
98

2339 F

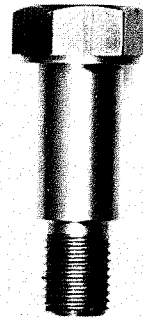


9937

22874 F



61468



22817 A



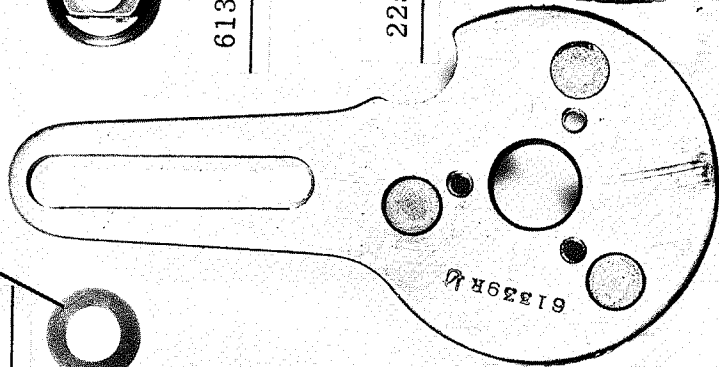
61368 F



22712 F



61339 B



22564 B (3)



22560 A (2)

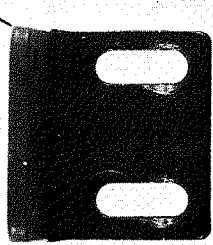
61339 R

29126 CV



22832 G

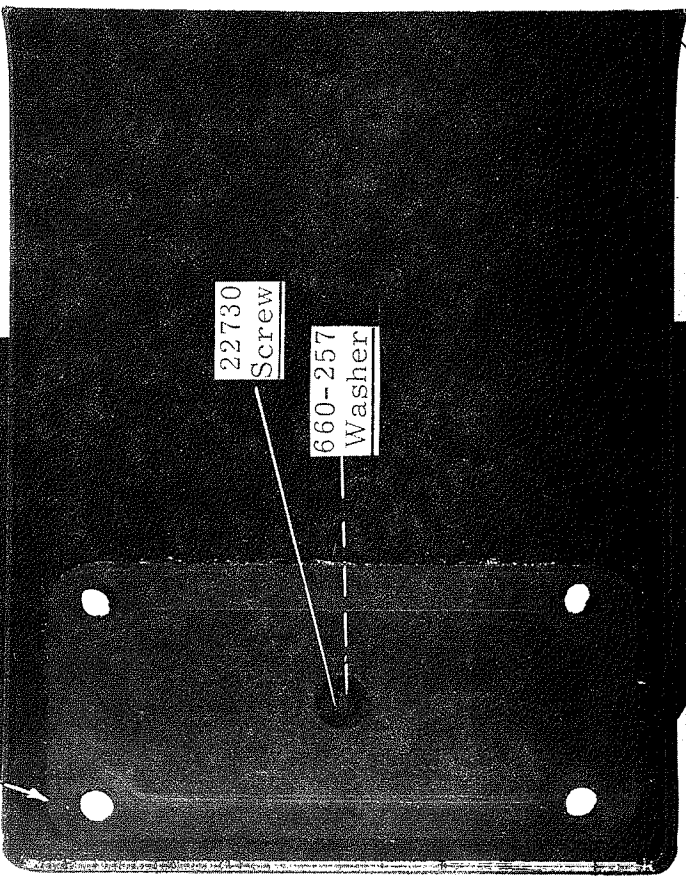
23564 G



93(2)

61382M

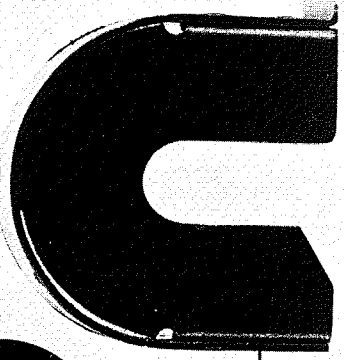
61282E
GASKET



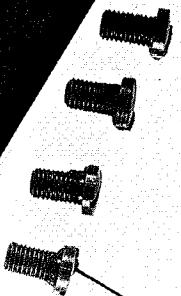
22730
Screw

660-257
Washer

61482B

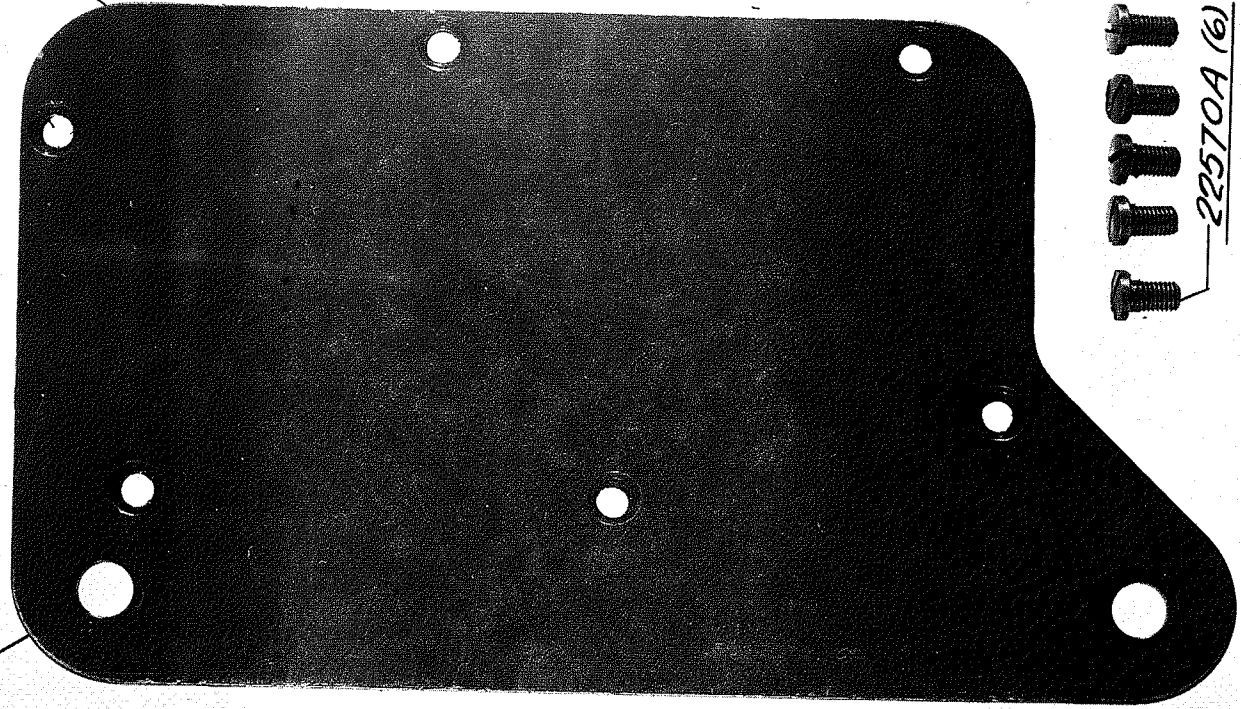


61482A



22570A (4)

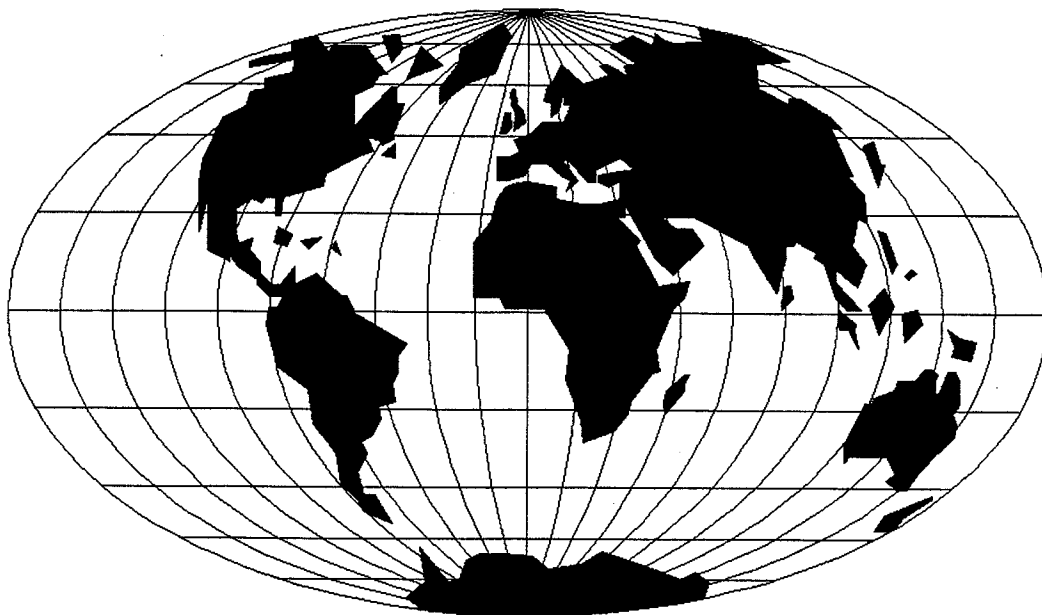
61382L PLATE 61282D GASKET



22570A (6)



22829 (2)



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.

Corporate Office:
One Union Special Plaza
Huntley, IL 60142
Phone: 708•669•5101
Fax: 708•669•1096

European Distribution Center:
Union Special GmbH
Raiffeisenstrasse 3
D-71696 Möglingen, Germany
Tel: 49•07141•247•0
Fax: 49•7141•247•100

Brussels, Belgium
Charlotte, N.C.
Commerce, CA
El Paso, TX
Hong Kong, China
Huntley, IL
Leicester, England
Lille, France
Miami, FL
Milan, Italy
Mission, TX
Möglingen, Germany
Montreal, Quebec
Osaka, Japan

Other Representatives throughout
all parts of the world.



Union Special
INDUSTRIAL SEWING EQUIPMENT