

UNITED

VERTICAL BORDER MACHINE

PARTS MANUAL

Part No.	Illustration on Plate No.	Part Name	No. Req' B
(BASE DRIVE)			
BM-2.....4.....		Main Frame	1
BM-3.....4.5.....		Speed Reducer1	
BM-4.....5.....		Slide Traverse	1
BM-5.....5.....		Main Lever	1
BM-7.....5.....		Guide-Traverse Slide	2
BM-8.....4.5.....		Brace-Roll Carrier2	
BM-9.....4.....		Roll Carrier-Traverse Slide	2
BM-11.....5.....		Stud-Traverse Adjustment	1
BM-12.....5.....		Pin-Lever Bracket	1
BM-13.....5.....		Lever Bracket-Sewing Mach	1
BM-14.....3.....		Shaft Sewing Machine Drive	1
BM-15.....2.....		Bushing-Main Lever	2
BM-16.....5.....		Support-Lever Shaft	2
BM-17.....5.....		Guide Block-Main Lever	2
BM-19.....4.5.6.....		Roll-Cam	3
BM-21.....3.....		Motor Pulley Flange.....\	
BM-22.....3.....		Motor Pulley Hub	
BM-23.....5.....		Shaft-Main Lever	
BM-25.....6.....		Lever End for BM-57	
BM-26.....6.....		Washer-Stud-Cam Roll	
BM-27.....6.....		Spring Rod-Crosshead	
BM-28.....3.....		Pin for BM-14	
BM-29.....6.....		Spring-Crosshead Return	
BM-30.....4.5.....		Traverse Cam, 5" to 7"	
BM-31.....4.6.....		Washer - Cam Hubs	
BM-32.....6.....		Cloth Feed Cam, 3" to 5" Pockets(
BM-33.....6.7.12.....		Clevis	
BM-34.....6.....		Stud-Cam Roll-Crosshead	
BM-35.....6.12.....		Pin-Clevis	
BM-36.....6.....		Crosshead-Cloth Feed	
BM-37.....6.....		Bracket-Pillow Block	
BM-38.....3.....		Base Plate-Motor	
BM-39.....3.....		Wall Bracket-Motor	
BM-40.....3.....		Shaft-Base Plate-Motor	
BM-41.....2.....		Lever-Centering	
BM-42.....2.....		Lever for BM-23	
BM-43.....2.....		Shoulder Screw-Centering	

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-44.....2 . . .		Hand Knob-Centering		
BM-45.....2 . . .		Stud-Hand Knob		
BM-46.....2 . . .		Drive Bar-Centering-Vertical		1 . . 1
BM-42.....2,6 . . .		Drive Bar-Centering-Horizontal		1 . . 1
BM-48.....1 . . .		Hinge Pin-Front Lower		1 . . 1
BM-49.....1 . . .		Hinge Pin-Front Upper		1 . . 1
BM-50.....1 . . .		Hinge Pin - Rear		1 . . 1
BM-55.....6 . . .		Link-Clevis-Crosshead		1 . . 1
BM-56.....6 . . .		Lever Shaft-Cloth Feed		1 . . 1
BM-57 6 . . .		Feed Roll Lever-Left		1 . . 1
BM-60.....2 . . .		Bushing-Hand Knob-Centering		1 . . 1
BM-61.....2 . . .		Pin for BM-41		
BM-62.....2 . . .		Pin for BM-42		
BM-63.....13 . . .		Wire for BM-US-54		
BM-65.....4 . . .		Speed Changer		
BM-66.....3 . . .		Pulley Hub-Drive Shaft		
BM-67.....3 . . .		Bearing-Sewing Mach. Shaft		
BM-68.....4 . . .		Pulley-Speed Reducer		
BM-70.....3 . . .		Motor		
BM-71.....6,8,9 . . .		Oil Cup for BM-37		
BM-72 2 . . .		Spacer-Shaft		
BM-73.....2 . . .		Collar - Shaft		
BM-74		Shaft-Hand Wheel		
BM-75		Assembly-Hand Wheel		
BM-76		Cover-Motor-Frame		
BM-77		Door-Back-Frame		
BM-78		Front Cover-Frame		
BM-79		Door-Front-Lower Frame		
BM-80		Door-Front-Upper Frame		
BM-81		Knob-Door-Frame		
BM-82		Hinge-Door-Frame		
BM-85		Spring Latch-Door-Frame		
BM-86		Spring-Hand Wheel		
BM-89		Bracket-Hand Wheel		
BM-90.....4,5,12 . . .		Lug for BM-30, 402 or 406		
BM-91.....4,5,12 . . .		Shoulder Screw for BM-90		
BM-92.....8,9 . . .		Runway Block		
BM-93.....3 . . .		Pulley Flange for BM-66		
BM-94.....3 . . .		Belt-Motor to Sewing Machine Drive Shaft		
BM-95.....3 . . .		Belt-Motor to Speed Changer		
BM-96.....4 . . .		Belt-Speed Changer to Reducer		

B - Border Machine, P - Pocket Machine

Illustration No.	on Plate No.	Part Name	No. Req'd	
			B	P
97	1.....	Cover-Cam		
99	1.....	Cover-Plate		
(SEWING MACHINE)				
100	13,14	Sewing Machine Head		
101	13	Cap-Sewing Machine Head		
102	14			
103	16,17	Base - Sewing		
104	13,14	Needle Lever		
105	17			
106	16	Front Runway-Lever Bracket		
107	16			
108	17	Base Plate Under Base		
109	13			
110	15	Base Plate-Under Head		
111	13	Thread Guide for BM-109		
112	15	Top Plate-Loose		
113	15			
114	15			
117i	13,18, 19	Thread Guide		3
123	18,19	Altered Activator, Micro-Switch		2
124	14	Thread Guide at Face Plate		2
125	14	Bushing - Needle Lever Stud		
127	13	Presser Foot Shaft		
128	13	Guide Block-Presser Foot Shaft		
130	13	Knob-Presser Foot Shaft		
131	13	Bushings-Top & Bottom Presser Foot Shaft		
132	13	Spring-Presser Foot Regulating		
133	13	Sleeve-Spring Retaining Presser Foot Shaft		
134	13	Presser Foot		
135	15	Guide Plate-Throat Plate		
138	15	Cam Roller Stud		
139	15	Cam Roller		
141	15	Needle Fender Block		
142	17	Splined Half Pulley		
143	17	Half Pulley		
144	15,16	Cam		
145	17	Pulley Bracket		
	18,19	Cylinder-Dash Pot		2
	17	Coupling-Crankshaft to Cam Shaft		1
	18,19	Piston - Dash Pot		2

B - Border Machine, P - Pocket Machine

Port No.	on Plate No.	Part Name	No. Req
			B
BM-149.....	16	Cam Shaft1 . .	
BM-151.....	18,19	Micro-Switch	
BM-153A.....	16	Bearing-Cam Shaft-Left1 . .	
BM-153B.....	17	Bearing-Cam Shaft-Middle & Right2 . .	
BM-i53D.....	16	Bearing-Looper Rocker Shaft2 . .	
BM-153E.....	17	Bearing-Cross Shaft-Front1 . .	
BM-153F.....	17	Bearing-Cross Shaft-Middle1 . .	
BM-153G.....	17	Bearing-Cross Shaft-Rear1 . .	
BM-154.....	17	Cross Shaft-Sewing Machine Base1 . .	
BM-155.....	17	Lever Bracket Screw1 . .	
BM-157.....	14	Gasket for BM-1021 . .	
BM-158.....	16	Oil Tube-Looper Drive Lever1 . .	
BM-159.....	16	Oil Tube-Looper Avoid Eccentric1 . .	
BM- 160.....	16	Oil Tube-Looper Rocker Assembly1 . .	
BM-161.....	16	Oil Tube - Cam1 . .	
BM- 163.....	14	Grommet - Head1 . .	
BM-164.....	15	Dowel3 . .	
BM-165.....	15	Oil Drip Plate-Base Plate...	
BM-166.....	13	Bushing-Upper-Needle Bar1 . .	
BM-167.....	17,18,19	Oil Gauge	
BM-168.....	14	Needle Lever Stud1 . .	
BM-170.....	Page 27	Gauge-Looper to Needle	
BM-171.....	16	Gasket for BM-1031 . .	
BM-172.....	17	Belt1 . .	
BM-173.....	17	Screw for BM-1853 . .	
BM-174.....	18,19	Tension Post-Face Plate	2 . .
BM-175.....	16	Dowel for BM-US-52857B2 . .	
BM-176.....	13	Needle....	
BM-177.....	14,18,19	Wire Conductor, Micro-Switch	1 . .
BM-178.....	14	Plug for BM-1771 . .	
BM-179.....	15	Washer1 . .	
BM-181.....	17	Spot Screw for BM-1051 . .	
BM-182.....	16	Looper Rocker Shaft1 . .	
BM- 184.....	16	Shim-Cam Adjustingsets: 1 . .	
BM-185.....	17	Main Shaft Bushing Housing1 . .	
BM-186.....	14	Plate, Model & Machine No. .1 . .	
BM-187.....	1	Plate, Model & Machine No1 . .	
BM-191.....	14	Bushing - Needle Lever1 . .	
BM-192.....	18,19	Whisker, Micro-Switch	

" B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No, Req' B
BM-194.....15	...	Throat Plate1 . .	
BM-195.....15	...	Thread Deflector1 . .	
BM-196.....15	...	Thread Deflector & Cam Roller Support.....1 . .	
BM-198.....18,19	...	Clip-Wire Conductor, Micro-Switch	
BM-199.....18,19	...	Face Plate-Double Thread Break .	

(CLOTH CONTROL)

BM-200	8,9	Feed Roll Bracket - Right	
BM-201	8,9	Feed Roll Bracket - Left	
BM-202	8,9	Feed Roll Pivot	
BM-203	8,9	Feed Roll Pivot Shaft	
BM-204	8,9	Feed Roll Lock & Cover	
BM-205	8,9,10	Knob	
BM-206	8,9	Sleeve-Feed Roll Bracket	
BM-208	10,11	Guide Plate, Left - Cloth Feed .	
BM-209	10,11	Guide Plate, Right - Cloth Feed .	
BM-210	10,11	Felt Apron-Cloth Feed	
BM-211	10,11,12	Cloth Clamp	
BM-212	10,12	Half Foot-Cloth Clamp	
BM-213	8,9	Rear Roil.V	
BM-214	8,9	Shaft - Front Roil	
BM-215	8,9	Shaft - Rear Roll	
BM-216	8,9	Pilot - Front Roll	
BM-217	8,9	Pilot - Rear Roll	
BM-218	10,11,12	End Plate - Right	
BM-219	10,11,12	End Plate - Left	
BM-220	12	Bracket-Cloth Clamp-Cam Lever.	
BM-221	10	Eccentric Screw-Cloth Clamp. . .	
BM-222	12	Cam Lever-Cloth	
BM-223	12	Cam Washer-Cloth Clamp	
BM-224	12	Cam Roller-Cloth Clamp	
BM-225	8,9	Toggle2	
BM-226	8,9	Swivel Pin - Toggle2	
BM-227	8,9	Hinge Pin - Toggle2	
BM-228	8,9 /	Spring Rod - Toggle2	
BM-229	8,9	Pin - Spring Rod - Toggle2	
BM-230	12	Lever - Cloth Clamp.1	
BM-231	12	Clevis - Lever - Cloth Clamp1	
BM-232	12	Pin - Lever - Cloth Clamp. . .1	

* B - Border Mochine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-234	12	Cam Stud - Cloth Clamp1 . . 1		
BM-236	12	Spring Clamp.....1		
BM-237	12	Latch Clamp1 . . 1		
BM-239	10	Front Apron - Cloth Feed1 . . 0		
		Apron - Rear - Cloth Control		1
BM-244	10	Cloth Guide - Front Apron2 . . 0		
BM-247	10	Pad Foot1 . . 0		
BMr252	12	Shaft - Bracket - Cloth Clamp1 . . 1		
BM-253	10,11	Shaft - Guide Plates1 . . 1		
BM-254	10,11	Pivot Shaft - Guide Plates1 . . 1		
BM-256	8,9	Spring for BM- 2282 . . 2		
BM-257	8,9	Key - Clutch to Shaft2 . . 2		
BM-259	12	Bushing - End Plates BM-218 & 219.....2		
BM-272	8,9	Collar - Rear Feed Roll1		
BM-273	10	Support - Insert Hem Truner. . . 0		
BM-275	10	Top Plate - Hem Turner.0		
BM-276	Bottom Plate	Hem Turner ...	0	
BM-277	10	Support - Hem Turner		0
BM-278	10	Guide - Right - Hem Turner. ; ,		0
BM-279	Guide - Left	Hem Turner. . .	0	
BM-280	Thumb Screw	Hem Turner ...		0
BM-281		Latch - Cloth Clamp		1
BM-287	12	Spring - Cloth Clamp		1
BM-288	10	Brush Holder - Cloth Tension . . 1		
BM-289	End Plate	Cloth Tension . . .	1	
BM-290	10,11	Guide - Cloth Tension.2		
BM-292		Spacer - Rear Roll		1
BM-293	10	Rivet for BM-2770		
BM-294	8,9	Pinion - Front Roll1		
BM-296	Half Foot	Cloth Clamp....		0
BM-297		Screw, Foot - Cloth Clamp	4	0
BM-298		Key for BM-294	1	1
BM-299	9	Front Roll01		

(ELECTRICAL)

BM-301	1	Magnetic Starter		1	1
BM-306	1	Receptacle	2	2	
BM-307	1	Plate, Receptacle	2	2	
BM-312	4	Junction Box		1	1
BM-313	4	Conduit - Junction Box to Wind-Up Outlet ...		1	1

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-315.....4.....	Conduit - Micro	Outlet to Junction Box.....1 . . 1		
BM-316....4.....	Outlet Box Cover	for BM-312	1	1
BM-317....1.....	Outlet Box		4	4
BM-318		Cover for BM-317	2	2
BM-319	Not Illust.	Watertight Connectors	8	8
BM-3 20	See Wiring Diagram	Wires - Motor to Junction Box	1	1
BM-321		Wires - Junction Box to Starter	1	1
BM-322		Wires - Micro-Switch Outlet to Starter..... 1	1	
BM-323		Wires - Wind-Up Outlet to Junction Box..... 1	1	
		Flexible Tubing - Motor to Junction Box	1 .. 1	

(BASE DRIVE)

BM-40 1.....4.....	Hub - Traverse	Cam	1	1
BM-402 ..4,5	Traverse Cam - 7" to 10"	1 . . 1		
BM-403 ..4,6	Retaining Nut	2 . 2		
BM-404 ..6	Hub - Cloth Feed Cam	1 . 1		
BM-409 ..3	Handle - Hand Wheel	1 . 1		
BM-410....5.....	Gauge - Traverse	Slide	1	1
BM-411....5	Pointer - Traverse	Adjustment	1	1
BM-412 ..1	Mounting Foot - Frame	4 . . 4		
BM-413....2	Nut - For Hand	Knob	1	1
BM-414....4	Key for BM-401		1	1
BM-415....6	Key for BM-404		1	1
BM-417.....3,4,5. . .	Shim for BM-3 & BM-67		6	6
BM-419....8,9	Shim - Runway Block.....	sets:3 . . 3		
BM-420 ..6	Bracket - Cross Head Slide	1 . . 1		
BM-421....6.....	Cloth Feed Cam - 7" to 10" Border.....	1 . . 0		
BM-422 ..6	Cloth Feed Cam - 5" to 7" Border.....		1	0
BM-423 ..6,8,9. . .	Gear Segment - Cloth Feed	1 . . 1		
BM-424 ..6	Spacer - Bracket BM-374 . .	4		
BM-425 ..6	Cloth Feed Cam - dVi" to 5" Border.....	1 . . 0		
BM-426 ..4,5. . .	Traverse Cam - 3/4" to 5" l..	1		
BM-427 ..6	Cloth Feed Cam - 1 1/2" to 3" Pockets.....	0 . . 1		
BM-428 ..1	Patent Number Plate	1 . . 1		
BM-430 ..1	Spindle - Thread Spool	..2 . . 2		
BM-431....1	Tee - Thread Guide		1	1

B - Border Machine, P - Pocket Machine

Part No.	111 u strat ion on Plate No.	Part Name	No. Req'd	
			B	P
BM-501.....	21 .			

(WIND UP STAND)

		Stand,Base	1 . .	1
BM-502	21	Spool Axle1 .	1	
BM-303	21	Fixed Hub1 .	1	
BM-504	21	Removable Hub1 .	1	
BM-510...BM-505	21	Friction Adjustment Spring1 . .	1	
BM-511...BM-506	21	Friction Adjustment Collar1 . .	1	
BM-512...BM-507	21	Spool Sides2 . .	2	
BM-513...BM-508	21	Motor1 .	1	
		Shim	2 . .	2
		Washer - Friction Adj. Spring	2 . .	2
		Plug	1	1
		Wire - Wind-Up to Frame.....	1	1

(CLOTH FEED STAND)

BM-610...BM-601	22	Stand, Cloth Feed1 .	0	
BM-612...BM-602	22 .			
BM-613...BM-603	22	Spool Arm.....	0	1
BM-618...BM-604	22	Spool Arm./..	1	0
BM-619...BM-606	22 .	Spool Shaft	2 . .	0
BM-608	10,22	Collar - Spool Shaft.....	0	10
BM-609	22	Arm\.....	1	0
		Disc Assembly	4 . .	0
		Panel Assembly	2 . .	0
		Bracket - Shaft	2 . .	0
		Separator Shaft	4 . .	0
BM-620	22 .	Guide Block - Separator	4 . .	0

(SPACING ATTACHMENT)

BM-651	7.	Base Plate	...	0
BM-652	7.	Stop Arm		0
BM-653	7.	Stop Arm Bracket		0
BM-654	7	Adjustable Stop		0
BM-655	7.	Trip		0
BM-656	7.	Trip Stud		0
BM-657	7.	Trip Lever		0
BM-658	7.	Shoulder Stud		0
BM-659	7.	Spacer - Trip Lever		0
BM-661	7,	Trip Pawl		0

B - Border MacMne, P - Pocket Machine

Part No.	III u strati on on Plate No.	Part Name	No. Req' B
BM-662	7	Index Pawl	
BM-663	7	Index Pawl Pivot	
BM-664	7	Index Lever	0
BM-665		Shoulder Stud	0
BM-666	7	Rack	0
BM-667		Rack Bracket	0
BM-668	7	Guide Block - Rack	0
Spring..... BM-669	7	Reset Pin	0
BM-670		Actuator Pin	0
BM-671	7	Rack Stud	0
BM-672	7	Index Pawl Spring	
BM-674	7	Trip Spring	0
BM-676	7	Index Lever Spring	0
BM-677	7	Stop Sleeve	
BM-678	7	Trip Pin	

(CLOTH CONTROL)

BM-701	10	Felt Guide - Left	0
BM-702	JO	Felt Guide - Right	0
BM-703	10,22	Shaft - Felt Guide	0
BM-710	8	Front Roll	0
BM-711	10	Adapter - Left Hem Turner	0
BM-712	10	Adapter - Right Hem Turner	0
BM-713	8	Frame - Finished Border Guide	0
BM-714	8	Guide Block - Finished Border	0
BM-715	8	Guide Plate - Right - Finished Border	0
BM-716	8	Guide Plate - Left - Finished Border	0

(CLOTH FEED STAND)

BM-801	23	Base - Cloth Stand	0
BM-802	23	Shaft - Creaser	0
BM-803	23	Shaft - Cloth - Base	0
BM-804	23	Washer - Sleeve	0
BM-805	23	Sleeve - Table Support	0
BM-806	23	Table	0
BM-807	23	Creaser - Cloth	0
BM-808	24	Table - Frame	0
BM-809	24	Leg - Creaser Support	0
BM-810	24	Strap - Frame Table	0

B - Border Machine, P - Pocket Machine

Part No.	on Plate No.	Part Name	No.	Req'd
BM-811.....		Set Screw - Lock Nut	0	1
BM-813	23	Tension Bar - Cloth.....	0	1
BM-815	23	Tension Spring - Cloth	0	1
BM-816	23	Tension Bar - Cloth	0	1
BM-817	23	Disc - Tension Spring	0	1
BM-819	23	Tension Spring - Cloth Shaft	0	1
BM-820	23	Tension Post - Cloth Shaft	0	1
		Collar - Tension Spring	0	1
		Lock Nut - Table	0	1
(CLOTH CONTROL)				
BM-850	11	Holder - Roll	0	1
BM-851	11	Roll - Foot	0	1
BM-852	11	Shaft - Cloth Guide - Frame	0	1
BM-853	11	Spacer - Cloth Clamp.....	0	1
(THREAD CUT-OFF)				
BM-901	20	Apron Rest	0	1
BM-902	20	Cylinder Block	0	1
BM-903	20	Thread Pick-Up Plate	0	1
BM-904	20	Plunger - Knife	0	1
BM-905	20	Knife	1	1
BM-906	20			
BM-907	20	Activator	0	1
(SEWING MACHINE)				
BM-US-18	16	Nut	3	3
BM-US-28	16	Screw	2	2
BM-US-43C	16	Looper Avoid Eccentric, Inch		
		(1) BM-US-22894D, Spot Screw	1	1
BM-US-52A	16,17	Thread Guide on Base	1	1
BM-US-54	13	Needle Lever Link	1	1
BM-US-56	13			1
BM-US-109B	18,19	Tension Disc	4	4
BM-US-116	1	Wrench, 9/32"	1	1
BM-US-269	16	Nut - Left Thread	1	1
BM-US-652C9	13	Shake Proof Lockwasher	1	1
BM-US-666-13	17	Felt Wick	9	9
BM-US-1286	13			
BM-US-8372A	17	Washer	1	1
BM-US-15430C	17	Nut - Left Thread	1	1

Border Machine. P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-US-15430D	14 . .	Nut - Right Thread	1	1
BM-US-21388 .	1. . .	Wrench,13/32".....	1	1
BM-US-22768 .	13 . .	Screw for BM-US-51258A	1 . .	1
BM-US-22894C	17 . .	Set Screw for BM- 147	2 . .	2
BM-US-22894D	16,17	Spot Screw for BM-147	2	2
BM-US-29066N	14 . .	Assemb. Needle Lever Conn. Rod Upper Brg. includes (1) BM-US-51216A (1) BM-US-51243B	1 . .	1
BM-US-29105B .	17			
BM-US-29192. .	16	Looper Rocker Assembly, Incl. (1) BM-US-73 Set Screw	1	1
BM-US-29476DD	17	Crankshaft Assembly, Incl. (1) BM-US-51322A, Crankshaft (2) BM-US-75A, Screws....."	1	1
BM-US-35759. .	13 ...	Needle Bar Connector, Incl. (2) BM-US-88A Set Screws (1) BM-US-78 Set Screw	1 . .	1
BM-US-51145 . .	16 . . .	Looper Avoid Eccentric Link	1	1
BM-US-51147 . .	17 ...	Main Shaft Collar, Incl. (2) BM-US-95, Screws	1 . .	1
BM-US-51190D .	17 ...	Main Shaft Bearing Hsg. Gasket	1	1
BM-US-51216 . .	14 . . .	Needle Lever Conn. Rod Tube	1	1
BM-US-51217 . .	13 ...	Needle Bar	1 . .	1
BM-US-51236A .	16 ...	Looper Avoid Link Pin	1 . .	1
BM-US-51240A .	16 ...	Looper Conn. Rod Adjusting Section.....	1 . .	1
BM-US-51241 . .	16 .Old .	Looper Conn. Rod Assembly-Right.....	1 . .	1
BM-US-51241D .	16 . . .	Looper Conn. Rod Ball Joint Assembly-Left. .	1 . .	1
BM-US-51241J .	16 .New.	Looper Conn. Rod Assembly-Right.....	1 . .	1
BM-US-51242K .	17 . . .	Looper Drive Lever Rocker, Incl. (1) BM-US-81, Set Screw (1) BM-US-627, Clamp Screw	1 . .	1
BM-US-51242V .	16 . . .	Looper Drive Lever, Incl. (1) BM-US-81, Spot Screw (1) BM-US-74, Clamp Screw (1) BM-US-51242M, 'Vasher	1 . .	1
BM-US-51243C .	14 .	Looper Drive Lever Ball Scud Guide Fork, incl. (1) BM-US-97, Screw	2 . .	2

B - Border Machine, P - Pocket Mochine

Part No.	Illustration on Plate No.	Part Name	No. Req'd	
			B	P
BM-US-51244	16	Looper Rocker Frame, Incl. (1) BM-US-22894D, Spot Screw (1) BM-US-22894C, Set Screw	1	1
BM-US-51244B	16	Looper Rocker Shaft Arm, Incl. (1) BM-US-77, Sec Screw (1) BM-US-93, Clamp, Screw	1	1
BM-US-51244C	16	Looper Rocker Shaft Sleeve, Incl. (1) BM-US-88B, Screw	1	1
BM-US-51246	16	Looper Rocker Stud Nut	1	1
BM-US-51254A	13	Needle Bar Bushing, Lower	1	1
BM-US-51258	13	Needle Lever Thread Eyelet	1	1
BM-US-51258A	13	Needle Bar Thread Eyelet	1	1
BM-US-51292A	18,19	Tension Post Ferrule	2	2
BM-US-51292C	18,19	Tension Regulating Nut	2	2
BM-US-51292D	18,19	Thread Tension Eyelet	2	2
BM-US-51292F5	18,19	Tension Spring for Needle Threads	1	1
BM-US-51292F8	18,19	Tension Spring for Needle Threads	1	1
BM-US-51523C	16	Shielded Disc Take Up, Incl. (1) BM-US-22894D, Spot Screw (1) BM-US-22580, Set Screw	1	1
BM-US-51959B	16	Looper Thread Nipper Disc	2	2
BM-US-51959c	16	Looper Thread Nipper Spring	1	1
BM-US-51959D	16	Looper Thread Nipper Nut	1	1
BM-US-51959E	16	Looper Thread Nipper Spacing Collar	1	1
BM-US-52804A	16	Cast Off Plate	1	1
BM-US-52834N	17	Cap Screw	4	4
BM-US-52841	17	Locking Nut	5	18
BM-US-52857B	16	Looper Drive Ball Joint Locking Stud	1	1
		Cast Off Wire Support	4	0

(MISCELLANEOUS)

BT-37	7	Stop Arm Spring	0	1
BT-101	14	Thread Guide	2	2
BT-157	10	Brush	12	0
66	5, 13, 16, 20	Machine Screw	10	13

* B - Border Machine, P - Pocket Machine

Part No.	(Illustration on Plate No.)	Part Name	No. Req'd *	
			B	P
109	7	Nut	4	6
119	Lockwasher		5	11
120	3,6,7,8,9,21	Lockwasher	24	25
122	9	Machine Screw	0	2
134	IZ	Cotter Pin	8	
151	3	Cap Screw	4	4
153	6	Street Elbow	2	2
172	8,9,10,24	Lockwasher	5	5
174	10,11,12,23	Nut	3	5
181	5	Washer	1	1
183	22	Machine Screw	12	0
271	2,3,6,8,9	Cotter Pin	12	12
213	4,17,21	Cap Screw	10	10
216	24	Cap Screw	0	2
286	2,11,15	Machine Screw	16	16
287	7	Cap Screw	0	3
270	3,21	Nut	8	8
282	3	Nut	4	4
368	1	Nut	4	4
369	1,4,5	Washer	8	8
392	3	Washer	4	4
393	304,6	Cap Screw	4	4
349	17	Cap Screw	2	2
354	8,9,12	Machine Screw	10	10
357	10	Machine Screw	2	0
364	22	Machine Screw	8	4
366	23	Set Screw	0	2
448	23	Machine Screw	0	3
497	18,19	Machine Screw	2	2
525	4	Machine Screw	4	4
558	3,6,7,12	Nut	5	7

* B - Border Machine, P - Pocket Machine

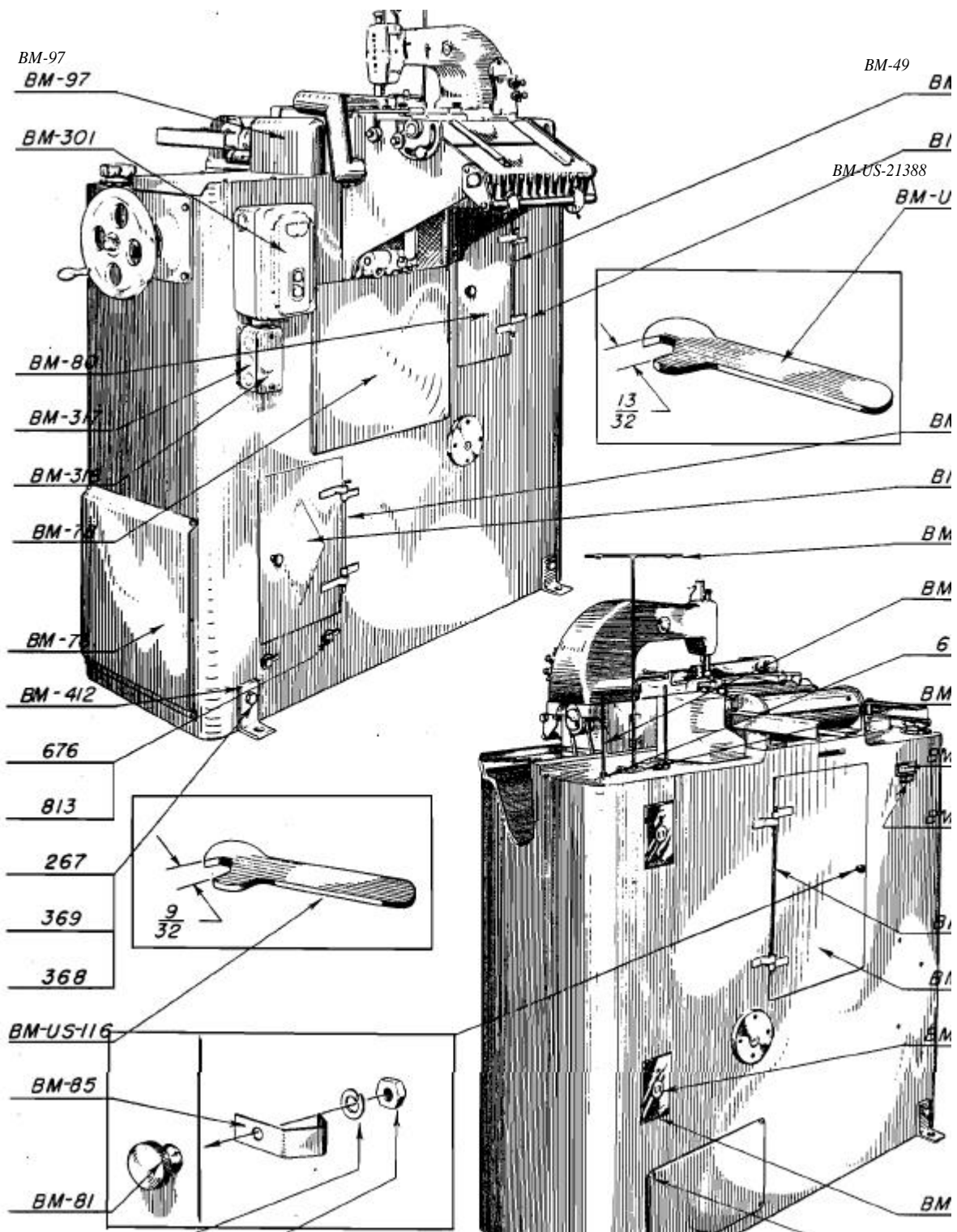
Part	Illustration		No. Req'd *	
	on Plate No.	Part Name	B	P
667.	3	Woodruff Key	1	1
673.	11	Screw Cap	2	1
674.	22	Cap Screw	2	0
676.	1,7	Screw Cap Screw 2 . . 3	0	2
681.	2,23	Cap Screw	1	2
688.				
749.	10	Machine Screw	2	0
751.		Lockwasher	0	2
754.	7	Screw Cap	0	◆
771.	10	Machine Screw	4	0
813.	1,4,5,6,8,9	Washer	12	12
815.		Grease Fitting	1	1
889.		Cap Screw	2	0
961.	18,19	Cap Screw Machine Screw	◆	1 . . 4
5707	4,5, 12 . .	Cap Screw	A/i . . 8 . . 8	
5709	3	Washer	1	1
5710				
5711				
5730	3,4,5 . . .	Spacing Washer 6 . . 6		
5741				
5762	4,5	Pipe Plug . .	2	2
5763	14	Drive Screw	4	4
5785	12	Bushing	1	1
5890	14	Cap Screw	6	6
5891	8,9,12 . .	Cap Screw	4	4
5894	4,5,6 . . .	Cap Screw	6	6
5951	22	Set Screw	4	0
5952	3	Set Screw	1	1
5997	6	Jam Nut	2	2
6018	5	Set Screw	1	1
6038	4,5	Set Screw	2	2
6048	8,9	Spacing Washer	1	1
6058	8	Cap Screw	2	0
6081	4	Cotter Pin	2	2
6083	8,9,12 . .	Set Screw	5	5
6136	8,9	Cap Screw	12	12
6139	1	Nut	1	1
6171	3	Washer	8	8
6180	1	Machine Screw	12	12
6197	5	Lockwasher	8	8
6205	5	Cap Screw	8	8

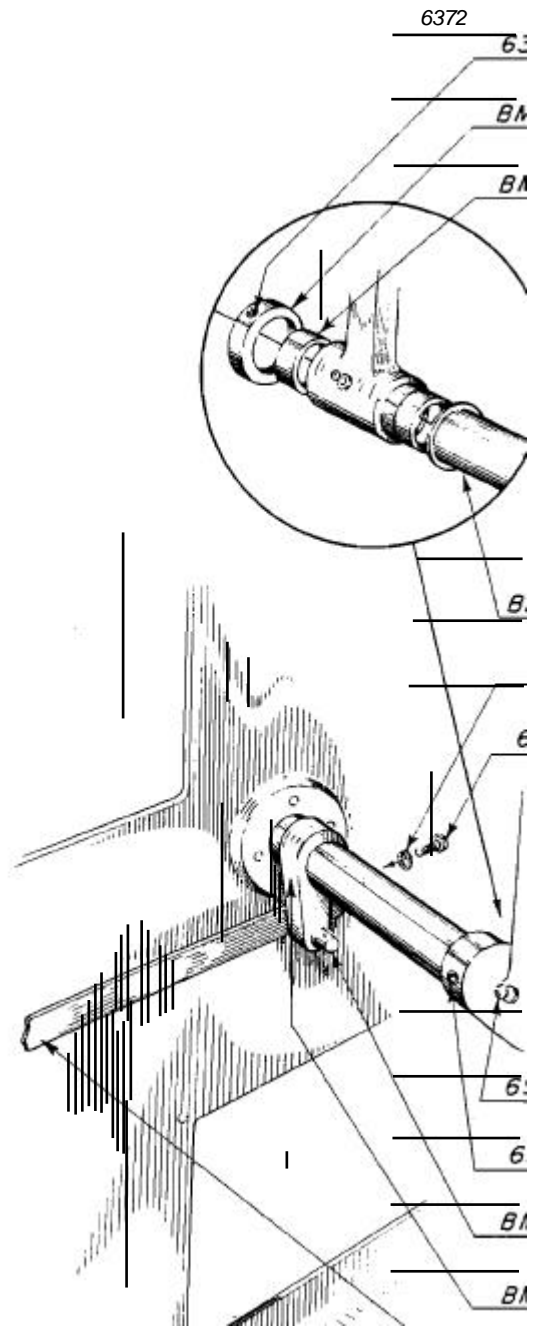
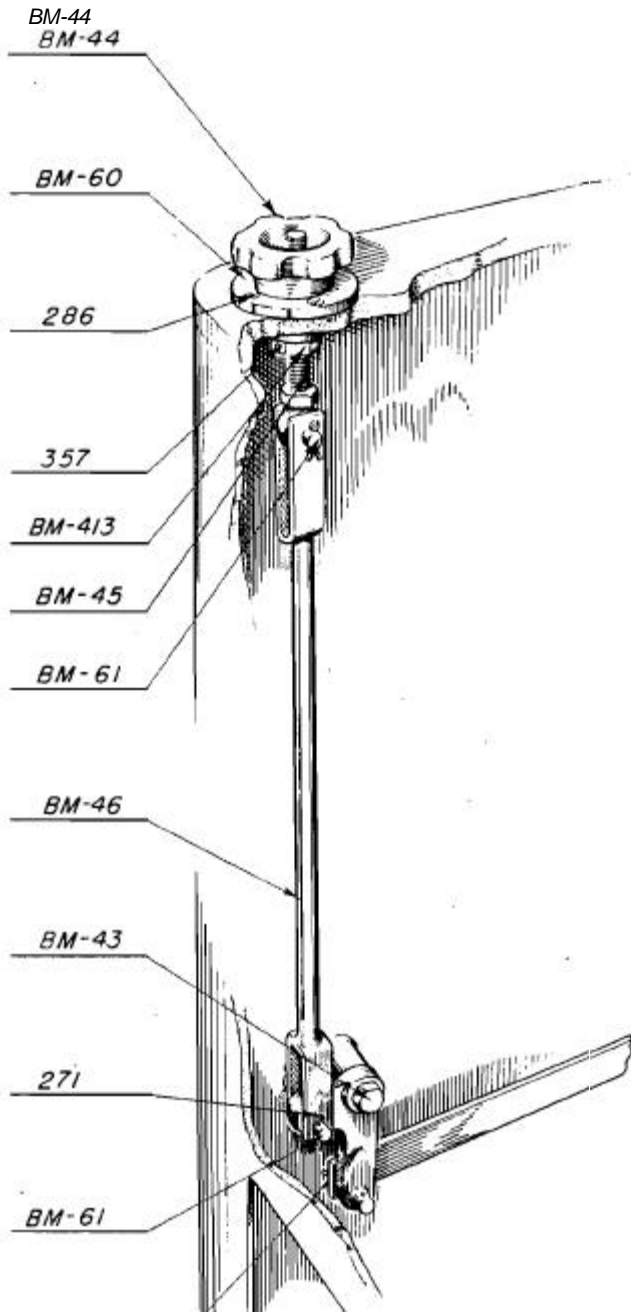
◆ B - Border Machine, P - Pocket Machine

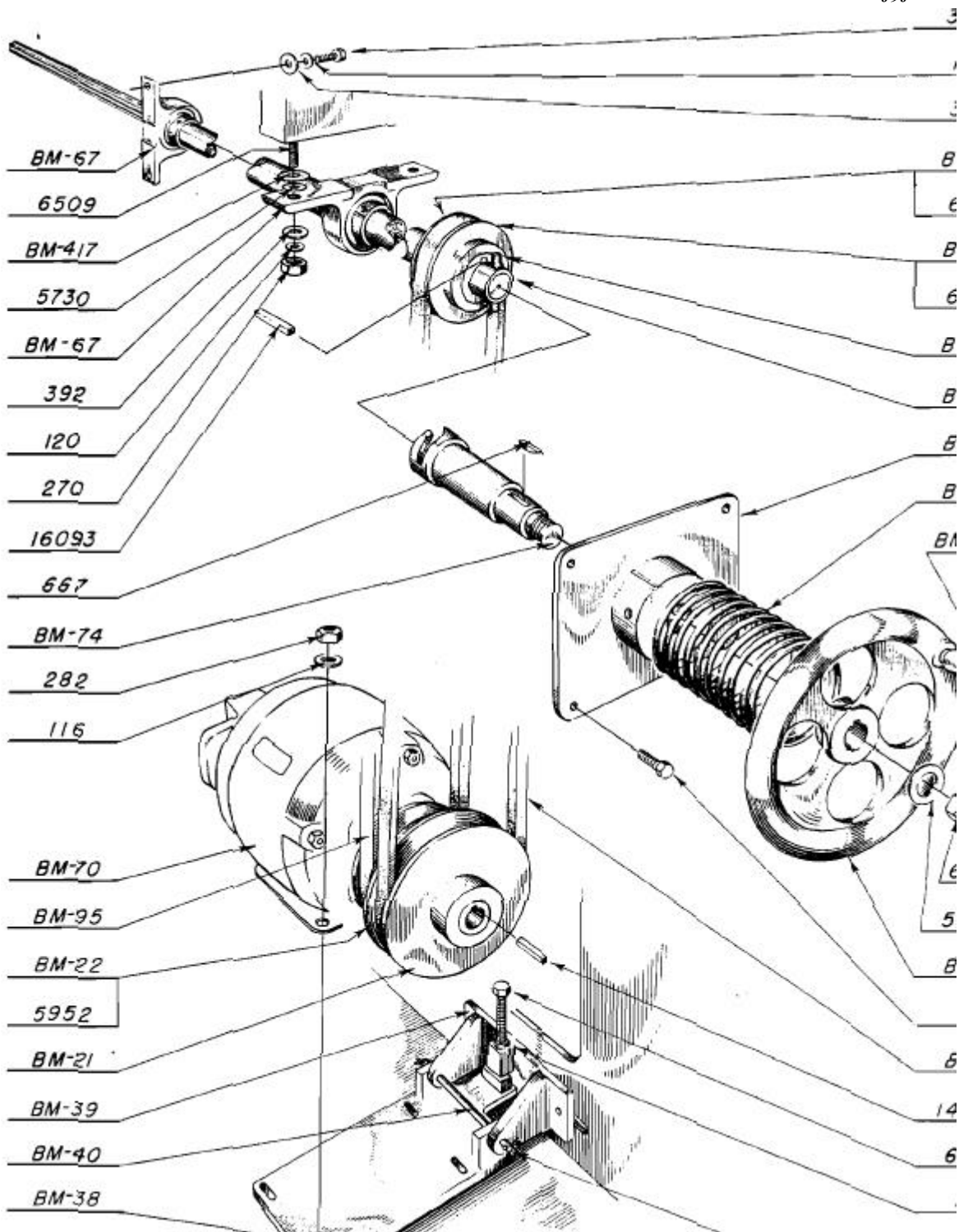
Part No.	Illustration on Plate No.	Part Name	No. Req'd	
			B	P
6243	8, 20	Cap Screw	4	0
6219	8, 20	Cap Screw	4	1
6228	3	Set Screw	1	1
6244	15, 17	Heli-Coil	9	9
6271	12	Lockwasher	4	4
6274	8, 9	Set Screw	3	3
6372	2, 21	Set Screw	3	3
6289	2, 21	Set Screw	3	3
6311	5	Lockwasher	2	2
6353	6	Bushing	2	2
6360	7, 11, 12, 20	Nut	5	5
6373	8, 9, 10, 11, 24	Washer	18	14
6375	8, 16	Washer	7	1
6410	10, 11, 13	Set Screw	4	4
6426	8, 9	Cap Screw	9	9
6451	18, 19	Nut	4	8
6473	13	Nut	1	1
6489	4	Snap Ring	2	2
6491	4, 5	Cap Screw	4	4
6492	3	Cap Screw	2	2
6494	16	Bearing	2	2
6517	8, 9, 14, 15	Cl Dowel	5	5
6496	8, 9, 14, 15	Cl Dowel	5	5
6497	13	Clamp Screw	1	1
6518	15	Bolt	1	1
6519	15	Machine Screw	5	5
6520	15	Machine Screw	5	5
6521	17, 5, 6	Oil Cup Pin	4	4
6499	17, 5, 6	Oil Cup Pin	4	4
6505	10	Thumb Nut	2	0
6530	21	Rivet	0	2
6508	21	Set Screw	0	2
6533	13, 18, 19	Heli-Coil	5	5
6526	13	Set Screw	1	1
6531	3, 6	Set Screw	3	3
6532	10, 11, 22	Thumb Screw	8	2
6536	13	Washer	1	1

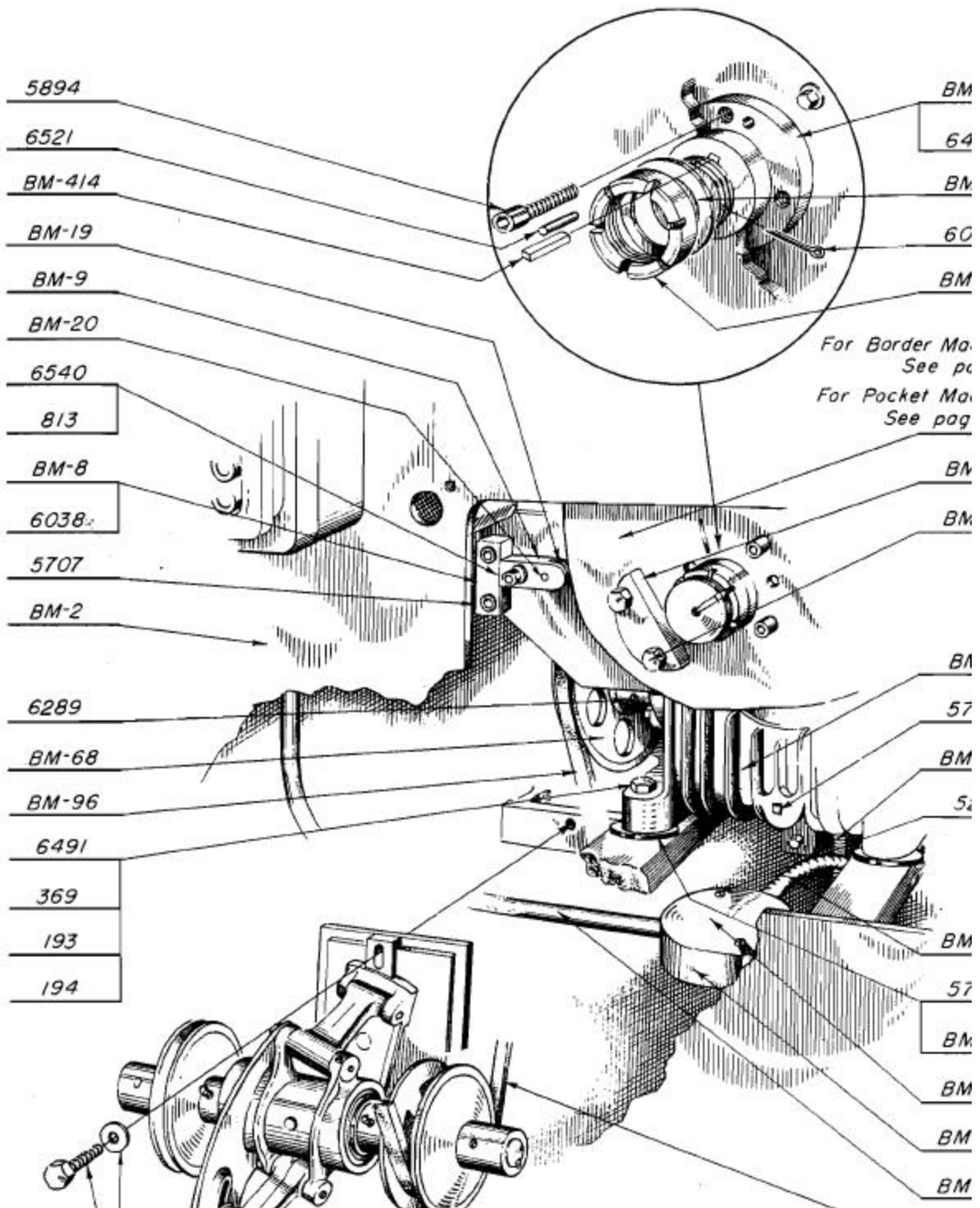
* B - Border Marine, P - Pocket Machine

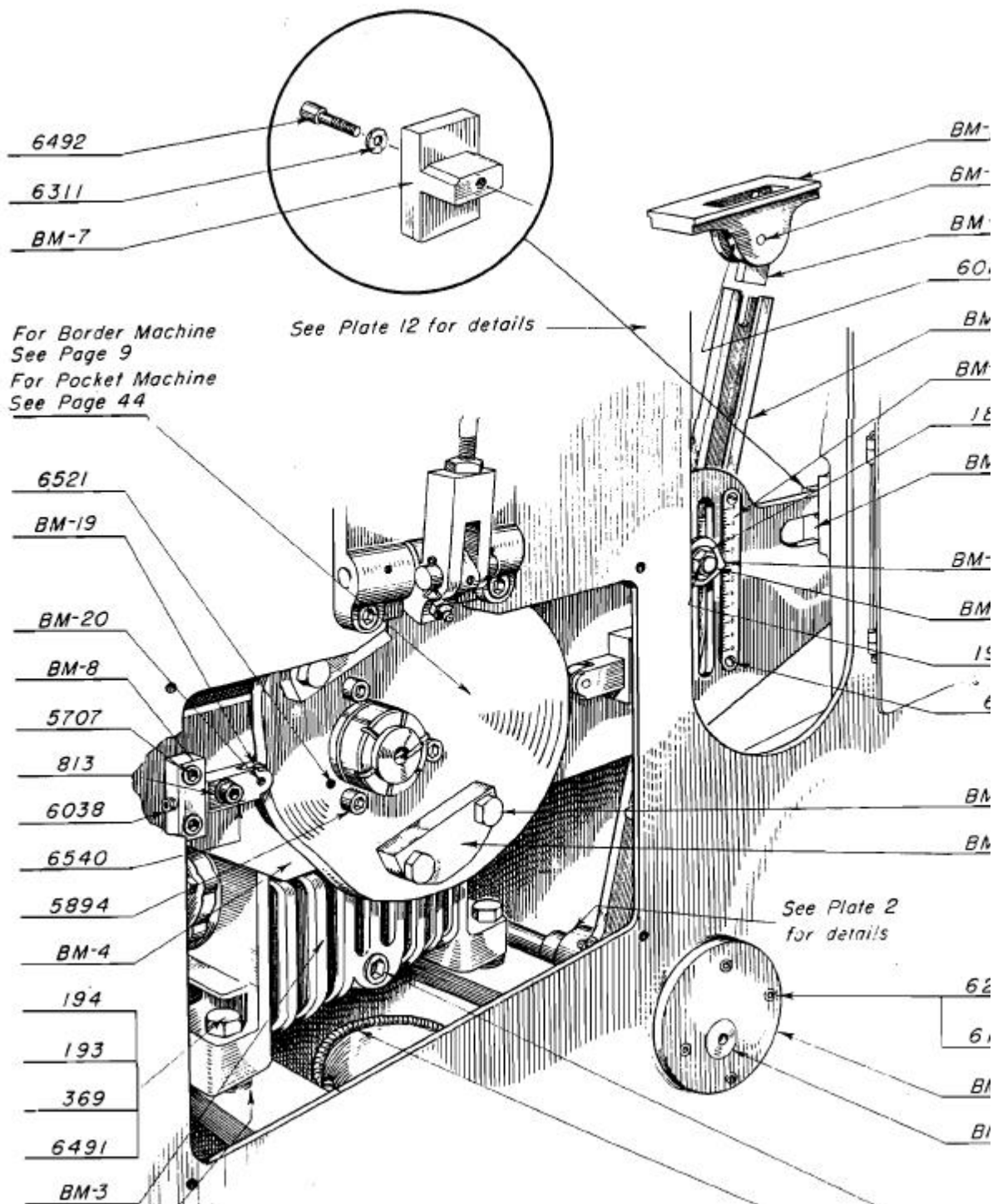
Part	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
6537	13,15,20	Machine Screw.....	3	4
6539	14,17	Heli-Coil	14	14
6540	4, 5, 16	Cap Screw	10	10
6541	17.....Screw	Set	1	1
6544	13.....	Machine Screw	2	2
6545	13.....	Machine Screw	1	1
6546	14.....Screw	Set	2	2
6547	17.....Screw	Set	1	1
6548	18,19	Machine Screw1	2	
6549	3.....Screw	Set	1	1
6550	8,9.....	Cotter Pin	2	2
6552	6.....	Dowel	4	4
6610	7.....	Lockwasher	0	5
6635	23.....Nut.....y 0	1	
6659	7,20	Drive Pin..	0	13
6677	7.....	Lockwasher	0	1
6678	7.....	Lockwasher	0	2
6680	23.....Screw	Set	0	1
6685	22.....	Thumb Screw.....0	2	
6695	18,19	Tasher2	4	
6697				
6698	23.....Thumb	Screw.....\0	1	
6699				
6716	7.....Cap	Screw	0	1
6740	10,11	Set Screw	2	2
6743	13,14,17,18,19	Machine Screw	7	10
6744	15.....Retaining	Ring	1	1
6799	15.....Machine	Screw	1	1
6953	20.....Machine	Screw	0	2
6966	2.....Grease	Fitting	1	1
6971	10.....Cap	Screw	2	0
6972	12.....Set	Screw	2	0
14461	3 Key		1	1
1456:	10,11	Key	2	2
1476;	8,9.....Key		4	4
1609:	3.....Key		2	2
1656	15.....Key		1	1
1831	17.....Lockwasher		1	1
1831:	17.....Locknut		1	1

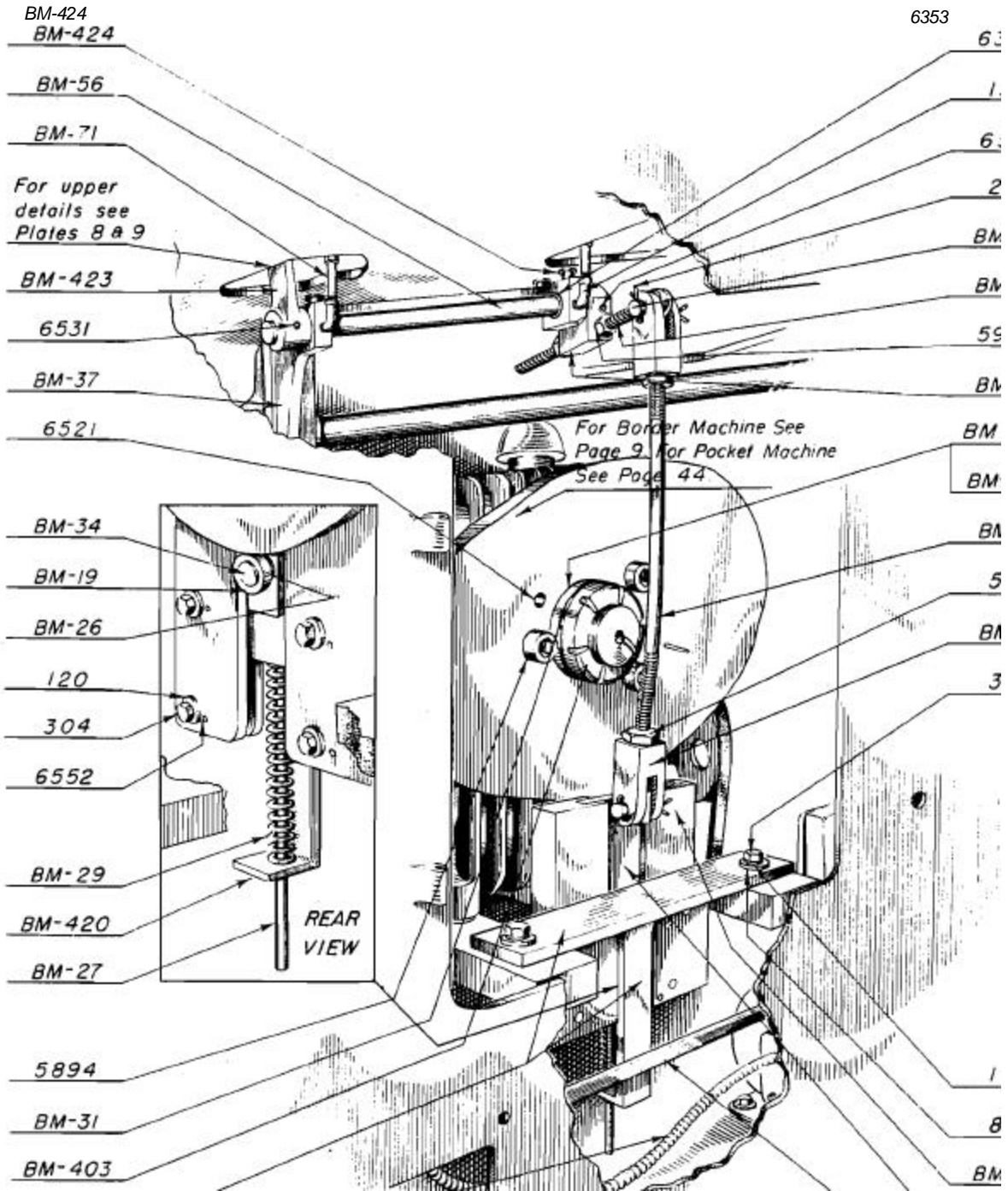




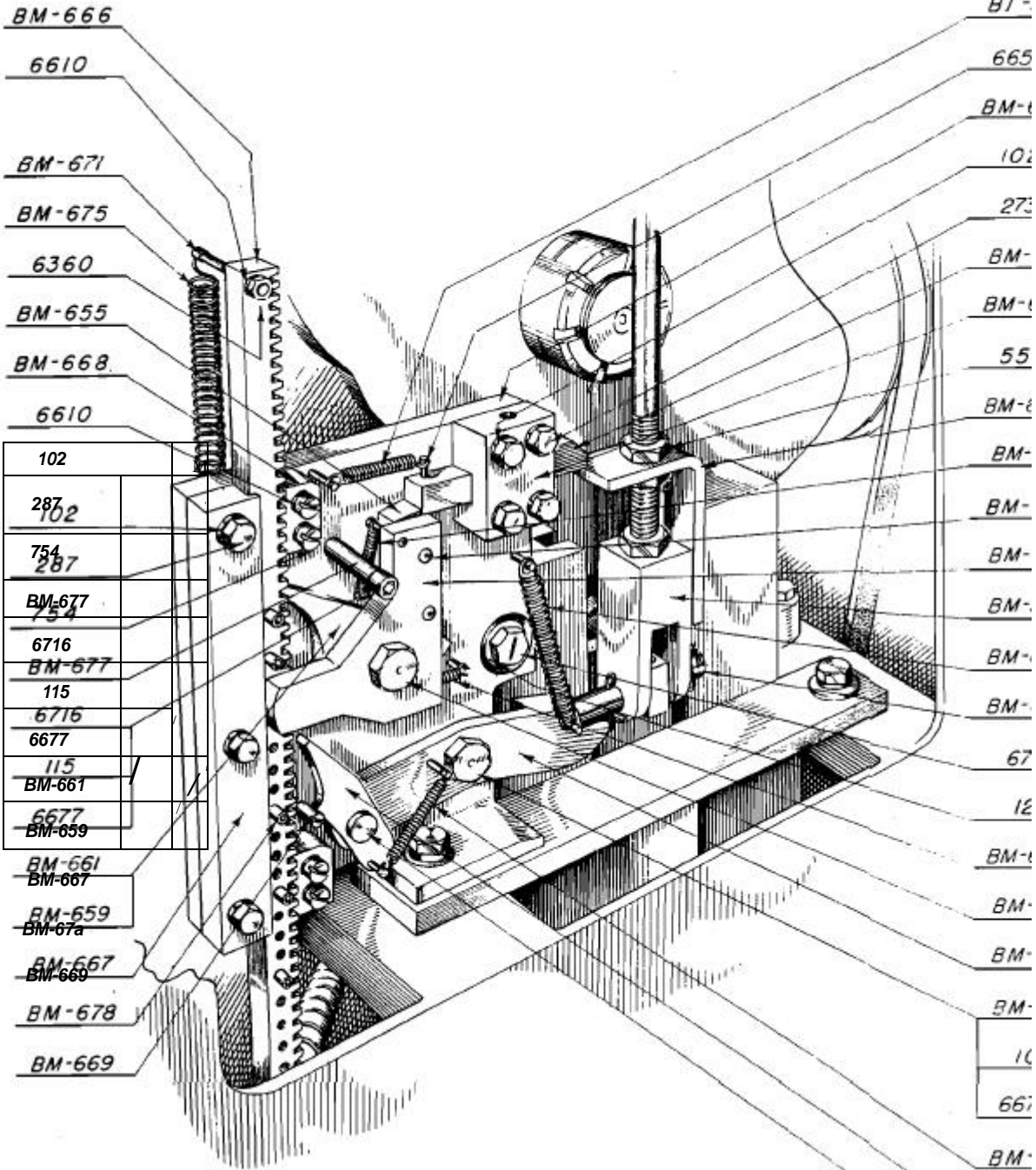








BT-37



AUTOMATIC SPACING ATTACHMENT
FOR UNITED POCKET MACHINES

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BM-202

BM-202

BM-227

BM-256

BM-272

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BM-215

BM-201

BM-206

BM-257

6496

BM-715

BM-713

BM-240

6243

6375

6219

6375

BM-714

BM-716

BM-205

6373

6058

BM-227

BM-423

BM-419

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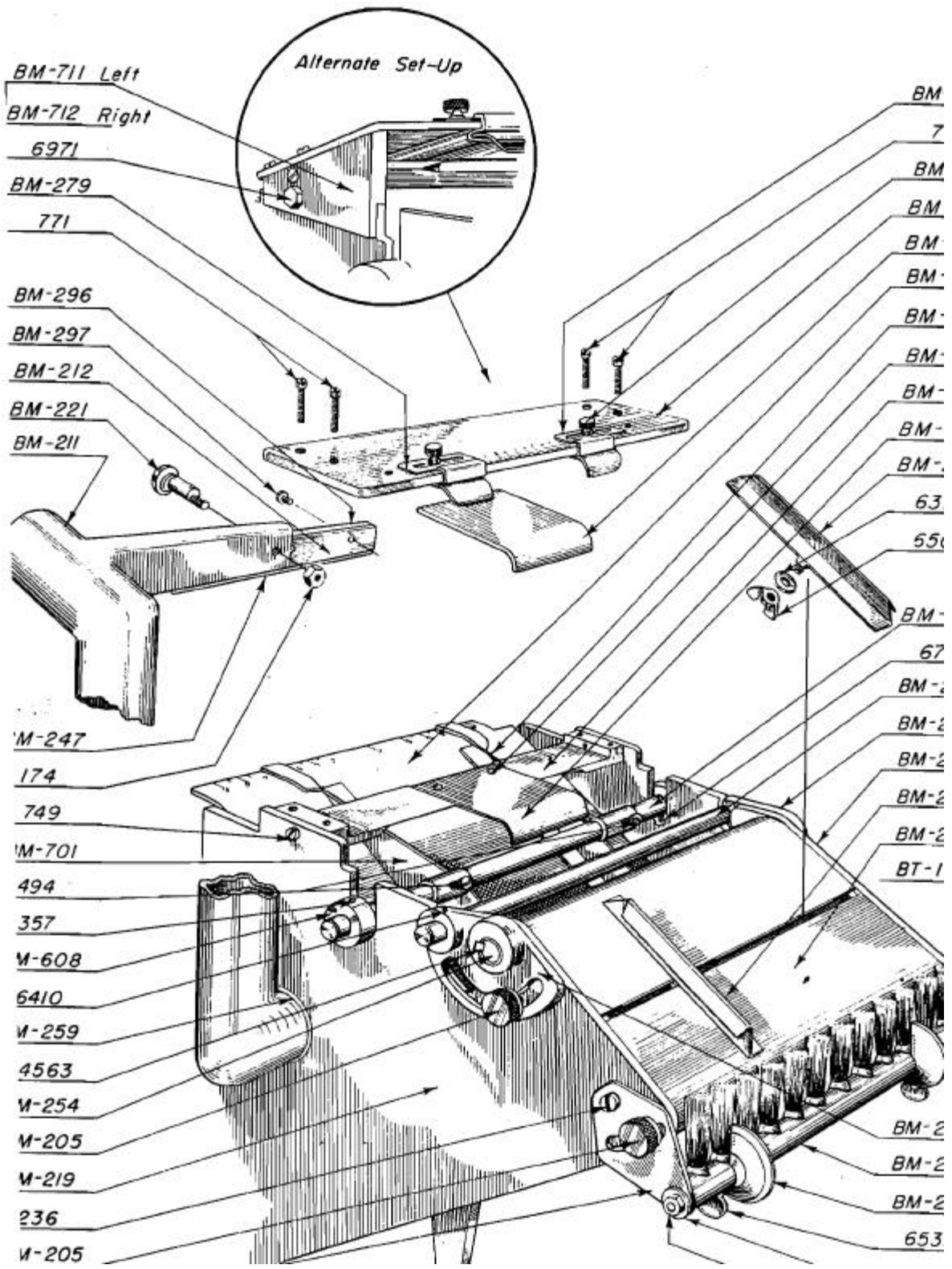
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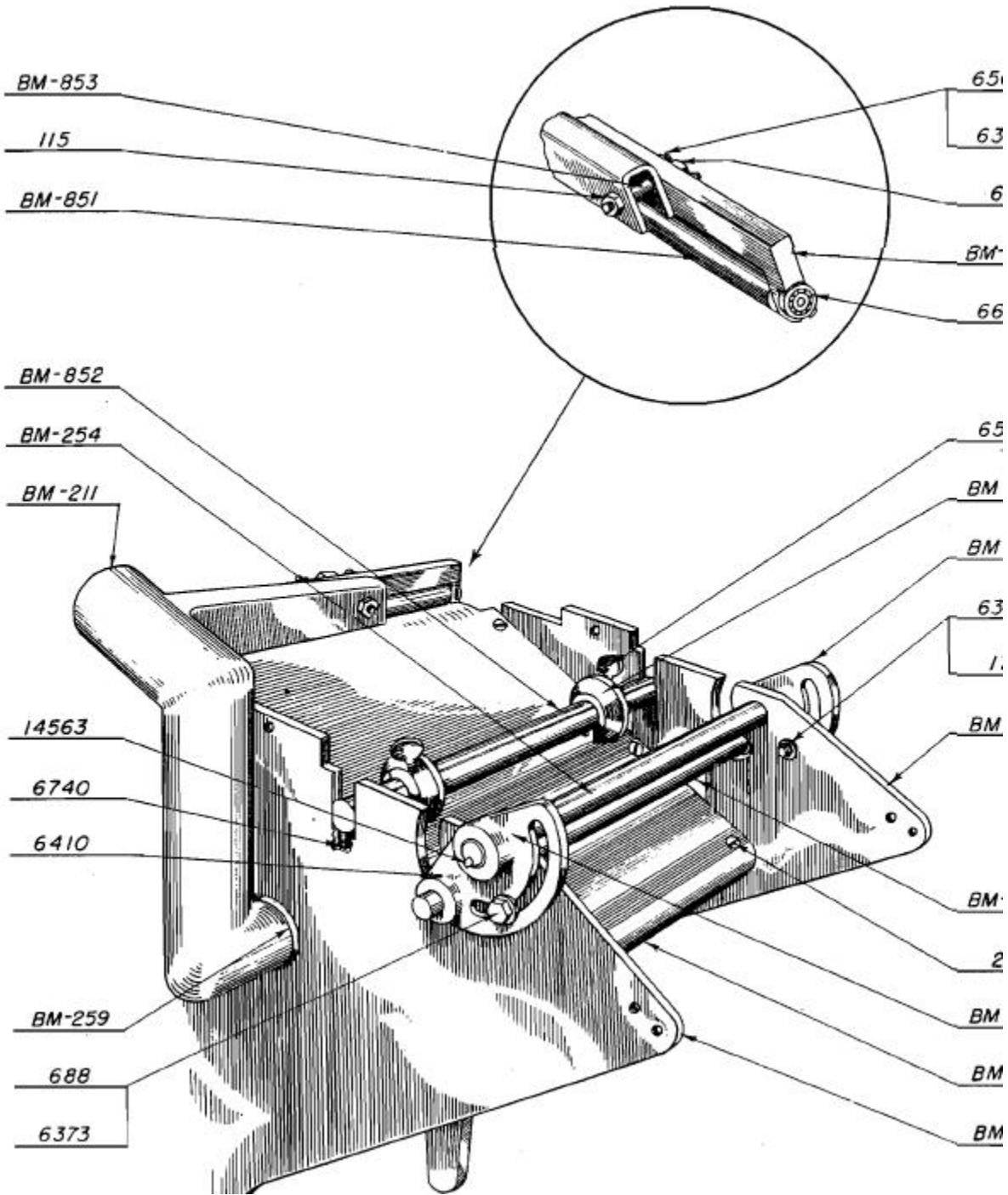
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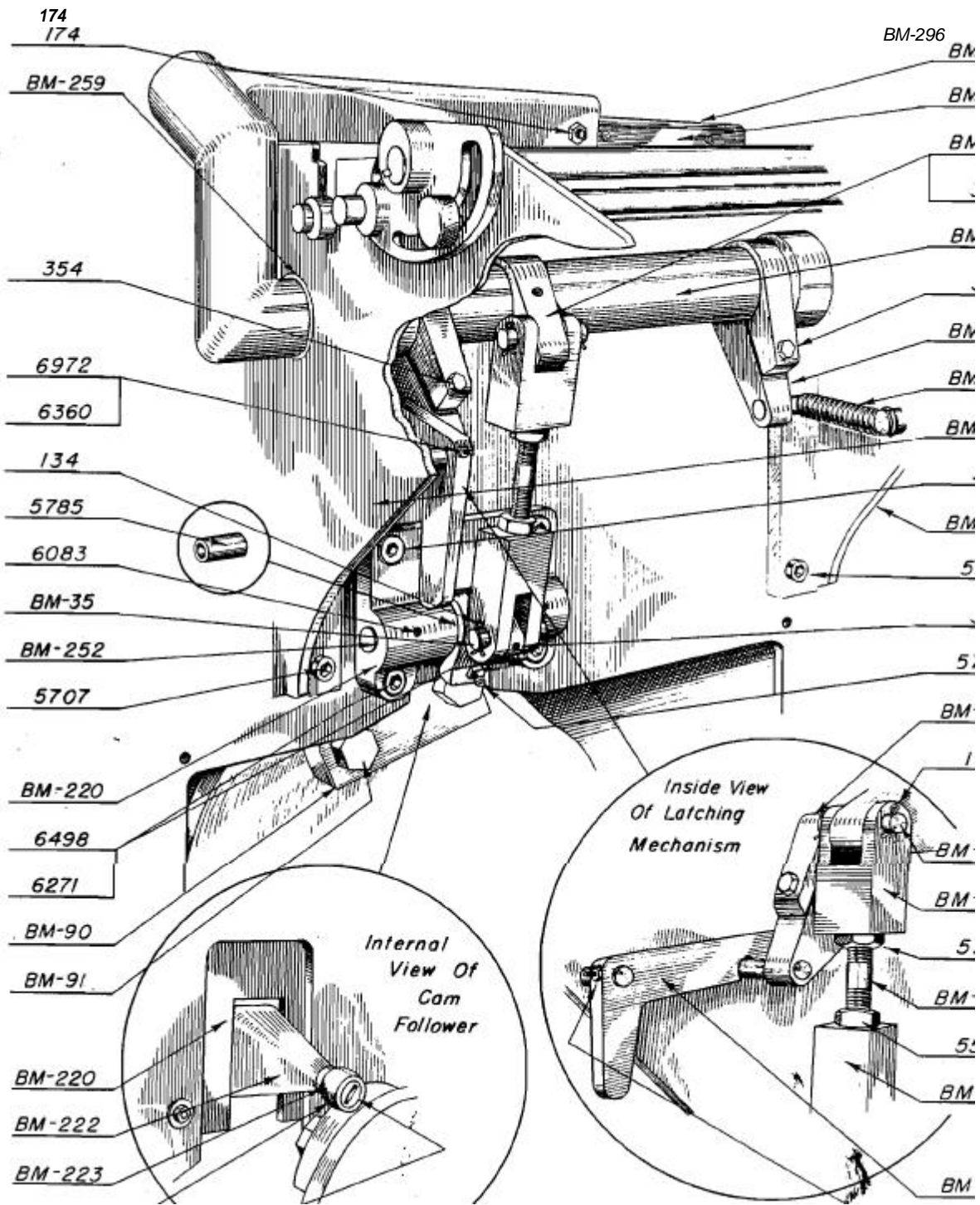


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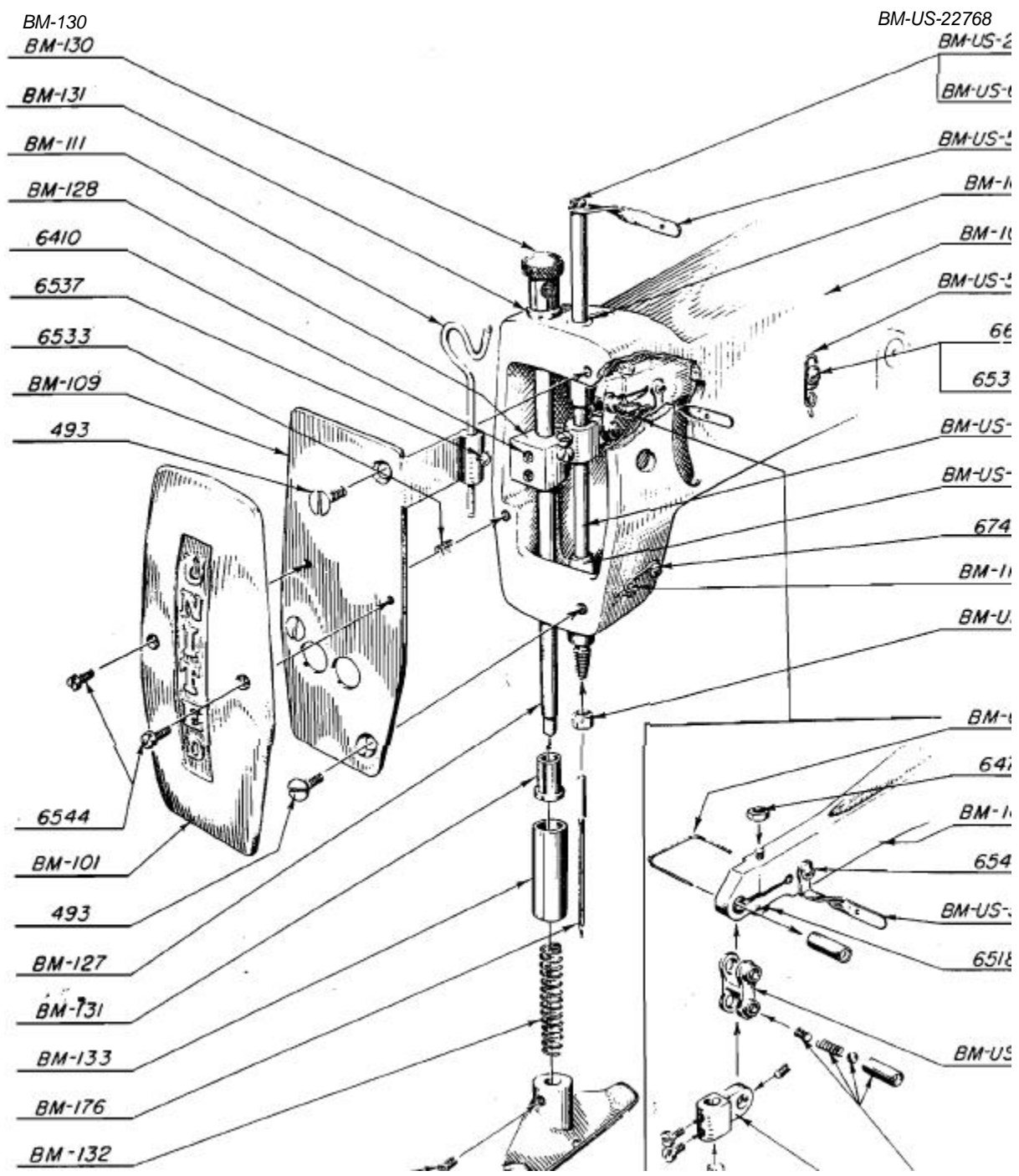


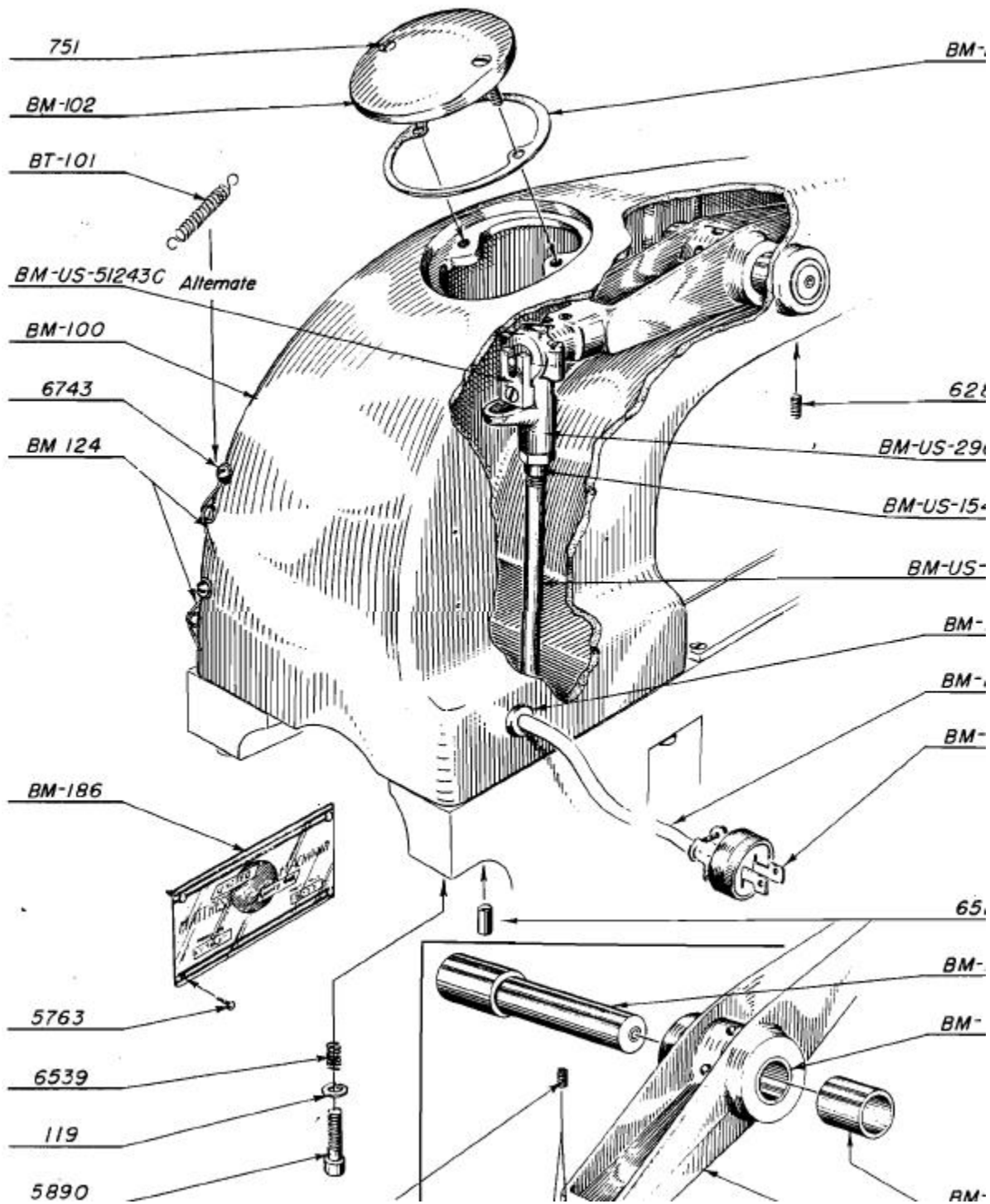
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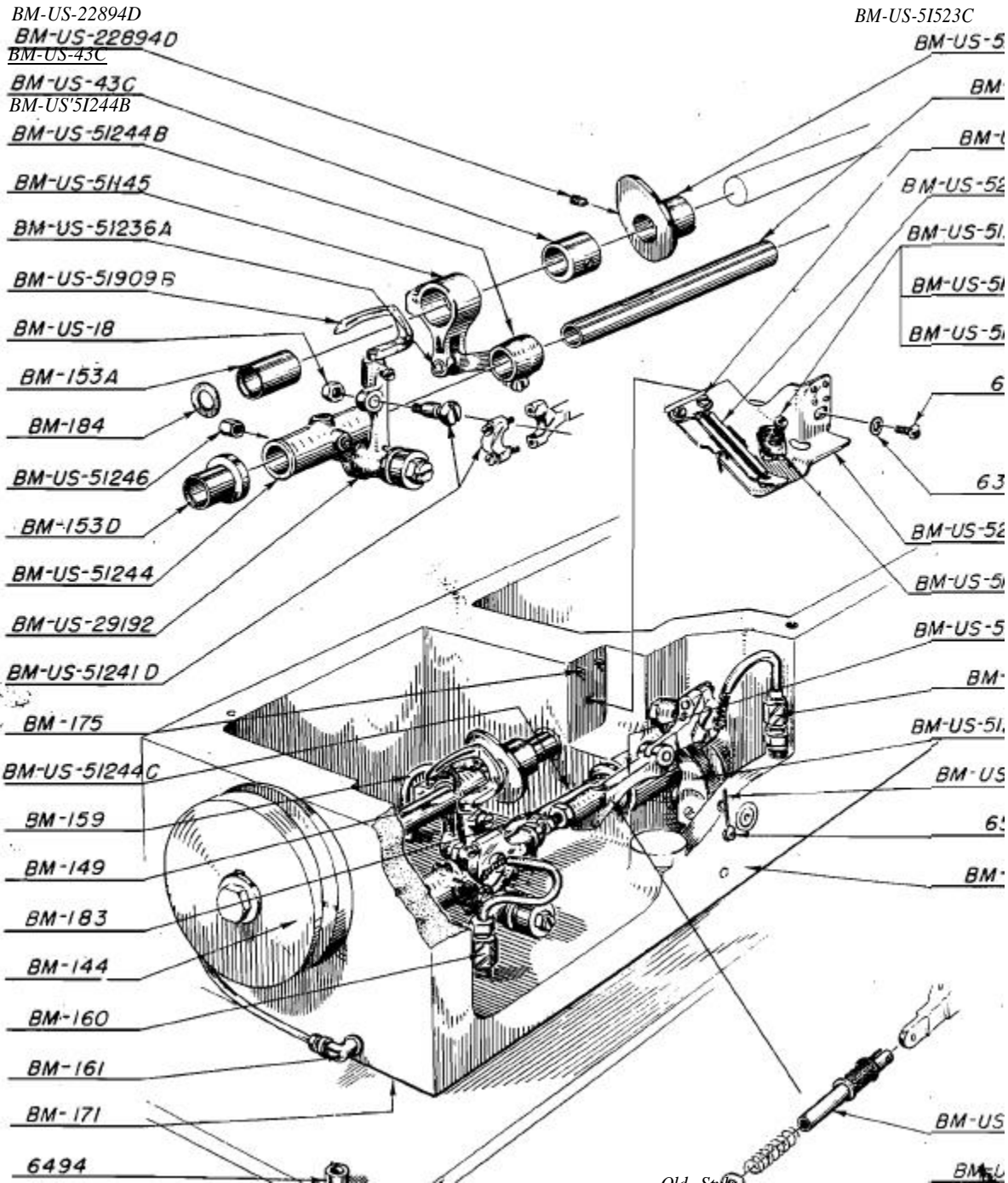
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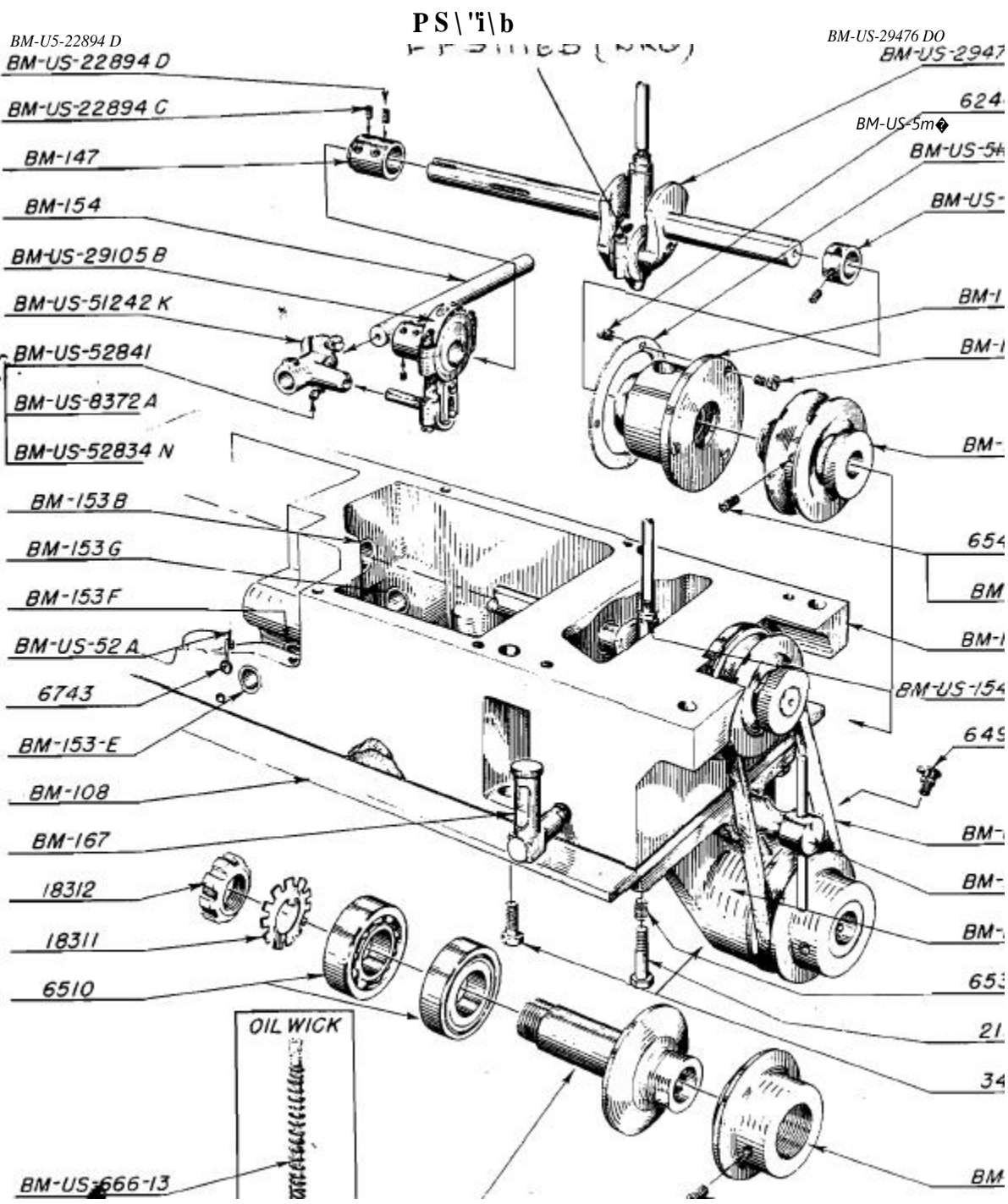
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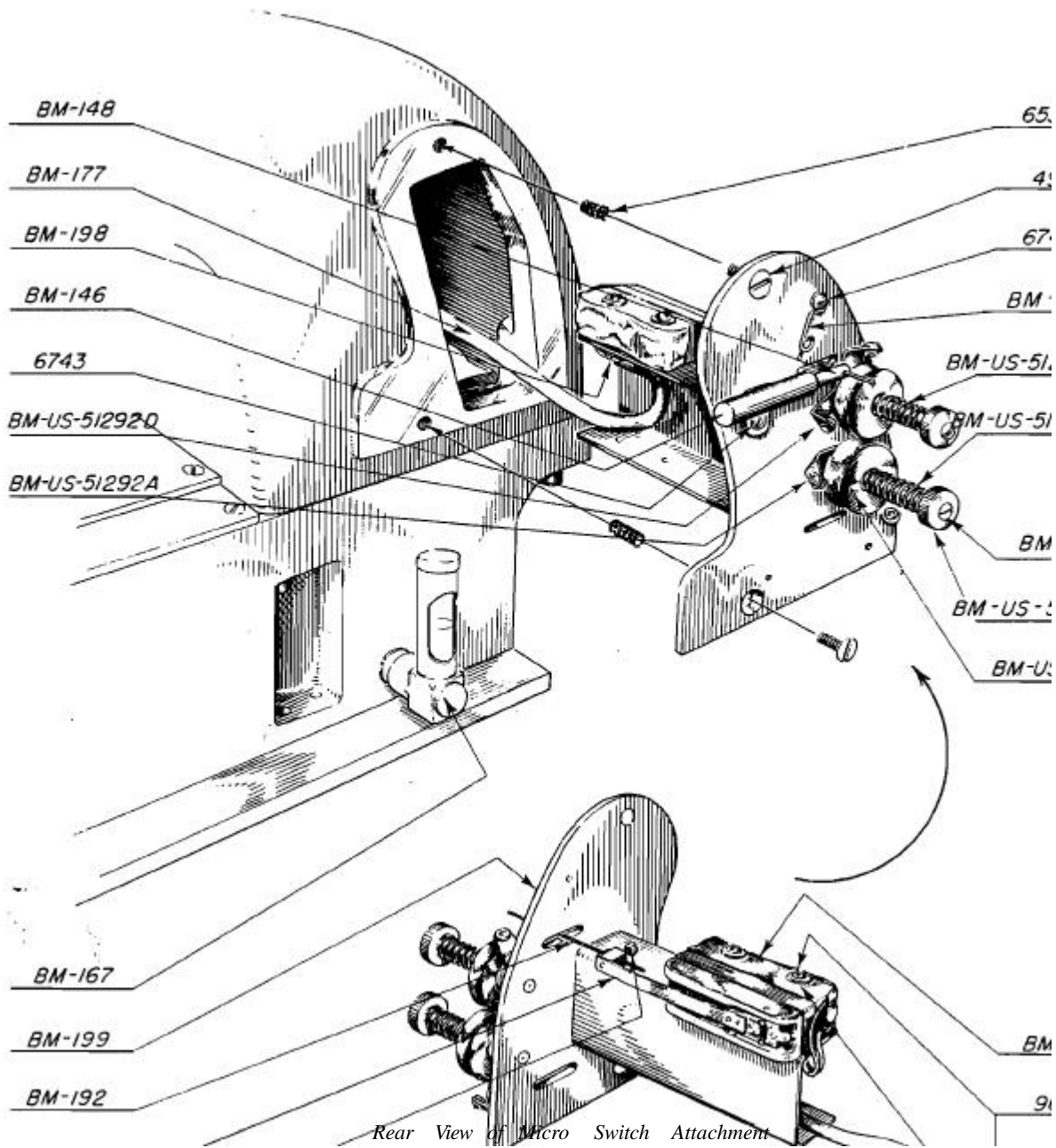
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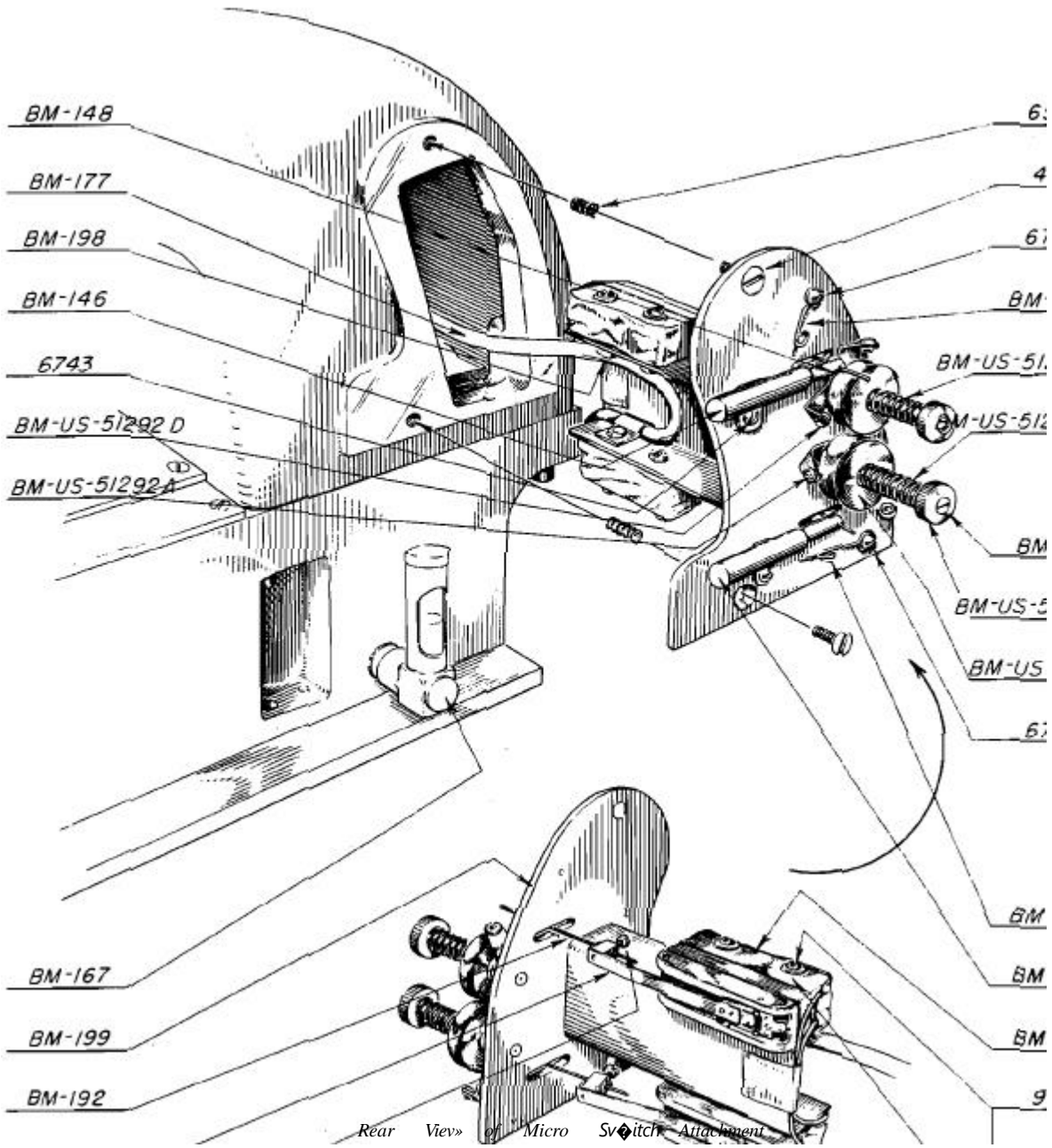
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Rear View of Micro Switch Attachment

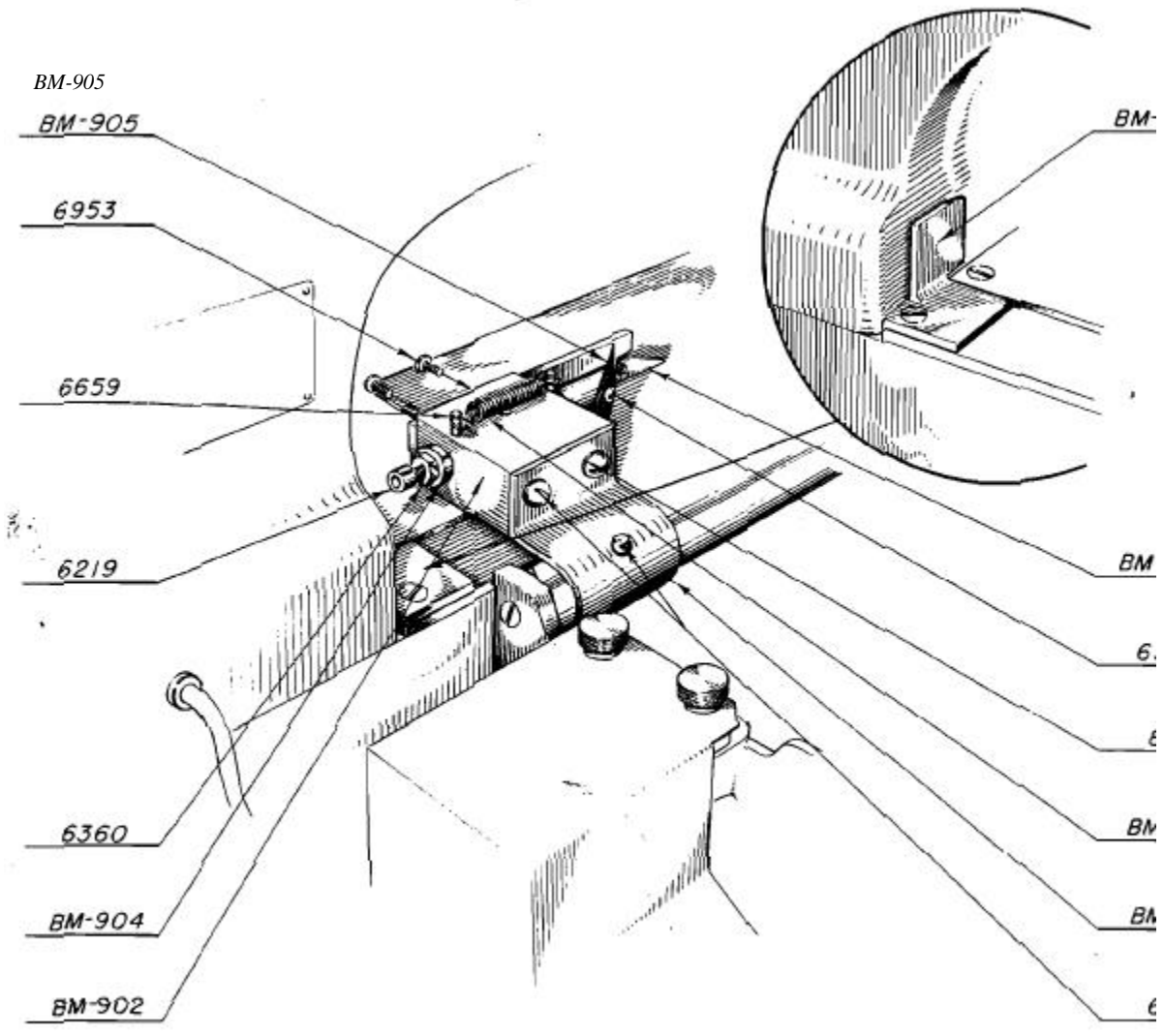
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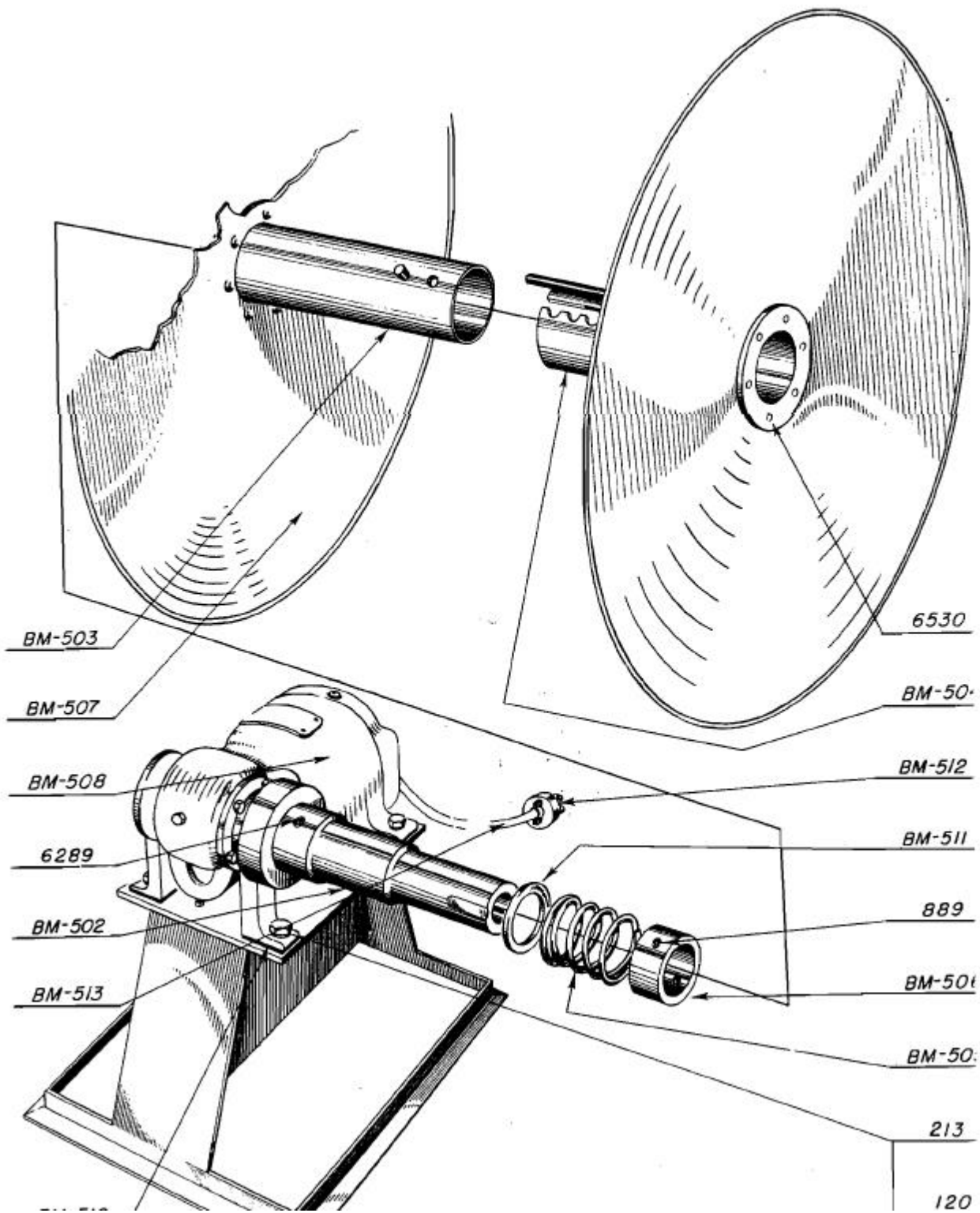
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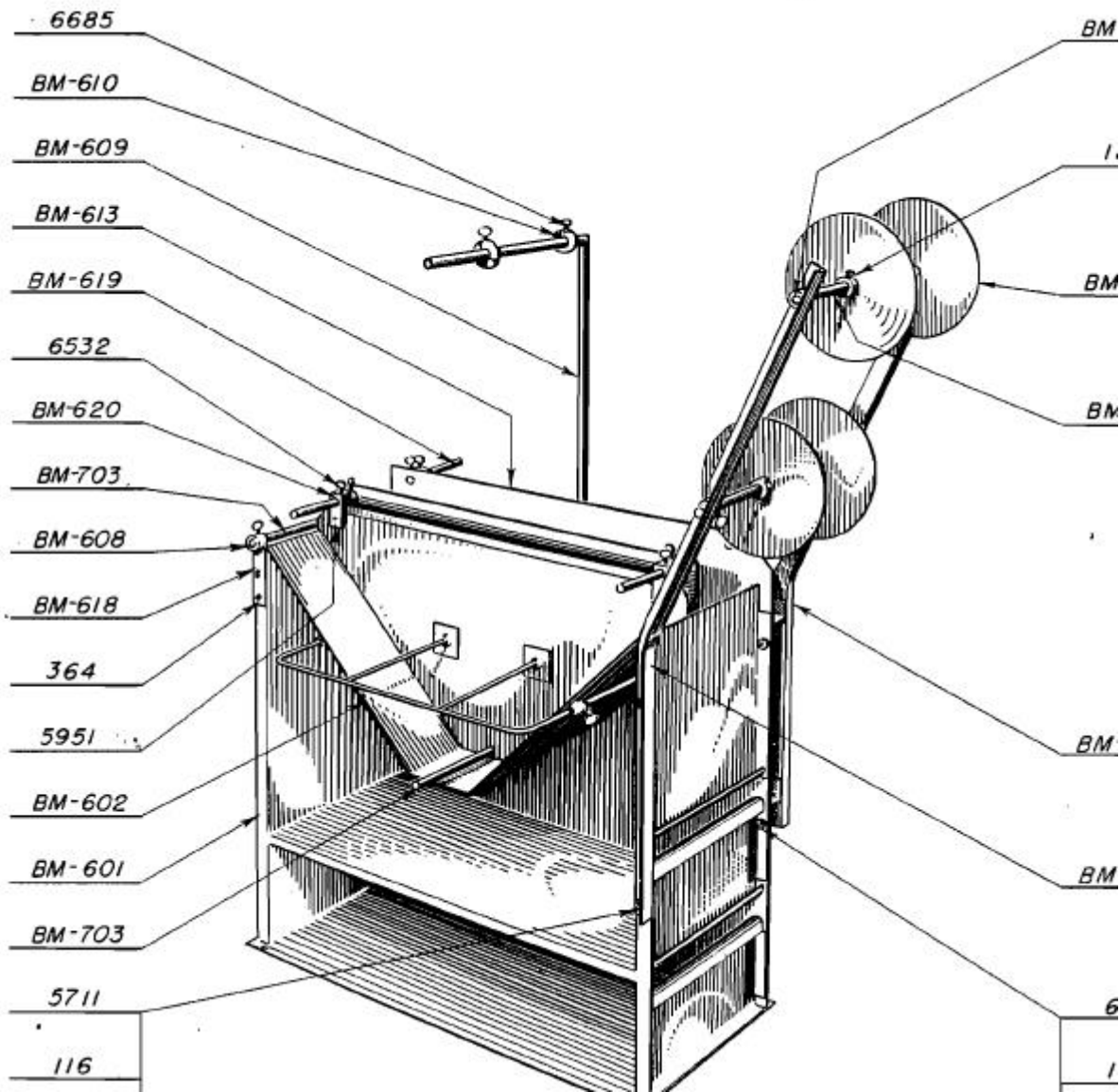
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THREAD CUTTER ATTACHMENT
 FOR UNITED POCKET MACHINE ONLY

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FOR UNITED BORDER MACHINE

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SUPPLEMENTARY PARTS LIST FOR THE
UNITED BORDER MACHINE

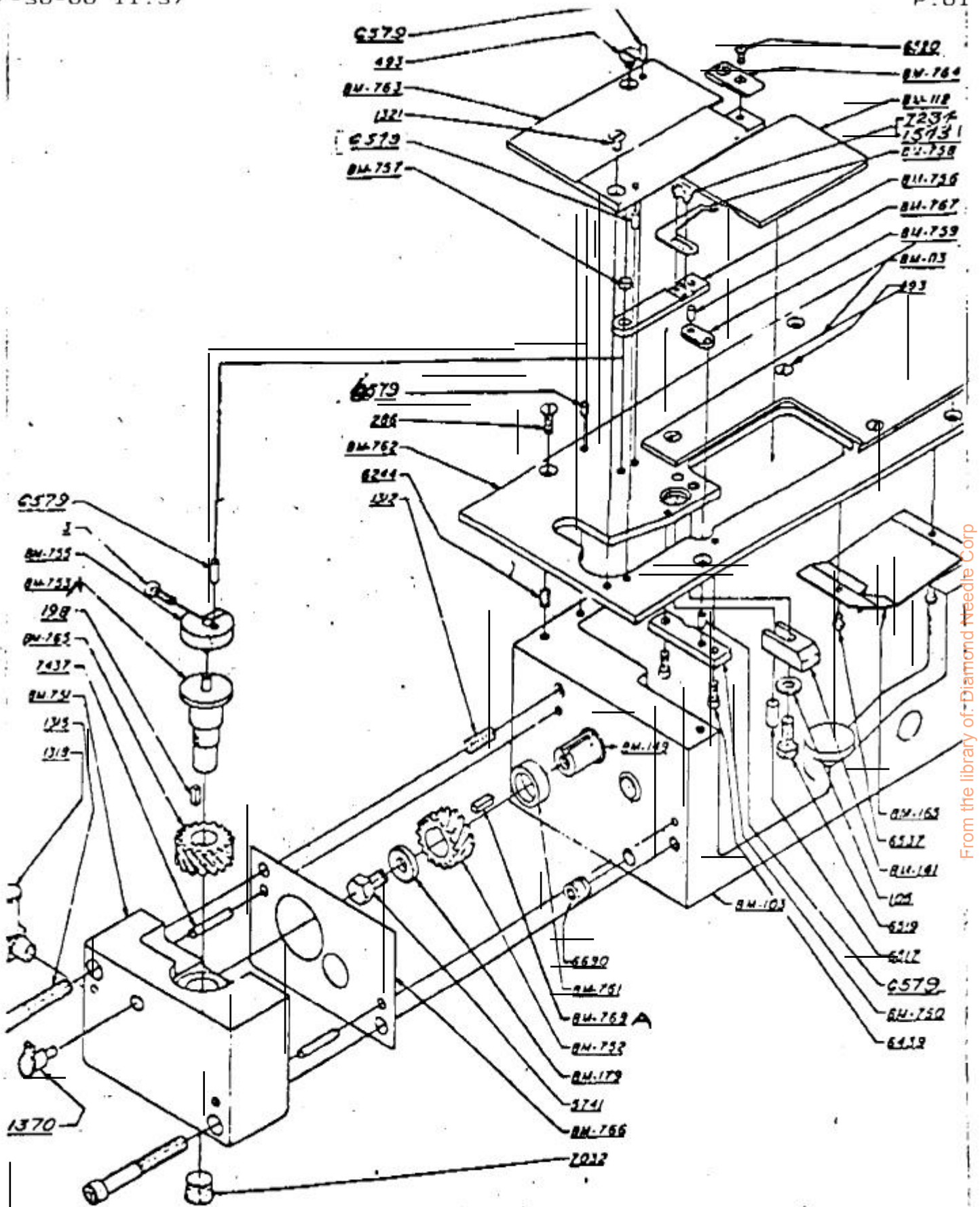
NOTE: This supplementary list describes additional parts used, since in this Manual, due to improvements or revisions of certain features of the Border Machine or Pocket Machine. While not illustrated in the Manual, these parts may be identified by the number on the part itself, or by the description given to the part in this list.

<u>PARTS NO.</u>	<u>NAME</u>	<u>NO. REQ'D</u>
BM-6A	Cloth Centering Disc	_____
BM-69	Cloth Centering Hand Screw....	_____
BM-188	Thread Guide Looper	_____
BM-189	Copper tubing?	_____
BM-302	Magnetic Starter	_____
BM-325	Conduit Junction Box to Micro Outlet#...	_____
BM-A33	Cloth Feed Cam 3-1/2" to 5" Alternate...	_____
BM-43A	Spool Carriage	_____
BM-A35	Cloth feed-Cartridge Bandoleer	_____
BM-A36	Front Cover-Lower Frame	_____
BM-A37	Back Cover-Framing	_____
BM-A38	Front Cover-Tapper Frame	_____
BM-A39	Top Cover-Frame	_____
BM-AA0	Lever End for BM-57.	_____
BM-AA1	Cross Head Bracket	_____
BM-AA2	Pillow Block Bracket	_____
BM-AA3	Crosshead Link Clevis	_____
BM-AAA	Back Frame Cover	_____
BM-AA5	Cloth Feed	_____
BM-A51	Traverse Cam - 3-1/2" to 5"	_____
BM-A75	Speed Reducer..	_____
BM-A76	Raising Block	_____
BM-A77	Trolley	_____
BM-A78	Crosshead Spring Rod Sleeve	_____

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<u>PART NO.</u>	<u>NAME</u>	<u>NO. REQ'D</u>
	Clamp Arm	1
BM-751	Eccentric Finger Gear Case	1
BM-752	Eccentric Finger Drive Gear	1
BM-753	Eccentric Finger Shaft	1
BM-T5 ◆	Key for BM-765	1
BM-755	Eccentric	1
BM-756	Eccentric Finger Ann	1
BM-758	Eccentric Finger	1
BM-759	Eccentric Finger Pivot Link	1
BM-760	Eccentric Finger Support Bar	1
BK-761	Eccentric Finger Spacer	1
BM-762	Underhead Base Plate	1
BM-763	Throat Plate	1
BM-76U	Throat Plate Insert	1
BM-765	Gear (Helical)	1
BM-766	Gear Case Gasket	1
Bf1-766	Feed Rolls - Spacer Block	2
BM-777	Feed Roll Lock and Cover	1
BM-778	Lever Shaft	1
BM-779	Cloth Control Apron - Rear	1
BM-780	Finished Border Guide Frame	1
BM-908	Bracket	1
BM-909	Clamp	1
BM-US-512I42M	Washer	1
BM-US-512U2X	Looper Drive Lever, Incl. Screws ...	1
BM-US-51I19IC	Thread Eyelet	:
BM-US-528UIG	Looper Drive Ball Joint	1
	Lock Stud	1
BM-US-528I4IH	Locking Nut	1
HS-57-B	Folder Plate - 1 each	2
	R&L	1
HS-57-C	Folder Plate - Flat	1
HS'37-D	Folder Plate - Flat	1
XX-83 ◆	Bushing	1

(12-9-65)



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