



Union Special
INDUSTRIAL SEWING EQUIPMENT

STYLES

**ADJUSTING INSTRUCTIONS AND
ILLUSTRATED PARTS LIST**

54200A

54200C

54200E

54200F

54200G

54200K

54200N

54200P

STREAMLINED MULTIPLE NEEDLE MACHINES

54400C

54400E

54400F

54400G

54400H

54400J

CATALOG

NO. 102L

**THIRD
EDITION**

THIRD EDITION
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Catalog No. 102 L

LIST OF PARTS

Classes 54200, 54400

STYLES

54200 A	54200 G	54400 A	54400 G
54200 C	54200 K	54400 C	54400 H
54200 E	54200 N	54400 E	54400 J
54200 F	54200 P	54400 F	

Third Edition

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UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES

CHICAGO

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FOREWORD

The Classes 54200 and 54400 streamlined machines covered by this catalog, represent the latest design in the UNION SPECIAL flat bed line. Light weight needle bars and driving mechanisms and light weight presser bars make it possible to attain the utmost in speed and production. Automatic lubrication, with a pump for returning filtered oil to the main reservoir has made maintenance simple. A conveniently located throw-out device enables the operator to disengage the loopers from their driving mechanism, thus exposing the heel and eye of each looper for easy threading. Some styles are equipped with a close coupled puller, with the clutch mechanism in the upper roller, to insure a uniformly controlled feeding, and an elastic metering device to allow the required amount of elastic in each garment. All parts are made by precision methods insuring complete interchangeability.

It is our constant aim to furnish carefully prepared information which will enable our customers to secure all possible economies from the use of UNION SPECIAL machines. The following pages illustrate and describe the parts for styles in Classes 54200 and 54400.

Additional catalogs, containing information relative to these machines and which will be furnished on request, are listed below:

Catalog No. 45 N
Form 357

Needle Manual
Engineering Department

Adjusting Instructions. Specify the style
of machine for which the adjusting
instructions are required.

In all manufacturing centers will be found Union Special representatives, who will cooperate with those who desire in planning and estimating their requirements.

UNION SPECIAL CORPORATION

Engineering Department

IDENTIFICATION OF MACHINES

Each UNION SPECIAL carries a style number which is stamped in 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 54200 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: "54200 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: "54200".

APPLICATION OF CATALOG

This catalog applies specifically to the standard styles of machines as listed herein. It can also be applied with discretion to the special machines in Classes 54200 and 54400. 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.

STYLES OF MACHINES

Streamlined, Enclosed Type, Flat Bed, Independent Row, Four, Nine and Twelve Needles Abreast, Light Weight Presser Bar Mechanism, Light Weight Needle Bar Drive Mechanism, Double Locked Stitch, Type 401. Loopers in Line With Feed, Looper Throw-out for Simplified Threading, Automatic Enclosed Type Oiling System, Filter Type Oil Return Pump, Oil Pan Base Plate and Head Oil Siphon Assembly.

54200 A-4 High Throw Machine, for attaching woven elastic to boxer type shorts, children's play suits, boys' trousers, swimming trunks, etc., on medium heavy to heavy weight materials. Body of garment turned downwardly, elastic not covered, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 4800 R. P. M.

54200 C-4 Same as 54200 A-4, except no attachment or elastic strip tension.

54200 E-4 High Throw Machine, for attaching woven elastic to swimming trunks, walking shorts, children's play suits, boys' trousers, hobby jeans, etc., on medium to heavy weight materials. Body of garment turned downwardly, elastic not covered, equipped with close coupled puller, upper roller driven, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 4800 R. P. M.

54200 F-4 Same as 54200 E-4, except no attachment or elastic strip tension.

54200 G-4 Same as 54200 E-4, except fitted with elastic metering device.

54200 K-4 High Throw Unequal Space Machine, for banding denim dungarees and overalls. Right angle folder, close coupled puller, upper roller driven. Standard gauges Nos. 12-56-12, 16-64-16. Seam Type BSc-4. Maximum recommended speed 4800 R. P. M.

54200 N High Throw Single Needle Machine equipped with close coupled puller with 3/4 inch wide rubber puller rollers, upper roller driven. For seaming trousers, skirts, jackets and similar garments made from Koratron and durable press materials; where seam is primarily straight. Seam Type 401-SSa-1. Maximum recommended speed 5500 R. P. M.

STYLES OF MACHINES (Continued)

- 54200 P Same as Style 54200 N except equipped with compensatory presser foot with yielding section to the left of needle hole. Seam Type 401-SSa-1. Maximum recommended speed 5500 R. P. M.
- 54400 A-4 Low Throw Machine, for attaching woven elastic to boxer type shorts, children's play suits, boys' trousers, etc., on light to medium weight materials. Body of garment turned downwardly, elastic not covered, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 5000 R. P. M.
- 54400 C-4 Same as 54400 A-4, except no attachments or elastic strip tension.
- 54400 E-4 Low Throw Machine, for attaching woven elastic to boxer type shorts, pajamas, etc., on light to medium weight materials. Body of garment turned downwardly, close coupled puller, upper roller driven, swing-out folder. Standard gauges Nos. 16, 21, 24, 32. Seam Type LSk-4, modified. Maximum recommended speed 4800 R. P. M.
- 54400 F-4 Same as 54400 E-4, except no attachments or elastic strip tension.
- 54400 G-4 Same as 54400 E-4, except fitted with elastic metering device.
- 54400 H-9, -12 Nine and Twelve Needle Machine, equally spaced, for decorative stitching operations on women's and children's dresses, blouses, coats, beachwear, and for similar operations on light to medium weight material. No attachment or thread stand. Standard gauge for nine needle No. 16; standard gauge for twelve needle No. 12. Maximum recommended speed 4000 R. P. M.
- 54400 J-9, -12 Same as 54400 H-9, -12, except equipped with close coupled puller, upper roller driven.

NEEDLES

Each UNION SPECIAL needle has both a type number and a 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, midway between the shank and the eye. Collectively, the type number and size number represents the complete symbol.

The standard needle for all Styles in Classes 54200 and 54400, is Type 113 GS, except Styles 54200 K, 54200 N and 54200 P which uses needle Type 133 GS. The descriptions of these needles and the sizes available are listed below.

<u>Type No.</u>	<u>Description and Sizes</u>
113 GS	Round shank, round point, extra short, double groove, spiral groove, struck groove, ball eye, spotted, chromium plated - sizes 075/029, 080/032, 090/036, 100/040, 110/044, 125/049, 140/054.
133 GS	Round shank, round point, short, double groove, spiral groove, struck groove, ball eye, spotted, chromium plated - sizes 080/032, 090/036, 100/040, 110/044, 125/049, 140/054.

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 113 GS, Size 100/040".

NEEDLES (Continued)

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.

ORDERING REPAIR PARTS

ILLUSTRATIONS

This catalog has been so arranged as to simplify the ordering of repair parts. Exploded views of the various sections of the mechanism are shown so that the parts may be seen in their actual position in the machine. On the page opposite the illustration will be found the listing of the parts with their part number, descriptions, and the number of pieces required in the particular view being shown.

The numbers in the first column are reference numbers only, and indicate the position of that part in the illustration. The reference number should never be used in ordering parts. Always use the part number shown in the second column.

Those component parts of sub-assemblies, which can be furnished for repairs, are indicated by the fact that their descriptions are indented under the description of the main sub-assembly. Example:

29126 DE	Puller Drive Eccentric Assembly -----	1
95	Screw-----	2
22587	Bearing Cap Screw -----	2

It will be noted in the above example that the eccentric and bearing are not listed. The reason for this is that the replacement of any of these parts individually is not recommended and the complete sub-assembly should be ordered.

In those cases where a part is common to all of the machines covered by this catalog, no specific usage will be mentioned in the description. However, when the parts for the various machines are not the same, the specific usage will be mentioned in the descriptions, and if necessary, the difference will be shown in the illustration.

At the back of the book will be found a numerical index of all the parts shown in the illustrations, which will facilitate locating the illustration and description when only the part number is known.

IDENTIFYING PARTS

Where the construction permits, each part is stamped with its part number. On some smaller parts, and on those where the construction does not permit, an identification letter is stamped to distinguish the part from similar ones.

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

USE GENUINE NEEDLES AND REPAIR PARTS

Success in the operation of these machines can be secured only by the use of 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 made with the utmost precision. The maximum efficiency and durability are assured.

USE GENUINE NEEDLES AND REPAIR PARTS (Continued)

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 strictly net cash and subject to change without notice. All shipments are forwarded at the buyer's risk f. o. b. shipping point. Parcel post shipments are insured unless otherwise directed. A charge is made to cover the postage and insurance.

OILING AND THREADING INSTRUCTIONS

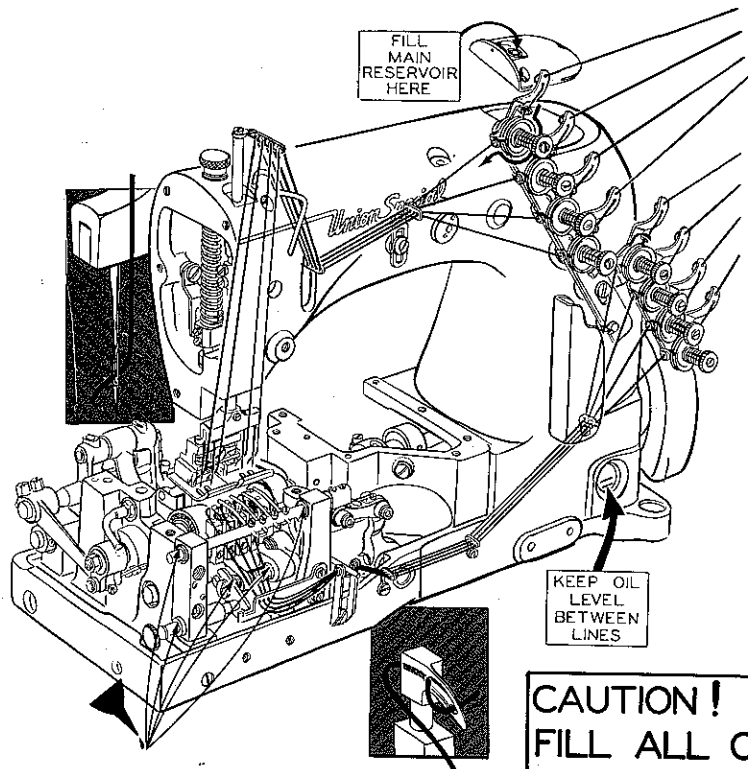
The oil has been drained from the machine before shipping, and the reservoir must be filled before beginning to operate. Use a straight mineral oil with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit.

Oil is filled at the spring cap in the top cover, and the oil level is checked at the sight gauge on the front of the machine. The capacity of the oil reservoir is twelve ounces.

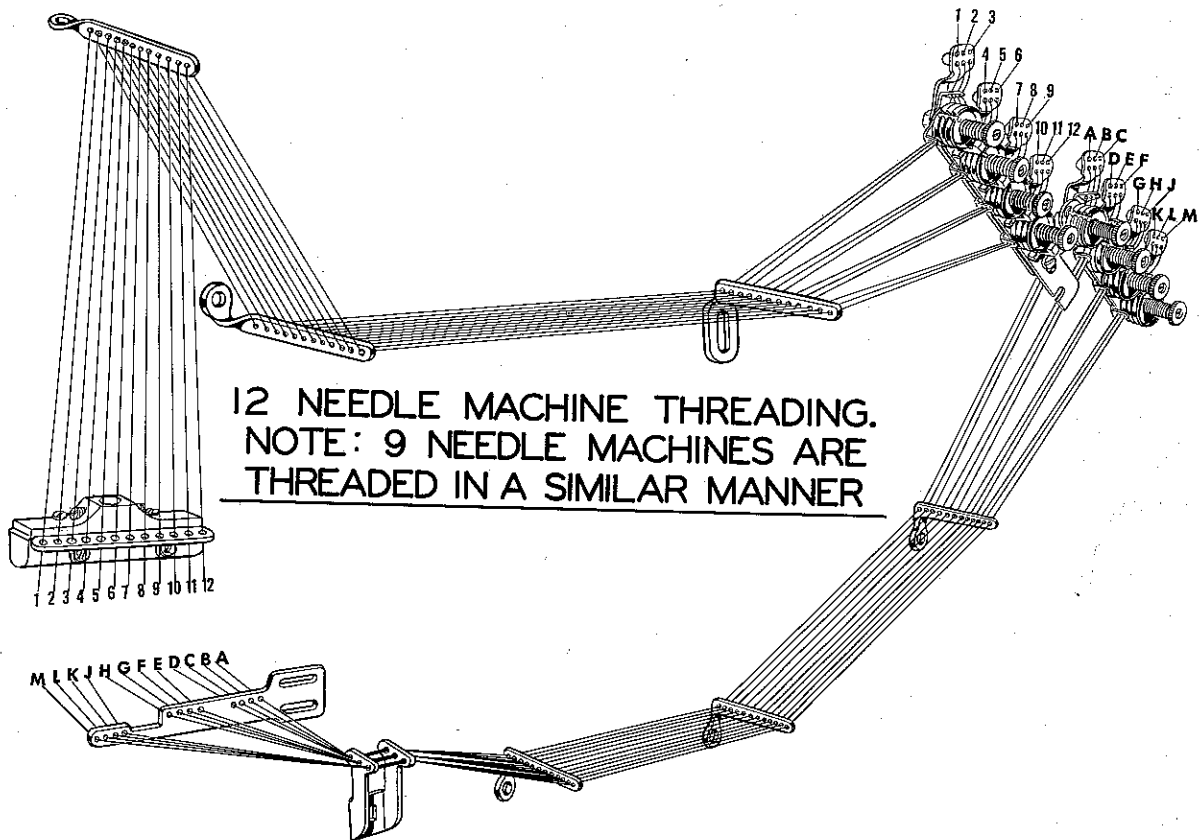
The machine is almost entirely automatically lubricated, and no oiling other than an occasional drop of oil at both bearings of the retainer holder, the looper throw-out pin, and looper holder frame locking pin, as indicated in the oiling diagram, are required.

A daily check before the morning start should be made, to see that the level of the oil in the main reservoir is kept between the two red lines on the gauge. Oil which has gone through the machine is filtered and pumped back into the main reservoir, making too frequent oilings unnecessary. Excessive oil in the main reservoir may be drained at the plug screw in the main frame directly under the handwheel. After draining oil, wipe the hole and plug screw dry, paint hole and screw with a little gasket cement, and re-assemble screw.

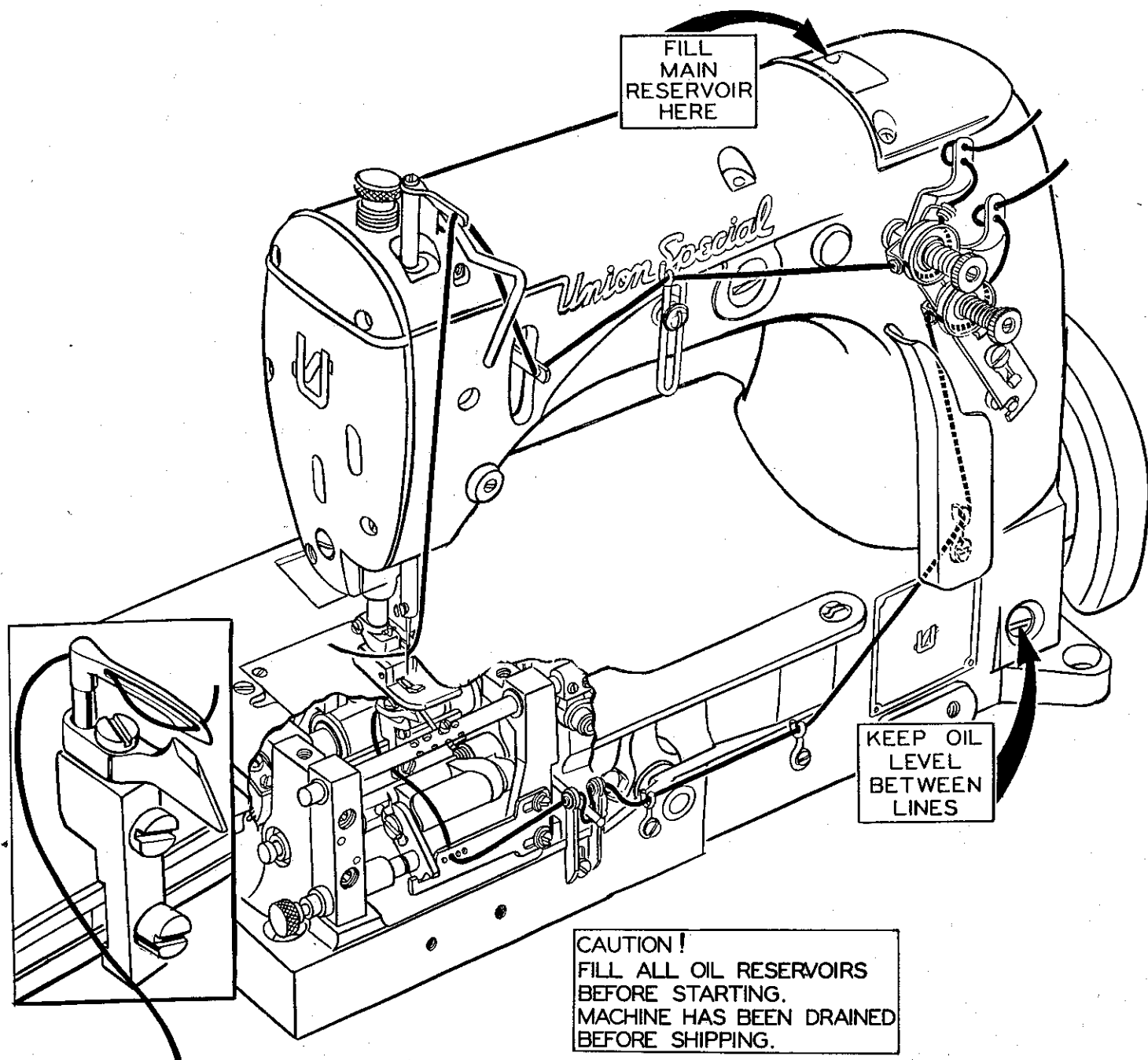
The accompanying drawings also show the manner in which the machine is threaded. Please note, that the needles are inserted in the needle holder with the eyes in a plane at right angles to the direction of line of feed, and are threaded from right to left.



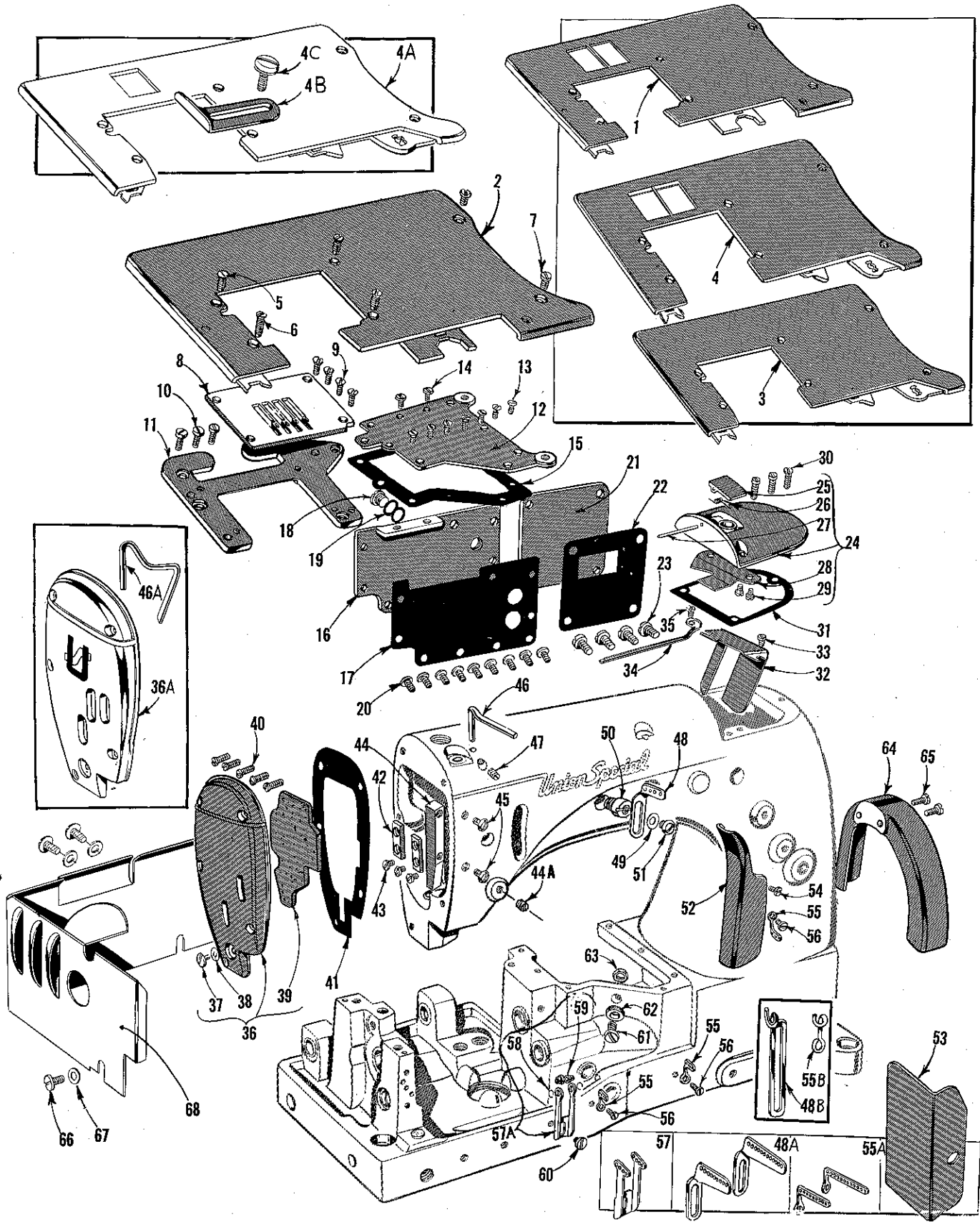
4 NEEDLE MACHINE THREADING.



THREADING AND OILING DIAGRAM FOR STYLES 54200 N AND 54200 P

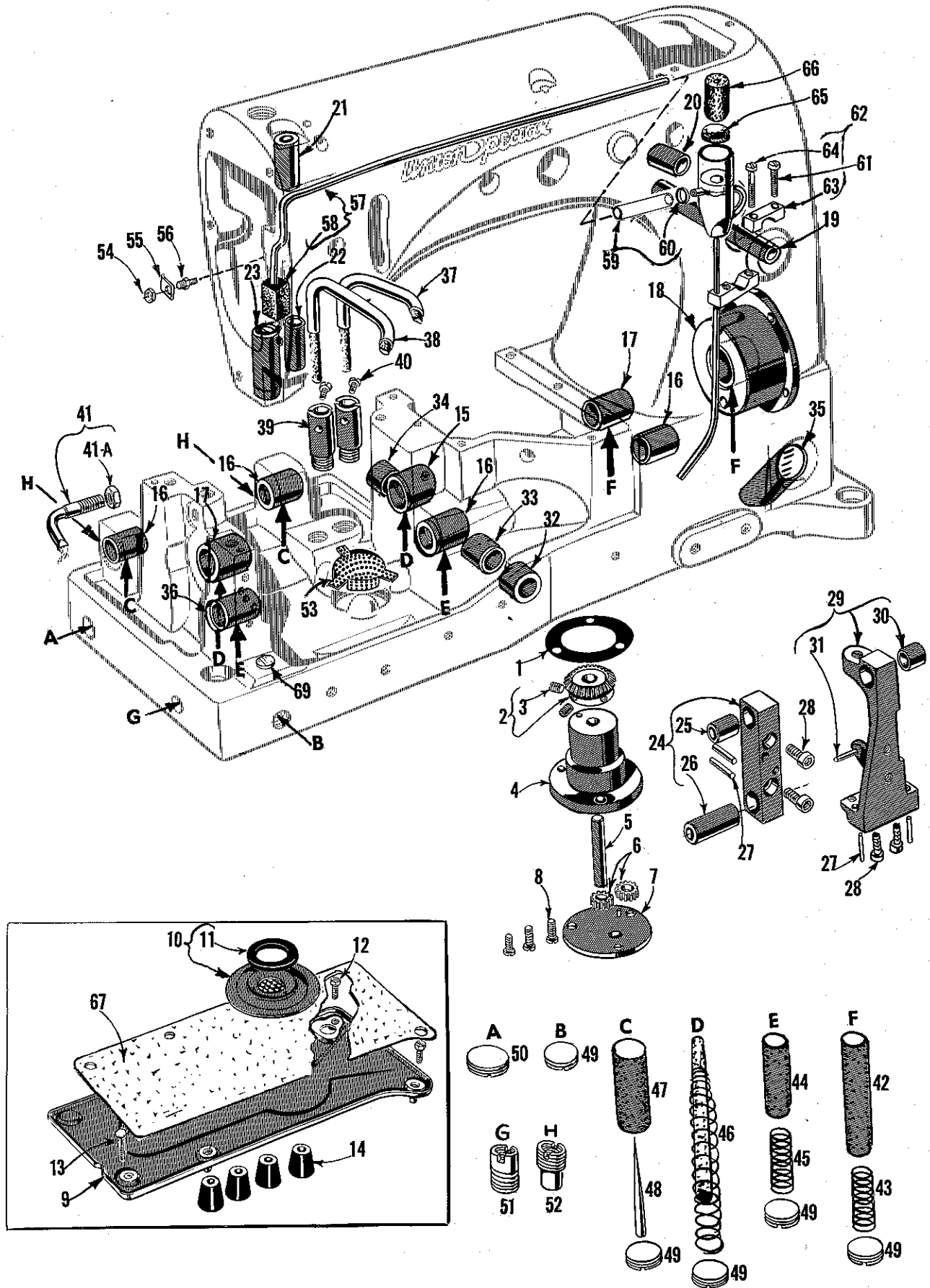


EXPLODED VIEWS
AND
DESCRIPTION OF PARTS
FOR
54200 MULTIPLE NEEDLE MACHINES



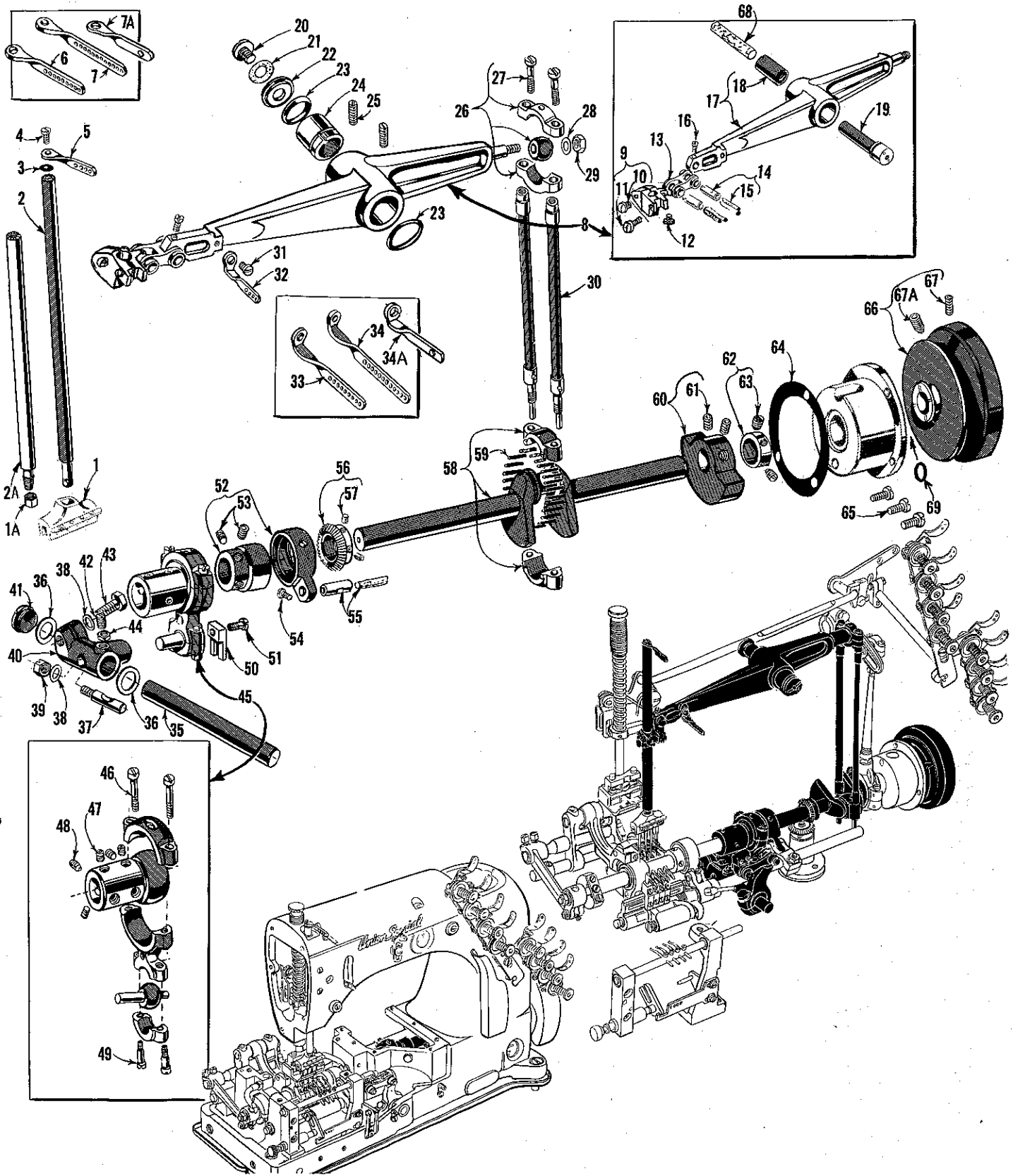
MAIN FRAME, MISCELLANEOUS COVERS AND PLATES

Ref. No.	Part No.	Description	Amt. Req.
1	54201 B	Cloth Plate, for Styles 54200 E, F, G, K-4-12-56-12, 54400 E, F, G	1
2	54201 C	Cloth Plate, for Styles 54200 A, C, 54400 A, C	1
3	54401	Cloth Plate, for Style 54400 H	1
4	54401 A	Cloth Plate, for Styles 54200 K-4-16-64-16, 54400 J	1
4A	54201 D	Cloth Plate, for Styles 54200 N, P	1
4B	24 X	Edge Guide, for Styles 54200 N, P	1
4C	22517 B	Screw, for edge guide, on Styles 54200 N, P	1
5	80	Screw	3
6	22574	Screw	1
7	22839 C	Screw	2
8		Throat Plate (see pages 31, 33)	1
9	87	Screw	4
10	22839	Screw	3
11	54280	Throat Plate Support, for machines without puller	1
12	53782 B	Oil Reservoir Top Cover	1
13	22524	Screw	7
14	22585 A	Screw	2
15	51382 A	Gasket	1
16	52882 L	Oil Reservoir Back Cover	1
17	52882 M	Gasket	1
18	22733 B	Plug Screw, for oil reservoir back cover	1
19	41394 A	Gasket	2
20	22848	Screw	9
21	52882 AE	Crank Chamber Cover	1
22	52882 U	Gasket	1
23	22548	Screw	4
24	52882 AD	Crank Chamber Oil Cover	1
25	39582 L	Oil Cap	1
26	52882 AC	Oil Cap Torsion Spring	1
27	50-789 Blk.	Oil Cap Hinge Pin	1
28	52882 AA	Oil Drip Plate	1
29	90	Screw	2
30	22541 B	Screw	3
31	52882 P	Gasket	1
32	52882 Y	Baffle Plate	1
33	90	Screw	1
34	51282 AE	Needle Lever Bearing Oiler	1
35	90	Screw	1
36	51282 Y	Head Cover, for all Styles except 54200 N, P and 54400 H, J	1
	51782 A	Head Cover, for Styles 54400 H, J	1
36A	54282 A	Head Cover, for Styles 54200 N, P	1
37	22542	Plug Screw	1
38	52882 W	Gasket	1
39	54282 B	Felt Liner, for No. 54282 A	1
40	22569 B	Screw	5
41	51282 Z	Head Cover Gasket	1
42	35731 A	Presser Bar Connection Guide Plate	2
43	22513	Screw	3
44	51454 A	Needle Bar Connection Guide Block	1
44A	95	Plug Screw	1
45	22849	Screw	2
46	54270	Needle Thread Take-up Wire, for all Styles except 54200 N, P	1
46A	51270 B	Needle Thread Take-up Wire, for Styles 54200 N, P	1
47	95	Screw	1
48	51858	Needle Thread Frame Eyelet, for four needle machines	1
48A	54458 B-9	Needle Thread Frame Eyelet, for nine needle machines	1
	54458 B-12	Needle Thread Frame Eyelet, for twelve needle machines	1
48B	539	Needle Thread Frame Eyelet, for single needle machines	1
49	20	Washer	1
50	22889 A	Adapter Screw	1
51	22848	Screw	1
52	51291 A	Looper Thread Guard, for four needle machines	1
53	54491 A	Looper Thread Guard, for nine and twelve needle machines	1
54	98 A	Screw	1
55	1068	Thread Eyelet, for four needle machines	3
55A	54459 A-9	Thread Eyelet, for nine needle machines	3
	54459 A-12	Thread Eyelet, for twelve needle machines	3
55B	52 A	Thread Eyelet, for single needle machines	3
56	98 A	Screw	3
57	54459 B	Looper Thread Pull-off Eyelet, for nine and twelve needle machines	1
57A	57858	Looper Thread Pull-off Eyelet, for four needle machines	1
58	668-28	Locking Ring	2
59	668-29	Eyelet	2
60	22585 C	Screw	1
61	22891	Screw, for machines without puller	1
62	61394 AF	Gasket, for machines without puller	1
63	258 A	Nut, for machines without puller	1
64	BB21375 AH	Belt Guard	1
65	93	Screw	2
66	22848	Screw, for oil shield	3
67	20	Washer, for No. 22848	3
68	54282	Oil Shield	1



MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

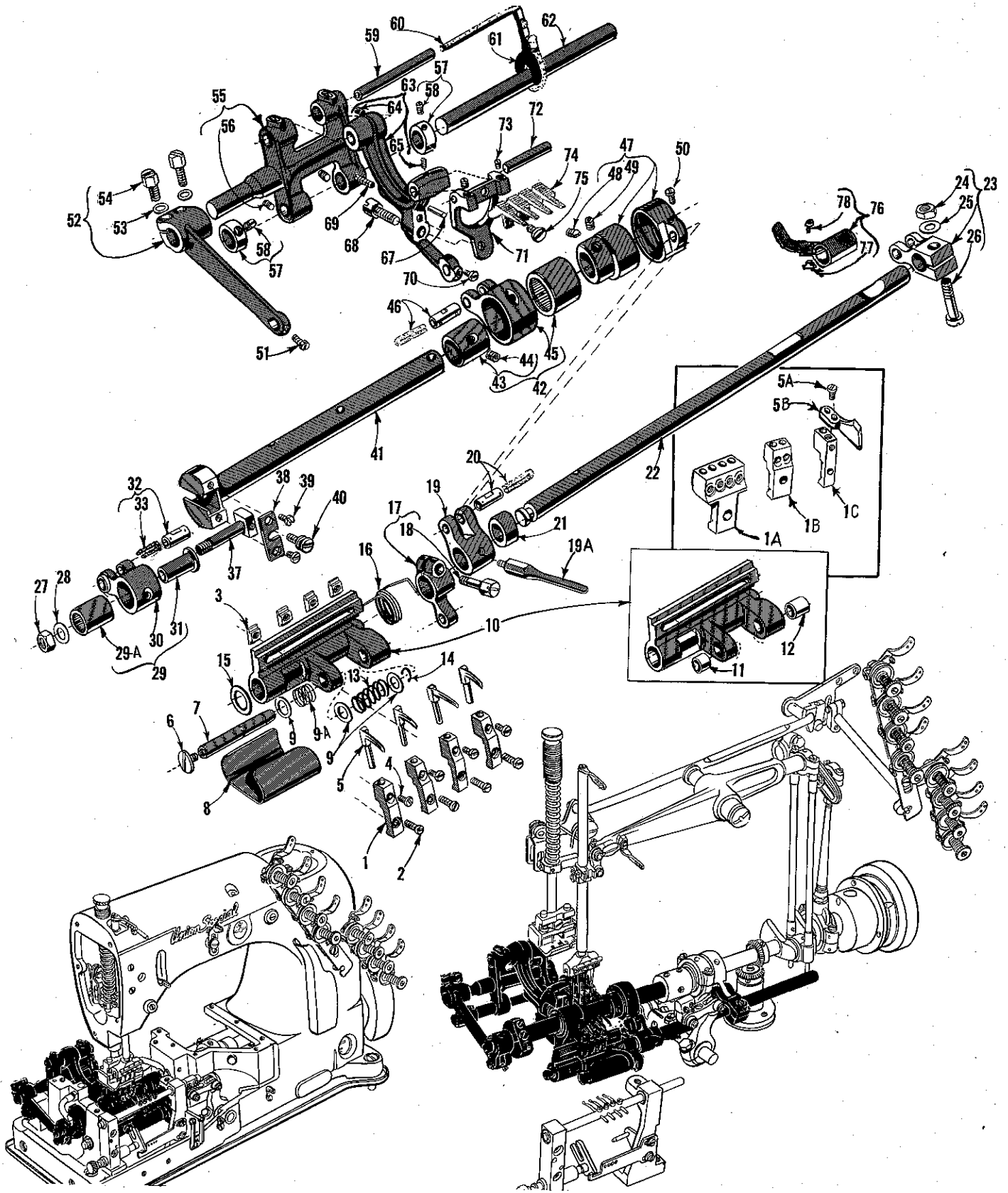
Ref. No.	Part No.	Description	Amt. Req.
1	643-127 Blk.	Gasket -----	1
2	51493 BQ	Oil Pump Driven Gear -----	1
3	531	Screw -----	2
4	51493 AG	Oil Pump Housing -----	1
5	51493 D	Oil Pump Driving Shaft-----	1
6	51493 E	Oil Pump Driving Shaft Gear-----	2
7	51493 AH	Oil Pump Housing Cover -----	1
8	22569 B	Screw -----	3
9	51493 BA	Base Plate-----	1
10	51493 BH	Filter Cap Assembly-----	1
11	51493 BJ	Washer, rubber-----	1
12	22823 A	Screw -----	2
13	22823 B	Screw -----	1
14	51295 A	Mounting Isolator-----	4
15	51290 T	Main Shaft Bushing, middle-----	1
16	52936	Feed Rock Shaft Bushing, left and right, and Looper Rock Shaft Bushing, middle and right-----	4
17	52890 C	Main Shaft Bushing, left and inner right-----	2
18	52891 B	Crankshaft Bushing Housing, including bushing -----	1
19	21657 X	Tension Release Lever Shaft Bushing -----	1
20	52883 R	Foot Lifter Lever Bushing-----	1
21	51854 F	Needle Bar Bushing, upper-----	1
22	51854 E	Needle Bar Bushing, lower-----	1
23	51257 AA	Presser Bar Bushing, lower-----	1
24	54242 C	Retainer Holder Bearing, left-----	1
25	61354 A	Bushing, upper-----	1
26	51254 A	Bushing, lower-----	1
27	667 B-12	Dowel Pin -----	4
28	22652 B-8	Screw -----	4
29	54242 D	Retainer Holder Bearing, right -----	1
30	61354 A	Bushing -----	1
31	667 B-12	Dowel Pin -----	1
32	51242 Z	Looper Drive Lever Shaft Bushing, front-----	1
33	51242 R	Looper Drive Lever Shaft Bushing, middle-----	1
34	51242 S	Looper Drive Lever Shaft Bushing, rear -----	1
35	50-648 Blk.	Lucite Oil Gauge -----	1
36	52944 T	Looper Rocker Shaft Bushing, left, for machines without puller -----	1
	54244 N	Looper Rocker Shaft Bushing, left, for machines with puller -----	1
37	54293	Oil Tube, for feed lift eccentric-----	1
38	54293 A	Oil Tube, for take-up drive eccentric-----	1
39	52894 AB	Oil Tube Holder-----	2
40	90	Screw -----	2
41	660-136	Oil Tube, for feed crank link -----	1
41A	258 A	Nut -----	1
42	666-114	Oil Wick-----	2
43	35178 D	Spring-----	2
44	666-65	Oil Wick-----	2
45	35178 D	Spring-----	2
46	666-118	Oil Wick-----	2
47	666-111	Oil Wick-----	2
48	666-179	Wedge Pin -----	2
49	22571 A	Plug Screw -----	15
50	22539 H	Plug Screw -----	1
51	22889 D	Adaptor Plug Screw, left end -----	1
52	22889 C	Adaptor Plug Screw, back -----	2
53	51493 BK	Lint Filter Screen-----	1
54	7947	Nut -----	1
55	51294 P	Oil Tube Clamp -----	1
56	51294 R	Screw -----	1
57	51294 M	Oil Siphon Tube -----	1
58	666-214	Felt Lint Filter -----	1
59	51294 Z	Oil Tube Connection -----	1
60	21212	Oil Siphon Connection Locking Ring-----	1
61	22729 A	Screw -----	1
62	51294 U	Oil Siphon Assembly-----	1
63	51294 K	Upper Clamp-----	1
64	22729 B	Screw -----	1
65	666-209	Felt Disc -----	1
66	666-201	Felt Plug -----	1
67	51493 BG	Base Plate Felt -----	1



CRANKSHAFT, NEEDLE LEVER AND LOOPER DRIVING PARTS

Ref. No.	Part No.	Description	Amt. Req.
1		Needle Holder (See page 31) -----	1
1A	56	Nut, for No. 54617 needle bar, on single needle machines -----	1
2	51817 A	Needle Bar, for four needle machines -----	1
	54417	Needle Bar, for nine and twelve needle machines -----	1
2A	54617	Needle Bar, for single needle machines -----	1
3	27-484 Blk.	Needle Bar Eyelet Washer -----	1
4	22768	Screw -----	1
5	54158 A	Needle Bar Thread Eyelet, for four needle machines -----	1
6	54458 A-9	Needle Bar Thread Eyelet, for nine needle machines -----	1
7	54458 A-12	Needle Bar Thread Eyelet, for twelve needle machines -----	1
7A	56358	Needle Bar Thread Eyelet, for single needle machines -----	1
8	29348 S	Needle Lever Assembly -----	1
9	51454 B	Needle Bar Connection -----	1
10	22516 B	Screw -----	1
11	75 C	Screw -----	1
12	77	Screw -----	1
13	56354 A	Needle Lever Link -----	1
14	51054	Link Pin -----	2
15	666-149	Lubricating Felt -----	1
16	77	Screw -----	1
17	56315	Needle Lever -----	1
18	56350 B	Bushing -----	1
19	56350 A	Needle Lever Stud -----	1
20	22586 R	Screw -----	1
21	51250 F	Gasket -----	1
22	51250 D	Washer -----	1
23	660-212	Oil Seal Ring -----	2
24	51150	Needle Lever Thrust Collar -----	1
25	719	Screw -----	2
26	29066 R	Needle Lever Ball Joint -----	1
27	22559 G	Screw -----	2
28	51216 N	Washer -----	1
29	51216 P	Nut -----	1
30	51216 G	Needle Lever Connecting Rod -----	2
31	22768	Screw -----	1
32	54158	Needle Lever Thread Eyelet, for four needle machines -----	1
33	54458-9	Needle Lever Thread Eyelet, for nine needle machines -----	1
34	54458-12	Needle Lever Thread Eyelet, for twelve needle machines -----	1
34A	56358 A	Needle Lever Thread Eyelet, for single needle machines -----	1
35	51242 P	Looper Drive Lever Shaft -----	1
36	51242 L	Thrust Washer -----	2
37	52841 G	Locking Stud -----	1
38	51242 M	Washer -----	2
39	52841 J	Nut -----	1
40	51242 Y	Looper Drive Lever Rocker -----	1
41	22883 A	Plug Screw, for looper drive lever shaft hole -----	1
42	81	Screw -----	1
43	22852 A	Screw -----	1
44	12982	Nut -----	1
45	29105 AD	Retainer Drive Eccentric Assembly -----	1
46	22559 B	Bearing Screw, upper -----	2
47	22894 C	Set Screw -----	4
48	22894 D	Spot Screw -----	1
49	22559 A	Bearing Screw, lower -----	2
50	51243 C	Ball Stud Fork -----	1
51	22729	Screw -----	1
52	29133 K	Looper Drive Eccentric Assembly -----	1
53	22894 C	Set Screw -----	2
54	22768	Screw -----	1
55	51236 A	Link Pin -----	1
56	51493 BP	Oil Pump Driving Gear -----	1
57	22560 B	Screw -----	2
58	29476 GZ	Crankshaft Assembly, for styles in Class 54200, .990 inch throw -----	1
	29476 HA	Crankshaft Assembly, for styles in Class 54400, .770 inch throw -----	1
	51216 M	Needle Bearing -----	28
59	51247	Counterweight, for machines without close coupled puller -----	1
60	22894 J	Screw -----	2
61	9660 B	Thrust Collar -----	1
62	98	Screw -----	2
63	56390 E	Bearing Housing Gasket -----	1
64	22569 B	Screw -----	3
65	51221 C	Pulley, for No. 1 "V" and round belt on machines without close coupled puller -----	1
66	52921 B	Pulley, for No. 1 "V" and round belt on machines with close coupled puller -----	1
	51321 G	Pulley, for No. 2 "V" belt on machines with close coupled puller -----	1
	22894 F	Screw, used with No. 51221 C -----	2
	22894 G	Screw, used with No. 52921 B -----	1
	22894 E	Screw, used with Nos. 51321 G, 52921 B -----	1
67A	22894 H	Screw, used with No. 51321 G -----	1
*68	666-170	Oil Wick, for needle lever stud -----	1
69	660-202	Oil Seal Ring -----	1

* For use with needle lever stud No. 51250 E in old machines.



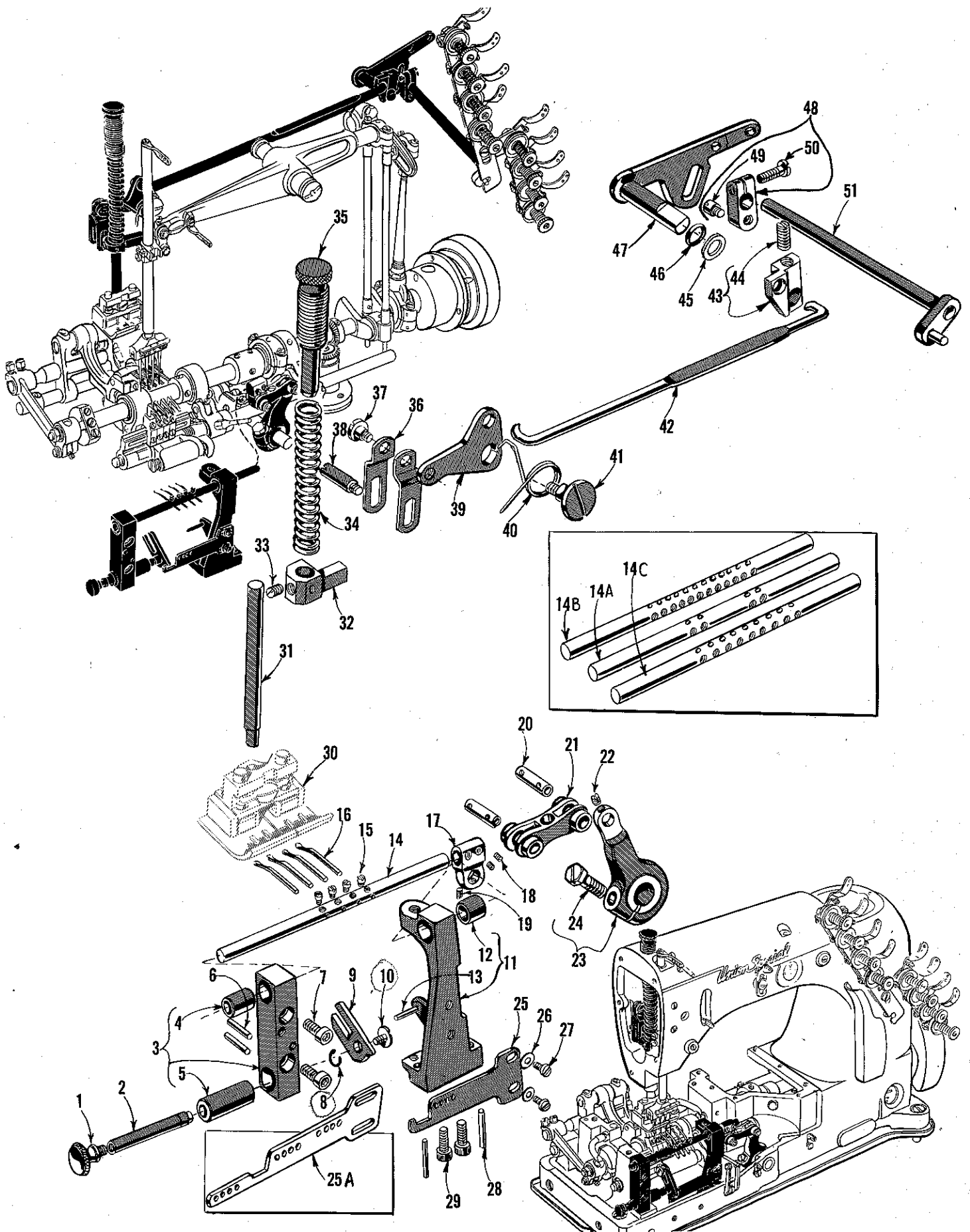
MAIN SHAFT, FEED DRIVING AND LOOPER DRIVING PARTS

Ref. No.	Part No.	Description	AMOUNT REQUIRED			
			1 Needle Machine	4 Needle Machine	9 Needle Machine	12 Needle Machine
1	54485 A	Looper Holder, marked "S", for all Class 54400 machines except Styles 54400 H and J		4		
1A	54285 A-4-16	Looper Holder, marked "H-4-16", for Styles 54400 H-9-16, J-9-16			2	
1B	54485 B	Looper Holder, marked "T" for Style 54200 K-4-12-56-12		2		
1C	54285 B	Looper Holder, marked "M" for Styles 54400 H-9-16, J-9-16 and all Class 54200 except Style 54200 K-4-12-56-12	1	4	1	
	54485	Looper Holder, marked "Q", for Styles 54400 H-12-12, J-12-12				3
2	97 A	Screw, for looper holder	1	4	3	3
3	54285 C	Nut, for No. 97 A screw	1	4	3	3
4	J87 J	Screw, for looper, for Styles 54400 H-9-16, J-9-16 and all Class 54200 except Style 54200 K-4-12-56-12	1	4	8	
	77	Screw, for looper, for Style 54200 K-4-12-56-12 and all Class 54400				12
5	54208 A	Looper, marked "CB"	1	4	9	12
	54208	Looper, marked "BZ"				
5A	22768	Screw, for needle guard	1	4		
5B	54225	Needle Guard, for all Styles in Class 54200 except 54200 K-4-12-56-12	1	4		

Ref. No.	Part No.	Description	Amt. Req.
6	22542-A	Screw -----	1
7	59444 J	Looper Holder Frame Locking Pin -----	1
8	54244 M	Looper Holder Frame Thread Shield -----	1
9	6042 A	Washer -----	3 2
9A	54244 H	Throw-out Fork Pressure Spring -----	1
10	54244 P	Looper Holder Frame -----	1
11	54244 E	Bushing, left -----	1
12	54244 F	Bushing, right -----	1
13	39173 A	Looper Frame Locking Pin Spring -----	1
14	660-215	Retaining Ring -----	1
15	51242 L	Thrust Washer -----	2
16	54244 C	Looper Holder Frame Throw-out Spring -----	1
17	54244 B	Looper Thread Take-up Driving Arm -----	1
18	22519 C	Screw -----	1
19	54245 A	Looper Thread Take-up Driving Link -----	1
19A	54223 A	Looper Thread Take-up -----	1
20	51236 A	Link Pin -----	1
21	54244 K	Spacing Collar -----	1
22	51244 K	Looper Rocker Shaft -----	1
23 thru 78		See Following Page	

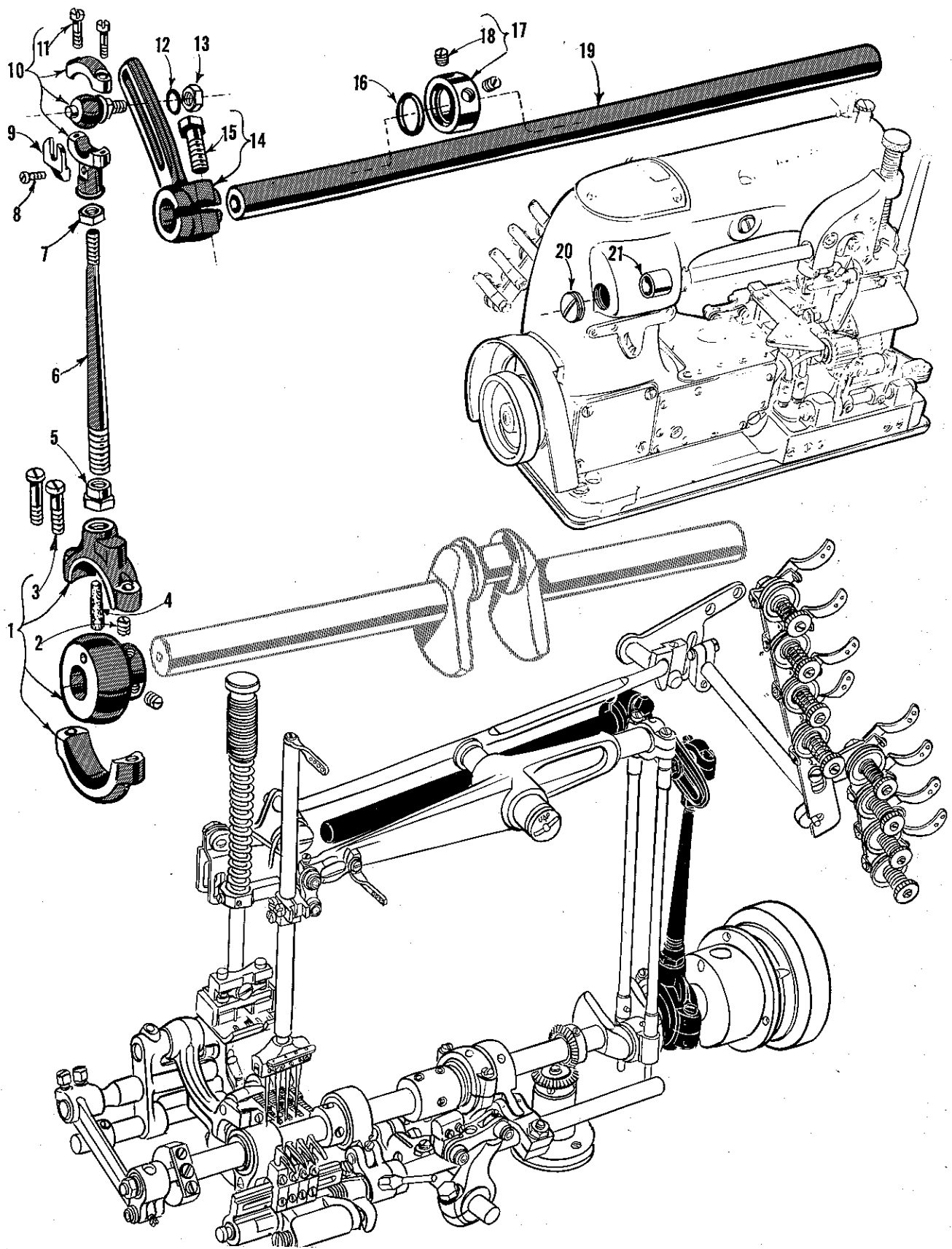
MAIN SHAFT, FEED DRIVING AND LOOPER DRIVING PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1 thru 22		See Preceding Page	
23	54244 A	Looper Travel Drive Link -----	1
24	18	Nut, for locking stud -----	1
25	20	Washer -----	1
26	55244 G	Locking Stud -----	1
27	269	Nut, left thread -----	1
28	20	Feed Crank Stud Washer -----	1
29	51236 E	Feed Crank Link Assembly, for all machines except 54200 G, 54400 G -----	1
29A	660-169	Needle Bearing -----	1
30	51236 D	Feed Crank Link -----	1
31	51236 F	Feed Crank Link Ferrule -----	1
32	51054	Feed Crank Link Pin -----	1
33	666-149	Oil Wick -----	1
37	51236 G	Feed Crank Stud -----	1
38	51236 B	Feed Crank Stud Cap -----	1
39	22768	Screw -----	2
40	82	Stitch Regulating Stud -----	1
41	54222	Main Shaft -----	1
42	29476 KR	Feed Lift Eccentric Assembly -----	1
43	51406	Eccentric, .062 inch throw -----	1
44	22894 D	Screw -----	1
45	54245 C	Eccentric Bearing -----	1
46	51236 A	Link Pin -----	1
47	29133 J	Take-up Drive Eccentric Assembly -----	1
48	22894 L	Eccentric Spot Screw -----	1
49	22894 C	Eccentric Set Screw -----	1
50	22768	Screw -----	1
51	77	Screw -----	1
52	51235 A	Feed Rocker Arm -----	1
53	51235 G	Washer -----	2
54	22519 C	Screw -----	2
55	51235	Feed Rocker -----	1
56	98	Screw -----	2
57	482	Feed Rocker Shaft Collar -----	2
58	98	Screw -----	1
59	51134 C	Feed Bar Shaft -----	1
60	51134 P	Lubricating Felt -----	1
61	51134 R	Lubricating Felt Guard -----	1
62	8	Feed Rocker Shaft -----	1
63	54234 B	Feed Bar -----	1
64	22560 B	Screw -----	1
65	22733	Screw -----	1
67	667 B-20	Dowel Pin, for feed bar -----	1
68	88 F	Screw, for feed bar -----	1
69	531	Screw -----	1
70	77	Screw -----	1
71	54234 C	Feed Bar Tilting Extension -----	1
72	54134 N	Pin -----	1
73	22560 B	Screw -----	2
74		Feed Dog (See pages 31, 33) -----	1
75	HA 61 D	Screw -----	1
76	54243 A	Looper Drive Eccentric Oil Slinger -----	1
77	54135	Nut -----	1
78	J 87 J	Screw -----	1



FOOT LIFTER AND RETAINER DRIVING PARTS

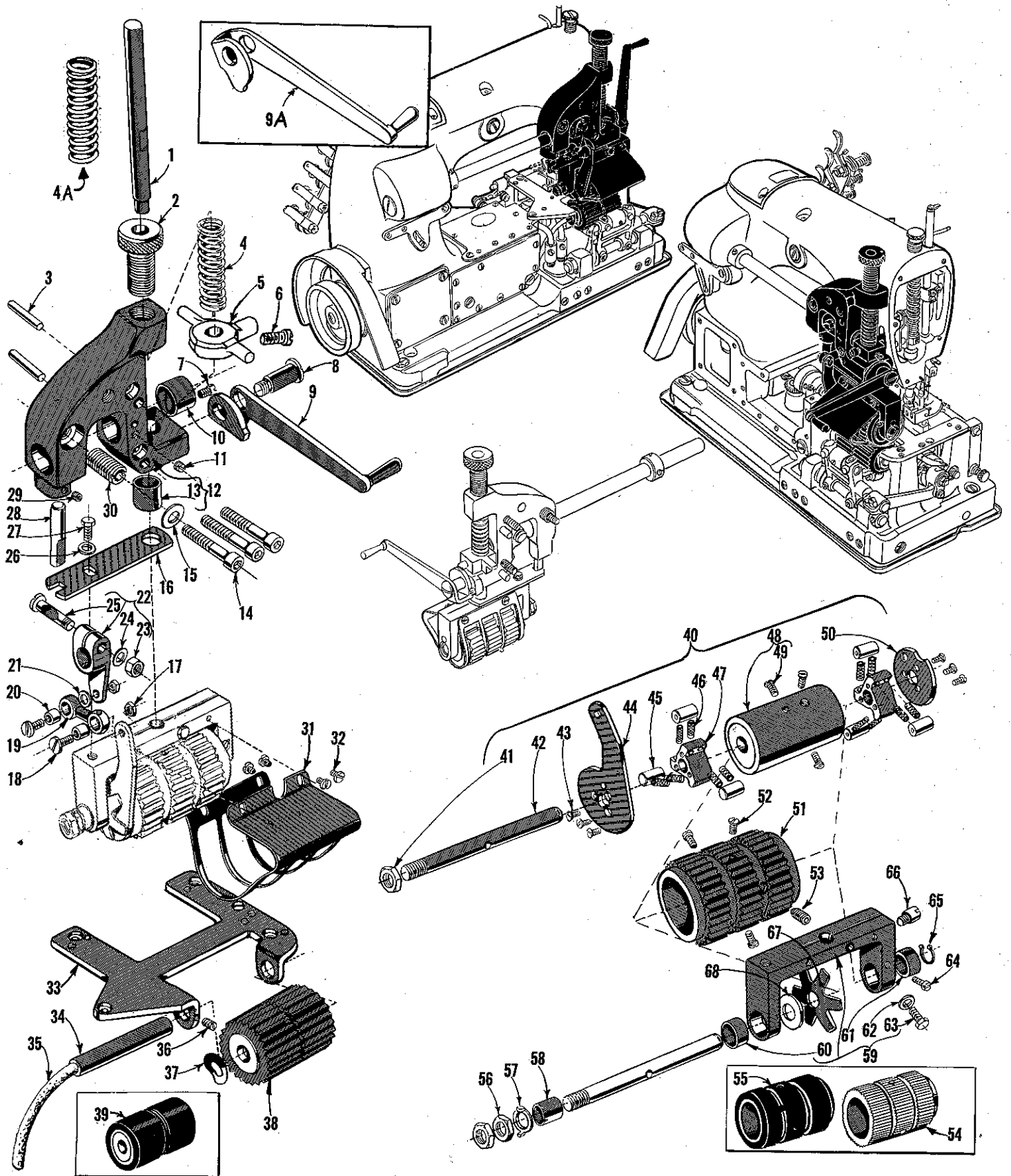
<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	15489 B	Screw	1
2	54244 J	Looper Throw-out Actuating Pin	1
3	54242 C	Retainer Holder Bearing, left	1
4	61354 A	Bushing, upper	1
5	51254 A	Bushing, lower	1
6	667 B-12	Dowel Pin	2
7	22652 B-8	Screw	2
8	660-215	Retaining Ring	1
9	54244 G	Looper Throw-out Fork	1
10	22542 A	Screw	1
11	54242 D	Retainer Holder Bearing, right	1
12	61354 A	Bushing	1
13	667 B-12	Dowel Pin	1
14	54242 B-4-16	Retainer Holder, for four needle, 16 gauge	1
	54242 B-4-21	Retainer Holder, for four needle, 21 gauge	1
	54242 B-4-24	Retainer Holder, for four needle, 24 gauge	1
	54242 B-4-32	Retainer Holder, for four needle, 32 gauge	1
14A	K67664	Retainer Holder, for four needle, 12-56-12 gauge	1
	54242 B-16-64-16	Retainer Holder, for four needle, 16-64-16 gauge	1
14B	54242 B-12-12	Retainer Holder, for twelve needle, 12 gauge	1
14C	54242 B-9-16	Retainer Holder, for nine needle, 16 gauge	1
15	22845 B	Screw, for single needle machines	1
		Screw, for four needle machines	4
		Screw, for nine needle machines	9
		Screw, for twelve needle machines	12
16	54211 A	Retainer, marked "BW", for four needle machines	4
		Retainer, for nine needle machines	9
		Retainer, for twelve needle machines	12
		Retainer, for single needle machines	1
17	9650 A	Connection AS PER CR# 50834	1
18	88	Screw	2
19	78	Screw	1
20	51134 Y	Link Pin AS PER CR# 50834	2
21	HA54 A	Retainer Drive Lever Link	1
22	22564	Screw	1
23	54242 E H	Retainer Drive Lever AS PER CR# 50834	1
24	22811 B	Screw	1
25	54259	Thread Eyelet, for four needle machines	1
25A	54459-12	Thread Eyelet, for nine and twelve needle machines	1
26	41358	Washer	2
27	J87 J	Screw	2
28	667 B-12	Dowel Pin	2
29	22652 B-8	Screw	2
30		Presser Foot (See pages 31, 33)	1
31	51257 K	Presser Bar	1
32	51257 M	Presser Bar Connection and Guide	1
33	531	Screw	2
34	53787	Presser Spring	1
35	56356	Presser Spring Regulator	1
36	53783 S	Lifter Lever Link, for machines with close coupled puller	2
	53783 A	Lifter Lever Link, for machines without close coupled puller	1
37	240	Screw, for No. 53783 S	1
	22758 C	Screw, for No. 53783 A	1
38	22799 T	Screw, for No. 53783 S	1
	402	Screw, for No. 53783 A	1
39	53783 L	Lifter Lever Bell Crank	1
40	52883 S	Lifter Lever Bell Crank Spring	1
41	22557 B	Screw	1
42	53783 M	Lifter Lever Connecting Rod	1
43	53783 N	Foot Lifter Lever, internal	1
44	22537	Screw	1
45	39552 C	Washer, for No. 53783 N	1
46	660-207	Oil Seal Ring	1
47	51283 H	Foot Lifter and Tension Disc Release Lever	1
48	21657 Y	Tension Release and Foot Lifter Lever Connection	1
49	402	Screw	1
50	22596	Screw	1
51	21657 W	Tension Release and Foot Lifter Lever Shaft	1



PULLER DRIVING PARTS

NOTE: The following parts are used for Styles 54200 E, F, G, K, N, P, 54400 E, F, G, J only.

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	29126 DE	Puller Drive Eccentric Assembly -----	1
2	95	Screw -----	2
3	22587	Bearing Cap Screw -----	2
4	666-53	Lubricating Felt-----	1
5	15430 D	Nut, right thread-----	1
6	53716	Connecting Rod-----	1
7	269	Nut, left thread -----	1
8	22747	Screw -----	1
9	41255 B	Ball Stud Guide Fork-----	1
10	52854	Puller Driving Connecting Rod Ball Joint-----	1
11	97 A	Bearing Cap Screw -----	2
12	454 A	Washer-----	1
13	258	Nut -----	1
14	53752	Puller Driving Shaft Segment Lever -----	1
15	22811	Screw -----	1
16	660-202	Oil Seal Ring-----	1
17	52849 C	Thrust Collar -----	1
18	95	Screw -----	2
19	54249	Puller Driving Shaft -----	1
20	22539 D	Plug Screw -----	1
21	53790 A	Puller Driving Shaft Bushing-----	1

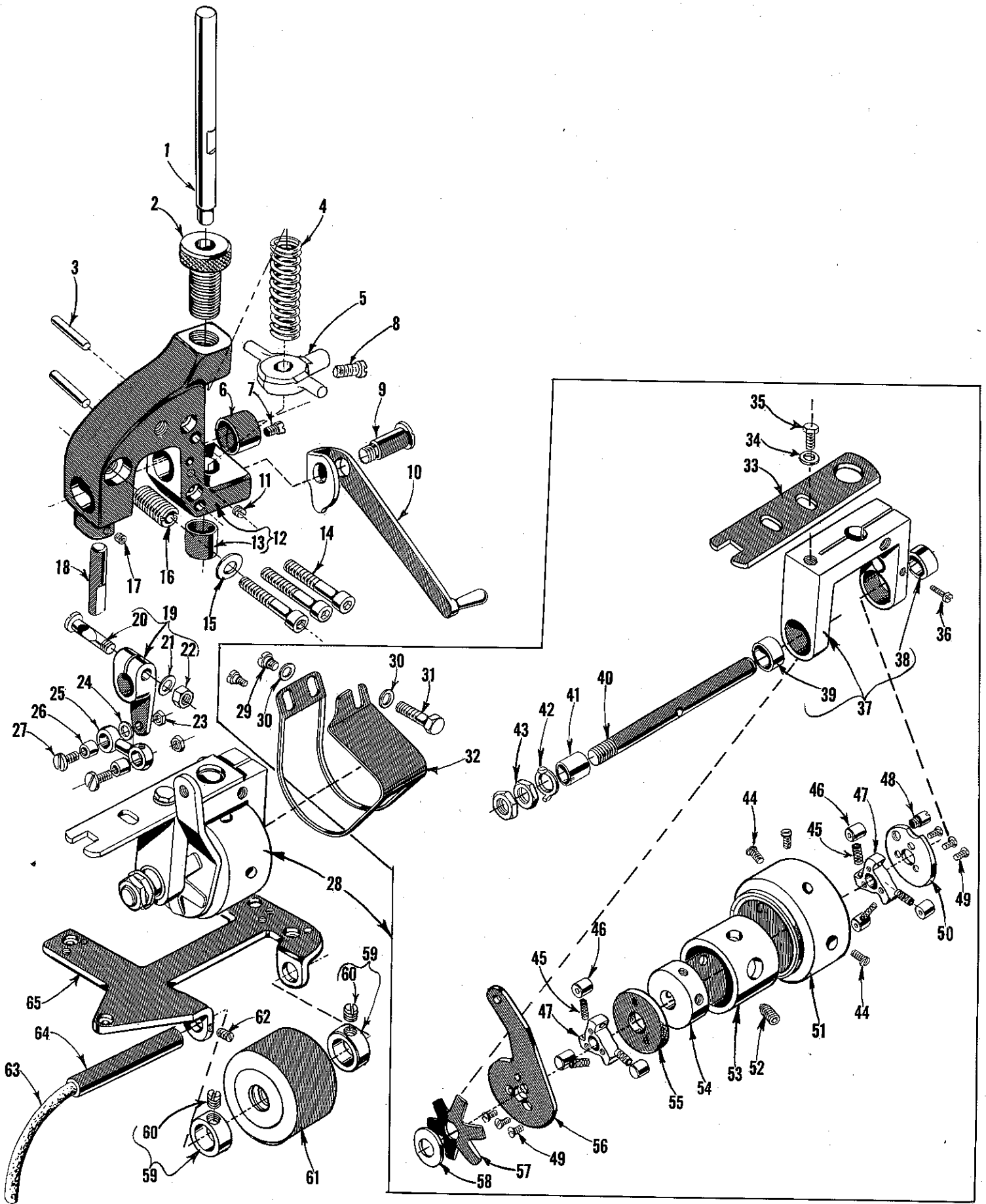


FEED ROLLER AND PULLER CLUTCH PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
NOTE: The following parts are used for Styles 54200 E, F, G, K, N, P, 54400 E, F, G, J only.			
1	54277 J	Feed Roller Presser Bar -----	1
2	54277 C	Feed Roller Presser Spring Regulator -----	1
3	667 D-24	Dowel Pin -----	2
4	54277 B	Feed Roller Presser Spring, for Styles 54200 E, F, G, K, 54400 E, F, G, J -----	1
4A	28633 L	Feed Roller Presser Spring, for Styles 54200 N, P -----	1
5	54277 M	Feed Roller Presser Bar Collar -----	1
6	22517	Screw -----	1
7	33174 B	Stop Screw -----	1
8	22854 D	Screw -----	1
9	54277 K	Feed Roller Lifter Lever, for Styles 54200 E, F, G, K, 54400 E, F, G, J -----	1
9A	54277 L	Feed Roller Lifter Lever, for Styles 54200 N, P -----	1
10	54249 B	Clutch Driving Shaft Bushing, left -----	1
11	89	Screw -----	1
12	54277 HA	Feed Roller Mounting Bracket -----	1
13	43245 N	Bushing -----	1
14	22653 D-24	Screw -----	3
15	43137 E	Washer -----	1
16	54278 T	Feed Roller Yoke Guide -----	1
17	12934 A	Nut -----	2
18	22757	Screw -----	2
19	51770-56	Connection Link -----	1
20	51771	Ferrule -----	2
21	54249 D	Washer -----	1
22	54249 C	Clutch Driving Lever -----	1
23	55235 E	Nut -----	1
24	6042 A	Washer -----	1
25	55235 D	Locking Stud -----	1
26	8372 A	Washer -----	1
27	22792 A	Screw -----	1
28	54278 B	Guide Stud -----	1
29	89	Screw -----	1
30	22899	Screw -----	1
31	54278 X	Feed Roller Guard -----	1
32	22704	Screw -----	4
33	54280 A	Throat Plate and Lower Feed Roller Support -----	1
34	54276 L	Lower Feed Roller Shaft -----	1
35	666-153	Oil Wick -----	1
36	22733	Screw -----	1
37	660-223	Spring Washer -----	1
38	54276	Lower Feed Roller, bakelite, on all machines except Style 54200 K -----	1
39	54276 A	Lower Feed Roller, rubber, for Style 54200 K -----	1
40	29476 GG	Feed Roller Clutch Assembly -----	1
41	11638 M	Nut -----	1
42	54274 G	Clutch Shaft -----	1
43	605 A	Screw -----	6
44	54274 K	Clutch Driving Lever -----	1
45	54274 L	Roller -----	6
46	29480 KP	Clutch Spring and Wear Cap Assembly -----	12
47	54274 H	Clutch Disc -----	2
48	54274 F	Clutch Barrel -----	1
49	538	Screw -----	3
50	54274 J	Clutch Plate -----	1
51	54275 D	Upper Feed Roller, bakelite, on all machines except Style 54200 K -----	1
52	538	Screw -----	3
53	22894 H	Screw -----	1
54	54275 C	Upper Feed Roller, steel, for Style 54200 K -----	1
*55	54275 E	Upper Feed Roller, rubber -----	1
56	11638 M	Nut -----	1
57	54278 Y	Driving Washer -----	1
58	54278 W	Feed Roller Yoke Bearing Sleeve -----	1
59	54278 S	Upper Feed Roller Yoke -----	1
60	54278 U	Bushing, right -----	1
61	54278 V	Bushing, left -----	1
62	51235 G	Washer -----	1
63	T38	Screw -----	1
64	77 B	Screw -----	1
65	660-208	Locking Ring -----	1
66	22892 D	Screw -----	1
67	54274 N	Clutch Tension Spring -----	1
68	54274 P	Thrust Washer -----	1

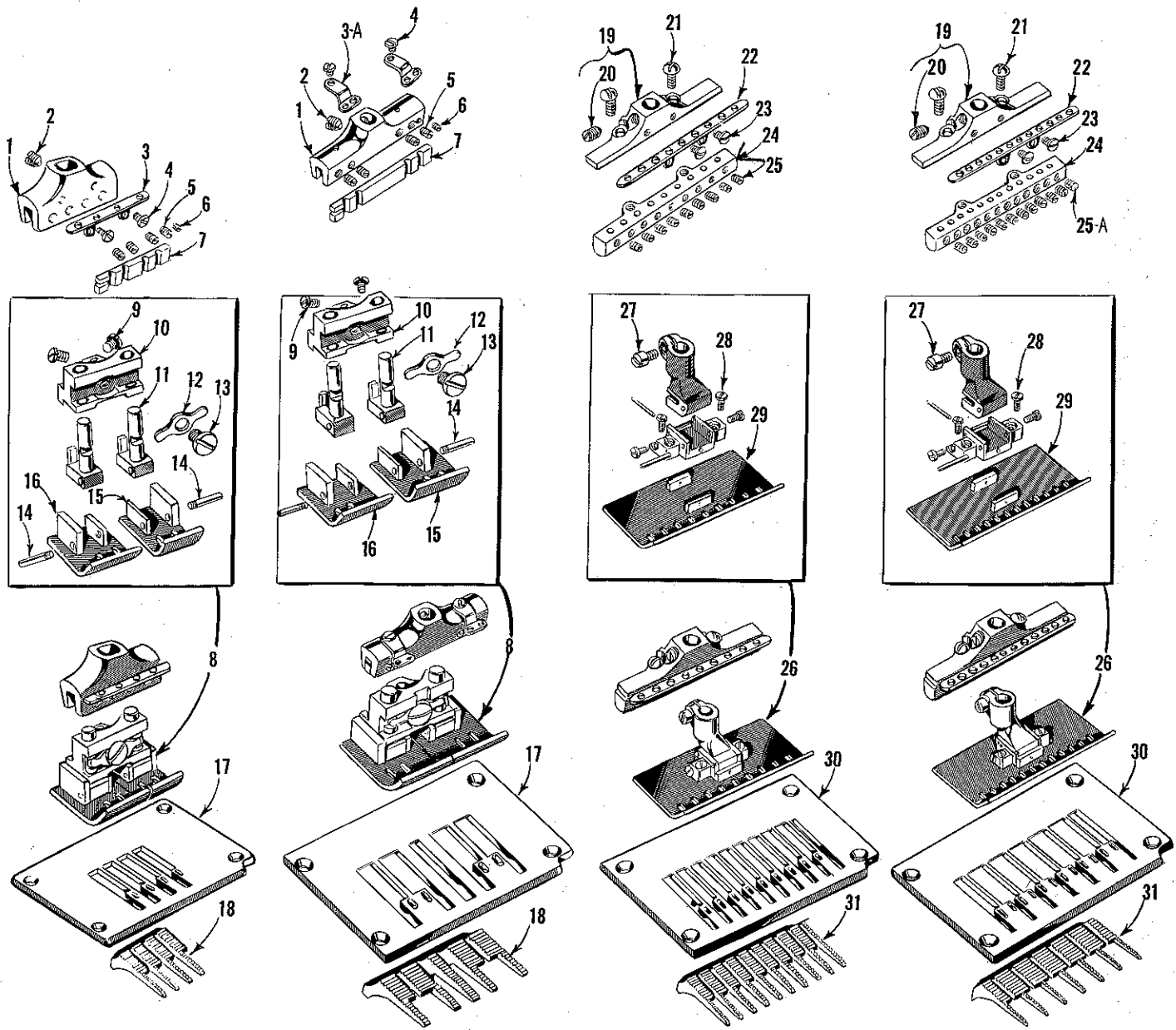
* Available as extra send and charge item.

NOTE: No. 54274 R - Brake Washer Spacer is required for rubber or steel rollers.



FEED ROLLERS AND PULLER CLUTCH PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	54277 J	Feed Roller Presser Bar -----	1
2	54277 C	Presser Spring Regulating Screw -----	1
3	667 D-24	Dowel Pin -----	2
4	28633 L	Feed Roller Presser Spring -----	1
5	54277 M	Presser Bar Collar -----	1
6	54249 B	Clutch Driving Shaft Bushing, left -----	1
7	33174 B	Stop Screw, for feed roller lifter lever -----	1
8	22517	Screw, for presser bar collar -----	1
9	22854 D	Screw, for lifter lever -----	1
10	54277 L	Feed Roller Lifter Lever -----	1
11	89	Screw, for left clutch driving shaft bushing -----	1
12	54277 HA	Feed Roller Mounting Bracket -----	1
13	43245 N	Bushing, for feed roller presser bar -----	1
14	22653 CD-24	Screw, for feed roller mounting bracket -----	3
15	43137 E	Washer -----	1
16	22899	Screw, for feed roller mounting bracket -----	1
17	89	Screw, for guide stud -----	1
18	54278 B	Guide Stud -----	1
19	54249 C	Clutch Driving Lever -----	1
20	55235 D	Screw -----	1
21	6042 A	Washer -----	1
22	55235 E	Nut -----	1
23	12934 A	Nut, for No. 22757 -----	2
24	54249 D	Washer, for clutch drive lever -----	1
25	51770-56	Connecting Link -----	1
26	51771	Ferrule, for connecting link -----	2
27	22757	Screw, for connecting link -----	2
28	29476 MC	Feed Roller and Clutch Assembly -----	1
29	88 A	Screw, for feed roller guard -----	2
30	51235 G	Washer -----	2
31	T38	Screw, for feed roller guard -----	1
32	54278 AD	Feed Roller Guard -----	1
33	54278 T	Feed Roller Yoke Guide -----	1
34	51235 G	Washer -----	1
35	22792 A	Screw -----	1
36	77 B	Screw -----	1
37	54278 AC	Feed Roller Yoke -----	1
38	54278 V	Bushing, left -----	1
39	54278 U	Bushing, right -----	1
40	54274 U	Clutch Shaft -----	1
41	54278 W	Feed Roller Yoke Bearing Sleeve -----	1
42	54278 Y	Driving Washer -----	1
43	11638 M	Nut, for clutch shaft -----	2
44	538	Screw, for feed roller -----	3
45	29480 KP	Clutch Spring and Wear Cap Assembly -----	6
46	54274 W	Clutch Roller -----	6
47	54274 T	Clutch Disc -----	2
48	22892 C	Stop Screw, for support plate -----	1
49	605	Screw, for clutch driving lever and support plate -----	6
50	54274 J	Support Plate -----	1
51	54275 M	Upper Feed Roller -----	1
52	22894 H	Spot Screw, for upper feed roller -----	1
53	51-297 Blk.	Clutch Barrel -----	1
54	51-298 Blk.	Clutch Barrel Core -----	1
55	54274 X	Clutch Brake Disc -----	1
56	54274 V	Clutch Lever -----	1
57	54274 N	Tension Spring -----	1
58	61351 C	Washer -----	1
59	482	Collar, for lower puller roller shaft -----	2
60	98	Screw -----	1
61	54276 X	Puller Roller, lower -----	1
62	22733	Screw, for puller roller shaft, lower -----	1
63	666-153	Oil Wick -----	1
64	54276 L	Puller Roller Shaft, lower -----	1
65	54280 A	Throat Plate Support -----	1



SEWING PART COMBINATIONS
FOR STYLES
54200 A, C, E, F, G, K, 54400 A, C, E, F, G

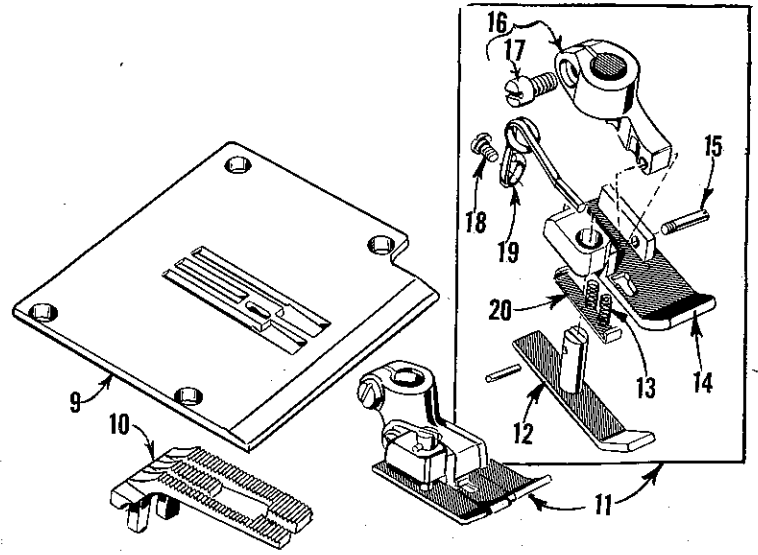
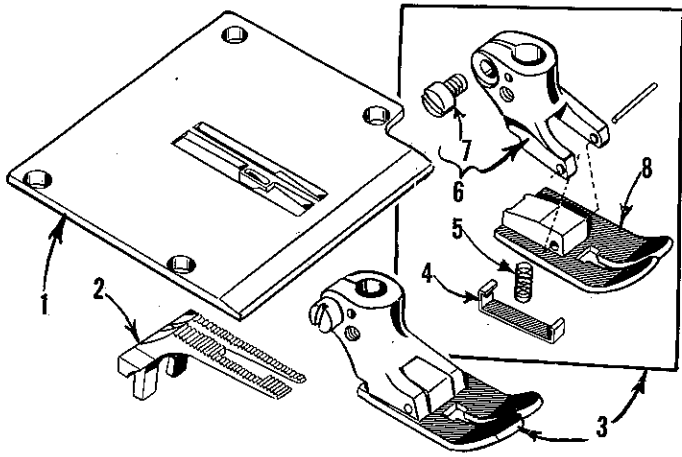
FOUR NEEDLE UNEQUAL SPACE

Ref. No.	Description	Amt.	FOUR NEEDLE EQUAL SPACE				FOUR NEEDLE UNEQUAL SPACE	
			16 Gauge	21 Gauge	24 Gauge	32 Gauge	12-56-12 Gauge	16-64-16 Gauge
1	Needle Holder	1	54218-4-16	54218-4-21	54218-4-24	54218-4-32	16154-12-56-12	16154-16-64-16
2	Screw	1	22894 P	22894 P	22894 P	22894 P	22894 P	22894 P
3	Needle Holder Eyelet	1	16197-4-16	16197-4-20	16197-4-24	54458 D-4-32		
3A	Needle Holder Eyelet	2					16197-2-16	
4	Screw	2	73 A	73 A	73 A	73 A	73 A	73 A
5	Screw	4	28 C	28 C	28 C	28 C	28 C	28 C
6	Screw	1	1096 B	1096 B	1096 B	1096 B	1096 B	1096 B
7	Needle Seat Block	1	54218 A-4-16	54218 A-4-21	54218 A-4-24	54218 A-4-32	16184 A-12-56-12	16184 A-16-64-16
8	Presser Foot	1	54220 A-4-16	54220 A-4-21	54220 A-4-24	54220 A-4-32	K67661	54220 A-16-64-16
9	Screw	2	22570 A	22570 A	22570 A	22570 A	22570 A	22570 A
10	Shank	1	51830	51830	51830	51830	22584	51830
11	Plunger	2	51830 C	51830 C	51830 C	51830 C	51830 C	51830 C
12	Equalizer	1	51830 D	51830 D	51830 D	51830 D	51830 D	51830 D
13	Screw	1	22758	22758	22758	22758	22758	22758
14	Screw	2	22799 S	22799 S	22799 S	22799 S	22799 S	22799 S
15	Bottom, right	1	54230-16	54230-21	54230-24	54230-32	K67660	54230-16-64-16
16	Bottom, left	1	54230 A-16	54230 A-21	54230 A-24	54230 A-32	K67659	54230 A-16-64-16
17	Throat Plate	1	54224 A-4-16	54224 A-4-21	54224 A-4-24	54224 A-4-32	K67663	54224 A-16-64-16
18	Feed Dog	1	54205 A-4-16	54226 A-4-21	54205 A-4-24	54205 A-4-32	K67662	54205 A-16-64-16

SEWING PART COMBINATIONS
FOR STYLES
54400 H, J

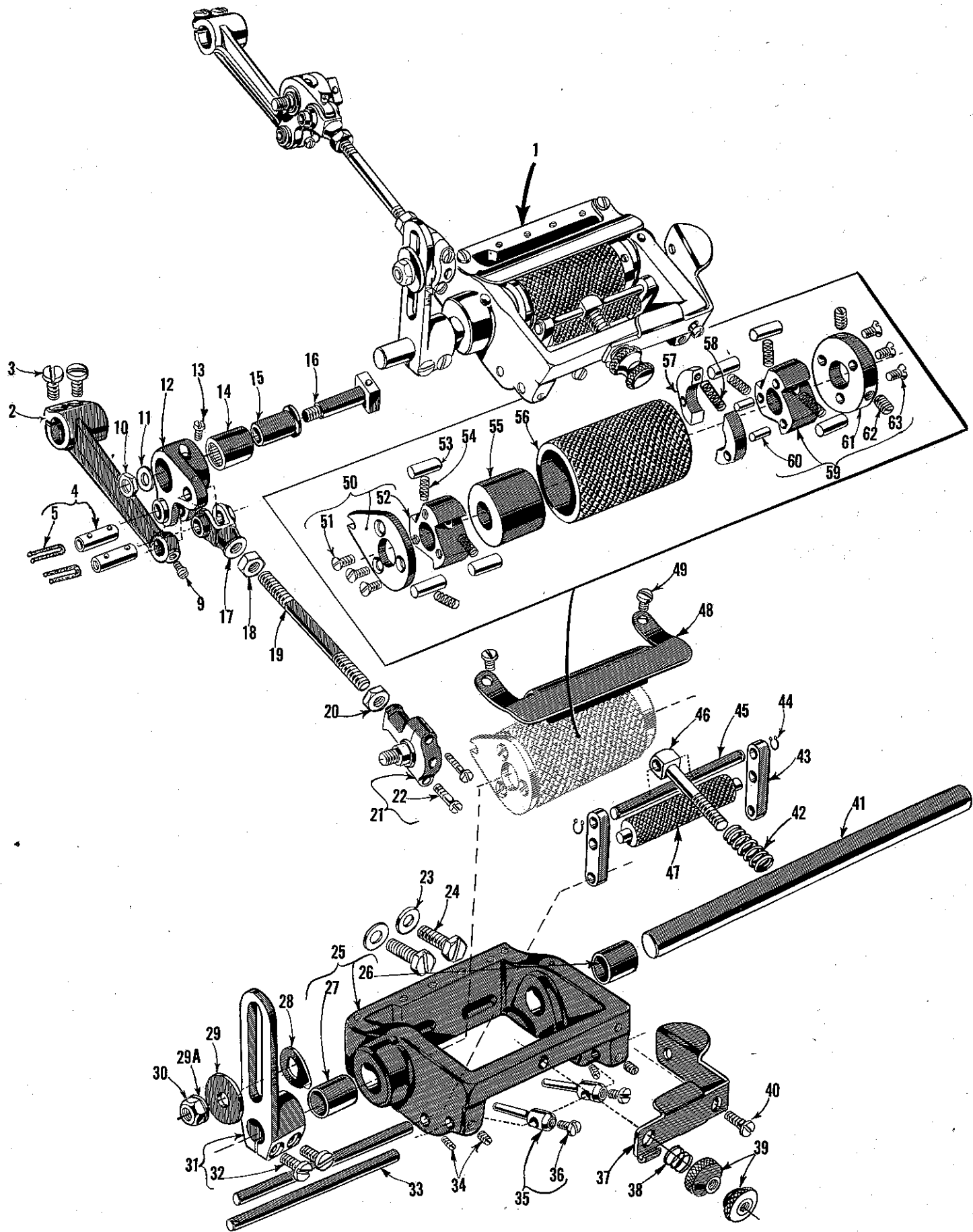
TWELVE NEEDLE EQUAL SPACE

Ref. No.	Description	Amt.	NINE NEEDLE EQUAL SPACE		TWELVE NEEDLE EQUAL SPACE	
			16 Gauge	12 Gauge		
19	Needle Stop Plate	1	54418 A	54418 A	54418 A	54418 A
20	Screw	1	22764 A	22764 A	22764 A	22764 A
21	Screw	2	22849	22849	22849	22849
22	Needle Holder Eyelet	1	54458 C-9	54458 C-9	54458 C-12	54458 C-12
23	Screw	2	73 A	73 A	73 A	73 A
24	Needle Holder	1	59218-9-16	59218-9-16	54418-12-12	54418-12-12
25	Screw	9	28 C	28 C	28 C	28 C
25A	Screw	12	54420-9-16	54420-9-16	54420-12-12	54420-12-12
26	Presser Foot	1	91	91	91	91
27	Screw	1	605 A	605 A	605 A	605 A
28	Screw	4	54430-9-16	54430-9-16	54430-9-16	54430-9-16
29	Bottom	1	54224 A-9-16	54224 A-9-16	54224 A-9-16	54224 A-9-16
30	Throat Plate	1	54205 A-9-16	54205 A-9-16	54205 A-9-16	54205 A-9-16
31	Feed Dog	1				



SEWING PARTS COMBINATIONS
FOR STYLES 54200 N, P

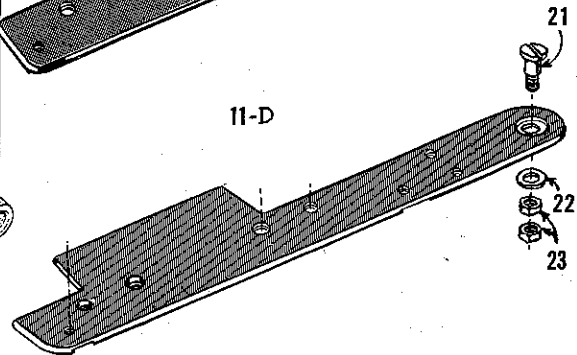
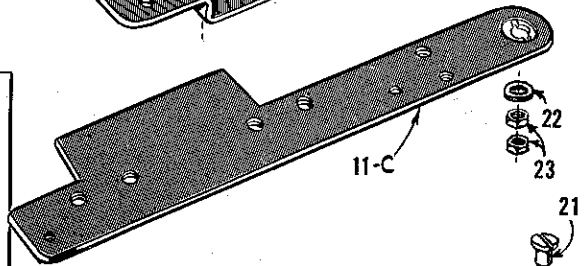
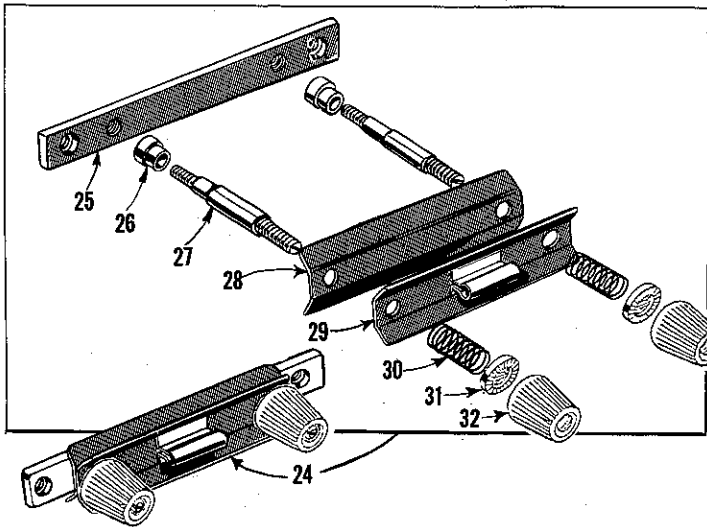
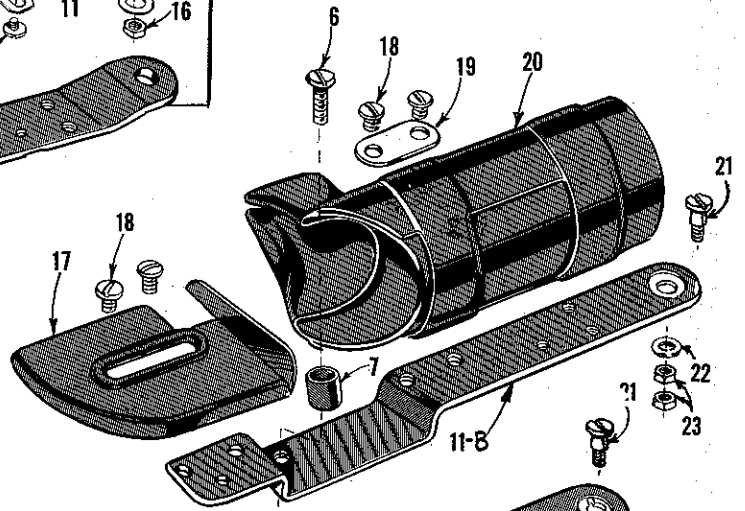
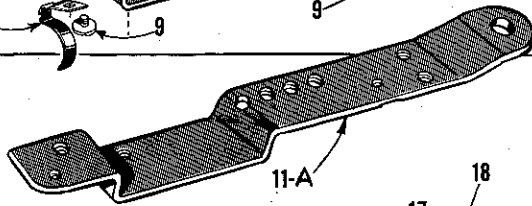
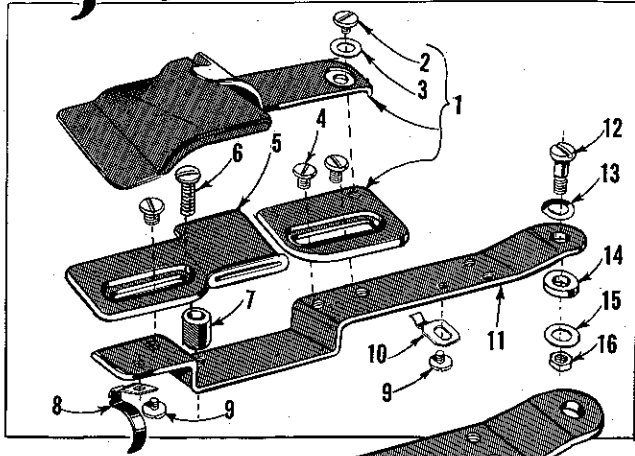
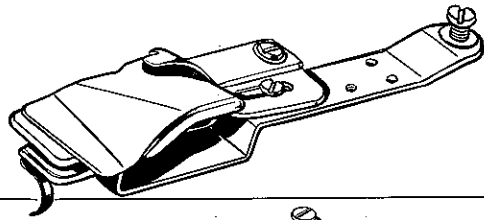
Ref. No.	Part No.	Description	Amt. Req.
1	54224 B	Throat Plate, for Style 54200 N -----	1
2	54205 B	Feed Dog, 22 teeth per inch, for Style 54200 N -----	1
3	54220 B	Presser Foot, for Style 54200 N -----	1
4	51330 AH	Chaining Section -----	1
5	51330 W	Spring, for chaining section -----	1
6	51330 AJ	Presser Foot Shank-----	1
7	91	Clamp Screw-----	1
8	54230 E	Presser Foot Bottom -----	1
9	54224 C	Throat Plate, for Style 54200 P -----	1
10	54205 C	Feed Dog, 22 teeth per inch, for Style 54200 P -----	1
11	56320 R	Presser Foot, for Style 54200 P -----	1
12	51230 N	Yielding Section -----	1
13	61430 BT	Spring, for chaining section -----	2
14	56330 C	Presser Foot Bottom -----	1
15	22799 G	Hinge Screw -----	1
16	56330 D	Presser Foot Shank-----	1
17	91	Clamp Screw-----	1
18	604	Screw -----	1
19	19146 A	Spring-----	1
20	56330 B	Chaining Section-----	1



ELASTIC METERING DEVICE

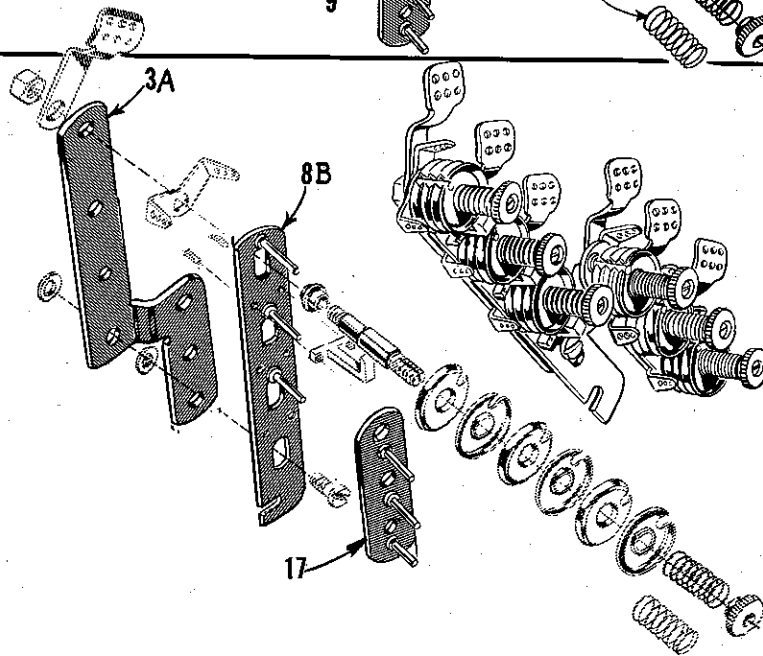
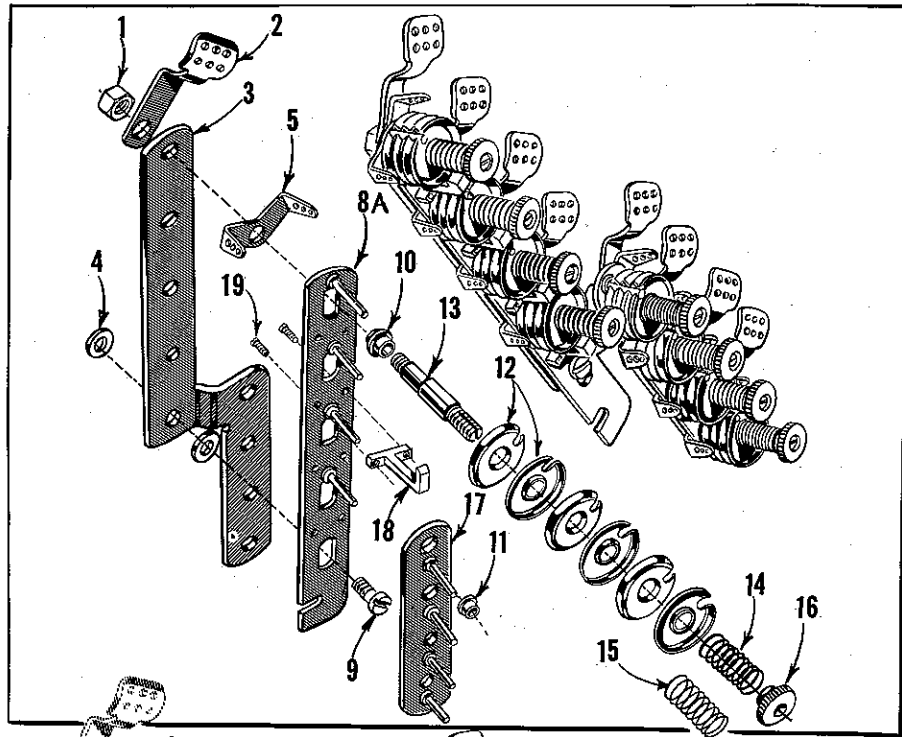
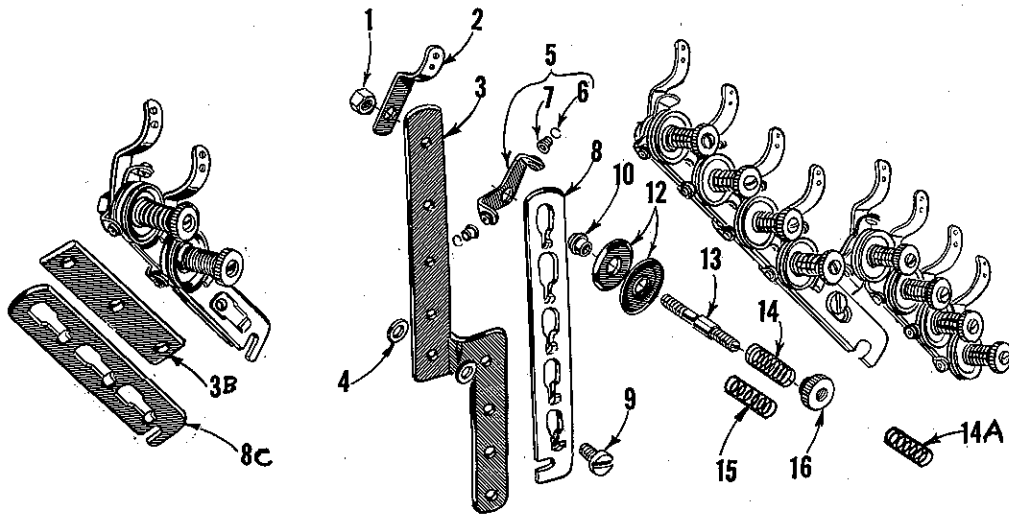
NOTE: The following parts are used on Styles 54200 G, 54400 G only.

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	29486 F	Elastic Metering Device, complete -----	1
2	51235 A	Feed Rocker Arm -----	1
3	93	Screw -----	2
4	51054	Link Pin -----	2
5	666-149	Oil Wick -----	1
9	77	Screw -----	1
10	269	Nut -----	1
11	20	Washer -----	1
12	52736	Feed Crank Link -----	1
13	77	Screw -----	1
14	660-169	Needle Bearing -----	1
15	51236 F	Feed Crank Link Ferrule -----	1
16	51236 G	Feed Crank Stud -----	1
17	52776 F	Connecting Rod Link -----	1
18	12538	Nut -----	1
19	39141	Connecting Rod -----	1
20	269	Nut -----	1
21	52776 C	Ball Joint -----	1
22	97 A	Cap Screw -----	2
23	21657 E	Washer -----	2
24	627 A	Screw -----	2
25	52776	Frame -----	1
26	80692	Bushing, right -----	1
27	80662	Bushing, left -----	1
28	52776 E	Indicator Washer -----	1
29	39258 C	Washer -----	1
29A	20	Washer -----	1
30	18	Nut -----	1
31	52776 B	Driving Arm -----	1
32	93	Screw -----	2
33	52778 B	Pivot Shaft -----	2
34	22565 C	Screw -----	4
35	52778 D	Guide -----	2
36	22562	Screw -----	1
37	52778 L	Tension Release Lever -----	1
38	52778 M	Spring -----	1
39	434	Adjusting Nut -----	2
40	22594	Screw -----	1
41	52776 A	Shaft -----	1
42	52778 J	Spring -----	1
43	52778 G	Strip Tension Roller End Plate -----	2
44	660-228	Retaining Ring -----	2
45	52778 H	Strip Tension Roller End Plate Shaft, upper -----	1
46	52778 K	Strip Tension Roller Spring Stud -----	1
47	52778 F	Strip Tension Roller -----	1
48	52777 K	Feed Roller Guard -----	1
49	90	Screw -----	2
50	52777 H	Check Clutch Arm -----	1
51	22589	Screw -----	3
52	52777 J	Check Clutch -----	1
53	52777 C	Clutch Roller -----	6
54	52777 D	Roller Clutch Spring -----	6
55	52777 G	Spacing Collar -----	1
56	52777	Feed Roller -----	1
57	52777 E	Brake Shoe -----	2
58	52777 F	Brake Shoe Spring -----	1
59	52777 A	Driving Clutch -----	1
60	51280 J	Dowel Pin -----	2
61	52777 B	Clutch Driving Collar -----	1
62	531	Screw -----	2
63	22589	Screw -----	3



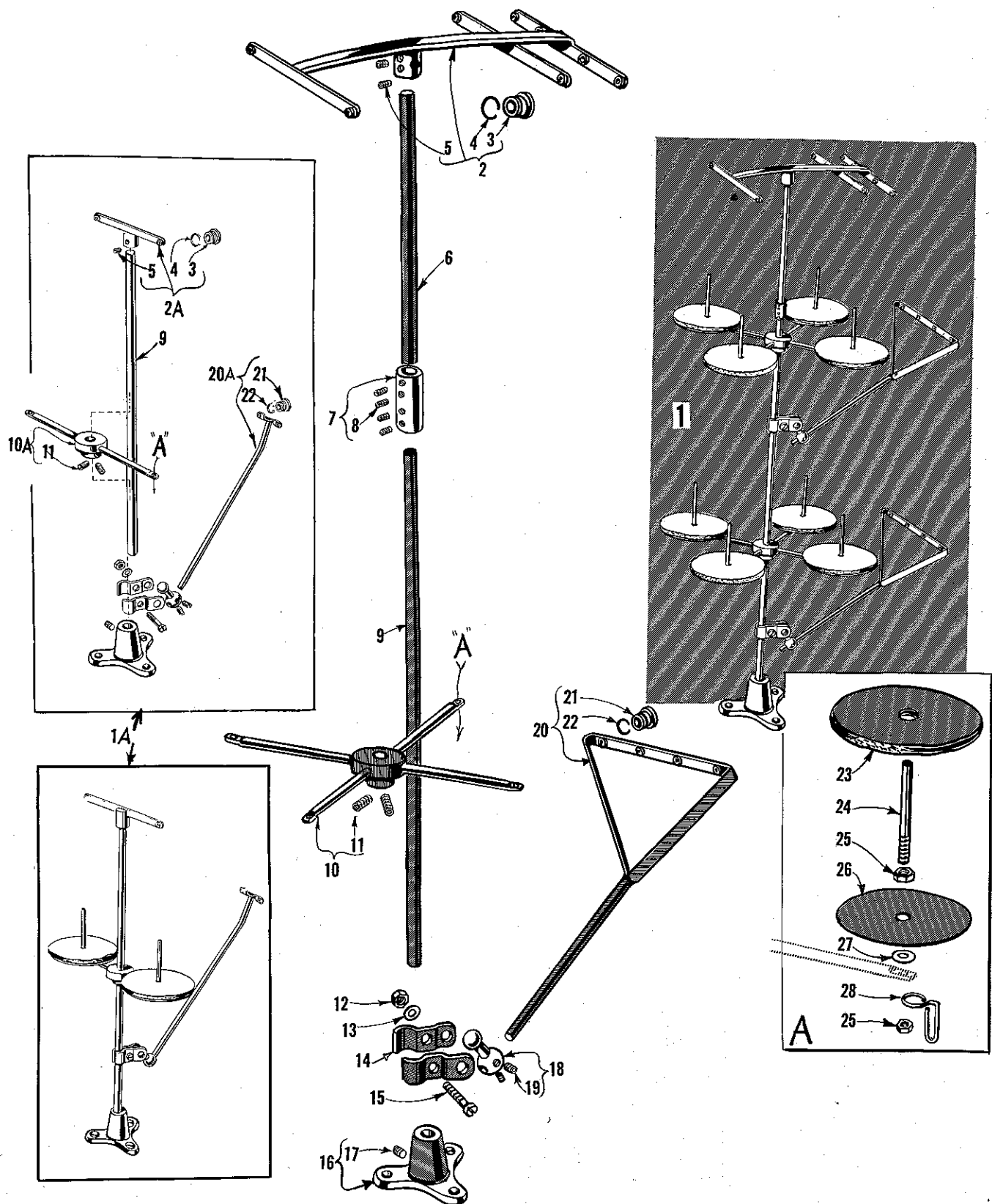
ATTACHMENTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	23405 R	Folder, for Nos. 16, 21, 24, 32 gauge Styles 54200 A, E, G, 54400 A, E, G; .5/64" capacity, makes 3/8" fold downwardly -----	1
2	22726	Screw -----	1
3	12957 E	Spring Washer-----	1
4	25 C	Screw -----	3
5	23404 G	Guide, for No. 16 gauge Styles 54200 A, E, G, 54400 A, E, G; uses 1" elastic -----	1
	23404 F	Guide, for No. 21 gauge Styles 54200 A, E, G, 54400 A, E, G; uses 1 1/4" elastic -----	1
	23404 H	Guide, for No. 24 gauge Styles 54200 A, E, G, 54400 A, E, G; uses 1 3/8" elastic -----	1
	23404 K	Guide, for No. 32 gauge Styles 54200 A, E, G, 54400 A, E, G; uses 1 3/4" elastic -----	1
6	22514 A	Screw, for use with Nos. 54264, 54264 F, 54264 G --	1
7	54264 D	Spacing Collar, for use with Nos. 54264, 54264 F, 54264 G-----	1
8	54264 C	Spring, with finger projection -----	1
9	12986 B	Screw -----	2
10	54264 B	Spring -----	1
11	54264	Folder Mounting Bracket, for Nos. 16, 21, 24 gauge Styles 54200 A, C, E, F, G, 54400 A, C, E, F, G, and 54200 K-4-12-56-12-----	1
11A	54264 G	Folder Mounting Bracket, for No. 32 gauge Styles 54200 A, C, E, F, G, 54400 A, C, E, F, G -----	1
11B	54264 F	Folder Mounting Bracket, for Style 54200 K-4-16-64-16 -----	1
11C	54464	Folder Mounting Bracket, for nine and twelve needle machines -----	1
11D	54264 H	Folder Mounting Bracket, for Style 54200 N, P -----	1
12	22854	Screw, for use with Nos. 54264, 54264 G -----	1
13	HA86 B	Spring Washer, for use with Nos. 54264, 54264 G ---	1
14	54264 A	Spacer, for use with Nos. 54264, 54264 G -----	1
15	61351 C	Washer, for use with Nos. 54264, 54264 G -----	1
16	258 A	Nut, for use with Nos. 54264, 54264 G -----	1
17	23404 J	Edge Guide, for Style 54200 K-----	1
18	25 C	Screw -----	4
19	23425 V	Washer Plate, for Style 54200 K-----	1
20	23360 G-1 5/8	Right Angle Folder, uses 4" strip finishes 1 5/8" for Style 54200 K-4-16-64-16 -----	1
	23360 G-1 7/16	Right Angle Folder, uses 3 1/2" strip, finishes 1 7/16" for Style 54200 K-4-12-56-12 -----	1
21	22504 A	Pivot Screw, for use with Nos. 54264 F, 54264 H 54464 -----	1
22	28577	Washer, for No. 22504 A -----	1
23	9937	Nut, for No. 22504 A-----	2
24	21182 N	Strip Tension Assembly, for Styles 54200 A, E, 54400 A, E-----	1
25	21182 P	Strip Tension Base-----	1
26	11261 B	Tension Post Ferrule -----	2
27	56392 E	Tension Post -----	2
28	21182 L	Strip Tension Plate, inner -----	1
29	21182 K	Strip Tension Plate, outer -----	1
30	110-3	Tension Spring -----	2
31	39592 AK	Tension Spring Ferrule-----	2
32	39592 Z	Tension Nut -----	2



THREAD TENSION PARTS

Ref. No.	Description	One Needle Machine		Four Needle Machine		Nine Needle Machine		Twelve Needle Machine	
		Part No.	Amt.	Part No.	Amt.	Part No.	Amt.	Part No.	Amt.
1	Nut	43266	1	43266	7	43266	5	43266	7
2	Lead-in Thread Guide	51491 C	2	51491 C	8	51491	6	54491	8
3	Tension Post Support			51892	1	51892	1	51892	1
3A	Tension Post Support					51992 A			
3B	Tension Post Support	52892	1						
4	Spacing Washer	80557	2	80557	2	80557	2	80557	2
5	Tension Thread Eyelet	51292 D	2	51292 D	8	54492 A	6	54492 A	8
6	Eyelet Locking Ring	668-28	2	668-28	2	668-28			
7	Eyelet	668-25	2	668-25	2	668-25			
8	Tension Disc Separator			21657 AM-5	1				
8A	Tension Disc Separator								
8B	Tension Disc Separator								
8C	Tension Disc Separator								
9	Screw	21657-3	1			21657 AB-9	1	21657 AB-12	1
10	Needle Thread Tension Post Ferrule	22598 C	1	22598 C	1	22598 C	1	22598 C	1
11	Looper Thread Tension Post Ferrule	51292 A	1	51292 A	4	51292 A	3	51292 A	4
12	Tension Disc	51292 A	1	51292 A	4	51292 A	3	54492 C	4
13	Tension Post	109	4	109	16	54492	36	54492	48
14	Tension Spring, for needle thread	51292 G	2	51292 G	8	51292 B	6	54492 B	8
14A	Tension Spring, for needle thread			51292 F-5	4	51292 F-5	3	51292 F-5	4
15	Tension Spring, for looper thread	51292 F-8	1						
16	Tension Regulating Nut	51292 F-2	1	51292 F-2	4	51292 F-1	3	51292 F-1	4
17	Looper Thread Tension Support	51292 C	2	51292 C	8	51292 C	6	51292 C	8
18	Needle Thread Tension Release Finger					54492 D	1	54492 E	1
19	Screw					21657 AC	3	21657 AC	4
						22738	6	22738	8



THREAD STAND PARTS

NOTE: The following thread stand parts are furnished with all Styles in Class 54200 and 54400, except the nine and twelve needle machines, for which no thread stands are available.

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
*1	21101 R-8 W	Thread Stand, complete for all styles except 54200 N, P, 54400 H, J-----	1
1A	21101 H-2	Thread Stand, complete, for Styles 54200 N, P ----	1
2	21114 H-4	Eyelet Support, for No. 21101 P-8 -----	1
2A	21114 H-2	Eyelet Support, for No. 21101 H-2 -----	1
3	21114 L	Eyelet -----	2 or 8
4	21114 M	Eyelet Locking Ring-----	2 or 8
5	22651 CD-4	Screw -----	1 or 2
6	21104 B-11	Thread Stand Rod, upper, for No. 21101 P-8 --	1
7	21127	Coupling, for No. 21101 P-8-----	1
8	22651 CD-3	Screw -----	4
9	21104 B-24	Thread Stand Rod -----	1
10	21114 D-4	Spool Seat Support, for No. 21101 P-8 -----	2
10A	21114 D-2	Spool Seat Support, for No. 21101 H-2 -----	1
11	22651 CD-5	Screw -----	2
12	21104 H	Nut-----	1 or 2
13	652-16	Washer -----	1 or 2
14	21114 U	Lead Eyelet Ball Split Socket-----	2 or 4
15	22810	Screw -----	1 or 2
16	21114 A	Base -----	1
17	22651 CD-5	Screw -----	1
18	21114 T	Lead Eyelet Socket Ball -----	1 or 2
19	22651 CD-4	Screw -----	2
20	21114 S-4	Lead Eyelet, for No. 21101 P-8 -----	2
20A	21114 S-2	Lead Eyelet, for No. 21101 H-2 -----	1
21	21114 L	Eyelet -----	2 or 4
22	21114 M	Eyelet Locking Ring-----	2 or 4
23	21104 V	Pad -----	2 or 8
24	21114 W	Spool Pin -----	2 or 8
25	258 A	Nut-----	4 or 16
26	21114	Spool Seat Disc -----	2 or 8
27	652-16	Washer -----	2 or 8
28	21114 AF	Eyelet, for No. 21101 P-8-----	4

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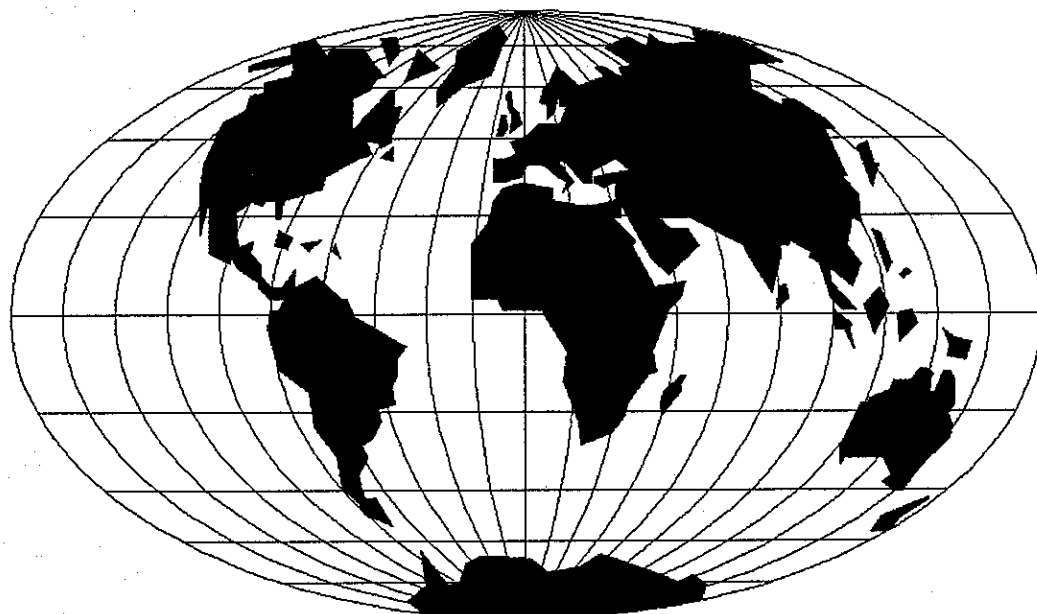
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