

**FIRST  
EDITION**



*Union Special*<sup>®</sup>  
INDUSTRIAL SEWING EQUIPMENT

**CATALOG NO. T124M**

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**STYLES**

**51000B**

**51100R**

**51100S**

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**SINGLE NEEDLE CYLINDER BED  
DOUBLE LOCKED STITCH MACHINES FOR  
MOCK-LINKING KNIT BORDERS**



Catalog No. T124 M

LIST OF PARTS

CLASSES 51000, 51100

Styles

51000 B

51100 R

51100 S

First Edition

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**UNION SPECIAL CORPORATION**

INDUSTRIAL SEWING MACHINES

**CHICAGO**

Printed in U.S.A.

November, 1978

## IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine is identified by a Style number which is stamped into the name plate on the machine. Style numbers are classified as standard and special. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 51000 B". 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 51000 BZ".

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: "51000".

## 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 Classes 51000 and 51100. 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.

### STYLE OF MACHINE IN CLASS 51000

Left Hand Flat Bed High Throw Machine, Single Needle, 1 1/2 Inch Needle Bar Travel, 1 1/4 Inch Looper Travel, Needle Bearings for Feed Crank, Feed Lift and Looper Avoid Eccentric, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Left of Needle Bar 8 1/2 Inches.

51000 B Upper and under feed machine for seaming valve type multi-wall paper bags. Stitch range 3 1/2 to 7, set at 3 1/2 S.P.I. Seam specification with valve type attachment, 401-BSa-1.

### STYLES OF MACHINES IN CLASS 51100

Right Hand Flat Bed High Throw Machine, Single Needle, 1 1/2 Inch Needle Bar Travel, 1 1/4 Inch Looper Travel, Needle Bearings for Feed Crank, Feed Lift and Looper Avoid Eccentric, Single Reservoir Enclosed Automatic Lubricating System, Filter Type Oil Return Pump, Lateral Looper Travel, Maximum Work Space to Right of Needle Bar 8 1/2 Inches.

51100 R Upper and under feed machine for seaming valve type multi-wall paper bags. Stitch range 3 1/2 to 7, set at 3 1/2 S.P.I. Seam specification with valve type attachment, 401-BSa-1.

51100 S Same as 51100 R, except fitted with round belt pulley.

## NEEDLES

Each UNION SPECIAL needle has both a type number and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes the largest diameter of blade measured in thousandths of an inch, midway between the shank and the eye. Collectively, the type number and the size number is the complete symbol.

Standard needle for Styles 51000 B, 51100 R and 51100 S is Type 947 G. It has a round shank, spear point, long length, double groove, ball eye, spotted, chromium plated - available in sizes 185/073, 200/080, 230/090.

## NEEDLES (continued)

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 947 G, 185/073".

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

## USE GENUINE NEEDLES AND REPAIR PARTS

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

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

## IDENTIFYING PARTS

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

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

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

## TERMS

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

## OILING

The oil has been drained from the machine before shipping, and the 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 oil cup in the top cover and the level is checked at the sight gauge on the front of the machine. The oil level should be maintained between the red lines on the gauge. The capacity of the oil reservoir is 12 ounces.

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

A daily check before the morning start should be made and oil added if required. 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.

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

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	8	Feed Rocker Shaft	1	98	Screw for 51044	1	1740	Pin for 51008 B, 51108 E
1	18	Nut for 43242 N	2	98	Screw for 51135 R			
1	18	Nut for 51036	1	98	Screw for 51244	2	6042 A	Washer for 51035 A
1	18	Nut for 51041 E	3	98 A	Screw for 52 A	2	6042 A	Washer for 51135 P
1	18	Nut for 51240 E	4	109	Tension Disc	1	11638 M	Nut for 51093 E
1	18	Nut for 52841 A	2	187 A	Screw for 51082 L	1	11638 M	Nut for 51193 F
1	20	Washer for 51036	2	187 A	Screw for 51182 K	1	12538	Nut for 51041 G
1	20	Washer for 51070	1	FI231	Felt	1	12538	Nut for 51241 K
1	20	Washer for 51136 E	1	258	Nut for 51034	1	12982	Nut for 81
1	20	Washer for 51170 E	1	258	Nut for 51134 B	3	14649	Collar for feed rocker shaft (88)
1	20	Washer for 51758	1	258 A	Nut for 51080 A			
1	20	Washer for 51126 N	1	258 A	Lock Nut for 51745	1	15430 C	Nut for 51216
2	CL21	Oil Wick for 51093 F	1	269	Nut for 43242 N	1	15430 D	Nut for 51216
2	CL21	Oil Wick for 51193 P	1	269	Nut for 51136 E	1	15465 F	Looper Rocker Cone for 29192 (88)
1	27-235 Blk.	Shim	1	269	Nut for 51240 E			
2	50-216 Blk.	Pin for cast-off wire support	1	402	Stud for 51083	1	15465 F	Looper Rocker Cone for 29192 J (88)
			2	531	Screw for 51493 BP	1	21102 B	Eyelet Rod
1	50-458 Blk.	Spring Pin for 51041 G	2	531	Screw for 51493 BQ	1	21104 B-18	Vertical Thread Stand Rod
			1	538	Screw for 51034			
1	50-458 Blk.	Spring Pin for 51241 K	1	538	Screw for 51134 B	1	21104 B-18	Horizontal Thread Stand Rod
			1	539	Needle Thread Eyelet			
3	52 A	Thread Eyelet (98 A)	2	643-127 Blk.	Gasket for 51093 P	1	21104 B-24	Vertical Thread Stand Rod
			1	652 D-8	Gasket for 51493 F	1	21104 C	Thread Stand Rod Connection (22650 CE-6)
1	73	Screw for looper	1	660-147	Washer for 22747 A	2	21104 D	Spool Seat (22650 CB-3)
1	73 A	Screw for looper needle guard	1	660-169	Brass Coupling	2	21104 E	Spool Seat Connection
3	74	Screw for customer's driving gear, for 51000 B, 51100 R	1	660-203	Needle Bearing for 51236 E	2	21104 G	Spool Pin (21104 H)
1	TA75	Tape Disc	1	660-203	Rivet for 29348 G	2	21104 H	Nut for 21104 G
1	77	Screw for 29348 G, upper link pin	2	660-212	Rivet for 29348 J	2	21105 J	Eyelet
1	77	Screw for 29348 J, upper link pin	2	666-65	Oil Wick for looper rocker shaft	1	21114 A	Thread Stand Base (22651 CD-3)
4	77	Screw for 51054, 51236 A	1	666-97	Oil Sight Gauge	2	21114 M	Locking Ferrule for 51192 G
1	77	Screw for 51204 A, for 51000 B	1	666-98	Oil Cup for 51082 G	1	21127	Thread Stand Rod Coupling (22651 CD-3)
1	77 A	Screw for 51204 A, for 51100 R, S	1	666-98	Oil Cup for 51282 W	1	21145	Wood Cones
			1	666-101	Felt Wick for 51193 F	1	21210	Looper Collar
			1	666-101	Felt Wick for 51093 E	1	21217 A	Eyelet Rod Support (22650 CB-4, 22651 CD-4)
3	80	Screw for clothplate	2	666-103	Felt Wick for 51193 J	1	21657 E	Washer for 22528
1	81	Screw for 51042 E (12982)	4	666-111	Oil Wick for feed rocker shaft	1	21657 Z	Tension Release Shaft Tube
1	81	Screw for 52742 K (12982)	1	666-114	Oil Wick for main shaft	4	22513	Screw for 35731 A
2	J87 J	Screw for 51004, 51104 K	1	666-121	Felt for 51093 K	1	22519 H	Screw for 51244 B
2	J87 J	Screw for 51104 J, 51104 K	1	666-121	Felt for 51293 U	7	22524	Screw for 51082 C
2	88	Screw for 14649	1	666-123	Felt for 51093 J	7	22524	Screw for 51282 L
2	88	Set Screw for 15465 F	1	666-124	Felt for 51193 X	1	22528	Screw for feed dog, lower
1	88 B	Screw for 51044 B	1	666-128	Oil Wick for needle bar	1	22528	Screw for feed dog, upper
1	88 B	Screw for 52944 G	1	666-128	Oil Wick for 51041 G	2	22528	Screw for 29348 G
1	90	Screw for 51134 V	1	666-130	Oil Wick for 51241 K	1	22528	Screw for 51057 A (21657 E) 51000 B
4	90	Screw for 51082 P	2	666-138	Felt Wick for 51134 S	1	22528	Screw for 51157 J (21657 E) 51100 R, S
4	90	Screw for 52894 AB	2	666-138	Oil Wick for 51034 L	2	22539 A	Plug Screw
2	93 A	Screw for 29348 J	2	666-138	Oil Wick for 51134 L	4	22548	Screw for 52882 AE
1	95	Screw for 51051 G	1	666-149	Felt Wick for 51054	1	22557	Screw for 51083 (43232 R)
2	95	Screw for 51147	1	666-170	Wick for 51134 V	1	22557	Screw for 51183 (43232 R)
1	HA95	Screw for 51034 L	1	666-170	Oil Wick for 51250 E	2	22559 A	Screw for 29105 R, small ball end
1	HA95	Screw for 51134 L	2	666-179	Wedge Pin for 666-111	2	22559 A	Screw for 29105 Y, small ball end
1	96	Spot Screw for 51023 A	2	668-27	Eyelet for 51192 G	2	22559 B	Screw for 29105 R, large ball end
1	96	Spot Screw for 51123 H	2	719	Screw for 51150, 51250 E	2	22559 B	Screw for 29105 Y, large ball end
1	96	Screw for 51244	1	906 A	Adjusting Screw for upper feed dog (907)	2	22559 E	Screw for 29476 DT
1	97	Screw for presser foot	2	907	Nut for 906A, 22562	2	22559 E	Screw for 29476 EV
2	97 A	Screw for 29066 N	1	1280	Nut for 52887 N	1	22560 B	Screw for 51034
2	97 A	Screw for 51041 G				2	22560 B	Screw for 51051
2	97 A	Screw for 51241 K				1	22560 B	Screw for 51134 B
						2	22560 B	Screw for 51751

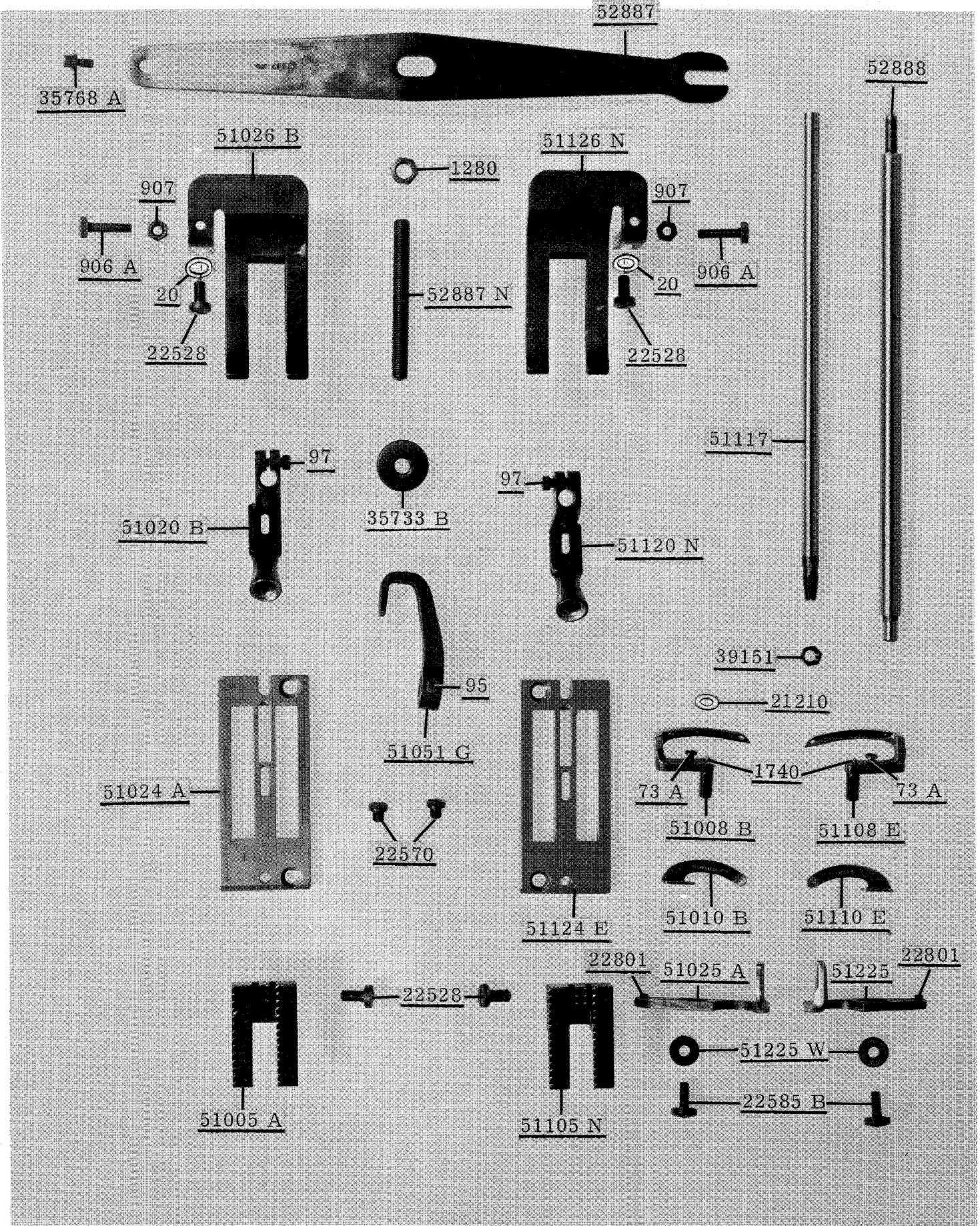
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	22562	Screw for 51186 E	3	22894 C	SetScrew for 29105 R	1	51008 B	Looper for 51000 B (73, 1740)
1	22562 A	Screw for 51254 H	3	22894 C	SetScrew for 29105 Y	1	51010 B	Looper Needle Guard for 51000 B (73 A)
1	22564	Screw for 29348 G, 29348 J	2	22894 D	Spot Screw for 29105 R	1	51013	Lpr, Rock, for 29192 J
3	22569 B	Screw for 51093 P	2	22894 D	Spot Screw for 29105 Y	1	51015 B	Needle Lever for 29348 G
3	22569 B	Screw for 51493 F	1	22894 D	Spot Screw for 51142 E	1	51020 B	Presser Foot for 51000 B (97)
3	22569 B	Screw for bearing housing	1	22894 D	Spot Screw for 51142 F	1	51021	Pulley for 51000 B, 51100 R (22597 A, 22597 B)
3	22569 G	Screw for 51093 P	1	22894 H	Screw for 51042 D	1	51022	Main Shaft for 51000 B
3	22569 G	Screw for 51493 F	1	22894 H	Screw for 52742 H	1	51023 A	Take-up for 51000 B (96, 22580 D)
2	22570	Screw for throat plate	1	29066 N	Needle Lever Connecting Rod Upper Bearing Assembly (97 A)	1	51024 A	Throat Plate for 51000 B (22570)
34	22571 D	Plug Screw	1	29105 R	Looper Drive Eccentric Assembly, for 51100 R, S (22559 A, 22559 B, 22894 C, 22894 D)	1	51025 A	Needle Guard for 51000 B (22585 B, 22801)
1	22580 D	SetScrew for 51023 A	1	29105 Y	Looper Drive Eccentric Assembly, for 51000 B (22559 A, 22559 B, 22894 C, 22894 D)	1	51026 B	Feed Dog, upper, for 51000 B (906 A, 907, 22528)
1	22580 D	SetScrew for 51123H	1	29192	Looper Rocker Assembly, for 51100 R, S	1	51034	Lower Feed Bar for 51000 B (77, 22834)
2	22585 A	Screw for 51082 C	1	29192 J	Looper Rocker Assembly, for 51000 B	1	51034 L	Upper Feed Bar for 51000 B (HA95)
2	22585 A	Screw for 51282 L	1	29192 J	Looper Rocker Assembly, for 51000 B	1	51034 M	Upper Feed Bar Arm for 51000 B
1	22585 B	Screw for needle guard (51225 W)	1	29348 G	Needle Lever Assembly, for 51000 B	1	51034 N	Upper Feed Bar Spring for 51000 B
1	22586	Screw for 51134 S	1	29348 J	Needle Lever Assembly, for 51100 R, S	1	51035	Feed Rocker for 51000 B (92127)
1	22586 R	Screw for 660-212	1	29348 J	Needle Lever Assembly, for 51100 R, S	1	51035 A	Feed Rocker Arm for 51000 B (6042 A, 55235 D, 55235 E)
2	22593	Screw for 51104 L	1	29476 DS	Looper Avoid Eccentric Assembly, complete .096 inch throw	1	51036 A	Feed Crank Stud for 51000 B (18, 20, 22799 F, 51136)
1	22597	Spot Screw for 51321 A	1	29476 DT	Crankshaft Assembly 1.132 inch throw, for 51100 R, S (22559 E)	1	51041 E	Looper Connecting Rod Ball Joint, right, for 51000 B (18, 22729 C)
1	22597 A	SetScrew for 51021	1	29476 DY	Feed Lift Eccentric Assembly, upper and lower, complete .112 inch throw	1	51041 G	Looper Connecting Rod and Ball Joint, left, for 51000 B (97 A, 12538)
1	22597 A	SetScrew for 51321 A	1	29476 EV	Crankshaft Assembly 1.132 inch throw, for 51000 B (22559 E)	1	51042 A	Looper Drive Lever Shaft for 51000 B
1	22597 B	Spot Screw for 51021	1	35178 D	Spring for 666-65	1	51042 D	Looper Drive Lever for 51000 B (22811 B, 22894 H)
1	22650 CB-4	Screw for 21217 A	2	35178 D	Spring for 666-114	1	51042 E	Looper Drive Lever Rocker for 51000 B (18, 22852 A)
2	22650 CE-6	Screw for 21104 C	4	35731 A	Presser Bar Connection Guide Plate (22513)	1	51044	Looper Rocker Frame for 51000 B (96, 98)
1	22651 CD-3	Screw for 21114 A	2	35733 B	Presser Spring Regulating Nut	1	51044 A	Looper Rocker Shaft for 51000 B
4	22651 CD-3	Screw for 21127	1	35768 A	Presser Spring Anchor Screw for 51082 N	1	51044 B	Spacing Collar for looper rocker shaft, for 51000 B (88 B)
1	22651 CD-4	Screw for 21217 A	1	35768 A	Presser Spring Anchor Screw for 51082 N	1	51051	Presser Bar Connection for 51000 B (22560 B)
2	22729	Screw for 51243 C	1	35768 A	Presser Spring Anchor Screw for 51282 W	1	51051 G	Top Feed Lifter (95)
2	22729 C	Screw for 51041 E	1	35833 C	Presser Spring Plate	1	51054	Feed Crank Link Pin (77)
2	22729 C	Screw for 52841 A	1	39132 V	Pin	2	51054	Link Pin for 29348 G
1	22733 A	Plug Screw for 51100 R, S	1	39151	Nut for 51117	2	51057 A	Link Pin for 29348 J
1	22733 B	Plug Screw for 51082 K (41394 A)	1	41394 A	Gasket for 22733 B	1	51058 A	Cast-off Wire Support for 51000 B (22528)
1	22733 B	Plug Screw for 51182 J (41394 A)	1	43232 R	Washer for 22557	1	51070	Needle Lever Thread Eyelet for 51000 B (652 D-8, 22747 A, 43443 Q)
2	22737	Screw for 51082 D	1	43242 N	Looper Connecting Rod for 51100 R, S (18, 269)	1	51080	Needle Thread Take-up Wire for 51000 B (20, 22848)
2	22737	Screw for 51282 N	1	43443 Q	Nut for 22747 A	1	51080	Throat Plate Support for 51000 B (22839)
1	22747 A	Screw for 51058 A (652 D-8, 43443 Q)	1	51001	Cloth Plate for 51000 B (80)	1	51080 A	Throat Plate Support Pin (258 A)
1	22747 A	Screw for 51158 E (652 D-8, 43443 Q)	1	51004	Auxiliary Cast-off for 51000 B (J87 J)	1		
1	22798 A	Screw for 51204	1	51005 A	Feed Dog, lower, for 51000 B (22528)	1		
1	22799 F	Screw for 51036						
1	22799 F	Screw for 51136						
1	22801	Screw for needle guard						
1	22811 B	Screw for 51042 D						
1	22811 B	Screw for 52742 H						
1	22829	Lock Nut Screw for 51745						
1	22834	Screw for 51034						
1	22834	Screw for 51082 M						
1	22837	Screw for 51282 B						
3	22839	Screw for 51080						
3	22839	Screw for 51180 H						
1	22840	Plug Screw for bed						
2	22848	Plug Screw for bed						
2	22848	Screw for customer's attachment, for 51000 B, 51100 R						
1	22848	Screw for 51070						
8	22848	Screw for 51082 K						
1	22848	Screw for 51170 E						
8	22848	Screw for 51182 J						
1	22848	Screw for 51758						
1	22849	Screw for 51082 N						
1	22849	Screw for 51282 W						
1	22852 A	Screw for 51042 E (51242 M)						
1	22852 A	Screw for 52742 K						
1	22863	Screw for 51034						
1	22863	Screw for 51134 B						
1	22883 A	Plug Screw						

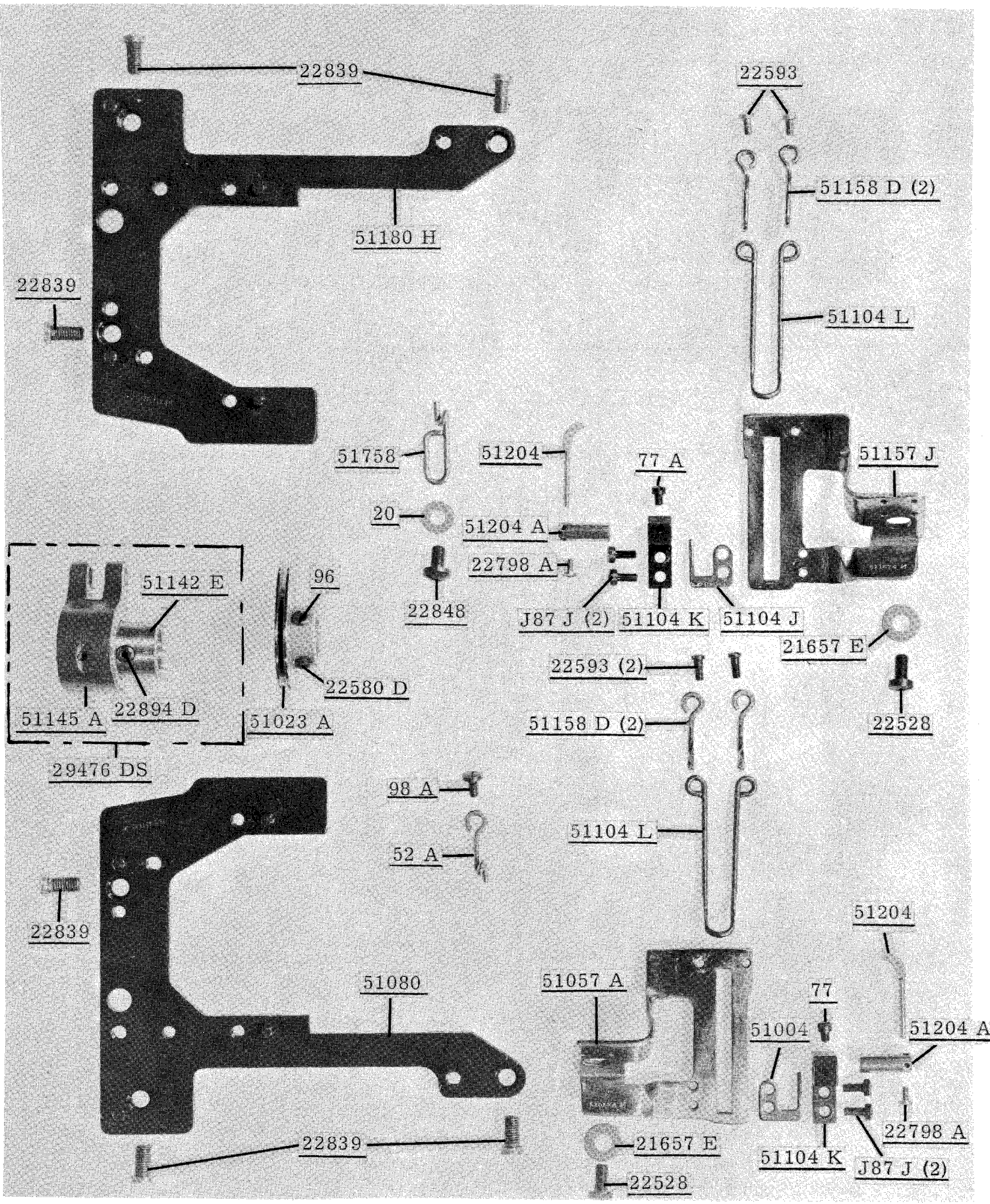
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51082 C	Oil Reservoir Top Cover for 51000 B (22524, 22585 A)	1	51134 M	Upper Feed Bar Arm for 51100 R, S	2	51192 G	Tension Thread Eyelet
1	51082 D	Drip Plate for 51082 C (22737)	1	51134 N	Upper Feed Bar Spring for 51100 R, S	1	51193 F	Oil Tube for feed crank, for 51100 R, S (11638 M)
1	51082 K	Oil Reservoir Back Cover for 51000 B (22733 B, 22848, 41394 A)	1	51134 S	Feed Bar Shaft (666-130, 22586)	1	51193 J	Oil Tube for looper drive ball joint, right, for 51000 B
1	51082 L	Top Cover Oil Drip Plate for 51000 B (187 A)	1	51134 T	Lubricating Felt for 51134 S	1	51193 J	Oil Tube for looper drive ball joint, left, for 51100 R, S
1	51082 M	Face Plate (22837)	1	51134 V	Taper Pin (90)	1	51193 P	Oil Wick for presser bar and needle bar, for 51100 R, S
1	51082 N	Top Cover for 51000 B (22849, 35768 A)	1	51134 X	Lower Feed Bar for 51100 R, S (77, 22834)	1	51193 W	Oil Tube for looper avoid and upper feed lift eccentric, for 51100 R, S
1	51082 P	Crankshaft Chamber Cover, upper for 51100 R, S (90)	1	51135 N	Feed Rocker for 51100 R, S (92127)	1	51193 X	Oil Tube for upper feed lift pin, for 51100 R, S
1	51083	Hand Lifter Lever for 51000 B (402, 22557, 43232 R)	1	51135 P	Feed Rocker Arm for 51100 R, S (6042 A, 55235 D, 55235 E)	1	51204	Cast-off Wire (22798 A)
1	51085	Stitch Regulating End Cap for 51000 B	1	51135 R	Feed Rocker Shaft Collar and Lubricating Felt Support (98)	1	51204 A	Cast-off Wire Support (77 or 77 A)
1	51093 E	Oil Tube for feed crank, for 51000 B (11638 M)	1	51136	Feed Crank Stud Washer	1	51204 A	Cast-off Wire Support (77 or 77 A)
1	51093 F	Oil Wick for presser bar and needle bar for 51000 B	1	51136 F	Feed Crank Stud for 51100 R, S (20, 269, 22799 F, 51136)	1	51213	Looper Rocker for 29192
1	51093 H	Oil Tube for looper avoid and upper feed lift eccentric, for 51000 B	1	51142 E	Eccentric for 29476 DS (22894 D)	1	51216	Needle Lever Connecting Rod Tube (15430 C, 15430 D)
1	51093 J	Oil Tube for upper feed lift pin, for 51000 B	1	51142 F	Eccentric for 29476 DY (22894 D)	1	51225	Needle Guard for 51100 R, S (22585 B, 22801)
1	51093 K	Oil Tube for feed lift eccentric, for 51000 B	1	51144	Looper Rocker Shaft for 51100 R, S	1	51225 W	Washer for 22585 B
1	51093 P	Oil Pump Housing, Tube and Filter Cap Assembly, for 51000 B (22569 B, 22569 G)	1	51145 A	Eccentric Bearing Assembly for 29476 DS	3	51236 A	Link Pin for feed lift and looper avoid eccentric assembly (77)
1	51101 A	Cloth Plate for 51100 R, S (80)	1	51145 A	Eccentric Bearing Assembly for 29476 DY	1	51236 D	Feed Crank Link for 51236 E
1	51104 J	Auxiliary Cast-off for 51100 R, S (J87 J)	1	51147	Main Shaft Collar (95)	1	51236 E	Feed Crank Link Assembly
1	51104 K	Auxiliary Cast-off Support (J87 J)	1	51150	Needle Lever Thrust Collar	1	51236 F	Feed Crank Ferrule for 51236 E
1	51104 L	Cast-off Wire (22593)	1	51154 C	Needle Bar Bushing, upper	1	51240 E	Looper Connecting Rod for 51000 B (18, 269)
1	51105 N	Feed Dog, lower, for 51100 R, S (22528)	1	51154 D	Needle Bar Bushing, lower	1	51241 K	Looper Connecting Rod and Ball Joint, right, for 51100 R, S (97 A, 12538)
1	51108 E	Looper for 51100 R, S (73, 1740)	1	51154 G	Needle Bar Conn. for 29348 G (22562 A)	2	51242 L	Thrust Washer for looper drive lever rocker
1	51110 E	Looper Needle Guard for 51100 R, S (73 A)	1	51154 G	Needle Bar Conn. for 29348 J (22562 A)	2	51242 M	Washer for 22852 A, 52841 G
1	51115 B	Needle Lever for 29348 J	1	51157 J	Cast-off Wire Support for 51100 R, S (22528)	2	51242 P	Looper Drive Lever Shaft for 51100 R, S
1	51117	Needle Bar, marked "DR" (39151)	2	51158 D	Take-up Thread Eyelet	1	51242 R	Looper Drive Lever Shaft Bushing, middle
1	51120 N	Presser Foot for 51100 R, S (97)	1	51158 E	Needle Lever Thread Eyelet for 51100 R, S (652 D-8, 22747 A, 43443 Q)	1	51242 S	Looper Drive Lever Shaft Bushing, rear
1	51123 H	Take-up for 51100 R, S (96, 22580 D)	1	51170 E	Needle Thread Take-up Wire for 51100 R, S (20, 22848)	1	51242 Z	Looper Drive Lever Shaft Bushing, front
1	51124 E	Throat Plate for 51100 R, S (22570)	1	51180 H	Throat Plate Support for 51100 R, S (22839)	2	51243 C	Ball Stud Fork (22729)
1	51126 N	Feed Dog, upper, for 51100 R, S (906 A, 907, 22528)	1	51182 J	Oil Reservoir Back Cover for 51100 R, S (22733 B, 22848, 41394 A)	1	51244	Looper Rocker Frame for 51100 R, S (96, 98)
1	51134 J	Washer for 51034	1	51182 K	Top Cover Oil Drip Plate for 51100 R, S (187 A)	1	51244 B	Looper Rocker Shaft Arm (77, 22519 H)
1	51134 J	Washer for 51134 B	1	51183	Hand Lifter Lever for 51100 R, S (402, 22557, 43232 R)	1	51244 L	Thrust Washer for looper rocker shaft
1	51134 L	Upper Feed Bar for 51100 R, S (HA95)	1	51185 D	Stitch Regulating End Cap for 51100 R, S	1	51246	Looper Rocker Stud Nut
			2	51186 E	Stitch Regulator Indicator (22562)	1	51250 A	Bushing for 51015 B
				51192 B	Tension Post Ferrule	1	51250 A	Bushing for 51115 B
						1	51250 D	Washer for 22586 R
						1	51250 E	Needle Lever Stud for 29348 G
						1	51250 E	Needle Lever Stud for 29348 J
						1	51250 F	Gasket for 22586 R
						1	51257 D	Presser Bar Bushing, lower



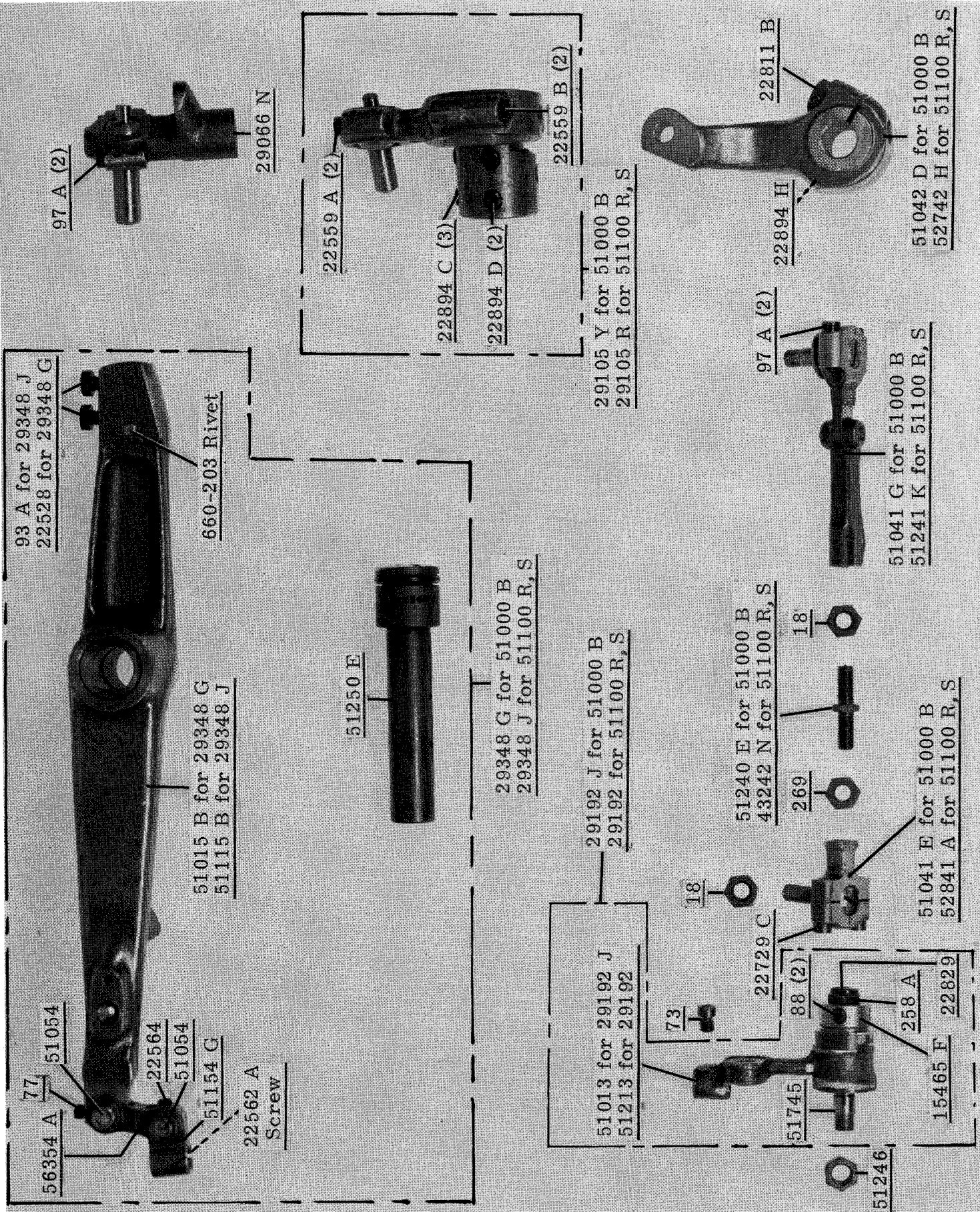
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51282 L	Oil Reservoir Top Cover for 51100 R, S (22524, 22585 A)	1	51493 BP	Oil Pump Driving Gear (531)	1	52888	Presser Bar
1	51282 M	Gasket for 51082 C	1	51493 BQ	Oil Pump Driven Gear (531)	1	52889	Presser Bar Bushing, upper
1	51282 M	Gasket for 51282 L	1	51722	Main Shaft for 51100 R, S	2	52890 C	Main Shaft Bushing, right and inner left, for 51000 B
1	51282 N	Drip Plate for 51282 L (22737)	1	51745	Looper Rocker Cone Stud for 29192 (258 A, 22829, 51246)	2	52890 C	Main Shaft Bushing, left and inner right, for 51100 R, S
1	51282 S	Gasket for 51082 K	1	51745	Looper Rocker Cone Stud for 29192 J (258 A, 22829, 51246)	1	52891 B	Main Shaft Housing, includes bushing (22569 B)
1	51282 S	Gasket for 51182 J	1	51745	Looper Rocker Cone Stud for 29192 J (258 A, 22829, 51246)	4	52894 AB	Oil Tube Holder (90)
2	51282 T	Crankshaft Chamber Cover, upper and rear, for 51000 B (90)	1	51751	Presser Bar Connection for 51100 R, S (22560 B)	1	52921 B	Pulley for 51100 S, (22597, 22597 A)
1	51282 U	Gasket for 51282 T	1	51751	Presser Bar Connection for 51100 R, S (22560 B)	2	52936	Feed Rocker Shaft Bushing
1	B51282 W	Top Cover for 51100 R, S (22849, 35768 A)	1	51758	Frame Needle Thread Eyelet (20, 22848)	1	52944 G	Spacing Collar for looper rocker shaft, for 51100 R, S (88 B)
1	51290 T	Main Shaft Bushing, middle	1	52742 H	Looper Drive Lever for 51100 R, S (22811 B, 22894 H)	1	52944 T	Looper Rocker Shaft Bushing, right, for 51000 B
2	51292	Tension Post	1	52742 K	Looper Drive Lever Rocker for 51100 R, S (18, 22852 A)	1	52944 T	Looper Rocker Shaft Bushing, left, for 51100 R, S
2	51292 C	Tension Nut	1	52841 A	Looper Connecting Rod Ball Joint, left for 51100 R, S (18, 22729 C)	1	52944 U	Looper Rocker Shaft Bushing, left, for 51000 B
1	51292 F-2	Tension Spring, looper thread	1	52841 G	Locking Stud for 51000 B (51242 M, 52841 H)	1	52944 U	Looper Rocker Shaft Bushing, right, for 51100 R, S
1	51292 F-8	Tension Spring, needle thread	1	52841 G	Locking Stud for 51100 R, S (51242 M, 52841 J)	1	54244 L	Thrust Washer for looper rocker shaft
1	51293 U	Oil Tube for feed lift eccentric, for 51100 R, S	1	52841 H	Nut for 52841 G, for 51000 B	2	55235 D	Screw for 51035 A
1	51493 A	Oil Pump Housing Cover	1	52841 J	Nut for 52841 G, for 51100 R, S	2	55235 D	Screw for 51135 P
1	51493 D	Oil Pump Driving Shaft	1	52882 E	Gasket for 51082 G	2	55235 E	Nut for 51035 A
2	51493 E	Oil Pump Driving Shaft Gear	1	52882 E	Gasket for 51282 W	2	55235 E	Nut for 51135 P
1	51493 F	Oil Pump Housing, Tube and Filter Cap Assembly, for 51100 R, S (22569 B, 22569 G)	1	52882 U	Gasket for 51282 X, for 51100 R, S	1	56334 E	Feed Dog Holder for 51034
1	51493 S	Oil Filter Cap Strainer for 51093 P	1	52882 AE	Crankshaft Chamber Cover, rear for 51100 R, S (22548)	1	56334 E	Feed Dog Holder for 51134 X
1	51493 S	Oil Filter Cap Strainer for 51493 F	1	52887	Presser Spring	1	56341 G	Spring for 51041 G
1	51493 AB	Gasket for 51493 AR	1	52887 G	Presser Spring Rest	1	56341 G	Spring for 51241 K
1	51493 AR	Filter Cup Assembly	1	52887 N	Presser Spring Regulating Stud (1280, 35733 B)	1	56354 A	Needle Bar Link for 29348 G
1	51493 AS	Felt Filter for 51493 AR	1			1	56354 A	Needle Bar Link for 29348 J
						1	56390 E	Crankshaft Bearing Housing Gasket
						2	92127	Screw for 51035
						2	92127	Screw for 51135 N

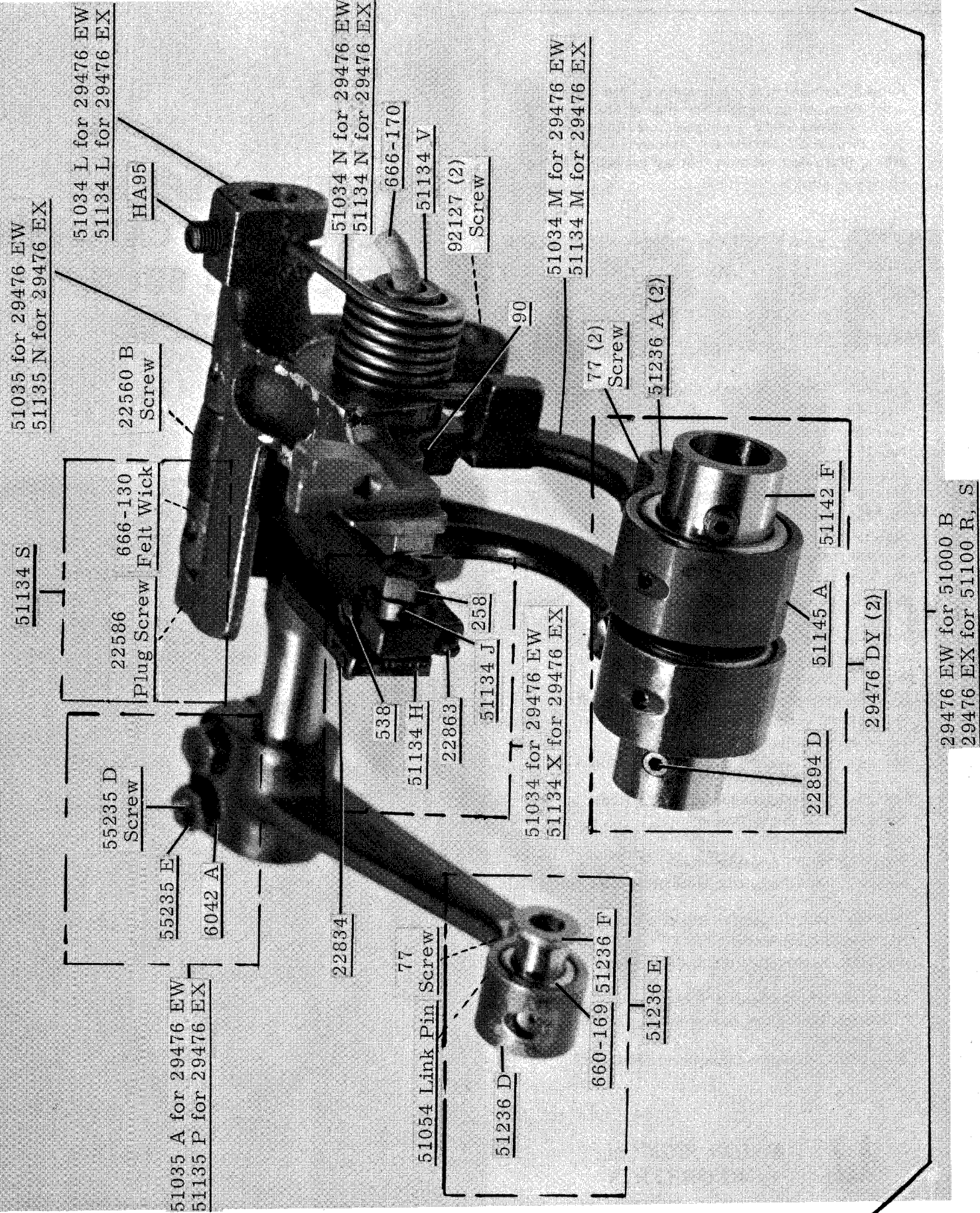
NOTE: Numbers in parentheses following parts' description indicate the screws, nuts, etc. used to attach or hold these parts.







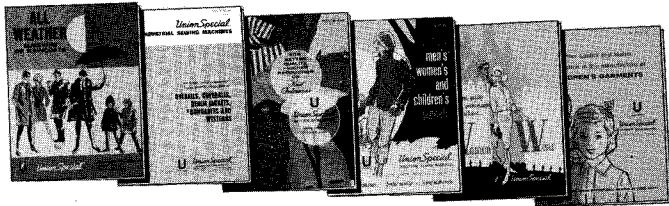




29476 EW for 51000 B  
29476 EX for 51100 R, S

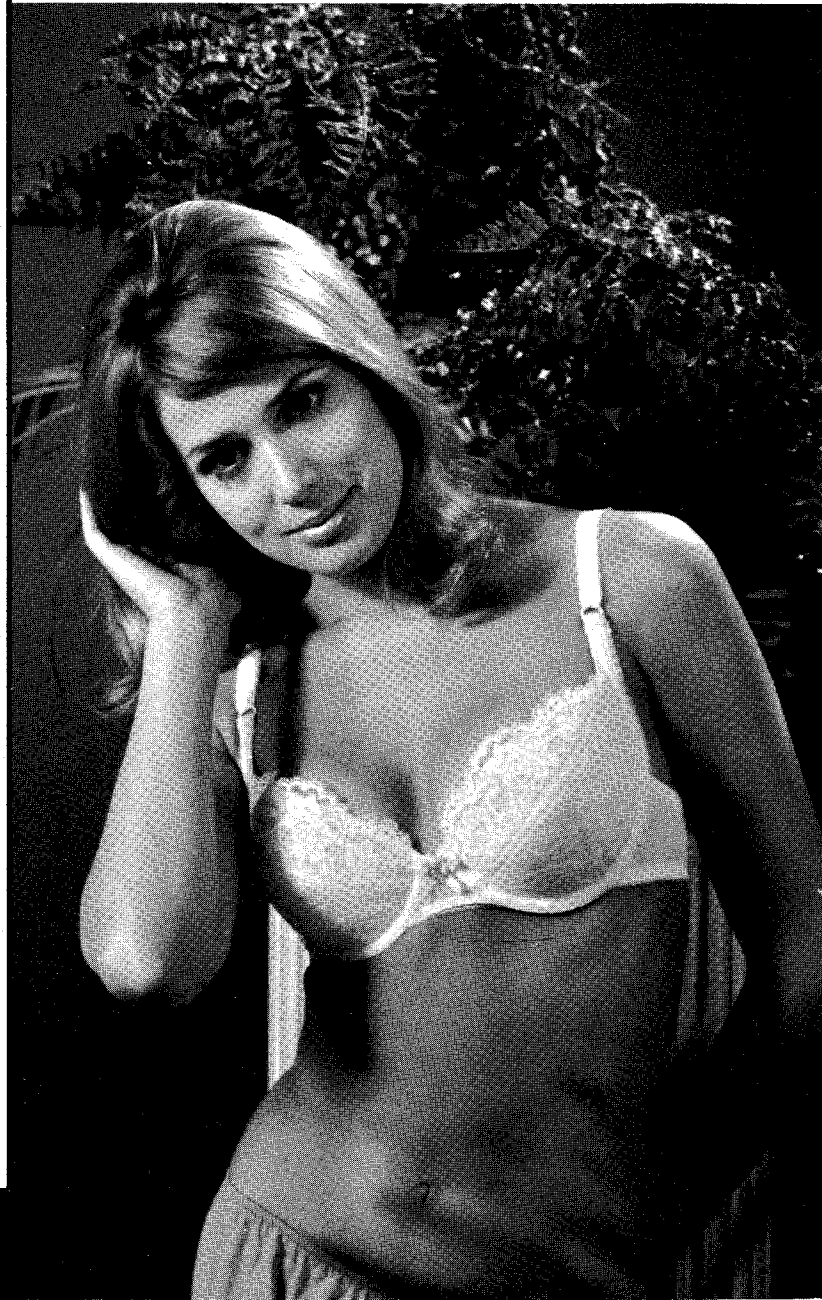


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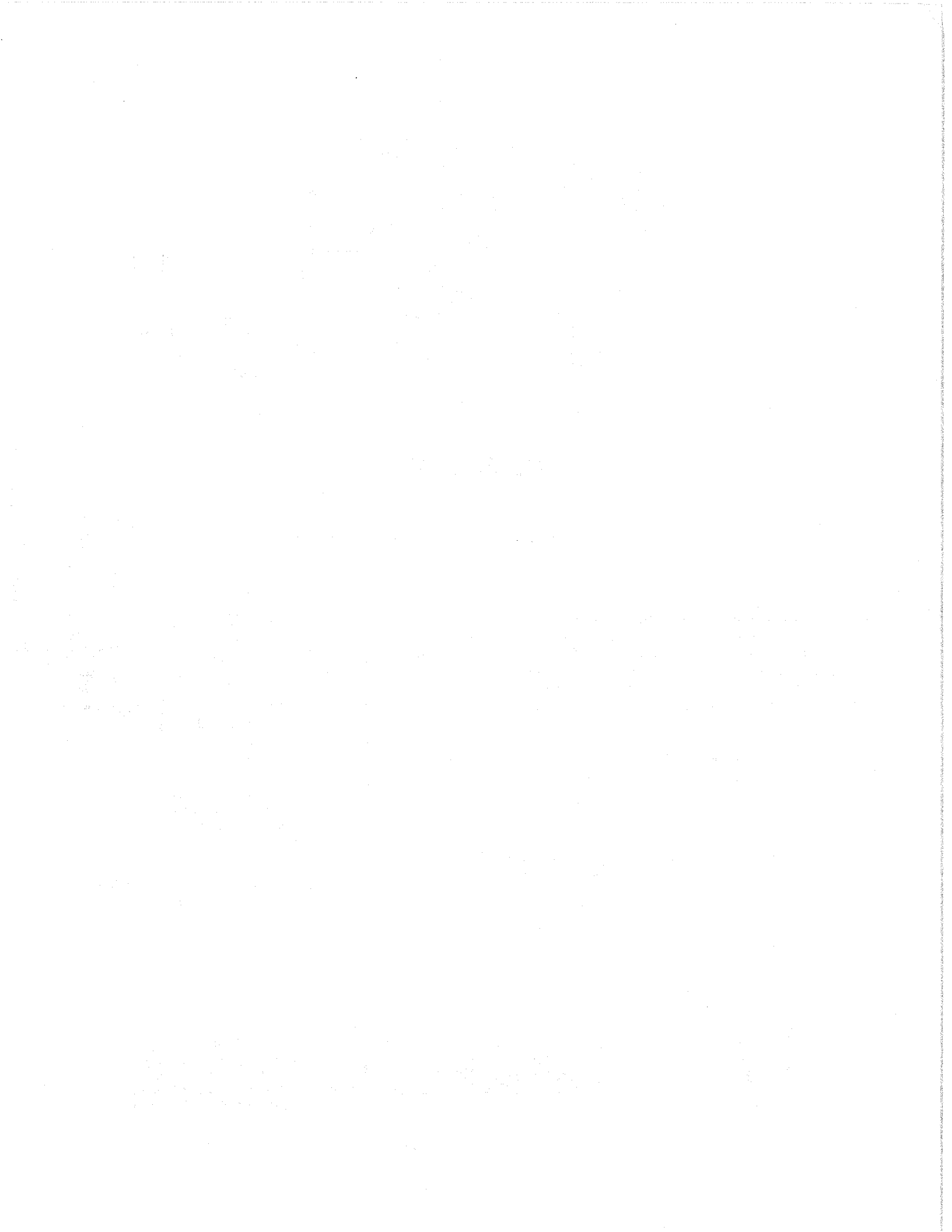


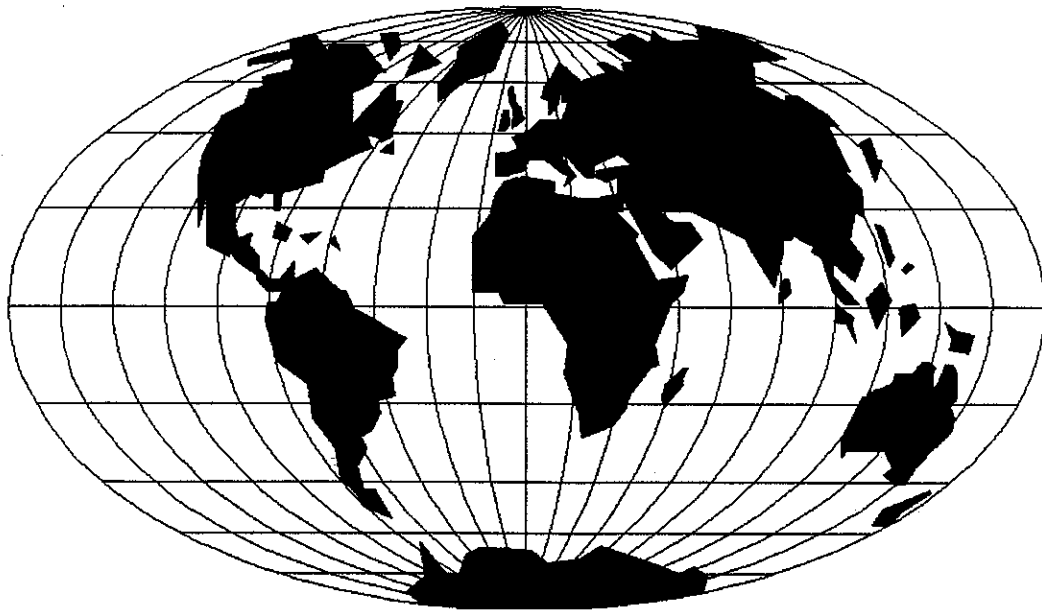
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- No. 251, "Service Shirts and Pants"
- No. 252, "Men's Shorts and Pajamas"
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