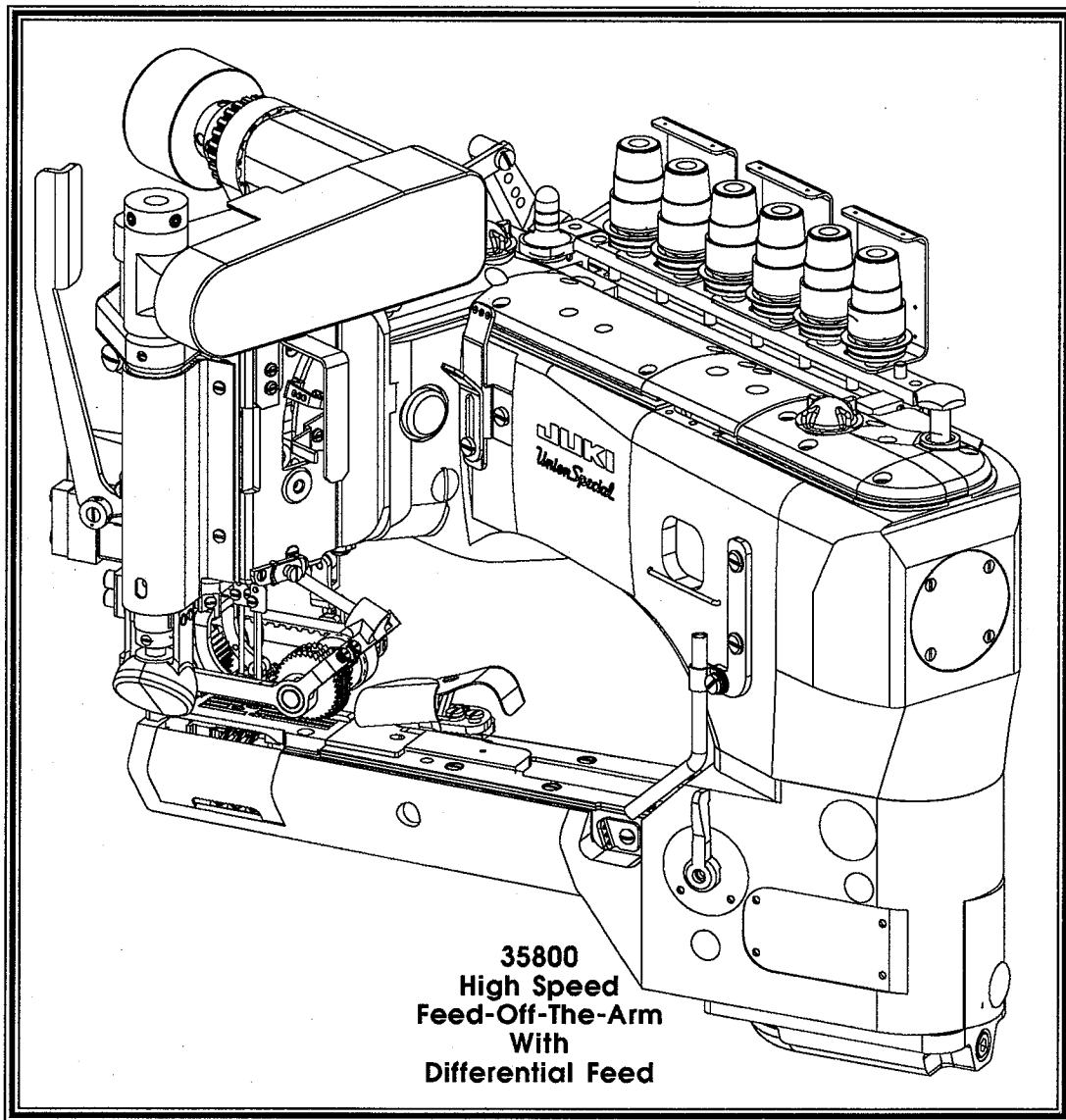




Union Special

INDUSTRIAL SEWING EQUIPMENT

OPERATOR'S / ILLUSTRATED PARTS MANUAL



MANUAL NO. PT9629

STYLES

**35800FPP
35800FP**

Manual No. PT9629 Operator's & Illustrated Parts Manual Supplement to Manual PT9640

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By

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Printed in U.S.A.

APPLICATION OF MANUALS

This parts manual has been prepared to assist you in locating individual parts or assemblies on machines.

It is the desire of Union Special that each machine run at its optimum performance. Parts listed in this manual are designed specifically for your machine and are manufactured with utmost precision to assure long lasting service.

IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine is identified by a style number, which is stamped into the style plate affixed to the middle of the machine under the tension assembly. The serial number is stamped into the serial number plate affixed to the right rear base of the machine.

This manual has been arranged to simplify ordering repair parts. Exploded views of 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 a listing of the parts with their part numbers, description and the number of pieces required in the particular view being shown.

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

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. As an example refer to the following text.

| | | | |
|----|---------|---|---|
| 5. | 29126EC | Upper Looper Drive Shaft Assembly | 1 |
| 6. | 22503F | Screw | 1 |
| 7. | 39543E | Cam Follower Locking Clamp | 1 |

When a part is common to all machines covered in this manual, 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 description and, if necessary, the difference will be shown in the illustration.

*Ref. No. showing no Part No. is for location only. Part is not for sale separately.

A numerical index of all the parts shown in this manual is located at the back. This will facilitate locating the illustration and description when only a part number is known.



IDENTIFYING PARTS

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

PLEASE NOTE: Part numbers represent the same part, regardless of which manual they appear. On all orders please include part number, name and style of machine for which the part was ordered.

For optimum performance use only genuine Union Special replacement parts.

CLASS DESCRIPTION

High speed, Feed-off-the-arm high throw machines, three needle, left needle in front. Light weight presser bar mechanism. Presser and roller bars are equipped with double acting air cylinders, air is used to supply down pressure and lift foot and roller assemblies for style 35800FPP. Adjustable looper avoid, double disc looper thread take-up, automatic enclosed type oiling system and filter type oil pump, visual sight oil action and supply gauges, .529 (17/32, 13.4mm) wide rear roller.

STYLE OF MACHINES

35800FPP **DOUBLE LAP SEAM.** Three needle, high capacity, differential feed, high lift feed eccentric, with upper driven. Rear roller located behind needles and upper driven front roller located in front of needles. - Typical Application - For in and out seaming on heavy weight denim garments. Seam specifications 401 LSc-2 or LSc-3. Standard gauge 9 (9/64, 3.6mm). Recommended needle 130GS, size 140/054. Maximum recommended speed 4500 R.P.M.. .094 step sewing parts.

35800FP **DOUBLE LAP SEAM.** Same as 35800FPP except without air.

NEEDLES

Each needle has both a type and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes the largest diameter of the blade measured between the shank and the eye. Collectively, the type number and size number represent the complete symbol which is given on the label of all needles packed and sold by Union Special.

TYPE

DESCRIPTION

130 GS Short, double groove, struck groove, ball eye, spotted, government point, chromium plated.
- Sizes available 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060.

When changing the needle, make sure it is fully inserted in the needle holder before the screw is tightened.

When ordering needles, please use the complete type and size numbers as printed on the package to ensure prompt and accurate processing of your order. A complete order should read as follows: "100 needles, type 130 GS, size 125/049".



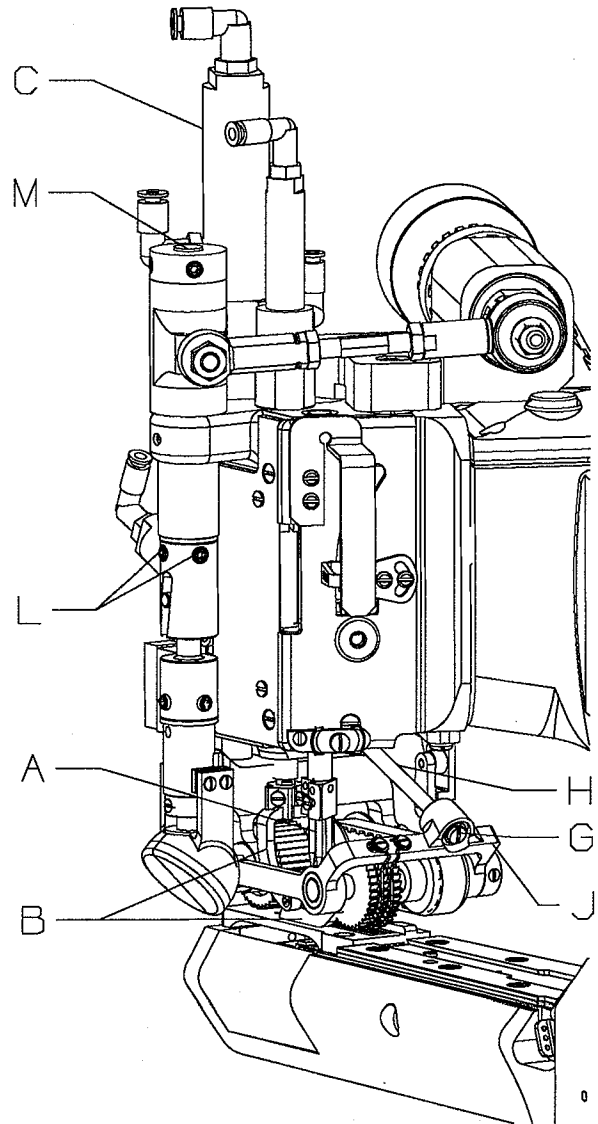
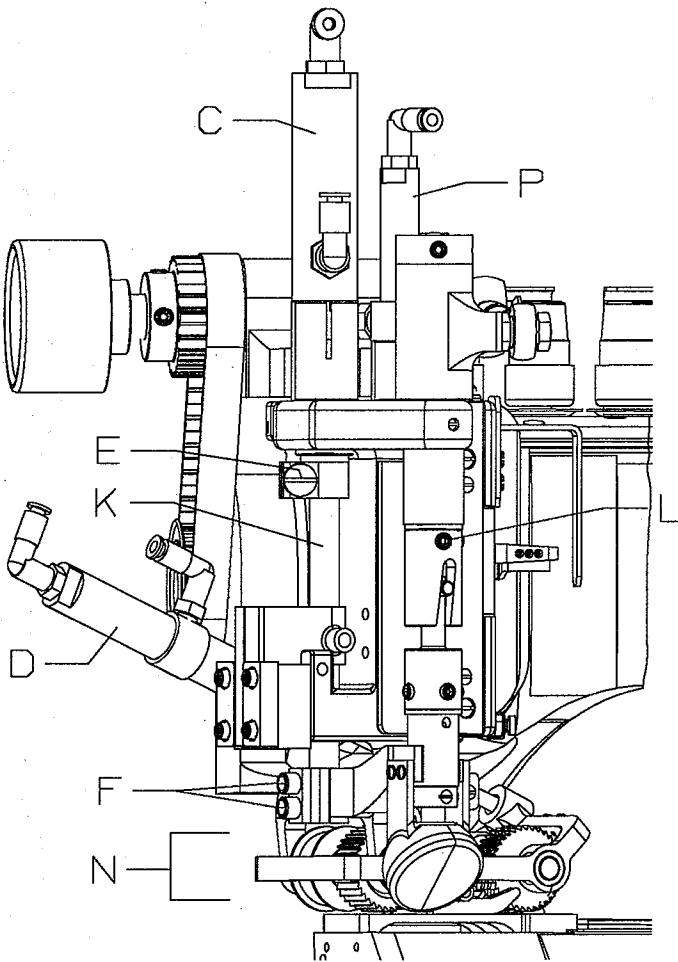
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FEED ROLLER MECHANISM REMOVAL

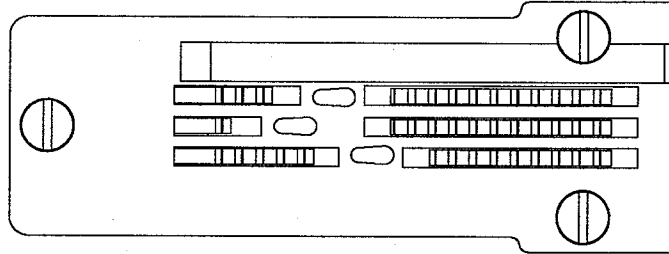
1. Remove needles (A)
2. Shut off air pressure to cylinder (C)
3. Shut off air pressure to cylinder (D)
4. Shut off air pressure to cylinder (P)
5. Remove presser foot & presser foot yoke (B)
6. Loosen screw (E)
7. Loosen two screws (F)
8. Remove screw (G) and washers (steel & rubber)
- *9. Slide cylinder shaft (H) out of roller bracket (J)
10. Raise cylinder puller shaft (K) up and out of bracket
11. Loosen upper coupling screws (L)
12. Remove drive puller shaft (M)
13. Remove entire mechanism (N)



* SEE CAT. PT9640 FOR INSTRUCTIONS

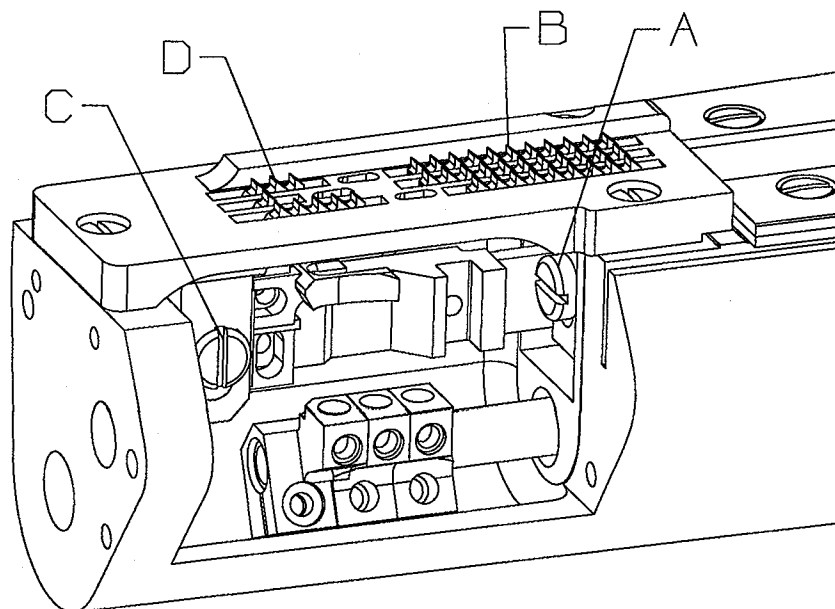
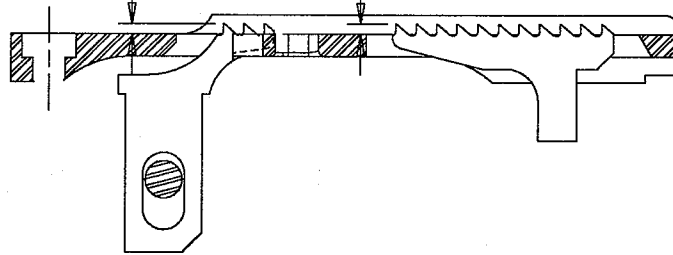
ADJUSTING FEED DOGS

1. To adjust feed dogs set needles at top of stroke.
2. Loosen screw (A) and move differential feed dog (B) up or down, so that top of feed dog is one full tooth above throat plate.
3. Retighten screw (A).
4. Loosen screw (C) and move main feed dog (D) up or down, so that top of feed dog is one full tooth above throat plate.
5. Retighten screw (C).



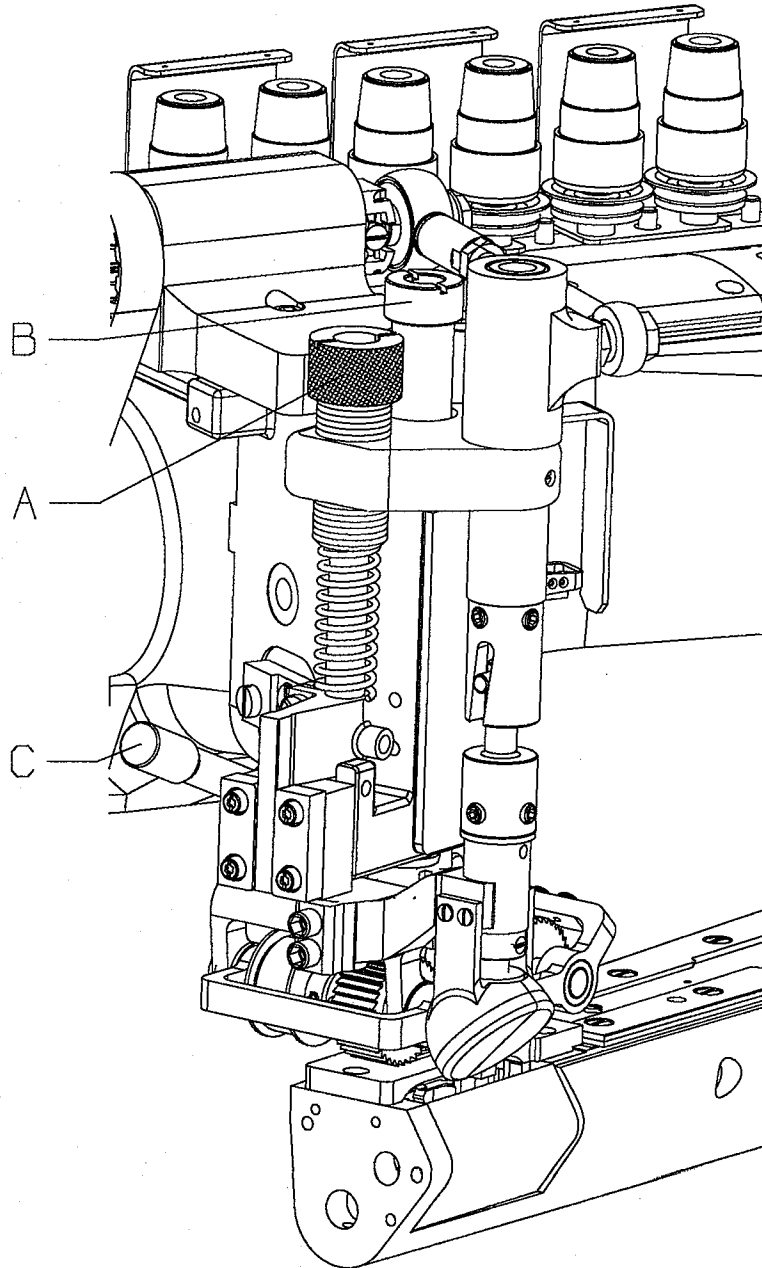
FULL TOOTH ABOVE THROAT PLATE

ONE TOOTH ABOVE THROAT PLATE



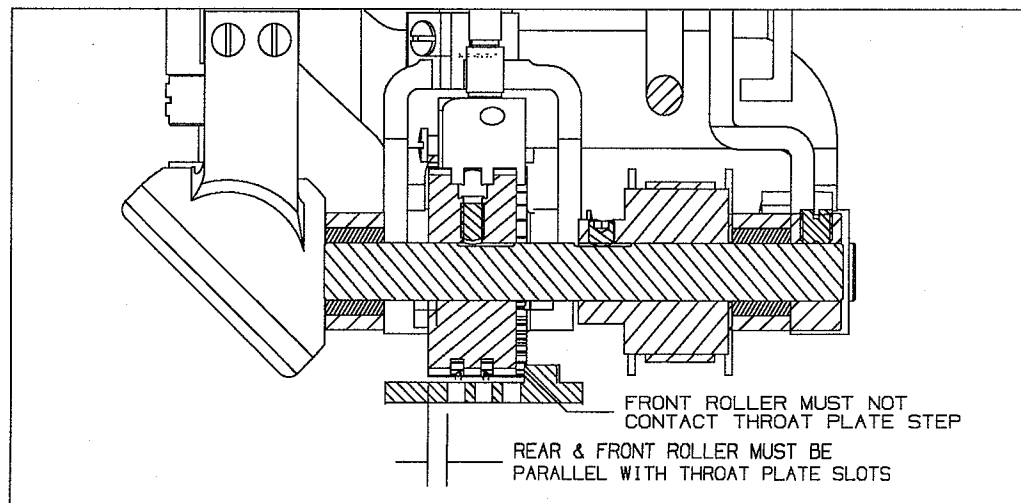
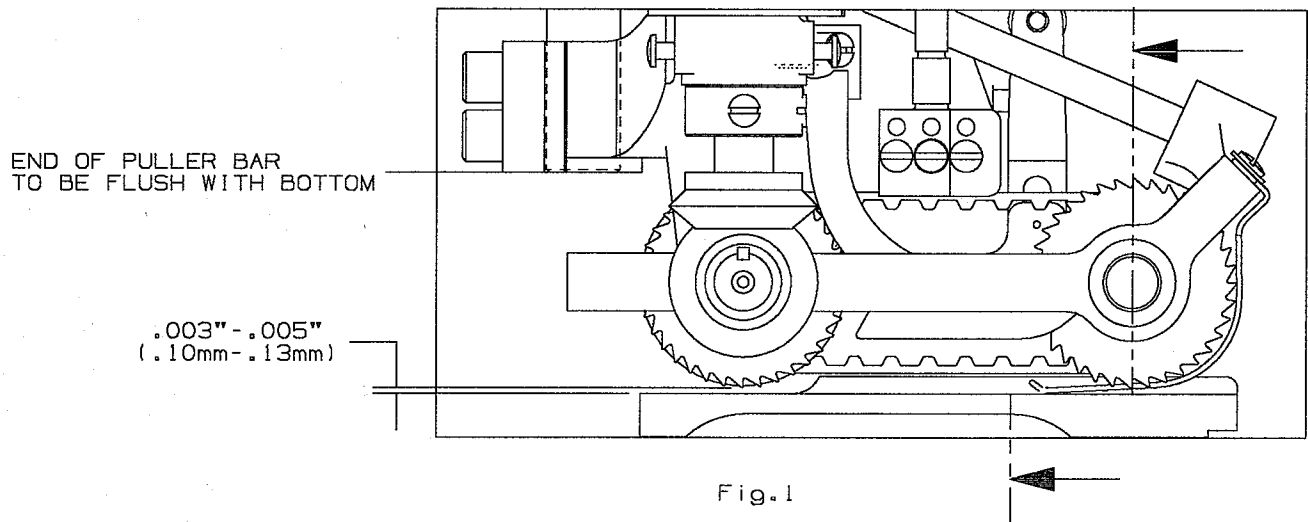
SETTING PRESSURE FOR FEED ROLLER AND PRESSER FOOT (ON NON PNEUMATIC MACHINES)

1. Regulate the pressure on the feed roller and presser foot so that it exerts only enough pressure on the fabric to feed the work uniformly.
2. Turning roller presser spring regulator knob (A) clockwise to increase or counterclockwise to decrease the pressure.
3. Turning presser foot spring regulator knob (B) clockwise to increase or counterclockwise to decrease the pressure.
4. Turning front roller spring regulator knob (C) clockwise to increase or counterclockwise to decrease the pressure.



ALIGNING AND ADJUSTING ROLLER MECHANISM

1. When feed roller mechanism (C, Fig. 3) has been removed or replaced, .003" (0.10mm) minimum to .005" (0.13mm) maximum clearance should be maintained between rear roller and throat plate, see (Fig. 1).
2. Rear roller and front roller must be parallel to slots on throat plate, see (Fig. 2).
3. Guide plates (F, Fig. 3) must be thrust against guide finger (B, Fig. 3) to secure feed roller mechanism (C, Fig. 3).



ALIGNING AND ADJUSTING ROLLER MECHANISM (CONT.)

1. Loosen two screws (A, Fig. 3). Using shim(s) adjust feed roller mechanism (C, Fig. 3) so that the rear roller is .003" (0.08mm) to .005" (0.13mm) above throat plate. Slide rear guide finger (B, Fig. 3) down so that it sits on top of rear guide support block (D, Fig. 3). Check to make sure rear and front rollers are parallel to throat plate slots. Tighten two screws (A, Fig. 3) to secure feed roller mechanism in place.
2. Thrust guide plates (F, Fig. 3) against guide finger (B, Fig. 3) with equal pressure. Tighten four screws (E, Fig. 3) to hold plates in place.

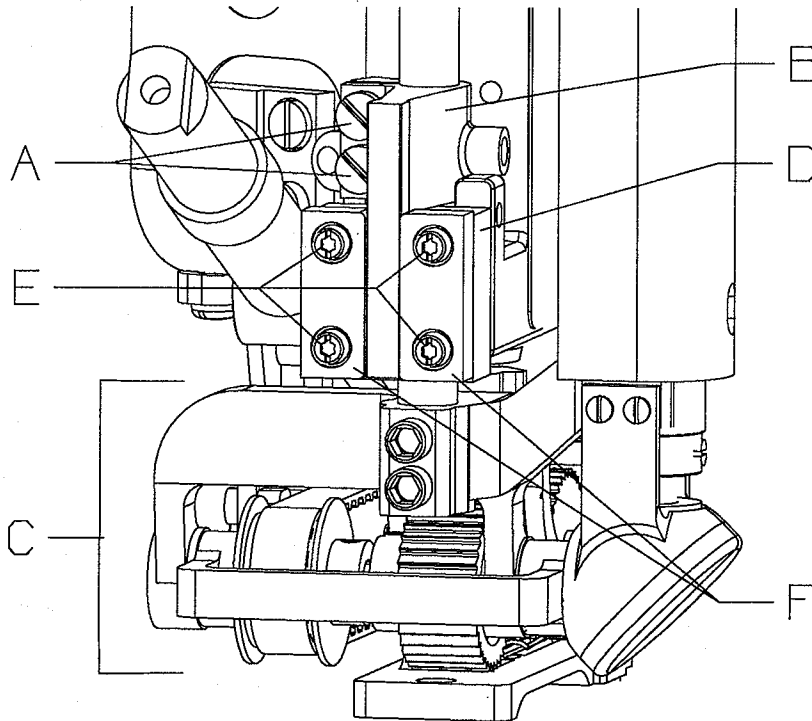


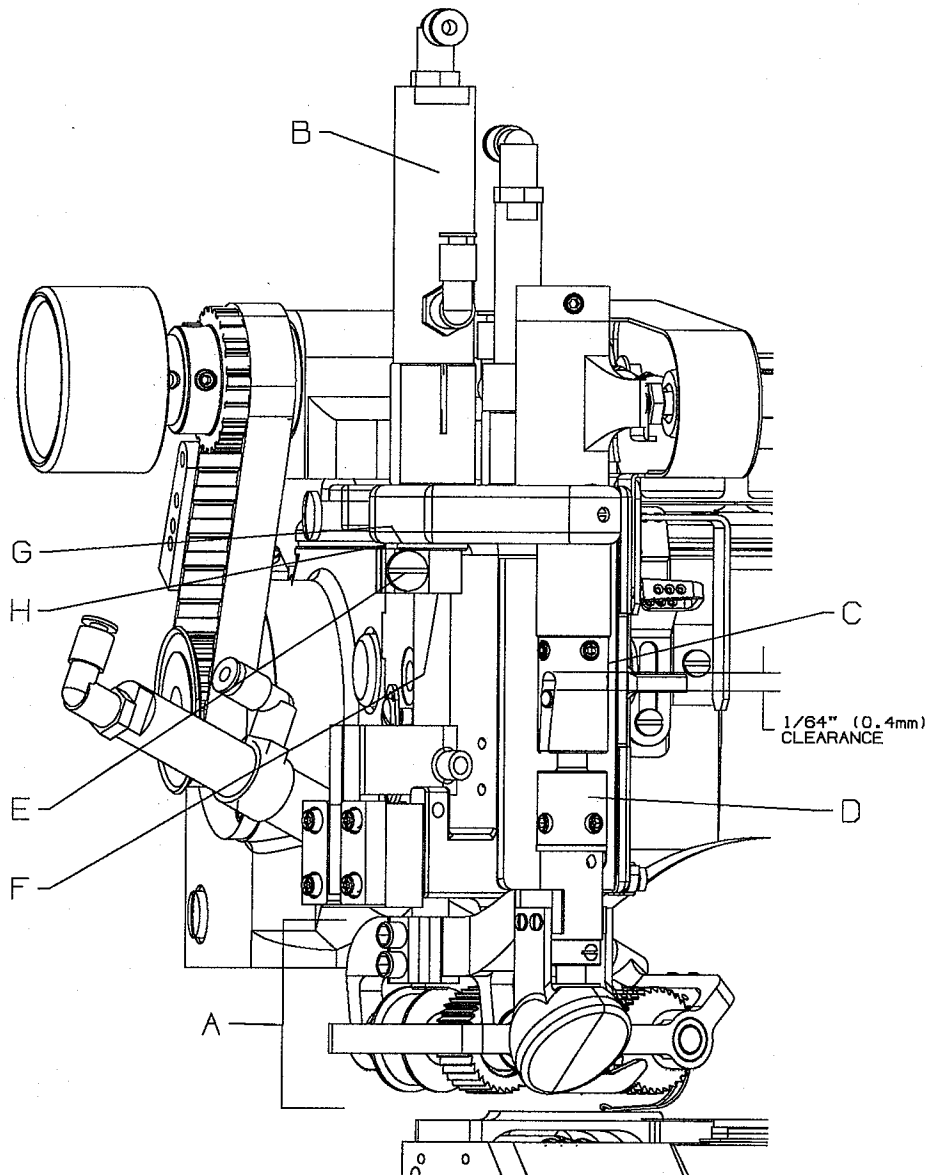
Fig.3

ADJUSTING STOP COLLAR ON FEED ROLLER FOR PNEUMATIC ROLLER IN FRONT OF NEEDLE MACHINES

(PNEUMATIC MACHINES ONLY)

When feed roller mechanism (A) and/or puller shaft cylinder assembly (B) has been removed or replaced, 1/64" (0.4mm) clearance should be maintained between upper connection (C) and lower feed roller connection (D) when feed roller mechanism is in up position.

Turn off air supply to puller shaft air cylinder assembly (B). Loosen screw (E). Lift feed roller mechanism (A) until there is 1/64" (0.4mm) clearance between upper connection (C) and lower feed roller connection (D). Slide roller stop collar (F) and rubber washer (H) up until they contact the underside of head assembly (G). Retighten screw (E).



SETTING PRESSER BAR STOP COLLAR

(PNEUMATIC MACHINES ONLY)

When presser bar air assembly (A, Fig. 2) and/or presser bar (B, Fig. 2) has been removed or replaced, presser bar stop collar (F, Fig. 2) must be reset. Stop collar must be set so that there is a minimum of $1/32$ " (0.8mm) clearance between top of presser foot (C) and needle bar head (D). The clearance setting must be done with needle bar at bottom of stroke.

Turn air supply off to presser foot air cylinder assembly (A). Loosen screw (E) on presser foot stop collar (F). Turn handwheel (G) until needle bar (D, Fig. 1) is at bottom of stroke. Lift presser foot (C, Fig. 1) up until there is $1/32$ " (0.8mm) clearance between needle bar (D, Fig. 1) and rubber washer (H) up until they contact underside of head. Retighten screw (E).

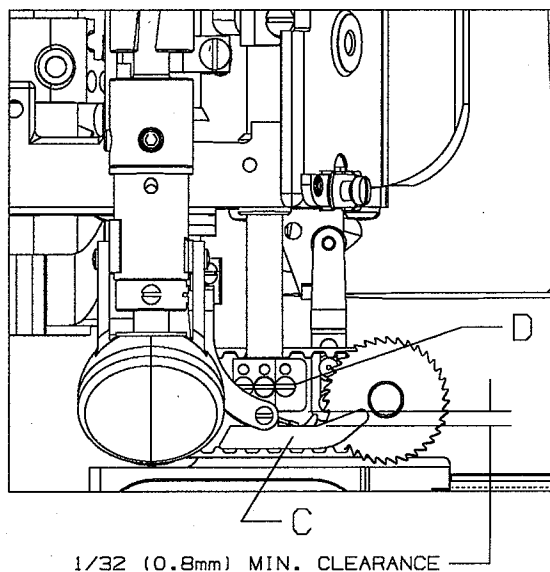


Fig. 1

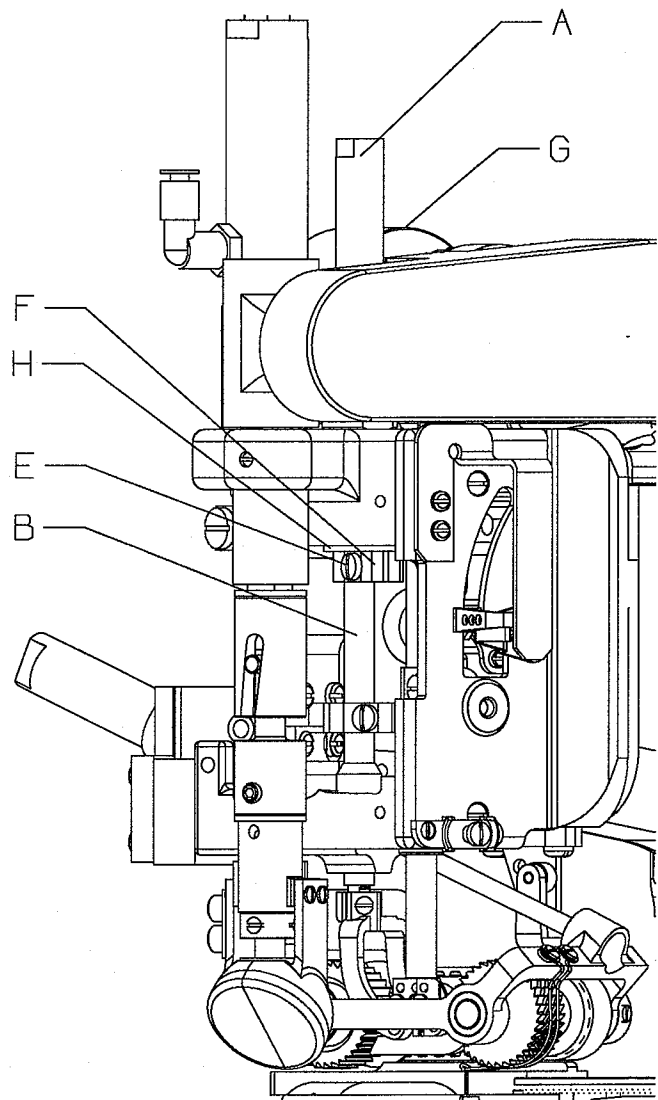


Fig. 2

FOLDER ADJUSTMENT

The suggested distance between the folder (A, Fig. 1) and the front roller (B, Fig. 1) is $3/16"$ (4.76mm) minimum or as needed depending on material thickness and/or application.

Slide folder (A, Fig. 1) until it contacts extension plate (C, Fig. 1). Adjust scroll support (D, Fig. 3) so there is a minimum of $3/16"$ (4.76mm) space between front roller (B, Fig. 1) and folder (A, Fig. 1).

To adjust scroll support (D, Fig. 3), remove scroll support screws (E, Fig. 3) and position scroll support (D, Fig. 3) in desired location. Replace screws (E, Fig. 3) in corresponding holes and retighten.

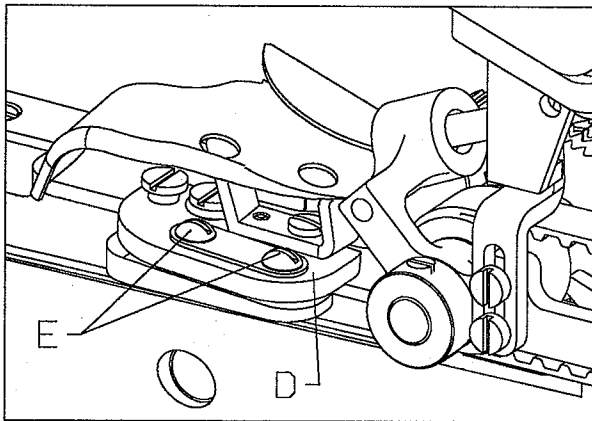


Fig. 3

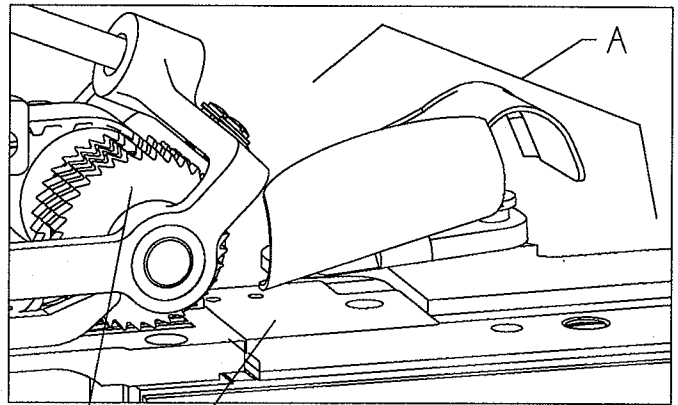


Fig. 1

$3/16"$ (4.76mm) minimum or as needed
depending on material thickness

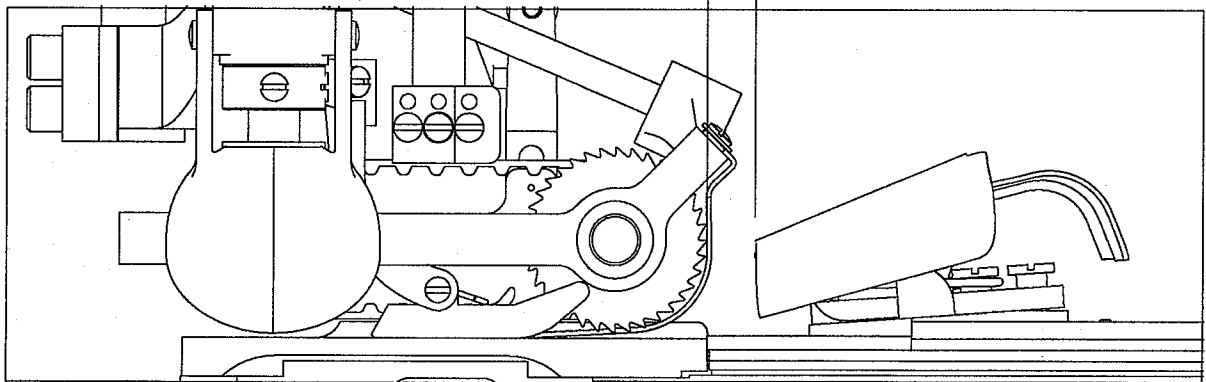


Fig. 2

PNEUMATIC SETTINGS AND HOOK UP

Pneumatic settings can vary between different sewing applications. For best results set all air lines and air pressure settings as in (Fig. 1a).

Air pressure settings should be set with air regulators as is shown in (Fig. 1a).

If air lines are disconnected follow connection as in (Fig. 1).

Air lines should be attached with each end of line to corresponding letter see (Fig. 1).

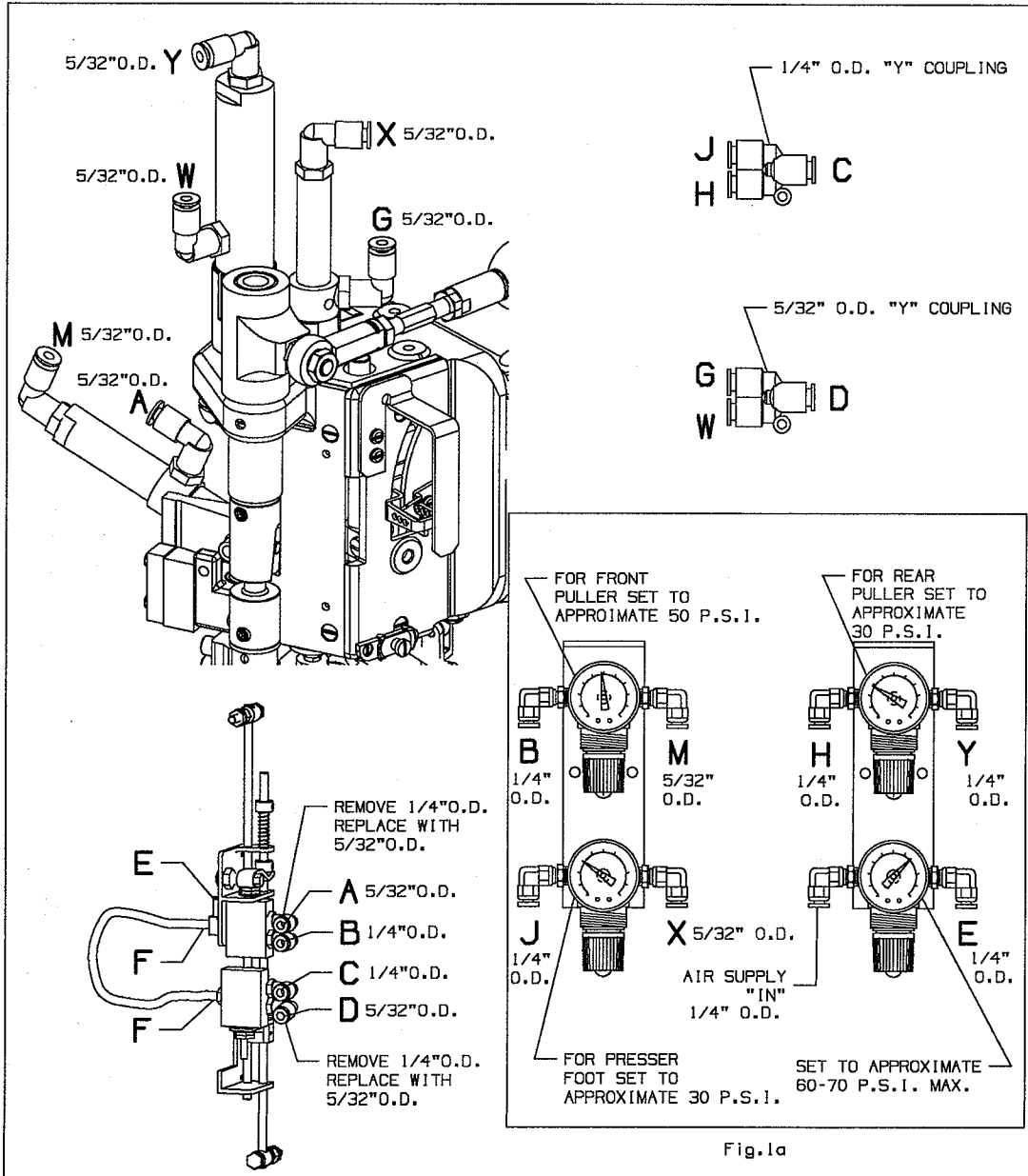
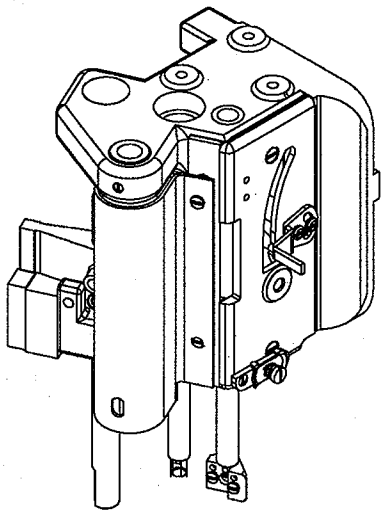
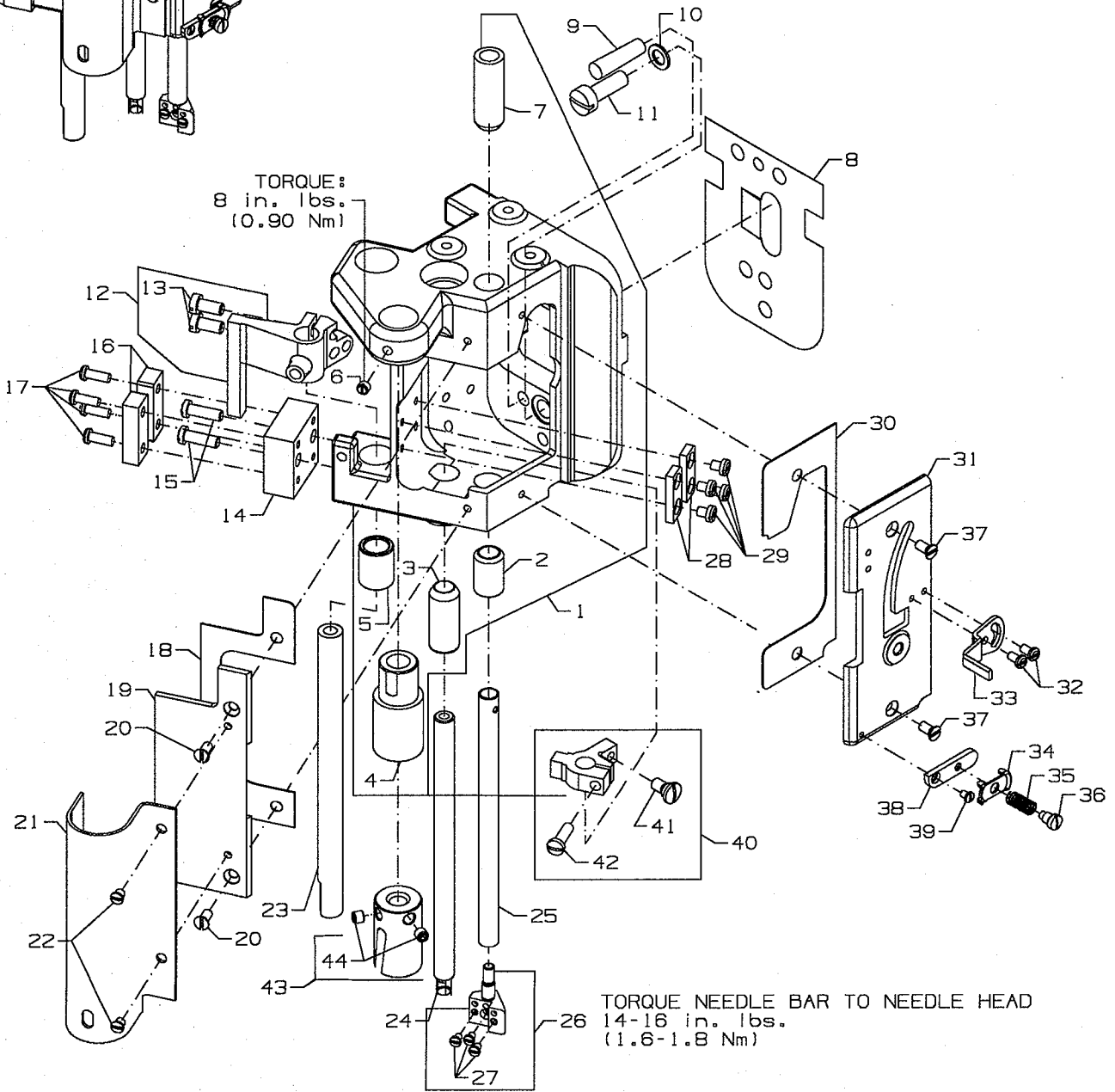


Fig.1





TORQUE:
8 in. lbs.
(0.90 Nm)



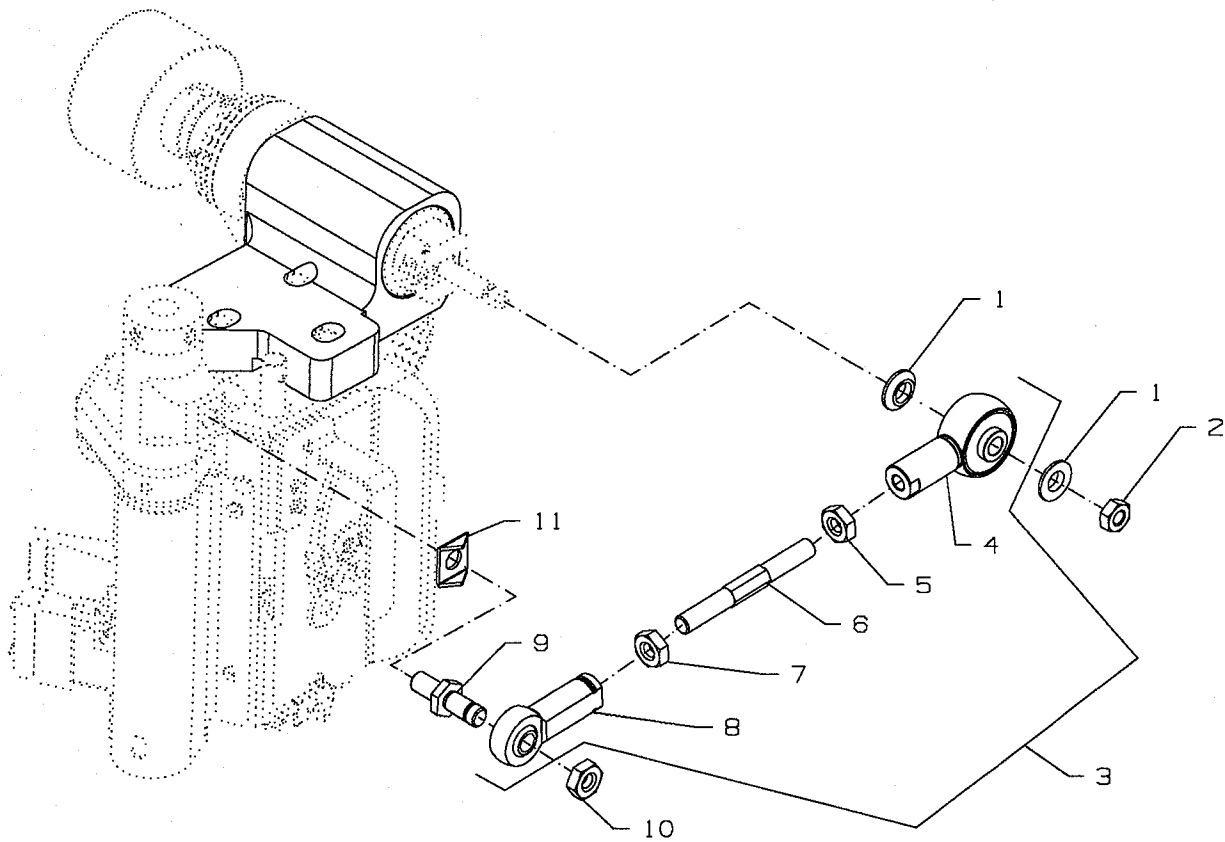
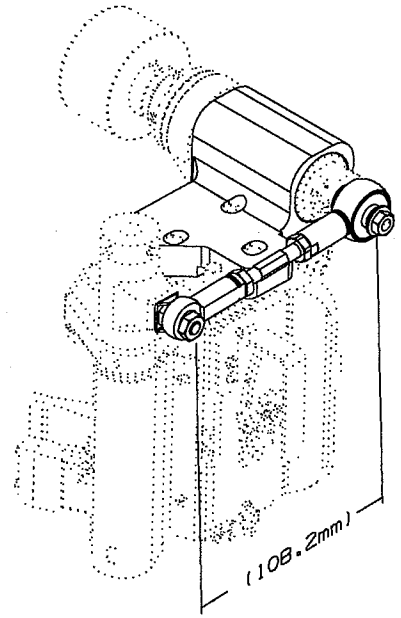
TORQUE NEEDLE BAR TO NEEDLE HEAD
14-16 in. lbs.
(1.6-1.8 Nm)



DETACHABLE HEAD ASSEMBLY

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-------------|-------------------------------------|--------------|
| 1. | 35829AN | Detachable Head Assembly | 1 |
| 2. | 35854B | Bushing | 1 |
| 3. | 35844N | Bushing | 1 |
| 4. | 35877AD | Bearing Sleeve Assembly | 1 |
| 5. | 35844T | Bushing | 1 |
| 6. | SS8120410SP | Set screw | 1 |
| 7. | 35854A | Bushing | 1 |
| 8. | 35889G | Plate, baffle | 1 |
| 9. | 664F-16 | Pin, taper | 1 |
| 10. | 6042A | Washer | 1 |
| 11. | 318 | Screw | 1 |
| 12. | 35837P | Guide finger, rear | 1 |
| 13. | SS6121010SP | Screw | 2 |
| 14. | 35838B | Block, support, rear guide | 1 |
| 15. | SS7121410TP | Screw | 2 |
| 16. | 35838A | Plate, guide, roller bar | 2 |
| 17. | SS4091015SP | Screw | 4 |
| 18. | 35884S | Gasket | 1 |
| 19. | 35882J | Cover, head, left | 1 |
| 20. | 22524 | Screw | 2 |
| 21. | 35882H | Cover | 1 |
| 22. | 22564B | Screw | 2 |
| 23. | 35877AL | Roller Presser Bar | 1 |
| 24. | 35822AE | Presser Bar | 1 |
| 25. | 35817S | Needle Bar | 1 |
| 26. | 35818CB-9 | Needle Head | 1 |
| 27. | 605 | Screw | 3 |
| 28. | 35731A | Plate, guide, presser bar | 2 |
| 29. | 22513D | Screw | 4 |
| 30. | 35884T | Gasket | 1 |
| 31. | 35882K | Cover, head, front | 1 |
| 32. | 22768 | Screw | 2 |
| 33. | 35870 | Take-up, needle thread | 1 |
| 34. | 57WB | Nipper Plate, needle thread | 1 |
| 35. | 15438C | Spring | 1 |
| 36. | 57WD | Screw | 1 |
| 37. | 22524 | Screw | 2 |
| 38. | 43296 | Needle Thread Nipper Base | 1 |
| 39. | 605 | Screw | 1 |
| 40. | 35843D | Presser Bar Lift Clamp | 1 |
| 41. | SD0640241SP | Screw | 1 |
| 42. | SS7111410TP | Screw | 1 |
| 43. | 35876AU | Connection, upper feed roller | 1 |
| 44. | 22894W | Screw | 2 |

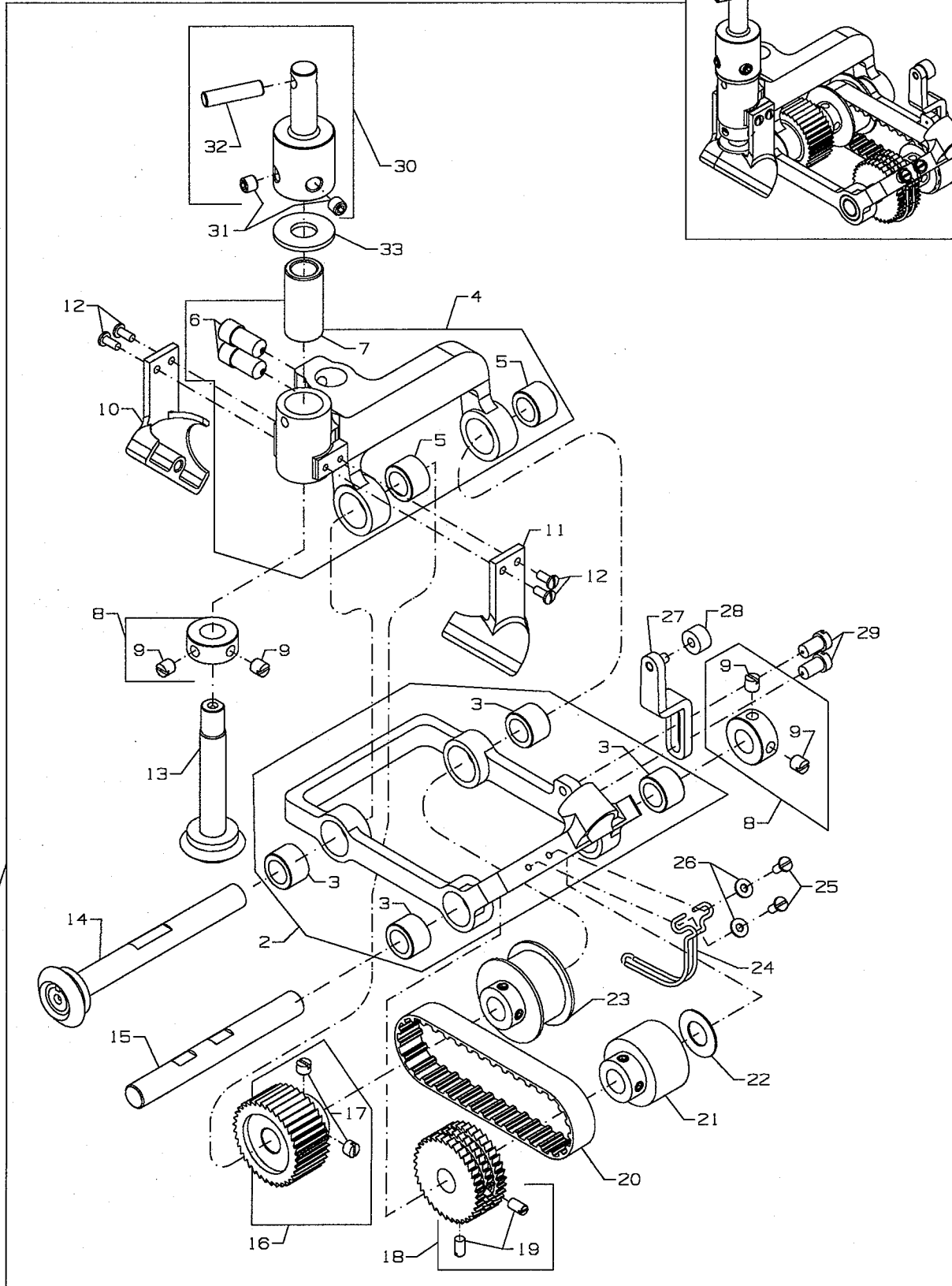




CONNECTING ROD ASSEMBLY

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|----------|-------------------------------|--------------|
| 1. | 99622A | Washer | 2 |
| 2. | 18 | Nut | 1 |
| 3. | 29478EM | Connecting Rod Assembly | 1 |
| 4. | 35844X | Bearing, rod end | 1 |
| 5. | 35887AK | Nut | 1 |
| 6. | 35845E | Connecting Rod | 1 |
| 7. | 35887AJ | Nut | 1 |
| 8. | 35844W | Rod End Bearing | 1 |
| 9. | 35837X | Stud | 1 |
| 10. | 35887AK | Nut | 1 |
| 11. | 35837W | Guide, Bearing | 1 |

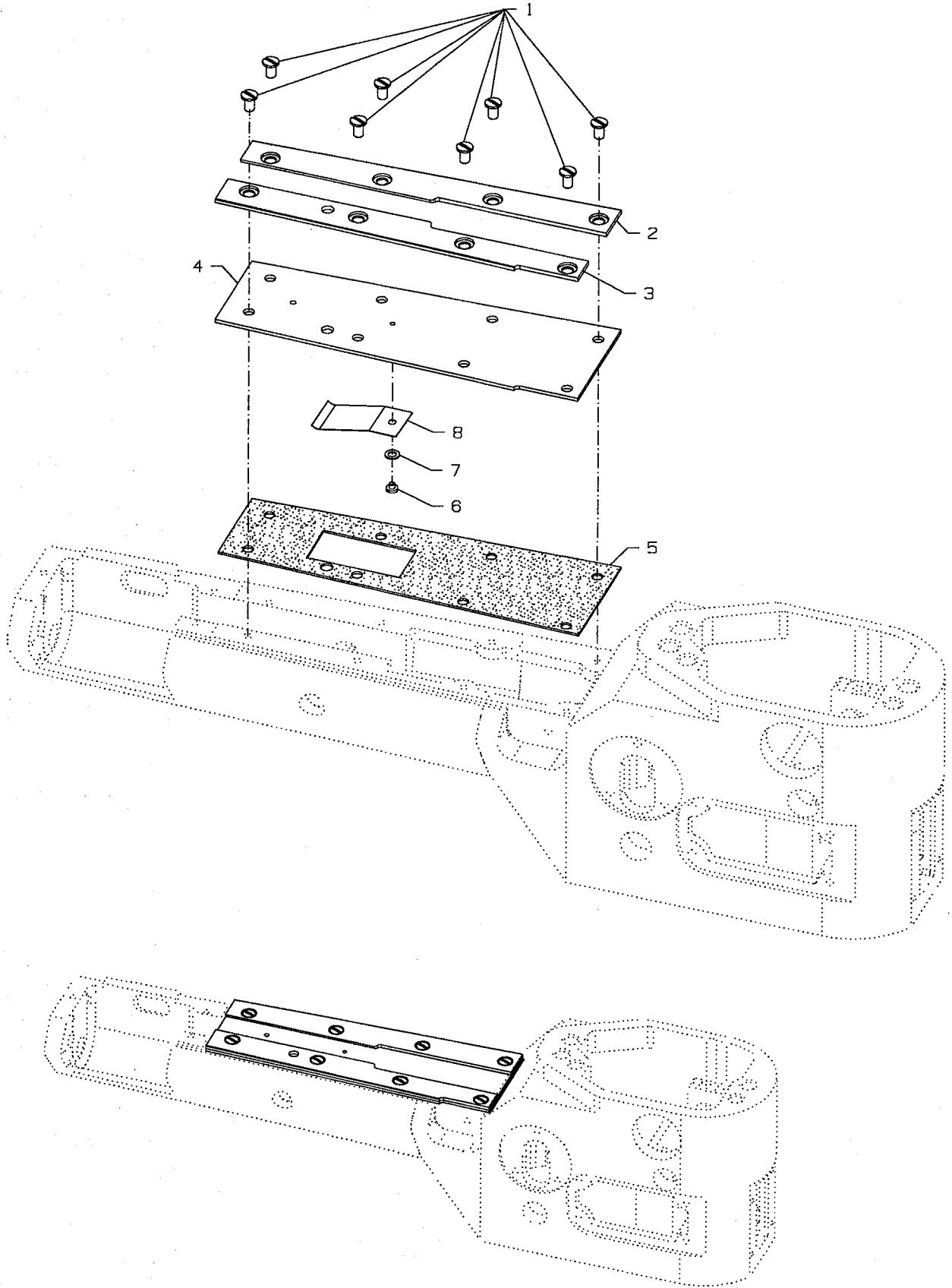




FEED ROLLER ASSEMBLY

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-------------|-------------------------------------|--------------|
| 1. | 29105BG | Feed Roller Assembly | 1 |
| 2. | 35883AD | Roller Frame | 1 |
| 3. | 35844M | Bearing | 4 |
| 4. | 35883AG | Roller Yoke | 1 |
| 5. | 35844M | Bearing | 2 |
| 6. | SS6151142TP | Screw | 1 |
| 7. | 35844U | Bushing | 3 |
| 8. | 35883L | Thrust Collar | 2 |
| 9. | SS8110520TP | Set Screw | 4 |
| 10. | 35882D | Gear Cover | 1 |
| 11. | 35882C | Gear Cover | 1 |
| 12. | SS7060610SP | Screw | 4 |
| 13. | 35839D | Driver Miter Gear | 1 |
| 14. | 35839E | Driven Miter Gear | 1 |
| 15. | 35877AK | Shaft, front roller | 1 |
| 16. | 35876AR | Roller, rear | 1 |
| 17. | SS8110410TP | Set Screw | 2 |
| 18. | 35876AS | Roller, front | 1 |
| 19. | SS8080610SP | Set Screw | 2 |
| 20. | 35842N | Belt | 1 |
| 21. | 35876AN | Pulley, front | 1 |
| 22. | 61351C | Washer, thrust | 1 |
| 23. | 35876AP | Pulley, rear | 1 |
| 24. | 35878V | Guard, material | 1 |
| 25. | SS7060610SP | Screw | 2 |
| 26. | WP0250516SD | Washer | 2 |
| 27. | 35883AE | Bracket, height adjustment | 1 |
| 28. | 35837S | Bumper, nylon | 1 |
| 29. | SS6090810TP | Screw | 2 |
| 30. | 35876AV | Feed Roller Driver Connection | 1 |
| 31. | 22894W | Screw | 2 |
| 32. | 667C12 | Pin | 1 |
| 33. | 54274P | Washer | 1 |

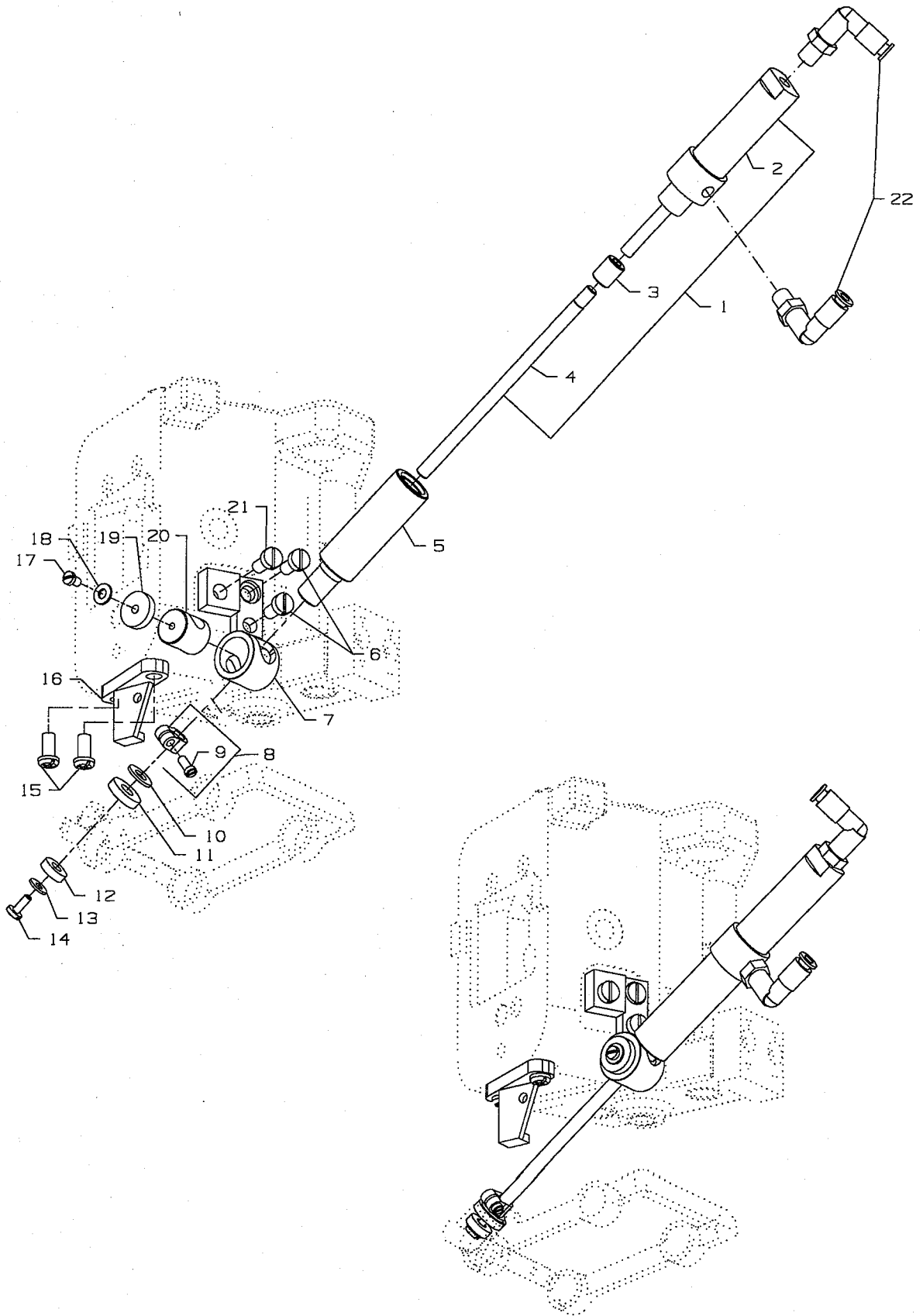




CYLINDER COVER, GASKET AND FOLDER GIBS

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-----------|-------------------------|-----------|
| 1. | 22564J | Screw | 8 |
| 2. | 35883PA | Folder Gib, right | 1 |
| 3. | 35883NA | Folder Gib, left | 1 |
| 4. | 35883TA | Cylinder Cover | 1 |
| 5. | 35883SA | Gasket | 1 |
| 6. | 22798 | Screw | 1 |
| 7. | 27-435BLK | Washer | 1 |
| 8. | 36284E | Upper Lint Shield | 1 |

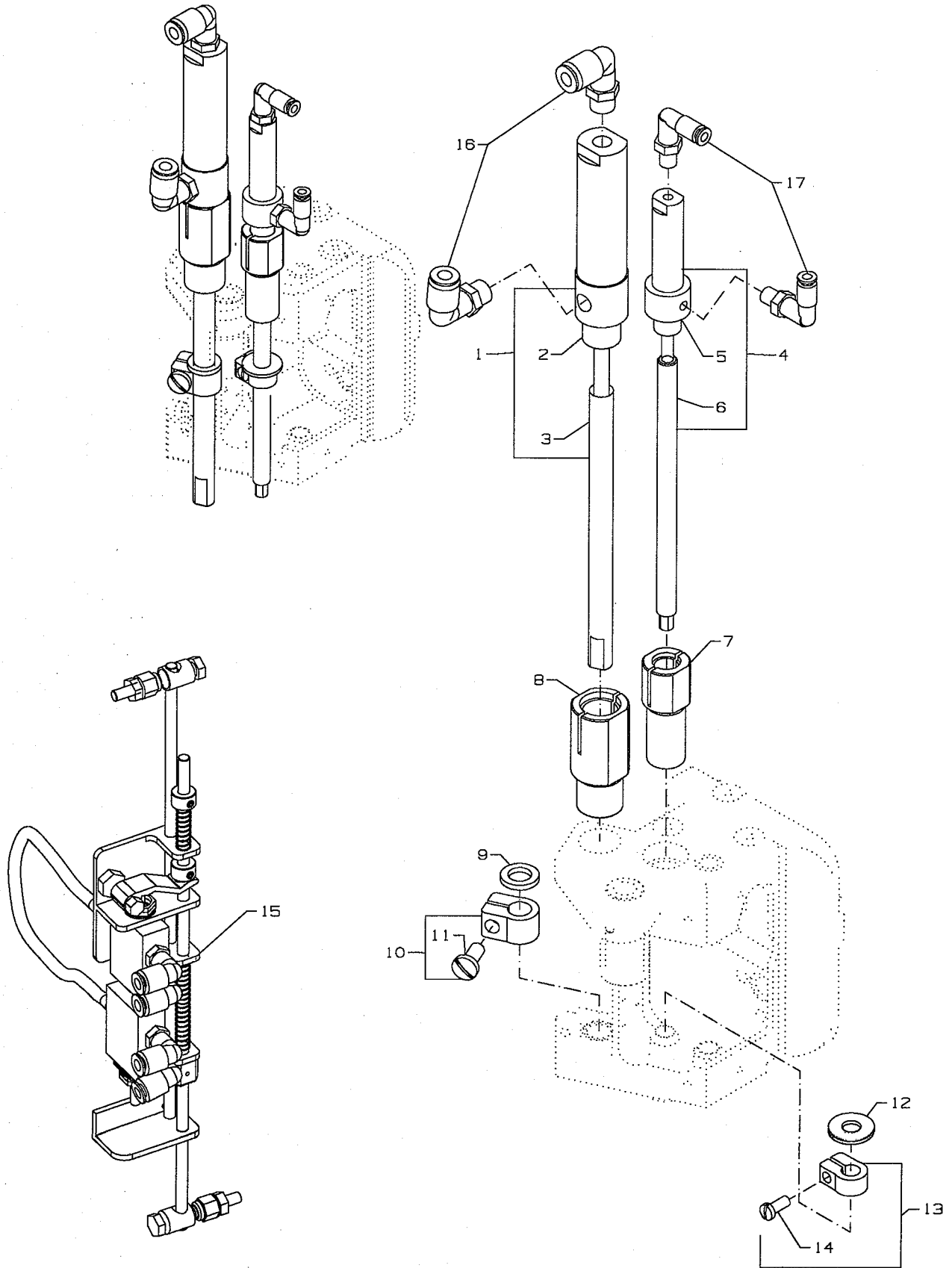




PNEUMATIC FRONT ROLLER ASSEMBLY

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-------------|----------------------------------|--------------|
| 1. | 29476TD | Pneumatic Assembly | 1 |
| 2. | 671A358 | Air Cylinder | 1 |
| 3. | 35883M | Coupling, air shaft | 1 |
| 4. | 35822AF | Front Air Shaft | 1 |
| 5. | 671A255 | Front Air Adapter | 1 |
| 6. | SS6121010SP | Screw | 2 |
| 7. | 35883AB | Bracket, spring pivot | 1 |
| 8. | 35883N | Clamp, front air | 1 |
| 9. | SS6080720SP | Screw | 1 |
| 10. | 35875AK | Washer, thrust | 1 |
| 11. | 35875AC | Washer, neoprene | 1 |
| 12. | 35875AG | Washer, neoprene | 1 |
| 13. | 35875AJ | Washer, thrust | 1 |
| 14. | 18-799 | Screw | 1 |
| 15. | SS6121220TP | Screw | 2 |
| 16. | 35883AF | Bracket, height adjustment | 1 |
| 17. | SS7080520SP | Screw | 1 |
| 18. | 35893F | Washer | 1 |
| 19. | 35893E | Felt | 1 |
| 20. | 35844L | Bushing, spring pivot | 1 |
| 21. | SS7121410TP | Screw | 1 |
| 22. | 671F82F | Fitting | 2 |

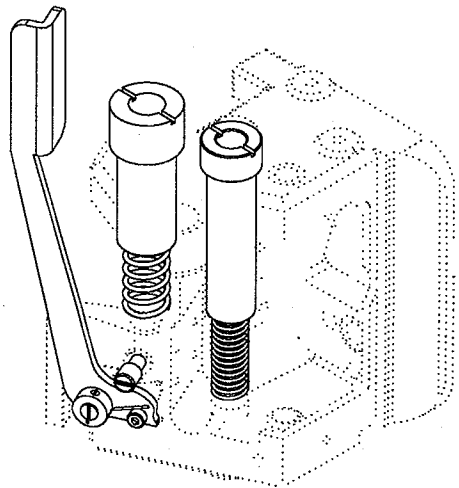
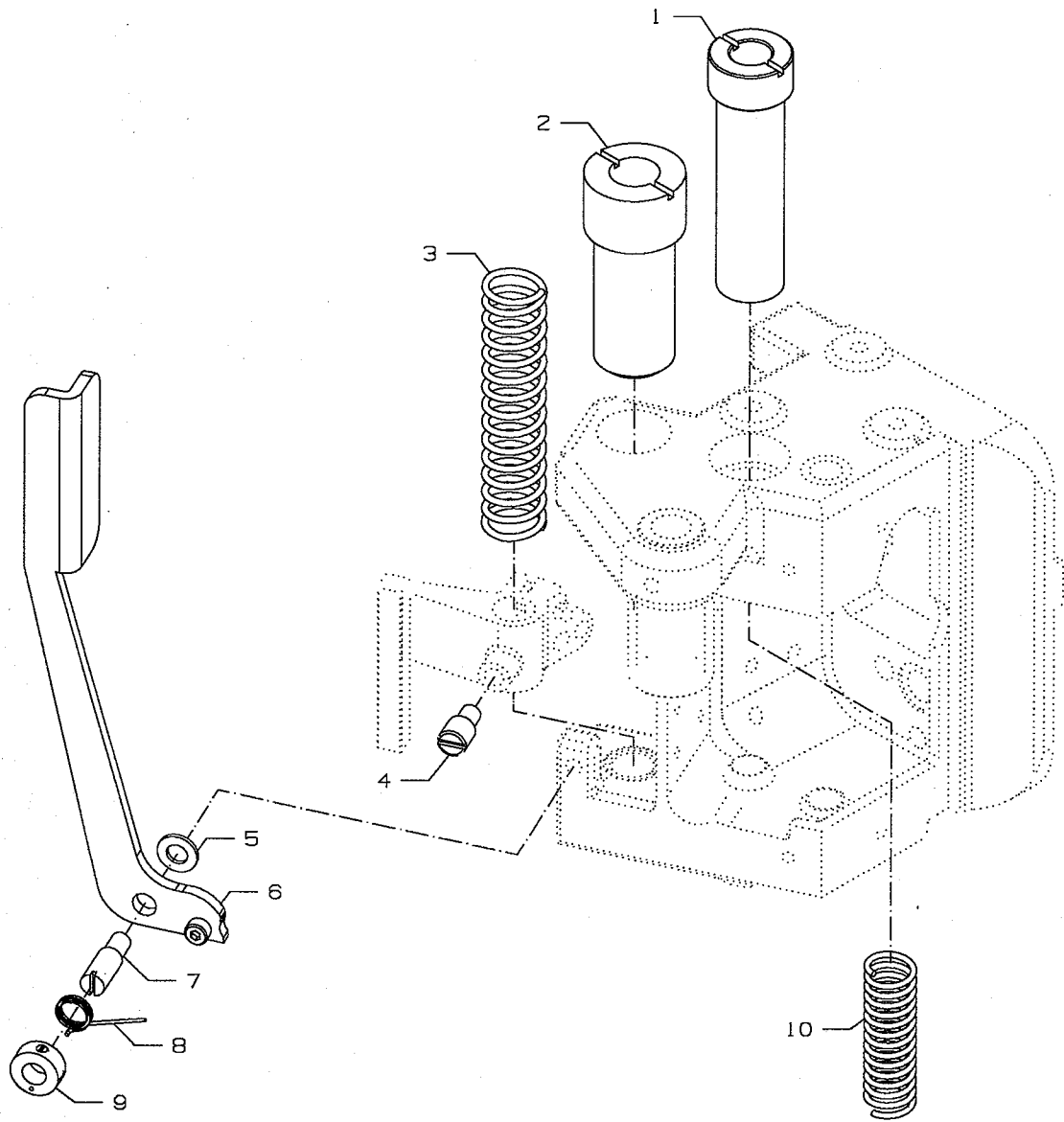




REAR ROLLER & PRESSER FOOT PNEUMATIC ASSEMBLY & TREADLE SWITCH

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-------------|--|--------------|
| 1. | 29476UD | Puller Shaft Air Cylinder Assembly | 1 |
| 2. | 671A35 | Air Cylinder | 1 |
| 3. | 35877AL | Puller Shaft | 1 |
| 4. | 29476TE | Presser Bar Air Assembly | 1 |
| 5. | 671A253 | Air Cylinder | 1 |
| 6. | 35822AE | Presser Bar Shaft | 1 |
| 7. | 671A256 | Adapter, air cylinder | 1 |
| 8. | 671A254 | Adapter, air cylinder | 1 |
| 9. | 35886H | Washer, neoprene | 1 |
| 10. | 35833R | Collar, clamp | 1 |
| 11. | SS7151310TP | Screw | 1 |
| 12. | 35886J | Washer, neoprene | 1 |
| 13. | 35883S | Collar, clamp | 1 |
| 14. | SS7111120TP | Screw | 1 |
| 15. | 29476SE | Treadle Switch | 1 |
| 16. | 671F82C | Elbow Fitting | 2 |
| 17. | 671F82F | Elbow Fitting | 2 |





**MANUAL REAR ROLLER LIFT & PRESSURE SPRING REGULATOR FOR REAR ROLLER
& PRESSER FOOT**

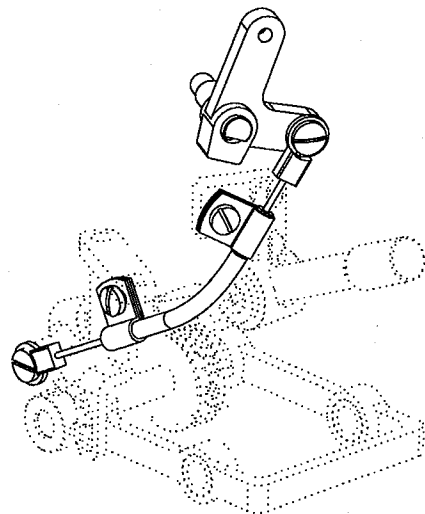
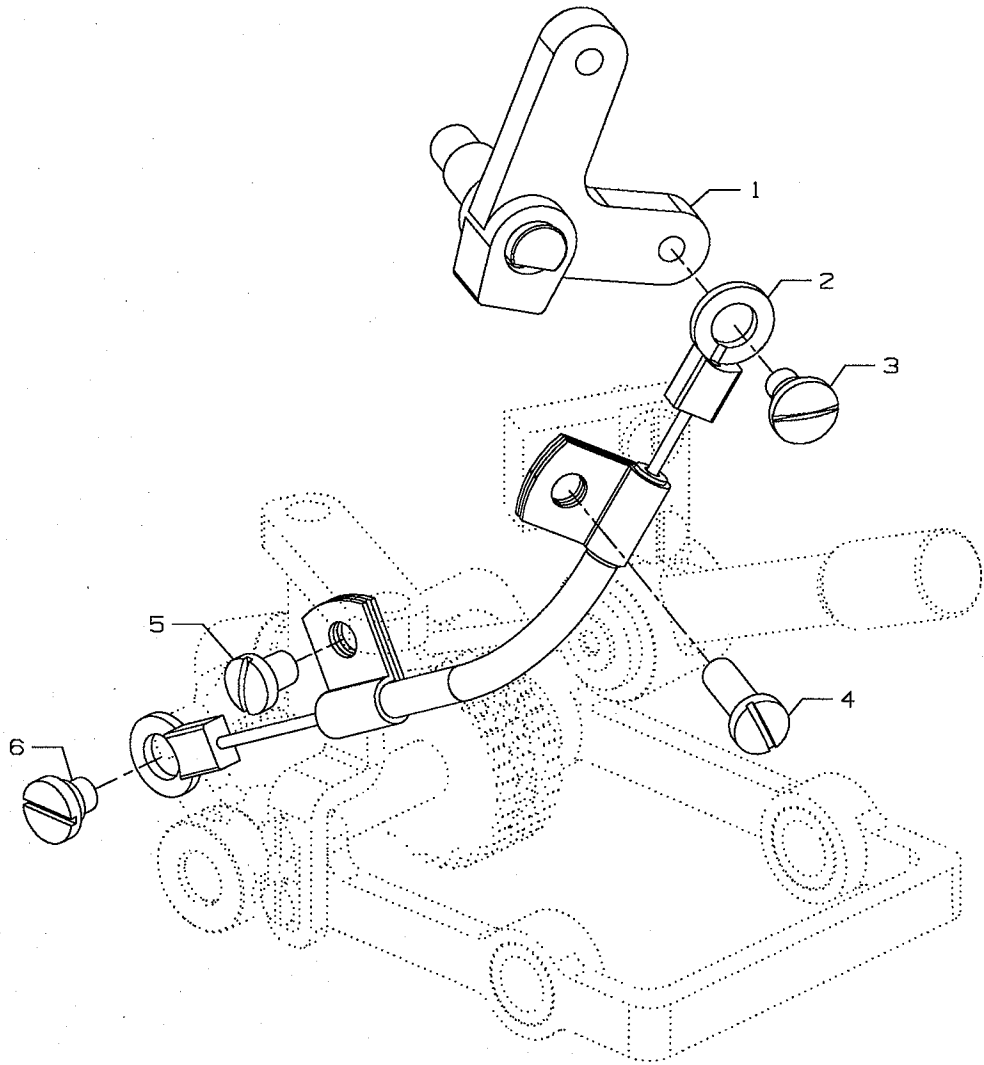
| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|----------|-----------------------------|--------------|
| 1. | 35843C | Presser Bar Knob | 1 |
| 2. | 35892A | Puller Bar Knob, rear | 1 |
| 3. | 35832B | Spring, puller bar | 1 |
| 4. | 35847H | Lever Lift Pin, rear | 1 |
| 5. | 35875AD | Washer | 1 |
| 6. | 35867 | Handle, roller lift | 1 |
| 7. | 35847W | Screw | 1 |
| 8. | 35832E | Spring, torsion | 1 |
| 9. | 35833P | Collar | 1 |
| 10. | 35832A | Spring, presser bar | 1 |



MANUAL FRONT ROLLER ASSEMBLY

| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|-------------|-----------------------------|--------------|
| 1. | 35883AC | Front Spring Knob | 1 |
| 2. | 35844L | Bushing, spring pivot | 1 |
| 3. | 35832C | Spring, front roller | 1 |
| 4. | 29476TB | Tube Guide Assembly | 1 |
| 5. | 35837R | Tube, guide | 1 |
| 6. | WP0650876SD | Washer, thrust | 1 |
| 7. | 35875AC | Washer, neoprene | 1 |
| 8. | SS6121010SP | Screw | 2 |
| 9. | 35883AB | Bracket, spring pivot | 1 |
| 10. | 35893E | Felt | 1 |
| 11. | 35893F | Washer | 1 |
| 12. | SS7080520SP | Screw | 1 |

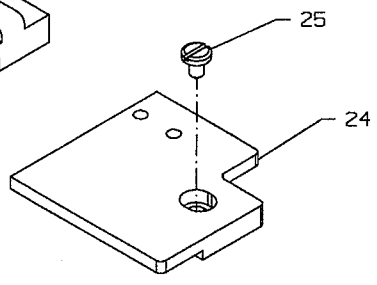
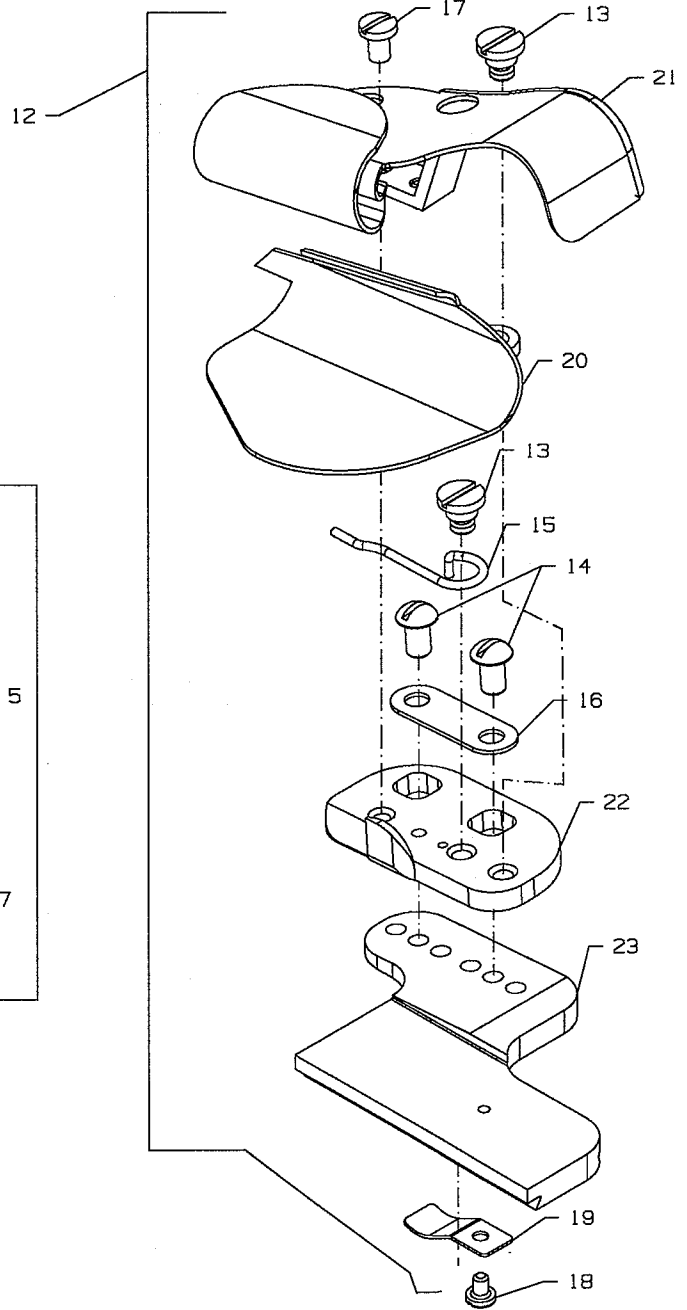
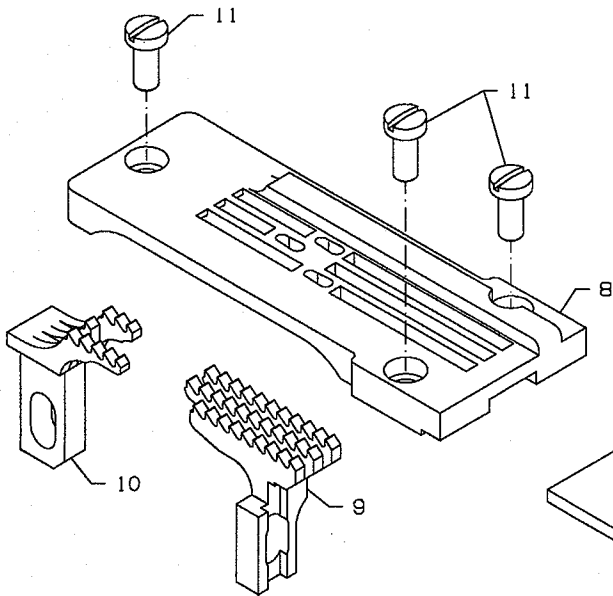
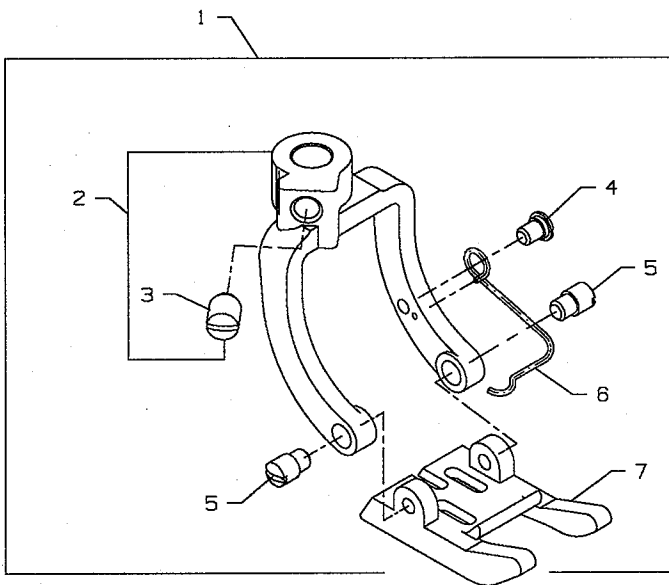
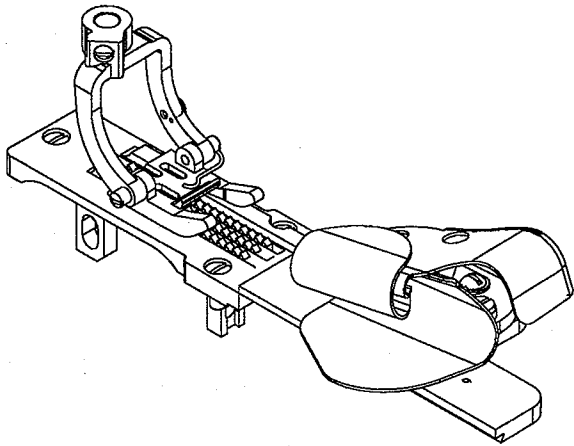




MANUAL LIFT CABLE FOR FRONT ROLLER FEED

| Ref. No. | Part No. | Description | Amt. Req. |
|----------|-------------|-------------------------------|-----------|
| 1. | 35880P | Lifter Lever Bell Crank | 1 |
| 2. | 670E1301 | Lifter Lever Assembly | 1 |
| 3. | 22758E | Screw | 1 |
| 4. | SS7121410TP | Screw | 1 |
| 5. | SS7120640SP | Screw | 1 |
| 6. | SD0640211SP | Screw | 1 |





PRESSER FOOT, THROAT PLATE & FEED DOGS

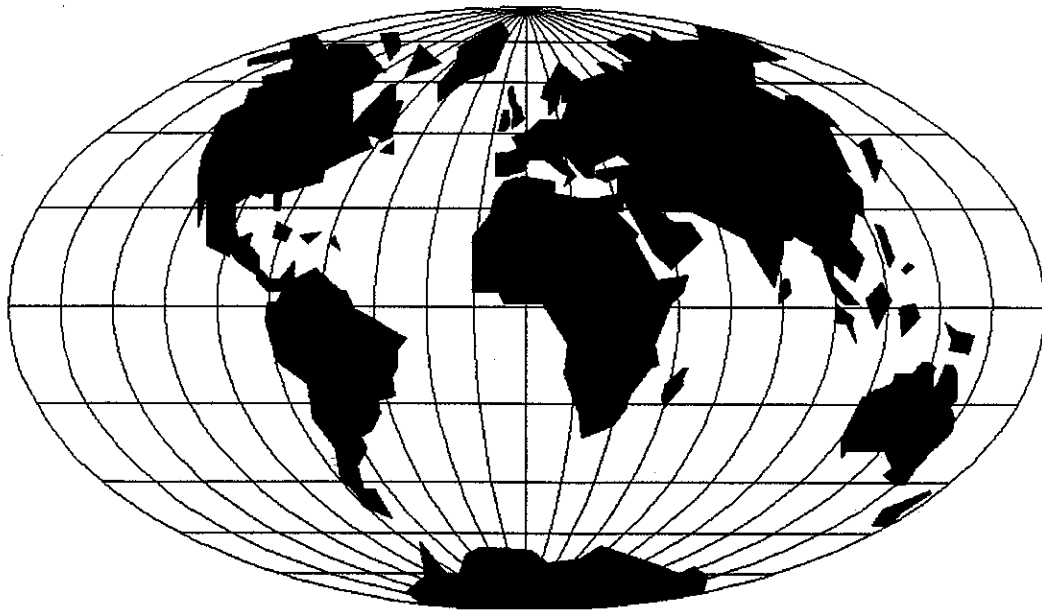
| Ref. No. | Part No. | Description | Amt. Req. |
|-------------|---------------|---|--------------|
| 1. | 35820CA | Presser Foot Assembly | 1 |
| 2. | 35830DY | Presser Foot Fork | 1 |
| 3. | SS8120740SP | Screw | 1 |
| 4. | 22599 | Screw | 1 |
| 5. | 22865B | Screw | 2 |
| 6. | 35832H | Spring | 1 |
| 7. | 35830DZ | Presser Foot, for 35800FPP9, FP9 | 1 |
| 8. | 35824EA9 | Throat Plate, for 35800FPP9, FP9 | 1 |
| 9. | 35826EB | Differential Feed Dog, for 35800FPP9, FP9 | 1 |
| 10. | 35805EA | Main Feed Dog | 1 |
| 11. | 22585 | Screw | 3 |
| 12. | 23420AA18-1/8 | Folder Assembly | 1 |
| 13. | 22760A | Screw | 2 |
| 14. | 22849A | Screw | 2 |
| 15. | 23424S | Lower Scroll Spring | 1 |
| 16. | 23425T | Clamp Plate | 1 |
| 17. | 87U | Screw | 1 |
| 18. | 73A | Screw | 1 |
| 19. | 23424F | Folder Support Spring | 1 |
| 20. | 23422AY18-1/8 | Lower Scroll | 1 |
| 21. | 23421AA18-1/8 | Upper Scroll | 1 |
| 22. | 23424T | Lower Scroll Support | 1 |
| 23. | 23424AA | Folder Support Slide | 1 |
| 24. | 35862D | Stop Plate | 1 |
| 25. | 73A | Screw | 1 |



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