

**THIRD
EDITION**



Union Special
INDUSTRIAL SEWING EQUIPMENT

CATALOG NO. T83T

STYLES

61400M

61400T

61400W

Catalog No. T83 T

LIST OF PARTS

Styles

61400 M 61400 T
61400 W

Top and Bottom Roller Feed Machines

Third Edition

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UNION SPECIAL CORPORATION
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U.S.A.

February, 1977

IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine is identified by a Style number which is stamped into the name plate on the front of the machine. Style numbers are classified as standard and special. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 61400 M". Special Style numbers contain the letter "Z". When only minor changes are made in a standard machine, a "Z" is suffixed to the standard Style number. Example: "Style 61400 MZ".

Styles of machines similar in construction are grouped under a class number which differs from the style number in that it contains no letters. Example: "61400".

APPLICATION OF CATALOG

This catalog applies specifically to the Standard Styles of machines as listed herein. It can also be applied with discretion to some Special Styles of machines in Class 61400. Catalog No. 83 R may prove helpful for illustrations not shown in this catalog. Reference to direction, such as right, left, front, back, etc., are given from the operator's position while seated at the machine. Operating direction of the handwheel is toward the operator.

STYLES OF MACHINES

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

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

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

NEEDLES

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

NEEDLES (Continued)

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

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

To have needle orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. Use description on label. A complete order would read: "1000 Needles, Type 180 GXS, Size 140/054".

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

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

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

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

USE GENUINE NEEDLES AND REPAIR PARTS

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

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

TERMS

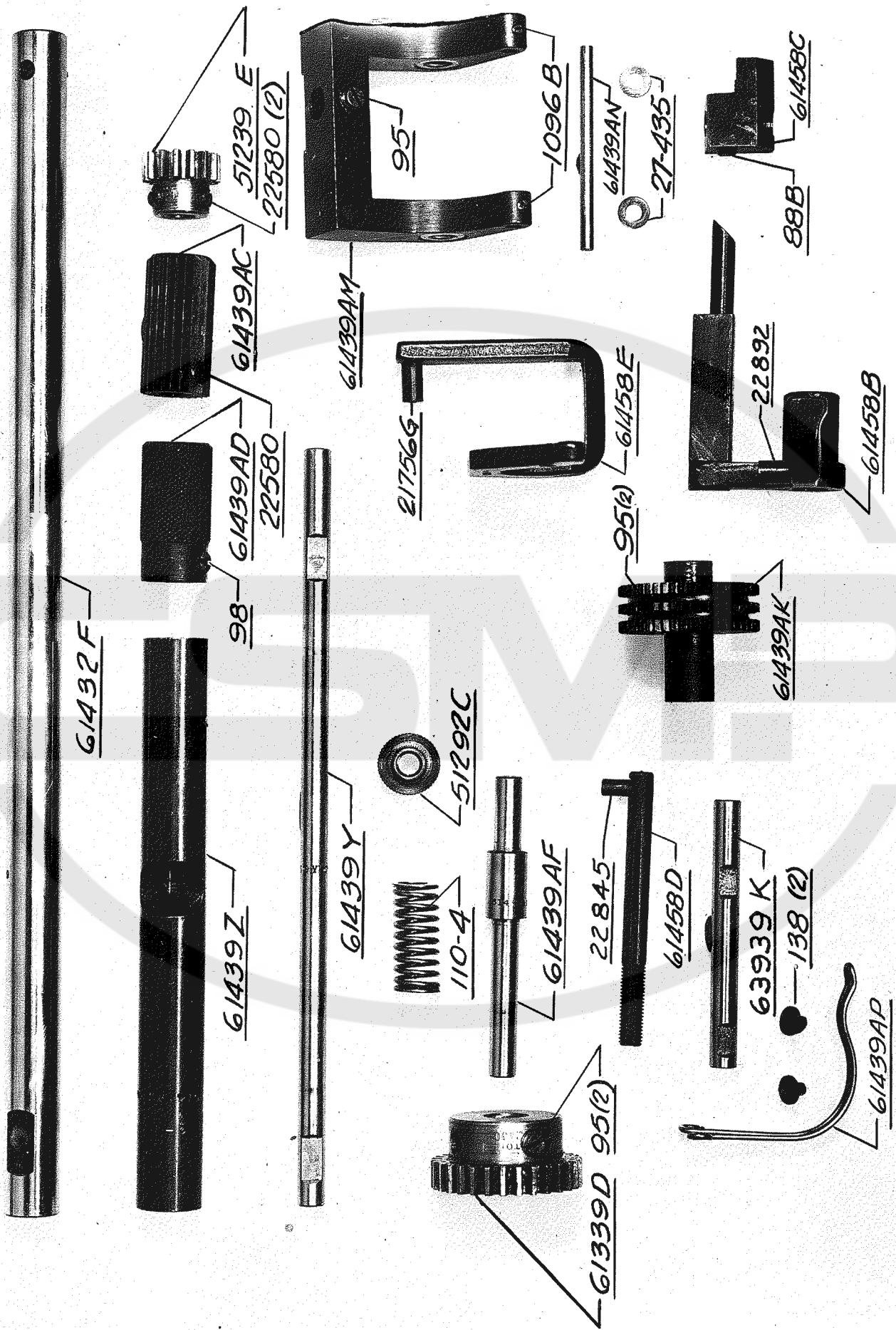
Prices are net cash and subject to change without notice. All shipments are forwarded f.o.b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

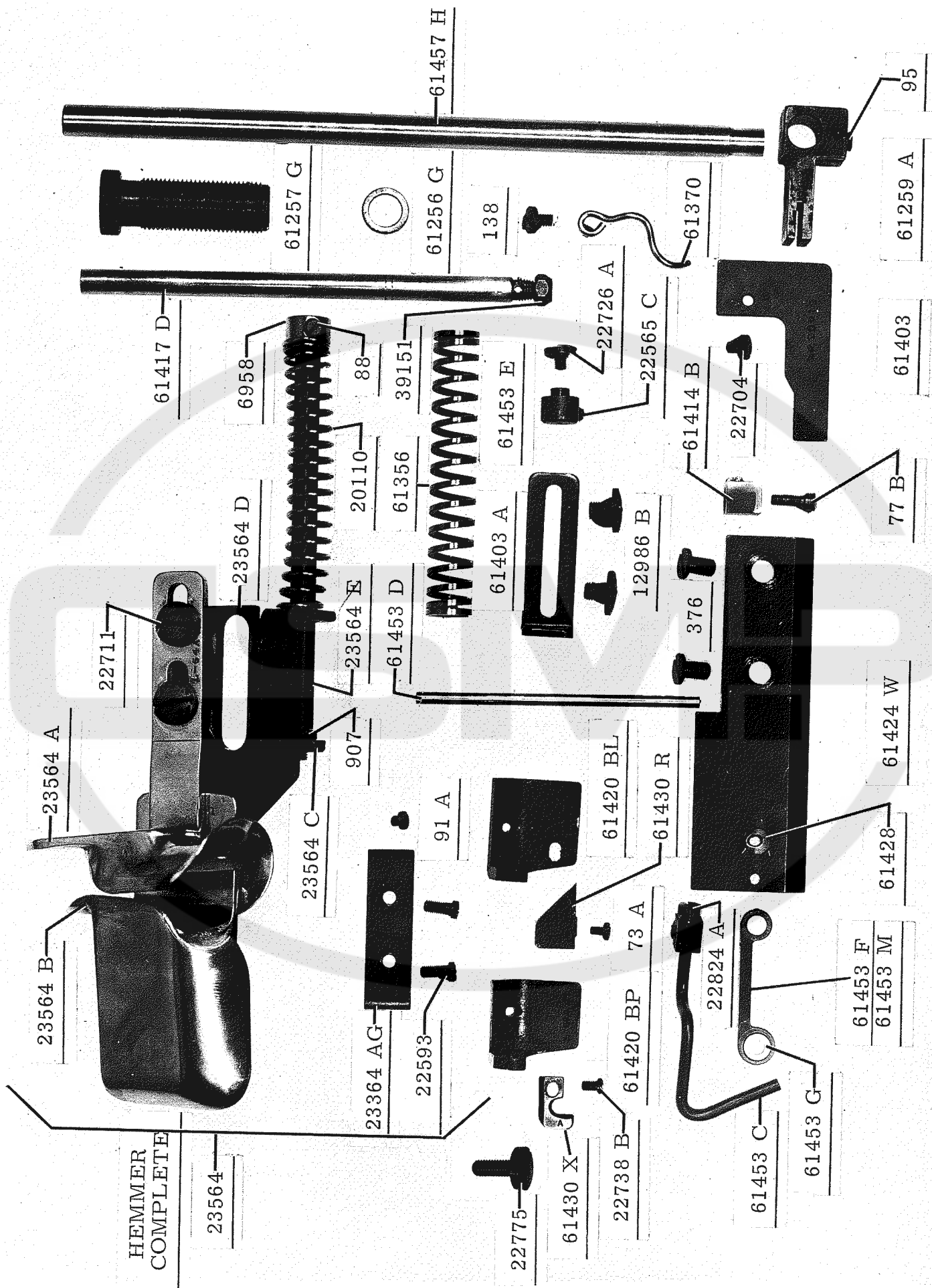
The following is a numerical list of the parts used in this machine. Quantities, part numbers, and descriptions are given. Following the parts list are photographs of some of the major parts.

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	18	Nut for 22832 G	2	22565 C	Screw for 51239 T	1	29126 CV	Top Roller Feed Drive Eccentric Assembly (22832 G)
4	27-435 Blk.	Washer for 61439 AN	1	22565 C	Screw for 61453 E			
3	28-95 Blk.	Spring Stop on 61339 R	2	22569 B	Screw for head cover	1	29474 G	Rotating Hook Assembly
1	28 C	Needle Clamp Screw for 61417 C	3	22569 C	Screw for 61494 A	1	29475 AA	Tension Assembly (22597 E, 22863 B)
1	50-223 Blk.	Rivet for 61351 L	1	22569 H	Hook Set Screw	1	39151	Needle Clamp Nut for 61417 D
1	50-567 Blk.	Oil Sight Gauge on 61494	6	22570 A	Screw for 61271	1	41258	Feed Clutch Roller
1	50-568 Blk.	Oil Gauge	4	22570 A	Screw for 61382 L	1	41358 M	Clutch Barrel (22597 B)
4	HA61 D	Screw for 61264, 61264 A	4	22570 A	Screw for 61382 M	1	41358 N	Clutch Block, right (22747)
1	73 A	Screw for 61430 R	1	22570 A	Screw for 61439 AB	1	41358 P	Clutch Block, left (22747)
1	77 B	Screw for 61414 B	1	22570 A	Screw for 61482 B	6	41358 Q	Feed Clutch Roller Spring
1	88	Screw for 6958	3	22570 B	Screw for 61391 D	6	41358 S	Clutch Spring Support Pin
2	88	Screw for 61242	4	22574	Screw for 61321 J	1	41358 T	Support Pin Washer
1	88 B	Screw for 61458 C	1	22580	Screw for 51239 E	1	41390 E	Bushing for 61439 G
2	89	Screw for 61244	1	22580	Screw for 61439 AC	1	51239 B	Feed Clutch Check Plate Pin (22729)
1	89	Screw for 61449 AA	2	22585 A	Screw for 61351 J	2	51239 E	15 tooth Gear (22580)
1	89	Screw for 61492	2	22593	Screw for 23564 B	2	51239 G	Universal Joint (22894 T)
1	91 A	Screw for 23564 D	2	22596 D	Adjusting Screw for 61391 D (8372 A)	1	51239 S	Roller Feed Clutch Shaft
2	93	Screw for 23564 G	1	22597 A	Screw for 61251 D	1	51239 T	Roller Feed Clutch Brake (22565 C)
2	93	Screw for 61482	3	22597 B	Screw for 62262	1	51239 U	Roller Feed Clutch Brake Washer
1	93	Screw for 61482 L	1	22597 E	Screw for 61358 M	1	51292 C	Presser Foot Tension Regulating Nut
1	95	Screw for 61259 A			Set Screw for tension assembly	1	61149 G	Stitch Eccen., .078 inch throw, for 29126 CV
4	95	Screw for 61339 D	1	22704	Screw for 61403	1	61149 H	Friction Disc for 61149 G
2	95	Screw for 61439 AK	2	22711	Screw for 23564	1	61208 B	Rotating Hook for 29474 G
2	95	Screw for 61439 AM	2	22711	Screw for 23564 A	1	61210 B	Hook Thread Guard for 29474 G (22716 A)
1	96	Screw for 61454 D	1	22712 F	Screw for 61368 F	1	61212	Bobbin for 29474 G
1	96 A	Screw for 61341 C	4	22716 A	Screw for 61210 B	1	61216	Hinge Pin for 61415
2	98	Screw for 2339 F	1	22716 B	Screw for 61414 C	1	61216 N	Bobbin Case Spring
1	98	Screw for 61439 AD	3	22716 H	Screw for 61411 A	1	61236	Bushing for 61261 A
2	109	Tension Disc for 29475 AA	2	22560 B	Screw for 61437 A	1	61242	Hook Shaft Collar (88)
1	110-4	Presser Foot Tension Regulating Spring	3	22564 B	Screw for 61255	1	61244	Hook Shaft Pinion Gear (89)
1	138	Screw for 61370	1	22726 A	Screw for 61437 C	1	61251 D	Take-up Lever Pin (660-205, 22597 A)
2	138	Screw for 61439 AP	1	22729	Screw for 61453 F, M	1	61252	Take-up Lever Link
2	376	Screw for 61424 W	1	22730	Screw for 51239 B	1	61252 J	Take-up Lever Crank Pin
1	454 A	Washer for 22891	1	22738 B	Screw for 61482 B	1	61255	Needle Bar Connecting Stud (22562 B)
1	652 B-20	Lock Washer for lifter lever stud	2	22738 F	Screw for 61430 X	1	61255 H	Needle Bar Link (22757 C)
1	660-142	Spring Cotter Pin for 61368 A	1	22747	Screw for 61430 BX	1	61256 G	Presser Spring Washer
1	660-205	Retaining Ring for 61251 D	1	22757 C	Screw for 41358 N, P	1	61257 G	Presser Bar Bushing, upper
1	660-226	Needle Bearing for 61439 AJ	1	22758 B	Screw for 61255 H	1	61259 A	Presser Bar Guide (95)
2	660-249	Needle Bearing for 61439 AM	1	22775	Screw for 61267	1	61260 A	Feed Driving Shaft Gear (22884)
1	660-257	Washer for 22730	1	22775	Screw for presser foot on 61400 M, T	1	61261 A	Feed Driving Shaft Intermediate Gear
2	666-20	Oil Wick	1	22775	Screw for 61430 U	1	61264	Intermediate Gear Shaft Collar, right (HA61 D)
1	666-104	Oil Wick for main shaft housing	1	22775	Screw for 61430 V	1	61264 A	Intermediate Gear Shaft Collar, left (HA61 D)
2	666-126	Oil Wick for 61293	1	22817 A	Stud for 61468	1	61267	Lifter Lever Link (22758 B)
1	666-127	Felt Oil Wick for 61393 C	1	22824 A	Screw for 61453 C	1	61267 G	Spring Pin for release lever
1	907	Adjusting Screw Nut for 23564	2	22829	Screw for 61482 A	1	61271	Frame Needle Thread Eyelet (22570 A)
2	1096 B	Screw for 61439 AN	1	22832 G	Screw for 29126 CV (18, 61434 G)	1	61282 D	Gasket for 61382 L
1	2339 F	Thrust Collar for lower main shaft	1	22845	Screw for 61458 D	2	61282 E	Gasket for 61382 M
1	6958	Collar for 23564 E (88)	1	22863 B	Adjusting Screw for tension assembly	1	61292 C	Nut for 61492
2	8372 A	Washer for 61391 D	1	22874	Screw for 61439 G (9937, 80557)	1	61292 G	Tension Release Pin
2	9937	Nut for 22874	1	22874 F	Screw for 61468 (9937)			
1	9937	Nut for 22874 F	1	22880	Spot Screw for 61391 D			
2	12986 B	Screw for 61403 A	1	22882	Screw for 61439 F			
1	15872 F	Spring for release lever	2	22884	Screw for 61260 A			
1	20110	Spring for 23564 E	2	22884	Screw for 61360			
1	21629	Stud for 61430 BW	1	22890	Screw for 61360 G			
1	21756 G	Stud for 61458 E	2	22891	Screw for 61466 A			
1	21756 G	Stud for 61458 H	1	22892	Screw for 61439 G (454 A)			
2	22539 D	Plug Screw for base	2	22894 J	Screw for 61458 B			
2	22564 E	Screw for 61414 C, 61415 A	2	22894 T	Screw for 61443			
1	22564 F	Screw for 61413 G	2	22894 V	Screw for 51239 G			
			1	23364 AG	Screw for 61391 D			
			1	23564	Hemmer Scroll Slide Spring			
			1	23564 A	Hemmer, comp., for 61400 M (907, 22711)			
			1	23564 B	Hemmer Scroll, right (22711)			
			1	23564 C	Hemmer Scroll, left (22593)			
			1	23564 D	Hemmer Scroll Slide			
			1	23564 E	Hemmer Base (91 A)			
			1	23564 G	Operating Rod (20110)			
					Hemmer Mounting Bracket for 61400 M (93)			

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

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





61434 G



18

61339 B



22832 G

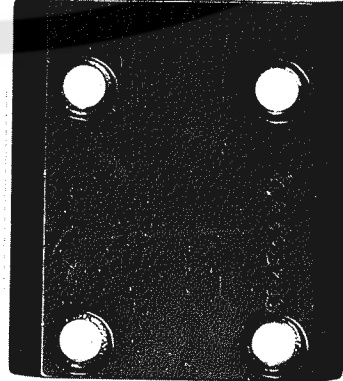


61482

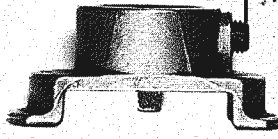


93

61439 AB

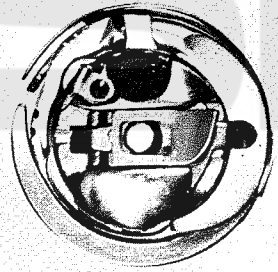


29474 G

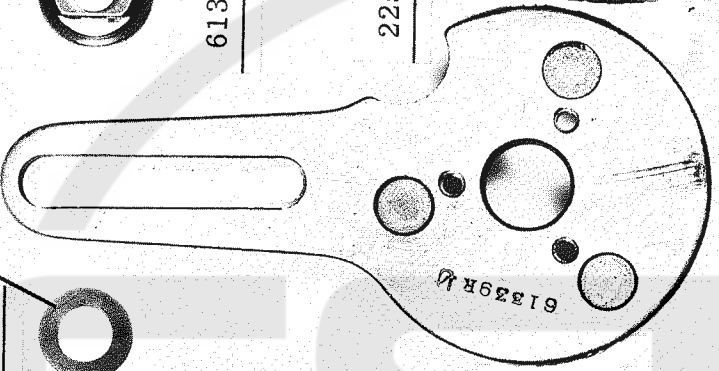


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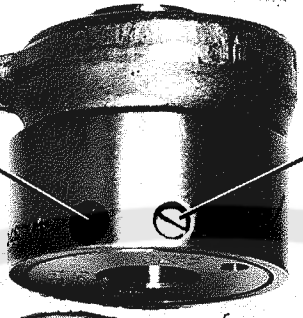
61339 R



22564 B (3)



29126 CV

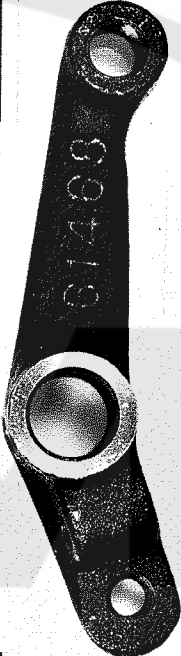


22560 A (2)

61449 AA



98



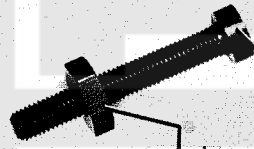
61468

2339 F



22570 A

9937

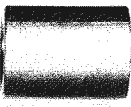


22874 F

22817 A



61368 F



22712 F



23564 G

61382L PLATE 61282D GASKET

61382M

61282E
GASKET

93(2)

22730
Screw

660-257
Washer

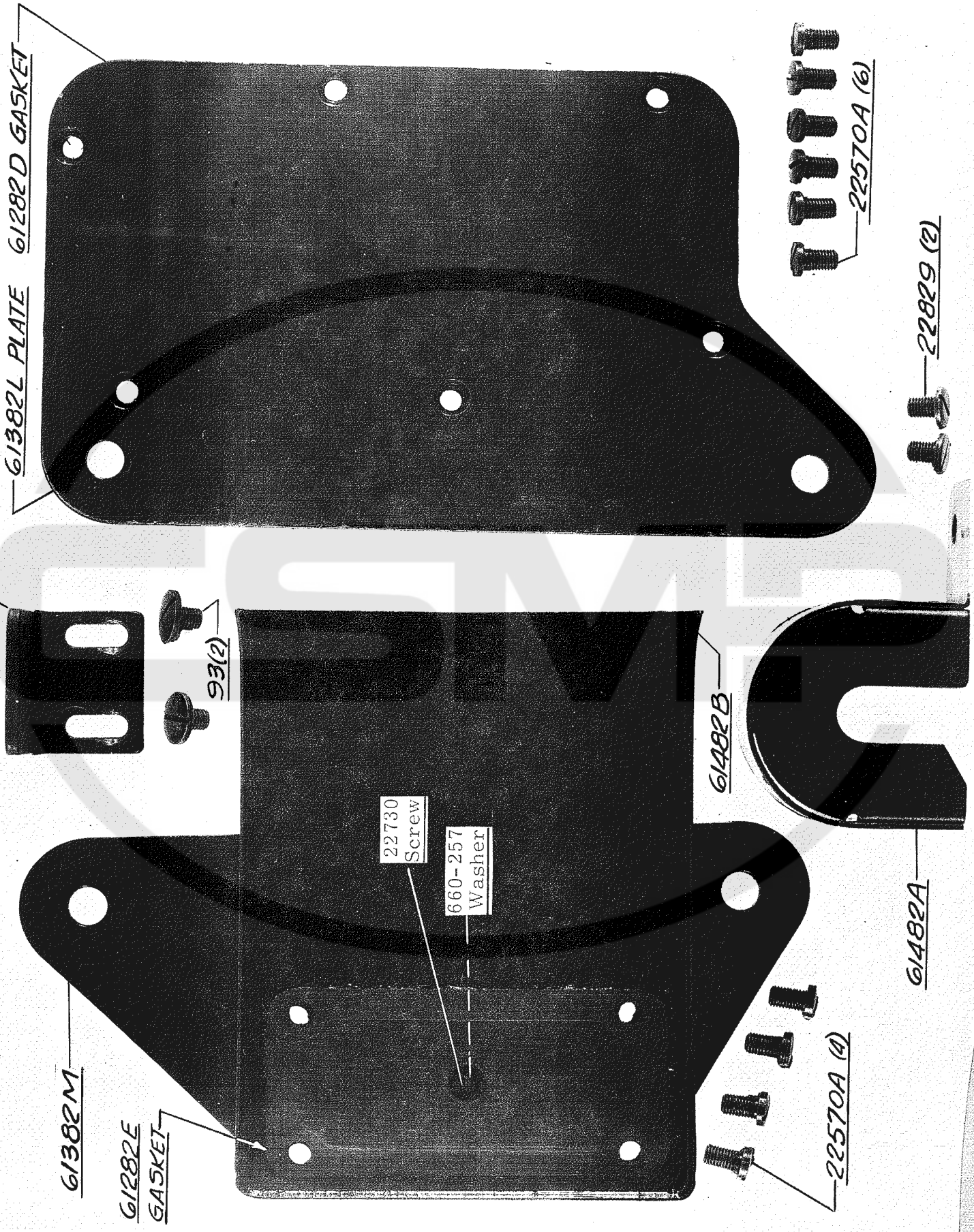
61482B

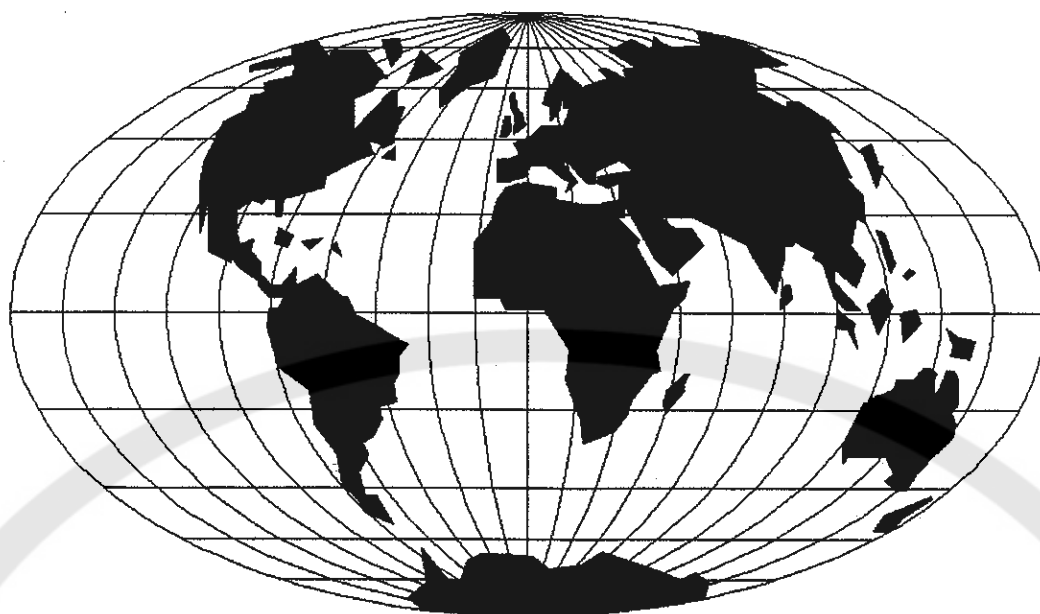
61482A

22570A (4)

22829 (2)

22570A (6)





WORLDWIDE SALES AND SERVICE

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