FOREWORD

The 51100 streamlined machines covered by this catalog represent the latest design of the UNION SPECIAL flat bed bag seaming machine. Automatic lubrication, with a pump for returning filtered oil to the main reservoir, has made maintenance simple. All parts are made by precision methods insuring complete interchangeability.

It is our constant aim to furnish carefully prepared information that will enable the customer to secure all possible advantages from the use of UNION SPECIAL sewing machines. The following pages illustrate and describe the parts used in the 51100 bag seaming machines covered by this catalog.

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 MACHINE

Each UNION SPECIAL carries a Style number which is stamped in the name plate 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 51100 BP". 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: 51100 BPZ".

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: "51100".

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 machines in Class 51100. 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.

DESCRIPTION OF MACHINE

Streamlined, Flat Bed, High Throw, One Needle, Lateral Looper Travel, Single Reservoir, Enclosed Automatic Lubricating System, Equipped With Filter Type Oil Return Pump, Seam Specification 401-SSa-1, Stitch Range 3 1/2 to 7 S.P.I.

51100 BM For seaming medium and large size cotton and light and medium weight burlap bags 1 5/16" needle bar travel. Light weight presser bar and needle bar driving mechanism.

51100 BP For seaming medium and large size bags, made from medium and light weight fabrics 1 1/2" needle bar travel.

NEEDLES

Each UNION SPECIAL needle has both 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 largest diameter of blade, measured in thousandths of an inch, midway between shank and eye. Collectively, type and size number represent the complete symbol which is given on the label of all needles packaged and sold by Union Special.

Standard needle for Styles 51100 BM, 51100 BP is Type 143 G. It is a number 2 bag, double groove, spotted, chromium plated needle and is available in sizes 185/073, 200/080, 230/090, 250/100.

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 143 G, Size 200/080".

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

Success in the operation of UNION SPECIAL machines can be secured only by use of needles packaged under our brand name, Union Specials, which is backed by a reputation for producing highest quality needles in materials and workmanship for more than three-quarters of a century.
ORDERING REPAIR PARTS

ILLUSTRATIONS

This catalog is arranged to simplify the ordering of repair parts. Exploded views of various sections of the mechanism are shown so parts may be seen in their actual position within the machine. Opposite the page of illustration is found a listing of parts shown, their part numbers, description and number of pieces required in the particular view shown.

Numbers in the first column are reference numbers only and indicate the position of the part within the illustration. Reference numbers should never be used in ordering parts. Always use the part number given in the second column.

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:

<table>
<thead>
<tr>
<th>Ref. No.</th>
<th>Part No.</th>
<th>Description</th>
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<tbody>
<tr>
<td>41</td>
<td>29105 Z</td>
<td>Looper Drive Eccentric Assembly</td>
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<td>42</td>
<td>22559 B</td>
<td>Bearing Cap Screw, upper</td>
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<tr>
<td>43</td>
<td>22894 D</td>
<td>Spot Screw</td>
<td>1</td>
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<td>44</td>
<td>22894 C</td>
<td>Set Screw</td>
<td>4</td>
</tr>
<tr>
<td>45</td>
<td>22559 A</td>
<td>Bearing Cap Screw, lower</td>
<td>2</td>
</tr>
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</table>

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

In those cases where a part is common to both Styles 51100 BM and 51100 BP, no specific usage will be mentioned in the descriptions. However, when the parts for both 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 parts shown in the illustrations, which will facilitate locating illustration and description when part number is known.

IDENTIFYING PARTS

Where construction permits, each part is stamped with its part number. Some smaller parts are stamped only with an identification letter to distinguish them from parts similar in appearance.

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 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.

OILING AND THREADING INSTRUCTIONS

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

Oil is filled at the spring cap in the top cover (A) of the accompanying drawing and oil level is checked at the sight gauge (B) on front of the machine. Oil level should be maintained between red lines on the gauge. The capacity of the oil reservoir is twelve ounces.

A daily check before the morning start should be made and oil added as required. Oil which has gone thru 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 diagram also shows the threading of machine Styles 51100 BM and 51100 BP.
<table>
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<td>75</td>
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<td>Plug Screw, for belt guard screw holes, Style 51100 BM</td>
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* Not shown on picture plate.
### MAIN FRAME, BUSHINGS AND MISCELLANEOUS OILING PARTS

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Union Special Wants to Help You
Cut Sewing Machine Maintenance Costs

Union Special is offering two practical systems to help pinpoint and reduce your sewing machine maintenance costs: a record keeping system to help spot machines requiring abnormally high maintenance, and a parts inventory system to speed routine repairs.

**Machine Maintenance Records**

Repair-prone machines or inexperienced competent operators can eat up your maintenance dollars in short order. To help spot these problems, Union Special suggests two variations of a simple maintenance record keeping system using cards provided by Union Special.

The first system utilizes a “Machine Maintenance Record” card (Form 237) for each sewing machine in a plant. When a repair is required, the card is pulled from the file and the repair date, parts used, and their cost are entered in the spaces provided and the card is refilled.

The second system is normally used when more detailed information on repair costs is desired. Two record cards are used: a “Repair Request Card” (Form 234), and a “Machine Repair Record” (Form 233). When a machine requires service, the forelady or foreman fills out the top of a “Repair Request Card” and gives it to a mechanic. He fills in the time the repair work is started, the parts used and their cost, and the completion time. This data is then transferred to the permanent “Machine Repair Record” kept in the office.

Whichever system is used, management now has an invaluable tool to reduce needless maintenance costs.

**Repair Part Inventories**

While record keeping tells management which machines require abnormally high maintenance, it does little to help reduce the downtime caused by routine repairs. To alleviate this situation, Union Special recommends that manufacturers establish a formal parts inventory system for each type of sewing machine they operate.

Excessive machine downtime and wasted hours by mechanics can be eliminated with an orderly in-plant inventory of the most commonly needed parts. There is no longer a need to cannibalize other machines for spare parts. Long waits for deliveries are avoided and machine downtime is kept to a minimum. The cost of a parts inventory is small when the overall savings are considered.

For free sample copies of the machine record cards and spare part inventory lists for a variety of the most popular machines, contact your local Union Special Representative or write direct to Union Special.

### Style 51100 BP

**Suggested Minimum Spare Parts List**

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Description</th>
<th>Minimum Quantity Per 5 Machines</th>
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<tbody>
<tr>
<td>198 X</td>
<td>Presser foot</td>
<td>1</td>
</tr>
<tr>
<td>6605 L</td>
<td>Feed dog</td>
<td>1</td>
</tr>
<tr>
<td>22528</td>
<td>Screw for feed dog</td>
<td>2</td>
</tr>
<tr>
<td>6624 L</td>
<td>Throat plate</td>
<td>1</td>
</tr>
<tr>
<td>87</td>
<td>Screw for throat plate</td>
<td>4</td>
</tr>
<tr>
<td>143 G</td>
<td>Needles (specify size)</td>
<td>100</td>
</tr>
<tr>
<td>51108 DA</td>
<td>Looper</td>
<td>1</td>
</tr>
<tr>
<td>51110 D</td>
<td>Looper needle guard</td>
<td>1</td>
</tr>
<tr>
<td>73 A</td>
<td>Screw for looper needle guard</td>
<td>2</td>
</tr>
<tr>
<td>73</td>
<td>Screw for looper</td>
<td>2</td>
</tr>
<tr>
<td>39151</td>
<td>Needle clamp nut</td>
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</tr>
<tr>
<td>22564</td>
<td>Needle bar clamp screw</td>
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<tr>
<td>21225-3/16</td>
<td>Looper gauge</td>
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<tr>
<td>29484</td>
<td>Screw assortment</td>
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</table>

*The parts and quantities listed above are intended to assist you in setting up the initial inventory of spare parts. An efficient inventory can only be established according to actual usage. The nature of the sewing operation will determine actual usage.*