



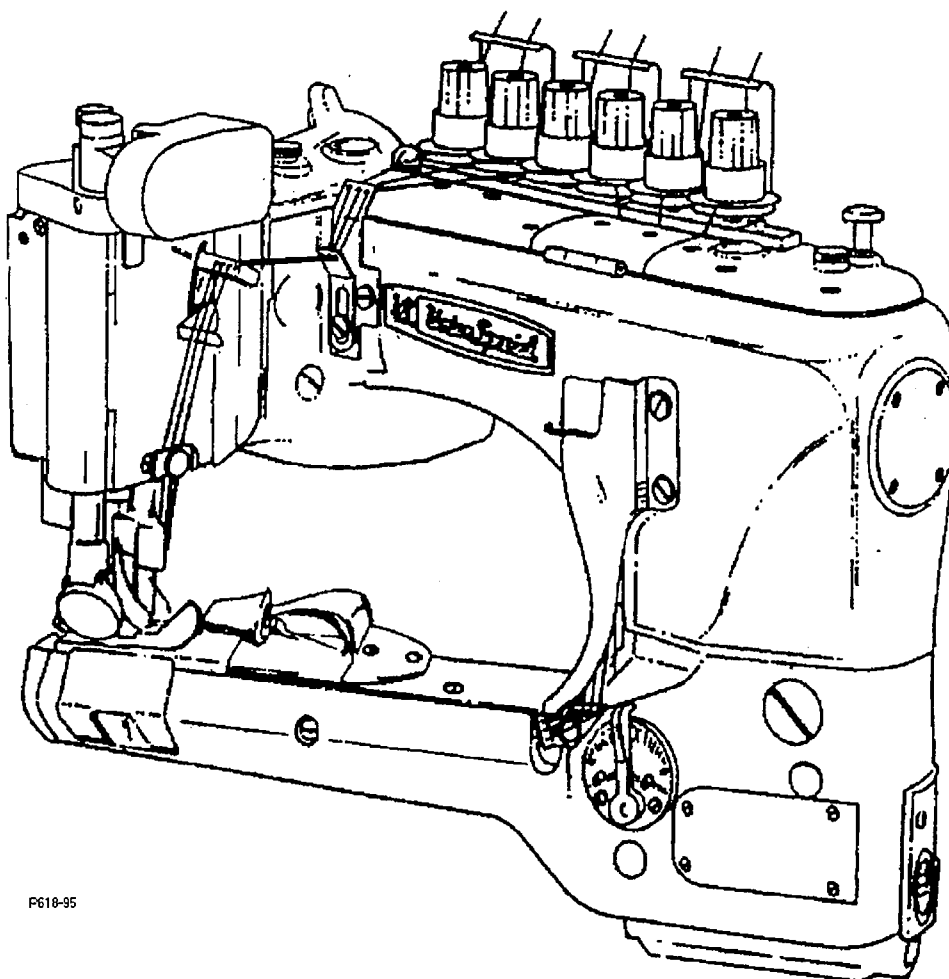
Union Special®

INDUSTRIAL SEWING EQUIPMENT

Parts List & Adjusting Instructions for Styles 35800BLW9, BQW8, 9,
BRW8, 9, BRWL8, 9, BWW8, 9, 18, BWWL8, 9, 18
Supplement to Manuals PT9407 & IN9406

Manual No. IP9528

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PREFACE

This parts/adjusting supplement has been prepared to assist you in locating NEW individual parts or assemblies on the 35800BLW9, BQW8, 9, BRW8, 9, BRWL8, 9, BWW8, 9, 18, BWWL8, 9, 18 machines. It has also been prepared to assist you in the adjustment of the puller mechanism. It can be used in conjunction with Union Special Parts Manual PT9407 and Adjusting Manual IN9406.

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.

This manual has been comprised on the basis of available information. Changes in design and/or improvements may incorporate a slight modification of configuration in illustrations or part numbers.

On the following pages are illustrations and terminology used in describing the parts and the puller adjustments used on the above 35800 machines.

SAFETY RULES

1. Before putting the machines described in this manual into service, carefully read the instructions. The starting of each machine is only permitted after taking notice of the instructions and by qualified operators.

IMPORTANT! Before putting the machine into service, also read the safety rules and instructions from the motor supplier.

2. Observe the national safety rules valid for your country.
3. The sewing machines described in this instruction manual are prohibited from being put into service until it has been ascertained that the sewing units which these sewing machines will be built into, have conformed with the Specific Countries Directives.

Each machine is only allowed to be used as foreseen. The foreseen use of the particular machine is described in paragraph "STYLES OF MACHINES" of this instruction manual. Another use, going beyond the description, is not as foreseen.

4. All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.
5. Wear safety glasses.
6. In case of machine conversions and changes all valid safety rules must be considered. Conversions and changes are made at your own risk.
7. The warning hints in the Instructions are marked with one of these two symbols:



8. When doing the following, the machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug:
 - 8.1 When threading needle(s), looper, spreader, etc.
 - 8.2 When replacing any parts such as needle(s), presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, fabric guide, etc.
 - 8.3 When leaving the workplace and when the workplace is unattended.
 - 8.4 When doing maintenance work.
 - 8.5 When using clutch motors without actuation lock, wait until the motor is stopped totally.
9. Maintenance, repair and conversion work (see Item 8) must be done only by trained technicians or special skilled personnel under consideration of the instructions.
10. Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.
11. Work on parts and equipment under electrical power is not permitted. Permissible exceptions may differ for your country
12. Before doing maintenance and repair work on the pneumatic equipment, the machine has to be disconnected from the compressed air supply. In case of existing residual air pressure, after disconnecting from compressed air supply (i.e. pneumatic equipment with air tank), the pressure has to be removed by bleeding.



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 in the casting at the right rear base of the machine.

CLASS DESCRIPTION

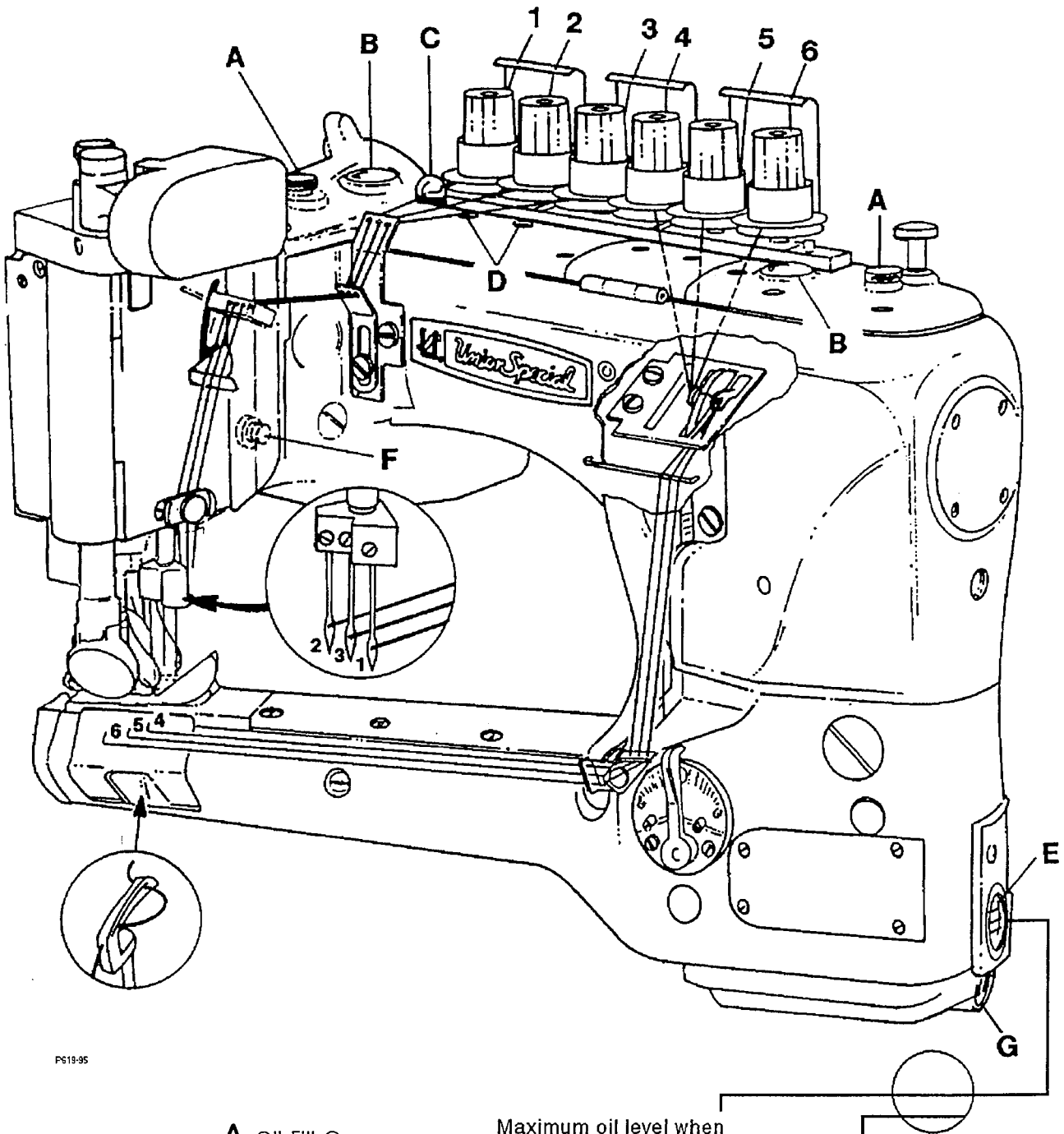
High Speed, Feed-Off-The-Arm High Throw Machines, Two and Three Needle, Left Needle In Front. Light Weight Presser Bar Mechanism, Adjustable Looper Avoid, Space in Front of Needles 8" (203.2 mm), Single Disc Looper Thread Take-Up, Automatic Enclosed Type Oiling System and Filter Type Oil Pump, Visual Sight Oil Action and Supply Gauges, .588" (19/32", 15.1mm) wide roller.

STYLE OF MACHINES

- 35800BLW** DOUBLE LAP SEAM. Three needle, low capacity, differential feed with upper driven roller feed. -Typical Application- For in and seams on medium weight denim garments. Seam Specification 401 LSc-3. Standard gauge Number 9 (9/64", 3.6mm). Recommended needle 130GS, size 125/049. Maximum recommended speed 4500 R.P.M.. .040 step sewing parts.
- 35800BQW** DOUBLE LAP SEAM. Three needle high capacity, plain feed, upper driven, roller feed. - Typical Application- For in and out seams on medium weight denim garments. Seam Specification 401 LSc-3. Standard gauge Numbers 8 (1/8", 3.2mm) and 9 (9/64", 3.6mm). Recommended needle 130GS, size 125/049. Maximum recommended speed 4500 R.P.M.. .040 step sewing parts.
- 35800BRW** DOUBLE LAP SEAM. Three needle, high capacity, plain feed, upper driven, roller feed. Feeds have higher teeth on front of feed dog. - Typical Application- For seat seaming, in and out seams on medium to heavy weight denim garments. Seam Specifications 401LSc-3. Standard gauge Numbers 8 (1/8", 3.2mm) and 9 (9/64", 3.6mm). Recommended needle 130GS, size 140/054. Maximum recommended speed 4500 R.P.M.. .094 step sewing parts.
- 35800BRWL** DOUBLE LAP SEAM. *Same as 35800BRWP without the folder.* Three needle, high capacity, plain feed, upper driven, roller feed. Feeds have higher teeth on front of feed dog. - Typical Application- For seat seaming, in and out seams on medium to heavy weight denim garments. Seam Specifications 401LSc-3. Standard gauge Numbers 8 (1/8", 3.2mm) and 9 (9/64", 3.6mm). Recommended needle 130GS, size 140/054. Maximum recommended speed 4500 R.P.M.. .094 step sewing parts.
- 35800BWW** DOUBLE LAP SEAM. Two and three needle, high capacity, differential feed, high lift feed eccentric, with upper driven, roller feed. Feeds have higher teeth on front of feed dog. - Typical Application- For in and out seaming on heavy weight denim garments. Seam Specifications 401 LSc-2 or 401 LSc-3. Standard gauge Numbers 8 (1/8", 3.2mm), 9 (9/64", 3.6mm), 18 (9/32", 7.2mm). Recommended needle 130GS, size 140/054. Maximum recommended speed 4500 R.P.M.. .094 step sewing parts.
NOTE: 18 gauge available with two needles only.
- 35800BWWL** DOUBLE LAP SEAM. *Same as 35800BWWP without the folder.* Two and three needle, high capacity, differential feed, high lift feed eccentric, with upper driven, roller feed. Feeds have higher teeth on front of feed dog. - Typical Application- For in and out seaming on heavy weight denim garments. Seam Specifications 401 LSc-2 or 401 LSc-3. Standard gauge Numbers 8 (1/8", 3.2mm), 9 (9/64", 3.6mm), 18 (9/32", 7.2mm). Recommended needle 130GS, size 140/054. Maximum recommended speed 4500 R.P.M.. .094 step sewing parts.
NOTE: 18 gauge available with two needles only.



THREADING & OILING



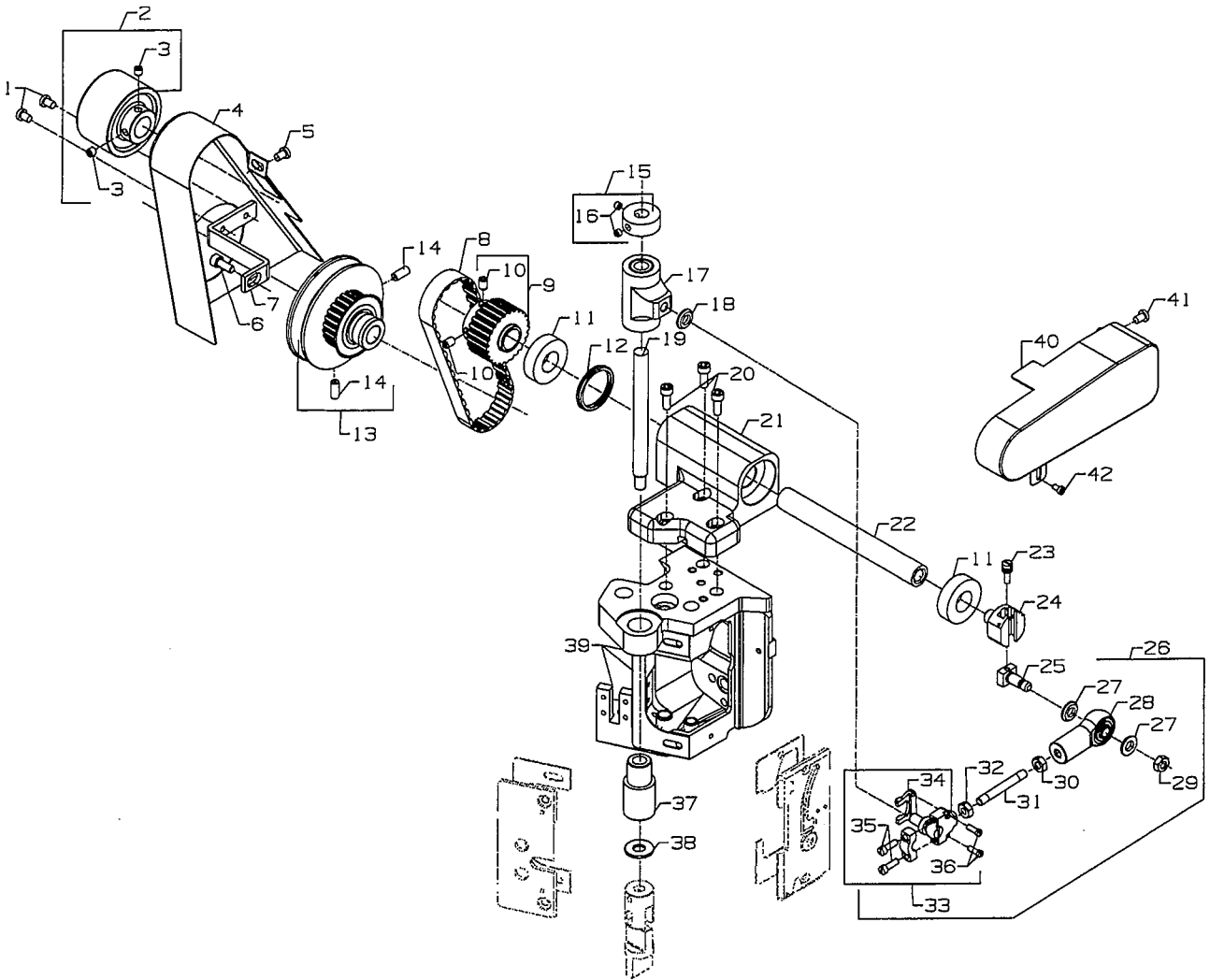
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- A** Oil Fill Cap
- B** Oil Sight
- C** Oil Level Gage
- D** Pump Primer Screws
- E** Oil Sight
- F** Head Oil Drain Plug
- G** Arm Oil Drain Plug

Maximum oil level when
machine is level

Minimum oil level when
machine is level



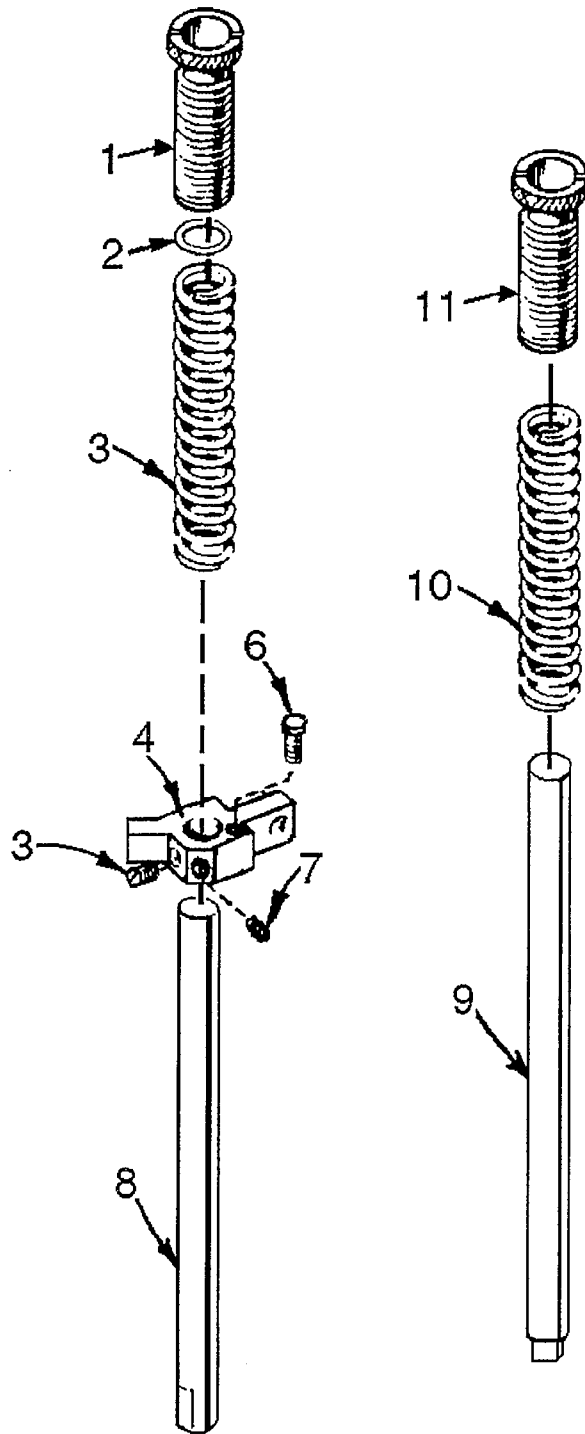


PULLER DRIVE ASSEMBLY

Ref. No.	Part No.	Description	Amt. Req.
1.	22569D	Screw, bracket	2
2.	35821T	Handwheel	1
3.	22894C	Set Screw	2
4.	35882F	Puller Belt Cover	1
5.	22569D	Screw, belt cover	1
6.	SS7701610SN	Screw, bracket	1
7.	35883Z	Bracket	1
8.	C50042AG	Drive Belt	1
*9.	35877AB	Upper Sprocket	1
10.	22894J	Set Screw	2
*11.	660-974	Bearing	2
*12.	660-675	Load Ring	1
13.	35821W	Main Shaft Pulley Assembly	1
14.	22894E	Set Screw	1
15.	35877AG	Clutch Shaft Collar	1
16.	22894W	Set Screw	2
17.	35877AH	Clutch Shaft Housing	1
18.	99622AA	Washer	1
19.	35877AF	Clutch Shaft	1
20.	22653B-16	Screw, upper shaft housing	3
*21.	35844F	Upper Shaft Housing	1
*22.	35874V	Upper Shaft	1
*23.	22795	Adjusting Screw	1
*24.	34776L	Shaft Head	1
*25.	34736L	Crank Stud	1
26.	29478EE	Connecting Rod Assembly	1
27.	99622A	Washer	2
28.	35877AE	Bearing, rod end	1
29.	18	Nut	1
30.	269	Nut	1
31.	41047	Connecting Rod	1
32.	18	Nut	1
33.	35876AL	Ball Joint	1
34.	35846D	Guide	1
35.	22729C	Screw	2
36.	22747	Screw	2
37.	35877AD	Bearing Sleeve	1
38.	54274P	Washer, flat	1
39.	35829AH	Top Support Plate Assembly	1
40.	35882B	Connecting Rod Cover	1
41.	22569D	Mounting Screw	1
42.	22768	Mounting Screw	1

* Part of Clutch Drive Assembly 29476SG.





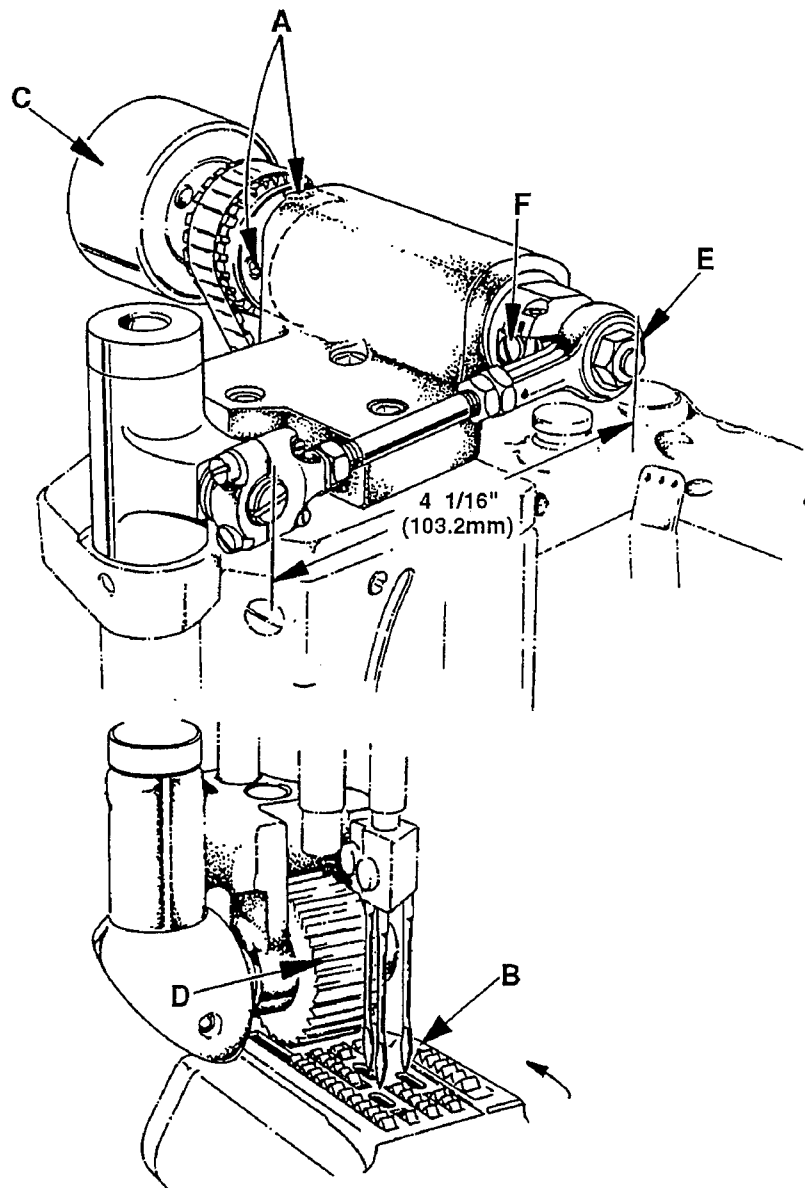
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UPPER ROLLER FEED AND THREAD TENSION PARTS

Ref. No.	Part No.	Description	Amt. Req.
1.	61257G	Roller Presser Spring Regulator	1
2.	61256G	Roller Presser Spring Washer	1
3.	35873Z	Roller Presser Spring	1
4.	35873AH	Presser Bar Connection Guide	1
5.	89	Screw	1
6.	22764	Screw	1
7.	22764A	Screw	1
8.	35877AJ	Roller Presser Bar	1
9.	35878T	Presser Bar	1
10.	35832A	Spring	1
11.	35843F	Presser Bar Regulator Screw	1





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ADJUSTING INSTRUCTIONS

When adjusting the puller the following steps should be taken.

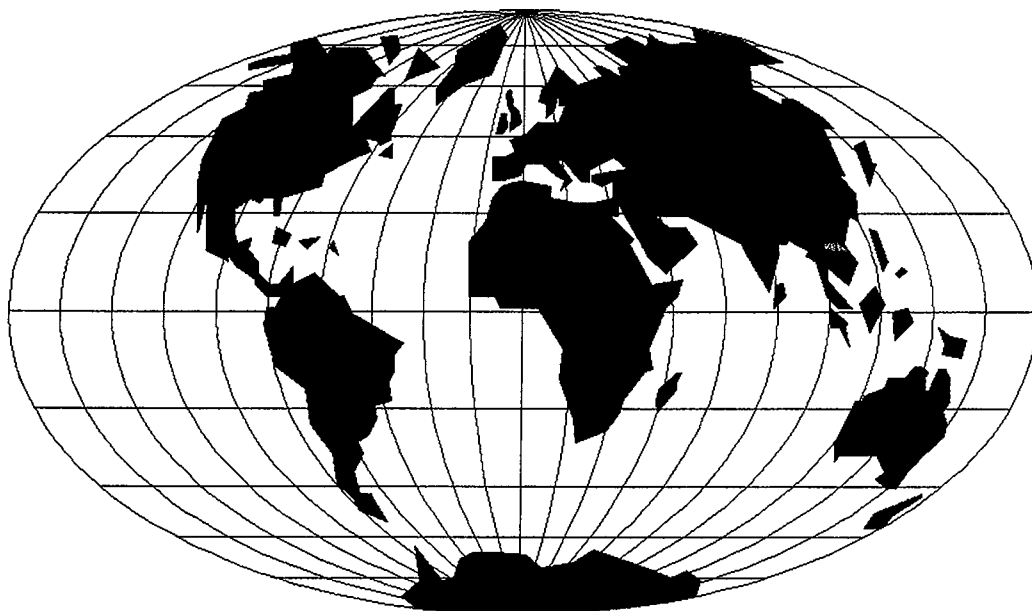
1. Timing of the Puller Mechanism:

Loosen two screws (A) in upper sprocket, rotate machine in operating direction until needle points are flush with top of throat plate (B). At this point, feed dogs are above throat plate but have not made any movement towards the rear. Rotate puller shaft (C) in operating direction until puller (D) shows some movement clockwise. At this time tighten two screws (A) in upper sprocket.

2. Setting Travel of Puller (stitch length):

Loosen nut (E) and turn screw (F) clockwise to shorten puller travel or counterclockwise to lengthen puller travel. Tighten nut (E). Sewing sample should be checked to assure that proper stitch length is obtained.





WORLDWIDE SALES AND SERVICE

Union Special Corporation maintains sales and service facilities throughout the world. These offices will aid you in the selection of the right sewing equipment for your particular operation. Union Special Corporation representatives and service technicians are factory trained and are able to serve your needs promptly and efficiently. Whatever your location, there is a qualified representative to serve you.

Corporate Office: One Union Special Plaza
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Fax: 847•669•1096

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