





# CATALOG NO. T118 H

# STYLES 36200 H 36200 J 36200 AH 36200 AJ

# HIGH SPEED CYLINDER FLATSEAMER MACHINES

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# Catalog No. T118 H (Supplement To Catalog No. 118L)

#### INSTRUCTIONS

### FOR

# ADJUSTING AND OPERATING

# LIST OF PARTS

### STYLES

36200	Н	36200	АН
36200	J	36200	ΑJ

#### First Edition

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# UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES CHICAGO

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#### 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 36200 H". 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 36200 HZ".

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: "Class 36200".

#### APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 118 L and should be used in conjunction therewith. Only the parts found on Styles 36200 H, J, AH and AJ but not on Styles 36200 A, B, X, AA, AB, AK or AX are illustrated and listed at the back of this catalog. At the back are illustrations identifying the parts by reference numbers and on the opposite pages will be found a listing of the parts, with their part number, descriptions and the number of pieces required. Any part that is a component of another part is indicated on the picture plate by having the reference numbers in a box or inside a bracket. On the copy page, a component of another part is indicated by indenting its description under the description of the assembly or complete part. Always use the part number in the second column, never use the reference number in the first column when ordering repair parts.

#### STYLES OF MACHINES

Feed-Off-The-Arm, High Speed, Medium Throw, Four Needles, One Looper, Six Thread, Manually Operated Differential Feed, Automatic Enclosed Type Oiling System and Filter Type Oil Return Pump, Visual Sight Oil Action and Supply Gauges, Space in Front of Needle 8 Inches.

- 36200 H LAP-SEAMER. Six threads for simultaneously trimming and lap seaming on men's briefs. For closing the crotch seam on men's knitted briefs, when the added strength of a reinforced seam is required. The right section is raised .050 inch (1.27 mm) which helps prevent uneven or "peaks" when sewing on and off the leg binding. Seam Specification 607-LSa-1. Maximum recommended speed 4200 R.P.M.
- 36200 J FLATSEAMER. Six threads for simultaneously trimming and flatseaming knit undergarments, infants' clothing, corsets, girdles, and similar knitted light to medium weight garments where seaming and closing elastic is necessary. Fitted with sewing components that produce a seam .236 inch (6 mm) wide, .032 inch (.813 mm) wider than on other 36200 styles. Seam Specification 607 FSa-1. Maximum recommended speed 4200 R.P.M.

36200 AH Same as Style 36200 H, except prepared for Pedestal Installation. 36200 AJ Same as Style 36200 J, except prepared for Pedestal Installation.

#### 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 midway 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 packaged and sold by Union Special.

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

For best results, use only genuine UNION SPECIAL needles in the operation of these machines. They are packaged under our brand name, , which is backed by a reputation for producing highest quality needles for more than three-quarters of a century.

Standard needle for Styles 36200 H, J, AH and AJ is Type 118 GKS-075/029. It has a round shank, round point, extra short, double groove, struck groove, spotted, .060 inch (1.52 mm)diameter shank, chromium plated, and is available in sizes 070/027, 075/029, 080/032.

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 118 GAS, Size 075/029".

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

### VIEWS AA and BB:

Thread as indicated in illustration on opposite page, starting with #4, progressing to 3, 2, 1, 5 and 6 in order and passing needle threads UNDER the stitch unlocking spring at needle thread frame eyelet "G".

VIEW CC:

Close-up of tension post assembly. A, Tension Nut; B, Spring; C, Post; D, Disc, upper; E, Disc, lower; F, Post Slot.

Pass threads thru slots "F" in tension post "C", and between tension discs "D" and "E".

VIEW DD:

Close-up of looper thread and cover thread take-ups.

VIEW EE:

Close-up of needle thread sequence.

#### OILING

Referring to illustration on opposite page, machine is filled at the caps "H" and "J". Use a straight mineral oil, with a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit. The level is checked at the two sight gauges "K" and "L", located on the right side of the main frame under the foot lifter lever and at the front of the cylinder, respectively. Maintain oil level between red lines of these gauges.

Automatic lubrication is featured with a continuously driven rotary pump. Flow of oil can be observed thru windows "M" and "N" in crank chamber cover and front top cover. When installing a new machine or starting one that has been idle for some time, priming may be necessary. To do so, remove the two plug screws "P", fill holes with recommended oil and replace screws BEFORE operating. If oil does not flow while machine is running, pump is inoperative.

Oil is drained from machine at two places, "Q" and "R". "R" is located below and back of drive pulley. Belt cover must first be removed. When replacing the screw at "Q" be sure the hole in the filter box, that the screw goes into, lines up with the hole in the bottom of the cylinder.

Occasionally, it is necessary to oil the linkage of the presser foot, the knife holder shank No. 36273 A, guide collar No. 36273 K and the various links and bearings of the presser foot lifting mechanism and thread tension release.



#### INSTRUCTIONS FOR SEWING ADJUSTMENTS

In addition to the "INSTRUCTIONS FOR SEWING ADJUSTMENTS" covered in Catalog No. 118 L, the following instructions will apply to the Styles 36200 H and AH covered in this supplement catalog.

The lap former (A, Fig. S) must be centered in the presser foot slot. This can be accomplished by loosening screws (B) which will allow the positioning of the lap former within its elongated holes. The gibs (C) must be set so the lap former slide block (located under the lap former) will have a snug (not tight) fit, the entire length of the gibs. This can be accomplished by loosening screws (D), reposition gibs as required and retightening the screws.



Fig. S

The only difference in the "INSTRUCTIONS FOR SEWING ADJUSTMENTS" covered in Catalog No. 118 L and the adjustment for 36200 J and AJ is:

In the "Needles and Needle Bar" instructions, with the Needle Bar motion at its highest point of travel, the fourth or lowest needle should be 1/2 inch (12.7 mm) from the top of throat plate on 36200 J and AJ (this adjustment may be obtained by using needle gauge 21227 DS), compared to the 17/32 inch (13.49 mm) measurement used for 36200 H and AH (using needle gauge 21227 BU).

## EXPLODED VIEWS.

# AND

# DESCRIPTION OF PARTS

# PECULIAR TO

# STYLES 36200 H, J, AH and AJ

# HIGH SPEED CYLINDER FLATSEAMER MACHINES





# PRESSER FOOT, LAP FORMER, CYLINDER COVER, GIBS THROAT PLATE AND FEED DOGS (FOR STYLES 36200 H AND AH)

Ref. No.	Part No.	Description	Amt. <u>Req.</u>
1	36220	Presser Foot Assembly	1
2	36230	Yielding Section, marked "AH"	1
3	22565	Screw	1
4	36230	Yielding Section Spring	î
5	36230	Presser Foot, marked "BP" (late parts have part	-
J	20220	number)	1
6	94	Screw	1
7	36251	Cross Cover Thread Hook	1
8	22562	Screw	
9	36251	Cover Thread Hook Driving Lever and Shaft	1
10	22738	Screw, for link pin	
11	36251	Link, for cover thread carrier and hook driving	
	00201	lever	
12	36251	Link Pin	4
13	36251	Cover Thread Carrier and Hook Driving Segment	1
14	36251	Cover Thread Carrier Driving Lever and Shaft	
15	36251	Cover Thread Carrier, marked "A"	1
16	22565	Screw	
17	22731	Screw	1
18	36279	Spring, for chip guard	1
19	36279	Chip Guard	1
20	150	Screw	1
21	36230	Cloth Guide Plate, marked "T"	1
22	22716	Screw	1
23	36250	Stationary Knife	1
*24	36250	Stationary Knife Clamp, .326 inch (8.28 mm)	_
24	50250	Bright Finish	1
*	36250	Stationary Knife Clamp, .318 inch (8.08 mm)	
		Black Finish	
25	22738	Screw	
26	36232	Presser Foot Shoe, right	1
27	36231	Presser Foot Shoe, left	1
28	36230	Shoe Holding Wire	1
29	23420	B Lap Former	1
30	22738	Screw, for lap former	1
31	73	Screw, for lap former	1
32	36283	Gib. right	1
33	23423	Lap Former Slide Block	1
34	36283	Gib. left	- 1
35	23424	Lap Former Slide Block Spring	1
36	22716	Screw	1
37	36283	Cylinder Cover	1
38	36224	Throat Plate, .050 inch (1.27 mm) step on right side-	
40	36240	Stitch Tongue, marked "D"	- 1
41	36205	Main Feed Dog, marked "PR", 14 t.p.i.	
71	50205	(1.83 mm per tooth)	- 1
42	36226	Differential Feed Dog, marked "PQ", 14 t.p.i.	
76	50220	(1.83 mm per tooth)	- 1

\* When replacing the stationary knife clamp, order the clamp that has the same finish as the one being replaced.



# BALL JOINT, LEVER, NEEDLE BAR HEAD, PRESSER FOOT AND THROAT PLATE (FOR STYLES 36200 J AND AJ)

Ref.	Part No.		Description	Amt.
<u>No.</u>	110.		Description	<u>Req</u> .
1	36251	Y	Cover Thread Carrier and Hook Driving Connecting Rod Ball Joint	1
2	97	A	Ball Joint	
3	36251	v	Sleeve Driving Lever	1
4	22585		Screw	1
5	36218	J	Needle Bar Head	
6	22738	н	Screw	5
7	96651		Roll Pin	5
8	36220	К	Presser Foot Assembly, for Styles 36200 J, AJ	1
9	22565	А	Screw	2
10	36230	J	Yielding Section, marked "AP"	1
11	36230	С	Spring	1
12	36251	FA	Cover Thread Hook	1
13	22562	A	Screw	
14	36230	U	Presser Foot, marked "BT"	1
15	94		Screw	1
16	36251	н	Cover Thread Hook Driving Lever and Shaft	1
17	22738	В	Screw	
18	36251	U.	Link, for cover thread carrier and hook driving	
			1ever	2
19	36251	К	Link Pin	
20	36251	L	Cover Thread Carrier and Hook Driving Segment	1
21	36251	G	Cover Thread Carrier Carrier Driving Lever and	
			Shaft	1
22	22731		Screw	1
23	36279	D	Spring	
24	36279	C	Chip Guard	1
25	36251	W	Cover Thread Carrier, marked "B"	1
26	150		Screw	1
*27	36250	Ģ	Stationary Knife Clamp, .326 inch (8.28 mm) Bright Finish	1
* _	36250	В	Stationary Knife Clamp, .318 inch (8.08 mm)	
			Black Finish	1
28	22738	G	Screw	2
29	36232		Presser Foot Shoe, right	
30	36231		Presser Foot Shoe, left	1
31	36250		Stationary Knife	1
32	36230		Shoe Holding Wire	1
33	36224		Throat Plate	1
34	22716		Screw	1
35	36240		Stitch Tongue, marked "AC"	1
# -	21227		Needle Height Gauge (not shown)	
"				

\* When replacing the stationary knife clamp, order the clamp that has the same finish as the one being replaced.

# Available as extra send and charge item.





## WORLDWIDE SALES AND SERVICE

Union Special Corporation maintains sales and service facilities throughout the world. These offices will ald 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. Brussels, Belgium Charlotte, N.C. El Paso, TX Hong Kong, China Huntley, IL Leicester, England Lille, France Miami, FL Milan, Italy Möglingen, Germany Montreal, Quebec Osaka, Japan Santa Fe Springs, CA

Other Representatives throughout all parts of the world.



