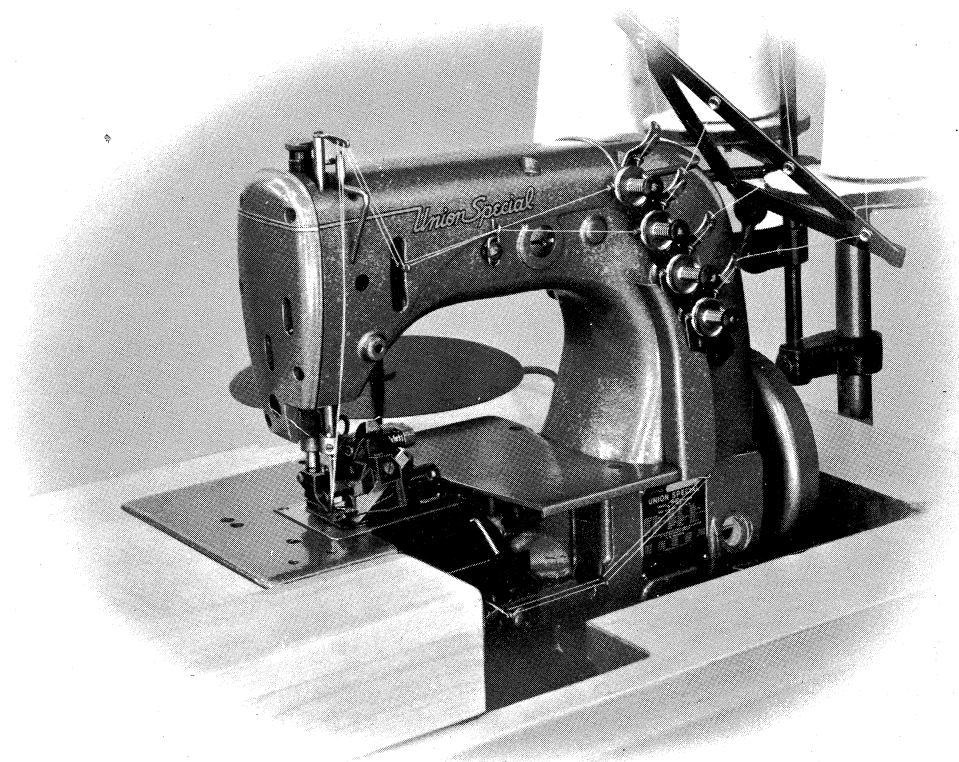




Union Special[®]
LEWIS[®] • COLUMBIA[®]

INDUSTRIAL
SEWING
MACHINES

STYLE
51400 BJ



CATALOG

T107 L

Second
Edition

LIST OF PARTS
FOR
STYLE 51400 BJ

UNION SPECIAL CORPORATION

CHICAGO

Catalog No. T107 L

LIST OF PARTS

Style

51400 BJ

Second Edition

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UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES

CHICAGO

Printed in U.S.A.

May, 1980

IDENTIFICATION OF MACHINE

Each UNION SPECIAL machine carries a Style number which is stamped in 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 51400 BJ". 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: "51400 BJZ".

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 51400. 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

51400 BJ Streamlined Flat Bed, Two Needle, Two Loopers, Upper and Under Feed, Trimmer, With Front Disposal of Trimmings, Light Weight Presser Bar and Needle Bar, Light Weight Needle Bar Driving Mechanism, Automatically Lubricated. For Seaming and Binding Dresses, Aprons; Also Seaming Trouser Pockets by "Nu-Pocket" Method. Seam Type BSc-2, Stitch Type 401. Standard Gauge No. 10.

NEEDLES

Each UNION SPECIAL needle has both a type number and a 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 across the eye. Collectively, type number and size number represent the complete symbol.

Standard needle for Style 51400 BJ is Type 108 GKS. It is a round shank, round point, extra short, double groove, struck groove, oversize ball eye, spotted, chromium plated, and is available in sizes 080/032, 090/036, 100/040. Unless otherwise specified, the machine will be equipped with size 090/036.

To have needle orders promptly and accurately filled, the empty package, a sample needle, or type and size number should be given. Use description on label. A complete order would read: "1000 Needles, Type 108 GKS, Size 090/036".

Selection of proper needle size should be 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 this machine can be secured only with the genuine UNION SPECIAL needles. Genuine needles are packaged with labels marked *Union Special*®. This is your guarantee of needles of the highest quality in materials and workmanship.

OILING

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

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

The machine is automatically lubricated, and no oiling other than keeping the main reservoir filled is necessary.

A daily check before the morning start should be made, and oil added if required. Excessive oil in the main reservoir may be drained at the plug screw in main frame, directly under the handwheel.

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	8	Feed Rocker Shaft	1	660-625	Oil Seal Ring for	1	22570 B	Screw for 51278 D
3	18	Nut for 57840,			56350 D (22586 R)	15	22571 A	Plug Screw for bed
		55241 N, 55244 G	2	666-65	Oil Wick for 51244 K	1	22571 B	Plug Screw for bed
2	20	Washer for 539,	2	666-111	Oil Wick for 8	1	22580 D	Set Screw for 51223 A
		51236 G	2	666-114	Oil Wick for right	2	22585 A	Screw for 51282 AF
1	27-435	Needle Bar Eyelet			main shaft	1	22585 B	Screw for 51425 E
	Blk.	Washer	2	666-118	Oil Wick for left	1	22586 R	Screw for 660-625
2	50-216	Pin for 51257 T			main shaft	1	22588 A	Screw for 52350 A
	Blk.		1	666-121	Oil Felt for 51493 E	1	22596	Screw for 21657 Y
1	50-294	Pin for 51493 AH	1	666-123	Felt for 51193 X	1	22711	Screw for 52372 A
	Blk.		1	666-138	Felt (90)	2	22729	Screw for 51243 C,
1	50-648	Lucite Oil Gauge	1	666-149	Felt for 51054			51472 B
	Blk.		1	666-170	Felt Wick for 51134 V	1	22729 A	Screw for 51294 U
1	50 J-16	Stop Pin for 51417 C	2	666-179	Wedge Pin for	1	22729 B	Screw for 51294 U
2	73	Screw for looper			666-111	2	22729 C	Screw for 55241 N
1	77	Screw for 52336 A	1	666-201	Felt Plug for 51294 U	2	22730	Screw for 51278
3	77	Screw for 51236 A	1	666-208	Felt for 51294 W	1	22733 B	Plug Screw for
2	77	Screw for 51054,	1	666-209	Felt Plug for 51294 U			52882 L (41394 A)
		51204 C	1	666-214	Felt for 51294 M	1	22758 C	Screw for 53783 A
3	80	Screw for 51401 R	2	667 B-		1	22760 A	Screw for 13430 D
1	81	Screw for 51242 Y		10	Dowel Pin for 51273 A	3	22768	Screw for 51244 B,
		(12982)	2	668-25	Steel Eyelet for			56458, 56458 A
1	82	Screw for 51236 G			51292 D	2	22768	Screw for 51236 B
2	87	Screw for 51424 S-10	2	668-28	Locking Ring for	2	22798	Screw for 51472 A
2	J87 J	Screw for 51204 C			51292 D	1	22798 A	Screw for 51204 A
2	87 U	Screw for 23322 AG	2	719	Screw for 29348 AF,	1	22799 F	Screw for 51420 S
2	88	Screw for 15465 F			56350 D	1	22801	Pivot Screw for
2	88	Screw for 14649	1	1740	Stop Pin for 51420 S			51425 E
1	88	Screw for 52894 AK	2	6042 A	Washer for 51135 P	1	22811 B	Screw for 51242 W
2	88 B	Screw for 51134 S	1	6042 A	Washer for 52894 AM	1	22829	Screw for 51745 (258 A)
2	88 B	Screw for 51418 F	1	7947	Nut for 51294 R	1	22834	Adjusting Screw for
1	89	Spot Screw for 51418 F	1	12538	Nut for 51241 K			needle guard
1	90	Screw for 23439 A	1	12957 E	Spring Washer for	*2	22839	Screw for 52980 A
2	90	Screw for 52882 AD			23437 E	2	22839 C	Screw for 51401 R
1	90	Screw for 666-138	1	12982	Lock Nut for 81	1	22848	Screw for 539 (20)
2	90	Screw for 56382 AC	1	13430 B	Shank for 51420 S (91)	9	22848	Screw for 52882 L
3	90	Screw for 52894 AB	1	13430 D	Spring for 51420 S	1	22852	Screw for 52934 D
2	90	Screw for 23437 K			(22760 A)			(51216 N)
1	91	Screw for 13430 B	3	14649	Collar for 8 (88)	1	22852 A	Screw for 51242 Y
2	93	Screw for BB21375 AH	1	15465 F	Diff. Rocker Cone for			(51242 M)
1	93 A	Screw for 51426 S			29192 D (88)	1	22863	Tilting Screw for
1	95	Screw for 51270 B	2	21212	Oil Siphon Conn.			52934
1	95	Plug Screw			Locking Ring	1	22883 A	Plug Screw for bed
2	95	Screw for 51147	1	BB21375 AH	Belt Guard (93)	1	22889 A	Plug Screw for 539
1	HA95	Adjusting Screw for	1	21657 E	Washer for 51257 T	2	22889 C	Plug Screw for bed
		51134 N	1	21657 W	Tension Release	1	22889 D	Plug Screw for bed
1	96	Spot Screw for			Lever Shaft	4	22894 C	Set Screw for
		51223 A	1	21657 X	Release Lever Bush.			29105 AA
1	96	Screw for 51244	1	21657 Y	Connection (402,	1	22894 C	Set Screw for 52372 A
2	97 A	Screw for 51241 K			22596)	2	22894 C	Screw for 51273 B
1	98	Screw for 51244	1	21657-4	Tens. Release	1	22894 D	Spot Screw for
3	98 A	Screw for 158 B			Separator			29105 AA
1	98 A	Screw for 51291 A	3	22513	Screw for 35731 A	1	22894 D	Screw for 29476 DP
8	109	Tension Disc	2	22517	Screw for 51273 A	1	22894 D	Screw for 29476 DR
3	158 B	Thread Eyelet (98 A)	1	22519 H	Screw for 51244 B	2	22894 F	Set Screw for 51221 C
1	258	Nut for 51134 HA	6	22524	Screw for 51282 AF	1	22894 H	Screw for 51242 W
1	258	Nut for 51280 E	1	22528	Screw for 51257 T	2	22894 J	Screw for 51247
1	258 A	Nut for 660-136			(21657 E)	1	22894 T	Screw for 29476 HZ
1	258 A	Nut for 52894 AM	1	22528	Screw for 51405 S-8	1	22894 T	Screw for 29476 JN
1	258 A	Check Nut for 29192 D	1	22537	Screw for 53783 N	1	23322 M	Washer for 23322 AG
2	269	Nut for 51236 G, 57840	1	22539 H	Plug Screw for bed	1	23322 AG-	
1	402	Screw for 21657 Y	1	22539 R	Plug Screw for bed		3/4	Binder for 3/4 inch
1	402	Screw for 53783 A	3	22541 B	Screw for 52882 AD			binding (87 U,
1	531	Screw for 51257 M	1	22542	Screw for 51282 Y			23322 M)
2	531	Screw for 51493 BQ	1	22547 C	Screw for 51478	1	23322 AG-	
1	538	Height Adj. Screw			(51250 C)		7/8	Binder for 7/8 inch
		for 52934	4	22548	Screw for 52882 AE			binding (87 U,
1	539	Frame Ndl. Thd. Eye.	1	22557 B	Screw for 53783 L			23322 M)
		(20, 22848, 22889 A)	2	22559 A	Lower Cap Screw for	1	23322 AG-	
1	604	Screw for 51430 L			29105 AA		1	Binder for 1 inch
1	643-127	Oil Pump Hous. Gasket	2	22559 B	Upper Cap Screw for			binding (87 U,
	Blk.				29105 AA			23322 M)
1	660-90	Felt Wiper for 29105 AA	2	22559 G	Screw for 29066 R	1	23437 E	Screw for 23437 H
1	660-136	Feed Crank Link Oil	1	22560 B	Screw for 52934	1	23437 H	Binder Mounting
		Tube (258 A)	2	22560 B	Screw for 51493 BP			Bracket (12957 E,
1	660-169	Needle Bearing for	1	22562 A	Screw for 51254 K			23437 E)
		51236 E	1	22564	Screw for 52336 A	1	23437 J	Binder Holder
1	660-202	"O" Ring for pulley	1	22568	Screw for 51450			Bracket for 23437 H
1	660-207	Oil Seal Ring for foot	3	22569 B	Screw for bearing	1	23437 K	Binder Mounting
		lifter lever bushing			housing			Bracket Base for
1	660-614	Temper Load Ring for	5	22569 B	Screw for 51282 Y			23437 H (90)
		56350 D	3	22569 B	Screw for 51493 AH	1	23439 A	Pin Tension (90)

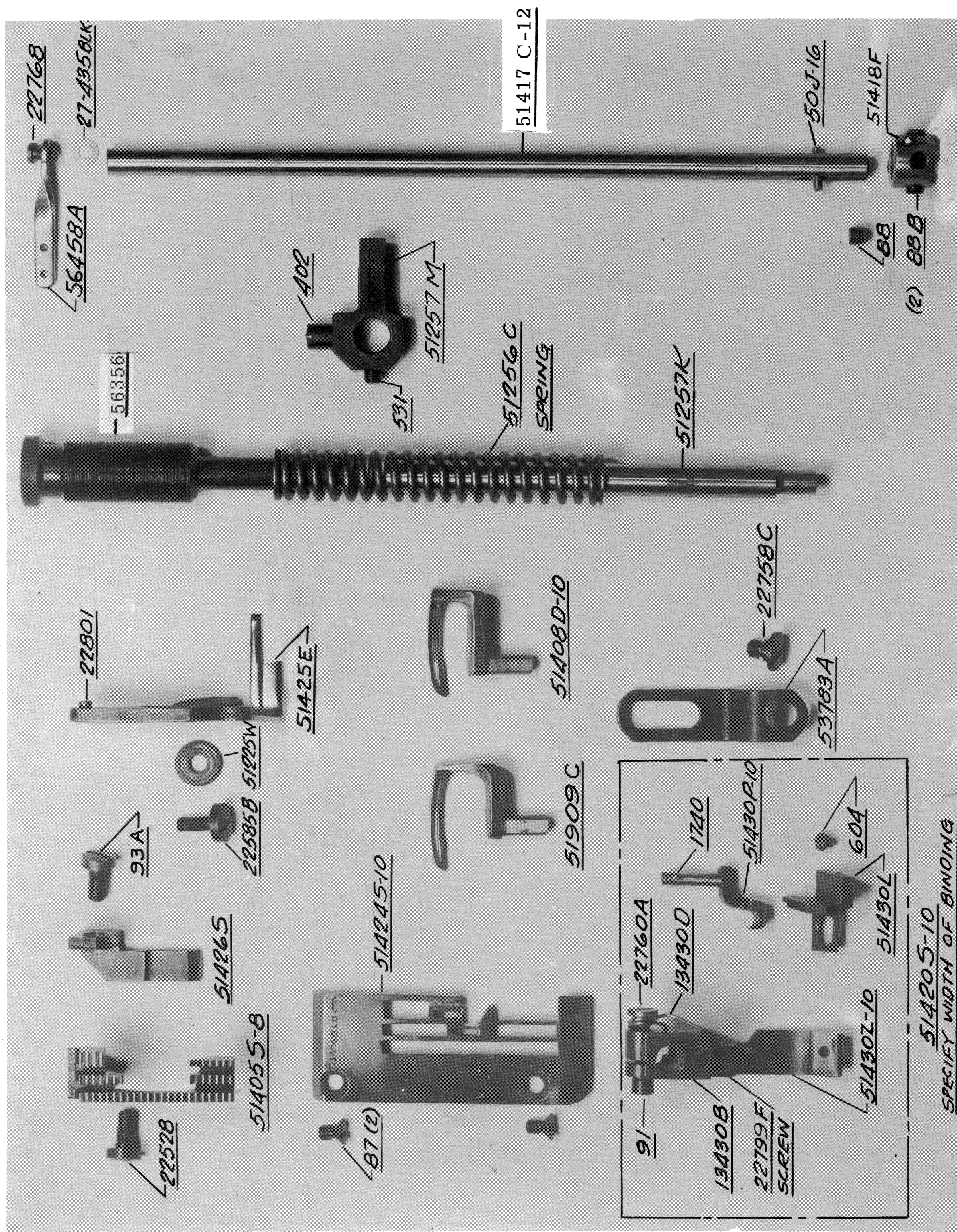
*For old Style 52980 A, use countersunk head screw No. 80.

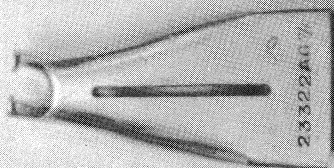
Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	29066 R	Upper Needle Lever Connecting Rod Ball Joint Assembly (22559 G)	1	51236 B	Feed Crank Stud Cap (22768)	1	51282 Z	Head Cover Gasket
1	29105 AA	Looper Drive Eccentric Assembly, .220 inch throw	1	51236 D	Link for 51236 E	1	51282 AF	Oil Reservoir Top Cover (22524, 22585 A)
1	29192 D	Looper Rocker Assembly	1	51236 E	Feed Crank Link Assembly	1	51283 H	Presser Foot Lifter and Tension Disc Release Lever
1	29348 AF	Needle Lever Assembly	1	51236 F	Ferrule for 51236 E	1	51290 R	Bushing for 52891 B
1	29476 DP	Upper Feed Lift Eccen. Assembly, .140 inch throw	1	51236 G	Feed Crank Stud (20, 82, 269)	1	51290 T	Main Shaft Bushing, center
1	29476 DR	Feed Lift Eccentric Assembly, lower .080 inch throw	1	51241 K	Looper Connecting Rod and Ball Joint, right (12538)	1	51291 A	Looper Thread Guard (98 A)
1	29476 HJ	Crankshaft Assembly, .770 inch throw	2	51242 L	Thrust Washer for 51242 P	4	51292 A	Tension Post Ferrule
1	29476 HZ	Knife Drive Eccen. Assembly, .140 inch throw	2	51242 M	Washer for 22852 A, 52841 G	4	51292 C	Tension Post Nut
1	29476 JN	Looper Avoid Eccen. Assembly, .062 inch throw	1	51242 P	Looper Drive Lever Shaft (51242 L)	4	51292 D	Tension Thread Eyelet
2	35178 D	Spring for 666-114	1	51242 R	Looper Drive Lever Shaft Bushing, middle	2	51292 F-4	Tension Spring, looper
2	35178 D	Spring for 666-65	1	51242 S	Looper Drive Lever Shaft Bushing, rear	2	51292 F-8	Tension Spring, needle
2	35731 A	Presser Bar Conn. Guide Plate (22513, 51294 R)	1	51242 W	Looper Drive Lever (22811 B, 22894 H)	4	51292 G	Tension Post (43266)
1	35766	Screw for 51450	1	51242 Y	Looper Drive Lever Rocker (81, 22852 A)	1	51294 K	Upper Clamp for 51294 U
1	39158 G	Hinge for 51278	1	51242 Z	Looper Drive Lever Shaft Bushing, front	1	51294 M	Oil Tube
1	39158 U	Spring for 51278	1	51243 C	Ball Stud Fork (22729)	1	51294 P	Oil Tube Clamp (7947)
1	39552 C	Washer for 53783 N	1	51244	Looper Rocker Frame (96, 98)	1	51294 R	Screw for 51294 P
1	39582 L	Oil Cap for 52882 AD	1	51244 B	Looper Rocker Shaft Arm (77, 22519 H)	1	51294 U	Oil Siphon Assembly
2	41394 A	Gasket for 22733 B	1	51244 K	Looper Rocker Shaft (51244 L)	1	51294 W	Oil Tube for 51273 D
2	43266	Nut for 51292 G	2	51244 L	Thrust Washer for 51244 K	1	51294 Z	Oil Tube Connection (21212)
1	51054	Feed Crank Link Pin (77, 666-149)	1	51244 N	Looper Rocker Shaft Collar (18, 55244 G)	1	51382 A	Gasket for 51282 AF
1	51134 C	Feed Bar Shaft	1	51246	Looper Rocker Stud Nut	1	51401 R	Cloth Plate (80, 22839 C)
1	51134 J	Washer for 51134 HA	1	51247	Main Shaft Counterweight (22894 J)	1	51405 S-8	Lower Feed Dog (22528)
1	51134 N	Spring for 52934 A (HA 95)	1	51250 C	Nut for 22547 C	1	51406	Eccentric for 29476 JN (22894 T)
1	51134 S	Upper Feed Bar Shaft (88 B)	1	51250 D	Washer for 22586 R	1	51408 D-10	Looper, front (73)
1	51134 V	Taper Pin for 52934 B	1	51250 F	Gasket for 22586 R	1	51417 C-12	Needle Bar (50 J-16)
1	51134 HA	Feed Dog Holder (258)	1	51254 C	Upper Needle Bar Bushing	1	51418 F	Needle Clamp Collar (88 B, 89)
1	51135 P	Feed Rocker Arm (6042 A, 55235 D, 55235 E)	1	51254 D	Lower Needle Bar Bushing	1	51420 S-10-3/4	Presser Foot for Style 51400 BJ-10-3/4
1	51142 B	Eccentric for 29476 DP, 29476 HZ	1	51254 K	Needle Bar Conn. for 29348 AF (22562 A)	1	51420 S-10-7/8	Presser Foot for Style 51400 BJ-10-7/8
1	51142 C	Eccentric for 29476 DR	1	51256 C	Presser Bar Spring	1	51420 S-10-1	Presser Foot for Style 51400 BJ-10-1
1	51145 A	Eccentric Link Assembly	1	51257 K	Presser Bar	1	51422 E	Main Shaft
1	51147	Main Shaft Collar (95)	1	51257 M	Presser Bar Conn. and Guide (531)	1	51424 S-10	Throat Plate (87)
1	51193 X	Oil Tube for upper feed bar pin (666-123)	1	51257 T	Cast-off Plate Support (22528)	1	51425 E	Needle Guard (22585 B, 51225 W)
1	51204	Looper Thread Retaining Finger (22798 A)	1	51257 AA	Lower Presser Bar Bushing	1	51426 S	Upper Feed Dog (93 A)
1	51204 A	Looper Thread Retaining Finger Holder (77, 22798 A)	1	51270 B	Needle Thread Take-up Wire (95)	1	51430 L	Knife Guard for 51420 S-10 (604)
1	51204 B	Auxiliary Cast-off	1	51272 C	Block Guide Collar Shaft	1	51430 P-10-3/4	Yielding Section for 51420 S-10-3/4
1	51204 C	Cast-off Finger Support Bracket (J87 J, 77)	1	51272 D	Block Guide Collar Shaft Spring	1	51430 P-10-7/8	Yielding Section for 51420 S-10-7/8
2	51216 G	Needle Lever Connecting Rod	1	51273 A	Upper Knife Holder Bracket (22517)	1	51430 P-10-1	Yielding Section for 51420 S-10-1
28	51216 M	Needle Bearing Roller for 29476 HJ	1	51273 B	Upper Knife Holder Rocker Stud (22894 C)	1	51430 Z-10	Presser Foot Bottom for 51420 S-10
3	51216 N	Washer for 22852, 55244 G, 56315 A	1	51273 D	Upper Knife Holder Rocker Arm	1	51449	Knife, lower
1	51216 P	Nut for 56315 A	1	51278	Chip Guard Assembly (22730)	1	51450	Lower Knife Holder Block (22568, 35766)
1	51221 C	#1 "V" and Round Belt Pulley (22894 F)	1	51278 A	Chip Guard for 51278 Spring (22570 B)	1	51470	Knife, upper
1	51223 A	Take-up (96, 22580 D)	1	51278 D	Hinge Pin for 51278	1	51472 A	Upper Knife Shield (22798)
1	51225 W	Washer for 22585 B	1	51280 E	Throat Plate Support Pin (258)	1	51472 B	Upper Knife Clamp (22729)
1	51236 A	Link Pin for 51273 D (77)	2	51280 J	Dowel Pin for 52980 A	1	51478	Front Cover and Chip Guard Latch (22547 C, 51250 C)
2	51236 A	Feed Lift Eccentric Link Pin (77)	1	51282 Y	Head Cover (22569 B)	4	51491 C	Lead-in Thread Eye.
1	51236 A	Looper Avoid Eccentric Link Pin						

Amt.	Part No.	Description	Amt.	Part No.	Description	Amt.	Part No.	Description
1	51493 B	Gear Stud for 51493 AG	1	52882 AC	Oil Cap Torsion Spr. for 52882 AD	1	53783 N	Presser Foot Lifter Lever, internal (22537)
1	51493 D	Pump Driving Shaft	1	52882 AD	Chamber Cover (22541 B)	2	55235 D	Screw for 51135 P
2	51493 E	Driving Shaft Gear	1	52882 AE	Crank Chamber Cover (22548)	2	55235 E	Nut for 51135 P
1	51493 AG	Oil Pump Housing	1	52883 R	Presser Foot Lifter Lever Bushing	1	55241 N	Looper Connecting Rod Ball Joint, left (18)
1	51493 AH	Pump Housing Cover (22569 B)	1	52883 S	Presser Foot Lifter Lever Bell Crank	1	55244 G	Looper Shaft Collar Stud (18, 51216 N)
1	51493 BK	Lint Filter Screen	2	52890 C	Main Shaft Bushing, left and inner right	1	56315 A	Needle Lever for 29348 AF (51216 N, 51216 P)
1	51493 BP	Pump Driving Gear (22560 B)	1	52891 B	Main Shaft Housing (22569 B)	1	56341 G	Spring for 51241 K
1	51493 BQ	Pump Driven Gear (531)	3	52894 AB	Oil Tube Holder (90)	1	56350 D	Needle Lever Stud (719, 660-625)
1	51494 E	Oil Tube for upper and lower feed lift eccentric	1	52894 AK	Oil Tube for looper rocker and left ball joint (88)	1	56350 E	Thrust Collar for 56350 D
1	51513	Looper Rocker for 29192 D	1	52894 AM	Oil Tube for right ball jt. (258A, 6042A)	1	56350 F	Thrust Washer for 56350 D
1	51745	Rocker Cone Stud (22829, 51246)	1	52934	Feed Bar, tiltable	1	56354 D	Needle Bar Link for 29348 AF
1	51909 C	Looper, back (73)	1	52934 A	Upper Feed Bar (HA95)	1	56356	Presser Spring Regulator
2	52336 A	Link Pin for 29348 AF (77, 22564)	1	52934 B	Upper Feed Bar Arm	1	56382 X	Tension Post Support Bracket
1	52350 A	Knife Holder Plate (22588 A)	1	52934 C	Rubber Stop Pad	1	56382 AC	Bearing Oiler Assembly (90)
1	52372	Upper Knife Holder Block (22711)	1	52934 D	Top Feed Holder (22852)	1	56383 AB	Presser Foot Lifter Lever Connecting Rod
1	52372 A	Upper Knife Holder Block Guide Collar (22711, 22894 C)	1	52934 E	Lubricating Felt Guard	1	56390 E	Gasket for 52891 B
2	52373 A	Bushing for 51273 D	1	52934 F	Lubricating Felt Guard	1	56458	Needle Lever Thread Eyelet (22768)
1	52470	Stop for looper connecting rod	2	52936	Feed Rocker Shaft Bushing	1	56458 A	Needle Bar Thread Eyelet (27-435 Blk., 22768)
1	52841 G	Locking Stud for 51242 Y (51242 M)	1	52944 T	Looper Rocker Shaft Bushing, left	1	57840	Looper Connecting Rod (18, 269)
1	52841 J	Nut for 52841 G	1	52944 U	Looper Rocker Shaft Bushing, right	2	92127	Screw for 52935
1	52882 L	Oil Reservoir Back Cover (22733 B, 22848)	*1	52980 A	Throat Plate Support (80 or 22839)			
1	52882 M	Gasket for 52882 L	1	53783 A	Lifter Lever Link (402, 22758 C)			
1	52882 P	Gasket for 52882 AD	1	53783 L	Presser Foot Lifter Lever Bell Crank (22557 B)			
1	52882 U	Gasket for 52882 AE						
1	52882 W	Gasket for 51282 Y						
1	52882 AA	Drip Plate for 52882 AD						

*For old Style 52980 A, use countersunk head screw No. 80.

NOTE: Numbers in parenthesis following parts' descriptions indicate the screws, nuts, etc. used to attach or hold those parts.





23322AG

SPECIFY WIDTH OF BINDING

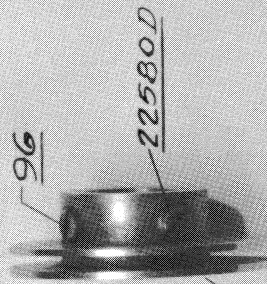


23322M



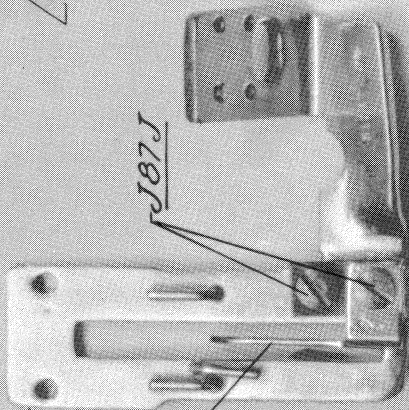
87U

96



22580D

51223A



J87J

51204B



51204

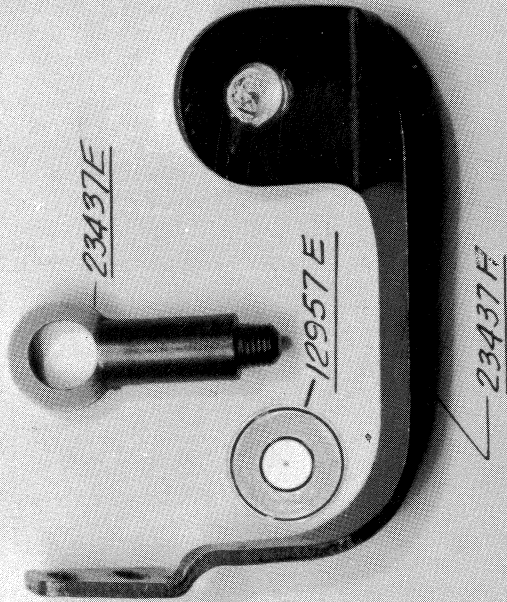
77

51204C

22528



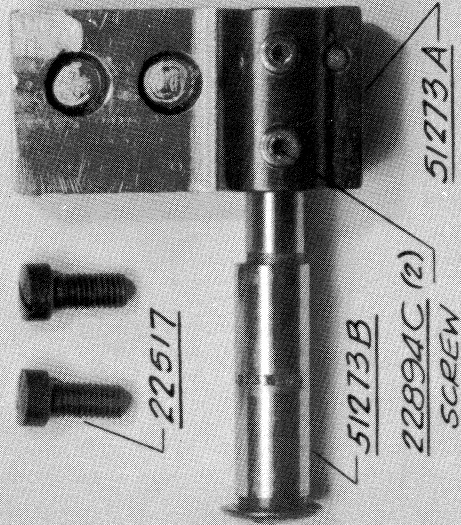
21657E



23437E

12957E

23437F

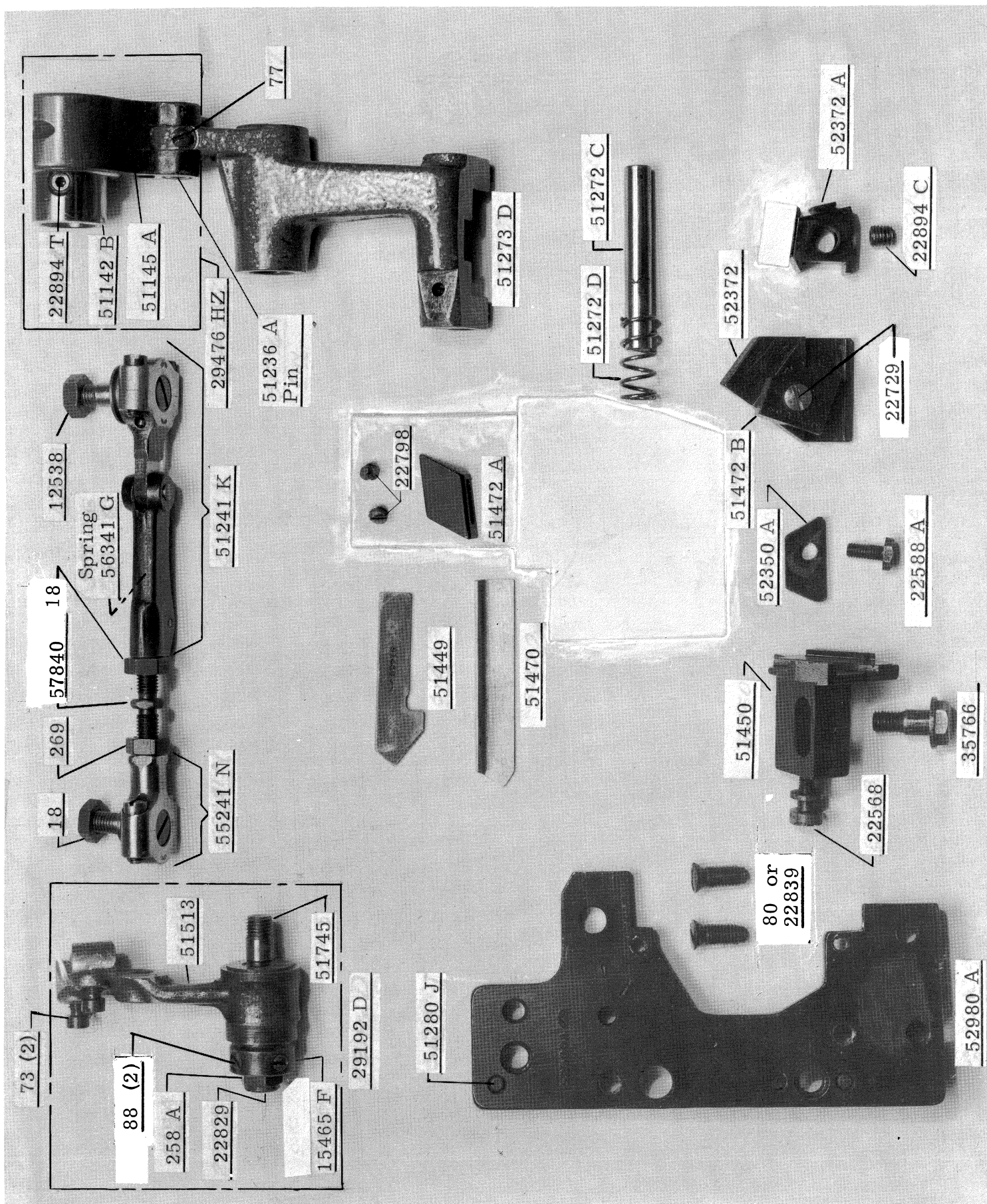


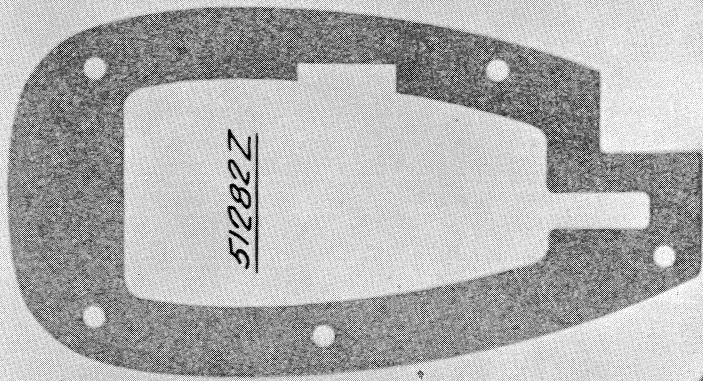
51273B

22894C (2)

SCREW

51273A



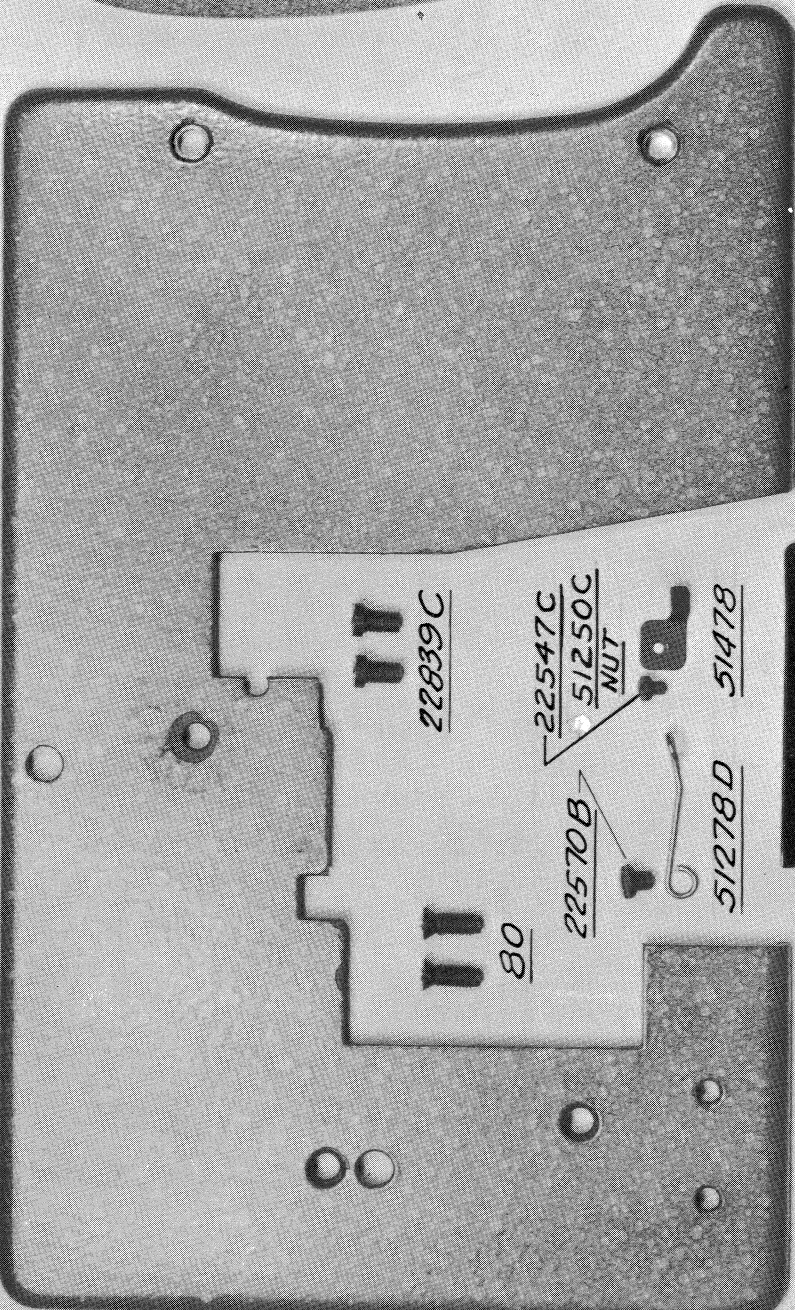


51282Z

22569B



51282Y



22839C

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22547C

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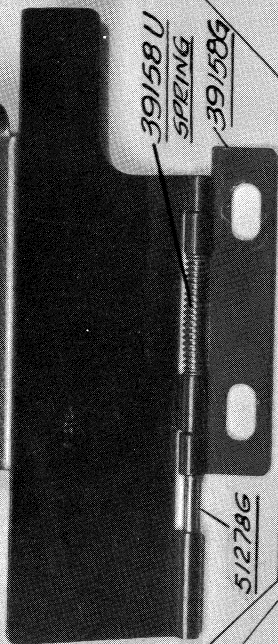
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51401R

22542

SCREW

51278A



39158U

SPRING

39158G

51278G

22730 (2)

51278



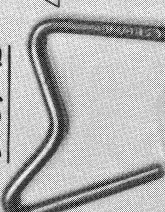
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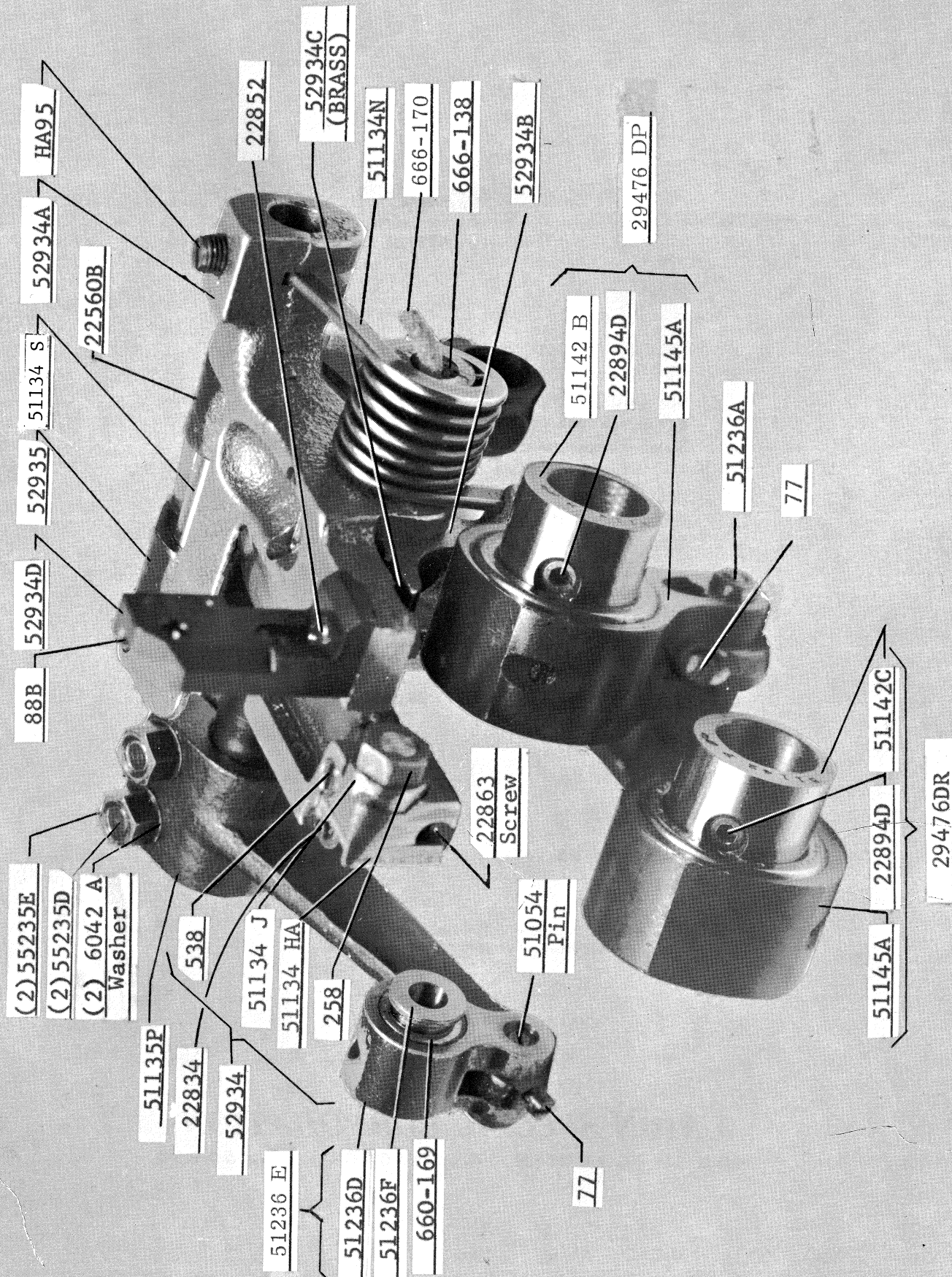
20

51758

98A

-158B







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