

UNITED

VERTICAL BORDER MACHINE

PARTS MANUAL

MATPARTS

Matparts2006

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
(BASE DRIVE)				
BM-2	4	Main Frame	1	1
BM-3	4,5	Speed Reducer	1	1
BM-4	5	Slide Traverse	1	1
BM-5	5	Main Lever	1	1
BM-7	5	Guide-Traverse Slide	2	2
BM-8	4,5	Brace-Roll Carrier	2	2
BM-9	4	Roll Carrier-Traverse Slide	2	2
BM-11	5	Stud-Traverse Adjustment	1	1
BM-12	5	Pin-Lever Bracket	1	1
BM-13	5	Lever Bracket-Sewing Mach.	1	1
BM-14	3	Shaft-Sewing Machine Drive	1	1
BM-15	2	Bushing-Main Lever	2	2
BM-16	5	Support-Lever Shaft	2	2
BM-17	5	Guide Block-Main Lever	2	2
BM-18	6	Crosshead Slide	2	2
BM-19	4,5,6	Roll-Cam	3	3
BM-20	4,5	Stud - Cam Roll	2	2
BM-21	3	Motor Pulley Flange	1	1
BM-22	3	Motor Pulley Hub	1	1
BM-23	5	Shaft-Main Lever	1	1
BM-25	6	Lever End for BM-57	1	1
BM-26	6	Washer-Stud-Cam Roll	1	1
BM-27	6	Spring Rod-Crosshead	1	1
BM-28	3	Pin for BM-14	1	1
BM-29	6	Spring-Crosshead Return	1	1
BM-30	4,5	Traverse Cam, 5" to 7"	1	1
BM-31	4,6	Washer - Cam Hubs	2	2
BM-32	6	Cloth Feed Cam, 3" to 5" Pockets	0	1
BM-33	6,7,12	Clevis	3	3
BM-34	6	Stud-Cam Roll-Crosshead	1	1
BM-35	6,12	Pin-Clevis	3	3
BM-36	6	Crosshead-Cloth Feed	1	1
BM-37	6	Bracket-Pillow Block	1	1
BM-38	3	Base Plate-Motor	1	1
BM-39	3	Wall Bracket-Motor	1	1
BM-40	3	Shaft-Base Plate-Motor	1	1
BM-41	2	Lever-Centering	1	1
BM-42	2	Lever for BM-23	1	1
BM-43	2	Shoulder Screw-Centering	1	1

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-44	2	Hand Knob-Centering	1	1
BM-45	2	Stud-Hand Knob	1	1
BM-46	2	Drive Bar-Centering -Vertical	1	1
BM-42	2,6	Drive Bar-Centering-Horizontal	1	1
BM-48	1	Hinge Pin-Front Lower	1	1
BM-49	1	Hinge Pin-Front Upper	1	1
BM-50	1	Hinge Pin - Rear	1	1
BM-55	6	Link-Clevis-Crosshead	1	1
BM-56	6	Lever Shaft-Cloth Feed	1	1
BM-57	6	Feed Roll Lever-Left	1	1
BM-60	2	Bushing-Hand Knob-Centering	1	1
BM-61	2	Pin for BM-41	3	3
BM-62	2	Pin for BM-42	1	1
BM-63	13	Wire for BM-US-54	1	1
BM-65	4	Speed Changer	1	1
BM-66	3	Pulley Hub-Drive Shaft	1	1
BM-67	3	Bearing-Sewing Mach. Shaft	2	2
BM-68	4	Pulley-Speed Reducer	1	1
BM-70	3	Motor	1	1
BM-71	6,8,9	Oil Cup for BM-37	2	2
BM-72	2	Spacer-Shaft	1	1
BM-73	2	Collar - Shaft	1	1
BM-74	3	Shaft-Hand Wheel	1	1
BM-75	3	Assembly-Hand Wheel	1	1
BM-76	1	Cover-Motor-Frame	1	1
BM-77	1	Door-Back-Frame	1	1
BM-78	1	Front Cover-Frame	1	1
BM-79	1	Door-Front-Lower Frame	1	1
BM-80	1	Door-Front-Upper Frame	1	1
BM-81	1	Knob-Door-Frame	3	3
BM-82	1	Hinge-Door-Frame	6	6
BM-85	1	Spring Latch-Door-Frame	3	3
BM-86	3	Spring-Hand Wheel	1	1
BM-89	3	Bracket-Hand Wheel	1	1
BM-90	4,5,12	Lug for BM-30, 402 or 406	2	2
BM-91	4,5,12	Shoulder Screw for BM-90	4	4
BM-92	8,9	Runway Block	3	3
BM-93	3	Pulley Flange for BM-66	1	1
BM-94	3	Belt-Motor to Sewing Machine Drive Shaft	1	1
BM-95	3	Belt-Motor to Speed Changer	1	1
BM-96	4	Belt-Speed Changer to Reducer	1	1

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Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-97	1	Cover-Cam	1	1
BM-99	1	Rear Cover-Frame	1	1

(SEWING MACHINE)

BM-100	13,14	Sewing Machine Head	1	1
BM-101	13	Cap-Sewing Machine Head	1	1
BM-102	14	Top Cover-Sewing Machine Head	1	1
BM-103	16,17	Base - Sewing	1	1
BM-104	13,14	Needle Lever	1	1
BM-105	17	Sewing Machine Hand Wheel	1	1
BM-106	16	Front Runway-Lever Bracket	1	1
BM-107	16	Rear Runway-Lever Bracket	1	1
BM-108	17	Base Plate Under Base	1	1
BM-109	13	Cap Plate-Sewing Machine Head	1	1
BM-110	15	Base Plate-Under Head	1	1
BM-111	13	Thread Guide for BM-109	1	1
BM-112	15	Top Plate-Loose	1	1
BM-113	15	Top Plate-Right	1	1
BM-114	15	Insert-Throat Plate	1	1
BM-117A	13,18,19	Thread Guide	2	3
BM-123	18,19	Altered Activator, Micro-Switch	1	2
BM-124	14	Thread Guide at Face Plate	2	2
BM-125	14	Bushing - Needle Lever Stud	1	1
BM-127	13	Presser Foot Shaft	1	1
BM-128	13	Guide Block-Presser Foot Shaft	1	1
BM-130	13	Knob-Presser Foot Shaft	1	1
BM-131	13	Bushings-Top & Bottom Presser Foot Shaft	2	2
BM-132	13	Spring-Presser Foot Regulating	1	1
BM-133	13	Sleeve-Spring Retaining Presser Foot Shaft	1	1
BM-134	13	Presser Foot	1	1
BM-135	15	Guide Plate-Throat Plate	2	2
BM-138	15	Cam Roller Stud	1	1
BM-139	15	Cam Roller	1	1
BM-141	15	Needle Fender Block	1	1
BM-142	17	Splined Half Pulley	1	1
BM-143	17	Half Pulley	1	1
BM-144	15,16	Cam	1	1
BM-145	17	Pulley Bracket	1	1
BM-146	18,19	Cylinder-Dash Pot	1	2
BM-147	17	Coupling-Crank Shaft to Cam Shaft	1	1
BM-148	18,19	Piston - Dash Pot	1	2

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-149	16	Cam Shaft.	1	1
BM-151	18,19	Micro-Switch	1	2
BM-153A	16	Bearing-Cam Shaft-Left	1	1
BM-153B	17	Bearing-Cam Shaft-Middle & Right	2	2
BM-153D	16	Bearing-Looper Rocker Shaft	2	2
BM-153E	17	Bearing-Cross Shaft-Front	1	1
BM-153F	17	Bearing-Cross Shaft-Middle	1	1
BM-153G	17	Bearing-Cross Shaft-Rear	1	1
BM-154	17	Cross Shaft-Sewing Machine Base	1	1
BM-155	17	Lever Bracket Screw	1	1
BM-157	14	Gasket for BM-102	1	1
BM-158	16	Oil Tube-Looper Drive Lever	1	1
BM-159	16	Oil Tube-Looper Avoid Eccentric	1	1
BM-160	16	Oil Tube-Looper Rocker Assembly	1	1
BM-161	16	Oil Tube - Cam	1	1
BM-163	14	Grommet - Head	1	1
BM-164	15	Dowel	3	3
BM-165	15	Oil Drip Plate-Base Plate	1	1
BM-166	13	Bushing-Upper-Needle Bar	1	1
BM-167	17,18,19	Oil Gauge	1	1
BM-168	14	Needle Lever Stud	1	1
BM-170	Page 27.	Gauge-Looper to Needle	1	1
BM-171	16	Gasket for BM-103	1	1
BM-172	17	Belt	1	1
BM-173	17	Screw for BM-185	3	3
BM-174	18,19	Tension Post-Face Plate	2	2
BM-175	16	Dowel for BM-US-52857B	2	2
BM-176	13	Needle	1	1
BM-177	14, 18, 19	Wire Conductor, Micro-Switch.	1	1
BM-178	14	Plug for BM-177.	1	1
BM-179	15	Washer	1	1
BM-181	17	Spot Screw for BM-105	1	1
BM-182	16	Looper Rocker Shaft	1	1
BM-183	16	Shims-Looper Shaft	sets: 1	1
BM-184	16	Shim-Cam Adjusting	sets: 1	1
BM-185	17	Main Shaft Bushing Housing	1	1
BM-186	14	Plate, Model & Machine No.	1	1
BM-187	1	Plate, Model & Machine No.	1	1
BM-191	14	Bushing - Needle Lever	1	1
BM-192	18,19	Whisker, Micro-Switch	1	2
BM-193	15	Assembly, Adjuster-Thread Deflector.	1	1

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Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-194	15	Throat Plate	1	1
BM-195	15	Thread Deflector	1	1
BM-196	15	Thread Deflector & Cam Roller Support	1	1
BM-198	18, 19	Clip-Wire Conductor, Micro-Switch	1	1
BM-199	18, 19	Face Plate-Double Thread Break	1	1

(CLOTH CONTROL)

BM-200	8,9	Feed Roll Bracket - Right	1	1
BM-201	8,9	Feed Roll Bracket - Left	1	1
BM-202	8,9	Feed Roll Pivot	1	1
BM-203	8,9	Feed Roll Pivot Shaft	1	1
BM-204	8,9	Feed Roll Lock & Cover	1	1
BM-205	8, 9, 10	Knob	6	2
BM-206	8,9	Sleeve-Feed Roll Bracket	1	1
BM-208	10, 11	Guide Plate, Left - Cloth Feed	1	1
BM-209	10, 11	Guide Plate, Right - Cloth Feed	1	1
BM-210	10, 11	Felt Apron-Cloth Feed	1	1
BM-211	10, 11, 12	Cloth Clamp	1	1
BM-212	10, 12	Half Foot-Cloth Clamp	1	0
BM-213	8,9	Rear Roll	1	1
BM-214	8,9	Shaft - Front Roll	1	1
BM-215	8,9	Shaft - Rear Roll	1	1
BM-216	8,9	Pilot - Front Roll	1	1
BM-217	8,9	Pilot - Rear Roll	1	1
BM-218	10, 11, 12	End Plate - Right	1	1
BM-219	10, 11, 12	End Plate - Left	1	1
BM-220	12	Bracket-Cloth Clamp-Cam Lever	1	1
BM-221	10	Eccentric Screw-Cloth Clamp	1	0
BM-222	12	Cam Lever-Cloth	1	1
BM-223	12	Cam Washer-Cloth Clamp	1	1
BM-224	12	Cam Roller-Cloth Clamp	1	1
BM-225	8,9	Toggle	2	2
BM-226	8,9	Swivel Pin - Toggle	2	2
BM-227	8,9	Hinge Pin - Toggle	2	2
BM-228	8,9	Spring Rod - Toggle	2	2
BM-229	8,9	Pin - Spring Rod - Toggle	2	2
BM-230	12	Lever - Cloth Clamp	1	1
BM-231	12	Clevis - Lever - Cloth Clamp	1	1
BM-232	12	Pin - Lever - Cloth Clamp	1	1
BM-233	12	Link - Clevis - Cloth Feed	1	1

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Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-234	12	Cam Stud - Cloth Clamp	1	1
BM-236	12	Spring Clamp	1	1
BM-237	12	Latch Clamp	1	1
BM-239	10	Front Apron - Cloth Feed	1	0
BM-240	8,9	Apron - Rear - Cloth Control	1	1
BM-244	10	Cloth Guide - Front Apron	2	0
BM-247	10	Pad Foot	1	0
BM-252	12	Shaft - Bracket - Cloth Clamp	1	1
BM-253	10,11	Shaft - Guide Plates	1	1
BM-254	10,11	Pivot Shaft - Guide Plates	1	1
BM-256	8,9	Spring for BM-228	2	2
BM-257	8,9	Key - Clutch to Shaft	2	2
BM-259	10,11,12	Bushing - End Plates BM-218 & 219	2	2
BM-272	8,9	Collar - Rear Feed Roll	1	1
BM-273	10	Support - Insert Hem Turner	1	0
BM-275	10	Top Plate - Hem Turner	1	0
BM-276	10	Bottom Plate - Hem Turner	1	0
BM-277	10	Support - Hem Turner	1	0
BM-278	10	Guide - Right - Hem Turner	1	0
BM-279	10	Guide - Left - Hem Turner	1	0
BM-280	10	Thumb Screw - Hem Turner	2	0
BM-281	12	Latch - Cloth Clamp	1	1
BM-287	12	Spring - Cloth Clamp	1	1
BM-288	10	Brush Holder - Cloth Tension	1	1
BM-289	10	End Plate - Cloth Tension	1	1
BM-290	10,11	Guide - Cloth Tension	2	2
BM-292	8,9	Spacer - Rear Roll	1	1
BM-293	10	Rivet for BM-277	2	0
BM-294	8,9	Pinion - Front Roll	1	1
BM-296	10,12	Half Foot - Cloth Clamp	1	0
BM-297	10	Screw, Foot - Cloth Clamp	4	0
BM-298	8,9	Key for BM-294	1	1
BM-299	9	Front Roll	0	1

(ELECTRICAL)

BM-301	1	Magnetic Starter	1	1
BM-306	1	Receptacle	2	2
BM-307	1	Plate, Receptacle	2	2
BM-312	4	Junction Box	1	1
BM-313	4	Conduit - Junction Box to Wind-Up Outlet	1	1
BM-314	4	Conduit - Junction Box to Starter	1	1

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-315	4	Conduit - Micro Outlet to Junction Box	1	1
BM-316	4	Outlet Box Cover for BM-312	1	1
BM-317	1	Outlet Box	4	4
BM-318	1	Cover for BM-317	2	2
BM-319	Not Illust.	Watertight Connectors	8	8
BM-320	} See Wiring Diagram {	Wires - Motor to Junction Box	1	1
BM-321		Wires - Junction Box to Starter	1	1
BM-322		Wires - Micro-Switch Outlet to Starter	1	1
BM-323		Wires - Wind-Up Outlet to Junction Box	1	1
BM-324	5,6	Flexible Tubing - Motor to Junction Box	1	1

(BASE DRIVE)

BM-401	4	Hub - Traverse Cam	1	1
BM-402	4,5	Traverse Cam - 7" to 10"	1	1
BM-403	4,6	Retaining Nut	2	2
BM-404	6	Hub - Cloth Feed Cam	1	1
BM-405	6	Cloth Feed Cam . 5" to 8" Pockets	0	1
BM-409	3	Handle - Hand Wheel	1	1
BM-410	5	Gauge - Traverse Slide	1	1
BM-411	5	Pointer - Traverse Adjustment	1	1
BM-412	1	Mounting Foot - Frame	4	4
BM-413	2	Nut - For Hand Knob	1	1
BM-414	4	Key for BM-401	1	1
BM-415	6	Key for BM-404	1	1
BM-417	3,4,5	Shim for BM-3 & BM-67	6	6
BM-419	8,9	Shim - Runway Block	sets: 3	3
BM-420	6	Bracket - Cross Head Slide	1	1
BM-421	6	Cloth Feed Cam - 7" to 10" Border	1	0
BM-422	6	Cloth Feed Cam - 5" to 7" Border	1	0
BM-423	6,8,9	Gear Segment - Cloth Feed	1	1
BM-424	6	Spacer - Bracket BM-37	4	4
BM-425	6	Cloth Feed Cam - 3½" to 5" Border	1	0
BM-426	4,5	Traverse Cam - 3½" to 5"	1	1
BM-427	6	Cloth Feed Cam - 1½" to 3" Pockets	0	1
BM-428	1	Patent Number Plate	1	1
BM-430	1	Spindle - Thread Spool	2	2
BM-431	1	Tee - Thread Guide	1	1
BM-432	1	Clamp - Conductor, Micro-Switch	1	1

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Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P

(WIND UP STAND)

BM-501	21	Stand, Base	1	1
BM-502	21	Spool Axle	1	1
BM-503	21	Fixed Hub	1	1
BM-504	21	Removable Hub	1	1
BM-505	21	Friction Adjustment Spring	1	1
BM-506	21	Friction Adjustment Collar	1	1
BM-507	21	Spool Sides	2	2
BM-508	21	Motor	1	1
BM-510	21	Shim	2	2
BM-511	21	Washer - Friction Adj. Spring	2	2
BM-512	21	Plug	1	1
BM-513	21	Wire - Wind-Up to Frame	1	1

(CLOTH FEED STAND)

BM-601	22	Stand, Cloth Feed	1	0
BM-602	22	Sliding Panel	1	0
BM-603	22	Spool Arm	1	0
BM-604	22	Spool Arm	1	0
BM-606	22	Spool Shaft	2	0
BM-608	10,22	Collar - Spool Shaft	10	0
BM-609	22	Arm	1	0
BM-610	22	Collar - Arm	2	0
BM-612	22	Disc Assembly	4	0
BM-613	22	Panel Assembly	2	0
BM-618	22	Bracket - Shaft	2	0
BM-619	22	Separator Shaft	4	0
BM-620	22	Guide Block - Separator	4	0

(SPACING ATTACHMENT)

BM-651	7	Base Plate	0	1
BM-652	7	Stop Arm	0	1
BM-653	7	Stop Arm Bracket	0	1
BM-654	7	Adjustable Stop	0	1
BM-655	7	Trip	0	1
BM-656	7	Trip Stud	0	2
BM-657	7	Trip Lever	0	1
BM-658	7	Shoulder Stud	0	1
BM-659	7	Spacer - Trip Lever	0	1
BM-661	7	Trip Pawl	0	1

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-662	7	Index Pawl	0	1
BM-663	7	Index Pawl Pivot	0	1
BM-664	7	Index Lever	0	1
BM-665	7	Shoulder Stud	0	1
BM-666	7	Rack	0	1
BM-667	7	Rack Bracket	0	1
BM-668	7	Guide Block - Rack	0	2
BM-669	7	Reset Pin	0	1
BM-670	7	Actuator Pin	0	1
BM-671	7	Rack Stud	0	1
BM-672	7	Index Pawl Spring	0	1
BM-673	7	Trip Pawl Spring	0	1
BM-674	7	Trip Spring	0	1
BM-675	7	Rack Spring	0	1
BM-676	7	Index Lever Spring	0	1
BM-677	7	Stop Sleeve	0	1
BM-678	7	Trip Pin	0	4

(CLOTH CONTROL)

BM-701	10	Felt Guide - Left	1	0
BM-702	10	Felt Guide - Right	1	0
BM-703	10,22	Shaft - Felt Guide	1	0
BM-710	8	Front Roll	1	0
BM-711	10	Adapter - Left Hem Turner	1	0
BM-712	10	Adapter - Right Hem Turner	1	0
BM-713	8	Frame - Finished Border Guide	1	0
BM-714	8	Guide Block - Finished Border	2	0
BM-715	8	Guide Plate - Right - Finished Border	1	0
BM-716	8	Guide Plate - Left - Finished Border	1	0

(CLOTH FEED STAND)

BM-801	23	Base - Cloth Stand	0	1
BM-802	23	Shaft - Creaser	0	1
BM-803	23	Shaft - Cloth - Base	0	1
BM-804	23	Washer - Sleeve	0	1
BM-805	23	Sleeve - Table Support	0	1
BM-806	23	Table	0	1
BM-807	23	Creaser - Cloth	0	1
BM-808	24	Table - Frame	0	1
BM-809	24	Leg - Creaser Support	0	1
BM-810	24	Strap - Frame Table	0	1

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Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-811	23	Set Screw - Lock Nut	0	1
BM-813	23	Tension Bar - Cloth	0	1
BM-814	23	Tension Spring - Cloth	0	1
BM-815	23	Tension Bar - Cloth	0	1
BM-816	23	Disc - Tension Spring	0	1
BM-817	23	Tension Spring - Cloth Shaft	0	1
BM-818	23	Tension Post - Cloth Shaft	0	1
BM-819	23	Collar - Tension Spring	0	1
BM-820	23	Lock Nut - Table	0	1
(CLOTH CONTROL)				
BM-850	11	Holder - Roll	0	1
BM-851	11	Roll - Foot	0	1
BM-852	11	Shaft - Cloth Guide - Frame	0	1
BM-853	11	Spacer - Cloth Clamp	0	1
(THREAD CUT-OFF)				
BM-901	20	Apron Rest	0	1
BM-902	20	Cylinder Block	0	1
BM-903	20	Thread Pick-Up Plate	0	1
BM-904	20	Plunger - Knife	0	1
BM-905	20	Knife	0	1
BM-906	20	Spring	0	1
BM-907	20	Activator	0	1
(SEWING MACHINE)				
BM-US-18	16	Nut	3	3
BM-US-28	16	Screw	2	2
BM-US-43C	16	Looper Avoid Eccentric, Incl. (1) BM-US-22894D, Spot Screw.	1	1
BM-US-52A	16, 17	Thread Guide on Base	1	1
BM-US-54	13	Needle Lever Link	1	1
BM-US-56	13	Needle Clamp Nut	1	1
BM-US-109B	18, 19	Tension Disc	4	4
BM-US-116	1	Wrench, 9/32"	1	1
BM-US-269	16	Nut - Left Thread	1	1
BM-US-652C9	13	Shake Proof Lockwasher	1	1
BM-US-666-13	17	Felt Wick	9	9
BM-US-1286	13	Needle Lever Link Pin Assembly	2	2
BM-US-8372A	17	Washer	1	1
BM-US-15430C	17	Nut - Left Thread	1	1

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Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-US-15430D	. 14	Nut - Right Thread	1	1
BM-US-21388	. . 1	Wrench, 13/32"	1	1
BM-US-22768	. . 13	Screw for BM-US-51258A	1	1
BM-US-22894C	. 17	Set Screw for BM-147	2	2
BM-US-22894D	. 16, 17 . .	Spot Screw for BM-147	2	2
BM-US-29066N	. 14	Assemb. Needle Lever Conn. Rod Upper Brg. includes (1) BM-US-51216A (1) BM-US-51243B	1	1
BM-US-29105B	. 17	Looper Drive Eccentric Assembly	1	1
BM-US-29192	. . 16	Looper Rocker Assembly, Incl. (1) BM-US-73 Set Screw	1	1
BM-US-29476DD	17	Crankshaft Assembly, Incl. (1) BM-US-51322A, Crankshaft (2) BM-US-75A, Screws	1	1
BM-US-35759	. . 13	Needle Bar Connector, Incl. (2) BM-US-88A Set Screws (1) BM-US-78 Set Screw	1	1
BM-US-51145	. . 16	Looper Avoid Eccentric Link	1	1
BM-US-51147	. . 17	Main Shaft Collar, Incl. (2) BM-US-95, Screws	1	1
BM-US-51190D	. 17	Main Shaft Bearing Hsg. Gasket	1	1
BM-US-51216	. . 14	Needle Lever Conn. Rod Tube	1	1
BM-US-51217	. . 13	Needle Bar	1	1
BM-US-51236A	. 16	Looper Avoid Link Pin	1	1
BM-US-51240A	. 16	Looper Conn. Rod Adjusting Section	1	1
BM-US-51241	. . 16 . Old .	Looper Conn. Rod Assembly-Right	1	1
BM-US-51241D	. 16	Looper Conn. Rod Ball Joint Assembly-Left	1	1
BM-US-51241J	. 16 . New .	Looper Conn. Rod Assembly-Right	1	1
BM-US-51242K	. 17	Looper Drive Lever Rocker, Incl. (1) BM-US-81, Set Screw (1) BM-US-627, Clamp Screw	1	1
BM-US-51242V	. 16	Looper Drive Lever, Incl. (1) BM-US-81, Spot Screw (1) BM-US-74, Clamp Screw (1) BM-US-51242M, Washer	1	1
BM-US-51243C	. 14	Looper Drive Lever Ball Stud Guide Fork, incl. (1) BM-US-97, Screw	2	2

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
BM-US-51244	16	Looper Rocker Frame, Incl. (1) BM-US-22894D, Spot Screw (1) BM-US-22894C, Set Screw	1	1
BM-US-51244B	16	Looper Rocker Shaft Arm, Incl. (1) BM-US-77, Set Screw (1) BM-US-93, Clamp, Screw	1	1
BM-US-51244C	16	Looper Rocker Shaft Sleeve, Incl. (1) BM-US-88B, Screw	1	1
BM-US-51246	16	Looper Rocker Stud Nut	1	1
BM-US-51254A	13	Needle Bar Bushing, Lower	1	1
BM-US-51258	13	Needle Lever Thread Eyelet	1	1
BM-US-51258A	13	Needle Bar Thread Eyelet	1	1
BM-US-51292A	18, 19	Tension Post Ferrule	2	2
BM-US-51292C	18, 19	Tension Regulating Nut	2	2
BM-US-51292D	18, 19	Thread Tension Eyelet	2	2
BM-US-51292F5	18, 19	Tension Spring for Needle Threads	1	1
BM-US-51292F8	18, 19	Tension Spring for Needle Threads	1	1
BM-US-51523C	16	Shielded Disc Take Up, Incl. (1) BM-US-22894D, Spot Screw (1) BM-US-22580, Set Screw	1	1
BM-US-51758	13	Frame Needle Thread Eyelet	1	1
BM-US-51909B	16	Looper	1	1
BM-US-51959B	16	Looper Thread Nipper Disc	2	2
BM-US-51959C	16	Looper Thread Nipper Spring	1	1
BM-US-51959D	16	Looper Thread Nipper Nut	1	1
BM-US-51959E	16	Looper Thread Nipper Spacing Collar	1	1
BM-US-52804A	16	Cast Off Plate	1	1
BM-US-52834N	17	Locking Nut	1	1
BM-US-52841	17	Looper Drive Ball Joint Locking Stud	1	1
BM-US-52857B	16	Cast Off Wire Support	1	1
(MISCELLANEOUS)				
BT-37	7	Stop Arm Spring	0	1
BT-101	14	Thread Guide	2	2
BT-157	10	Brush	12	0
66	5, 13, 16, 20	Machine Screw	10	13
101	3	Cap Screw	4	4
102	1, 7, 24	Washer	5	18
105	15	Washer	1	1
106	22	Nut	4	0

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
109.	7	Nut	4	6
115.	1,7,11,24	Nut	5	11
116.	3,22	Lockwasher	8	4
119.	14	Washer	4	4
120.	3,6,7,8,9,21	Lockwasher	24	25
122.	9	Machine Screw	0	2
134.	12	Cotter Pin	8	8
151.	3	Cap Screw	4	4
153.	6	Street Elbow	2	2
172.	8,9,10,24	Cap Screw	2	6
174.	10,11,12,23	Nut	3	5
181.	5	Washer	1	1
183.	22	Machine Screw	12	0
193.	2,4,5	Lockwasher	5	5
194.	4,5,32	Nut	5	6
213.	4,17,21	Cap Screw	10	10
216.	24	Cap Screw	0	2
236.	10	Cap Screw	2	0
267.	1	Cap Screw	4	4
270.	3,21	Nut	8	8
271.	2,3,6,8,9	Cotter Pin	12	12
273.	7	Cap Screw	0	4
282.	3	Nut	4	4
286.	2,11,15	Machine Screw	16	16
287.	7	Cap Screw	0	3
304.	6	Cap Screw	4	4
349.	17	Cap Screw	2	2
354.	8,9,12	Cap Screw	2	2
357.	2,8,9,10,12	Set Screw	10	4
364.	22	Machine Screw	8	4
366.	23	Set Screw	0	2
368.	1	Nut	4	4
369.	1,4,5	Washer	8	8
392.	3	Washer	4	4
393.	3,6,12	Cap Screw	5	5
448.	23	Machine Screw	0	3
493.	13,15	Machine Screw	10	10
494.	10	Machine Screw	2	0
497.	18,19	Machine Screw	2	2
525.	4	Machine Screw	4	4
558.	3,6,7,12	Nut	5	7

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
667.	3.	Woodruff Key	1	1
673.	11.	Cap Screw	2	1
674.	22.	Cap Screw	2	0
676.	1,7	Cap Screw	2	3
681.	2,23	Cap Screw	1	2
688.	11.	Cap Screw	0	2
749.	10.	Machine Screw	2	0
751.	14.	Machine Screw	2	2
754.	7.	Cap Screw	0	4
771.	10.	Machine Screw	4	0
813.	1,4,5,6,8,9	Washer	12	12
815.	20.	Lockwasher	0	2
889.	21.	Set Screw	4	4
961.	18,19	Machine Screw	2	4
5707.	4,5,12	Cap Screw	8	8
5709.	3.	Washer	1	1
5710.	12.	Grease Fitting	1	1
5711.	22.	Cap Screw	2	0
5730.	3,4,5	Spacing Washer	6	6
5741.	15.	Cap Screw	1	1
5762.	4,5	Pipe Plug	2	2
5763.	14.	Drive Screw	4	4
5785.	12.	Bushing	1	1
5890.	14.	Cap Screw	6	6
5891.	8,9,12	Cap Screw	4	4
5894.	4,5,6	Cap Screw	6	6
5951.	22.	Set Screw	4	0
5952.	3.	Set Screw	1	1
5997.	6.	Jam Nut	2	2
6018.	5.	Set Screw	1	1
6038.	4,5	Set Screw	2	2
6048.	8,9	Spacing Washer	1	1
6058.	8.	Cap Screw	2	0
6081.	4	Cotter Pin	2	2
6083.	8,9,12	Set Screw	5	5
6136.	8,9	Cap Screw	12	12
6139.	1.	Nut	1	1
6171.	3.	Washer	8	8
6180.	1.	Machine Screw	12	12
6197.	5.	Lockwasher	8	8
6205.	5.	Cap Screw	8	8

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
6219	8,20	Cap Screw	4	1
6228	3	Set Screw	1	1
6243	8	Cap Screw	4	0
6244	15,17	Heli-Coil	9	9
6271	12	Lockwasher	4	4
6274	8,9	Set Screw	3	3
6284	14	Set Screw	2	2
6289	4,21	Set Screw	3	3
6311	5	Lockwasher	2	2
6353	6	Bushing	2	2
6360	7,11,12,20	Nut	5	5
6372	2	Set Screw	4	4
6373	8,9,10,11,24	Washer	18	14
6375	8,16	Washer	7	1
6410	10,11,13	Set Screw	4	4
6426	8,9	Cap Screw	9	9
6451	18,19	Nut	4	8
6473	13	Nut	1	1
6489	4	Snap Ring	2	2
6491	4,5	Cap Screw	4	4
6492	5	Cap Screw	2	2
6494	16	Cap Screw	2	2
6496	8,9	Clutch	2	2
6497	3	Nut	1	1
6498	8,9,12	Cap Screw	4	4
6499	17	Oil Cup	1	1
6505	10	Thumb Nut	2	0
6508	11	Set Screw	0	2
6509	3	Cap Screw	2	2
6510	17	Bearing	2	2
6517	8,9,14,15	Dowel	5	5
6518	13	Clamp Screw	1	1
6519	15	Bolt	1	1
6520	15	Machine Screw	5	5
6521	4,5,6	Dowel Pin	4	4
6526	13	Set Screw	1	1
6530	21	Rivet	12	12
6531	3,6	Set Screw	3	3
6532	10,11,22	Thumb Screw	8	2
6533	13,18,19	Heli-Coil	5	5
6536	13	Washer	1	1

* B - Border Machine, P - Pocket Machine

Part No.	Illustration on Plate No.	Part Name	No. Req'd *	
			B	P
6537	13,15,20	Machine Screw	3	4
6539	14,17	Heli-Coil	14	14
6540	4,5,16	Cap Screw	10	10
6541	17	Set Screw	1	1
6544	13	Machine Screw	2	2
6545	13	Machine Screw	1	1
6546	14	Set Screw	2	2
6547	17	Set Screw	1	1
6548	18,19	Machine Screw	1	2
6549	3	Set Screw	1	1
6550	8,9	Cotter Pin	2	2
6552	6	Dowel	4	4
6610	7	Lockwasher	0	5
6635	23	Nut	0	1
6659	7,20	Drive Pin	0	13
6677	7	Lockwasher	0	1
6678	7	Lockwasher	0	2
6680	23	Set Screw	0	1
6685	22	Thumb Screw	2	0
6695	18,19	Washer	2	4
6697	23	Bearing	0	2
6698	23	Thumb Screw	0	1
6699	11	Ball Bearing	0	2
6716	7	Cap Screw	0	1
6740	10,11	Set Screw	2	2
6743	13,14,17,18,19	Machine Screw	7	10
6744	15	Retaining Ring	1	1
6799	15	Machine Screw	1	1
6953	20	Machine Screw	0	2
6966	2	Grease Fitting	1	1
6971	10	Cap Screw	2	0
6972	12	Set Screw	2	0
14468	3	Key	1	1
14563	10,11	Key	2	2
14763	8,9	Key	4	4
16093	3	Key	2	2
16561	15	Key	1	1
18311	17	Lockwasher	1	1
18312	17	Locknut	1	1

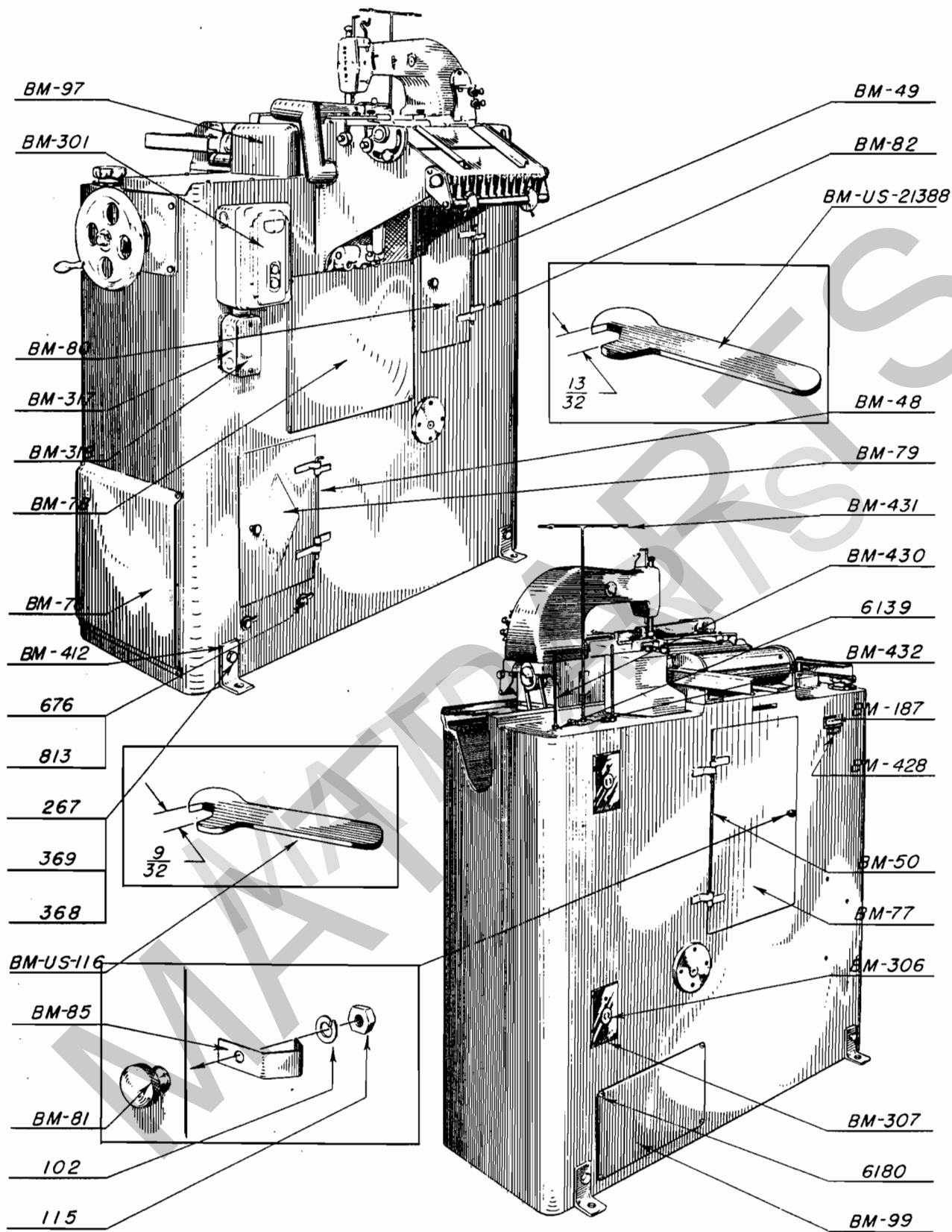


PLATE ONE

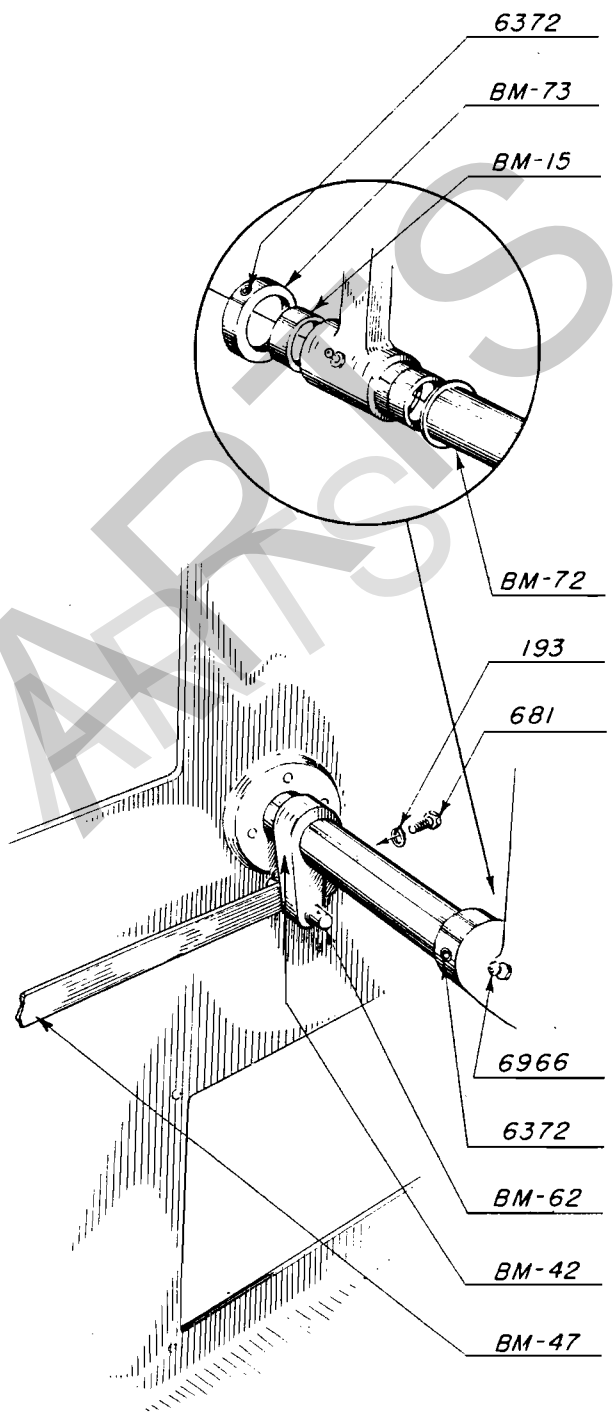
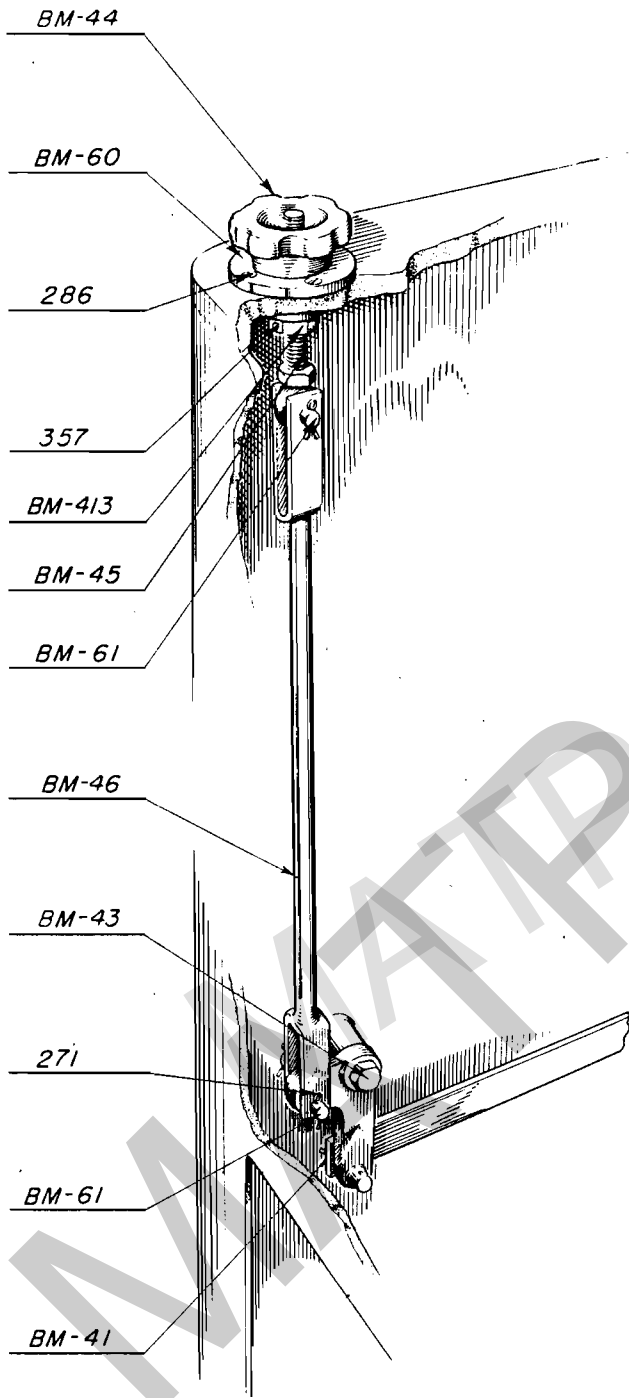


PLATE TWO

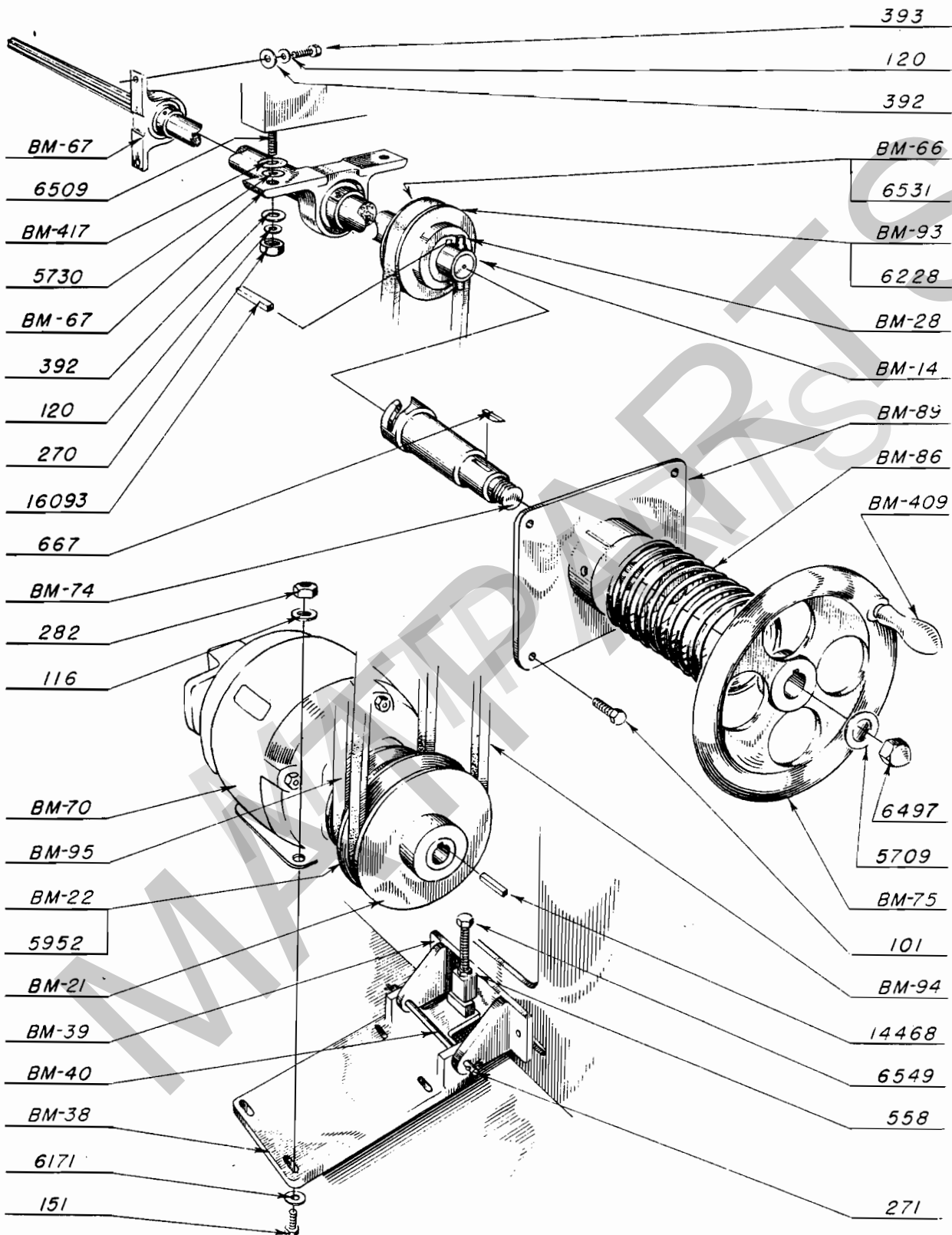


PLATE THREE

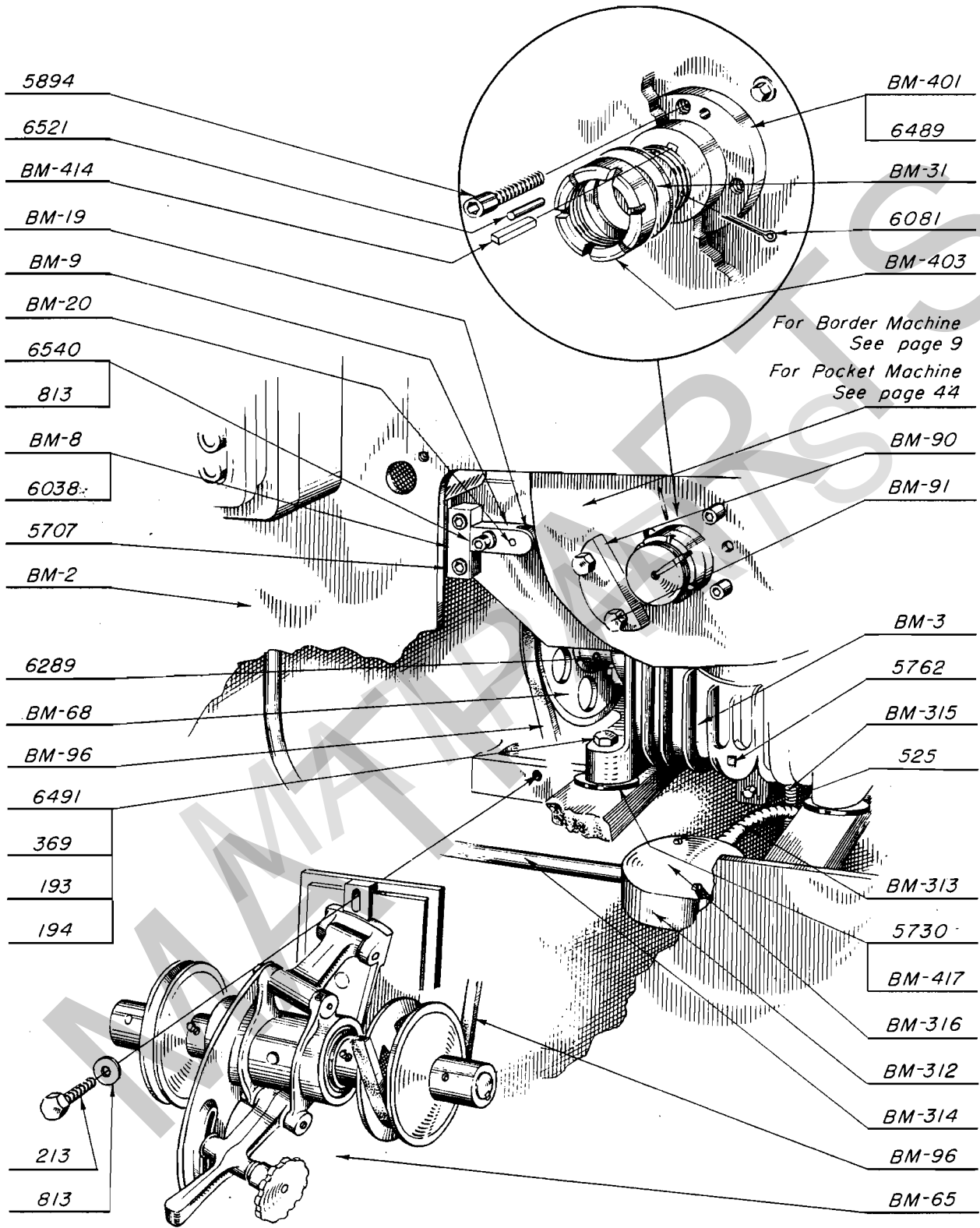


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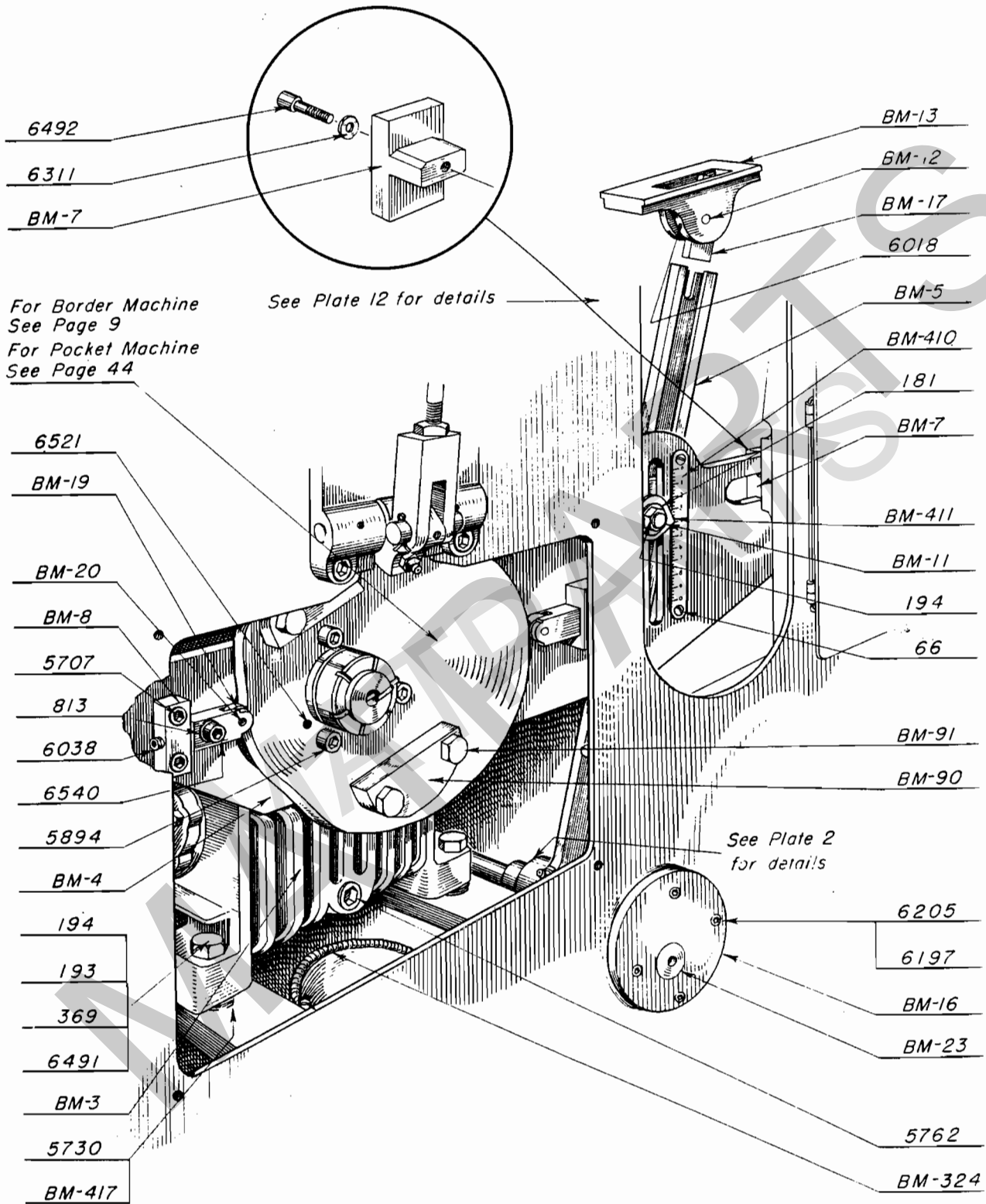


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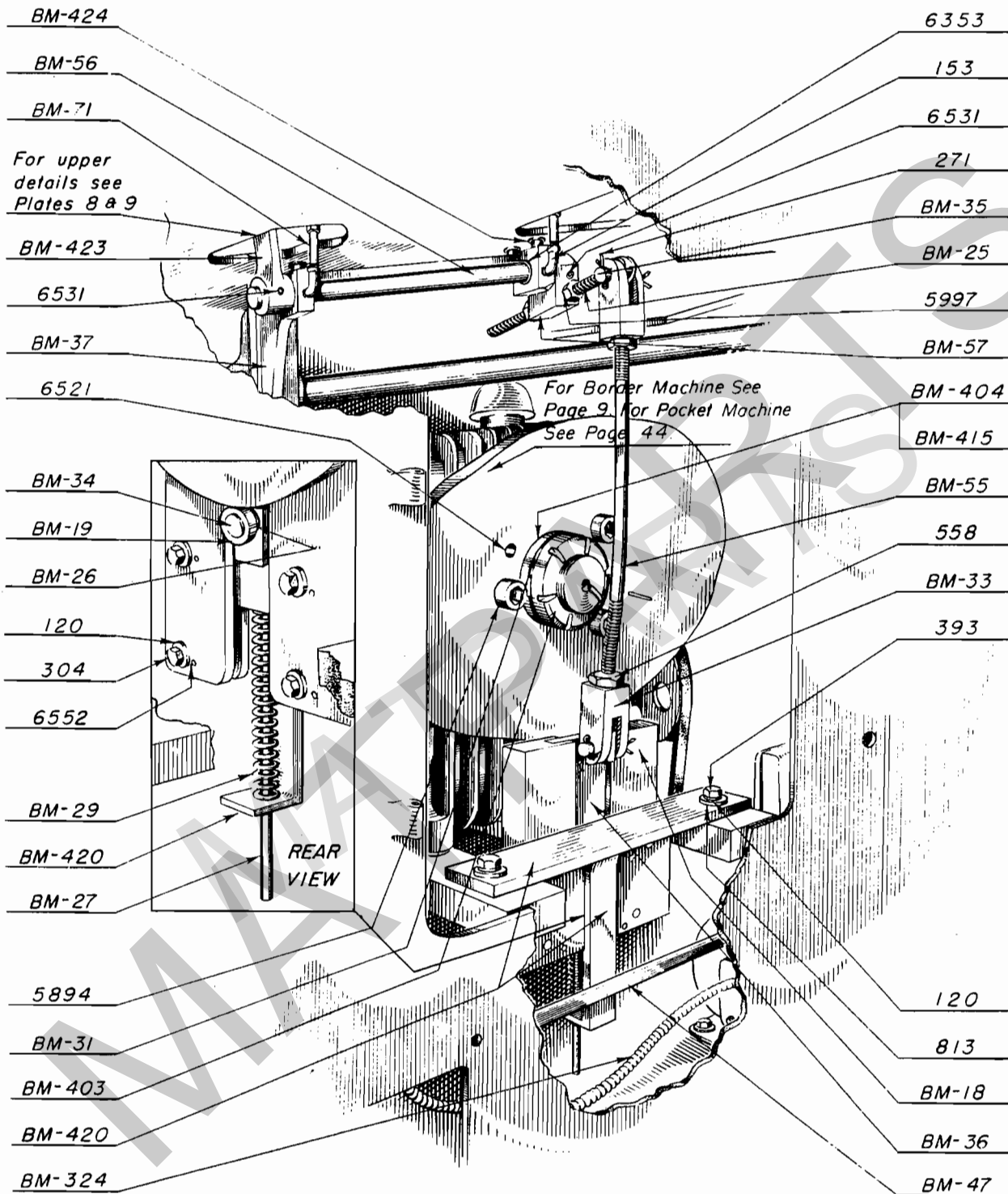
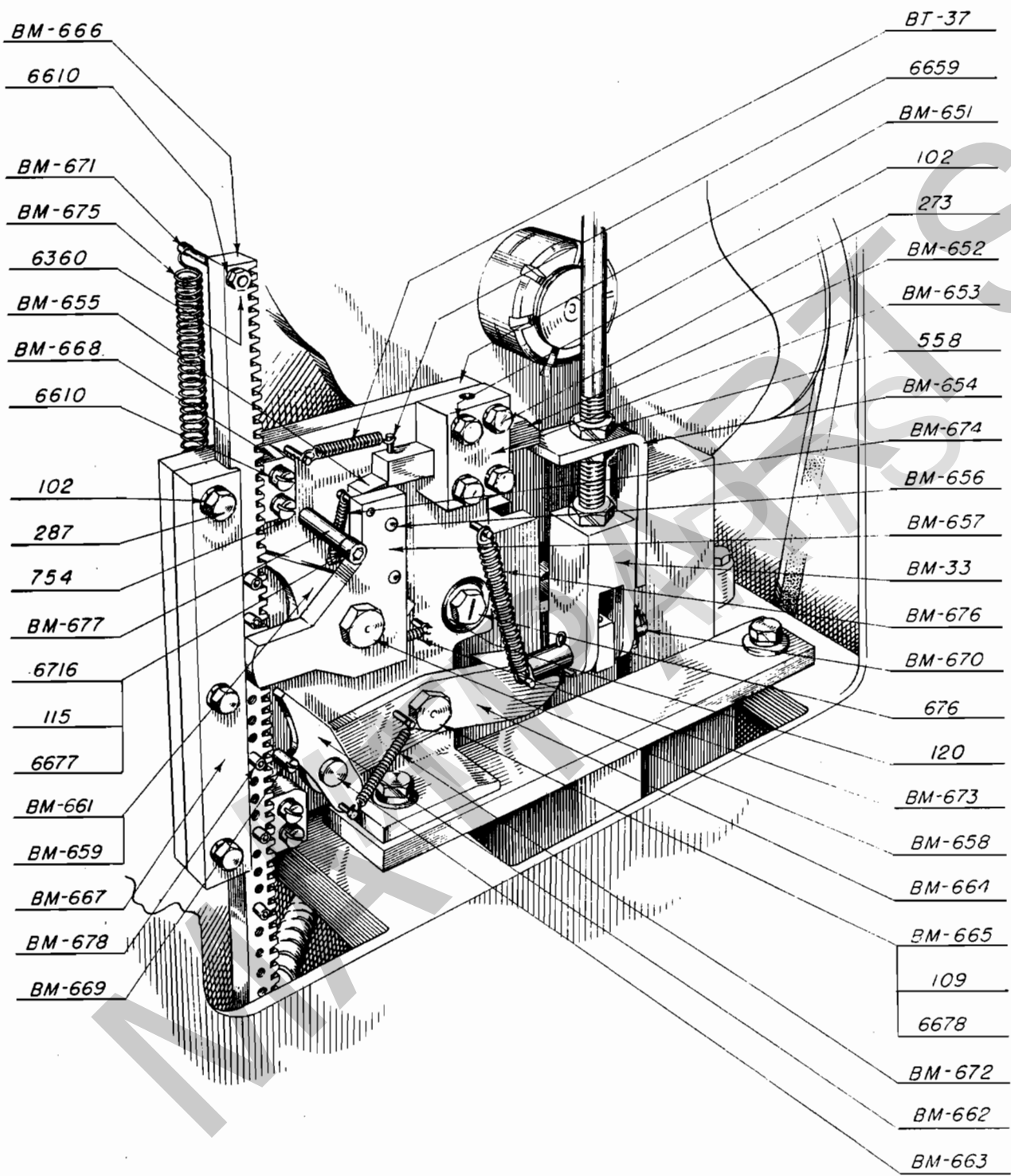


PLATE SIX



AUTOMATIC SPACING ATTACHMENT
FOR UNITED POCKET MACHINES

PLATE SEVEN

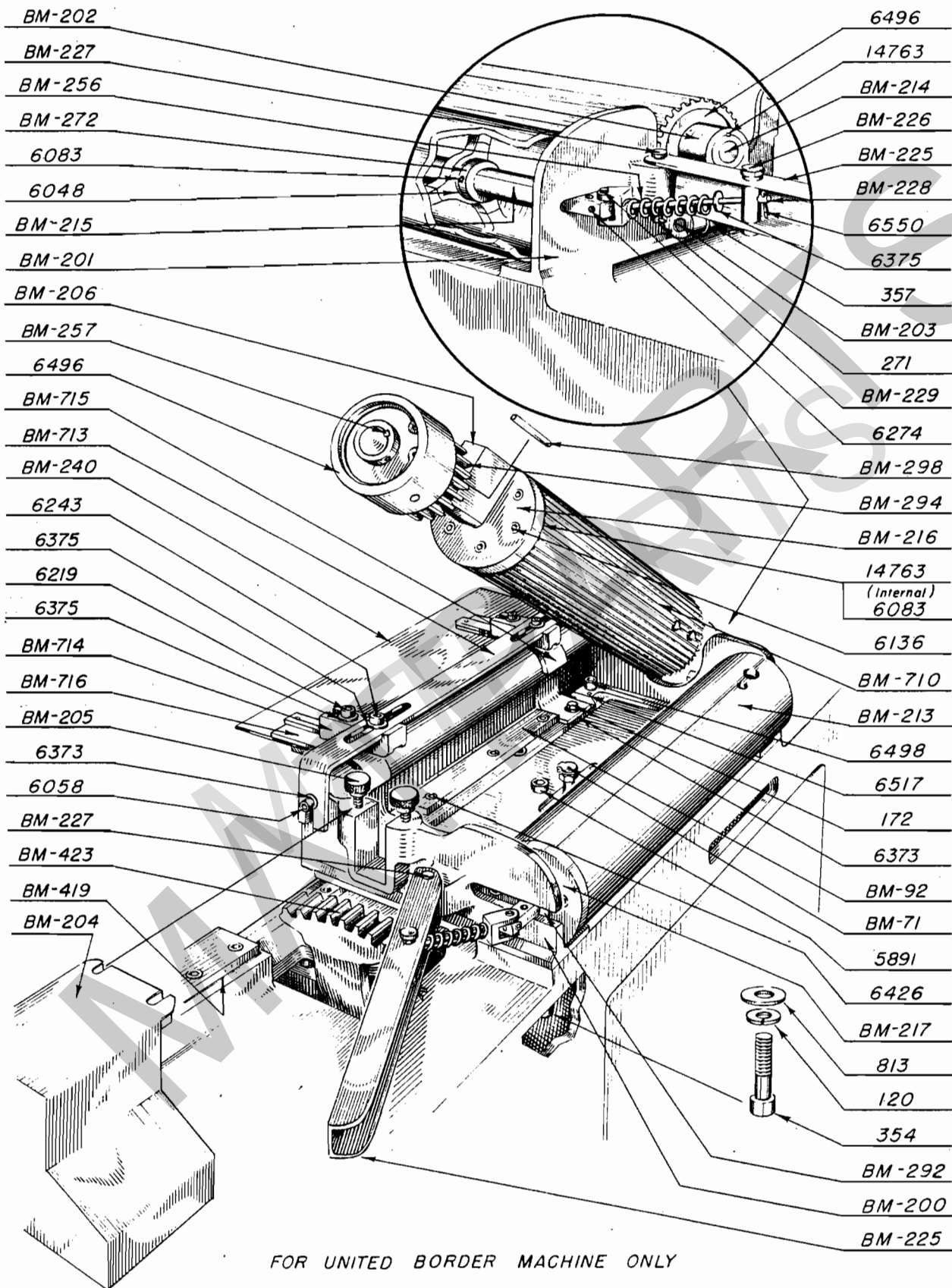


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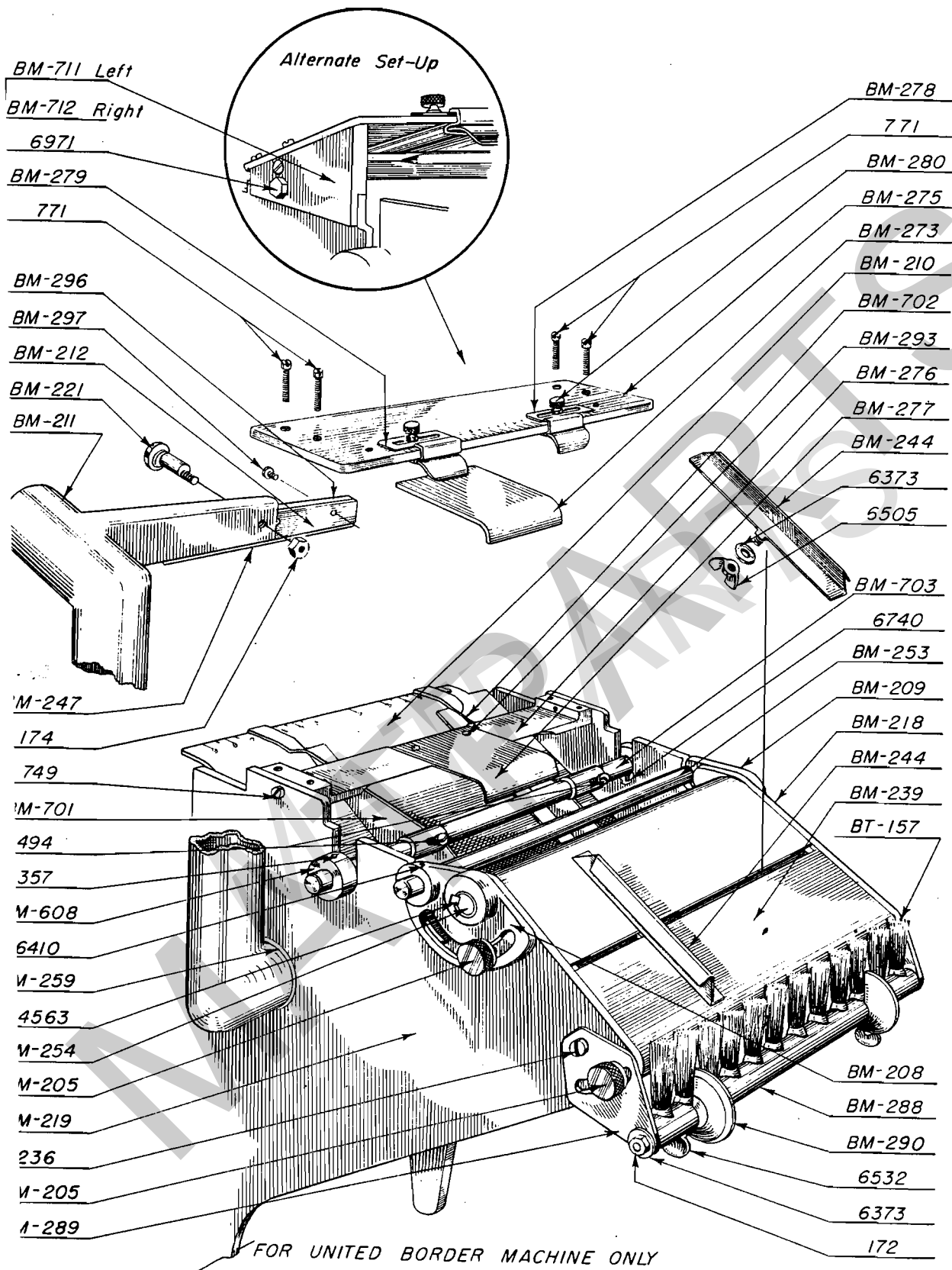
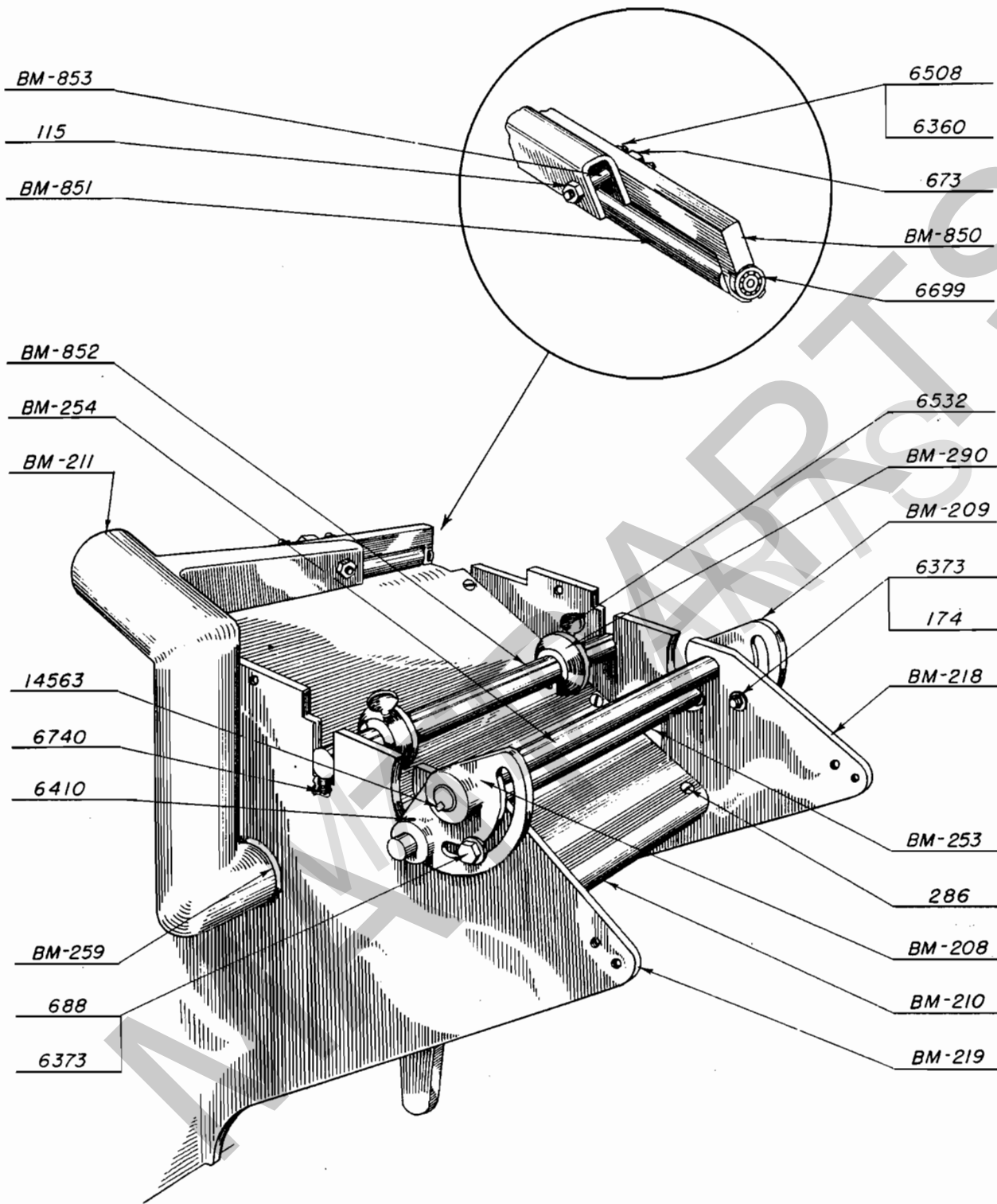


PLATE TEN



FOR UNITED POCKET MACHINE ONLY

PLATE ELEVEN

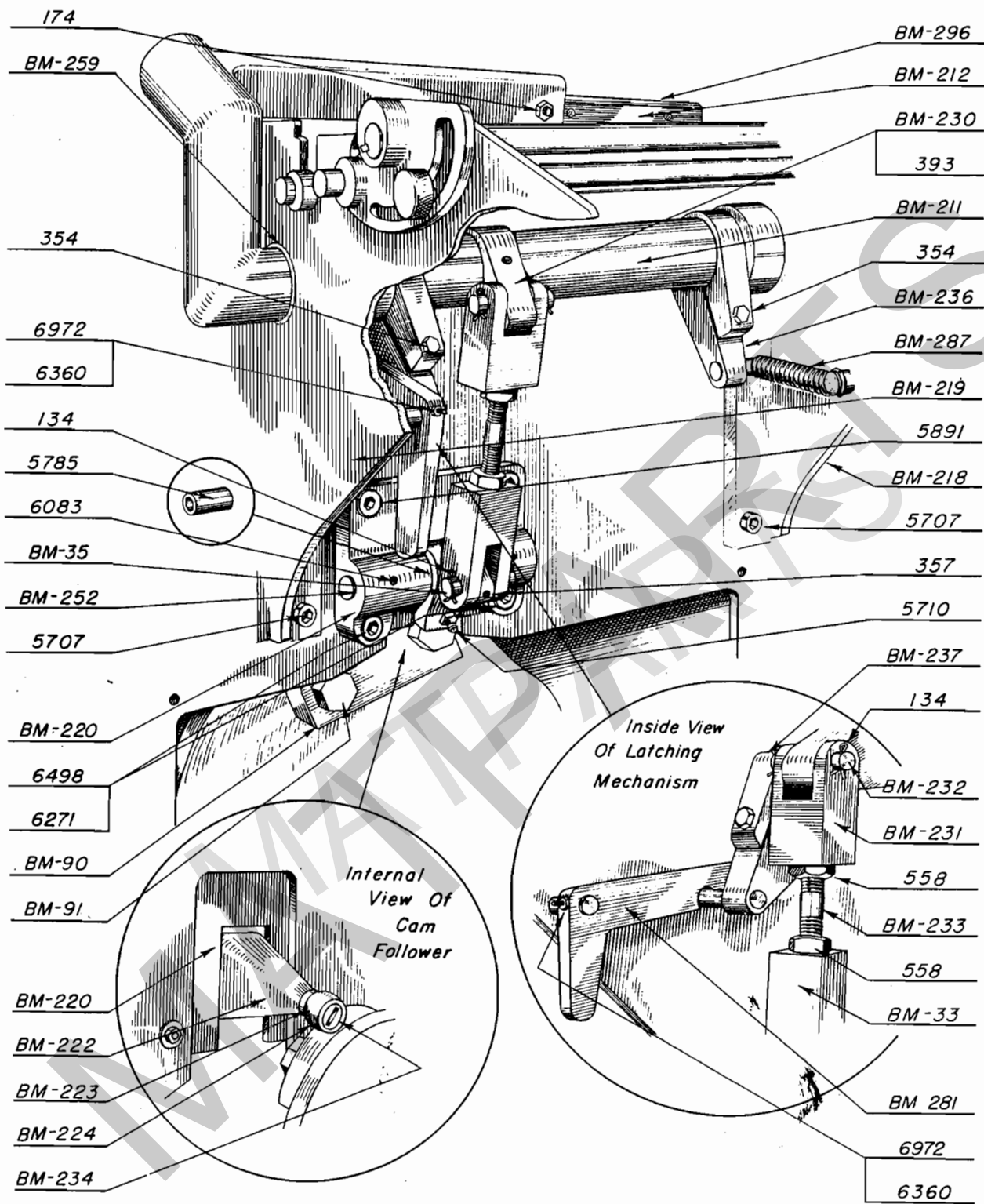


PLATE TWELVE

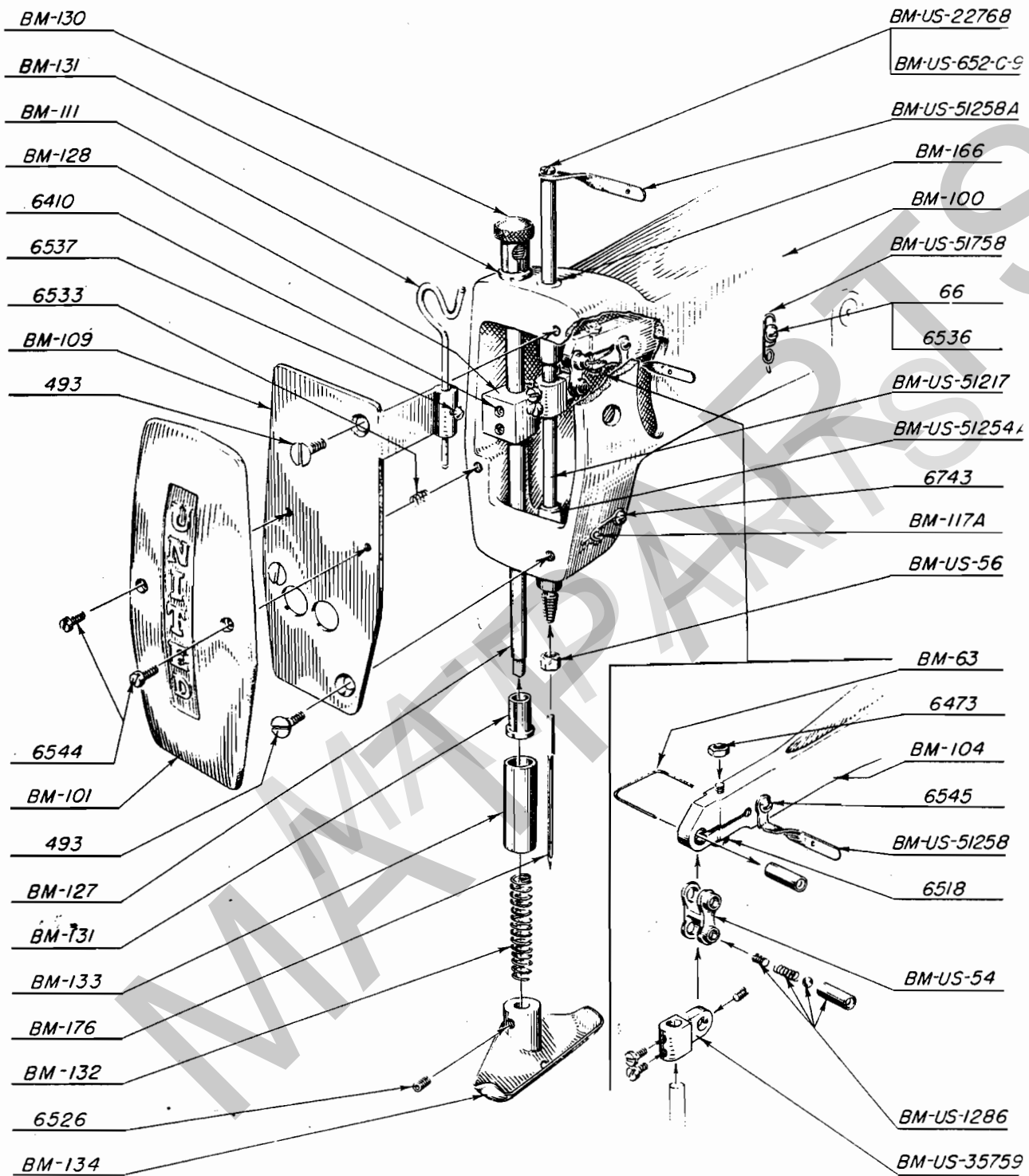


PLATE THIRTEEN

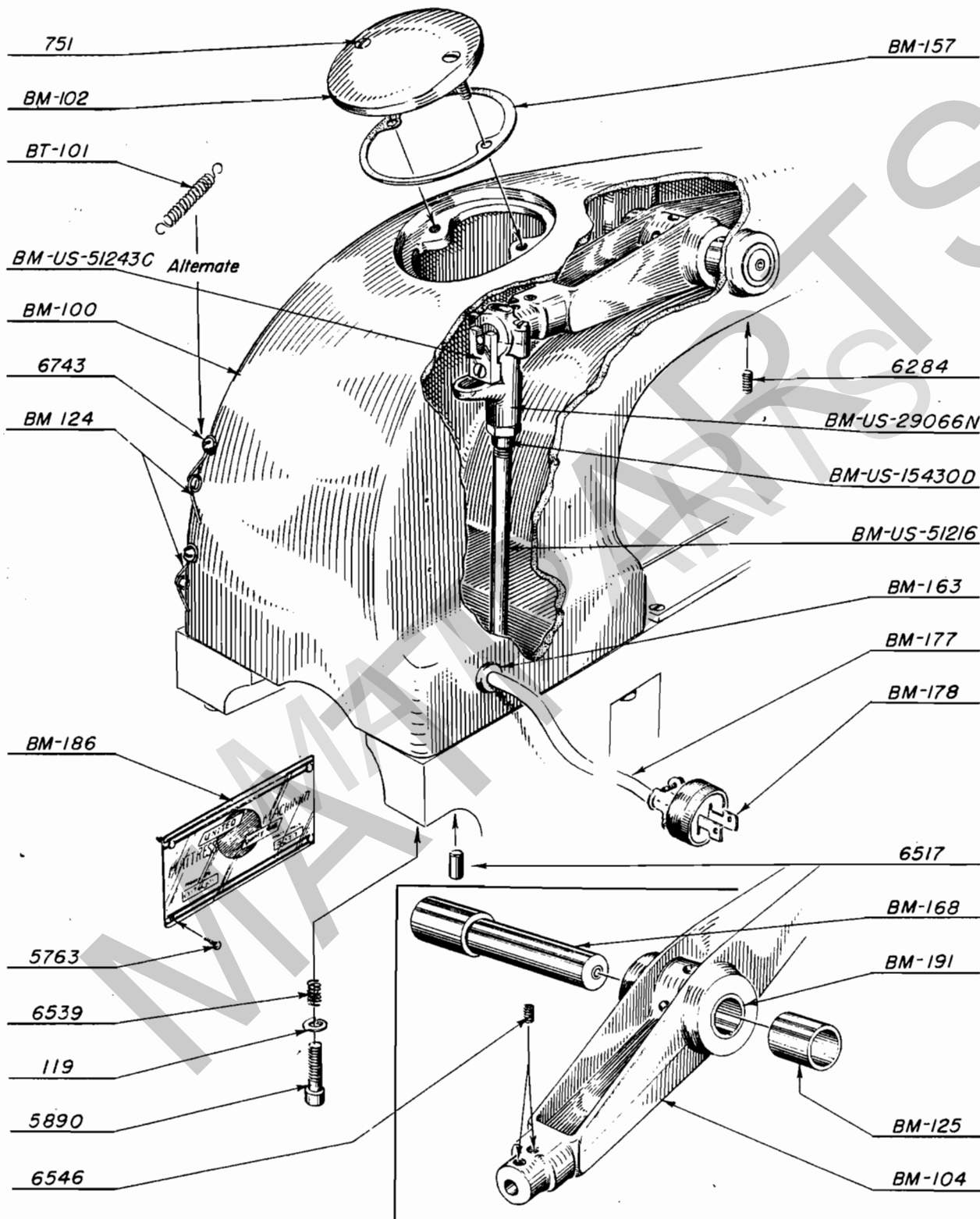


PLATE FOURTEEN

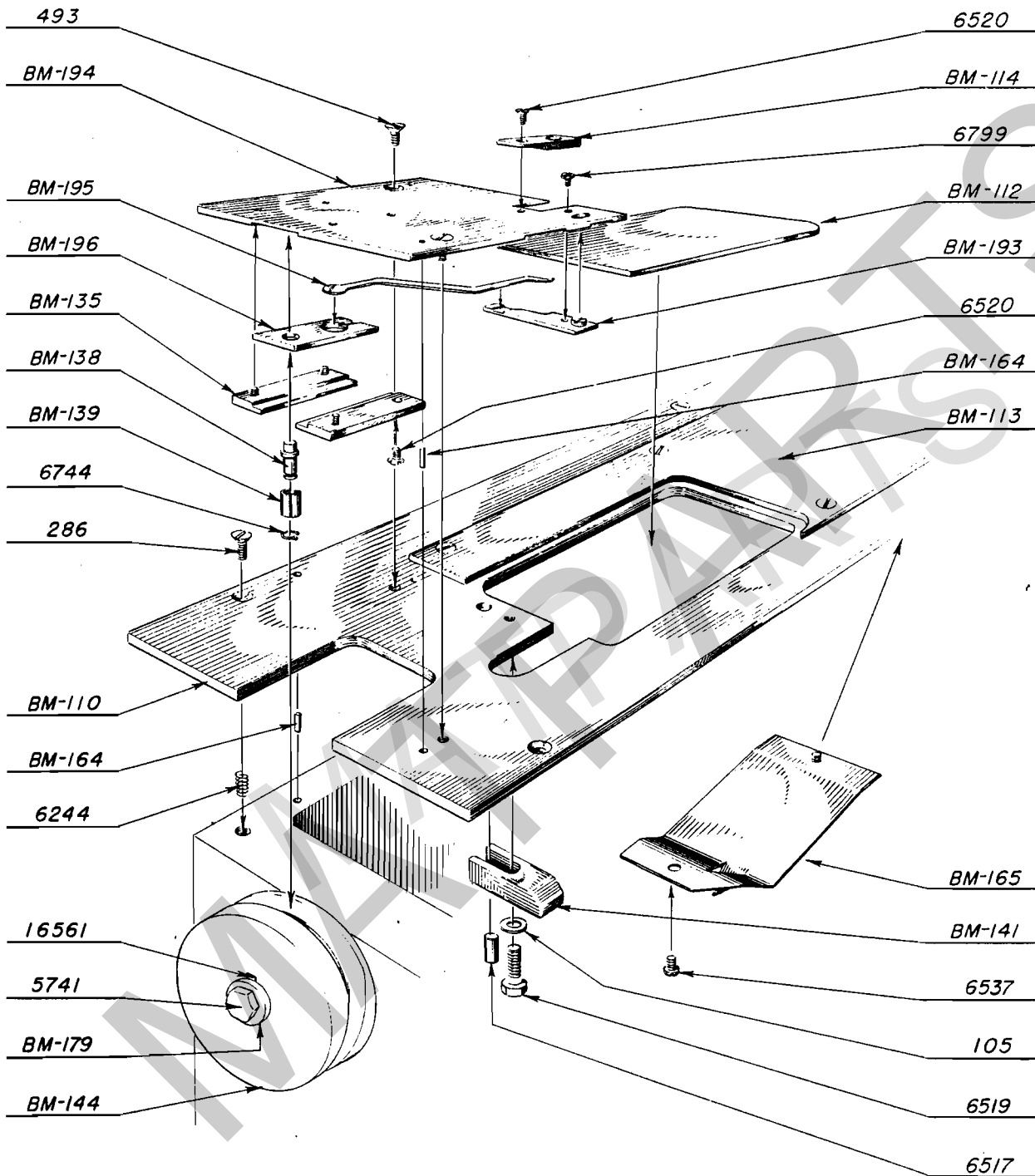


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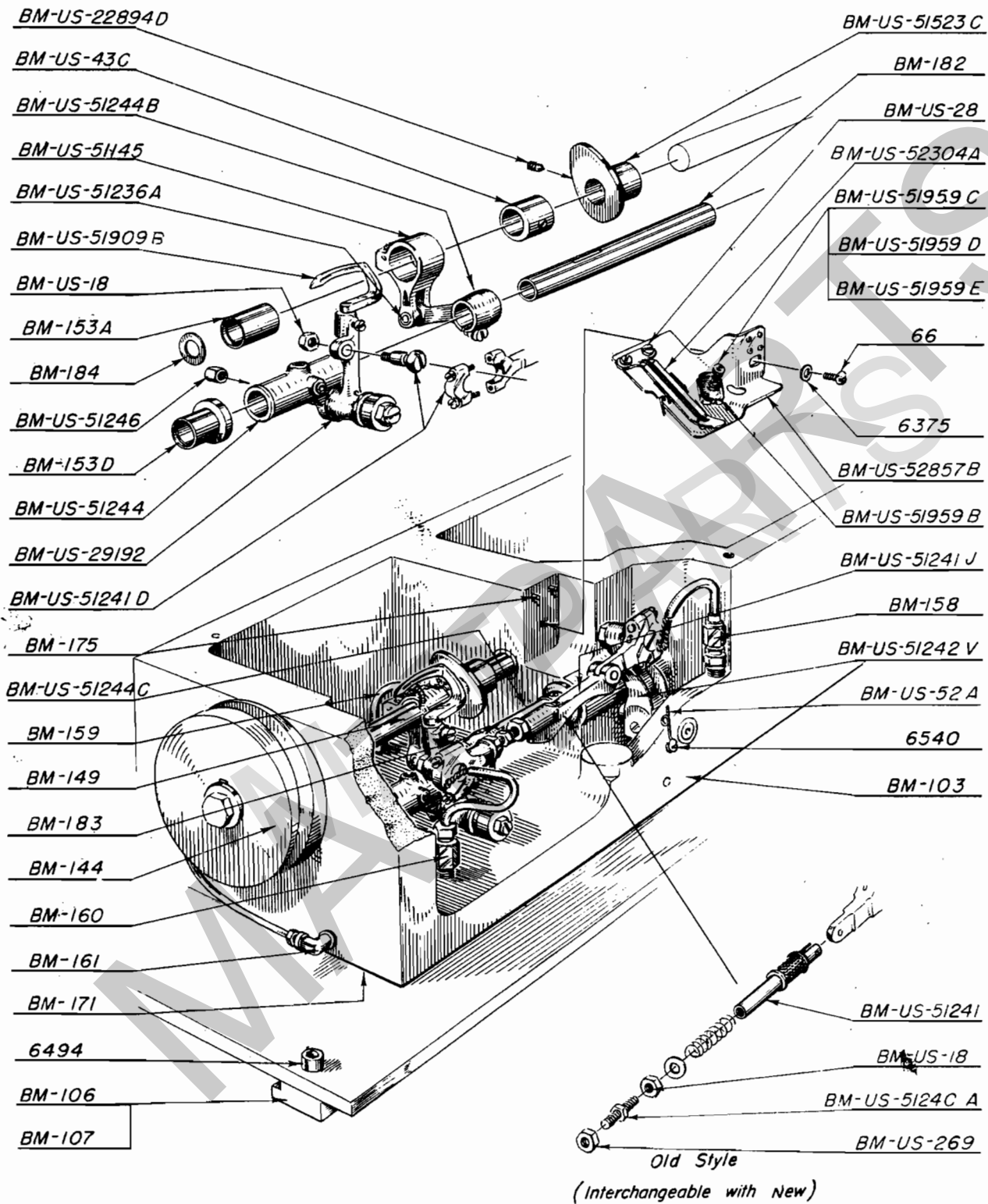


PLATE SIXTEEN

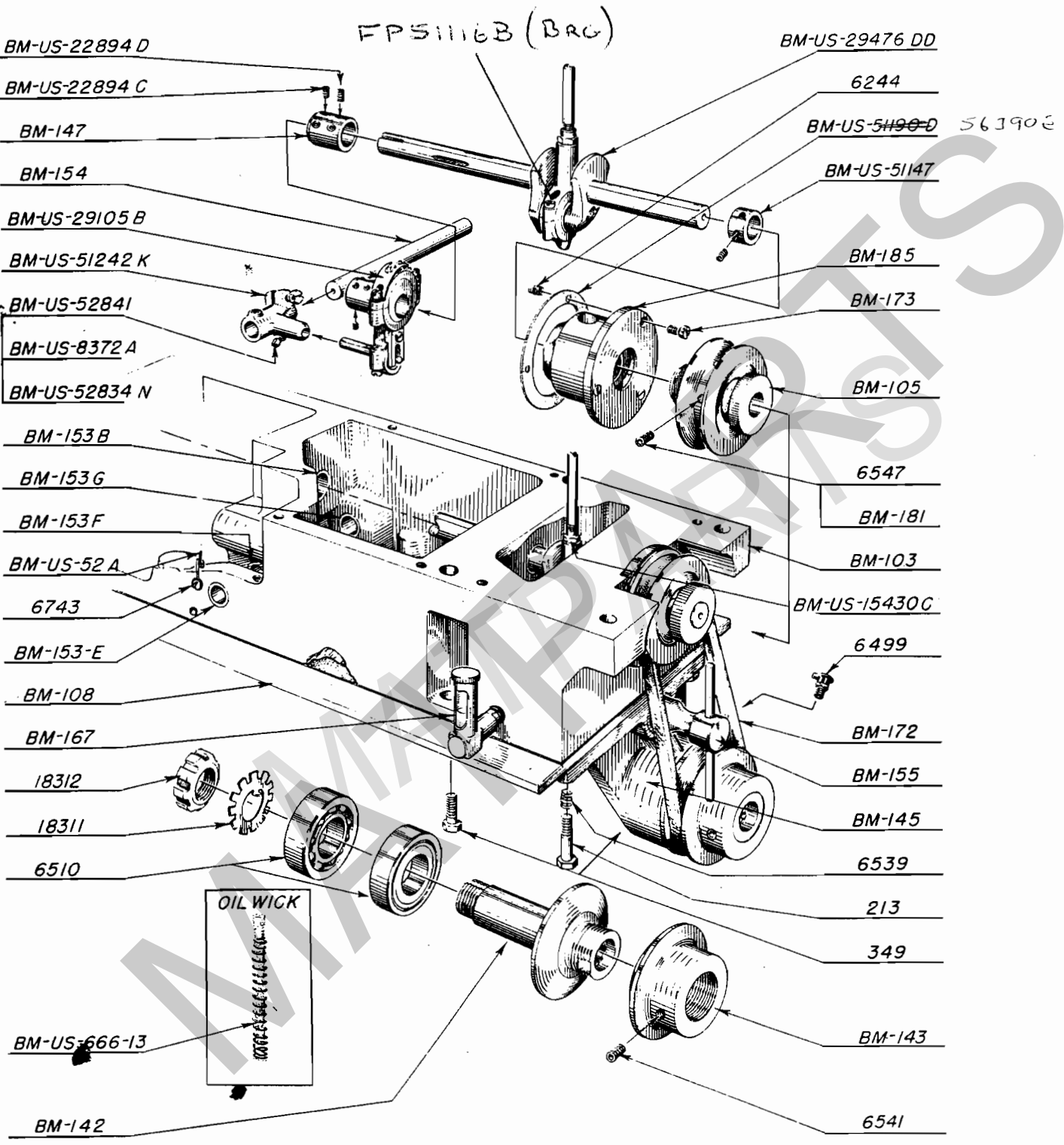
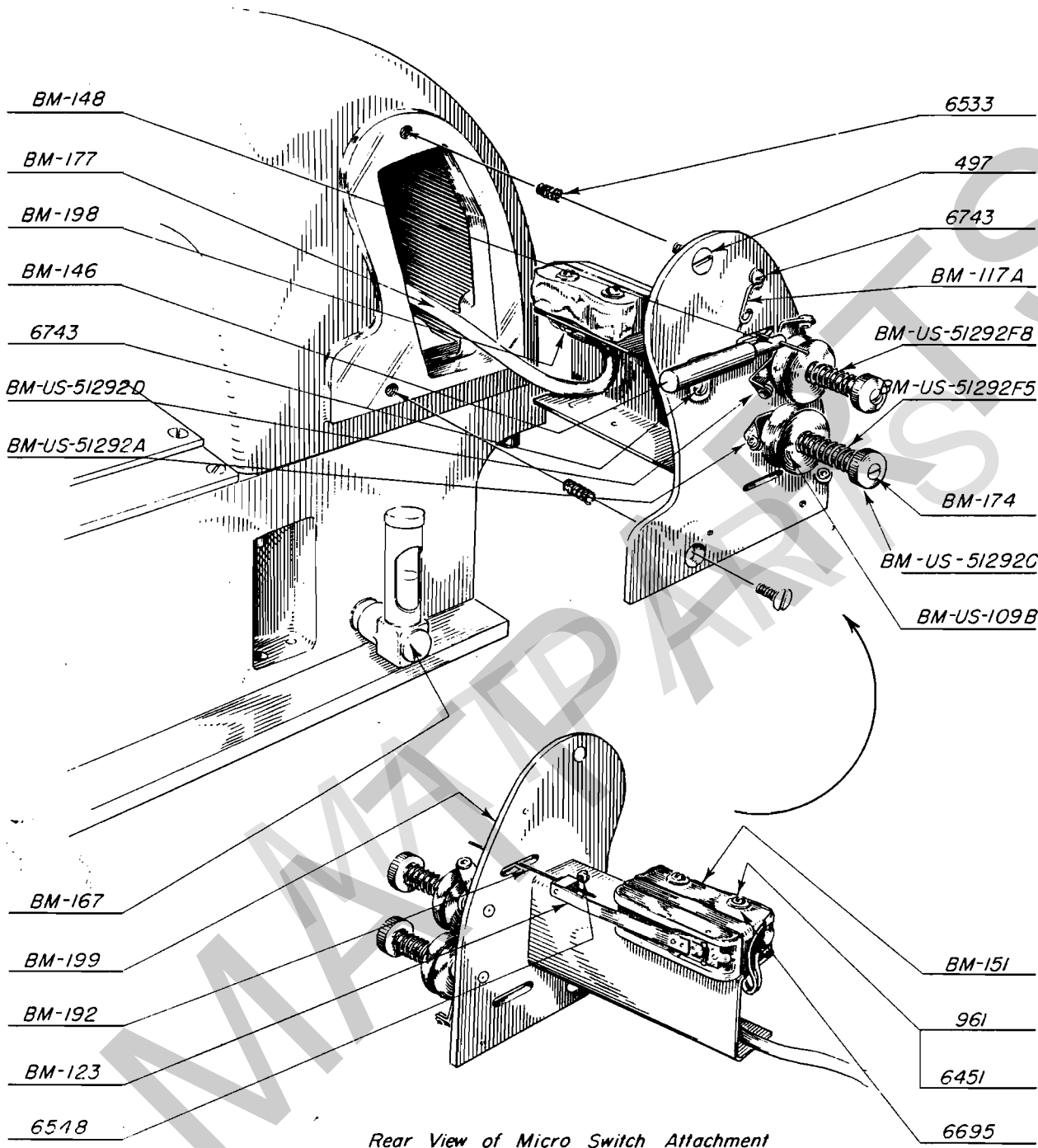


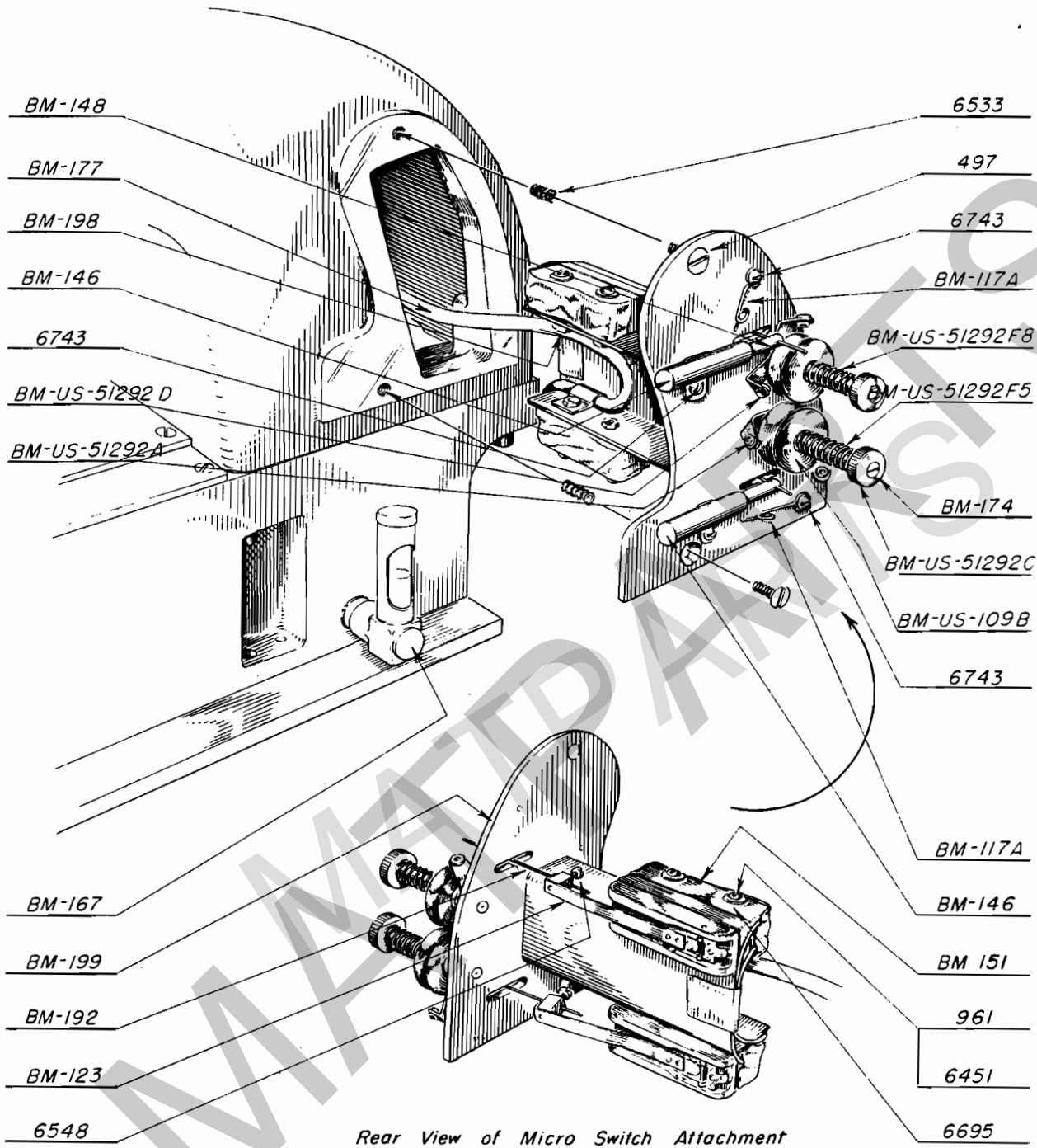
PLATE SEVENTEEN



Rear View of Micro Switch Attachment

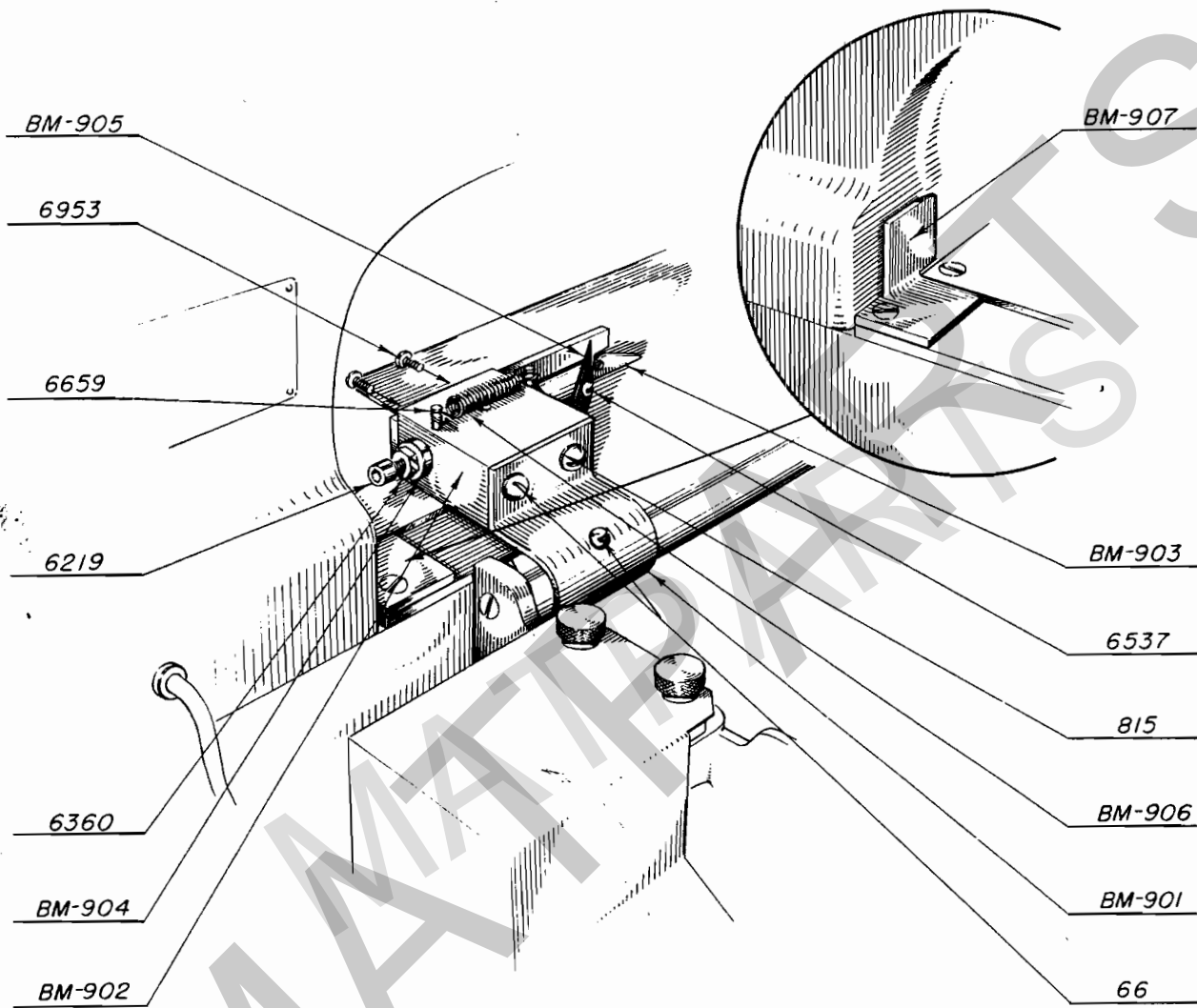
FOR UNITED BORDER MACHINE ONLY

PLATE EIGHTEEN



FOR UNITED POCKET MACHINE ONLY

PLATE NINETEEN



THREAD CUTTER ATTACHMENT
FOR UNITED POCKET MACHINE ONLY

PLATE TWENTY

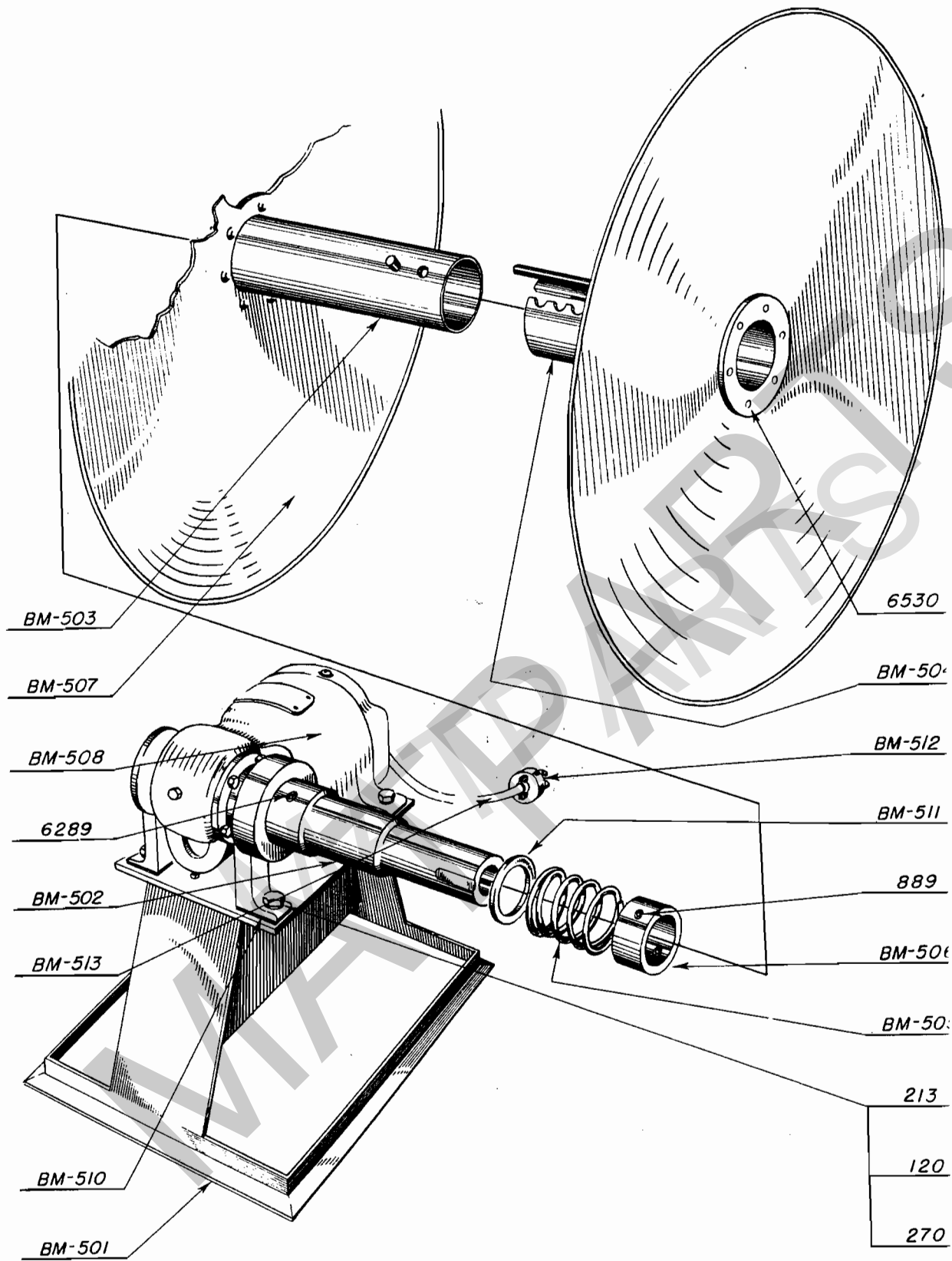
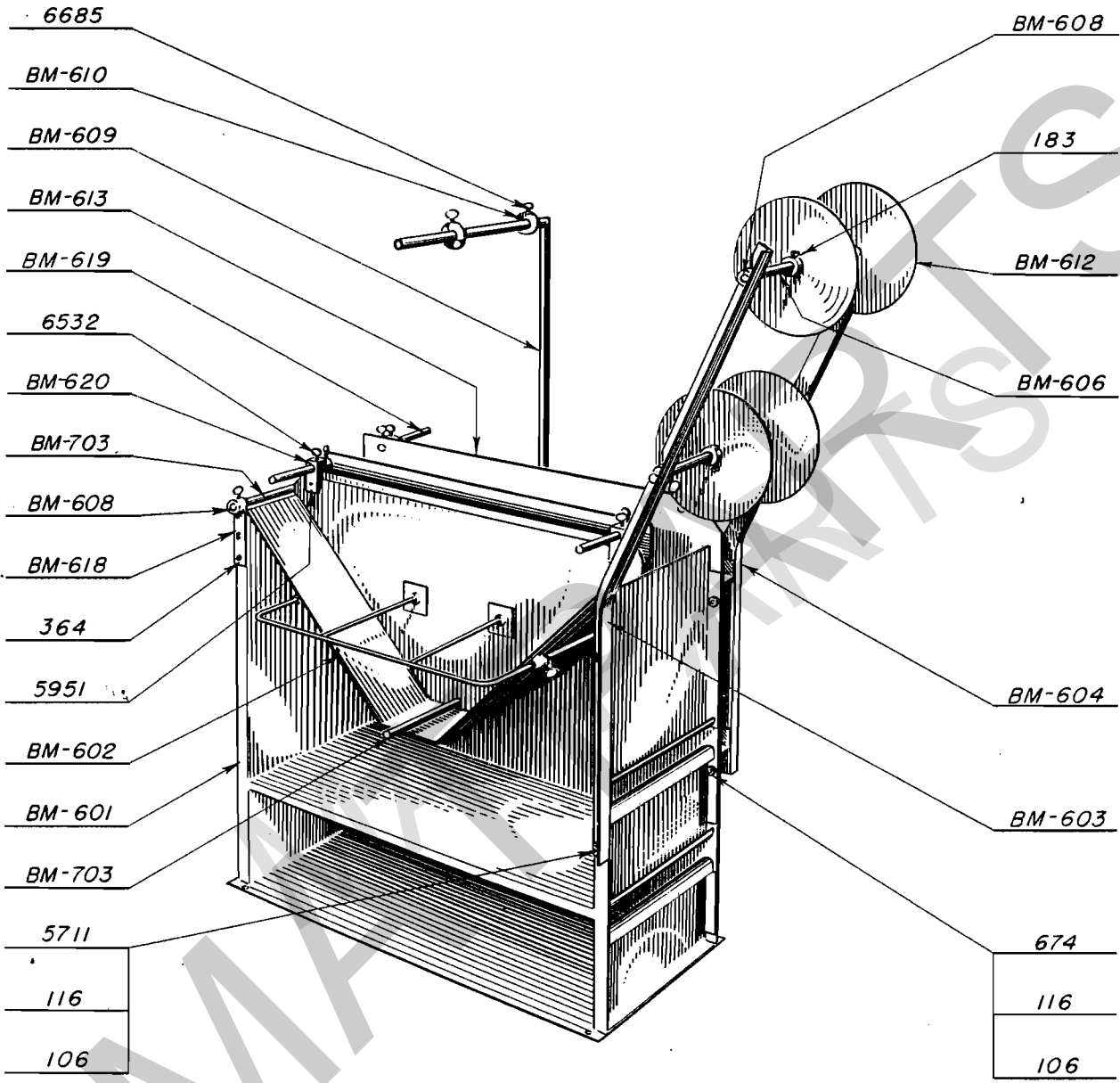


PLATE TWENTY ONE



FOR UNITED BORDER MACHINE

PLATE TWENTY TWO

SUPPLEMENTARY PARTS LIST FOR THE

UNITED BORDER MACHINE

NOTE: This supplementary list describes additional parts used, since printing this Manual, due to improvements or revisions of certain features of the Border Machine or Pocket Machine. While not illustrated in the Manual, these parts may be identified by the number on the part itself, or by the description given to the part in this list.

<u>PARTS NO.</u>	<u>NAME</u>	<u>NO. REQ'D</u>
BM-64	Cloth Centering Disc.....	1
BM-69	Cloth Centering Hand Screw.....	1
BM-188	Thread Guide Looper.....	1
BM-189	Copper tubing.....	1
BM-302	Magnetic Starter.....	1
BM-325	Conduit Junction Box to Micro Outlet,...	1
BM-433	Cloth Feed Cam 3-1/2" to 5" Alternate...	1
BM-434	Spool Carriage.....	1
BM-435	Cloth feed-Cartridge Bandoleer.....	1
BM-436	Front Cover-Lower Frame.....	1
BM-437	Back Cover-Frame.....	1
BM-438	Front Cover-Upper Frame.....	1
BM-439	Top Cover-Frame.....	1
BM-440	Lever End for BM-57.....	1
BM-441	Cross Head Bracket.....	1
BM-442	Pillow Block Bracket.....	1
BM-443	Crosshead Link Clevis.....	1
BM-444	Back Frame Cover.....	1
BM-445	Cloth Feed.....	1
BM-451	Traverse Cam - 3-1/2" to 5".....	1
BM-452	Shim for BM-67.....	1
BM-475	Speed Reducer.....	1
BM-476	Raising Block.....	1
BM-477	Pulley.....	1
BM-478	Crosshead Spring Rod Sleeve.....	1

<u>PART NO.</u>	<u>NAME</u>	<u>NO. REQ'D</u>
BM-744	Clamp Arm	1
BM-751	Eccentric Finger Gear Case	1
BM-752	Eccentric Finger Drive Gear	1
BM-753	Eccentric Finger Shaft	1
BM-754	Key for BM-765	1
BM-755	Eccentric	1
BM-756	Eccentric Finger Arm	1
BM-758	Eccentric Finger	1
BM-759	Eccentric Finger Pivot Link	1
BM-760	Eccentric Finger Support Bar	1
BM-761	Eccentric Finger Spacer	1
BM-762	Underhead Base Plate	1
BM-763	Throat Plate	1
BM-764	Throat Plate Insert	1
BM-765	Gear (Helical)	1
BM-766	Gear Case Gasket	1
BM-768	Key for BM-752	1
BM-766	Feed Rolls - Spacer Block	2
BM-777	Feed Roll Lock and Cover	1
BM-778	Lever Shaft	1
BM-779	Cloth Control Apron - Rear	1
BM-780	Finished Border Guide Frame	1
BM-908	Bracket	1
BM-909	Clamp	1
BM-US-51242M	Washer	1
BM-US-51242X	Looper Drive Lever, Incl. Screws	1
BM-US-51491C	Thread Eyelet	2
BM-US-52841G	Looper Drive Ball Joint Lock Stud	1
BM-US-52841H	Locking Nut	1
HS-57-B	Folder Plate - 1 each R & L	2
HS-57-C	Folder Plate - Flat	1
HS-57-D	Folder Plate - Flat	1
KX-834	Bushing	1
16808	Key	1

