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*Union Special*<sup>®</sup>

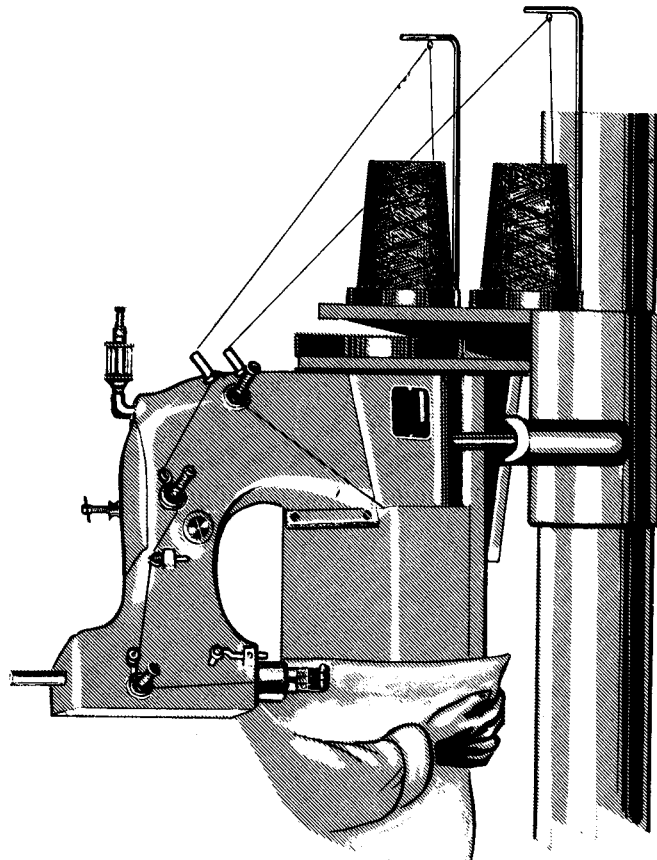
LEWIS · COLUMBIA

**INDUSTRIAL  
SEWING  
MACHINES**

**STYLES**

80600 R

80600 S



**CLASS 80600**

**SUPPLEMENTARY  
CATALOG**

No.

229 BE

This supplementary catalog contains only those parts of styles 80600 R and 80600 S which are not listed in catalog No. 229.

80600 R replaces style 80600 CZ, ST 3002

80600 S replaces style 80600 DZ, ST 3002 A

*Union Special* **MASCHINENFABRIK** G.M.  
B.H. **STUTT GART W SCHWABSTRASSE 33**

## Styles

- 80600 R Flat bed one needle bag closing machine for closing filled bags. With feeler controlled start and stop mechanism and solenoid actuated cutting device. Two thread double locked stitch. Filter cord guided under presser foot.
- Seam specification SSa-1, stitch type 401, plain feed, teeth cut 7 per inch, working diameter of pulley 5 7/8 inches (150 mm).
- 80600 S Same as 80600 R, however for one thread chain stitch type 101.

## DESCRIPTION

### OF BAG CLOSING MACHINES WITH AUTOMATIC START, STOP, AND CHAIN CUT.

80600 R for double locked stitch,

80600 S for chain stitch.

These automatic bag closing machines are developed from our standard closing heads 80600 C and 80600 D. The seams produced are identical. However, the stitch range is limited to 2 - 3 Stitches per inch. For extra seam strength a filter cord can be used. Both closing heads can be furnished in combination with our standard bag closing units 20100 D, H, G, 90800 K, and with our new dual headed unit. They also can be mounted on existing units. In both cases a new switch box is necessary and the existing motor has to be replaced by a brake motor.

As the basic construction of the automatic heads corresponds with the standard machines the spare part numbers can be taken from the catalog No. 229. Additional parts of feeler control and of the cutting device are listed in this supplementary catalog No. 229 BE.

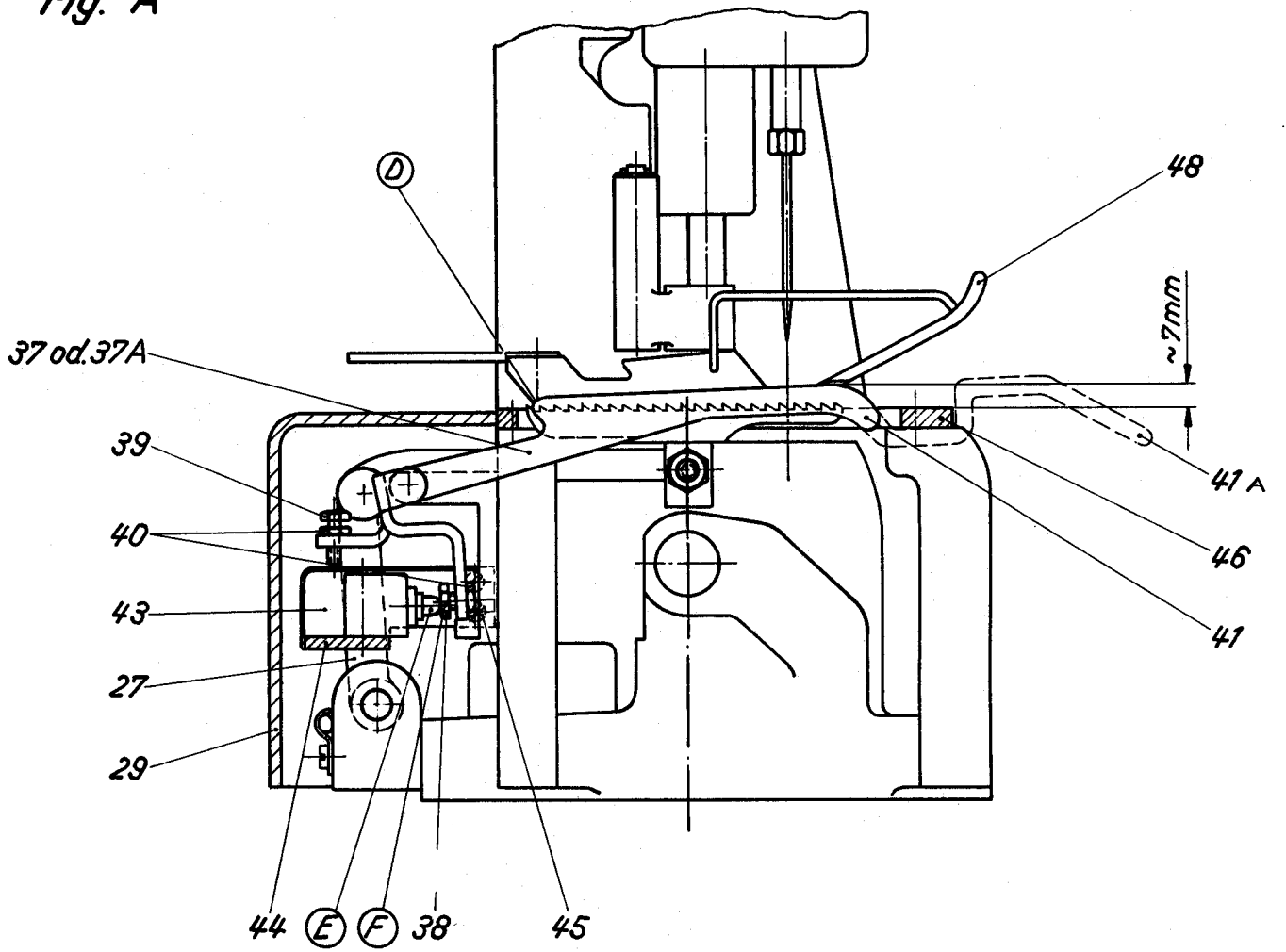
The automatic start, stop, and chain cutting device works as follows:

When the bag moves between the throat plate (46) and the presser foot (48) it touches a sensitive feeler (41 or 41A) which releases a micro-switch (43). This gives power to the motor by means of a relay and the machine starts sewing. During the sewing operation the cutter is kept below the surface of throat plate by means of a retaining spring (26) (see fig. B where position is shown with heavy lines). As soon as the bag is closed, which means that the entire bag has passed the feeler (41 or 41A), the feeler moves back to its initial position and disconnects the micro-switch (43). This cuts off the power supply for the motor and the sewing machine stops. At the same time the relay transfers current to the solenoid (1), the stroke of the solenoid causing the cutting knives (14) to rush forth into cutting position (see fig. B, position shown with interrupted lines). The knives remain in this position until the next bag pushes down the feeler (41 or 41A). Thereby power is again supplied to the motor while the power to the solenoid is switched off.

ADJUSTING INSTRUCTIONS ETC. FOR FEELER CONTROLLED START AND  
STOP MECHANISM AND FOR SOLENOID ACTUATED CHAIN CUTTING DEVICE

- 1.) The feeler (41 or 41A) (see fig. A and C) rests easily movable between points on the bracket (36). Set the stud to center the slot of the throat plate. This is accomplished by loosening the screws (49) and moving the stud to the left or to the right. Check that the feeler (41 or 41A) has no axial play.
- 2.) The setting of the feeler (41 or 41A) is correct when it projects  $9/32$  inch (7 mm) above the surface of the throat plate (46) (see fig. A). This setting is achieved by means of a stop screw (39). The space between the button (E) of the micro-switch (43) and the head (F) of the switch screw (38) should be appr. .008 inch (0,2 mm). This means that the button (E) has its stop inside the micro-switch (43).
- 3.) When the solenoid (1) is without current the upper edge (G) of the cutting knives (14) must be about .040 inch (1 mm) below the upper edge of the throat plate (see fig. B) but not lower, in order to clear the feed bar (28). Tighten the guard (12) securely to maintain this setting.
- 4.) The after-cutting-position of the knives (14) is shown in fig. B with interrupted lines. The knives should somewhat overlap each other, similar to scissors, to guarantee an immaculate chain cutting. This should be noticed especially when the knives have been resharpened.
- 5.) Attach the solenoid (1) and bracket (4) with screws (5) (tighten securely!) to the bed so that the plunger (H) comes to rest on the bottom (J) of the solenoid. When the solenoid is switched on a metallic click must be heard. After the knives have been resharpened a lengthwise shifting of the solenoid bracket (4) may become necessary. For this purpose the frame has segment holes.
- 6.) The knives can as frequently be resharpened as their cutting edges still overlap each other and the long shank (K) of the one knife still clears the lower edge of the throat plate. It should never contact throat plate since the only permissible stop (see point 5.) is at the bottom of the solenoid. Likewise, there should be no contact between the knife stud (20) and the knife at "L".
- 7.) The knives can be replaced in pairs only (det. 14, part No. A9203). For this purpose, remove cloth plate (29) and throat plate (46), swing back cover plate (31) and turn pulley until feed dog (47) is at its most forward end of travel at "M". After loosening the screw (22) shift both knives and stud (14 and 20) in direction of arrow (N) (see fig. C) and then take out the knives from above.

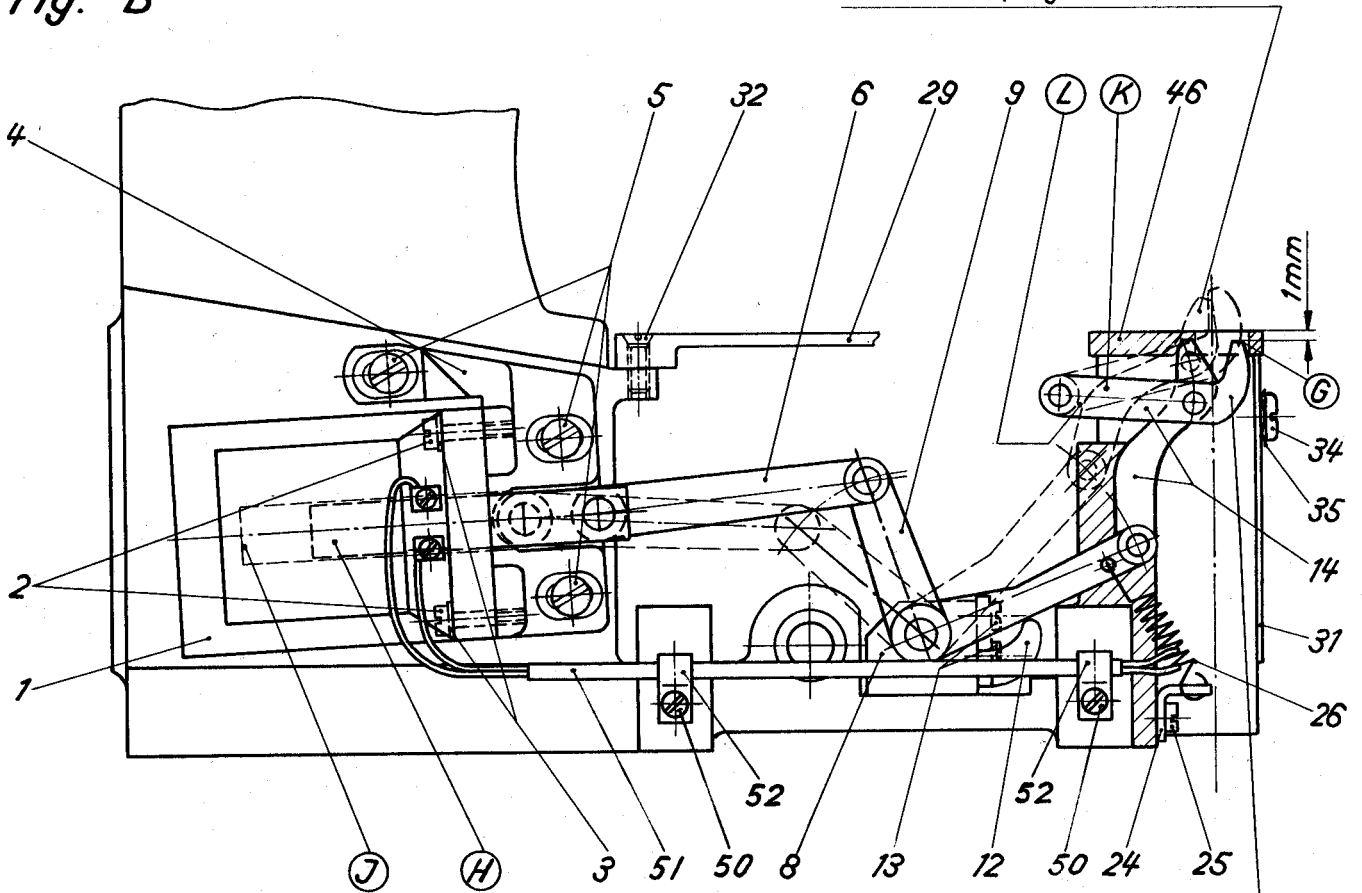
Fig. A



<u>Ref.No.</u>	<u>Part No.</u>	<u>Description</u>
27	80633 R	Feed Rocker (formerly A 9205)
29	80601 R	Cloth Plate (3- 22574) (formerly A 9207)
37	80690 R	Feeler Assembly (formerly A 9208) consisting of:
	1- 80697 R	Feeler (formerly A 9208 A)
	1- 80638 S	Pin (formerly A 9208 D)
	1- 99288	Spot Screw (formerly A 9208 E)
	1- 906	Screw
	2- 907	Nut
	1- 15037 A	Nut
	1- 22588 A	Screw
37 A	80690 S	Feeler Assembly (formerly A 9208 G), same as 80690 R but with elongated Feeler 80697 S
38	22588 A	Screw
39	906	Screw
40	907	Nut
41	80697 R	Feeler, for 80690 R Assembly (formerly A 9208 A)
41 A	80697 S	Feeler, for 80690 S Assembly (formerly A 9208 F)
43	G 21233 RS	Micro-Switch Assembly (formerly A 9209) (single parts see drawing No. 18753-N)
44	80695 R	Micro-Switch Support (4- 22585) (formerly A 9209 A)
45	22585	Screw
46	80628 R	Throat Plate (formerly A 9210)
48	80627 R	Presser Foot Assembly (formerly A 9212) consisting of:
	2- 88	Screw, set, for 80620 N
	1- G 50-211	Guide Wire, right
	2- 12934 A	Nut, for 22560 A
	1- 22526	Screw, for 80627 U
	2- 22560 A	Screw, for 80620 N
	1- 80620 G	Chaining Block Spring
	1- 80620 H	Locking Pin, for 80627 T
	1- 80620 P	Double Tension Spring
	1- 80620 N	Presser Foot Shank
	1- 80627 S	Presser Foot Bottom
	1- 80627 T	Chaining Block
	1- 80627 U	Guide
	1- 80627 V	Guide Wire, left
	1- 92131	Hinge Screw

**Fig. B**

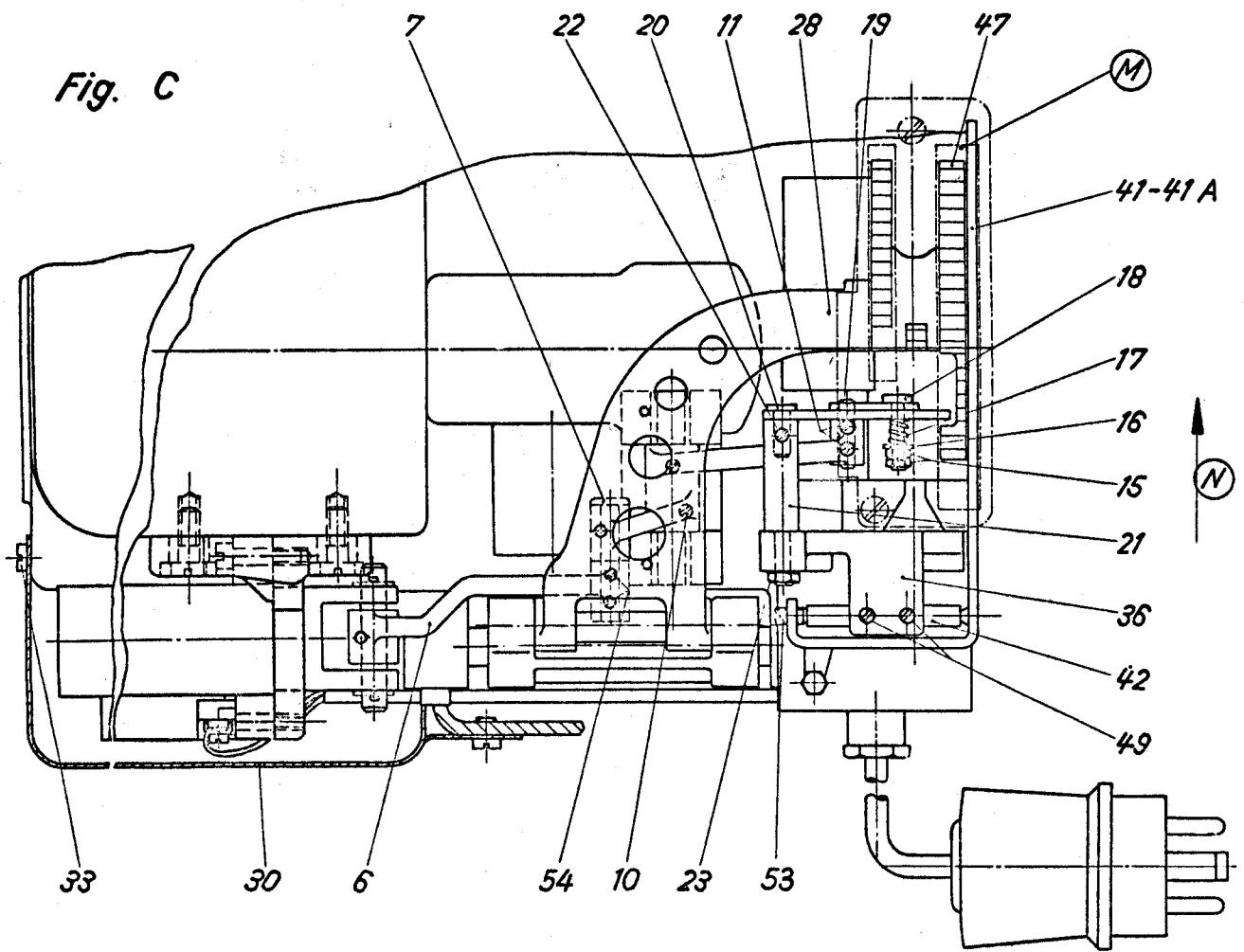
*Messerstellung nach dem  
Schneiden (Magnet hat Strom)*



*Messerstellung beim Nähen  
Magnet ist stromlos  
Rückzugfeder 96702 hält  
Schneidapparat gegen  
Anschlag 80685 R*

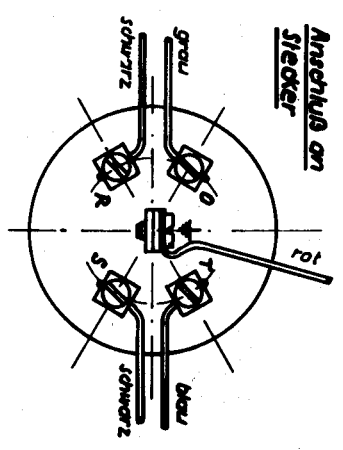
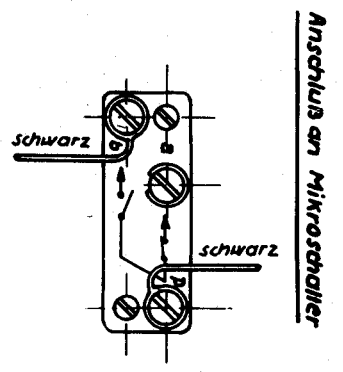
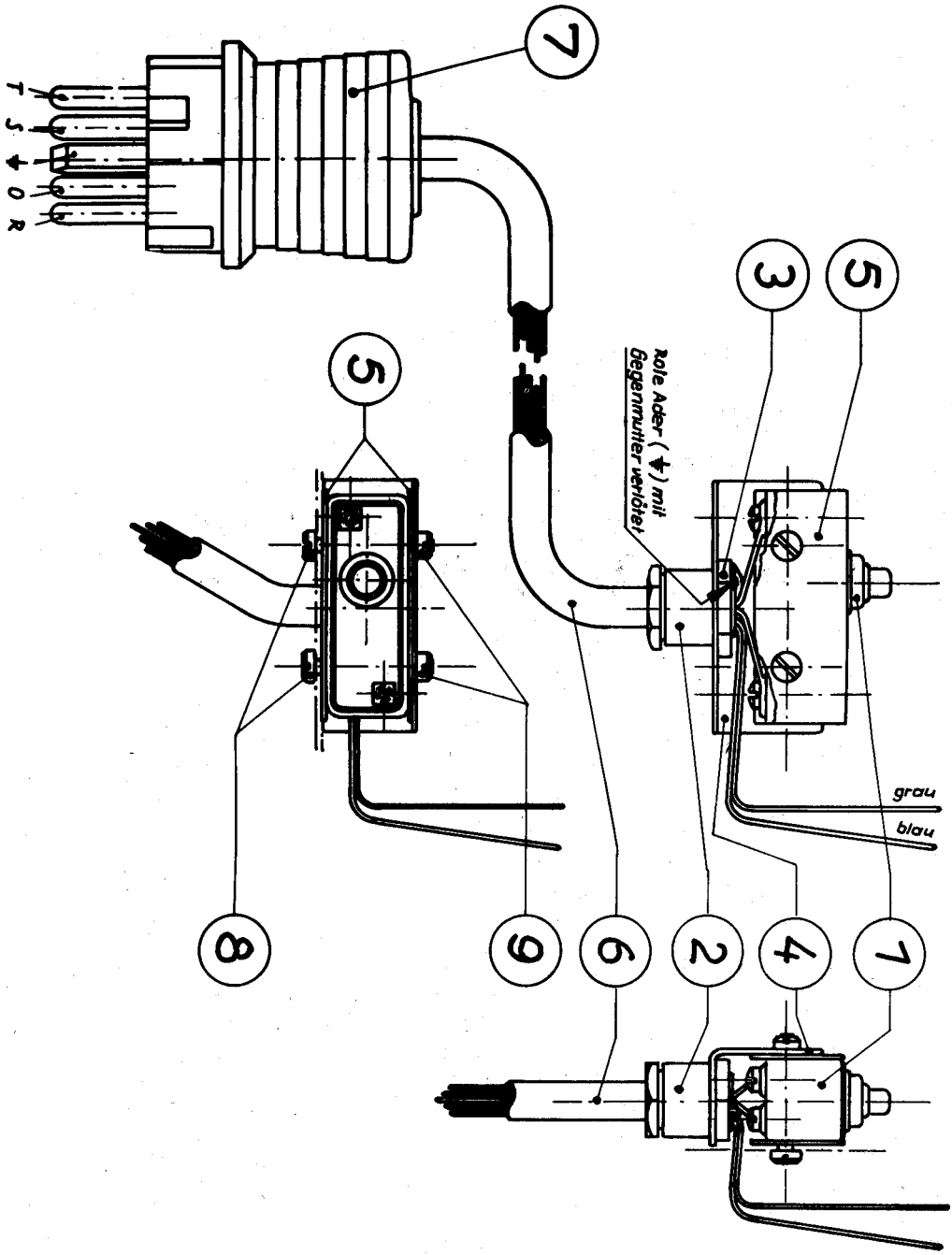
<u>Ref.No.</u>	<u>Part No.</u>	<u>Description</u>
1	998-50	Solenoid (4- 22826, 4- 80265) (formerly A 9200)
2	22826	Screw for 998-50
3	80265	Washer
4	80680 R	Attachment Bracket (3- 99289) (formerly A 9200 A)
5	99289	Screw for 80680 R (formerly A 9202 C)
6	80684 S	Lever (2- 94) (formerly A 9201)
8	80684 R	Bracket with two Bushings 80692 A (2- 99289) (formerly A 9202)
9	80683 R	Lever (2- 22580, 2- 22743) (formerly A 9202 A)
12	80685 R	Guard (2- 22528) (formerly A 9202 B)
13	22528	Screw for 80685 R
14	80677 R	Upper Knife and Lower Knife Assembly (formerly A 9203)
24	80696 R	Spring Support (1- 93 A) (formerly A 9204)
25	93 A	Screw
26	96702	Spring (formerly A 9204 A)
29	80601 R	Cloth Plate (3- 22574) (formerly A 9207)
31	80682 R	Cover Plate (1- 92921, 1- J 1614) (formerly A 9207 B)
32	22574	Screw for 80601 R
34	92121	Screw
35	J 1614	Spring Washer
46	80628 R	Throat Plate (formerly A 9210)
50	90	Screw
51	80698 R	Cable Tube
52	G 21233 D-4	Cable Holder

Fig. C

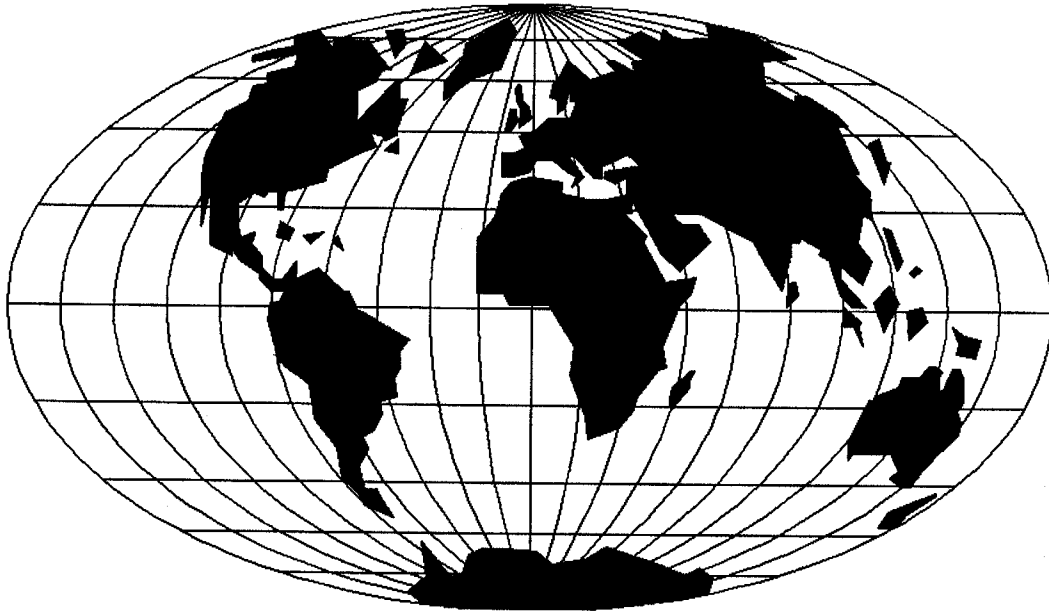




<u>Ref.No.</u>	<u>Part No.</u>	<u>Description</u>
6	80684 S	Lever (2- 94) (formerly A 9201)
7	80652 S	Stud (formerly A 9201 A)
10	22580	Screw for 80683 R
11	22743	Screw for 80683 R
15	41071 G	Nut
16	80265	Washer
17	97000	Spring (formerly A 9203 C)
18	80652 R	Stud (formerly A 9203 D)
19	80699 R	Pin (formerly A 9203 E)
20	80651 R	Stud (formerly A 9203 F)
21	80651 S	Knife Stud (1- 88, 1- 12538) (formerly A, 9203 G)
22	88	Screw for 80651 S
23	12538	Nut for 80651 S
28	80634 R	Feed Bar (formerly A 9206)
30	80682 S	Cover (3- 94) (formerly A 9207 A)
33	94	Screw for 80682 S
36	80691 R	Bracket (formerly A 9208 B)
41	80697 R	Feeler for 80690 R Assembly (formerly A 9208 A)
41 A	80697 S	Feeler for 80690 S Assembly (formerly A 9208 F)
42	80638 R	Shaft (formerly A 9208 C)
47	80605 R	Feed Dog (formerly A 9211)
49	88	Screw



<u>Ref.No.</u>	<u>Part No.</u>	<u>Description</u>
1	G 21233 P-240	Micro-Switch
2	G 21233 R	Plug Screw
3	G 21233 S	Nut
4	G 21233 X	Cover Plate
5	G 21233 Y	Insulating Plate
6	G 21233 AD	Cable
7	G 21233 VA	Connector
8	99279	Screw
9	99013	Nut
-	G 21233 RS	Micro-Switch Assembly (formerly A 9209)



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