

BASIC MAINTENANCE FOR CLASS 80800 MACHINES

By Doug Kanies

Union Special Corporation's Class 80800 bag closing sewing machines close bags filled with grains, pet foods, outdoor products and many other miscellaneous products.

However, Class 80800 machines do not have an automatic enclosed lubrication system. As a result, it must be lubricated by hand. Following are the proper procedures for maintaining this rugged, reliable equipment.

1) The machines have to be cleaned and lubricated at the points indicated on **Figure 1** twice a day, before morning and afternoon start. The sight feed oiler has to be refilled before 2/3rds of the oil is used up.

For lubrication we recommend "Mobil Oil DTE Medium" or Spec. 175, Mobil Oil Prorex 39 which can be purchased from Union Special Corporation in 1 pint containers under part number 28604R, or in 1 quart containers under part number 28604S.

Before operating a new machine for the first time, the needle bar guard, **E, Figure 1**, and the sight feed oiler, which are two of the accessories that come with the machine, have to be screwed in. The sight feed oiler has to be adjusted. And all lubricating points indicated on the diagram, **Figure 1**, have to be oiled.

For adjusting, fill the sight feed half way with oil and turn the metering pin, **A, Figure 1**, a little bit out. Then turn it in until you get an oil flow rate of approximately 2 drops

per minute. This can be checked on the sight glass, **B, Figure 1**. Secure the setting of the metering pin with lock nut **C, Figure 1**. Fill the oiler. Repeat oiling of a new machine after 10 minutes of operation. When the machine is out of operation the oil flow can be stopped by tilting lever **D, Figure 1**, on the sight feed oiler. **IMPORTANT!** The oil flow has to be switched on again before operating the machine.

2) Next check the machine for proper threading, **Figure 2**. Im-

Style 80800 bag closing machine from Union Special Corporation.

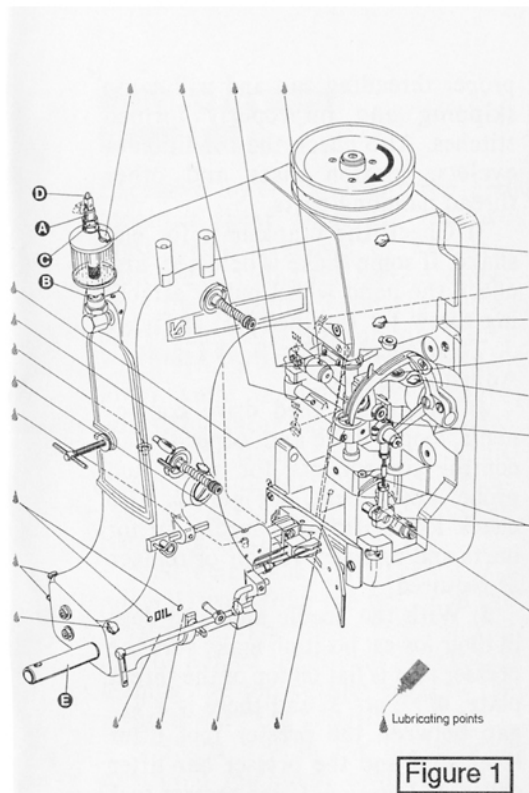
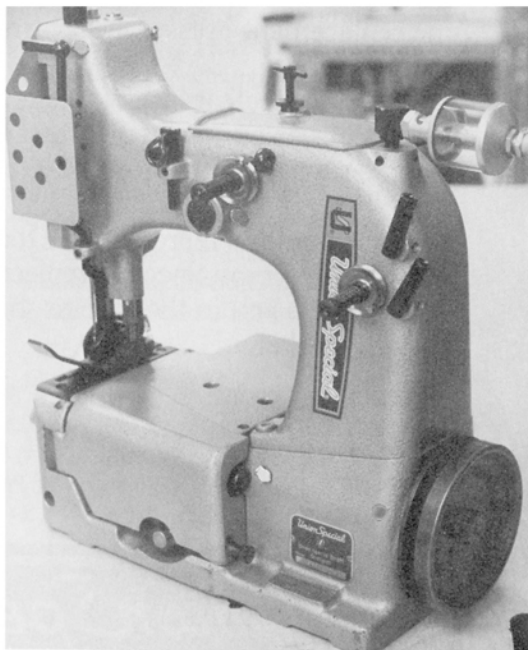


Figure 1

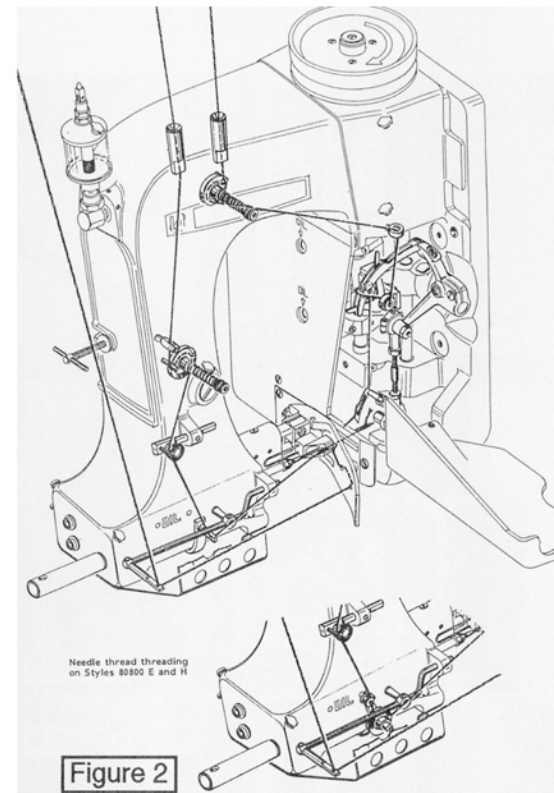


Figure 2

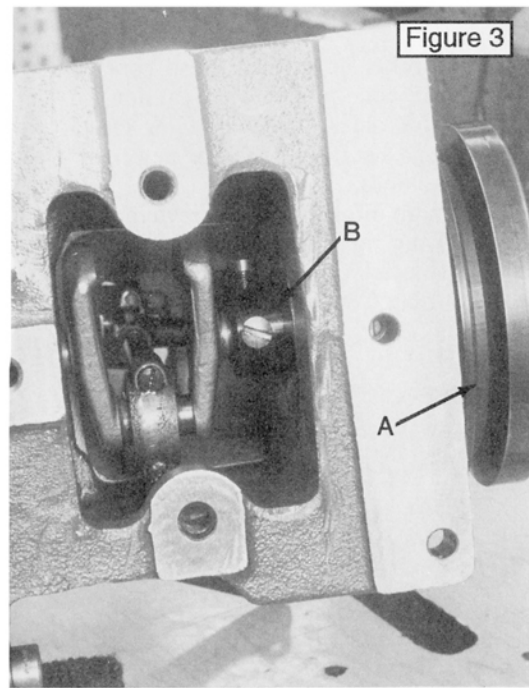


Figure 3

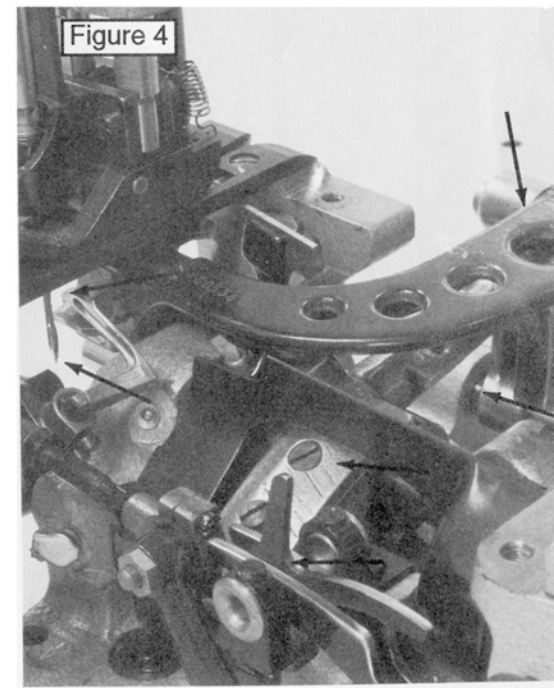
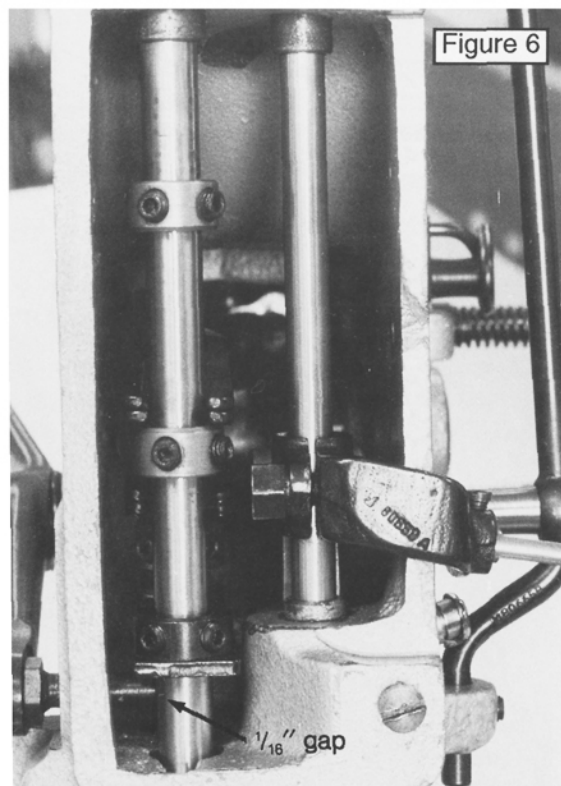
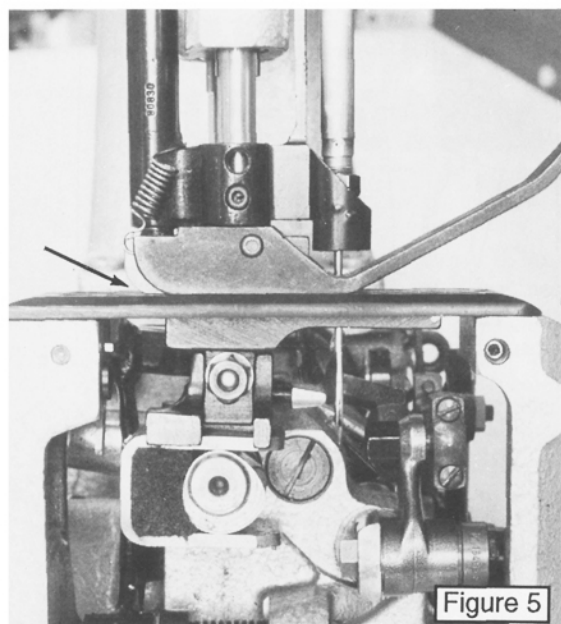


Figure 4



proper threading can and will cause skipping and improperly formed stitches. Also check the condition of eyelets, tension discs and other thread handling parts.

3) Check the crankshaft for end shake. If some shake is detected, first check the hand wheel pulley attaching screw for tightness, **A, Figure 1 3**. Then check collar **B, Figure 3**. Adjust as needed.

4) Check the feed drive components, looper drive and looper thread control components for wear and proper adjustment, **Figure 4**. Also check looper tip and needle tip for burrs and damage. Repair or replace as required.

5) With the needle and feed dogs in their lowest position make sure the presser foot is flat on top of the throat plate, **Figure 5**. and there is a $\frac{1}{16}$ '' gap between the presser foot lifter lever stud and the presser bar lifter collar, **Figure 6**. If the presser foot is hung, the material will not feed properly.

6) All other adjustments and correct parts can be found in catalog #137M for older 80800 E, F & H styles. And catalogs #285 for newer style machines.