FIRST EDITION



CATALOG NO. 103X

STYLES

39500X

STREAMLINED HIGH SPEED OVERSEAMERS

Union Special Wants to Help You Cut Sewing Machine Maintenance Costs

Union Special is offering two practical systems to help pinpoint and reduce your sewing machine maintenance costs: a record keeping system to help spot machines requiring abnormally high maintenance, and a parts inventory system to speed routine repairs.

Machine Maintenance Records

Repair-prone machines or inexperienced operators can eat up your maintenance dollars in short order. To help spot these problems, Union Special suggests two variations of a simple maintenance record keeping system using cards provided by Union Special.

The first system utilizes a "Machine Maintenance Record" card (Form 237) for each sewing machine in a plant. When a repair is required, the card is pulled from the file and the repair date, parts used, and their cost are entered in the spaces provided and the card is refiled.

	ER'S NAME	STYLE	TY	PE NEEDLE	SERIAL NO.	DATE PURCH.
DATE	SYMBOL PART U	SED	COST	DATE	SYMBOL PART USE	D COS
		FO Mach	Ma	237		
		= Mach	ine M	laintené	Ince	
		Rec	ora ca		 -	
		Rec	ord Ca			

The second system is normally used when more detailed information on repair costs is desired. Two record cards are used: a "Repair Request Card" (Form 234), and a "Machine Repair Record" (Form 233). When a machine requires service, the

MAKER'S NAME MAKER'S NAME DATE MECH'S COST COST SERVICE DATE MECH'S COST COST SERVICE MAKER'S NAME MAKER'S NAMER'S NAMER'S MAKER'S NAMER'S MAKER'S NAMER'S MAKER'S NAMER'S MAKER'S NAMER'S MAKER'S NAME						INV. SYMBOL	
DATE MECH'S LASOR PARTS TOTAL SERVICE BAYS MAKER'S NAME.	IAKER'S NAME	MAKER'S SYMBOL		NEEDLES SERIAL DAY EMPLOYED NUMBER PURC		PURCHA	
Machine Repair Record FORM 234 Repair Request Card	DATE MECH'S LA		TOTAL	service	REPA DATE INVENTORY S MAKER'S NAM MACH, SERIA OPERATOR'S	IR REQUEST YMBDL 46. L NO. NO. PARTS USED PART NUMBERS	COST

forelady or foreman fills out the top of a "Repair Request Card" and gives it to a mechanic. He fills in the time the repair work is started, the parts used and their cost, and the completion time. This data is then transferred to the permanent "Machine Repair Record" kept in the office.

Whichever system is used, management now has an invaluable tool to reduce needless maintenance costs.

Repair Part Inventories

While record keeping tells management which machines require abnormally high maintenance, it does little to help reduce the downtime caused by routine repairs. To alleviate this situation, Union Special recommends that manufacturers establish a formal parts inventory system for each type of sewing machine they operate.

Excessive machine downtime and wasted hours by mechanics can be eliminated with an orderly in-plant inventory of the most commonly needed parts. There is no longer a need to cannibalize other machines for spare parts. Long waits for deliveries are avoided and machine downtime is kept to a minimum. The cost of a parts inventory is small when the overall savings are considered.

Style 39	500 QB	
Part Number	Description	Minimum Spare Parts Per Machine
39520 A	Presser foot	1
39530	Presser foot hinge spring	2
39597 A	Presser foot stitch tongue marked "DS"	
39524 B 3/32	Throat plate marked "V-3/32"	1
or	or	-
39524 B 1/8	Throat plate marked "V-1/8"	1
22524	Throat plate screw	2
39526 B	Differential feed dog, 16 teeth per inch	1
39505 B	Main feed dog marked B, 16 theth per inc	
39505	Chaining feed do LE SCRAMPLE SAMPLE Spare Parts List Spare Parts List	1
22528	Screw ANDIL	2
93 A	CAIVIF	2
22797 A	Darts List	2
39570	Spare	4
14077	N upper knife clamp stud	ĭ
39549	Lower knife	. 4
22588 A	Screw for lower knife clamp	1
39508 B	Lower looper	i
39508 A	Upper looper marked "CC"	i
225646	Screw for upper looper	2
39551 F	Needle clamp stud	1
14077	Nut for needle clamp stud	î
22596 E	Screw for needle driving arm	2
21225 1/8	Looper guage	Ť.
154 GAS	Needles (specify size)	100

For free sample copies of the machine record cards and spare part inventory lists for a variety of the most popular machines, contact your local Union Special Representative or write direct to Union Special.

Catalog No. 103 X (Supplement to Catalog No. 103 R)

INSTRUCTIONS

FOR

ADJUSTING AND OPERATING

LIST OF PARTS

CLASS 39500

Style

39500 X

First Edition

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UNION SPECIAL CORPORATION

INDUSTRIAL SEWING MACHINES

CHICAGO

Printed in U.S.A.

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 39500 X". 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 39500 XZ".

Styles of machines similar in construction are grouped under a Class number, which contains no letters. Example: "Class 39500".

APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 103 R and should be used in conjunction therewith. Only those parts which are used on Style 39500 X and not on Style 39500 N are illustrated and listed at the back of the book.

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 39500. All references to directions, such as right and left, front and back, etc., are taken from the operator's position while seated at the machine. Operating direction of handwheel is away from operator.

STYLES OF MACHINES

Single Curved Blade Needle, Two Looper, Three Thread, Overseaming Machine. Plain Feed, Trimming Mechanism with Spring Pressed Lower Knife, Automatic Lubricating System.

39500 X For simultaneously attaching right pants flies and zipper tapes to pants fronts; also attaching zippers to right flies only and similar operations. Seam specification 504-SSa-1 or 504-SSj-1, standard seam width 3/8 inch; stitch range 6 to 16 per inch, standard setting 10 per inch.

OILING

CAUTION! Oil was drained from machine when shipped, so reservoir must be filled before beginning to operate. Oil capacity of Class 39500 is eight ounces. A straight mineral oil of a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit should be used.

Machine is filled with oil at spring cap in top cover. Oil level is checked at sight gauge on front of machine. Red bulb on oil level indicator should show between gauge lines.

Machine is automatically lubricated. No oiling is necessary, other than keeping main reservoir filled. Check oil daily before the morning start; add oil as required.

Drain plug screw is located at back of machine near bottom edge of base. It is a magnetic screw designed to accumulate possible foreign materials which may have entered the crank case. It should be removed and cleaned periodically.

NEEDLES

Each UNION SPECIAL needle has both a type 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 largest diameter of blade, measured in thousandths of an inch, midway between the shank and the eye. Collectively, the type and size number represent the complete symbol which is given on the label of all needles packaged and sold by Union Special.

Style 39500 X uses curved blade needles. The standard needle for this style is Type 154 GAS. It has a round shank, round point, curved blade, standard length, single groove, struck groove, spotted, chromium plated and is available in sizes -055/022, 065/025, 070/027, 075/029, 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060.

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 154 GAS, Size 090/036".

Selection of proper needle size is 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 UNION SPECIAL machines can be secured only by use of needles packaged under our brand name, Union Special, which is backed by a reputation for producing highest quality needles in materials and workmanship for more than three-quarters of a century.

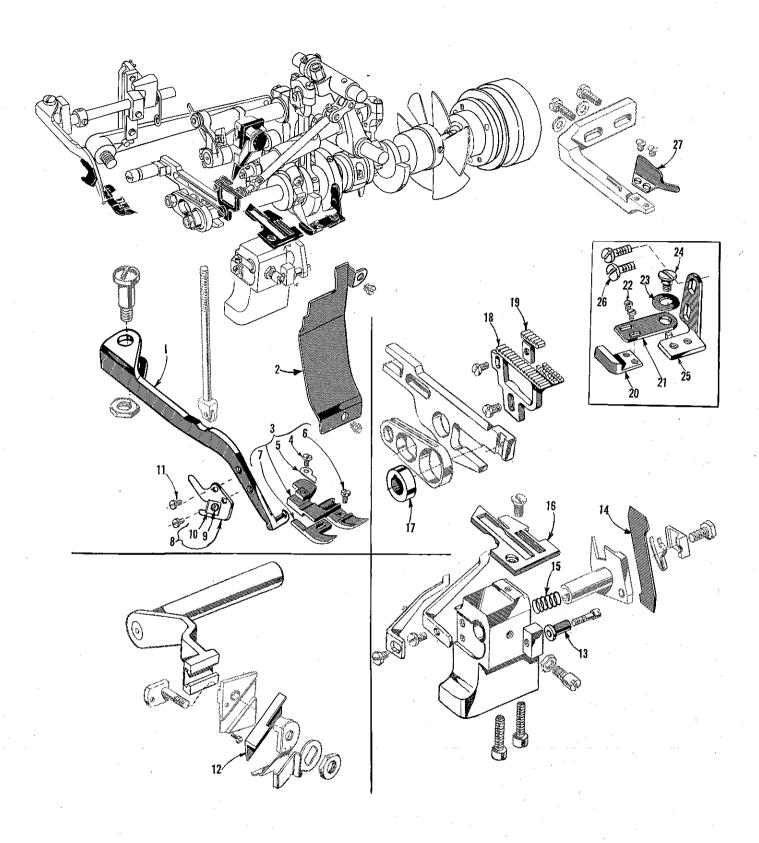
CHANGING NEEDLES, ETC.

All instructions in regard to Changing Needles, Thread Stand, Threading, are the same as for Style 39500 N covered in Catalog No. 103 R.

ASSEMBLING AND ADJUSTING SEWING PARTS

All the instructions pertaining to the adjustment of Style 39500 X are the same as those for Style 39500 N illustrated in Catalog No. 103 R except for the following:

- 1. Under the heading 'SETTING THE NEEDLE', the height of the needle above the throat plate for Style 39500 X should be 15/32 inch instead of 1/2 inch.
- 2. Under the same heading, in paragraph three, the looper gauge for Style 39500 X should be 3/32 inch instead of 1/8 inch, and looper gauge No. 21225-3/32 should be used.

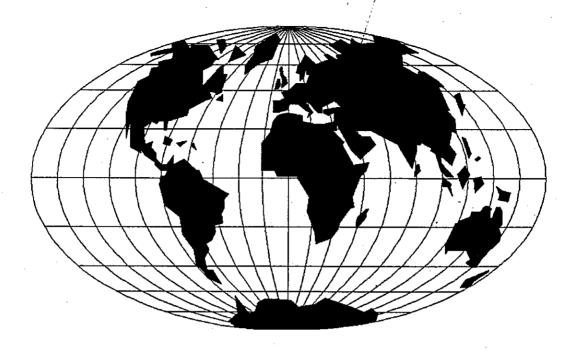


The parts illustrated on the preceding page and described on this page represent the parts that are used on Style 39500 X, but not used on Style 39500 N.

Those parts shown in phantom views and bearing no reference numbers are common to Styles $39500~\mathrm{X}$ and $39500~\mathrm{N}_{\bullet}$

Use Catalog No. 103 R for all parts not illustrated or described here.

Ref. No.	Part No.	Description	Amt.
		- Court ipitoii	Req.
1	39556 D	Presser Foot Arm	1
2	$39578~\mathrm{BA}$	Chip Guard	
3	39520 FX	Presser Foot	
4	87 U	Screw	
5	39530	Hinge Spring	
6	28	Screw	1
7	$39530~\mathrm{AB}$	Guide, marked "S"	
8	$39556~\mathrm{M}$	Chain Cutting Knife, complete	
9	22 798	Screw	1
10	$39556~\mathrm{L}$	Chain Cutting Knife	
11	605	Screw	· 1
12	39570 J	Upper Knife	ے 1
13	$39550~\mathrm{R}$	Lower Knife Holder Locating Stud	1
14	39549 Ј	Lower Knife	1
15	39550 P	Knife Holder Spring	1
16	$39524~\mathrm{X}$	Throat Plate, marked "AR"	1
17	39540 B -1 0	Main Feed Driving Eccentric, . 022 inch throw	1
18	39505 X	Main Feed Dog	1
19	39505 M	Chaining Feed Dog, marked "Y"	1
20	39503 A	Edge Guide, adjustable	1
21	39503 D	Edge Guide Swinging Arm	1
22	604	Screw	9
23	12957 E	Washer	1
24	$22758~\mathrm{E}$	Screw	1
25	39503 C	Edge Guide Mounting Bracket	1·
26	22569 C	Screw	9
27	39578 S	Fabric Guard	1



WORLDWIDE SALES AND SERVICE

Union Special Corporation maintains sales and service facilities throughout the world. These offices will aid 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.
Ei Paso, TX
Hong Kong, China
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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.



