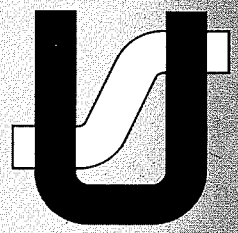


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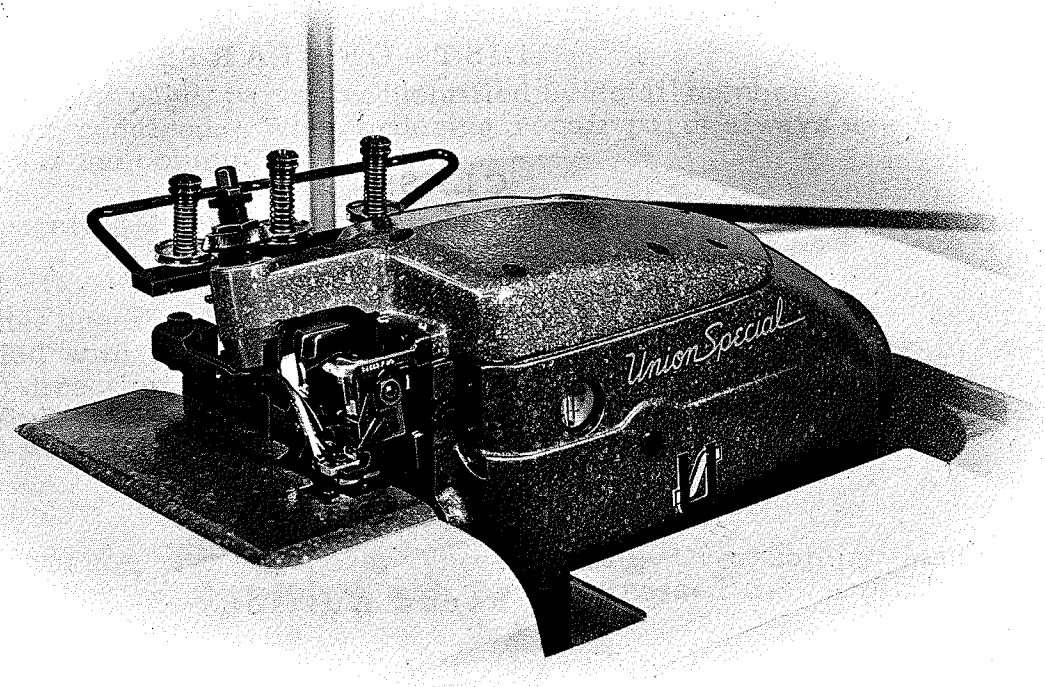
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**STYLE  
39500AS**



**CATALOG  
No.  
103AS**

**CLASS 39500**

**STREAMLINED  
HIGH SPEED OVERSEAMERS**

*Union Special* **MACHINE COMPANY**

**CHICAGO**

Catalog No. 103 AS  
(Supplement to Catalog No. 103 S)

INSTRUCTIONS  
FOR  
ADJUSTING AND OPERATING

LIST OF PARTS

CLASS 39500

Style 39500 AS

The parts listed in this catalog are  
furnished at list prices for repairs only.

First Edition

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**MACHINE COMPANY**  
INDUSTRIAL SEWING MACHINES  
**CHICAGO**

Printed in U.S.A.

July, 1966

## IDENTIFICATION OF MACHINE

Each Union Special machine is identified by a Style number which is stamped into 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 AS". 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 ASZ".

Styles of machines similar in construction are grouped under a class number which differs from the style number, in that it contains no letters. Example: "39500".

## APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 103 S and should be used in conjunction therewith. Only those parts which are used on Style 39500 AS and not on Styles 39500 A, B, P or AF are illustrated and listed at the back of the book. For clarity, certain 39500 A, B, P and AF parts are shown in phantom to help locate the 39500 AS parts.

Opposite the illustration page, parts are identified by detail number, part number, description and amount required. When ordering repair parts always use the part number listed in the second column.

Adjusting and operating instructions included represent only areas concerned with Style 39500 AS.

The catalog applies specifically to the Standard Style of machine as listed herein. It can also be applied with discretion to some Special Styles of machines in this class. Reference to direction, such as right, left, front, back, etc., are given from the operator's position while seated at the machine. Operating direction of handwheel is away from the operator.

## STYLE OF MACHINE

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

39500 AS For producing high quality, turned down edge seams on pajamas, negligees, peignoirs, blouses and similar sheer items requiring reinforced seams. Seam specification 504 EFe-1 inverted; standard seam width 3/32 inch; stitch range, 8 to 30 per inch; cam adjusted main and differential feeds.

## OILING

**CAUTION!** Oil was drained from machine when shipped, so reservoir must be filled before beginning to operate. Oil capacity of Class 39500 is six ounces. A straight mineral oil of a Saybolt viscosity of 200 to 250 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.

## IDENTIFYING PARTS

Where construction permits, each part is stamped with its part number. On some of the smaller parts, and on those where construction does not permit, an identification letter is stamped in to distinguish the part from similar ones.

Part numbers represent the same part, regardless of catalog in which they appear.

**IMPORTANT! ON ALL ORDERS, PLEASE INCLUDE PART NAME AND STYLE OF MACHINE FOR WHICH PART IS ORDERED.**

## TERMS

Prices are net cash and subject to change without notice. All shipments are forwarded f. o. b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

## 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 the largest diameter of blade measured in thousandths of an inch, midway between the shank and the eye. Collectively, the type number and the size number is the complete symbol.

Style 39500 AS uses a curved blade needle. The standard needle for this Style is Type 154 GBS. It has a round shank, round point, curved blade, standard length, double groove, struck groove, spotted, chromium plated, in sizes 025, 027, 029, 032.

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 GBS, Size 029".

Selection of the 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.

## USE GENUINE NEEDLES AND REPAIR PARTS

Success in the operation of these machines can be secured only with genuine Union Special Needles and Repair Parts as furnished by the Union Special Machine Company, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles, and are made with utmost precision. Maximum efficiency and durability are assured.

Genuine needles are packaged with labels marked *Union Special*. Genuine repair parts are stamped with the Union Special trade mark. Each trade mark is your guarantee of the highest quality in materials and workmanship.

## THREAD STAND

After thread comes from cone on thread stand (V, Fig. 1), it is brought up through back thread eyelet, then down through front thread eyelet (W). Next it is threaded through each pair of holes in tension thread guide wire (A), down right hand hole and up through left hand hole. Then thread continues between tension discs (AD), through slot (AE), and on through thread guide (B).

## THREADING

Only parts involved in threading are shown in threading diagram (Fig. 1). Parts are placed in their relative positions for clarity.

It will simplify threading this machine to follow recommended sequence of threading lower looper first, upper looper second, and needle third.

Before beginning to thread, swing cloth plate open, turn handwheel in operating direction until needle (N) is at high position, release pressure on presser foot by turning presser foot release bushing (U); and swing presser arm (H) out of position.

Be sure threads, as they come from the tension thread guide, are between tension discs (AD) and in diagonal slots (AE) in tension posts (AC).

### TO THREAD LOWER LOOPER

Double end of thread and lead it through both eyes of lower looper thread eyelet (E, Fig. 1) from right to left. Note: Thread must pass in front of looper thread pull-off (T). Lead thread behind fabric guard (F) and through both holes of frame looper thread guide (G). Turn handwheel in operating direction until heel of lower looper (K) is all the way to the left; then thread through both eyes from left to right. Left eye of lower looper can be threaded easily if tweezers are in left hand.

### TO THREAD UPPER LOOPER

Turn handwheel until point of upper looper (L) is all the way left. Lead thread through auxiliary looper thread eyelet (D) from back to front, then through both eyes of upper looper thread eyelet (C) from left to right. Note: Thread must pass in front of looper thread pull-off (T). After pulling up upper looper thread tube assembly (M), lead thread under neck of top cover casting and down through thread tube assembly. Pull thread out bottom of tube; push tube down, then insert thread through upper looper eye from front to back.

**CAUTION!** Be sure upper looper thread is under lower looper thread when passing from tube assembly to upper looper eye.

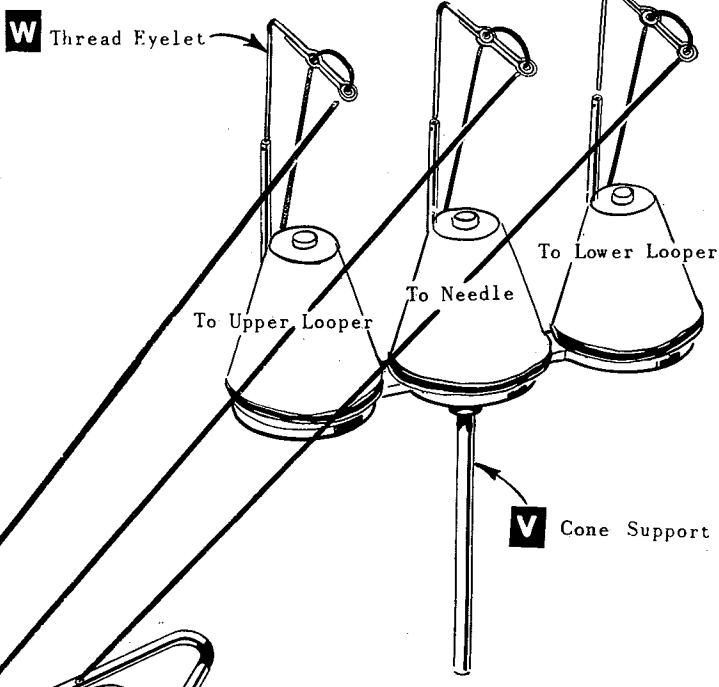
### TO THREAD THE NEEDLE

Turn handwheel in operating direction until needle (N, Fig. 1) is at its highest position. Insert needle thread from right to left, through both eyes of needle thread eyelet (R), under neck of top cover casting; then down through hole in top cover needle thread eyelet (P). Thread needle from front.

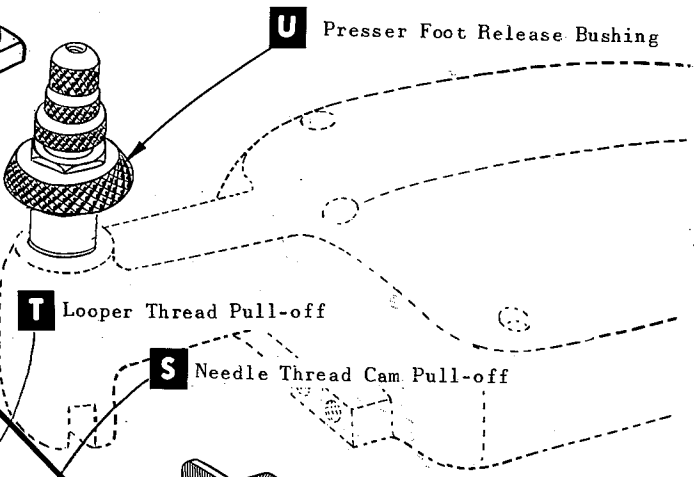
## THREAD TENSION

The amount of tension on needle and looper threads is regulated by three knurled tension nuts (AA, Fig. 1). Tension on threads should be only enough to secure proper stitch formation.

- AA** Tension Nut
- AB** Tension Spring
- AC** Tension Post
- AD** Tension Discs
- AE** Tension Post Slot



- A** Tension Thread Guide Wire
- B** Thread Guide
- C** Upper Loooper Thread Eyelet
- D** Auxiliary Loooper Thread Eyelet
- E** Lower Loooper Thread Eyelet
- F** Fabric Guard Bracket
- G** Frame Loooper Thread Guide
- H** Presser Arm



- R** Needle Thread Eyelet
- P** Top Cover Needle Thread Eyelet
- M** Upper Loooper Thread Tube Assembly
- N** Needle
- L** Upper Loooper
- K** Lower Loooper

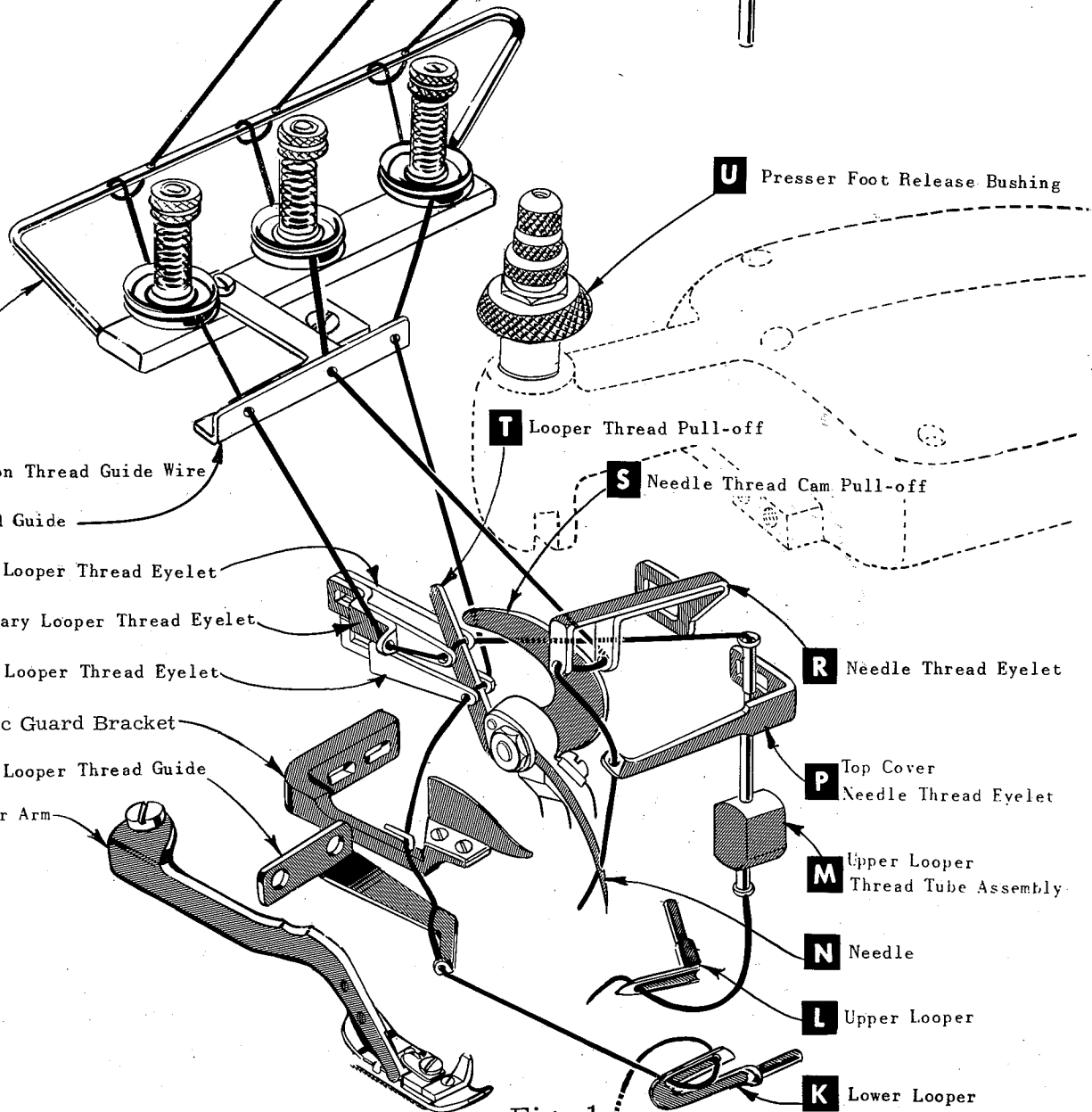


Fig. 1

## FEED ECCENTRIC

Feed eccentrics used in this machine have been selected to produce approximately 14 stitches per inch. It will be noted that the part number of both the main feed and differential feed is 39540-14. Minor numbers of the part symbol indicate approximately the number of stitches obtainable when using that eccentric. Unless otherwise specified, machine will be shipped with above combination of eccentrics.

Generally speaking, differential (right hand) feed eccentric determines number of stitches produced; main (left hand) feed eccentric is selected in relation to degree and direction of stretch of material being sewn, or type of operation.

Following stitch number feed eccentrics are available under No. 39540-4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 18, 20, 22, 24, 26, 28, 30, 32, 34, 36, 40. Only two eccentrics are supplied with each machine. Additional eccentrics may be ordered separately. To order an eccentric, use No. 39540 with a minor number suffixed to indicate number of stitches desired. Example: "39540-14".

### ASSEMBLING AND ADJUSTING SEWING PARTS (Page 8)

All instructions pertaining to the adjustment of Style 39500 AS are the same as those for Style 39500 A covered by Catalog No. 103 S with the following exceptions. The differences, applicable only to Style 39500 AS, are underlined below with page numbers where each is found in Catalog No. 103 S.

### SETTING THE UPPER KNIFE (Page 11)

Replace upper knife assembly. Clamp upper knife (D, Fig. 13) in position, setting nut (E) to hold clamp (F) in its most clockwise position against upper knife. At bottom of its stroke, front cutting edge of upper knife should extend not less than 1/64 inch below cutting edge of lower knife. The chain guard (J) should be set down against the upper knife and slightly back from the cutting edge.

After upper knife has been set for proper width of trim, screw (G) should be tightened to lock upper knife holding block (H) in place. This will simplify resetting when upper knife is replaced.

NOTE: An approximate setting for the upper knife would be to measure twice the distance of the desired width of seam, from the centerline of the needle to the cutting edge of the upper knife. Example: If a 3/32 inch seam width is desired, set the upper knife cutting edge 3/16 inch away from the centerline of needle.

### SETTING THE PRESSER FOOT HOLD DOWN PLATE (This adjustment to follow "Setting The Presser Foot", Page 12)

This machine comes equipped with a presser foot hold down plate (A, Fig. 16A). It is for the purpose of holding down the rear of the presser foot and when set correctly it will help produce a more flat pucker free seam. An approximate setting is shown in Fig. 16A. Set the machine with the feed dogs below the throat plate and insert a .005 inch shim (B) under the front portion of the presser foot (C). Loosen the screws (D) which hold the hold down plate in position and move the plate down until it rests firmly against the presser foot. Tighten the two screws and remove the shim.

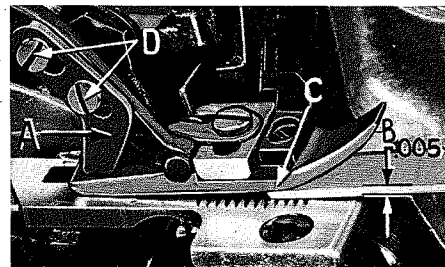
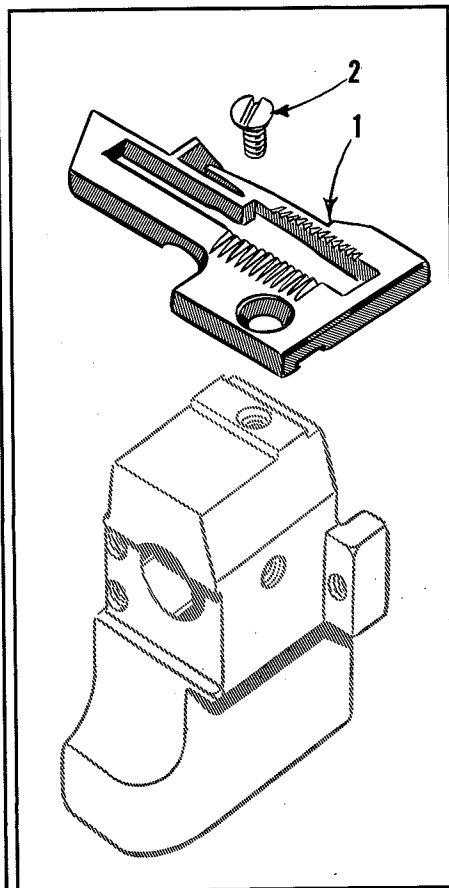
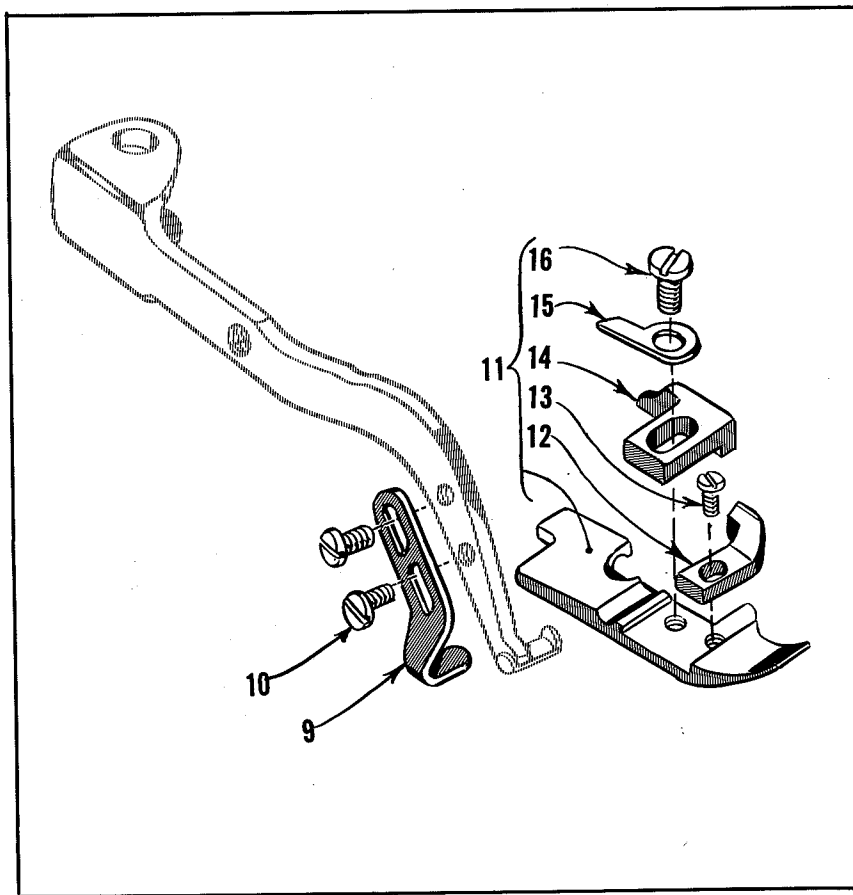
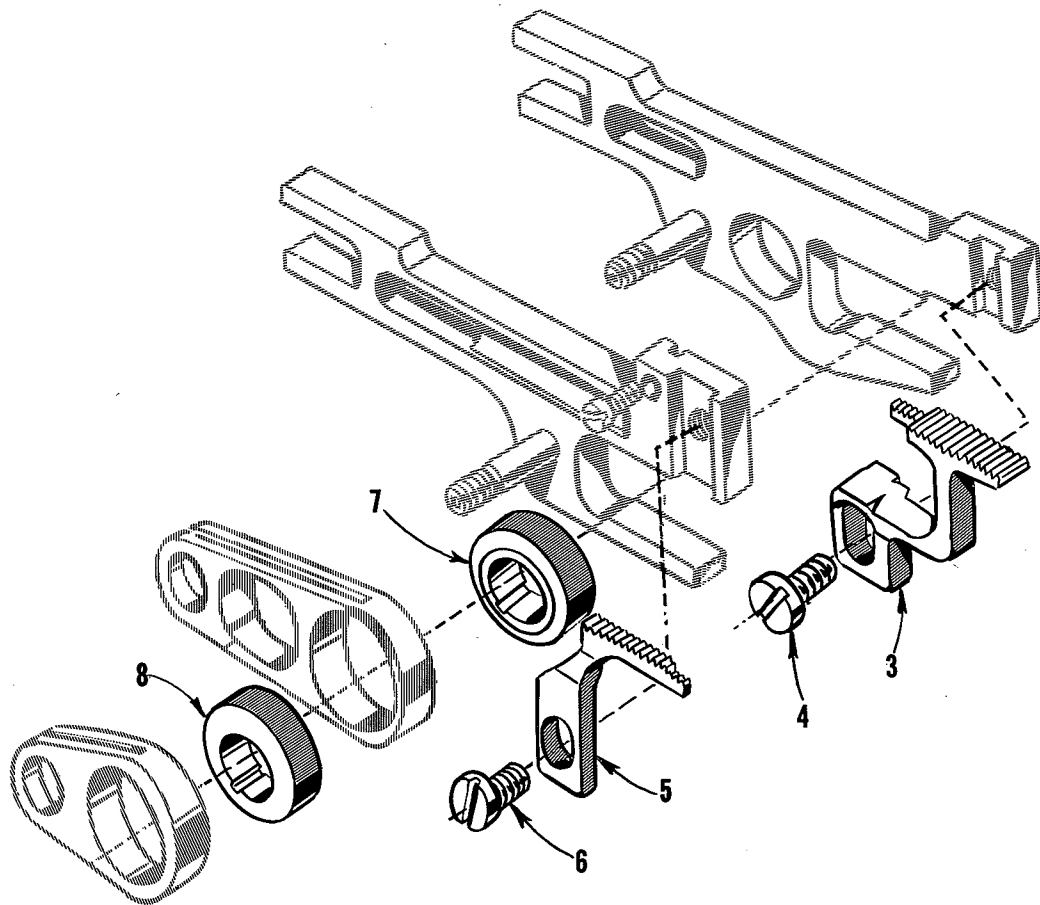


Fig. 16A



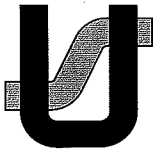


The parts illustrated on the preceding page and described on this page represent the parts used on Style 39500 AS, but not used on Styles 39500 A, B, P or AF.

Parts shown in phantom views, bearing no reference numbers, are common to Styles 39500 A, B, P, AF and AS.

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

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	39524 AS	Throat Plate, marked "BE" -----	1
2	22524	Screw - Throat Plate-----	1
3	39526 AC	Differential Feed Dog -----	1
4	22528	Screw - Differential Feed Dog-----	1
5	39505 AC	Main Feed Dog, marked "AM" -----	1
6	93 A	Screw - Main Feed Dog -----	1
7	39540 B-14	Differential Feed Driving Eccentric, .010 inch throw -	1
8	39540 B-14	Main Feed Driving Eccentric, .010 inch throw -----	1
9	39556 H	Presser Foot Hold Down Plate -----	1
10	605 A	Screw - Presser Foot Hold Down Plate-----	2
11	39520 AS	Presser Foot-----	1
12	39530 P	Presser Foot Chip Guard -----	1
13	22738 B	Screw - Presser Foot Chip Guard -----	1
14	39597 AS	Stitch Tongue, marked "ES" -----	1
15	39530	Presser Foot Hinge Spring-----	1
16	22768 B	Screw - Tongue and Hinge Spring -----	1



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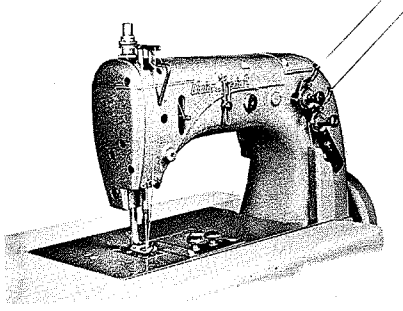
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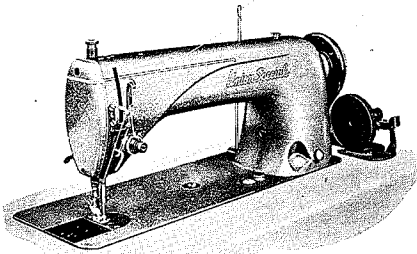
**... for Every Purpose!**

Job requirements vary — that's why Union Special builds a wide variety of specially designed sewing machines. It is also the reason why Union Special field representatives make a careful study of requirements before giving you detailed recommendations on the kind of equipment to install. Plants equipped with modern, high speed Union Specials have an important advantage. Union Special machines are built to do the job faster . . . better . . . cheaper, and they stay on the job with minimum time out for repairs. You're ahead when you use Union Special.



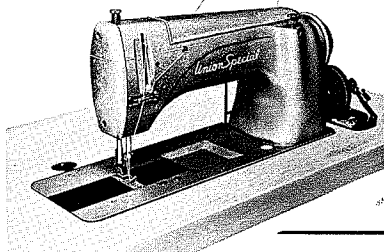
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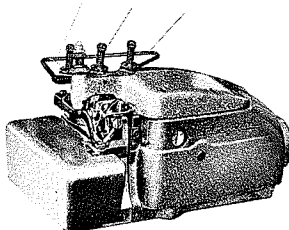
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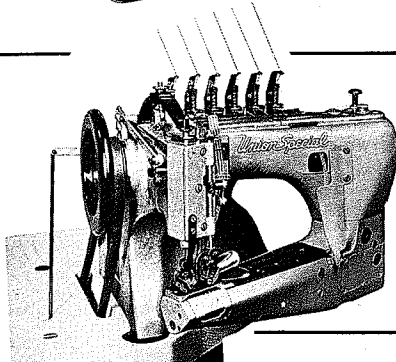
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