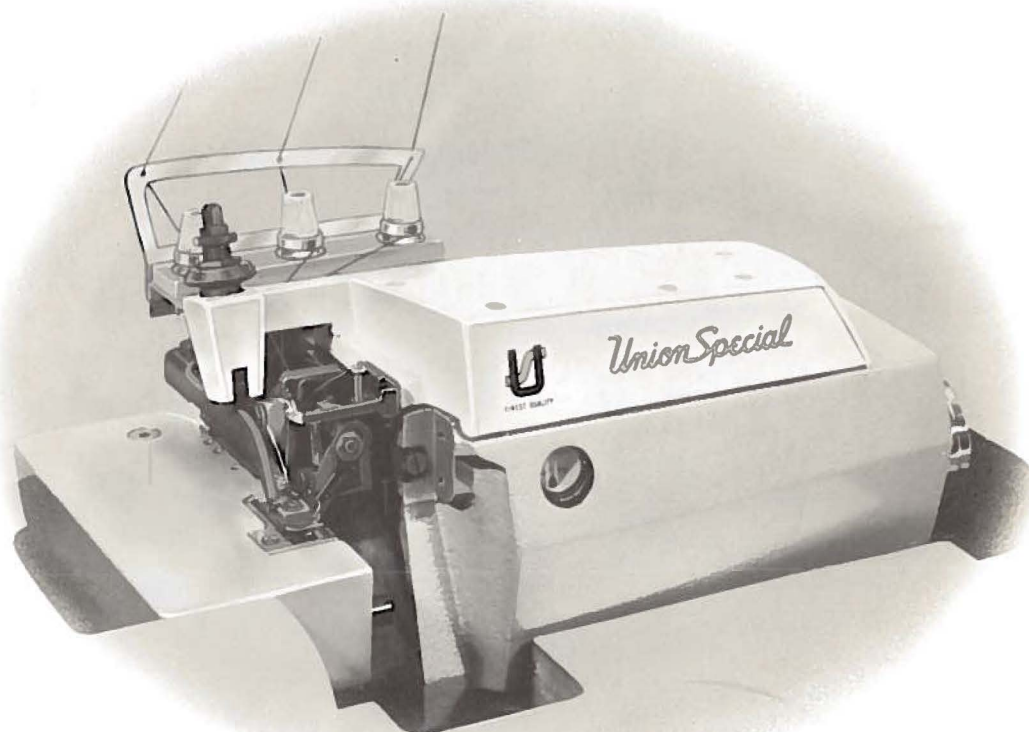


FINEST QUALITY

Union Special[®]
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**INDUSTRIAL
SEWING
MACHINES**

**STYLE
39500GK**



CLASS 39500

**HI-STYLED
HIGH SPEED OVERSEAMER
WITH
KNIFE SHIFT MECHANISM**

**CATALOG
NO.
103GK**

Union Special **MACHINE COMPANY**
CHICAGO

From the library of: Superior Sewing Machine & Supply LLC

Catalog No. 103 GK
(Supplement to Catalog No. 103 FA)

INSTRUCTIONS
FOR
ADJUSTING AND OPERATING

LIST OF PARTS

CLASS 39500

Style
39500 GK

First Edition

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MACHINE COMPANY
INDUSTRIAL SEWING MACHINES
CHICAGO

Printed in U. S. A.

July, 1967

IDENTIFICATION OF MACHINES

Each Union Special machine is identified by a Style number on a 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 GK". 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 GKZ".

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: "Class 39500".

APPLICATION OF CATALOG

This catalog is a supplement to Catalog No. 103 FA and should be used in conjunction therewith. Only parts found on Style 39500 GK, but not on Style 39500 FB are illustrated. On the page opposite the illustration will be found a listing of the parts with their part numbers, description and the number of pieces required. Numbers in the first column are reference numbers only, and merely indicate the position of that part in the illustration. Reference numbers should never be used in ordering parts. Always use the part number listed in the second column.

This catalog applies specifically to the standard Styles of machines as listed herein. It can also be applied with discretion to some Special Styles of machines in Class 39500. References to directions, 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 operator.

STYLES OF MACHINES

Hi-Styled High Speed Single Curved Blade Needle, Two Looper, Three Thread, Overseaming Machine, Differential Feed, Trimming Mechanism with Spring Pressed Lower Knife, and Variable Width Knife Shift Mechanism. Automatic Lubricating System.

39500 GK Light to medium duty machine for seaming light and medium weight flat, warp and ribbed knit fabrics of cotton, silk, or similar weight synthetics. For general purpose seaming on "T" shirts, polo shirts, panties and similar garments which have varying plies of material requiring an adjustable bite. The variable width knife shift mechanism permits quick change from narrow to wide bite when crossing elastic, lace, etc. Seam specification, 504-SSa-1; standard seam widths, 3/32 and 1/8 inch; stitch range, 8 to 30 per inch; cam adjusted main and differential feeds. Maximum recommended speed 7000 R.P.M.

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 when machine is stationary.

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.

The oil 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 the 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.

NEEDLES

Each Union Special needle has both 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 shank and eye. Collectively, the type and the size number represent the complete symbol which is given on the label of all needles packaged and sold by Union Special.

Selection of proper needle size should be determined by the size of the thread used. Thread should pass freely through the needle eye in order to produce a good stitch formation.

For best results, use only genuine Union Special needles in the operation of this machine. They are packaged under our brand name, *Union Special* which is backed by a reputation for producing highest quality needles for more than three-quarters of a century.

Style 39500 GK 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 022, 025, 027, 029, 032, 036, 040, 044, 049, 054.

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 027".

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 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.

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.

CHANGING NEEDLES, ETC.

All instructions with regards to Changing Needles, Thread Stand and Threading are the same for Style 39500 GK as for Style 39500 FB covered in Catalog 103 FA.

ASSEMBLING AND ADJUSTING SEWING PARTS

All instructions pertaining to the adjustment of Style 39500 GK are the same as those for Style 39500 FB, described in Catalog No. 103 FA, except with the additional instructions pertaining to the variable width knife shift mechanism described below. These instructions and Fig. 13A should follow the two paragraphs on "Setting The Upper Knife", on Page 13.

SETTING THE VARIABLE WIDTH KNIFE SHIFT MECHANISM

Loosen set screws (A and B, Fig. 13A) on pawl shaft stop collars (C and D) and move knives (E and F) by pushing down on pawl lever (G) to position desired for obtaining the standard $3/32$ or $1/8$ inch seam width. From the operator's position while seated at the machine, rotate collar (C) clockwise to its upper position and tighten set screws (A). This will position the knives for the Standard seam width or constant trim line.

Next, move knives to the right to obtain the variable trim line desired by pushing down on lever (G) and rotate collar (D) counterclockwise to its upper position and tighten set screws (B). This will position the knives for the variable trim line when lever (G) is pulled downwardly, when crossing elastic, etc.

Screw (H) holds the variable shift mechanism in place, while screw (J) is used for holding the tension post mounting bracket.

NOTE: This machine is designed to give a maximum of $5/64$ inch travel of the cutting knives from the constant trim line to the variable trim line.

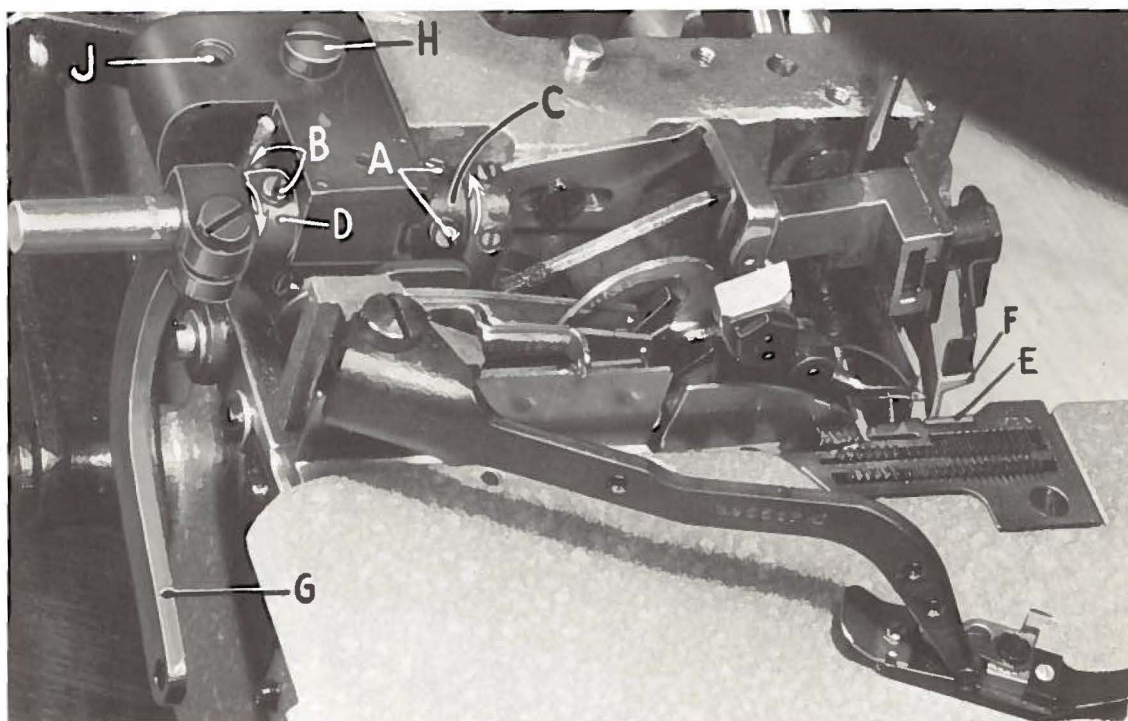
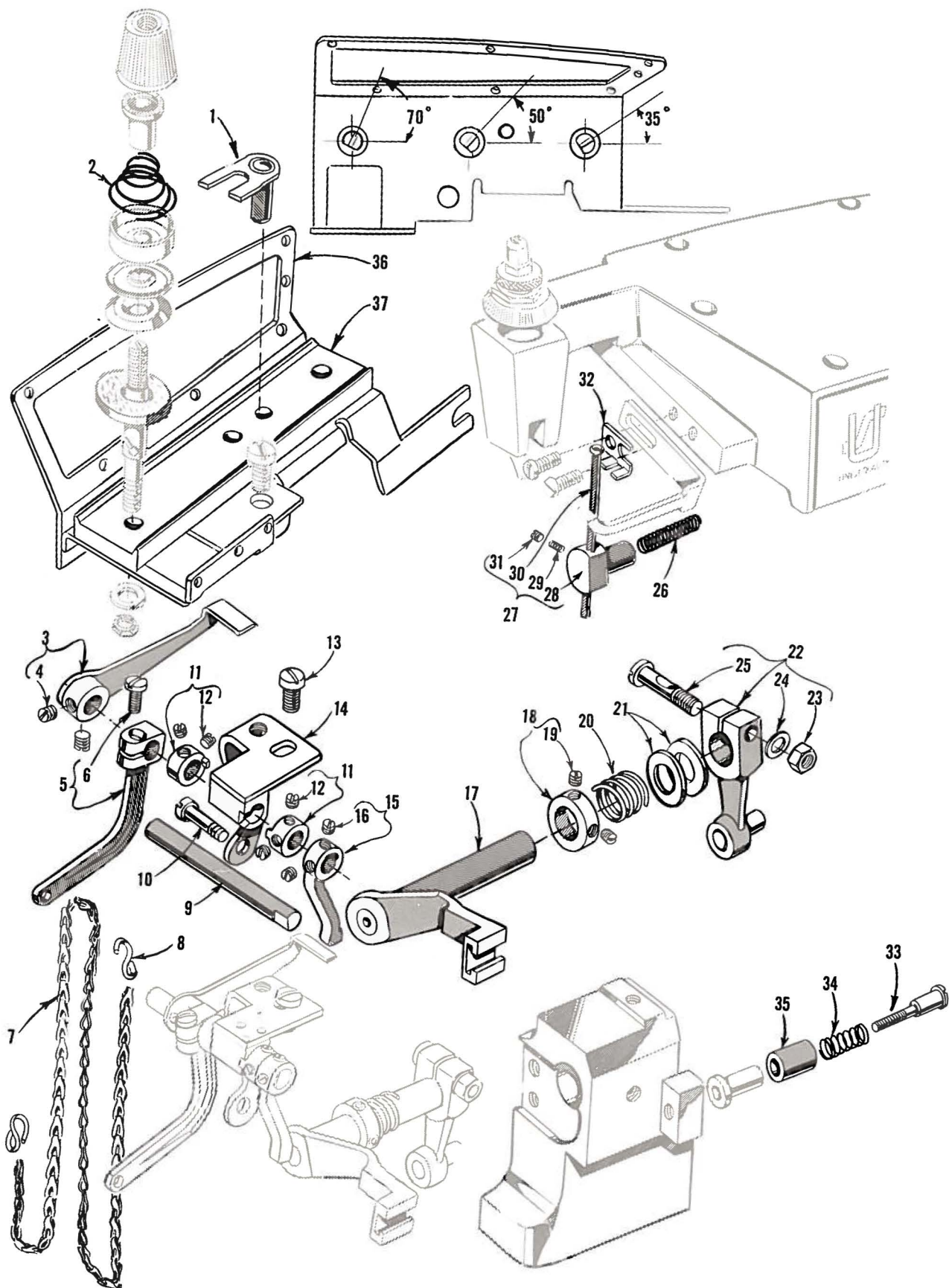


Fig. 13A



The parts illustrated on the preceding page and described below represent the parts that are used on Style 39500 GK, but not used on Style 39500 FB.

Those parts shown in phantom view and bearing no reference numbers, are common to Styles 39500 FB and GK.

Use Catalog No. 103 FA (Style 39500 FB) for all parts not illustrated or described in this catalog.

Reference numbers that are inside a bracket on the picture plate and have indented descriptions, indicate they are component parts of a complete part or assembly.

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>	<u>Amt. Req.</u>
1	39592 V	Needle Thread Tension Plunger-----	1
2	39592 AE-5	Looper Thread Tension Spring-----	2
-	39592 AE-8	Needle Thread Tension Spring-----	1
3	39592 U	Needle Thread Tension Release Arm-----	1
4	88	Set Screw-----	2
5	39573 S	Pawl Lever-----	1
6	93	Screw, for pawl lever-----	1
7	421 D-34	Treadle Chain, 34 inches long-----	1
8	660-264	"S" Hook, for treadle chain-----	2
9	39573 N	Knife Regulating Pawl Shaft-----	1
10	22572 A	Screw, for pawl shaft support bracket-----	1
11	39573 P	Pawl Shaft Stop Collar-----	2
12	88	Set Screw-----	2
13	22891	Screw, for pawl shaft support bracket-----	1
14	39573 M	Pawl Shaft Support Bracket-----	1
15	39573 R	Knife Regulating Pawl-----	1
16	88	Set Screw-----	2
17	39573 T	Upper Knife Driving Arm-----	1
18	39573 U	Upper Knife Driving Arm Collar-----	1
19	22894 W	Set Screw-----	2
20	39573 V	Upper Knife Driving Arm Spring-----	1
21	39573 A	Driving Arm Washer-----	2
22	39573 W	Upper Knife Driving Lever-----	1
23	55235 E	Nut, for driving lever-----	1
24	6042 A	Washer, for driving lever-----	1
25	55235 D	Locking Stud, for driving lever-----	1
26	39573 Z	Knife Support Block Spring-----	1
27	29477 HR	Upper Looper Thread Tube Assembly-----	1
28	39573 X	Knife Support Block-----	1
29	39568 J	Spring, for thread tube-----	1
30	39568 G	Thread Tube-----	1
31	22743	Set Screw, for thread tube-----	1
32	39573 Y	Thread Tube Guide-----	1
33	22559 H	Screw, for lower knife holder locking stud-----	1
34	39550 J	Lower Knife Pressure Equalizing Spring-----	1
35	39550 K	Spring Cover-----	1
36	39592 T-3	Tension Post Mounting Bracket-----	1
37	39592 AP	Tension Post Bar-----	1



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