

Flatbed Single Needle
Chainstitch

FS300



FS311S11-1MCC2







OPERATIONS & SUBCLASSES

 *Union Special*
FINEST QUALITY

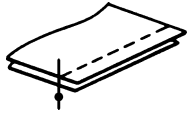
- General seaming of light to medium weight materials—FS311S01, S02, S11, S12, S13, S14; and FS312S21 subclasses:
Single needle seaming.

SPECIFICATIONS

Model No.	FS311S01, S02, S11, S12, S13, S14; FS312S21
Needle	128GBS070/027~090/036 standard 090/036
Material Weight	light to medium wovens and knits
Stitch Length Adjustment	by adjusting knob
Differential Feed Adjustment (FS312S21 only) Ratio	by lever adjustment mechanism 1:0.6~1:1.5
Needle Bar Stroke	32mm
Lubrication	automatic
Lubricating Oil	Union Special Spec 175 (ISO grade 22)
Stitch Type	401
Seam Type	SSa-1

					
FS311S01-1M and CC2	1	2	1.8~2.5 (2.5 standard)	8mm	6500 RPM
FS311S02-1M and CC2	1	2	1.8~2.5 (2.5 standard)	8mm	6500 RPM
FS311S11-1M and CC2	1	2	2.5~3.6 (3.2 standard)	8mm	6500 RPM
FS311S12-1M and CC2	1	2	2.5~3.6 (3.2 standard)	8mm	6500 RPM
FS311S13-1M and CC2	1	2	2.5~3.6 (3.2 standard)	8mm	6500 RPM
FS311S14-1M and CC2	1	2	2.5~3.6 (3.2 standard)	8mm	6500 RPM
FS312S21-1M and CC2	1	2	2.5~3.6 (3.2 standard)	8mm	6500 RPM

FS300 Single Needle Chainstitch Styles



FS311S01-1M

FS312S21-1MCC2

Plain feed machine with standard hinged presser foot. For side and inseaming on work and dress pants of light to medium weight material. (Similar to 56300G.)

FS311S02-1M

Plain feed machine with yielding left section on standard hinged presser foot. For seaming operations on light to medium weight material when crossing pockets and seams is required.

FS311S11-1M

Plain feed machine with feeding presser foot. For side and inseaming on trousers, coats, and similar operations on light to medium weight material where matching plies or patterns is a must. (Similar to 56300F.)

FS311S12-1M

Plain feed machine with yielding left section on feeding presser foot. For seaming operations on light to medium weight material when crossing pockets and seams is required and matching plies or patterns is a must. (Similar to 56300R.)

FS311S13-1M

Plain feed machine with narrow feeding presser foot for seaming and similar operations on trousers, coats, panels of baseball caps, of light to medium weight material.

FS311S14-1M

Plain feed machine with low inertia presser foot for seaming side and inseams on trousers of light to medium weight material.

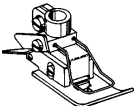
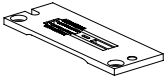
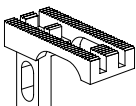
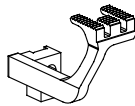

FS312S21-1M

Differential feed machine with low inertia presser foot for seaming side and inseams on trousers of light to medium weight material.



SEWING PARTS



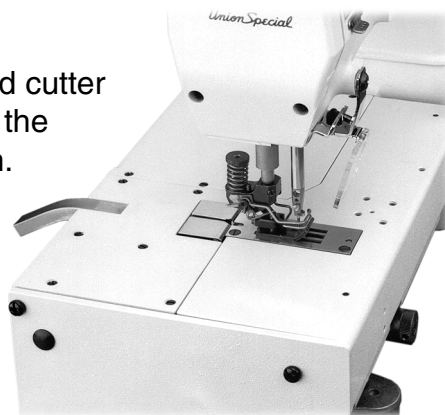
STYLE	 PRESSER FOOT ASSEMBLY	 THROAT PLATE	 FEED DOG	 DIFFERENTIAL FEED DOG	 NEEDLE HEAD
FS311S01-1M	G51320	50624A	C50005G		50618
FS311S02-1M	56320R	50624A	C50005G		50618
FS311S11-1M	56320F	50624	C50005F		50618
FS311S12-1M	56320H	50624	C50005F		50618
FS311S13-1M	56320E	50624B	50624B		50618
FS311S14-1M	C50020	50624	50624		50618
FS312S21-1M	C50020	50624	50624	50626	50618

DEVICES & ATTACHMENTS



CC2 AIR-KLIPP®

Pneumatic type chain-off thread cutter creates a clean appearance at the beginning and end of the seam. With horizontally mounted venturi suction.



INSTALLATIONS



Use this chart to choose the correct table top for FS300 machines. Table top dimensions are 51cm x 122cm with a heavy plywood underboard that can be adjusted for use as a semi-submerged or fully submerged installation.

Model No.	Table Board Part Number	Table Board Description
FS311 S01, S02, S11, S12, S13, S14	21371AAH48	Semi/Fully Submerged Plain Feed
FS312S21	21371AAE48	Semi/Fully Submerged Differential Feed

ADDITIONAL INFORMATION

Use these descriptions of the different presser feet available on FS311 single needle chainstitch styles to help determine the style most suited to the sewing operation.

- ❶ Standard Hinged Presser Foot—foot is hinged and bottom is flat, for easy sewing over seams.

Standard Finged Presser Foot with Left Yielding Section—similar to Standard Presser Foot, and includes a yielding section to help guide bottom of foot when crossing pockets or edge stitching.

Feeding Presser Foot—specially designed foot to reduce fabric marking and match material plies more effectively. This foot works like a top feed to help feed the top ply of material evenly with the bottom ply. Feeding and pressure are regulated by a spring, adjusted with a knurled nut on back of foot.

- ❷ Feeding Presser Foot with Left Yielding Section—similar to Standard Feeding Presser Foot, and includes a yielding section to help to guide bottom of foot when crossing pockets or edge stitching.

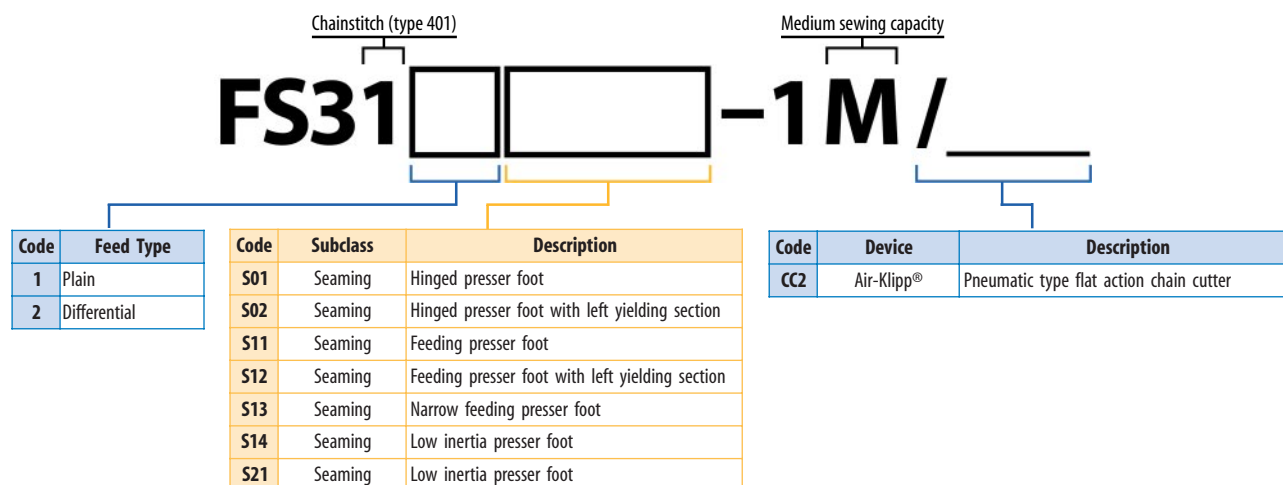
Narrow Feeding Presser Foot—similar to Standard Feeding Presser Foot except narrower, to allow for sewing close to seams and for turning sharper curves.

- ❸ Low Inertia Presser Foot—similar to Standard Hinged Presser Foot, except low inertia design allows for sewing long runs at high speed while keeping the foot flat on the material.



HOW TO ORDER

This chart outlines the key elements of the single needle FS300 numbering system. When ordering, styles must follow this system.



Single Needle Flatbed Machines FS300 Series










The Indexed Thread Ratio Control quickly sets a loose or tight stitch

This **NEW GENERATION** of high speed single needle flatbed machines offers the performance required to produce the high quality, bobbinless double-locked stitch Type 401 that Union Special Corporation is known for. They combine the proven features of the famous 50000 Series with the latest developments and engineering skills to set a new standard of sewing performance.

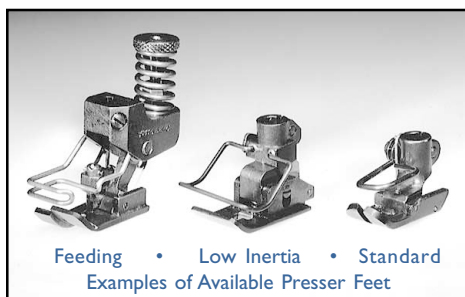
All machines are equipped with an Indexed Thread Ratio Control for fast, simple adjustment from a tight to loose stitch, a totally enclosed feed and looper drive mechanism, and an automatic pressurized lubrication system with a replaceable filter that's easily accessible. Styles are available with a standard presser foot, "Feeding Presser Foot" or "Low Inertia Presser Foot;" plain or differential feed; and Air Klipp® Chain Cutter — for the sewing versatility needed in today's marketplace.

JUKI
Union Special

The new FS311 and FS312 — high speed single needle flatbed machines with the performance necessary for the high quality, bobbinless double-locked stitch that Union Special Corporation is known for. With the proven features of the famous 50000 Series and the latest developments and engineering skills, they set a new standard of sewing performance.

Machine	Features	Application	Seam	Fabric	Stitch Length Range	Maximum speed*
PLAIN FEED STYLES						
FS311S01-1M FS311S01-1MCC2 (with pneumatic power Air Klipp® Chain Cutter)	SEAMER-One needle, medium capacity with standard presser foot	Side and inseaming on work and dress pants	40 I SSa-I 	Light to medium weight pants material	10-14 SPI (10 Std.) 1.8-2.5mm	6500 SPM
FS311S02-1M FS311S02-1MCC2 (with pneumatic power Air Klipp® Chain Cutter)	SEAMER-One needle, medium capacity with yielding left section on standard presser foot	Seaming operations when crossing pockets and seams is required	40 I SSa-I 	Light to medium weight pants material	10-14 SPI (10 Std.) 1.8-2.5mm	6500 SPM
FS311S11-1M FS311S11-1MCC2 (with pneumatic power Air Klipp® Chain Cutter)	SEAMER-One needle, medium capacity with "Feeding Presser Foot"	Side and inseaming on trousers, coats and similar operations where matching plies or patterns is a must	40 I SSa-I 	Light to medium weight pants material	7-10 SPI (8 Std.) 2.5-3.6mm	6500 SPM
FS311S12-1M FS311S12-1MCC2 (with pneumatic power Air Klipp® Chain Cutter)	SEAMER-One needle, medium capacity with yielding left section on "Feeding Presser Foot"	Seaming operations when crossing pockets and seams is required and matching plies or patterns is a must	40 I SSa-I 	Light to medium weight pants material	7-10 SPI (8 Std.) 2.5-3.6mm	6500 SPM
FS311S13-1M FS311S13-1MCC2 (with pneumatic power Air Klipp® Chain Cutter)	SEAMER-One needle, medium capacity with narrow "Feeding Presser Foot" (3/16" from needle to edge of foot)	Seaming trousers, coats, panels for baseball caps and similar operations	40 I SSa-I 	Light to medium weight material	7-10 SPI (8 Std.) 2.5-3.6mm	6500 SPM
FS311S14-1M FS311S14-1MCC2 (with pneumatic power Air Klipp® Chain Cutter)	SEAMER-One needle, medium capacity with "Low Inertia Presser Foot"	Side and inseaming on trousers, coats and similar operations	40 I SSa-I 	Light to medium weight material	7-10 SPI (8 Std.) 2.5-3.6mm	6500 SPM
DIFFERENTIAL FEED STYLES						
FS312S21-1M FS312S21-1MCC2 (with pneumatic power Air Klipp® Chain Cutter)	SEAMER-One needle, medium capacity with tandem differential feed and "Low Inertia Presser Foot"	Side and inseaming on trousers, coats and similar operations on a variety of woven and knit materials	40 I SSa-I 	Light to medium weight woven and knit material	7-10 SPI (8 Std.) 2.5-3.6mm	6500 SPM

* Depending on operation



FEATURES

- Indexed Thread Ratio Control
- Improved Internal Lubrication
- Variety of Presser Feet Available
- Plain or Differential Feed
- Power Air Klipp® Available
- Inverted Slider Crank Needle Bar Drive



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Distributed by:

Flatbed Two and Three Needle
Chainstitch

FS300



FS316L63-3H36/CC2/PA1

OPERATIONS & SUBCLASSES

 *Union Special*
FINEST QUALITY

- Lapseaming of medium to heavy weight materials—FS311L51, L52, L53 subclasses:
Two needle or three needle full felled seaming
- Lapseaming with roller puller of medium to heavy weight materials—FS315L63;
FS316L61, L62, L63 subclasses:
Two needle or three needle full felled seaming