

**Curved Needle Overedge
One and Two needle**

39500



39500QB1/8



OPERATIONS & SUBCLASSES



FOR KNITS

Seaming—light to medium weight materials—39500QB, CQB, XEQB, CXEQB subclasses:
One needle, differential feed overedge seaming.

Seaming—medium to heavy weight materials—39500RF, CRF, XERF subclasses:
One needle, differential feed overedge seaming.

Seaming—heavy weight materials—39500QP subclass:
One needle, differential feed overedge seaming.

Seaming with Reinforced Tape—light to medium weight materials—39500RA subclass:
One needle, differential feed overedge seaming with tape.

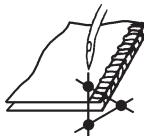
**Blind Hemming without Seams—light to medium weight materials—
39500RN, XERN, SD, CSD, XESD, CXESD subclasses:**
One needle, differential feed overedge blindhemmer.

Collar Attaching—light to medium weight materials—39500SE subclass:
One needle, differential feed overedge collar attaching.

see next page for additional subclasses

						
39500QB and CQB	1	3	.1/8" or 5/32"	.85~3.2 (2.1 standard)	L~M	8000 RPM
39500XEQB and CXEQB	1	3	.1/8" or 5/32"	.85~3.2 (2.1 standard)	L~M	9000 RPM
39500RF and CRF	1	3	.3/32" or 1/8"	.85~3.2 (2.1 standard)	M~H	8000 RPM
39500XERF	1	3	.1/8"	.85~3.2 (2.1 standard)	M~H	9000 RPM
39500QP	1	3	.1/8"	1.3~3.2 (2.1 standard)	H	7500 RPM
39500RA	1	3	.5/32"	1.6~4.2 (3.2 standard)	L~M	7500 RPM
39500RN	1	2	.3/32"	.85~3.2 (2.1 standard)	L~M	8000 RPM
39500XERN	1	2	.3/32"	.85~3.2 (2.1 standard)	L~M	9000 RPM
39500SD and CSD	1	2	.1/8"	.85~3.2 (2.1 standard)	L~M	8000 RPM
39500XESD and CXESD	1	2	.1/8"	.85~3.2 (2.1 standard)	L~M	9000 RPM
39500SE	1	3	.1/8"	.85~3.2 (2.1 standard)	L~M	8000 RPM

SEAMING KNITS—LIGHT TO MEDIUM WEIGHT



39500QB1/8 and 5/32 (1/8" and 5/32" seam widths)

1 needle, 3 thread, differential feed, curved needle Mark IV overedge. For trimming and seaming T-shirts, blouses, polo shirts, pajamas, nightgowns, children's shorts, pants, sleepers and similar knit garments.

39500CQB1/8 and 5/32 (1/8" and 5/32" seam widths)

Same as 39500QB, except with pneumatic Air Klipp® chain cutter.

39500XEQB1/8 and 5/32 (1/8" and 5/32" seam widths)

1 needle, 3 thread, differential feed, curved needle 9M (9000RPM) overedge, with external oil pump and oil cooler. For trimming and seaming T-shirts, blouses, polo shirts, pajamas, nightgowns, children's shorts, pants, sleepers and similar knit garments.

39500CXEQB1/8 and 5/32 (1/8" and 5/32" seam widths)

Same as 39500XEQB, except with pneumatic Air Klipp® chain cutter.

SEAMING KNITS—MEDIUM TO HEAVY WEIGHT



39500RF3/32 and 1/8 (3/32" and 1/8" seam widths)

1 needle, 3 thread, differential feed, curved needle Mark IV overedge. For trimming and seaming heavy T-shirts, sweatshirts, sweatpants, polo shirts, shorts, knit slacks, sleepers and similar knit or polar fleece garments.

39500CRF1/8 (1/8" seam width)

Same as 39500RF, except with pneumatic Air Klipp® chain cutter.

39500XERF1/8 (1/8" seam width)

1 needle, 3 thread, differential feed, curved needle 9M (9000RPM) overedge, with external oil pump and oil cooler. For trimming and seaming heavy T-shirts, sweatshirts, sweatpants, polo shirts, shorts, knit slacks, sleepers and similar knit or polar fleece garments.

SEAMING KNITS—HEAVY WEIGHT



39500QP (1/8" seam width)

1 needle, 3 thread, differential feed, curved needle Mark IV overedge, with coarse-tooth feed dogs. For trimming and seaming, heavy sweatshirts, sweatpants, and similar heavy fleece or polar fleece activewear.

SEAMING KNITS WITH REINFORCED TAPE —LIGHT TO MEDIUM WEIGHT



39500RA (5/32" seam width)

1 needle, 3 thread, differential feed, curved needle Mark IV overedge, with tape slot in presser foot, coarse-tooth feed dogs and wide material trimming knives. For trimming, seaming and simultaneously inserting a reinforced tape on shoulder seams of T-shirts, polo shirts and similar garments.

BLIND HEMMING KNITS WITHOUT SEAMS —LIGHT TO MEDIUM WEIGHT:



39500RN (3/32" seam width)

1 Needle, 2 Thread Differential Feed curved needle Mark IV overedge, for automated sewing units, includes 12.7mm, 19mm, and 25.4mm hemmers. For trimming and blind hemming sleeves and bottoms of T-shirts, A-shirts, polo shirts and similar products.

39500XERN (3/32" seam width)

Same as 39500RN, except in 9M (9000 RPM) with external oil pump and oil cooler.

39500SD1/8 (1/8" seam width)

1 Needle, 2 Thread Differential Feed curved needle Mark IV overedge, with swing-out cloth plate, includes 12.7mm, 19mm, and 25.4mm hemmers. For trimming and blind hemming sleeves and bottoms of T-shirts, A-shirts, polo shirts and similar products.

39500CSD1/8 (1/8" seam width)

Same as 39500SD, except with pneumatic Air Klipp® chain cutter.

39500XESD1/8 (1/8" seam width)

Same as 39500SD, except in 9M (9000 RPM) with external oil pump and oil cooler.

39500CXESD1/8 (1/8" seam width)

Same as 39500SD, except with pneumatic Air Klipp® chain cutter and in 9M (9000 RPM) with external oil pump and oil cooler.

COLLAR ATTACHING ON KNITS—LIGHT TO MEDIUM WEIGHT:



39500SE1/8 (1/8" seam width)

1 Needle, 3 Thread Differential Feed curved needle Mark IV overedge, with fine-tooth feed dogs and sewing combination to accept collarette folder. Does not include folder. For seaming and attaching collars to T-shirts

SPECIFICATIONS—styles for wovens



Model No.	39500QJ	39500QL	39500QN 39500QX	39500TM	39500QW	39500TT	39500RU, CRU
Needle	standard 090/036		standard 100/040		standard 090/036		standard 110/044
Material Weight	light to medium woven cotton, linen, denim		medium to heavy woven cotton, linen, denim	light to medium woven cotton, linen, denim	medium to heavy woven cotton, linen, denim	light to medium woven cotton, linen, denim	medium to heavy woven cotton, linen, denim
Stitch Length Adjustment	by changing stitch cams						
Differential Feed Adjustment	(plain feed)			lever	cam	lever	(plain feed)
Lubrication	automatic						
Lubricating Oil	Union Special Spec 175 (ISO grade 22)						
Stitch Type	503	505	504	504	512	504	
Seam Type	EFd-1		SSa-1	SSa-1			

39500QN	1	3	3/16"	1.3~3.2 (2.1 standard)	M~H	7500 RPM
39500QW	2	4	17/64"	1.3~3.2 (2.1 standard)	M~H	7500 RPM
39500QJ	1	2	3/16"	3.2~6.4 (5.1 standard)	L~M	7500 RPM
39500QL	1	3	3/16"	3.2~6.4 (5.1 standard)	L~M	7500 RPM
39500TM	1	3	3/16"	1.3~3.2 (1.8 standard)	L~M	6000 RPM
39500TT	1	3	3/16"	1.3~3.2 (1.8 standard)	L~M	6000 RPM
39500QX	1	3	3/8"	1.6~4.2 (2.5 standard)	M~H	7500 RPM
39500RU and CRU	1	3	3/16"	2.5~6.4 (2.5 standard)	M~H	7500 RPM

DEVICES & ATTACHMENTS



Latch Tacking Presser Foot

Presser foot number 39520CB is available for latch tacking seams when overedging with 39500 machines. The operator chains off after sewing, lifts the presser foot, brings the chain around to the front of the foot and pulls it into the knife and clamp. The next garment piece can be loaded and sewn so that the remaining chain is sewn into the seam. Seams are consistently latch tacked closed with clean finish at start.

This presser foot is easily attached to most single needle, three thread 39500 machines used to close sleeves and side seams on men's and women's knits shirts, children's clothes and similar garments requiring a latch tacking at the beginning.



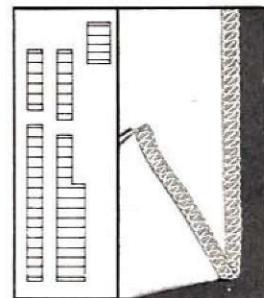
INSTALLATIONS



Use this chart to choose the correct table top for 39500 machines.
Table top dimensions are 51cm x 122cm.

Model No.	Table Board Part Number	Table Board Description
39500 all styles	21371RD48	Non-Submerged
	21371WL48	Fully-Submerged
39500 Mark IV styles	21371RL48	Semi-Submerged
39500 9M styles	21371WZ48	Semi-Submerged

8000 SPM
three-thread
overseamer
for trimming and
seaming operations



These Mark IV three-thread overseamers combine the best in mechanical and sewing principles developed through years of producing the finest sewing machines for the industry. Where operations permit, these machines will effortlessly cruise at up to 8000 stitches-per-minute. Many advanced features make these machines unequalled in performance and sewing room efficiency.

8000 Stitches-Per-Minute
three-thread overseamers
for maximum performance
for trimming and seaming
today's materials.



DESCRIPTION			SPECIFICATION				
MACHINE	FEATURES	APPLICATION	SEAM & STITCH TYPE	SEAM WIDTH	FABRIC WEIGHT & TYPE	STITCHES PER INCH	MAX.* SPEED
39500 QB	Light duty, cam driven main and differential feed.	For general seaming on "T" shirts, Polo shirts, children's knitwear	504 SSa-1 	3/32" 1/8" 5/32"	Lightweight cotton, synthetic & blended, knit fabric.	8-30 12 Std.	8000 SPM

* Depending on operation

Additional models:

39500CQB — same as 39500QB, with pneumatic Air Klipp®. For 1/8" gauge only.

39500XEQB — same as the 39500QB, with external oil pump. Unit operates at 9000 spm.

39500CXEQB — same as 39500XEQB, with Air Klipp®.

FOR TRIMMING & SEAMING

- SLIPS/PAJAMAS
- NIGHTGOWNS
- POLO SHIRTS/SWEAT SHIRTS
- PANTIES, INFANTS' & CHILDREN'S KNITWEAR

OTHER IMPORTANT FEATURES

- SEW-TESTED UP TO 8000 SPM WITHOUT STRAIN
- QUALITY CURVED NEEDLE STITCHING
- INSTANT ACCELERATION
- COMPLETELY ENCLOSED MECHANISMS

- AUTOMATIC LUBRICATION
- SUPERIOR THREAD HANDLING
- EFFORTLESS, QUIET OPERATION
- EASY THREADING
- MODERN DESIGN

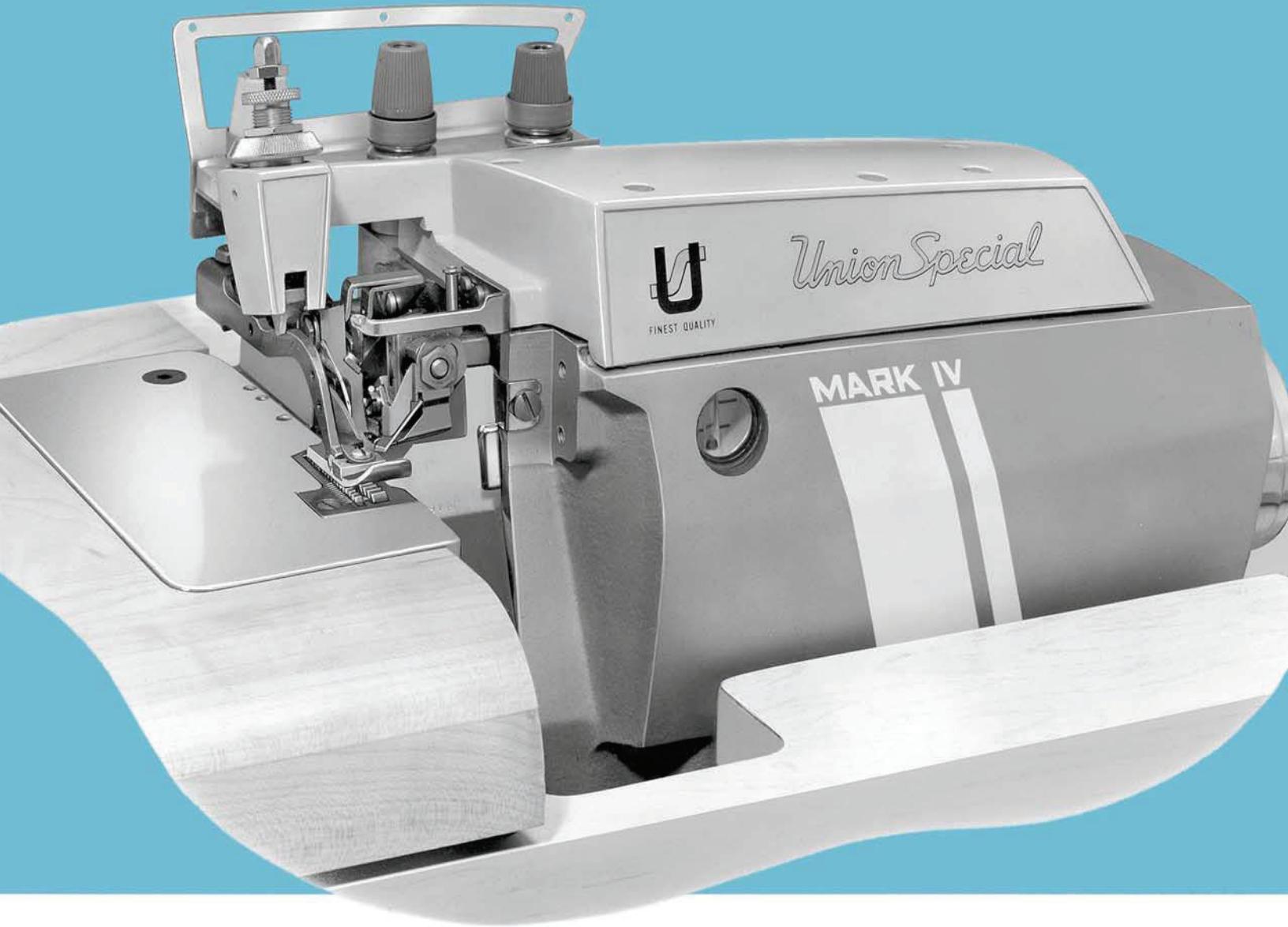
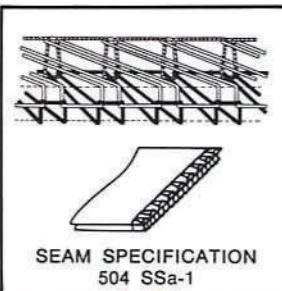
WORLDWIDE SALES AND SERVICE

Union Special Machine Company
One Union Special Plaza
Huntley, Illinois 60142

www.unionspecial.com
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Union Special®
INDUSTRIAL SEWING EQUIPMENT

**High-speed, three-thread
machines for trimming
and overseaming
medium to heavyweight
knit materials.**



These MARK IV MAXIMUM PERFORMANCE overseamers are designed to put "sample piece" quality in your knit garments. Styles 39500 QP and 39500 RF are ideal for trimming and overseaming operations on knit snow suits, swim suits, sweat shirts, jackets, underwear, and similar garments. They combine the best in mechanical and sewing principles developed through years of producing the finest sewing machines for the industry.

MARK IV
STYLE 39500 QP
STYLE 39500 RF

 **Union Special®**
Finest Quality
INDUSTRIAL SEWING EQUIPMENT

High-speed, three-thread
MAXIMUM PERFORMANCE machines for
trimming and overseaming operations
on knit snow suits, swim suits,
sweat shirts, jackets and underwear.

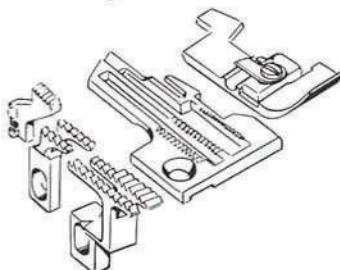


FEATURES

- UP TO 7500 SPM WITHOUT STRAIN
- QUALITY CURVED NEEDLE STITCHING
- INSTANT ACCELERATION
- COMPLETELY ENCLOSED MECHANISMS
- AUTOMATIC LUBRICATION
- SUPERIOR THREAD HANDLING
- EFFORTLESS QUIET OPERATION
- EASY THREADING
- FAST STARTING AND STOPPING

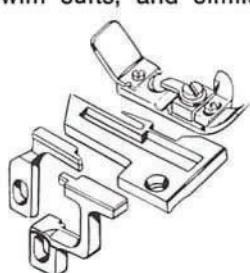
STYLE 39500 QP

Single-needle differential feed machine for overseaming medium to heavyweight flat, warp and ribbed knit materials made from cotton, wool, synthetics and silk. Used on snow suits, sweat shirts, underwear and similar garments.



STYLE 39500 RF

Similar to Style 39500 QP except fitted with sewing parts designed especially for seaming and trimming light-medium to heavyweight flat, warp, and ribbed knit materials made from cotton, wool, and synthetics such as "T" shirts, sweat shirts, underwear, infants' and children's knit wear, swim suits, and similar garments.

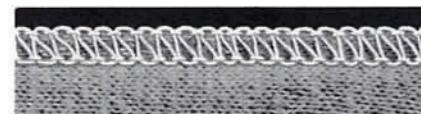


ADDITIONAL STYLES:

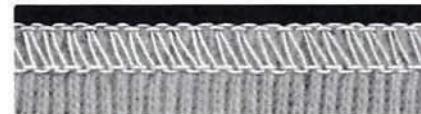
39500CRF — same as 39500RF, with Air Klipp®.

39500XERF — same as the 39500RF, with external oil pump.
Unit operates at 9000 spm.

39500CXERF — same as 39500XERF, with Air-Klipp®.



Several plies of knit sweat shirt material seamed on Style 39500 QP illustrate sewing capacity and well-covered seams.



Overseaming on "T" shirt material as produced on Style 39500 RF.

Seam Specification



504



SSa-1

SPECIFICATIONS

STYLE 39500 QP

Seam Specification	504 SSa-1
Stitch Range	8 to 20 S.P.I.
Standard Setting	12 S.P.I.
Needle.....	154 GAS-050/036
Needle Thread.....	60-3 Soft
Looper Thread.....	60-3 Soft
Sewing Capacity	23/64" (9.13 mm)
Speed	7500 S.P.M.*
Installation	Semi-submerged

STYLE 39500 RF

Seam Specification	504 SSa-1
Stitch Range	8 to 30 S.P.I.
Standard Setting	12 S.P.I.
Needle.....	154 GAS-070/027
Needle Thread.....	70-2 Soft
Looper Thread.....	70-2 Soft
Sewing Capacity	7/32" (5.56 mm) and 3/16" (4.76 mm)
Speed	7500 S.P.M.*
Installation	Semi-submerged

* Depending on operation

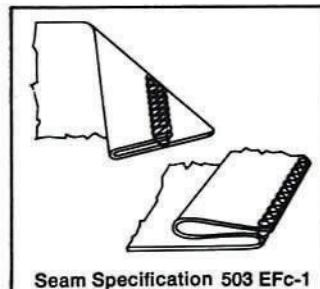
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 **Union Special®**
Finest Quality
INDUSTRIAL SEWING EQUIPMENT

**High speed
two-or three-thread
differential feed machines
for blindstitch hemming
on tubular or flat work**



These Maximum Performance MARK IV blindstitch hemmers are designed to meet tomorrow's production requirements today! They incorporate many advanced features which make them unequalled in performance and sewing room efficiency. Where operations permit, they will effortlessly cruise at up to 8000 stitches per minute! Ideal for blindstitch hemming lightweight flat, warp, and ribbed knit fabric.

STYLE 39500 QG

STYLE 39500 RN

STYLE 39500 SD

MARK IV



**Two-or three-thread
differential feed machines
for blindstitch hemming
on tubular or flat work are
capable of 8000 stitches-per-minute**



MACHINE	FEATURES	APPLICATION	SEAM & STITCH TYPE	SEAM WIDTH	FABRIC WEIGHT & TYPE	STITCHES PER INCH	MAX.* SPEED
39500 QG	Light to medium duty single needle differential feed hemmer, fitted with knee press operated, retractable hemming guide.	Blindstitch hemming kn/pull over type seam where operation may require crossing side seams.	503 EFc-1	Hem 1/2", 3/4", 1"	Lightweight flat, warp, and ribbed knit fabric.	8-30 14 Std.	8000 SPM
39500 RN	Light to medium duty, single needle, differential feed hemmer, with upper looper instead of spreader.	Blindstitch hemming where automated installations make threading lower looper inaccessible.	503 EFc-1	Hem 1/2", 3/4", 1"	Same as 39500 QG	8-30 9 Std.	8000 SPM
39500 SD	Light to medium duty, single needle differential feed hemmer, with swing out cloth plate.	Blindstitch hemming, both flat and circular hems.	503 EFc-1	Hem 1/2", 3/4", 1"	Same as 39500 QG	8-30 14 Std.	8000 SPM

* Depending on operation

Additional models:

39500CSD—

same as 39500SD except also with Air Klipp®

39500XESD—

same as the 39500SD except also with external oil pump.
Unit operates at 9000 spm.

39500CXESD—

same as 39500XESD except also with Air-Klipp®

39500XERN—

same as the 39500RN except also with external oil pump.
Unit operates at 9000 spm.



39500QG

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