

# COLLAR ATTACHING ON KNITS—LIGHT TO MEDIUM WEIGHT:







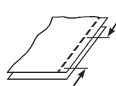


## 39500SE1/8 (1/8" seam width)

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

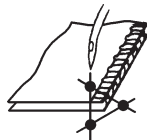
## SPECIFICATIONS—styles for wovens



Model No.	39500QJ	39500QL	39500QN 39500QX	39500TM	39500QW	39500TT	39500RU, CRU
Needle	154GAS055/022~150/060						
	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			

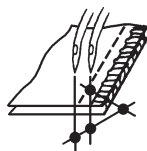
						
39500QN	1	3	3/16"	1.3~3.2 (2.1 standard)	M~H	7500 RPM
39500QW	2	4	17/64"	1.3~3.2 (2.1 standard)	M~H	7500 RPM
39500QJ	1	2	3/16"	3.2~6.4 (5.1 standard)	L~M	7500 RPM
39500QL	1	3	3/16"	3.2~6.4 (5.1 standard)	L~M	7500 RPM
39500TM	1	3	3/16"	1.3~3.2 (1.8 standard)	L~M	6000 RPM
39500TT	1	3	3/16"	1.3~3.2 (1.8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

## SEAMING WOVENS—MEDIUM TO HEAVY WEIGHT:



### 39500QN (3/16" seam width)

1 needle, 3 thread **plain feed** curved needle **Mark IV** overedge, with wide presser foot. For trimming and seaming operations on snowsuits, jackets, ski pants, garment pockets and similar garments.



### 39500QW (17/64" seam width)

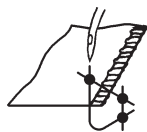
2 needle, 4 thread **differential feed** curved needle **simulated safety** stitch **Mark IV** overedge, with coarse-tooth dogs and wide material trimming knives. For trimming and seaming operations on drapery panels, pajamas, women's & children's pants and similar garments.

## EDGE FINISHING on WOVENS—LIGHT TO MEDIUM WEIGHT:



### 39500QJ (3/16" seam width)

1 needle, 2 thread **plain feed** curved needle **Mark IV** overedge, with wide material trimming knives and long stitch length. For serging the edge of trouser and skirt panels to prevent cloth from raveling.



### 39500QL (3/16" seam width)

Same as 39500QJ except with 3 thread box edge stitch.

## INTERMITTENT SHRIRING & SEAMING on WOVENS

—LIGHT TO MEDIUM WEIGHT:



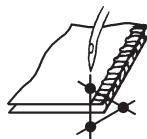
### 39500TM (3/16" seam width)

1 needle, 3 thread **intermittent differential feed** curved needle **Mark IV** overedge, with **5 to 1 shirring ratio** at 4 SPI. For seaming and intermittent shirring sleeves of women's blouses, slips and nightgowns and men's shirts.

### 39500TT (3/16" seam width)

Same as 39500TM except with **3 to 1 shirring ratio** at 14 SPI.

## ZIPPER ATTACHING on WOVENS—MEDIUM TO HEAVY WEIGHT:



### 39500QX (3/8" seam width)

1 needle 3 thread **plain feed** curved needle **Mark IV** overedge, with adjustable channel in presser foot for zipper teeth and wide material trimming knives. For attaching zipper tape without slide, to pants and jeans fronts.

### 39500RU (3/16" seam width)

1 needle 3 thread **plain feed** curved needle **Mark IV** overedge, with wide material trimming knives and narrow presser foot to allow zipper teeth with slider and staples to pass freely. For attaching zipper with slide and staple to pants and jeans fronts.

### 39500CRU (3/16" seam width)

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

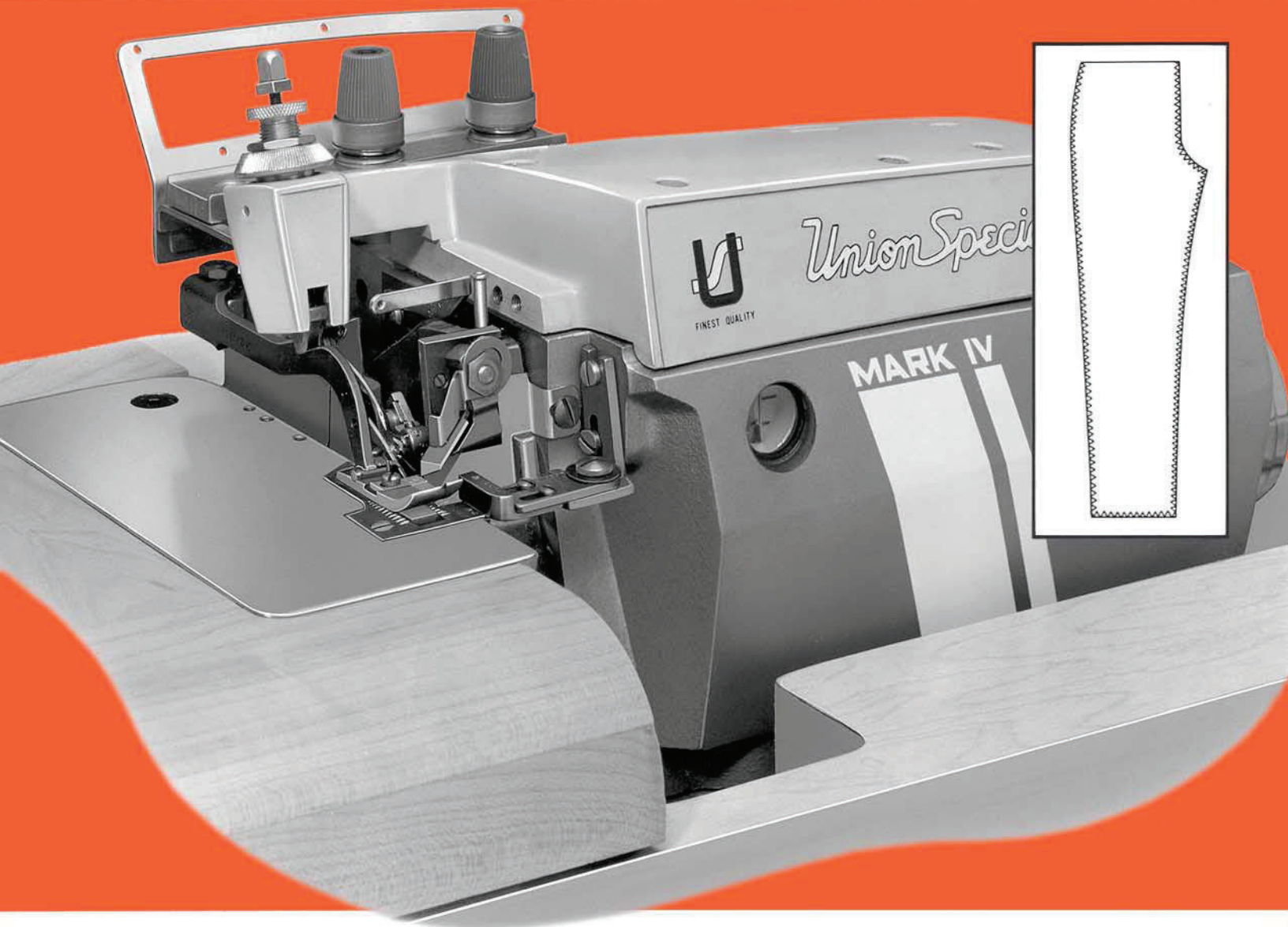
**7500 stitches-per-minute,  
two- and three-thread  
TROUSER SERGERS  
for all weights and  
types of material.**



Style 39500 QJ  
produces two-thread  
stitch, Type 503



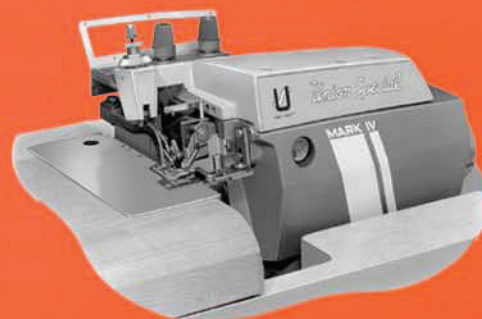
Style 39500 QL  
produces three-thread  
stitch, Type 505





These two MARK IV MAXIMUM PERFORMANCE machines are designed especially for serging trousers of all weights and materials. Styles QJ and QL combine the best in mechanical and sewing principles developed through years of producing the finest sewing machines for the industry. They're the answer to all your serging and trimming requirements.



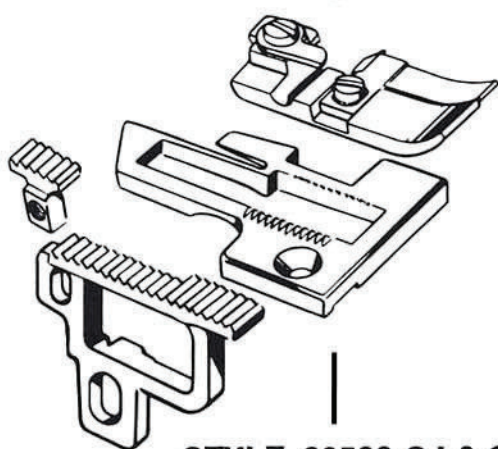
**High speed MAXIMUM PERFORMANCE**  
**two-thread and three-thread sergers**  
**for trousers of all weights**  
**and types of materials.**



MACHINE	FEATURES	APPLICATION	SEAM & STITCH TYPE	SEAM WIDTH	FABRIC WEIGHT & TYPE	STITCHES PER INCH	MAX.* SPEED
39500 QJ	Medium duty, single needle, plain feed, 2-thread stitch.	For serging trouser panels to prevent cloth from raveling.	503 EFd-1 	5/32" to 3/16"	Light to heavyweight woven pant material.	4-8 5 Std.	7500 SPM
39500 QL	Same as 39500 QJ except produces 3-thread square edge stitch.	Same as 39500 QJ except for maximum coverage on fabric edge.	505 EFd-1 	5/32" to 3/16"	Same as 39500 QJ	4-8 5 Std.	7500 SPM

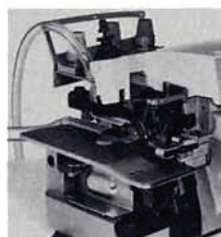
AIR-KLIPP CHAIN CUTTERS ARE AVAILABLE

\* Depending on operation



**STYLE 39500 QJ & QL**

### PRODUCTION AIDS TO INCREASE EFFICIENCY AND SAVE MATERIAL

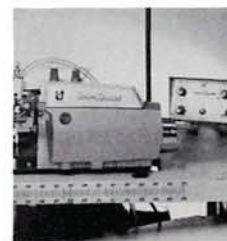


#### AIR-KLIPP CHAIN CUTTER

Compact, air-operated automatic chain cutter assures neat, close severing of the chain on a wide variety of operations. Horizontal knife eliminates obstructions behind presser foot.

#### SENS-A-TROL

An electronic device for automatic control functions of stitch (simulating tacking) and start-stop applications. Sensing system capable of sensing fabrics from meltons to tricot and even open weave lace.



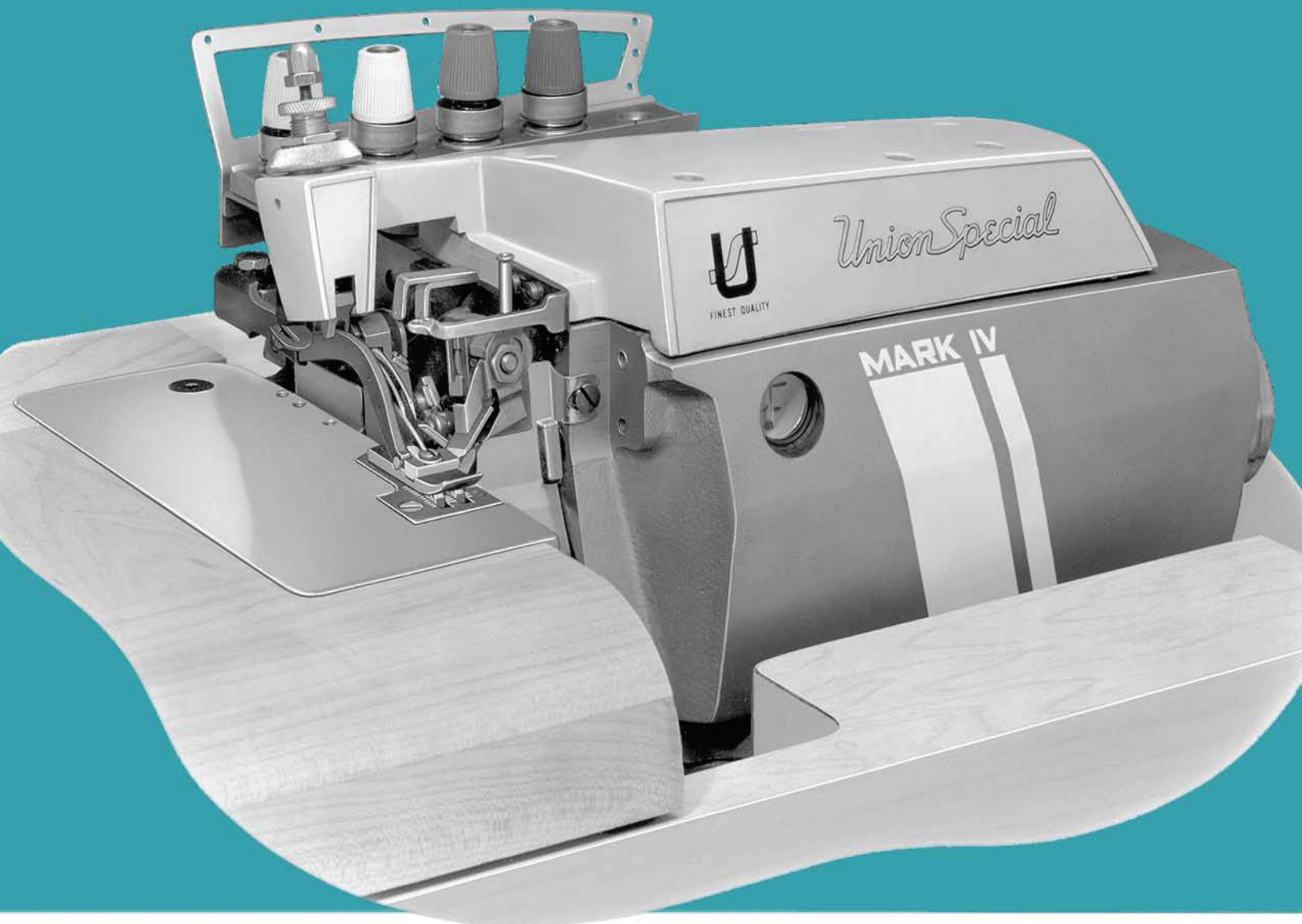
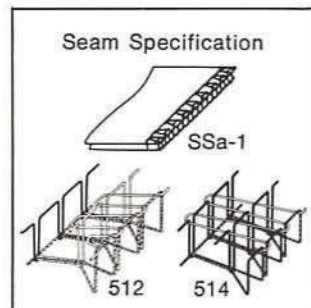
#### WORLDWIDE SALES AND SERVICE

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

[www.unionspecial.com](http://www.unionspecial.com)  
[www.the-needles-eye.com](http://www.the-needles-eye.com)  
[www.juki.com](http://www.juki.com)



**High-speed, two-needle,  
four-thread overseamers  
for trimming and seaming  
operations on knit and  
woven stretch garments**

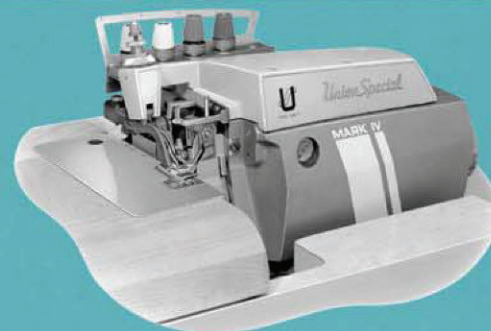


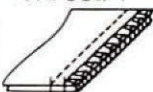



MARK IV  
 STYLE 39500 QW  
 STYLE 39500 RH

**Union Special**  
 INDUSTRIAL SEWING EQUIPMENT

Two new high-speed, two needle four-thread MAXIMUM PERFORMANCE overseamers especially designed for trimming and seaming operations on knit and woven stretch garments.

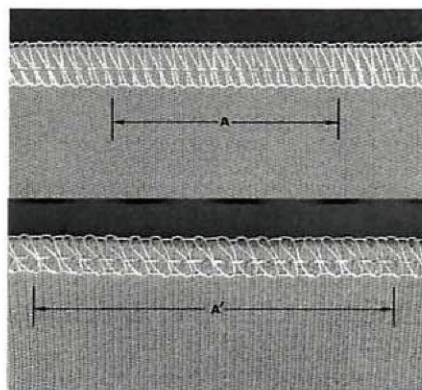


DESCRIPTION			SPECIFICATION				
MACHINE	FEATURES	APPLICATION	SEAM & STITCH TYPE	SEAM WIDTH	FABRIC WEIGHT & TYPE	STITCHES PER INCH	MAX.* SPEED
39500 QW	Medium to heavy duty, cam driven main and differential feed. Produces simulated safety stitch.	For seaming bathing suits, house dresses, children's garments and draperies.	512 SSa-1 	17/64"	Light, medium, and heavy weight woven and knit fabrics.	8-20 10 Std.	7500 SPM
39500 RH	Same as 39500 QW except medium duty. The upper looper thread is caught by both needles. Stitch produced is very elastic.	For seaming stretch slacks, foundation garments and operations that require unusual amounts of stretch in the seam.	514 SSa-1 	17/64"	Light to medium weight stretch type woven and knit fabrics.	6-15 10 Std.	7500 SPM

**DISCONTINUED**



Sample of overseaming produced with Style 39500 QW. Notice similarity in appearance to "Safety-Stitch".



Sample of four-thread, two-needle Stitch Type 514. In photo above A represents material as sewed and A' shows the same seam stretched.

## OTHER IMPORTANT FEATURES

- QUALITY CURVED NEEDLE STITCHING
- INSTANT ACCELERATION
- COMPLETELY ENCLOSED MECHANISMS
- AUTOMATIC LUBRICATION
- SUPERIOR THREAD HANDLING
- EFFORTLESS QUIET OPERATION
- EASY THREADING

### WORLDWIDE SALES AND SERVICE

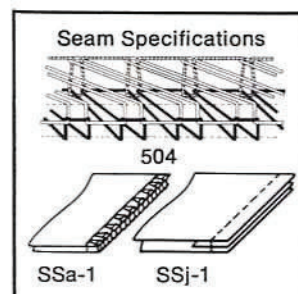
Union Special Machine Company  
 One Union Special Plaza  
 Huntley, Illinois 60142

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**Union Special**  
 INDUSTRIAL SEWING EQUIPMENT



**High-speed three-thread overedgers for zipper and fly attaching operations on pants, slacks, skirts and jackets.**



These two MARK IV *THIRTY/NINE/FIVES* bring you outstanding performance, dependability, quality, and sewing room efficiency.

*Style 39500 QX* is for attaching zipper tape without sliders to right fly, attaching fly with zipper tape to pants front, and attaching and serging left fly on men's pants and slacks. *Style 39500 RU* attaches closed zippers with slider and staples in place on pants, slacks, skirts and jackets.

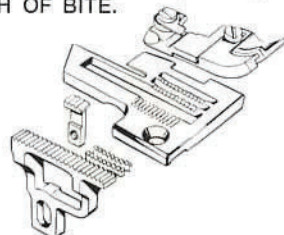


**MAXIMUM PERFORMANCE** high-speed, high-throw three-thread overedgers for attaching zippers and flies to men's pants and slacks, and for attaching closed zippers with slider and staples in place.



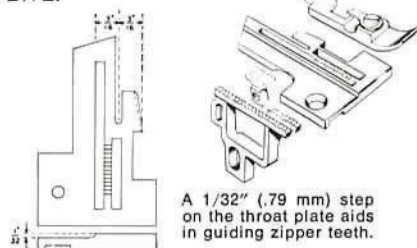
#### STYLE 39500 QX

Plain-feed, single-needle machine for simultaneously attaching right pants flies and zipper tapes without sliders to pants fronts, attaching zippers to right flies only, and similar operations. Has turned up toe, adjustable grooved section in bottom with adjustment to left for various size zipper teeth, especially designed for zipper tapes  $\frac{1}{2}$ " (12.70 mm) wide ( $\pm 1/32$ ", .79 mm).  $\frac{3}{8}$ " (9.52 mm) WIDTH OF BITE.



#### STYLE 39500 RU

Plain-feed, single-needle machine for simultaneously ATTACHING ZIPPERS WITH SLIDERS and staples in place (and overedge the facings) to pants flies, shirts, jackets, and similar garments. A  $\frac{1}{32}$ " (.79 mm) step on the throat plate provides a ridge to aid in guiding the zipper teeth. The step is located  $\frac{3}{16}$ " (4.76 mm) to the left of the needle. The edge of the presser foot prevents moving the zipper too far to the right and cutting the tape. Width of zipper tape to right of zipper teeth must be a minimum of  $\frac{3}{8}$ " (9.52 mm).  $\frac{3}{16}$ " (4.76 mm) WIDTH OF BITE.



Seam Specifications



504



SSa-1

SSj-1

#### Specifications:

##### STYLE 39500 QX

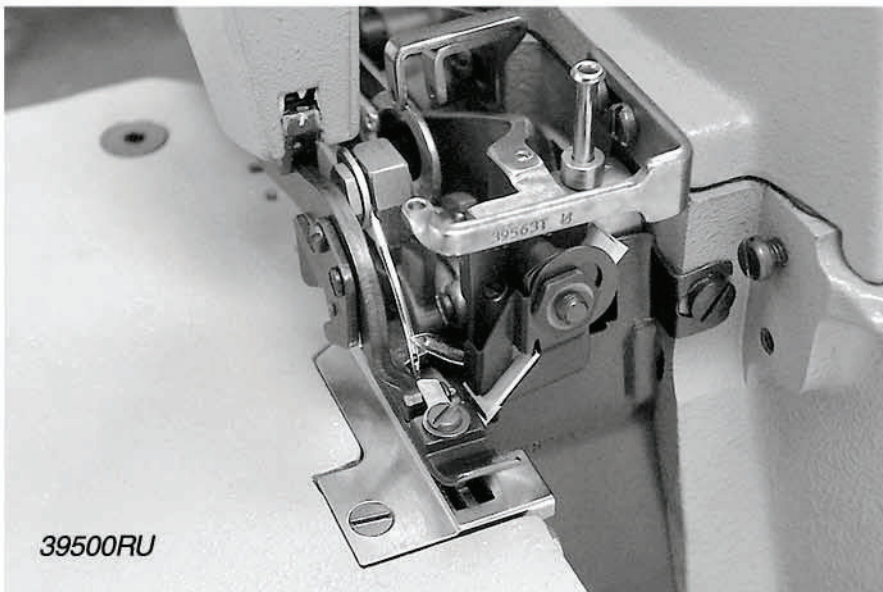
Seam Specification . . . 504 SSa-1 or SSj-1  
Stitch Range . . . . . 6 to 16 S.P.I.  
Standard Setting . . . . . 10 S.P.I.  
Needle . . . . . 154 GAS-040  
Needle Thread . . . . . 36-3 soft  
Looper Thread . . . . . 40-3 soft  
Sewing Capacity . . .  $\frac{13}{64}$  inch (5.16 mm)  
Speed, Up To . . . . . 7500 S.P.M.  
Installation . . . . . Semi-Submerged

##### STYLE 39500 RU

Seam Specification . . . . . 504 SSa-1  
Stitch Range . . . . . 4 to 10 S.P.I.  
Standard Setting . . . . . 7 S.P.I.  
Needle . . . . . 154 GAS-044  
Needle Thread . . . . . 70-2 soft  
Looper Thread . . . . . 70-2 soft  
Sewing Capacity . . . . .  $\frac{1}{8}$  inch (3.17 mm)  
Speed, Up To . . . . . 7500 S.P.M.  
Installation . . . . . Semi-Submerged

#### Additional styles:

39500CRU — same as 39500RU, with Air-Klipp®.



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