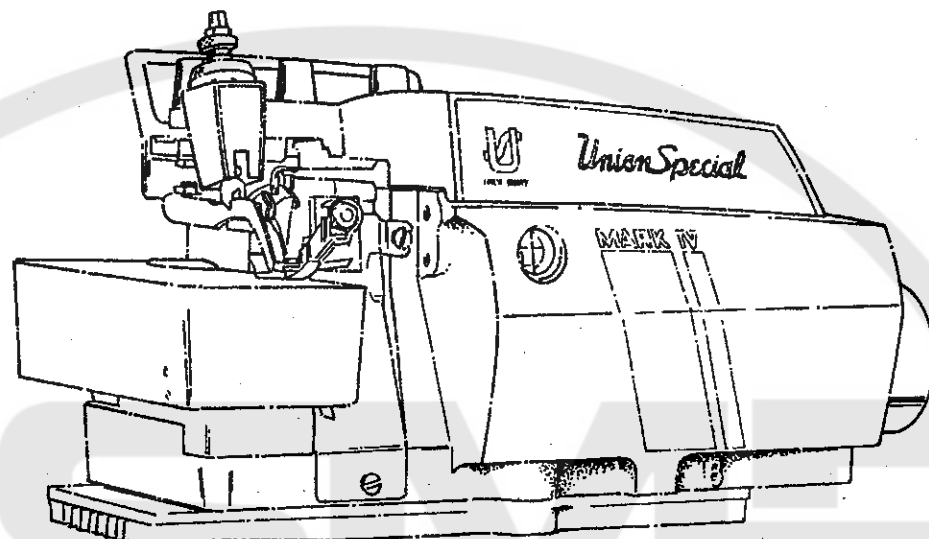


MANUAL NO.  
PRT9206

ILLUSTRATED PARTS LIST

STYLES

39500 QA  
39500 QB  
39500 QP  
39500 RA  
39500 RF  
39500 RR  
39500 RS  
39500 SE  
39500 SF  
39500 TE  
39500 CQA  
39500 CQB  
39500 CRF  
39500 SQB  
39500 SRF  
39500 CSRF



P049-92

39500 CLASS



*Union Special*  
INDUSTRIAL SEWING EQUIPMENT

# Manual No. PRT9206 Illustrated Parts List for 39500 Series Machines

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By

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## PREFACE

This parts manual has been prepared to assist you in locating individual parts or assemblies on 39500 Series machines. It can be used in conjunction with Union Special Adjusting Manual INS9207.

It is the desire of Union Special that each machine run at its optimum performance. Parts listed in this manual are designed specifically for your machine and are manufactured with utmost precision to assure long lasting service.

This manual has been comprised on the basis of available information. Changes in design and/or improvements may incorporate a slight modification of configuration in illustrations or part numbers.

On the following pages are illustrations and terminology used in describing the parts used on 39500 Series machines.

---

## SAFETY RULES



### General Operating Directions

The sewing machines described in this instruction manual are prohibited from being put into service until it has been ascertained that the sewing units, in which these sewing machines will be built-in have conformed with the EC Council Directives (89/392/EEC, Annex II B).

1. Before putting the machines described in this manual into service, carefully read the instructions. The starting of each machine is only permitted after taking notice of the instructions and by qualified operators.

**IMPORTANT!** Before putting the machine into service, also read the safety rules and instruction from the motor supplier.

2. Observe the national safety rules valid for your country.
3. Each machine is only allowed to be used as foreseen. The foreseen use of the particular machine is described in paragraph "STYLES OF MACHINES" of this instruction manual. Another use, going beyond the description, is not as foreseen.
4. All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.
5. The following safety devices are components of the sewing machines: Finger guard, needle lever eyelet guard, needle bar guard, needle break protection shield and handwheel-belt guard.
6. When gauge parts are exchanged (e.g. needle, presser foot, needle plate, feed dog and bobbin) during threading, when the operator leaves the workplace, and during service work, the machine must be isolated from the main power by switching off the main switch or disconnecting the main plug. On mechanically operated clutch motors without a start inhibitor it is necessary to wait until the motor has stopped.

7. Wear safety glasses.
8. In case of machine conversions and changes all valid safety rules must be considered. Conversions and changes are made at your own risk.
9. Commissioning of the sewing head is prohibited until such time as the entire sewing unit is found to comply with EC regulations.
10. The warning hints in the instructions are marked with one of these two symbols:



Items require special attention



Danger of injury to operative or service staff

Be sure to observe and adhere to these indications and to the generally applicable regulations.

#### Special Operating Directions

11. For the following the machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug:
  - 11.1 For threading needle(s), looper, spreader etc.
  - 11.2 For replacing sewing parts such as needle, presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, fabric guide etc.
  - 11.3 When leaving the workplace and when the workplace is unattended.
  - 11.4 For maintenance work.
  - 11.5 When using clutch motors without actuation lock, wait until the motor is stopped totally.

#### General Maintenance Directions

12. Maintenance, repair and conversion work (see item 8) must be done only by trained technicians or special skilled personnel under consideration of the instructions.
13. Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.

#### Special Maintenance Directions

14. Work on parts and equipment under electrical tension is not permitted. Permissible exceptions are described in the applicable sections of standard sheet DIN VDE 0105.
15. Before doing maintenance and repair work on the pneumatic equipment, the machine has to be disconnected from the compressed air supply. In case of existing residual air pressure after disconnecting from compressed air supply (e.g. pneumatic equipment with air tank), the pressure has to be removed by bleeding.

Exceptions are only allowed for adjusting work and function checks done by special skilled personnel.

#### Standards

17. The sewing machines described in this manual are built according to the following standards:

EN292-2 Safety of machinery-basic concepts, general principles for design.

IEC204-3-1/EN60204-3-1 Electrical equipment of industrial machines. Part 3: Particular requirements for sewing machines, units and systems.

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## ORDERING REPAIR PARTS

### ILLUSTRATIONS

This manual has been arranged to simplify ordering repair parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the machine. 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 in the particular view being shown.

Numbers in the first column are reference numbers only, and merely indicate the position of the part in the illustration. The reference number should never be used in ordering parts. Always use the part number listed in the second column.

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. As an example refer to the text below.

|     |          |                                         |   |
|-----|----------|-----------------------------------------|---|
| 9.  | 29126 EC | Upper Looper Drive Shaft Assembly ..... | 1 |
| 10. | 22503 F  | Screw .....                             | 1 |
| 11. | 39543 E  | Cam Follower Locking Clamp .....        | 1 |

It will be noted in the above example that the cam follower, bushing and cam guide and the upper looper drive shaft are not listed. The reason is that replacement of these parts individually is not recommended, so the complete upper looper drive shaft assembly should be ordered.

When a part is common to all machines covered in this manual, no specific usage will be mentioned in the description. However, when the parts for the various machines are not the same, the specific usage will be mentioned in the description and, if necessary, the difference will be shown in the illustration.

A numerical index of all the parts shown in this manual is located at the back. This will facilitate locating the illustration and description when only a part number is known.

## 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.

**PLEASE NOTE:** Part numbers represent the same part, regardless of which manual they appear. On all orders please include part number, name and style of machine for which the part was ordered.

## NEEDLES

Each needle has both a 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 the largest diameter of the blade measured between the shank and the eye. Collectively, the type number and size number represent the complete symbol which is given on the label of all needles packed and sold by Union Special.

| <u>TYPE</u> | <u>DESCRIPTION</u>                                                                                                                                                                                                                  |
|-------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 154 GAS     | Round shank, round point, curved blade, standard length, single groove, struck groove, spotted, chromium plated. Sizes available 055/022, 065/025, 070/027, 075/029, 080/032, 090/036, 100/040, 110/044, 125/049, 140/054, 150/060. |
| 154 GBS     | Round shank, round point, curved blade, standard length, double groove, struck groove, spotted, chromium plated. Sizes available 070/027, 075/029, 080/032.                                                                         |
| 154 GHS     | Round shank, ball point, curved blade, standard length, single groove, struck groove, spotted, chromium plated. Sizes available 065/025, 070/027, 075/029, 080/032, 090/036.                                                        |
| 162 SAS     | Round shank, round point, curved blade, short length, double groove, struck groove, spotted, chromium plated. Sizes available 055/022, 065/025, 070/027, 075/029, 080/032, 090/036, 100/040, 110/044.                               |

## APPLICATION

| Machine Style                       | Needle Type | Needle Size |
|-------------------------------------|-------------|-------------|
| 39500 QA, QB, RF, TE, CQA, CQB, CRF | 154 GAS     | 070/027     |
| 39500 SE                            | 154 GAS     | 080/032     |
| 39500 QP                            | 154 GAS     | 090/036     |
| 39500 RA, SF                        | 154 GAS     | 100/040     |
| 39500 RS                            | 154 GBS     | 075/029     |
| 39500 RR                            | 154 GHS     | 080/032     |
| 39500 SRF, CSRF                     | 162 SAS     | 065/025     |
| 39500 SQB                           | 162 SAS     | 070/027     |

When changing the needle, make sure it is fully inserted in the needle driving arm before the nut is tightened.

To have needles promptly and accurately filled, an empty package, a needle sample, or the type and size number should be forwarded. Use the description on the label. A complete order should read as follows: "100 needles, type 154 GAS, size 070/027".

## **TERMS**

Prices are net cash and subject to change without notice. All shipments are forwarded F.O.B. shipping point. A charge is made to cover postage and insurance.

## **TORQUE REQUIREMENTS**

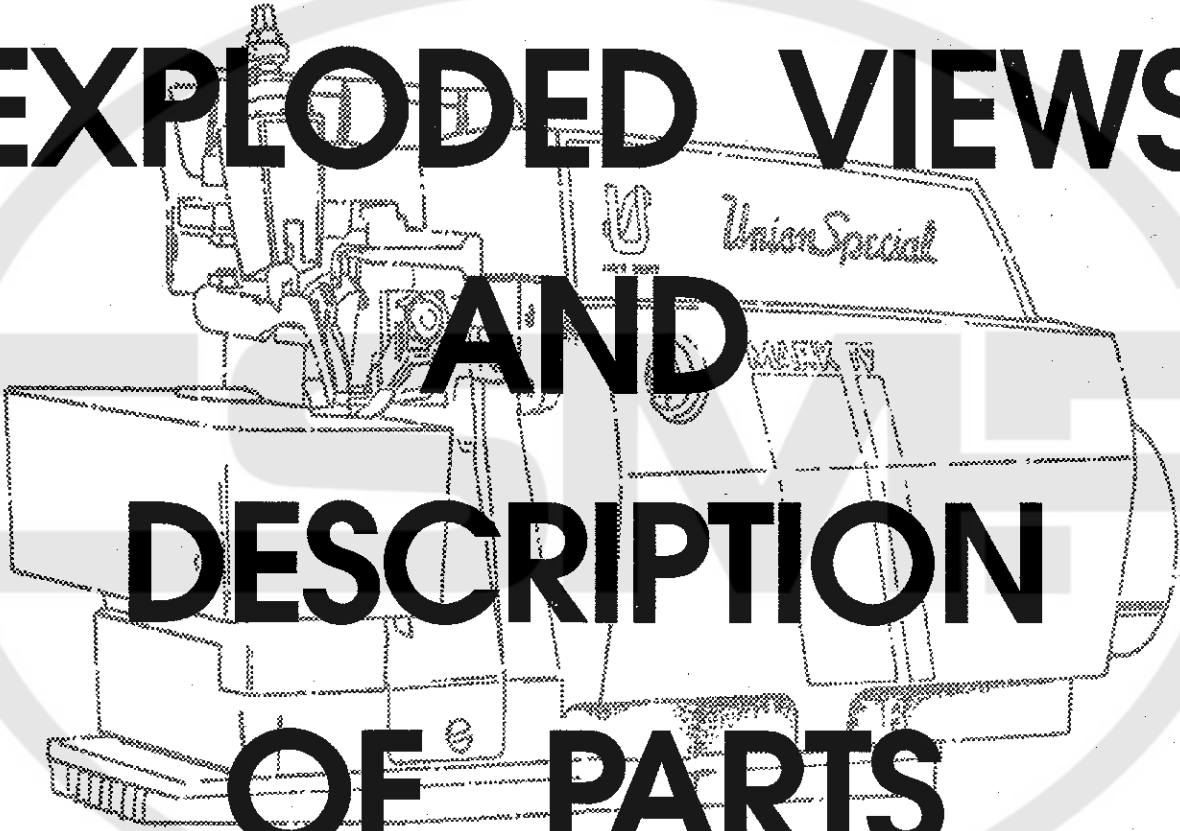
Torque measured in inch-pounds or centimeter/kilograms is a rotating force in pounds applied through a distance by a lever in inches, feet or meters. This is accomplished by a wrench, screwdriver, etc. Many of these devices are available, which when set at the proper amount of torque will tighten the part to the correct amount and no tighter.

All straps and eccentrics should be tightened to 26-28 inch-pounds (2.9-3.2Nm) unless otherwise noted. All other nuts, bolts, screws, etc. should be tightened by hand as tightly as possible, unless otherwise noted.

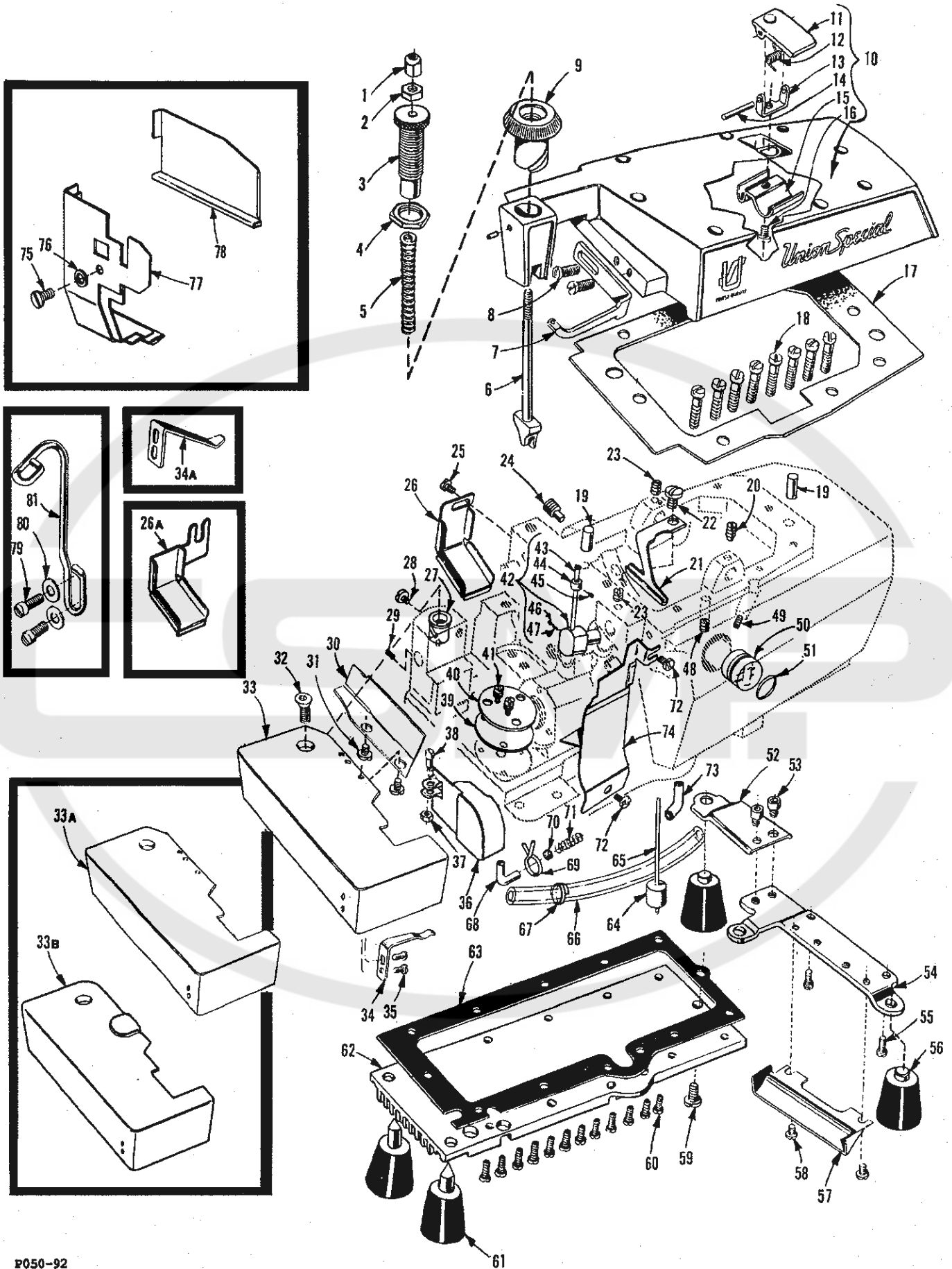
Screws requiring a specific torque will be indicated on the illustrations in 39500 Parts Manual PRT9206.



# EXPLODED VIEWS AND DESCRIPTION OF PARTS

An exploded view diagram of a Union Special sewing machine. The diagram shows the main body of the machine, the foot, the needle, and the presser foot assembly. The text "Union Special" is visible on the side of the machine body. The diagram is rendered in a technical, line-art style with a stippled background.

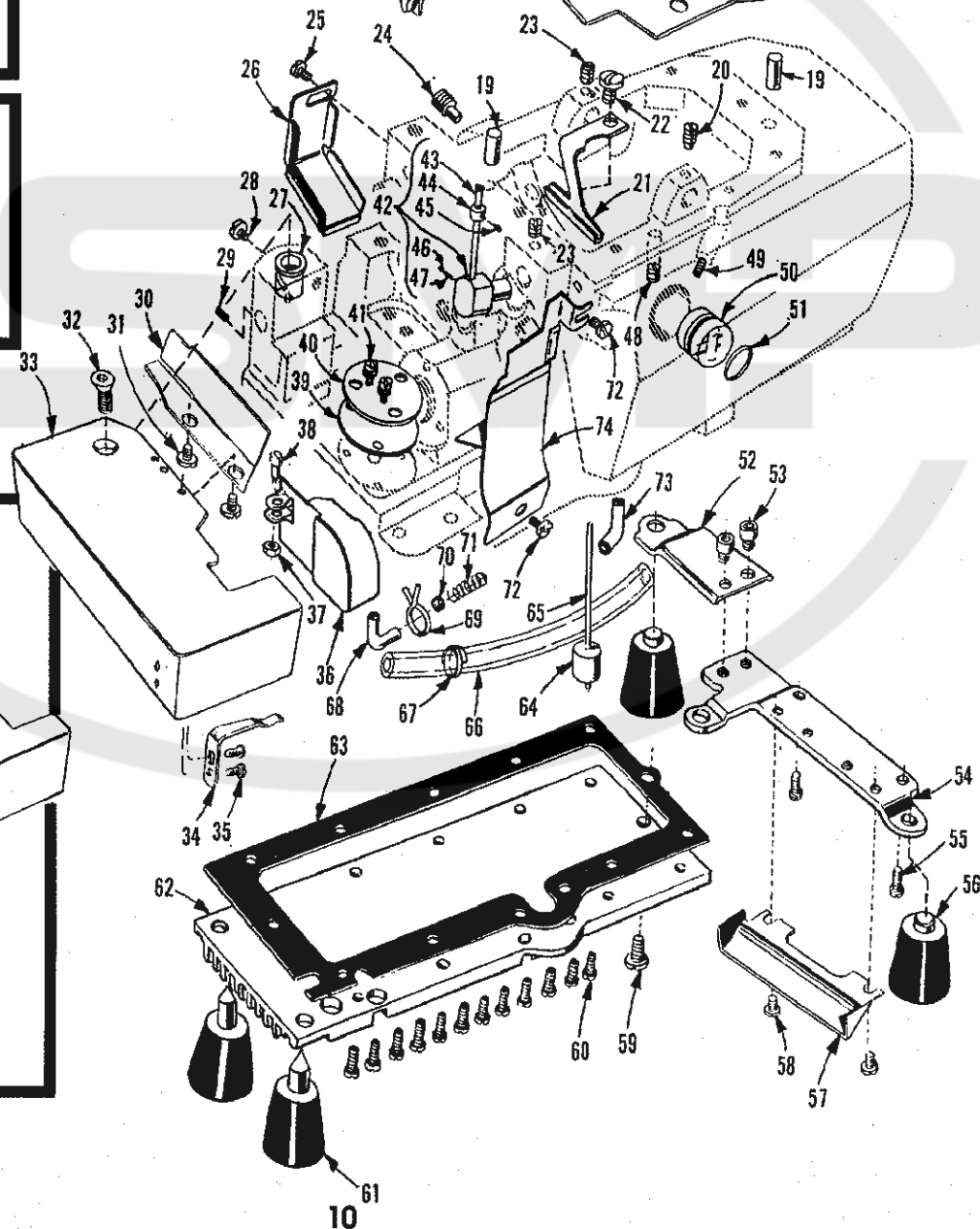
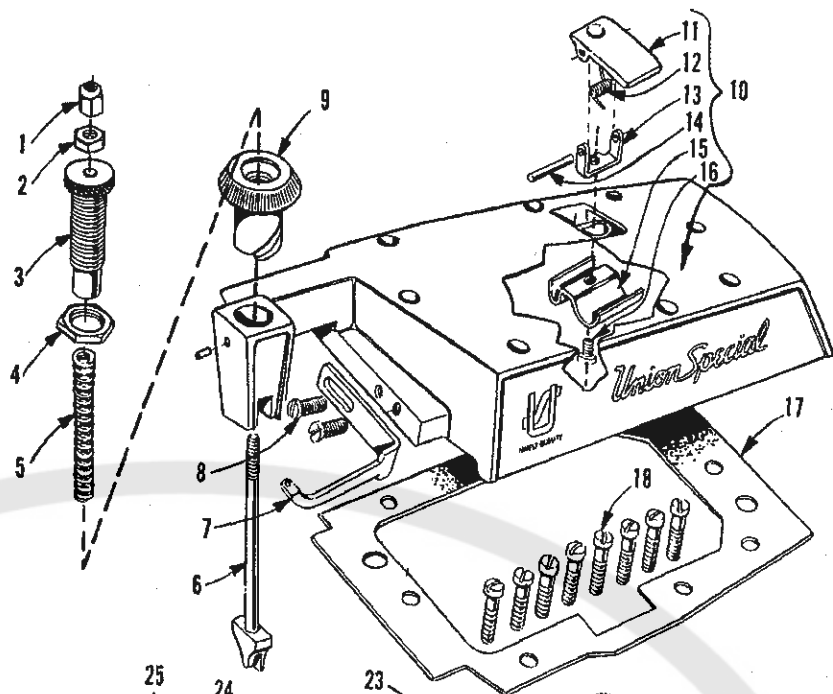
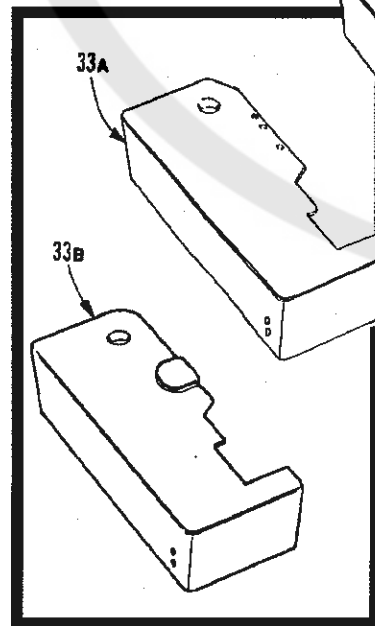
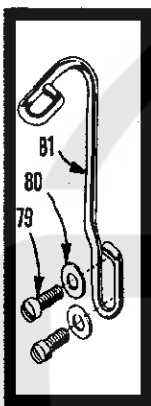
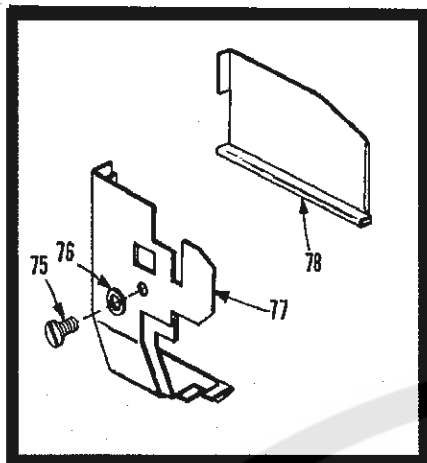
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# MAIN FRAME, MISCELLANEOUS COVERS & PRESSER FOOT RELEASE PARTS

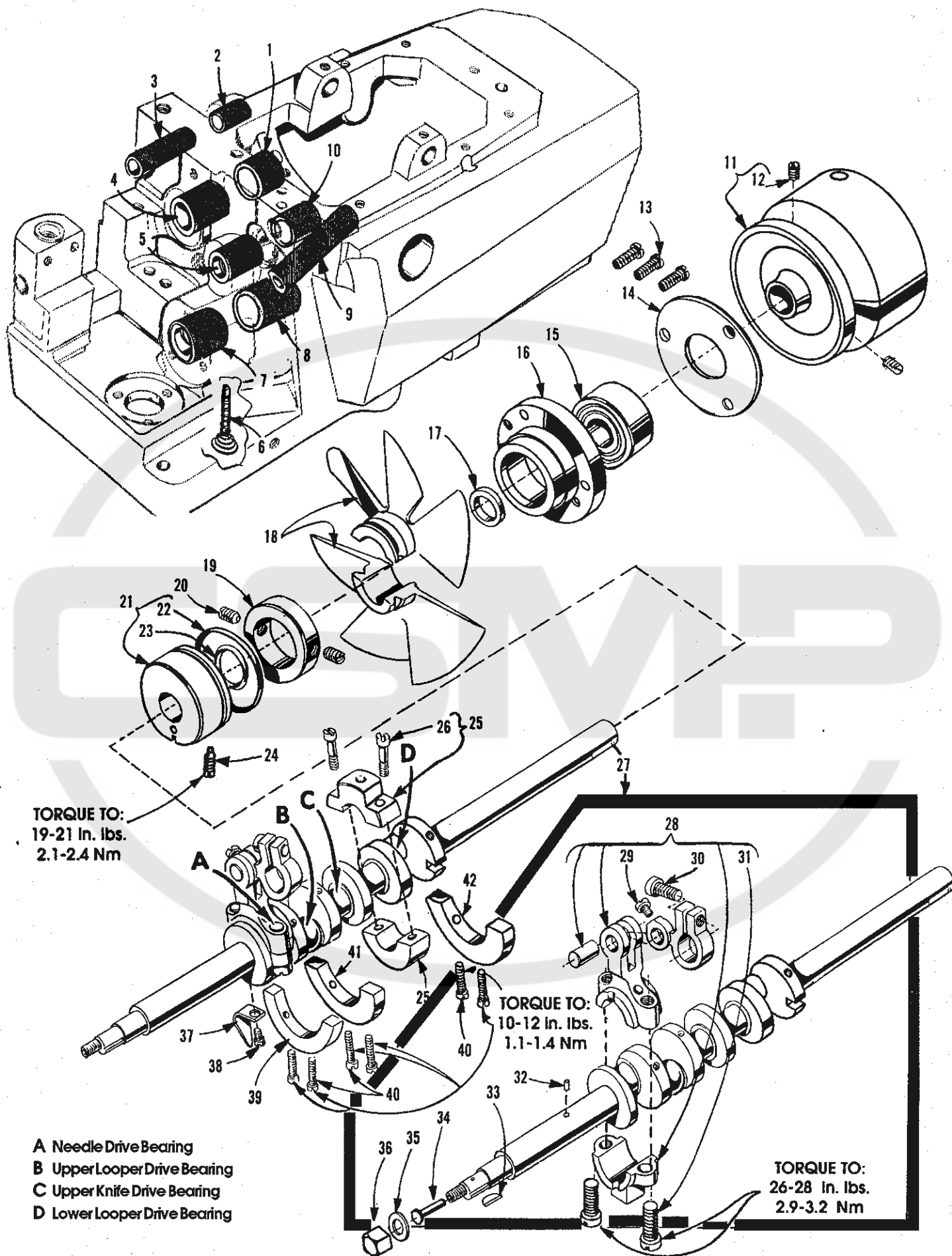
| Ref. No. | Part No.  | Description                                                                             | Amt. Req. |
|----------|-----------|-----------------------------------------------------------------------------------------|-----------|
| 1.       | 39557B    | Presser Spring Plunger Cap Nut .....                                                    | 1         |
| 2.       | 39557E    | Presser Spring Plunger Locking Nut .....                                                | 1         |
| 3.       | 39557C    | Presser Spring Plunger Adjusting Screw .....                                            | 1         |
| 4.       | 39557F    | Lock Nut .....                                                                          | 1         |
| 5.       | 39557     | Presser Spring .....                                                                    | 1         |
| 6.       | 39557A    | Presser Spring Plunger .....                                                            | 1         |
| 7.       | 39563F    | Top Cover Needle Thread Eyelet, for all Styles except 39500 RA, SF .....                | 1         |
| -        | 39563T    | Top Cover Needle Thread Eyelet, for Styles 39500 RA, SF .....                           | 1         |
| 8.       | 22569B    | Screw, for top cover needle thread eyelet .....                                         | 2         |
| 9.       | 39556A    | Presser Foot Release Bushing .....                                                      | 1         |
| 10.      | 39582AD   | Top Cover .....                                                                         | 1         |
| 11.      | 39582AF   | Oil Filler Cover .....                                                                  | 1         |
| 12.      | 39582V    | Spring .....                                                                            | 1         |
| 13.      | 39582AG   | Hinge Bracket .....                                                                     | 1         |
| 14.      | 51-103BLK | Hinge Pin .....                                                                         | 1         |
| 15.      | 39582W    | Oil Guard .....                                                                         | 1         |
| 16.      | 22562A    | Screw, for hinge bracket .....                                                          | 1         |
| 17.      | 39582BZ   | Top Cover Gasket .....                                                                  | 1         |
| 18.      | 22541     | Screw, for top cover .....                                                              | 8         |
| 19.      | 667D-8    | Dowel Pin .....                                                                         | 2         |
| 20.      | 22565S    | Spot Screw, for upper looper drive lever shaft .....                                    | 1         |
| 21.      | 39594R    | Oil Collector Plate .....                                                               | 1         |
| 22.      | 22569D    | Screw, for oil collector plate .....                                                    | 1         |
| 23.      | 22565     | Set Screw, for upper looper thread tube assembly & upper looper drive lever shaft ..... | 1         |
| 24.      | 22571E    | Magnetic Oil Drain Plug Screw .....                                                     | 1         |
| 25.      | 90        | Screw, for feed bar oil shield .....                                                    | 1         |
| 26.      | 39534R    | Feed Bar Oil Shield, for all Styles except 39500 CQA, CQB, CRF, CSRF .....              | 1         |
| 26A.     | 39534RB   | Feed Bar Oil Shield, for Styles 39500 CQA, CQB, CRF, CSRF .....                         | 1         |
| 27.      | 39501K    | Cloth Plate Stud, for all Styles .....                                                  | 1         |
| 28.      | 22569     | Screw, for cloth plate stud .....                                                       | 1         |
| 29.      | 22565F    | Screw, for feed adjusting pin .....                                                     | 1         |
| 30.      | 39578F    | Cloth Plate Fabric Guard, for Styles 39500 QA, QB, QP, RF, RS, SE, TE, SQB, SRF ....    | 1         |
| 31.      | 138       | Screw, for cloth plate fabric guard .....                                               | 2         |
| 32.      | 22657D-10 | Screw, for cloth plate .....                                                            | 1         |
| 33.      | 39501D    | Cloth Plate, for all Styles except 39500 SF, CQA, CQB, CRF, CSRF .....                  | 1         |
| 33A.     | 39501DB   | Cloth Plate, for Style 39500 SF .....                                                   | 1         |
| -        | 39501E    | Cloth Plate, for Style 39500 RR .....                                                   | 1         |
| 33B.     | G39501D   | Cloth Plate, for Styles 39500 CQA, CQB, CRF, CSRF .....                                 | 1         |
| 34.      | 39532A    | Cloth Plate Latch Spring, for all Styles except 39500 SF .....                          | 1         |
| 34A.     | 39532E    | Cloth Plate Latch Spring, for Style 39500 SF .....                                      | 1         |
| 35.      | 90        | Screw, for cloth plate latch spring .....                                               | 2         |

36. thru 81. See following page



# MAIN FRAME & MISCELLANEOUS COVERS

| Ref. No.                       | Part No.   | Description                                                                                                     | Amt. Req. |
|--------------------------------|------------|-----------------------------------------------------------------------------------------------------------------|-----------|
| 1. thru 35. See preceding page |            |                                                                                                                 |           |
| 36.                            | 39582FE    | Feed Mechanism Cover, for Styles 39500 RA, RR, SF .....                                                         | 1         |
| -                              | 39582FH    | Feed Mechanism Cover, for Styles 39500 CQA, CQB, CRF .....                                                      | 1         |
| 37.                            | 41071G     | Nut, for feed mechanism cover .....                                                                             | 1         |
| 38.                            | 86X        | Screw, for feed mechanism cover .....                                                                           | 1         |
| 39.                            | 39594H     | Felt Oil Strainer .....                                                                                         | 1         |
| 40.                            | 39594G     | Oil Filter Screen .....                                                                                         | 1         |
| 41.                            | 22760H     | Screw, for oil filter screen and strainer .....                                                                 | 2         |
| 42.                            | 29477MX    | Upper Looper Thread Tube Assembly .....                                                                         | 1         |
| 43.                            | 39568AN    | Thread Tube .....                                                                                               | 1         |
| 44.                            | 39568AP    | Collar .....                                                                                                    | 1         |
| 45.                            | 1096       | Screw .....                                                                                                     | 1         |
| 46.                            | 22743      | Set Screw .....                                                                                                 | 1         |
| 47.                            | 39568J     | Thread Tube Tension Spring .....                                                                                | 1         |
| 48.                            | 22569K     | Screw, for oil sight gauge .....                                                                                | 1         |
| 49.                            | 22894AE    | Screw, for lower looper driving lever shaft .....                                                               | 1         |
| 50.                            | 39593H     | Oil Sight Gauge .....                                                                                           | 1         |
| 51.                            | 660-243    | Oil Gauge Seal Ring .....                                                                                       | 1         |
| 52.                            | 39582F     | Bottom Cover Extension .....                                                                                    | 1         |
| 53.                            | 22653D-4   | Screw, for bottom cover extension .....                                                                         | 2         |
| 54.                            | 39582BM    | Base Plate .....                                                                                                | 1         |
| 55.                            | 22541B     | Screw, for base plate .....                                                                                     | 2         |
| 56.                            | 39595      | Isolator .....                                                                                                  | 2         |
| 57.                            | 39582BL    | Air Duct, outer .....                                                                                           | 1         |
| 58.                            | 22569D     | Screw, for outer air duct .....                                                                                 | 2         |
| 59.                            | 22586T     | Screw, for bottom cover .....                                                                                   | 1         |
| 60.                            | 22541B     | Screw, for bottom cover .....                                                                                   | 12        |
| 61.                            | 51295B     | Isolator .....                                                                                                  | 2         |
| 62.                            | 39582BW    | Bottom Cover .....                                                                                              | 1         |
| 63.                            | 39582BH    | Gasket, for bottom cover .....                                                                                  | 1         |
| 64.                            | 39593C     | Oil Gauge Float .....                                                                                           | 1         |
| 65.                            | 39593D     | Oil Gauge Indicator .....                                                                                       | 1         |
| 66.                            | 666-280    | Oil Tube .....                                                                                                  | 1         |
| 67.                            | RI-37      | Wire Ring .....                                                                                                 | 1         |
| 68.                            | 643-480BLK | Oil Tube .....                                                                                                  | 1         |
| 69.                            | 660-885    | Clamp .....                                                                                                     | 1         |
| 70.                            | 56393G     | Filter .....                                                                                                    | 1         |
| 71.                            | 56393V     | Spring .....                                                                                                    | 1         |
| 72.                            | 22569D     | Screw, for chip guard .....                                                                                     | 2         |
| 73.                            | 39593J     | Elbow Fitting .....                                                                                             | 1         |
| 74.                            | G39578T    | Chip Guard, for all Styles except 39500 QB 5/32, RA, RR, RF 5/32, CRF 5/32, SQB 5/32, SRF 5/32, CSRF 5/32 ..... | 1         |
| -                              | G39578TB   | Chip Guard, for Style 39500 RA .....                                                                            | 1         |
| -                              | 39578AH    | Chip Guard, for Styles 39500 QB 5/32, RF 5/32, CRF 5/32, SQB 5/32, SRF 5/32, CSRF 5/32 .....                    | 1         |
| -                              | G39578U    | Chip Guard, for Style 39500 RR .....                                                                            | 1         |
| 75.                            | 22804      | Screw, for lint shield .....                                                                                    | 1         |
| 76.                            | 41358      | Washer, for lint shield .....                                                                                   | 1         |
| 77.                            | 39582GJ    | Lint Shield, for all Styles except 39500 RA, RR, SF .....                                                       | 1         |
| 78.                            | 39582GL    | Side Cover, for all Styles except 39500 RA, RR, SF .....                                                        | 1         |
| 79.                            | 22569      | Screw, for tape guide .....                                                                                     | 2         |
| 80.                            | 69H        | Washer, for tape guide .....                                                                                    | 2         |
| 81.                            | 39599      | Tape Guide, for Styles 39500 RA, SF 1/8 .....                                                                   | 1         |



# CRANKSHAFT MECHANISM & BUSHINGS

| Ref. No. | Part No.  | Description                                                                                                 | Amt. Req. |
|----------|-----------|-------------------------------------------------------------------------------------------------------------|-----------|
| 1.       | 39573AA   | Upper Knife Driving Arm Bushing, right .....                                                                | 1         |
| 2.       | 39555R    | Foot Lifter Shaft Bushing, right .....                                                                      | 1         |
| 3.       | 39555P    | Foot Lifter Shaft Bushing, left .....                                                                       | 1         |
| 4.       | 39573K    | Upper Knife Driving Arm Bushing, left .....                                                                 | 1         |
| 5.       | 39552U    | Needle Driving Arm Crank Bushing, left .....                                                                | 1         |
| 6.       | 666-94    | Oil Wick and Spring .....                                                                                   | 1         |
| 7.       | 39590AB   | Crankshaft Bushing, left .....                                                                              | 1         |
| 8.       | 39590T    | Crankshaft Bushing, inner left .....                                                                        | 1         |
| 9.       | 39544Z    | Lower Looper Bar Bushing .....                                                                              | 1         |
| 10.      | 39552P    | Needle Driving Arm Crank Bushing, right .....                                                               | 1         |
| 11.      | 39521J    | Pulley .....                                                                                                | 1         |
| 12.      | 22650CD-4 | Screw .....                                                                                                 | 2         |
| 13.      | 22569B    | Screw, for crankshaft ball bearing retaining plate .....                                                    | 3         |
| 14.      | 39590H    | Crankshaft Ball Bearing Retaining Plate .....                                                               | 1         |
| 15.      | 660-835   | Crankshaft Ball Bearing .....                                                                               | 1         |
| 16.      | 39590G    | Crankshaft Ball Bearing Housing .....                                                                       | 1         |
| 17.      | 39590J    | Thrust Washer .....                                                                                         | 1         |
| 18.      | 39591L    | Crank Chamber Cooling Fan .....                                                                             | 1         |
| 19.      | 39591H    | Crank Chamber Cooling Fan Collar .....                                                                      | 1         |
| 20.      | 22894D    | Screw .....                                                                                                 | 2         |
| 21.      | 39590Y    | Crankshaft Bearing, inner right.....                                                                        | 1         |
| 22.      | 660-443   | Rubber "O" Ring .....                                                                                       | 1         |
| 23.      | 660-764   | Oil Seal .....                                                                                              | 1         |
| 24.      | 22565F    | Screw, for crankshaft bearing, inner right .....                                                            | 1         |
| 25.      | 39590AC   | Crankshaft Split Bearing .....                                                                              | 1         |
| 26.      | 97A       | Screw .....                                                                                                 | 2         |
| 27.      | 29477JM   | Crankshaft and Needle Driving Arm Crank Assembly, for Styles 39500 QA, QB, RS, SE, TE, CQA, CQB, SQB .....  | 1         |
| -        | 29477KE   | Crankshaft and Needle Driving Arm Crank Assembly, for Styles 39500 QP, RA, RF, RR, SF, CRF, SRF, CSRF ..... | 1         |
| 28.      | 29477MC   | Needle Driving Arm Crank and Connecting Rod Assembly .....                                                  | 1         |
| 29.      | 22768C    | Screw, for needle driving arm connecting rod pin .....                                                      | 1         |
| 30.      | 22596H    | Screw, for needle driving arm crank .....                                                                   | 2         |
| 31.      | 22729AB   | Screw, for needle driving arm connecting rod .....                                                          | 1         |
| 32.      | 51-228BLK | Vent Plug .....                                                                                             | 1         |
| 33.      | 39541A    | Feed Drive Eccentric Key .....                                                                              | 1         |
| 34.      | -----     | Metering Pin (refer to Chart A).....                                                                        | 1         |
| 35.      | 40-46     | Washer, for crankshaft .....                                                                                | 1         |
| 36.      | 39536FN   | Nut, for crankshaft .....                                                                                   | 1         |
| 37.      | 39594N    | Oil Splasher .....                                                                                          | 1         |
| 38.      | 22513C    | Screw, for oil splasher .....                                                                               | 1         |
| 39.      | 39591K    | Crankshaft Counterweight, left .....                                                                        | 1         |
| 40.      | 22747B    | Screw, for crankshaft counterweights.....                                                                   | 6         |
| 41.      | 39591A    | Crankshaft Counterweight, middle .....                                                                      | 1         |
| 42.      | 39591B    | Crankshaft Counterweight, right .....                                                                       | 1         |

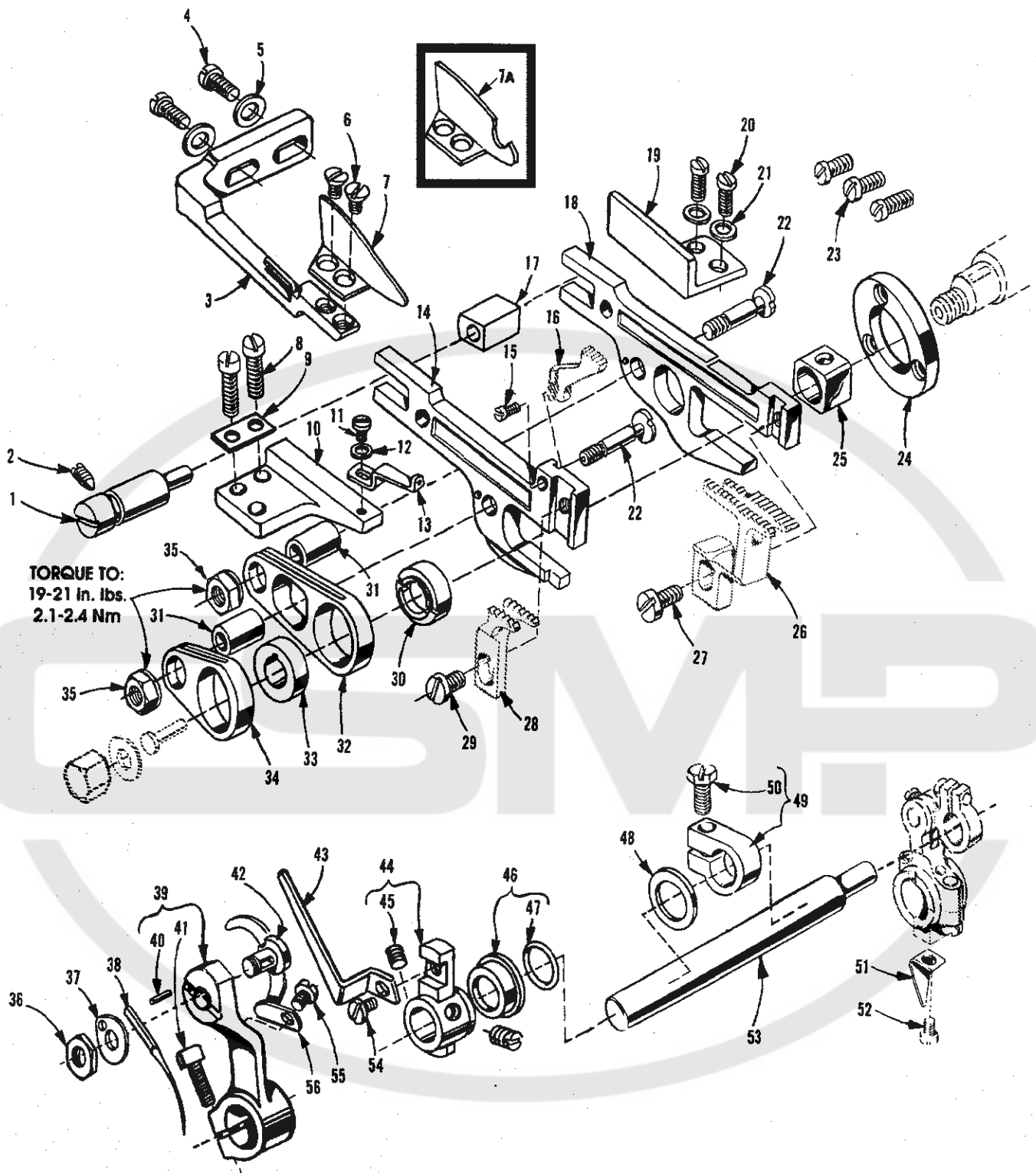
|             |             | Pin Diameter |             |
|-------------|-------------|--------------|-------------|
| Part Number | Color       | Inches       | Millimeters |
| 39593U123   | Violet      | .123         | 3.125       |
| 39593U1235  | Brown       | .1235        | 3.138       |
| 39593U124   | Orange      | .124         | 3.150       |
| 39593U1245  | White       | .1245        | 3.163       |
| 39593U125   | Green       | .125         | 3.175       |
| 39593U1255  | Lilac       | .1255        | 3.187       |
| 39593U126   | Yellow      | .1260        | 3.200       |
| 39593U1265  | Blue        | .1265        | 3.213       |
| 39593U127   | Black       | .1270        | 3.225       |
| 39593U1275  | Pink        | .1275        | 3.238       |
| 39593U128   | Light Blue  | .1280        | 3.251       |
| 39593U1285  | Dark Yellow | .1285        | 3.263       |
| 39593U129   | Red         | .1290        | 3.276       |

Chart A

\* Metering pins have been selected according to oil flow requirements. Each machine has been fitted with a pin that will provide approximately 10 to 15 milligrams of oil per minute for speeds from 7500 to 8000 RPM.

Recommended clearance between the metering pin and the crankshaft is .0005" to .001" for speeds above 7500 RPM. For speeds below 7500 RPM a .001" to .002" clearance is recommended.

Oil flow is determined by the sewing speed and machine usage. It may become desirable to either increase or decrease the amount of oil flow by changing the size of the metering pin. In most cases selecting a pin one size larger or one size smaller will provide the correct oil flow. Refer to Chart 'A'.



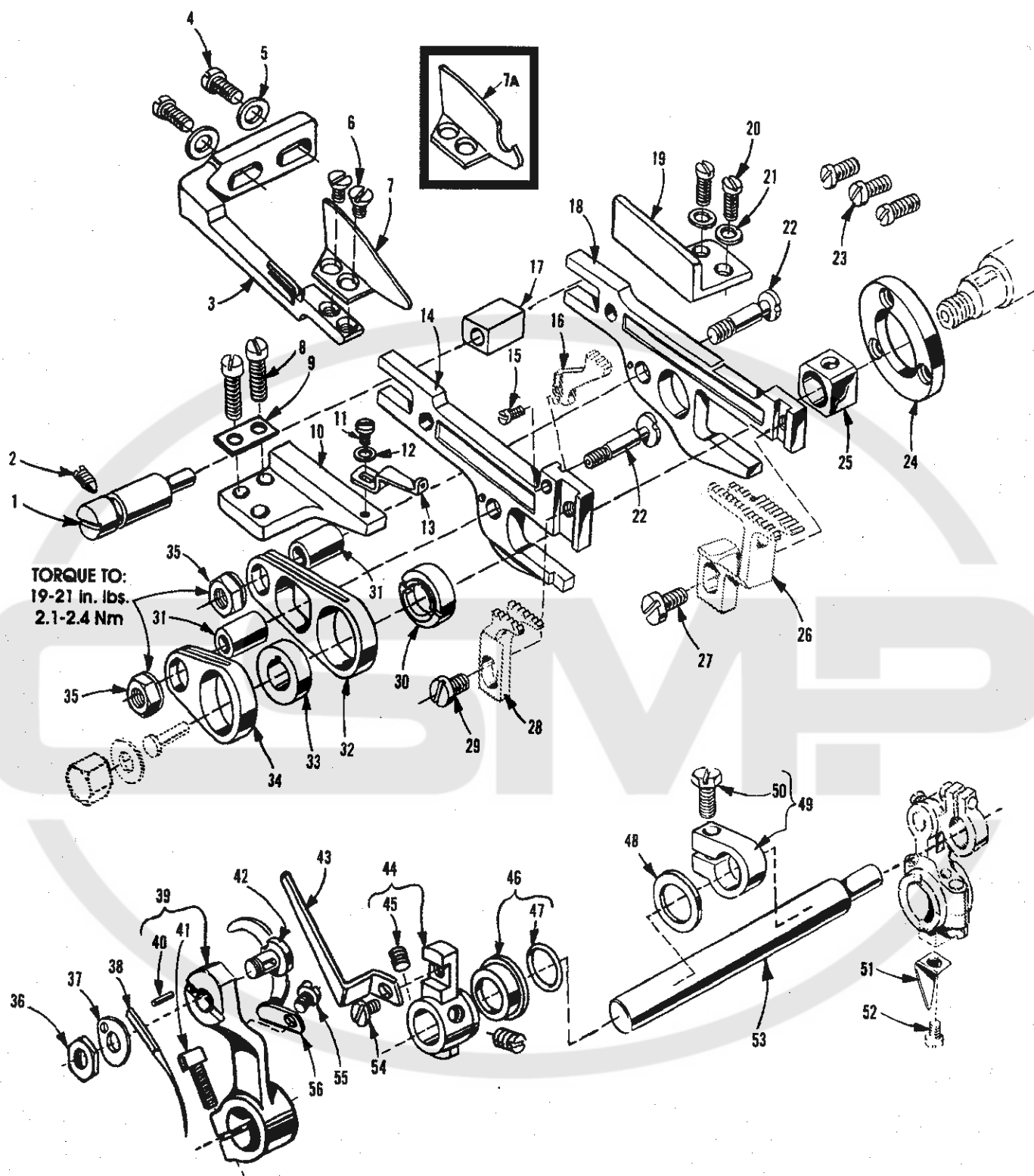
## FEED MECHANISM

| Ref. No. | Part No. | Description                                                                         | Amt. Req. |
|----------|----------|-------------------------------------------------------------------------------------|-----------|
| 1.       | 39535C   | Feed Adjusting Pin .....                                                            | 1         |
| 2.       | 22565F   | Screw, for feed adjusting pin .....                                                 | 1         |
| 3.       | 39578P   | Fabric Guard Mounting Bracket, for all Styles except 39500 CQA, CQB, CRF CSRF ..... | 1         |
| 4.       | 22569B   | Screw, for fabric guard mounting bracket .....                                      | 2         |
| 5.       | 8372A    | Washer, for mounting bracket screw .....                                            | 2         |
| 6.       | 87       | Screw, for 39578R fabric guard .....                                                | 2         |
| -        | 87B      | Screw, for G39578M fabric guard .....                                               | 2         |
| 7.       | 39578R   | Fabric Guard, for Styles 39500 QA, QB, QP, RA, RF, RR, RS, SE, SF .....             | 1         |
| 7A.      | G39578M  | Fabric Guard, for Styles TE, SQB, SRF .....                                         | 1         |
| 8.       | 22541B   | Screw, for main feed bar guide, left .....                                          | 2         |
| 9.       | 39835G   | Plate Washer, for 22541B .....                                                      | 1         |
| 10.      | 39535W   | Main Feed Bar Guide, left .....                                                     | 1         |
| 11.      | 87U      | Screw, for lower looper eyelet .....                                                | 1         |
| 12.      | 41358    | Washer, for lower looper eyelet .....                                               | 1         |
| 13.      | 39568E   | Eyelet, lower looper, for Styles 39500 CQA, CQB, CRF, CSRF .....                    | 1         |
| 14.      | 39534    | Main Feed Bar, for all Styles except 39500 SF .....                                 | 1         |
| -        | 39534C   | Main Feed Bar, for Style 39500 SF .....                                             | 1         |
| 15.      | 22797A   | Screw, for chaining feed dog .....                                                  | 1         |
| 16.      | -----    | Chaining Feed Dog, see pages 27, 29, 31 .....                                       | 1         |
| 17.      | 39535J   | Feed Bar Guide Block .....                                                          | 1         |
| 18.      | 39534G   | Differential Feed Bar .....                                                         | 1         |
| 19.      | 39535D   | Differential Feed Bar Guide, right .....                                            | 1         |
| 20.      | 22541B   | Screw, for differential feed bar guide, right .....                                 | 2         |
| 21.      | 8372A    | Washer, for 22569B .....                                                            | 2         |
| 22.      | 39536B   | Feed Bar Driving Stud .....                                                         | 2         |
| 23.      | 22569G   | Screw, for thrust washer .....                                                      | 3         |
| 24.      | 39534AF  | Differential Feed Bar Thrust Washer .....                                           | 1         |
| 25.      | 39538    | Feed Lift Block .....                                                               | 1         |
| 26.      | -----    | Differential Feed Dog, see pages 27, 29, 31 .....                                   | 1         |
| 27.      | 93A      | Screw, for main feed dog .....                                                      | 1         |
| 28.      | -----    | Main Feed Dog, see pages 27, 29, 31 .....                                           | 1         |
| 29.      | 22528    | Screw, for differential feed dog .....                                              | 1         |
| 30.      | -----    | Differential Feed Driving Eccentric (refer to Chart B) .....                        | 1         |
| 31.      | 39536C   | Feed Bar Driving Stud Bushing .....                                                 | 2         |
| 32.      | 39536AE  | Differential Feed Bar Driving Connection .....                                      | 1         |
| 33.      | -----    | Main Feed Driving Eccentric (refer to Chart B) .....                                | 1         |
| 34.      | 39536AF  | Main Feed Bar Driving Connection .....                                              | 1         |
| 35.      | 39536E   | Nut, for feed bar driving stud .....                                                | 2         |

36. thru 56. See following page

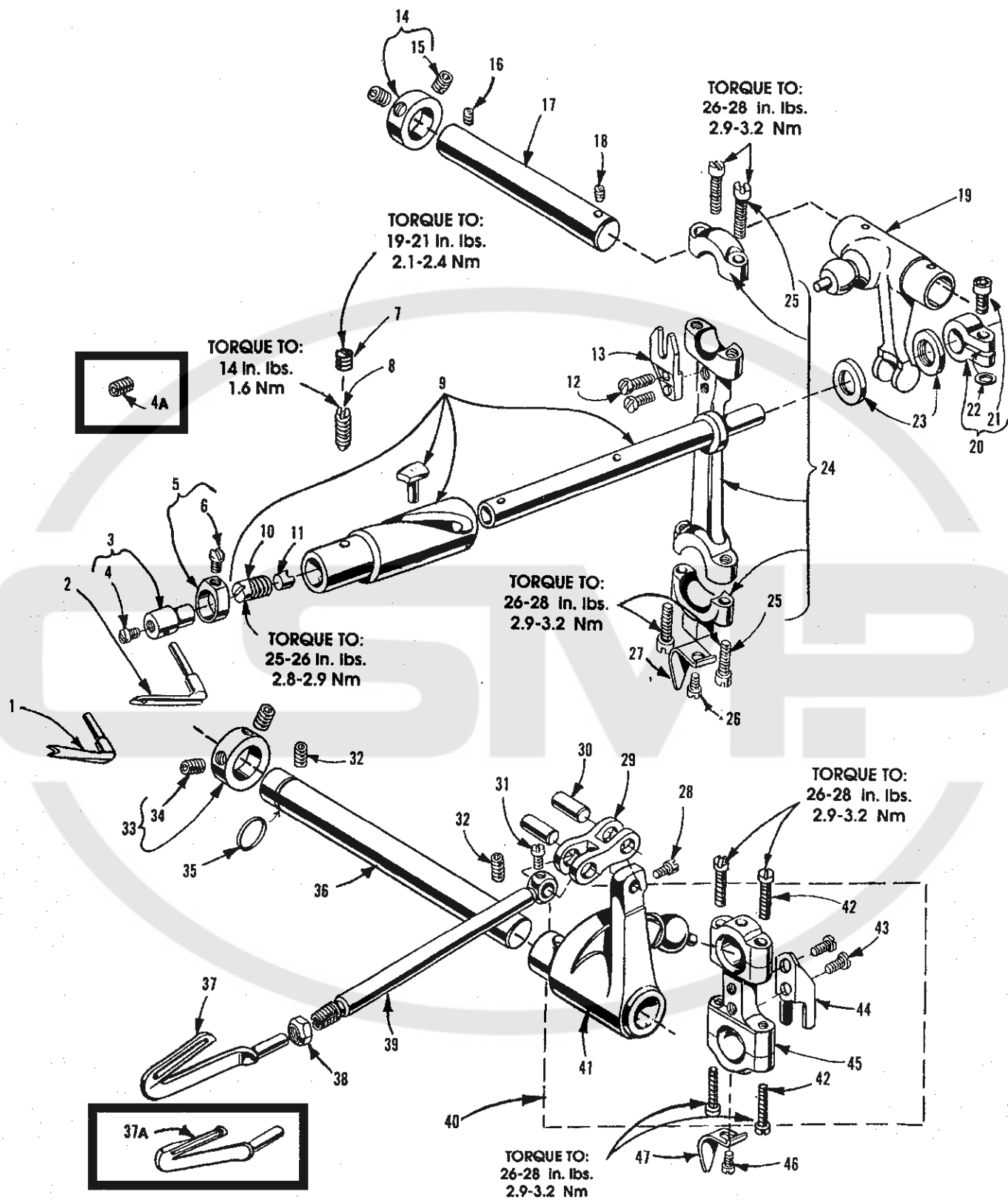
| Machine Style                                  | Reference Number 30<br>Differential Feed Driving Eccentric | Reference Number 33<br>Main Feed Driving Eccentric |
|------------------------------------------------|------------------------------------------------------------|----------------------------------------------------|
| 39500 QA, CQA                                  | 39540 B-12                                                 | 39540 B-10                                         |
| 39500 QB, QP, RF, TE, CQB, CRF, SQB, SRF, CSRF | 39540 B-10                                                 | 39540 B-12                                         |
| 39500 RA                                       | 39540 B-6                                                  | 39540 B-10                                         |
| 39500 RR                                       | 39540 B-18                                                 | 39540 B-20                                         |
| 39500 RS                                       | 39540 B-14                                                 | 39540 B-14                                         |
| 39500 SE                                       | 39540 B-12                                                 | 39540 B-9                                          |
| 39500 SF                                       | 39540 B-4                                                  | 39540 B-10                                         |

Chart B



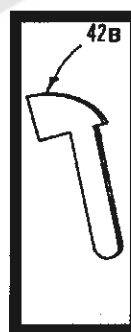
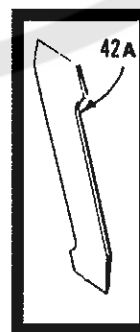
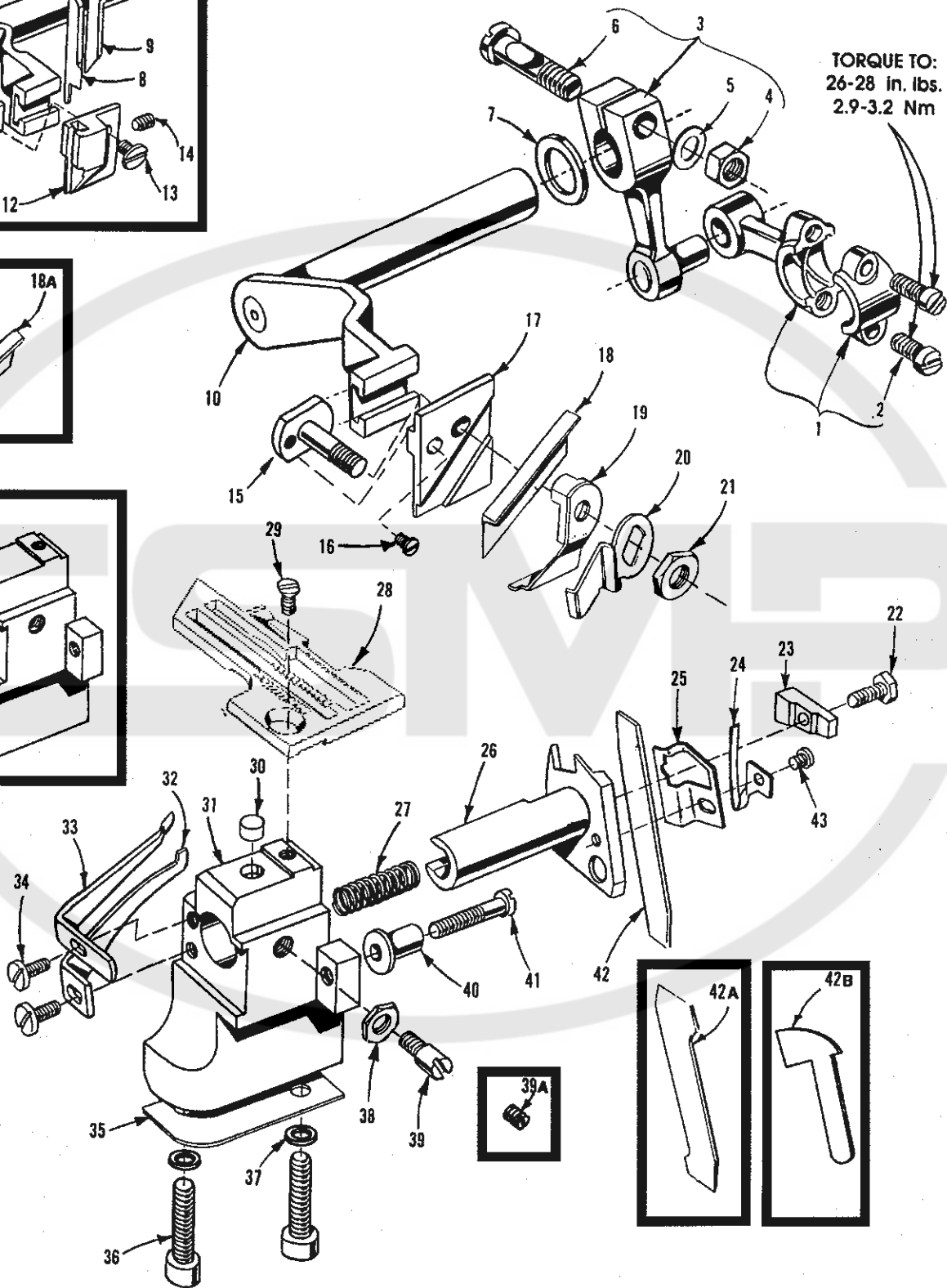
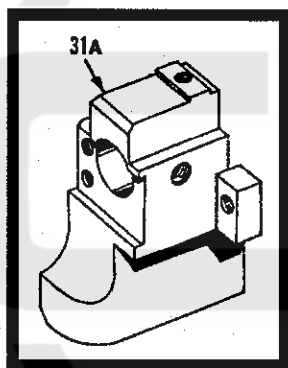
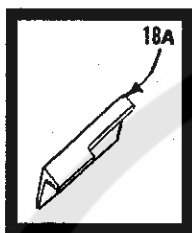
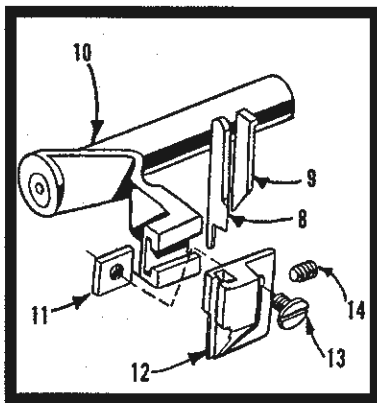
# NEEDLE DRIVING PARTS

| Ref. No.                       | Part No.    | Description                                                                     | Amt. Req. |
|--------------------------------|-------------|---------------------------------------------------------------------------------|-----------|
| 1. thru 35. See preceding page |             |                                                                                 |           |
| 36.                            | 14077A      | Nut, for needle clamp stud .....                                                | 1         |
| 37.                            | 39551H      | Needle Clamp Washer .....                                                       | 1         |
| 38.                            | -----       | Needle, see page 7 for the needle used on each specific Style .....             | 1         |
| 39.                            | 39552Z      | Needle Driving Arm, marked "K" for all Styles except 39500 SQB, SRF, CSRF ..... | 1         |
| -                              | 39552AJ     | Needle Driving Arm, marked "S", for Styles 39500 SQB, SRF, CSRF .....           | 1         |
| 40.                            | 39552AD     | Stop Pin .....                                                                  | 1         |
| 41.                            | 22596H      | Screw .....                                                                     | 1         |
| 42.                            | 39551J      | Needle Clamp Stud .....                                                         | 1         |
| 43.                            | 39568AM     | Looper Thread Pull-off .....                                                    | 1         |
| 44.                            | 39568AC     | Looper Thread Pull-off Lever .....                                              | 1         |
| 45.                            | 88B         | Screw .....                                                                     | 2         |
| 46.                            | 39552AG     | Oil Seal, for needle driving shaft .....                                        | 1         |
| 47.                            | 660-207     | Oil Seal Ring .....                                                             | 1         |
| 48.                            | C50043H-029 | Washer .....                                                                    | 1         |
| 49.                            | 39543Y      | Needle Drive Shaft Thrust Collar .....                                          | 1         |
| 50.                            | 22782A      | Screw .....                                                                     | 1         |
| 51.                            | 39594N      | Oil Splasher .....                                                              | 1         |
| 52.                            | 22513C      | Screw, for oil splasher .....                                                   | 1         |
| 53.                            | 39552R      | Needle Driving Shaft .....                                                      | 1         |
| 54.                            | 22513D      | Screw, for looper thread pull-off .....                                         | 1         |
| 55.                            | 87C         | Screw, for needle thread cam pull-off .....                                     | 1         |
| 56.                            | 39563G      | Needle Thread Cam Pull-off .....                                                | 1         |



# UPPER & LOWER LOOPER DRIVING PARTS

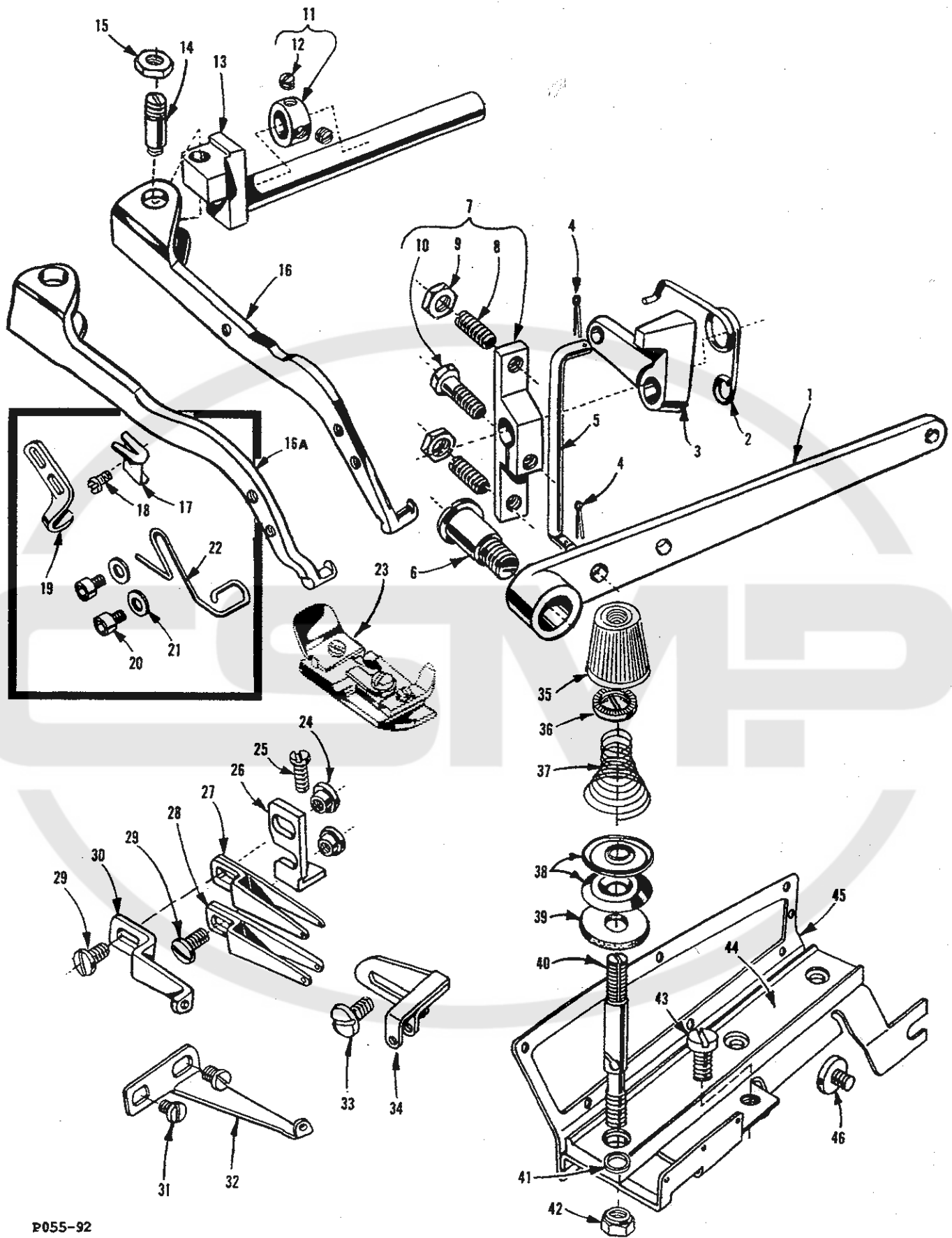
| Ref. No. | Part No. | Description                                                    | Amt. Req. |
|----------|----------|----------------------------------------------------------------|-----------|
| 1.       | 39560A   | Upper Spreader, for Style 39500 RR (503 stitch) .....          | 1         |
| 2.       | 39508A   | Upper Looper, for all Styles except 39500 RA, SF, TE .....     | 1         |
| -        | 39508E   | Upper Looper, for Styles 39500 RA, SF .....                    | 1         |
| -        | G39508A  | Upper Looper, for Style 39500 TE .....                         | 1         |
| 3.       | 39543    | Upper Looper Holder .....                                      | 1         |
| 4.       | 22564G   | Screw .....                                                    | 1         |
| 4A.      | 22894Y   | Set Screw, for looper and spreader on Style 39500 RR .....     | 1         |
| 5.       | 39543A   | Upper Looper Holder Collar .....                               | 1         |
| 6.       | 77       | Screw .....                                                    | 1         |
| 7.       | 102L     | Lock Screw, for 22565H .....                                   | 1         |
| 8.       | 22565H   | Spot Screw, for bushing and cam guide .....                    | 1         |
| 9.       | 29126EC  | Upper Looper Drive Shaft Assembly .....                        | 1         |
| 10.      | 22503F   | Screw .....                                                    | 1         |
| 11.      | 39543E   | Cam Follower Locking Clamp .....                               | 1         |
| 12.      | 97       | Screw, for ball joint guide fork .....                         | 2         |
| 13.      | 39544J   | Ball Joint Guide Fork, for upper looper drive lever .....      | 1         |
| 14.      | 482C     | Upper Looper Shaft Collar .....                                | 1         |
| 15.      | 22894C   | Set Screw .....                                                | 2         |
| 16.      | 22565    | Set Screw, for upper looper rocker shaft .....                 | 1         |
| 17.      | 39543X   | Upper Looper Drive Lever Shaft .....                           | 1         |
| 18.      | 22565S   | Spot Screw, for upper looper drive lever shaft .....           | 1         |
| 19.      | 39543W   | Upper Looper Drive Lever .....                                 | 1         |
| 20.      | 39543AT  | Clamp Collar, for upper looper drive shaft .....               | 1         |
| 21.      | 22875M   | Screw (metric) .....                                           | 1         |
| 22.      | 39543AU  | Washer, for clamp collar .....                                 | 1         |
| 23.      | 39543P   | Upper Looper Drive Shaft Thrust Washer .....                   | 2         |
| 24.      | 39543AV  | Upper Looper Drive Lever Connecting Rod .....                  | 1         |
| 25.      | 22729AB  | Screw .....                                                    | 4         |
| 26.      | 22513C   | Screw, for oil splasher .....                                  | 1         |
| 27.      | 39543N   | Oil Splasher .....                                             | 1         |
| 28.      | 77       | Screw, for lower looper bar connecting link pin .....          | 1         |
| 29.      | 39544B   | Lower Looper Bar Connecting Link .....                         | 1         |
| 30.      | 39544D   | Lower Looper Bar Connecting Link Pin .....                     | 2         |
| 31.      | 77       | Screw, for lower looper bar connecting link pin .....          | 1         |
| 32.      | 22894AE  | Set Screw, for lower looper driving shaft .....                | 2         |
| 33.      | 482C     | Lower Looper Driving Shaft Collar .....                        | 1         |
| 34.      | 22894C   | Set Screw .....                                                | 2         |
| 35.      | 660-206  | Rubber "O" Ring, for lower looper driving shaft .....          | 1         |
| 36.      | 39544V   | Lower Looper Driving Shaft .....                               | 1         |
| 37.      | 39508B   | Lower Looper, all Styles except 39500 RA, SF .....             | 1         |
| 37A.     | 39508D   | Lower Looper, for Styles 39500 RA, SF .....                    | 1         |
| 38.      | 39151    | Nut, for lower looper bar .....                                | 1         |
| 39.      | 39544    | Lower Looper Bar .....                                         | 1         |
| 40.      | 29126DF  | Lower Looper Bar Driving Lever & Connecting Rod Assembly ..... | 1         |
| 41.      | 39544U   | Lower Looper Bar Driving Lever .....                           | 1         |
| 42.      | 22729AB  | Screw .....                                                    | 4         |
| 43.      | 97       | Screw .....                                                    | 2         |
| 44.      | 39544S   | Ball Joint Guide Fork .....                                    | 1         |
| 45.      | 39544AA  | Lower Looper Drive Lever Connecting Rod .....                  | 1         |
| 46.      | 22513C   | Screw, for oil splasher .....                                  | 1         |
| 47.      | 39594N   | Oil Splasher .....                                             | 1         |



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# UPPER & LOWER KNIFE PARTS

| Ref. No. | Part No.  | Description                                                                                | Amt. Req. |
|----------|-----------|--------------------------------------------------------------------------------------------|-----------|
| 1.       | 39573AE   | Upper Knife Driving Connecting Rod .....                                                   | 1         |
| 2.       | 22729AB   | Screw .....                                                                                | 2         |
| 3.       | 39573E    | Upper Knife Driving Lever .....                                                            | 1         |
| 4.       | 55235E    | Nut .....                                                                                  | 1         |
| 5.       | 6042A     | Washer .....                                                                               | 1         |
| 6.       | 55235D    | Locking Stud .....                                                                         | 1         |
| 7.       | 39573A    | Washer, for upper knife driving arm .....                                                  | 1         |
| 8.       | 39270E    | Upper Knife, for Style 39500 SF .....                                                      | 1         |
| 9.       | 39571E    | Upper Knife Clamp Bar, for Style 39500 SF .....                                            | 1         |
| 10.      | 39573H    | Upper Knife Driving Arm .....                                                              | 1         |
| 11.      | 39571A    | Upper Knife Clamp Nut, for Style 39500 SF .....                                            | 1         |
| 12.      | 39572B    | Upper Knife Holder Block, for Style 39500 SF .....                                         | 1         |
| 13.      | 22829     | Screw, for upper knife holder block, Style 39500 SF .....                                  | 1         |
| 14.      | 22650CB-4 | Set Screw, for upper knife, Style 39500 SF .....                                           | 1         |
| 15.      | 39571D    | Upper Knife Clamp Stud, for all Styles except 39500 RR, SF .....                           | 1         |
| -        | 39571C    | Upper Knife Clamp Stud, for Style 39500 RR .....                                           | 1         |
| 16.      | 22738     | Screw, for 39571C and 39571D clamp stud .....                                              | 1         |
| 17.      | 39572     | Upper Knife Holder Block, for all Styles except 39500 RR, SF .....                         | 1         |
| -        | 39572A    | Upper Knife Holder Block, for Style 39500 RR .....                                         | 1         |
| 18.      | 39570     | Upper Knife, for all Styles except 39500 RA, SF .....                                      | 1         |
| 18A.     | 39570K    | Upper Knife, for Style 39500 RA .....                                                      | 1         |
| 19.      | 39571F    | Upper Knife Clamp, for all Styles except 39500 SF .....                                    | 1         |
| 20.      | 39571B    | Upper Knife Chain Guard, for all Styles except 39500 SF .....                              | 1         |
| 21.      | 14077     | Nut, for 39571C and 39571D clamp stud .....                                                | 1         |
| 22.      | 22588J    | Screw, for lower knife clamp .....                                                         | 1         |
| 23.      | 39550AD   | Lower Knife Clamp .....                                                                    | 1         |
| 24.      | 39550AE   | Lower Knife Clamp Spring .....                                                             | 1         |
| 25.      | 39550AC   | Lower Knife Guide Plate .....                                                              | 1         |
| 26.      | 39550AF   | Lower Knife Holder .....                                                                   | 1         |
| 27.      | 39550E    | Lower Knife Holder Spring .....                                                            | 1         |
| 28.      | -----     | Throat Plate, see pages 27, 29, 31 .....                                                   | 1         |
| 29.      | 22524     | Screw, for throat plate .....                                                              | 1         |
| 30.      | 39880N    | Rubber Bumper, for 39580A .....                                                            | 1         |
| 31.      | 39580A    | Throat Plate and Lower Knife Support Bracket, for all Styles except 39500 RA, RR, SF ..... | 1         |
| 31A.     | 39580AD   | Throat Plate and Lower Support Bracket, for Styles 39500 RA, RR, SF .....                  | 1         |
| 32.      | 39525R    | Front Needle Guard, for all Styles except 39500 SF .....                                   | 1         |
| -        | 39525L    | Front Needle Guard, for Style 39500 SF .....                                               | 1         |
| 33.      | GA39525N  | Rear Needle Guard, for Styles 39500 QA, QB, QP, CQA, CQB .....                             | 1         |
| -        | 39525A    | Rear Needle Guard, for Styles 39500 RA, RF, RR, RS, SE, SF, TE, CRF .....                  | 1         |
| -        | 39525P    | Rear Needle Guard, for Styles 39500 SQB, SRF, CSRF .....                                   | 1         |
| 34.      | 22585A    | Screw, for needle guards .....                                                             | 2         |
| 35.      | 39580E    | Shim, for Style 39500 SE 1/8 only .....                                                    | 1         |
| 36.      | 22653B-12 | Screw, for 39580A and 39580AD .....                                                        | 2         |
| 37.      | 39580F    | Washer, for 22653B-12 .....                                                                | 2         |
| 38.      | 14077     | Nut, for 22892B .....                                                                      | 1         |
| 39.      | 22892B    | Locking Screw, for lower knife holder, for all Styles except 39500 SF .....                | 1         |
| 39A.     | 88B       | Locking Screw, for lower knife holder, for Style 39500 SF .....                            | 1         |
| 40.      | 39550C    | Lower Knife Holder Locking Stud .....                                                      | 1         |
| 41.      | 22729B    | Screw, for lower knife holder locking stud .....                                           | 1         |
| 42.      | 39549     | Lower Knife, for all Styles except 39500 RA, SF .....                                      | 1         |
| 42A.     | 39549J    | Lower Knife, for Styles 39500 RA, SF .....                                                 | 1         |
| 42B.     | 39503H    | Front Fabric Guide, for Style 39500 RR .....                                               | 1         |
| 43.      | 605A      | Screw, for clamp spring .....                                                              | 1         |

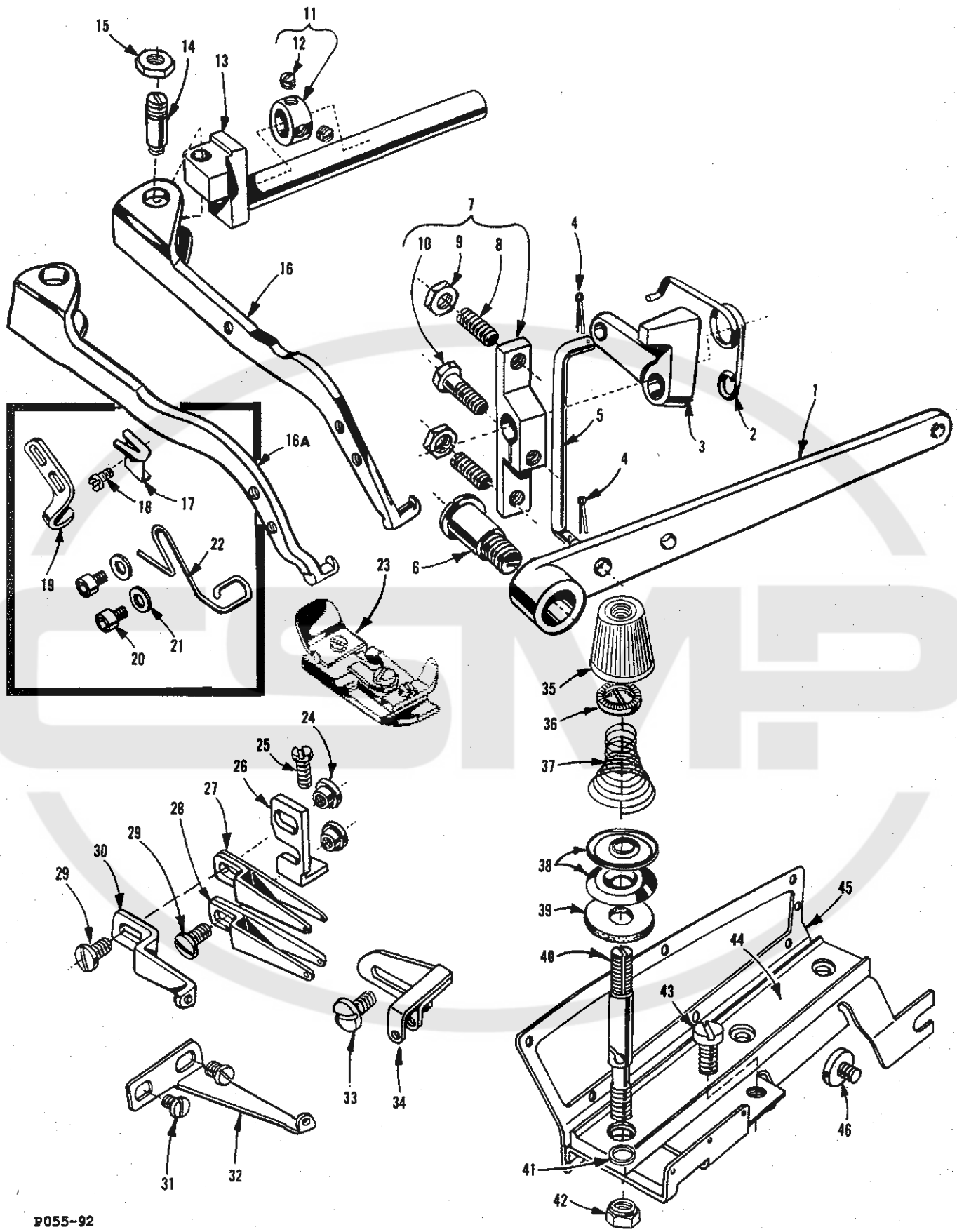


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# **FOOT LIFTER, CHAIN CUTTING KNIFE & MISCELLANEOUS EYELETS**

| Ref. No. | Part No. | Description                                                              | Amt. Req. |
|----------|----------|--------------------------------------------------------------------------|-----------|
| 1.       | 39855    | Foot Lifter Lever .....                                                  | 1         |
| 2.       | 39555B   | Foot Lifter Lever Spring .....                                           | 1         |
| 3.       | 39555D   | Foot Lifter Intermediate Lever .....                                     | 1         |
| 4.       | 660-142  | Colter Pin, for foot lifter lever connecting link .....                  | 2         |
| 5.       | 39555F   | Foot Lifter Lever Connecting Link .....                                  | 1         |
| 6.       | 22566B   | Screw, for foot lifter lever .....                                       | 1         |
| 7.       | 39555C   | Foot Lifter Lever Arm .....                                              | 1         |
| 8.       | 22597E   | Set Screw .....                                                          | 2         |
| 9.       | 12538    | Lock Nut .....                                                           | 2         |
| 10.      | 627      | Screw .....                                                              | 1         |
| 11.      | 12865    | Foot Lifter Lever Shaft Thrust Collar .....                              | 1         |
| 12.      | 88       | Screw .....                                                              | 2         |
| 13.      | 39555AA  | Foot Lifter Lever Shaft .....                                            | 1         |
| 14.      | 22791H   | Screw Pin, for presser arm .....                                         | 1         |
| 15.      | 258A     | Nut, for presser arm screw pin .....                                     | 1         |
| 16.      | 39556F   | Presser Arm, for all Styles except 39500 SE .....                        | 1         |
| 16A.     | 39556J   | Presser Arm, for Style 39500 SE .....                                    | 1         |
| 17.      | 39556K   | Chain Cutting Knife, for Style 39500 RR .....                            | 1         |
| 18.      | 22704    | Screw, for chain cutting knife .....                                     | 1         |
| 19.      | 39556H   | Presser Foot Hold Down Plate, for Style 39500 RR .....                   | 1         |
| 20.      | 99359    | Screw, for finger guard, all Styles except 39500 RR, RS .....            | 2         |
| -        | 99360    | Screw, for finger guard, on Styles 39500 RR, RS .....                    | 2         |
| 21.      | 95956    | Washer, for finger guard screw, all Styles .....                         | 2         |
| 22.      | 99682L   | Finger Guard .....                                                       | 1         |
| 23.      | -----    | Presser Foot, see pages 27, 29, 31 .....                                 | 1         |
| 24.      | 43139A   | Nut, for looper thread eyelet screws .....                               | 2         |
| 25.      | 22569B   | Screw, for looper thread eyelet mounting bracket .....                   | 1         |
| 26.      | 39568D   | Looper Thread Eyelet Mounting Bracket .....                              | 1         |
| 27.      | 39568L   | Upper Looper Thread Eyelet, for all Styles except 39500 RA, SF .....     | 1         |
| -        | 39568T   | Upper Looper Thread Eyelet, for Styles 39500 RA, SF .....                | 1         |
| 28.      | 39568B   | Lower Looper Thread Eyelet, for all Styles except 39500 RA, SF .....     | 1         |
| -        | 39568S   | Lower Looper Thread Eyelet, for Styles 39500 RA, SF .....                | 1         |
| 29.      | 93A      | Screw, for lower, upper and auxiliary looper thread eyelets .....        | 2         |
| 30.      | 39568E   | Auxiliary Looper Thread Eyelet, for all Styles except 39500 RA, SF ..... | 1         |
| -        | 39568U   | Auxiliary Looper Thread Eyelet, for Styles 39500 RA, SF .....            | 1         |
| 31.      | 73X      | Screw, for 39568W .....                                                  | 2         |
| 32.      | 39568W   | CQB, CRF, CSRF .....                                                     | 1         |
| 33.      | 22569D   | Screw, for needle thread eyelet .....                                    | 1         |
| 34.      | 39563H   | Needle Thread Eyelet, for all Styles except 39500 RA, SF .....           | 1         |
| -        | 39563U   | Needle Thread Eyelet, for Styles 39500 RA, SF .....                      | 1         |

35. thru 46. See following page



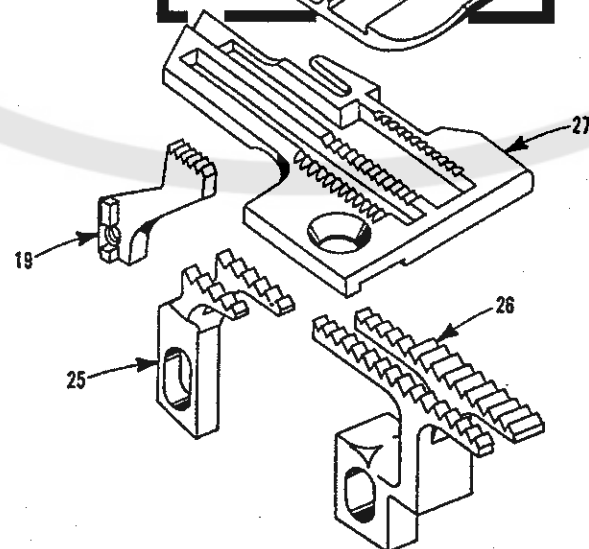
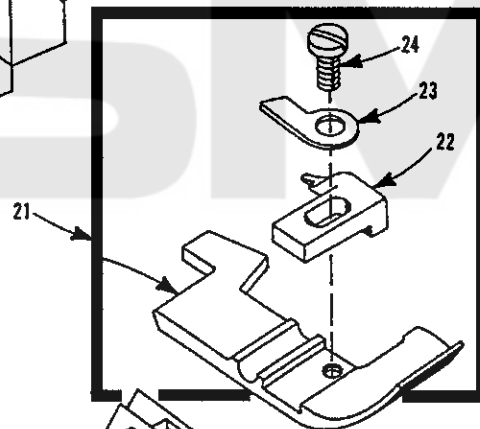
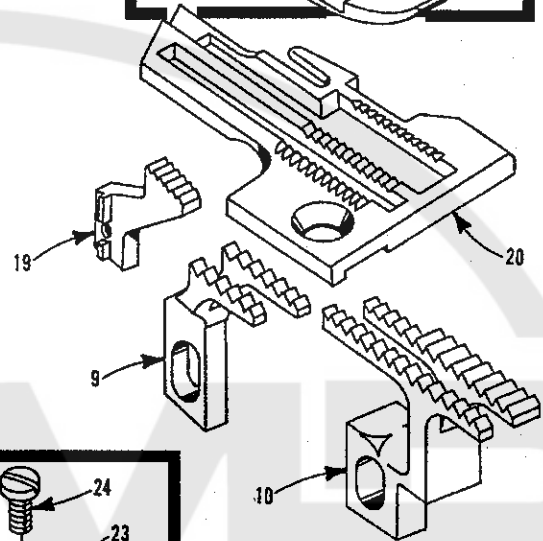
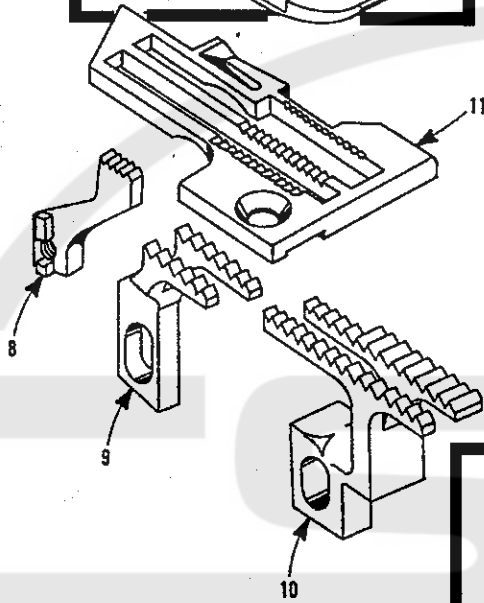
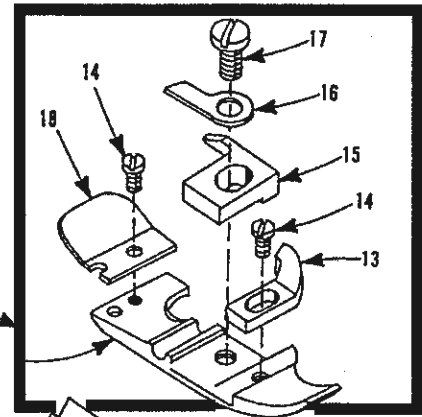
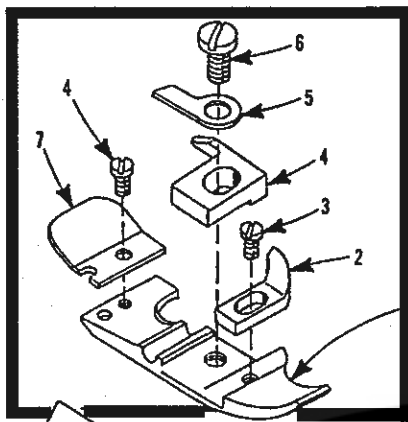
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## THREAD TENSION PARTS

| Ref. No.                       | Part No.  | Description                                      | Amt. Req. |
|--------------------------------|-----------|--------------------------------------------------|-----------|
| 1. thru 34. See preceding page |           |                                                  |           |
| 35.                            | 39592Z    | Tension Nut .....                                | 3         |
| 36.                            | 39592AK   | Tension Ferrule .....                            | 3         |
| 37.                            | -----     | Thread Tension Springs, (refer to Chart C) ..... | -         |
| 38.                            | 39592AD   | Thread Tension Disc .....                        | 6         |
| 39.                            | 39592AF   | Tension Disc Felt .....                          | 3         |
| 40.                            | 39592AL   | Tension Post .....                               | 3         |
| 41.                            | 8372A     | Washer .....                                     | 3         |
| 42.                            | 39592AH   | Locating Nut, for tension post .....             | 3         |
| 43.                            | 22806A    | Screw, for tension mounting bracket .....        | 1         |
| 44.                            | 39592AM   | Tension Post Bar .....                           | 1         |
| 45.                            | 39592AG-3 | Tension Post Mounting Bracket .....              | 1         |
| 46.                            | 22847B    | Screw, for tension post mounting bracket .....   | 1         |

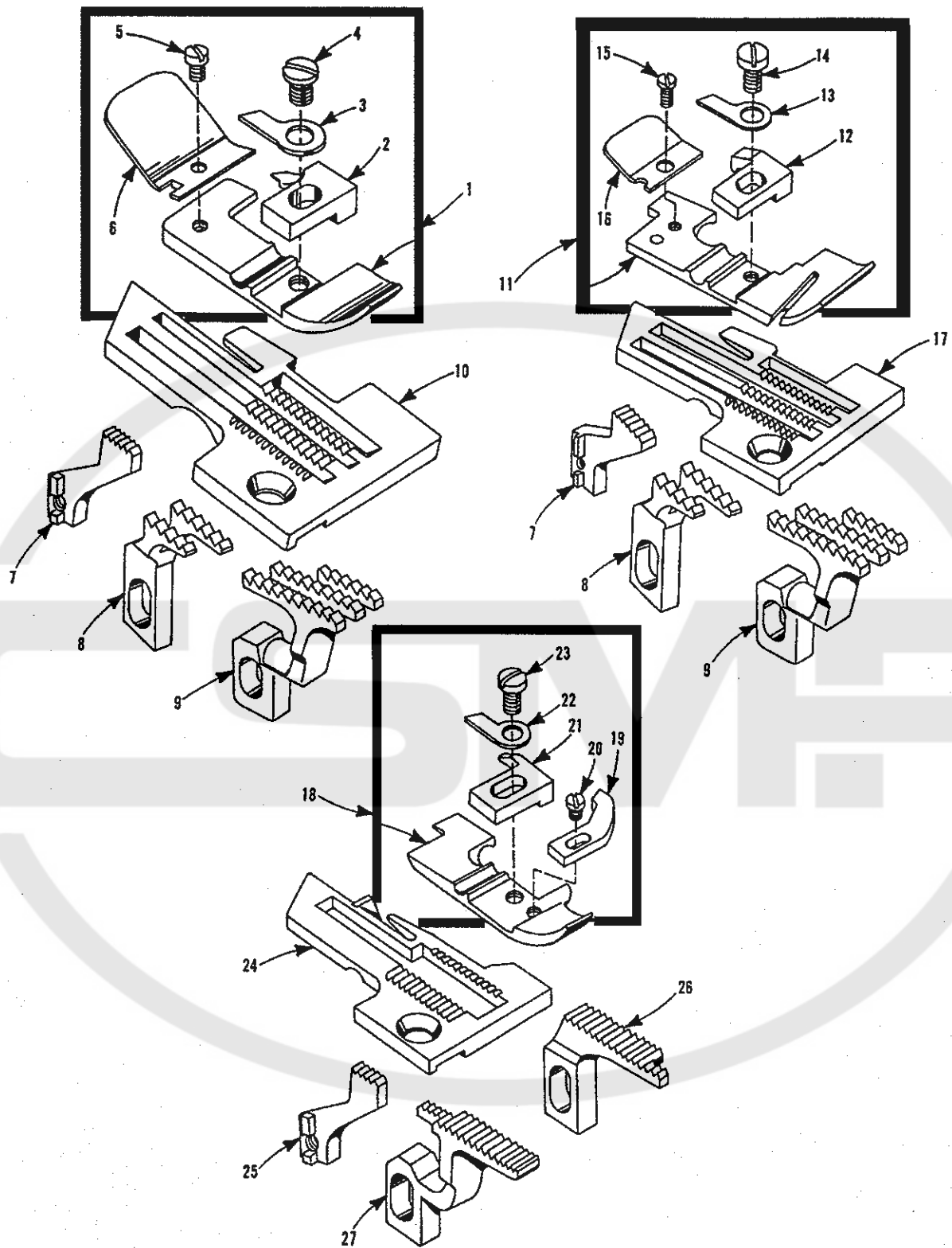
| Machine Style                                               | Upper Looper Spring | Needle Spring            | Lower Looper Spring      | Stitch Type |
|-------------------------------------------------------------|---------------------|--------------------------|--------------------------|-------------|
| 39500 QA, QB, QP, RF, SE, TE, CQA, CQB, CRF, SQB, SRF, CSRF | 39592 AR-5          | 39592 AR-8               | 39592 AR-5               | 504         |
| 39500 RA                                                    | 39592 AR-4          | 39592 AR-8               | 39592 AR-4               | 504         |
| 39500 RR                                                    | 39592 AR-2          | 39592 AR-1<br>39592 AR-2 | 39592 AR-8<br>39592 AR-8 | 505<br>503  |
| 39500 RS                                                    | 39592 AR-4          | 39592 AR-4               | 39592 AR-4               | 504         |
| 39500 SF                                                    | 39592 AR-4          | 39592 AR-8               | 39592 AR-4               | 504         |

Chart C



# FEED DOGS, THROAT PLATE & PRESSER FEET

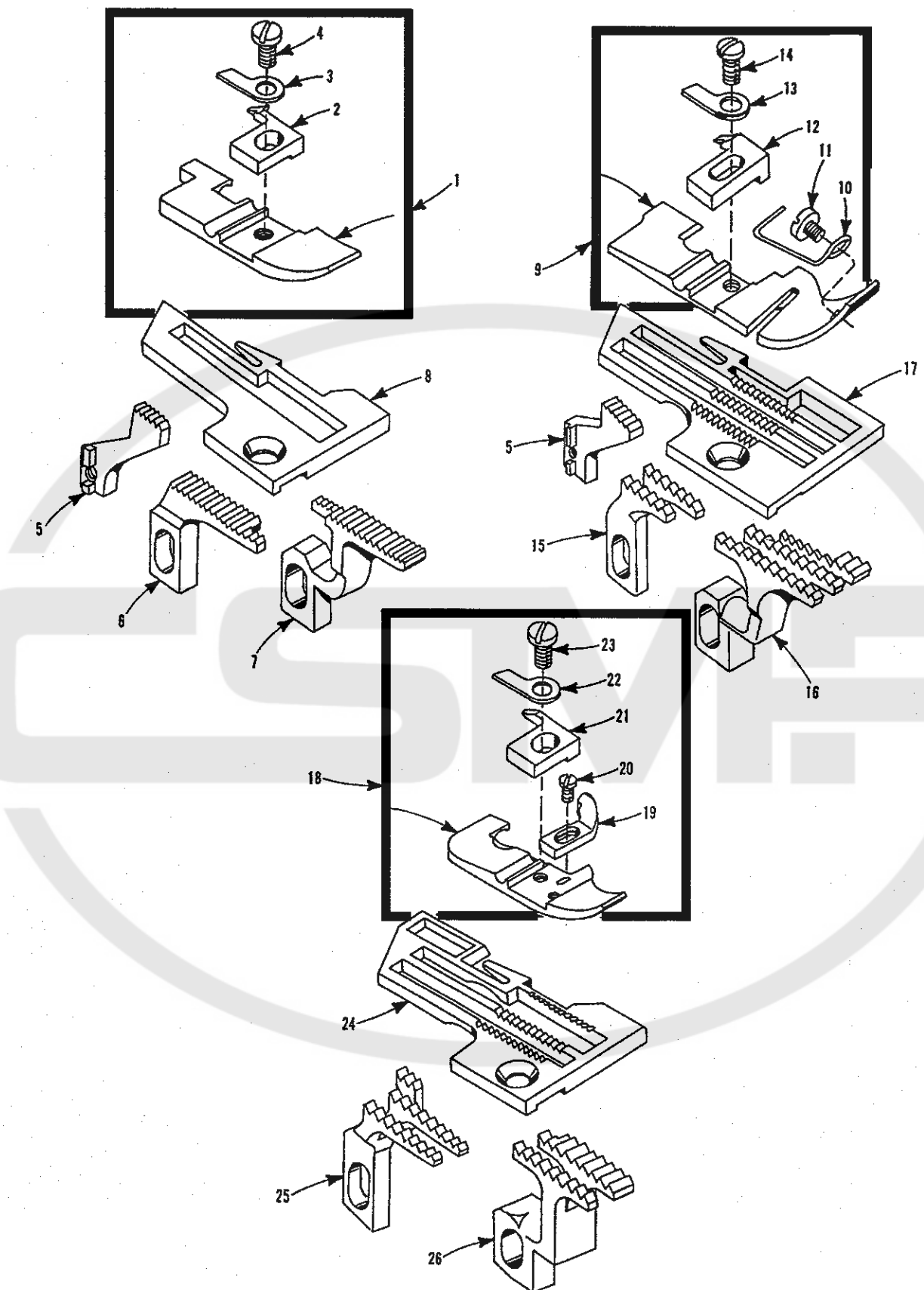
| Ref. No. | Part No.     | Description                                                                                                  | Amt. Req. |
|----------|--------------|--------------------------------------------------------------------------------------------------------------|-----------|
| 1.       | 39520B       | Presser Foot, for Styles 39500 QA, CQA .....                                                                 | 1         |
| 2.       | 39530P       | Chip Guard .....                                                                                             | 1         |
| 3.       | 22738B       | Screw .....                                                                                                  | 2         |
| 4.       | 39597A       | Stitch Tongue, marked "DS" .....                                                                             | 1         |
| 5.       | 39530        | Spring .....                                                                                                 | 1         |
| 6.       | 22768B       | Screw .....                                                                                                  | 1         |
| 7.       | 39530C       | Chain Shield .....                                                                                           | 1         |
| 8.       | 39505C       | Chaining Feed Dog, marked "C", 20 t.p.i., for Styles 39500 QA, RS, CQA .....                                 | 1         |
| 9.       | 39505B       | Main Feed Dog, marked "B", 16 t.p.i., for Styles 39500 QA, QB, RF, CQA, CQB, CRF, SQB, SRF, CSRF .....       | 1         |
| 10.      | 39526B       | Differential Feed Dog, 16 t.p.i., for Styles 39500 QA, QB, RF, CQA, CQB, CRF, SQB, SRF, CSRF .....           | 1         |
| 11.      | C39524C 3/32 | Throat Plate, marked "FC", for 3/32" (2.38mm) wide seam on Style 39500 QA .....                              | 1         |
| -        | C39524C 1/8  | Throat Plate, marked "FW", for 1/8" (3.17mm) wide seam on Styles 39500 QA, CQA .....                         | 1         |
| 12.      | 39520A       | Presser Foot, for Styles 39500 QB, RF, CQB, CRF, SQB, SRF, CSRF .....                                        | 1         |
| 13.      | 39530P       | Chip Guard .....                                                                                             | 1         |
| 14.      | 22738B       | Screw .....                                                                                                  | 2         |
| 15.      | 39597A       | Stitch Tongue, marked "DS" .....                                                                             | 1         |
| 16.      | 39530        | Spring .....                                                                                                 | 1         |
| 17.      | 22768B       | Screw .....                                                                                                  | 1         |
| 18.      | 39530C       | Chain Shield .....                                                                                           | 1         |
| 19.      | 39505E       | Chaining Feed Dog, 20 t.p.i., for all Styles except 39500 QA, RS, TE, CQA .....                              | 1         |
| 20.      | C39524B 3/32 | Throat Plate, marked "FU" for 3/32" (2.38mm) wide seam on Styles 39500 QB, RF, SQB, SRF .....                | 1         |
| -        | C39524B 1/8  | Throat Plate, marked "FB" for 1/8" (3.17mm) wide seam on Styles 39500 QB, RF, CQB, CRF, SQB, SRF, CSRF ..... | 1         |
| -        | C39524B 5/32 | Throat Plate, marked "FV", for 5/32" (3.97mm) wide seam on Styles 39500 QB, RF, CRF, SQB, SRF, CSRF .....    | 1         |
| 21.      | 39520P       | Presser Foot, for Style 39500 QP .....                                                                       | 1         |
| 22.      | 39597P       | Stitch Tongue, marked "EA" .....                                                                             | 1         |
| 23.      | 39530        | Spring .....                                                                                                 | 1         |
| 24.      | 22768B       | Screw .....                                                                                                  | 1         |
| 25.      | 39505P       | Main Feed Dog, marked "J", 12 t.p.i., for Styles 39500 QP, RA, RR .....                                      | 1         |
| 26.      | 39526P       | Differential Feed Dog, 12 t.p.i., for Style 39500 QP .....                                                   | 1         |
| 27.      | C39524P      | Throat Plate, marked "FE", for 1/8" (3.17mm) wide seam on Style 39500 QP .....                               | 1         |



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# FEED DOGS, THROAT PLATE & PRESSER FEET

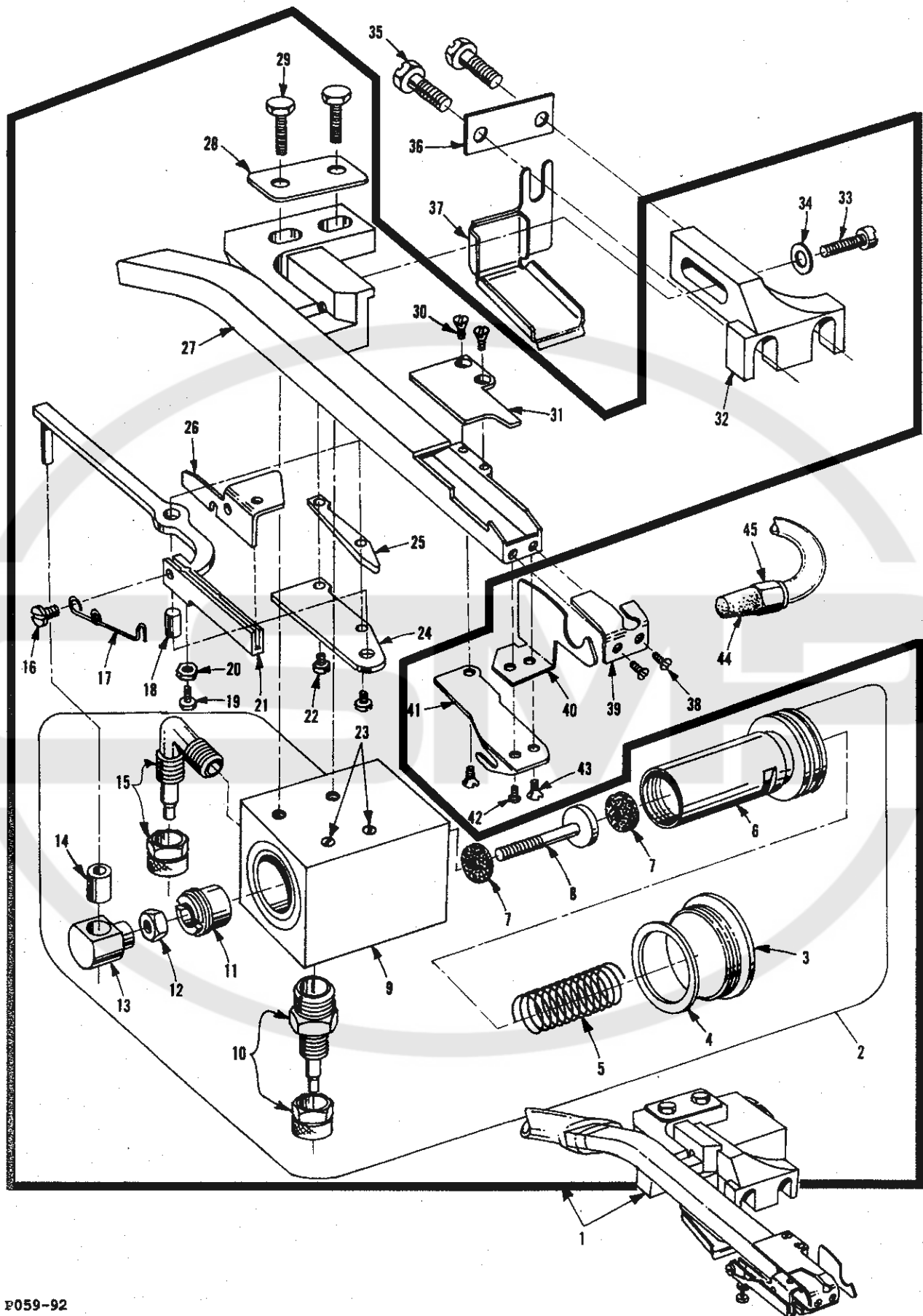
| Ref. No. | Part No.    | Description                                                                      | Amt. Req. |
|----------|-------------|----------------------------------------------------------------------------------|-----------|
| 1.       | 39520AR     | Presser Foot, for Style 39500 RR .....                                           | 1         |
| 2.       | 39597AR     | Stitch Tongue, marked "EN" .....                                                 | 1         |
| 3.       | 39530       | Spring .....                                                                     | 1         |
| 4.       | 22768B      | Screw .....                                                                      | 1         |
| 5.       | 22738B      | Screw .....                                                                      | 1         |
| 6.       | 39530H      | Chain Shield .....                                                               | 1         |
| 7.       | 39505E      | Chaining Feed Dog, 20 t.p.i., for all Styles except 39500 QA, RS, TE, CQA .....  | 1         |
| 8.       | 39505P      | Main Feed Dog, marked "J", 12 t.p.i., for Styles 39500 QP, RA, RR .....          | 1         |
| 9.       | 39526AA     | Differential Feed Dog, marked "AA", 12 t.p.i., for Styles 39500 RA, RR .....     | 1         |
| 10.      | 39524AR 1/4 | Throat Plate, marked "BC 1/4", for 1/4" (6.35mm) wide seam on Style 39500 RR ... | 1         |
| 11.      | 39520AA     | Presser Foot, for Style 39500 RA .....                                           | 1         |
| 12.      | 39597AA     | Stitch Tongue, marked "EG" .....                                                 | 1         |
| 13.      | 39530       | Spring .....                                                                     | 1         |
| 14.      | 22768B      | Screw .....                                                                      | 1         |
| 15.      | 22738B      | Screw .....                                                                      | 1         |
| 16.      | 39530C      | Chain Shield .....                                                               | 1         |
| 17.      | 39524AA     | Throat Plate, marked "AT", for 5/32" (3.97mm) wide seam on Style 39500 RA .....  | 1         |
| 18.      | 39520AS     | Presser Foot, for Style 39500 RS .....                                           | 1         |
| 19.      | 39530P      | Chip Guard .....                                                                 | 1         |
| 20.      | 22738B      | Screw .....                                                                      | 1         |
| 21.      | 39597AS     | Stitch Tongue, marked "ES" .....                                                 | 1         |
| 22.      | 39530       | Spring .....                                                                     | 1         |
| 23.      | 22768B      | Screw .....                                                                      | 1         |
| 24.      | C39524AS    | Throat Plate, marked "LE", for 3/32" (2.38mm) wide seam on Style 39500 RS .....  | 1         |
| 25.      | 39505C      | Chaining Feed Dog, marked "C", 20 t.p.i., for Styles 39500 QA, RS, CQA .....     | 1         |
| 26.      | 39505AC     | Main Feed Dog, marked "AM", 22 t.p.i., for Styles 39500 RS, SE .....             | 1         |
| 27.      | 39526AC     | Differential Feed Dog, 22 t.p.i., for Styles 39500 RS, SE .....                  | 1         |



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# FEED DOGS, THROAT PLATE & PRESSER FEET

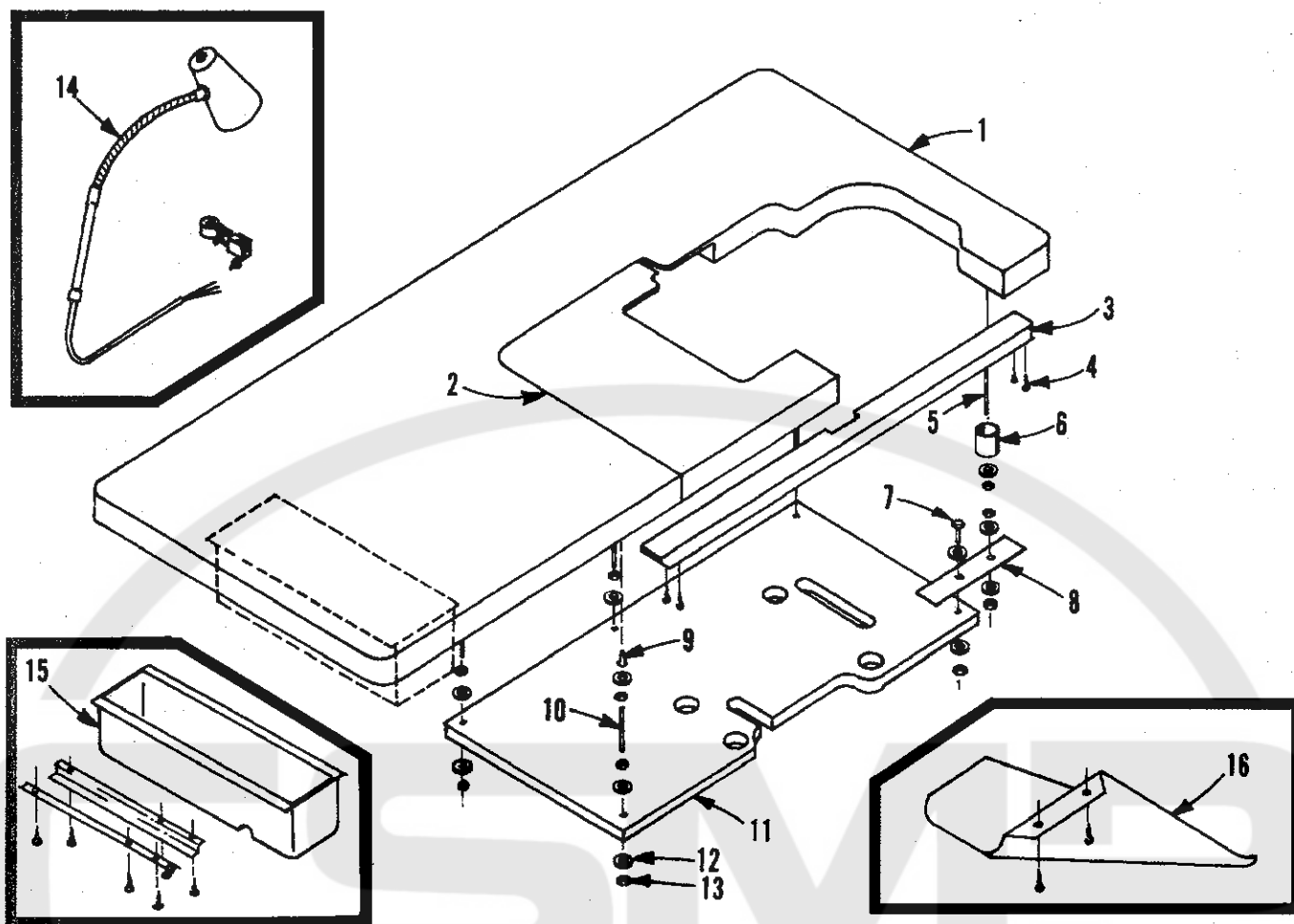
| Ref. No. | Part No.     | Description                                                                     | Amt. Req. |
|----------|--------------|---------------------------------------------------------------------------------|-----------|
| 1.       | 39527AD      | Presser Foot, for Style 39500 SE .....                                          | 1         |
| 2.       | 39597AB      | Stitch Tongue, marked "EL" .....                                                | 1         |
| 3.       | 39530        | Spring .....                                                                    | 1         |
| 4.       | 22768B       | Screw .....                                                                     | 1         |
| 5.       | 39505E       | Chaining Feed Dog, 20 t.p.i., for all Styles except 39500 QA, RS, TE, CQA ..... | 1         |
| 6.       | 39505AC      | Main Feed Dog, marked "AM", 22 t.p.i., for Style 39500 RS, SE .....             | 1         |
| 7.       | 39526AC      | Differential Feed Dog, 22 t.p.i., for Styles 39500 RS, SE .....                 | 1         |
| 8.       | C39528AD     | Throat Plate, marked "LM", for 1/8" (3.17mm) wide seam on Style 39500 SE .....  | 1         |
|          | C39524AB 1/8 | Throat Plate, marked "AX", for 1/8" (3.17mm) wide seam on Style 39500 SQB ..... | 1         |
| 9.       | 39520BF      | Presser Foot, for Style 39500 SF .....                                          | 1         |
| 10.      | 39530BF      | Tape Guide .....                                                                | 1         |
| 11.      | 22798B       | Screw .....                                                                     | 1         |
| 12.      | 39597P       | Stitch Tongue, marked "EA" .....                                                | 1         |
| 13.      | 39530        | Spring .....                                                                    | 1         |
| 14.      | 22768B       | Screw .....                                                                     | 1         |
| 15.      | 39505BF      | Main Feed Dog, marked "BY", 12 t.p.i., for Style 39500 SF .....                 | 1         |
| 16.      | 39526BF      | Differential Feed Dog, marked "BZ", 12 t.p.i., for Style 39500 SF .....         | 1         |
| 17.      | C39524BF     | Throat Plate, marked "LF", for 1/8" (3.17mm) wide seam on Style 39500 SF ....   | 1         |
| 18.      | GA39520      | Presser Foot, for Style 39500 TE .....                                          | 1         |
| 19.      | G39530A      | Chip Guard .....                                                                | 1         |
| 20.      | 22738B       | Screw .....                                                                     | 1         |
| 21.      | 39597A       | Stitch Tongue, marked "DS" .....                                                | 1         |
| 22.      | 39530        | Spring .....                                                                    | 1         |
| 23.      | 22738B       | Screw .....                                                                     | 1         |
| 24.      | GA39524C 1/8 | Throat Plate, marked "HB", for 1/8" (3.17mm) wide seam on Style 39500 TE ...    | 1         |
| 25.      | GA39505B     | Main Feed Dog, marked "JL", 16 t.p.i., for Style 39500 TE .....                 | 1         |
| 26.      | G39526JV     | Differential Feed Dog, 16 t.p.i., for Style 39500 TE .....                      | 1         |



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**POWER AIR-KLIPP® CHAIN CUTTER**  
(STYLES 39500 CQA, CQB, CRF, CSRF)

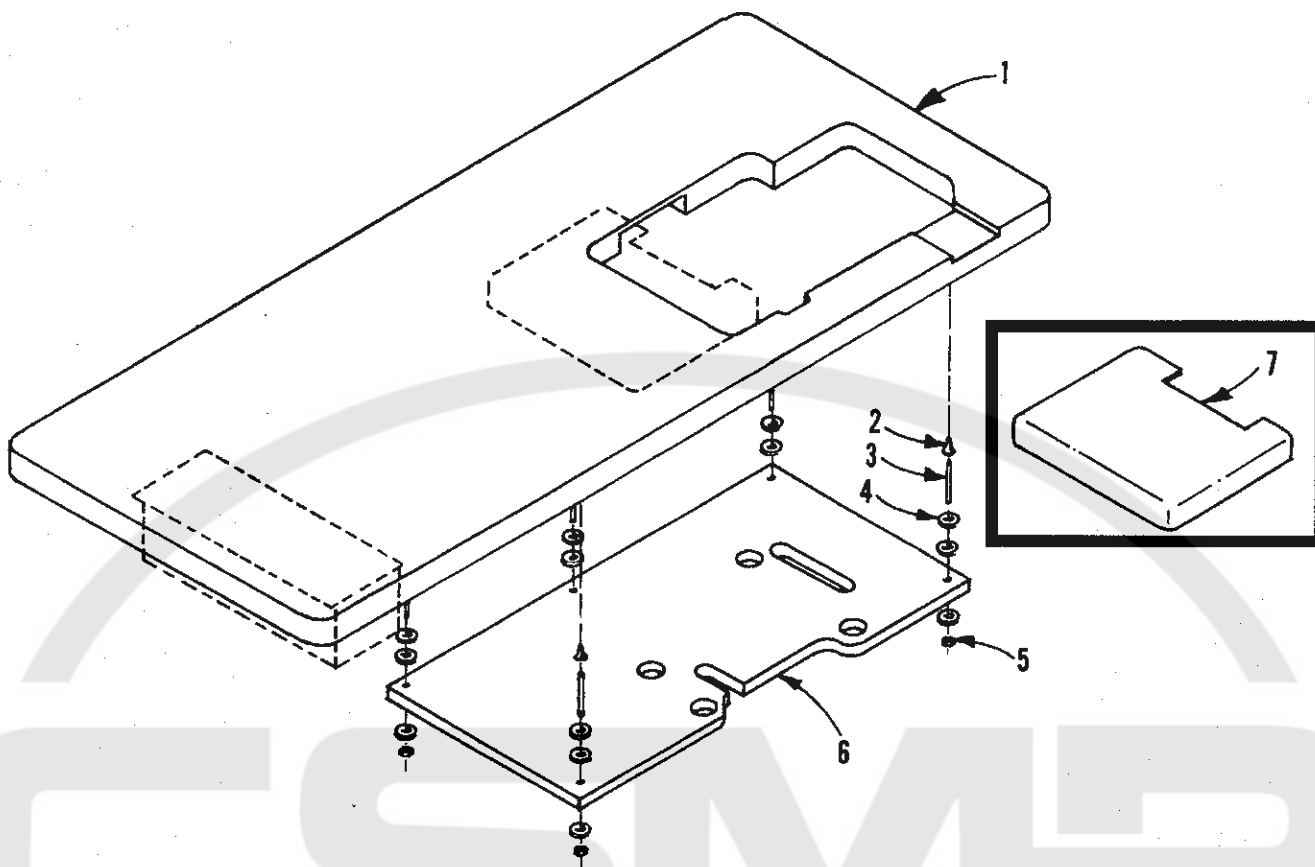
| Ref. No. | Part No. | Description                                                                                 | Amf. Req. |
|----------|----------|---------------------------------------------------------------------------------------------|-----------|
| 1.       | V29941AA | Power "AIR-KLIPP" Chain Cutter Assembly .....                                               | 1         |
| 2.       | 671H-1   | Air-Motor Assembly .....                                                                    | 1         |
| 3.       | 671H-1D  | Plug Screw .....                                                                            | 1         |
| 4.       | 671H-1F  | Rubber Bumper .....                                                                         | 1         |
| 5.       | 660-753  | Spring .....                                                                                | 1         |
| 6.       | 671H-1A  | Vibrator .....                                                                              | 1         |
| 7.       | 671H-1H  | Shock Washer .....                                                                          | 2         |
| 8.       | 39536DC  | Stud .....                                                                                  | 1         |
| 9.       | 671H-1B  | Housing .....                                                                               | 1         |
| 10.      | 991-126F | Straight Fitting .....                                                                      | 1         |
| 11.      | 671H-1E  | Plug Screw .....                                                                            | 1         |
| 12.      | 41071G   | Nut .....                                                                                   | 1         |
| 13.      | 39573AC  | Drive Link .....                                                                            | 1         |
| 14.      | 671H-1G  | Bushing .....                                                                               | 1         |
| 15.      | 999-141  | Elbow Fitting .....                                                                         | 1         |
| 16.      | 22825    | Screw .....                                                                                 | 1         |
| 17.      | 99697DB  | Torsion Spring .....                                                                        | 1         |
| 18.      | 39536DB  | Pin .....                                                                                   | 1         |
| 19.      | 22588K   | Screw .....                                                                                 | 1         |
| 20.      | 60078Z   | Nut .....                                                                                   | 1         |
| 21.      | 39573AB  | Knife Driving Lever .....                                                                   | 1         |
| 22.      | 22738A   | Screw .....                                                                                 | 2         |
| 23.      | 12935A   | Screw .....                                                                                 | 2         |
| 24.      | 99663MD  | Cover Plate .....                                                                           | 1         |
| 25.      | 99663MC  | Spacer Plate .....                                                                          | 1         |
| 26.      | 99669KH  | Lower Knife .....                                                                           | 1         |
| 27.      | 99676MC  | Tube Assembly .....                                                                         | 1         |
| 28.      | 95910A   | Plate Washer .....                                                                          | 1         |
| 29.      | 906      | Screw .....                                                                                 | 2         |
| 30.      | 22716    | Screw .....                                                                                 | 2         |
| 31.      | 99670LH  | Upper Knife .....                                                                           | 1         |
| 32.      | 99663KA  | Bracket .....                                                                               | 1         |
| 33.      | 22729D   | Screw .....                                                                                 | 1         |
| 34.      | 80265    | Washer .....                                                                                | 1         |
| 35.      | 99373C   | Mounting Screw .....                                                                        | 2         |
| 36.      | 95910B   | Plate Washer .....                                                                          | 1         |
| 37.      | 39534RB  | Oil Shield .....                                                                            | 1         |
| 38.      | 22716A   | Screw, for inlet .....                                                                      | 2         |
| 39.      | 99677H   | Inlet, marked "GF", has a .130" (3.3mm) opening, for Style 39500 CQA .....                  | 1         |
| -        | 99677HA  | Inlet, marked "GS", has a .169" (4.3mm) opening, for Styles 39500 CQA, CQB, CRF, CSRF ..... | 1         |
| -        | 99677HD  | Inlet, marked "GV", has a .205" (5.2mm) opening, for Styles 39500 CQB, CRF, CSRF .....      | 1         |
| 40.      | 99665    | Fabric Guard .....                                                                          | 1         |
| 41.      | 99664C   | Looper Thread Guide .....                                                                   | 1         |
| 42.      | 22716A   | Screw, for inlet and fabric guard .....                                                     | 1         |
| 43.      | 22716    | Screw, for inlet and fabric guard .....                                                     | 2         |
| 44.      | 999-140  | Muffler .....                                                                               | 1         |
| 45.      | 999-126A | Connector .....                                                                             | 1         |



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### FULLY-SUBMERGED TABLING

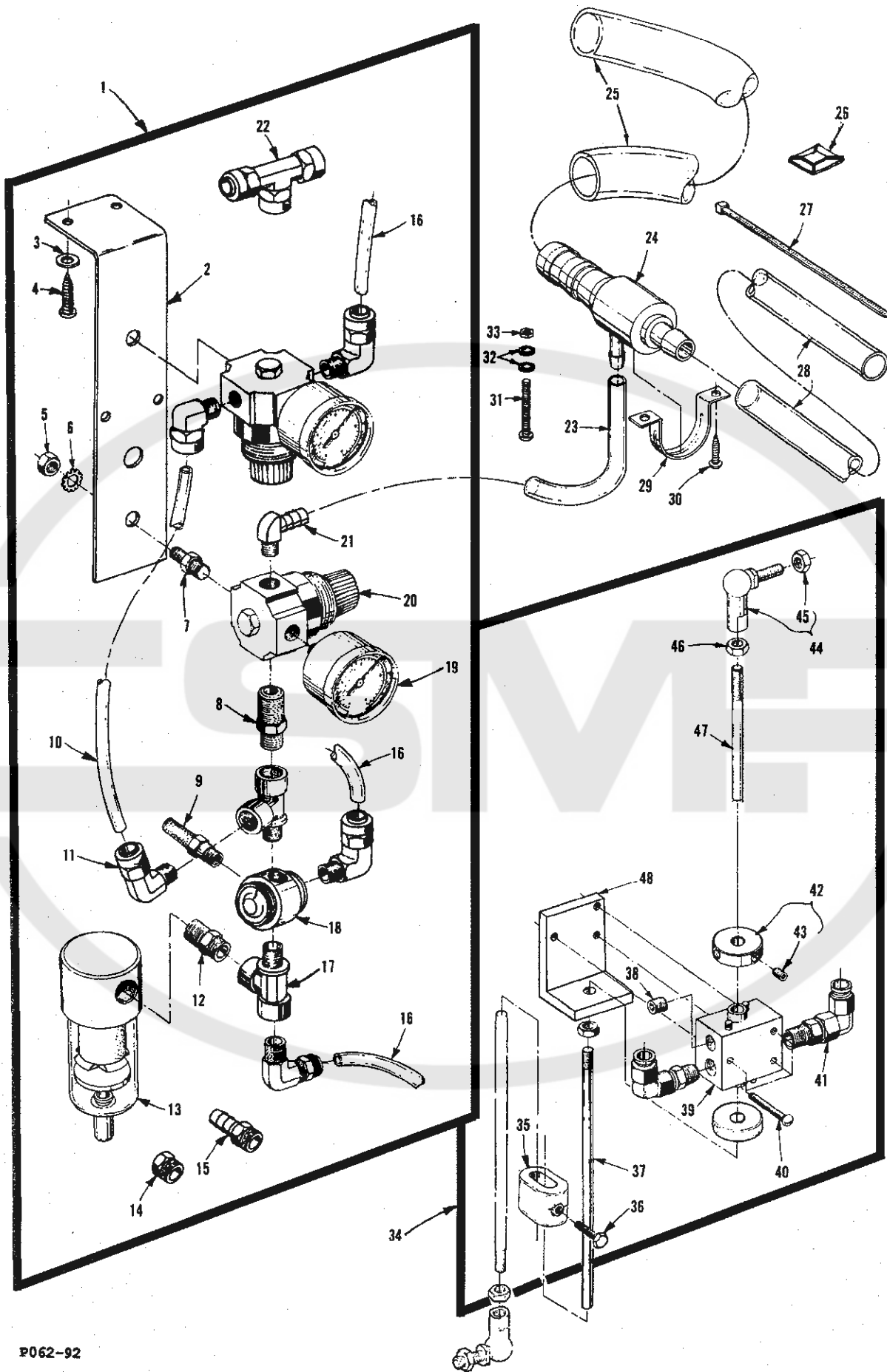
| Ref. No. | Part No.   | Description             | Amt. Req. |
|----------|------------|-------------------------|-----------|
| 1.       | 21371WL-48 | Table Board .....       | 1         |
| 2.       | 30-96BLK   | Insert .....            | 1         |
| 3.       | 30-97BLK   | Table Board Brace ..... | 1         |
| 4.       | SC470      | Screw .....             | 4         |
| 5.       | 21371PY-32 | Threaded Rod .....      | 1         |
| 6.       | 21371XW    | Spacer .....            | 1         |
| 7.       | 22820A     | Screw .....             | 1         |
| 8.       | 21371XY    | Bracket .....           | 1         |
| 9.       | 660-276    | Tap Lock Inserts .....  | 8         |
| 10.      | 21371PY-40 | Threaded Rod .....      | 4         |
| 11.      | 21372AG    | Underboard .....        | 1         |
| 12.      | 652 J-24   | Washer .....            | 17        |
| 13.      | 651 B-24   | Nut .....               | 16        |
| 14.      | 21233KH    | Light .....             | 1         |
| 15.      | 21371Q     | Drawer Assembly .....   | 1         |
| 16.      | 51278F     | Chip Chute .....        | 1         |



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### SEMI-SUBMERGED TABLING

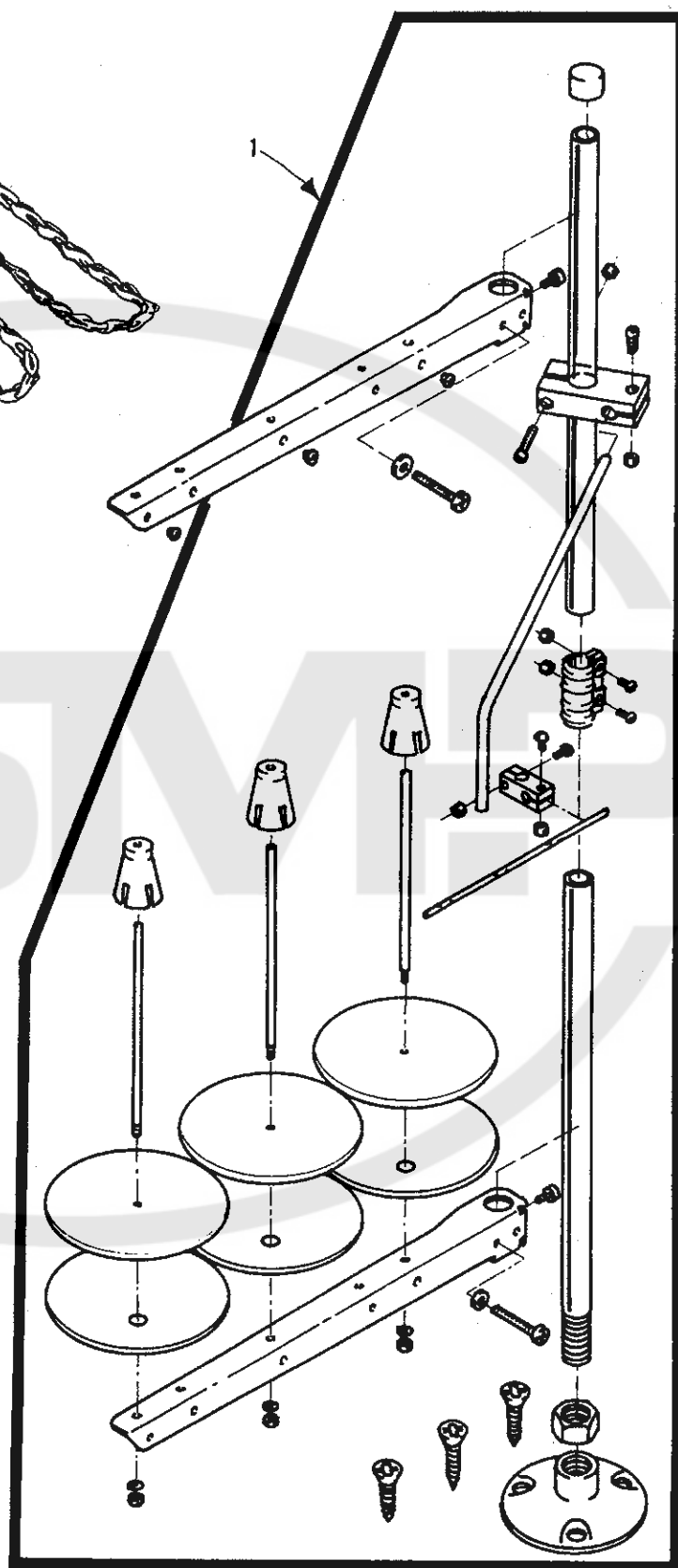
| Ref. No. | Part No.   | Description                          | Amt. Req. |
|----------|------------|--------------------------------------|-----------|
| 1.       | 21371RL-48 | Table Board .....                    | 1         |
| 2.       | 660-276    | Tap Lock Insert .....                | 5         |
| 3.       | 21371PY-28 | Threaded Rod .....                   | 5         |
| 4.       | 652J-24    | Washer .....                         | 15        |
| 5.       | 11698L     | Nut .....                            | 5         |
| 6.       | 21372AG    | Underboard .....                     | 1         |
| 7.       | 21377BP    | Tray .....                           | 1         |
| -        | 21371Q     | Drawer Assembly, (See page 34) ..... | 1         |
| -        | 51278F     | Chip Chute, (See page 34) .....      | 1         |
| -        | 21233KH    | Light, (See page 34) .....           | 1         |



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# PNEUMATIC CONTROL

| Ref. No. | Part No.   | Description                                      | Amt. Req. |
|----------|------------|--------------------------------------------------|-----------|
| 1.       | 29480UY    | Pneumatic Control .....                          | 1         |
| 2.       | 99638CC    | Mounting Bracket .....                           | 1         |
| 3.       | 39836AH    | Washer .....                                     | 2         |
| 4.       | RM2719-1   | Wood Screw .....                                 | 2         |
| 5.       | 11635B     | Nut .....                                        | 2         |
| 6.       | 652B-20    | Washer .....                                     | 2         |
| 7.       | 671C-16    | Mounting Stud .....                              | 2         |
| 8.       | RM3287-2   | Hex Nipple .....                                 | 1         |
| 9.       | 660-403    | Muffler .....                                    | 1         |
| 10.      | 660-392    | Air Tube .....                                   | 1         |
| 11.      | 660-401    | Elbow .....                                      | 5         |
| 12.      | RM3320-1   | Reducing Nipple .....                            | 1         |
| 13.      | 671D-5     | Air Line Filter .....                            | 1         |
| 14.      | 671F-6     | Reducing Bushing .....                           | 1         |
| 15.      | 671F-1     | Barb Fitting .....                               | 1         |
| 16.      | RM2997D    | Tube, 1/4" (6.35mm) O.D. 13' (3.96 meters) ..... | 1         |
| 17.      | RM2850D    | Pipe Tee .....                                   | 2         |
| 18.      | RM4098-1   | Pilot Valve .....                                | 1         |
| 19.      | 671D-15    | Gauge .....                                      | 2         |
| 20.      | 671D-9     | Regulator .....                                  | 2         |
| 21.      | 671F-2     | Connector .....                                  | 1         |
| 22.      | RM3384-1   | Union Tee .....                                  | 1         |
| 23.      | 671B-3     | Tube, venturi (air supply) .....                 | 1         |
| 24.      | 671D-2     | Venturi .....                                    | 1         |
| 25.      | 671B-11    | Tube, discharge .....                            | 1         |
| 26.      | 660-870    | Cable Tie Mount .....                            | 4         |
| 27.      | RM2871B    | Wire Tie .....                                   | 4         |
| 28.      | 671B-12    | Tube, suction .....                              | 1         |
| 29.      | 998-332    | Holder, venturi .....                            | 1         |
| 30.      | RM2719-1   | Screw, for wood table .....                      | 2         |
| 31.      | SC198      | Screw, for metal table .....                     | 2         |
| 32.      | 39836AH    | Washer, for metal table .....                    | 4         |
| 33.      | NU13       | Nut, for metal table .....                       | 2         |
| 34.      | 29480ACD   | Treadle Valve Assembly .....                     | 1         |
| 35.      | G28562A    | Pitman Rod Connector .....                       | 1         |
| 36.      | 95051      | Screw .....                                      | 1         |
| 37.      | 99563A-130 | Pitman Rod .....                                 | 1         |
| 38.      | 22571F     | Plug Screw .....                                 | 1         |
| 39.      | 671-134    | Valve Body .....                                 | 1         |
| 40.      | SC191      | Screw .....                                      | 3         |
| 41.      | 671F-69    | Swivel Fitting .....                             | 2         |
| 42.      | C50036AS   | Actuating Collar .....                           | 2         |
| 43.      | 22894R     | Screw .....                                      | 2         |
| 44.      | 999-146    | Link .....                                       | 2         |
| 45.      | 95250      | Nut .....                                        | 2         |
| 46.      | 95250      | Hex Nut .....                                    | 3         |
| 47.      | 99563A-75  | Pitman Rod .....                                 | 1         |
| 48.      | 671-135    | Mounting Bracket .....                           | 1         |



## THREAD STAND & MISCELLANEOUS ACCESSORIES

| Ref. No. | Part No. | Description                                                                      | Amt. Req. |
|----------|----------|----------------------------------------------------------------------------------|-----------|
| 1.       | 21101W3  | Thread Stand .....                                                               | 1         |
| 2.       | 660-264  | "S" Hook, for treadle chain .....                                                | 2         |
| 3.       | 421 D-34 | Treadle Chain, for presser foot lifter .....                                     | 1         |
| 4.       | 660-240  | Tweezers .....                                                                   | 1         |
| 5.       | 21227DR  | Cam Extractor .....                                                              | 1         |
| 6.       | 116      | Wrench, for 9/32" (7.142 mm) nuts .....                                          | 1         |
| 7.       | 21375BB  | Belt Guard .....                                                                 | 1         |
| 8.       | 80       | Screws, for belt guard .....                                                     | 2         |
| -        | 21388AU  | Socket Wrench, for 3/8" (9.52 mm) nuts holding feed eccentrics (not shown) ..... | 1         |
| -        | 28604R   | Pint of Oil (not shown) .....                                                    | 1         |
| -        | 660-458  | Dust Cover (not shown) .....                                                     | 1         |
| -        | 652-24   | Washer (not shown) .....                                                         | 8         |



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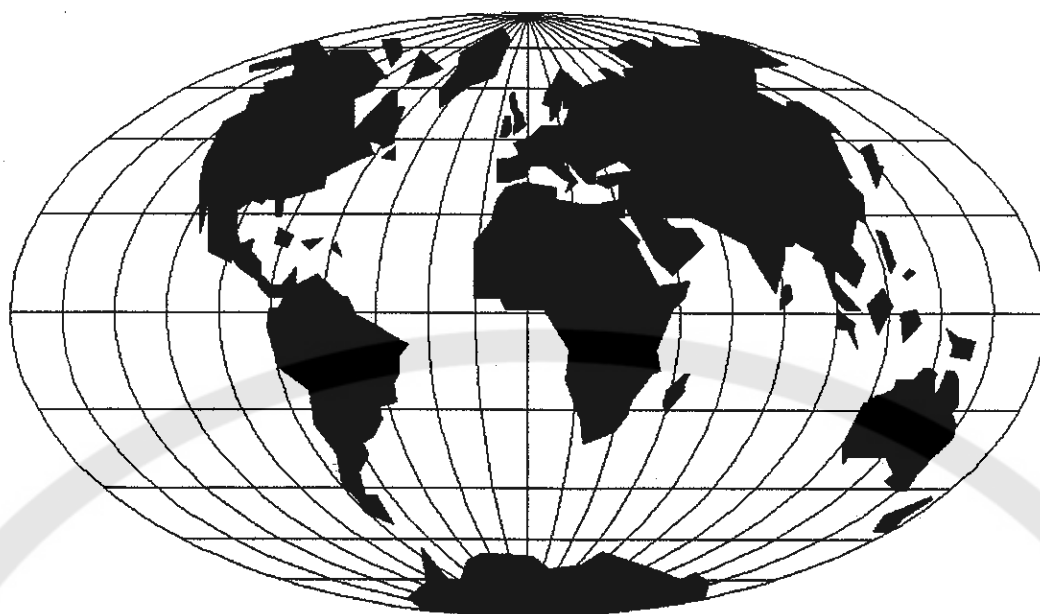
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