

**Illustrated Parts for the 9M Series machines  
(Supplement to Manual 103 XQA)**

Manual No. T103XEQA

Second edition

By

Union Special Corporation

Rights Reserved In All Countries

Printed in U.S.A. March, 1993

---

---

### APPLICATION OF MANUAL

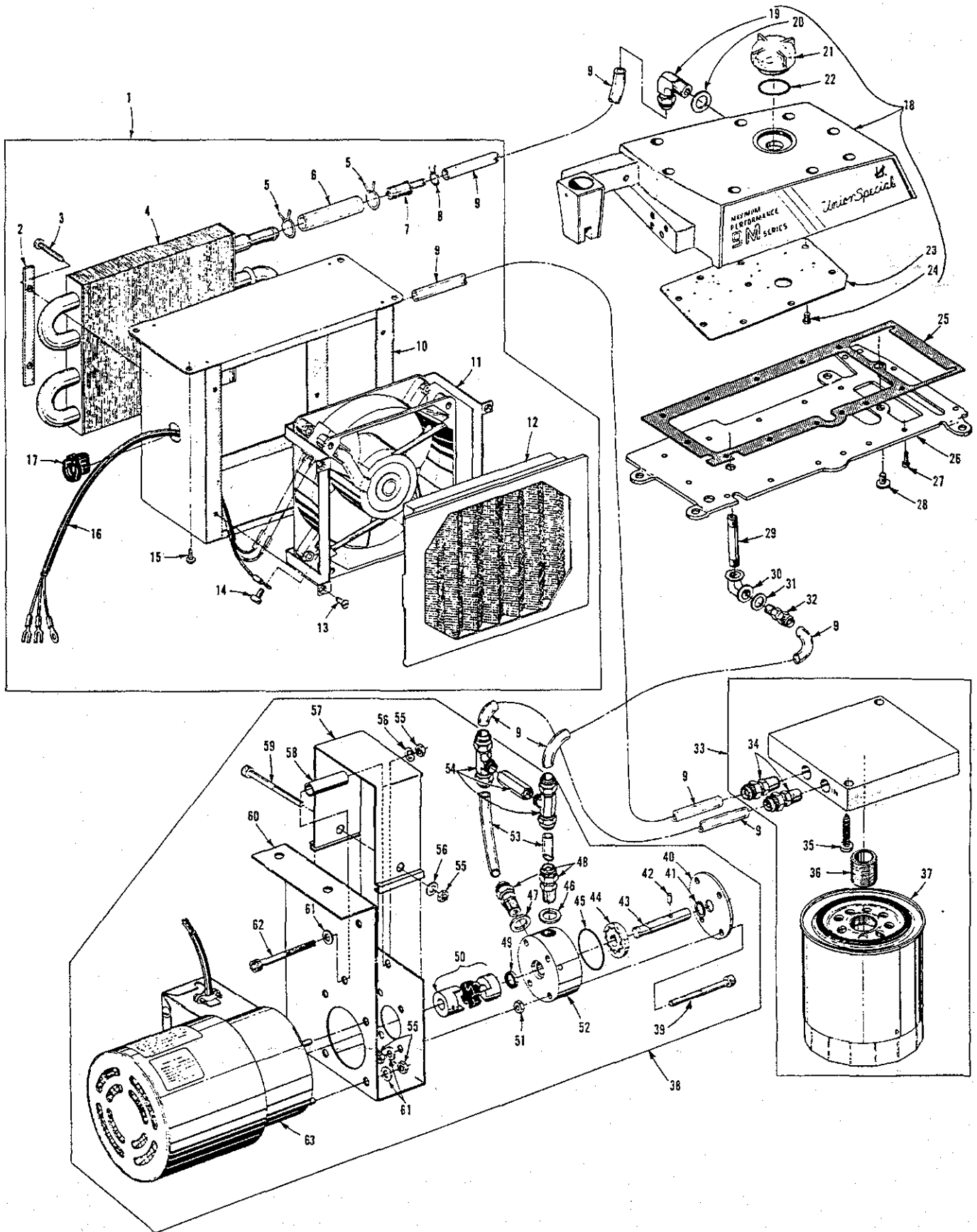
This manual is a supplement to manual 103 XQA and should be used in conjunction therewith. The styles listed in this supplement are identical to the corresponding styles in the 103 XQA manual but without the "E" in the suffix. Each machine has the same application and description as in the 103 XQA manual except the oil pump, oil filter and cooler are now external which allows for better lubrication and cooling ability.

The following styles do not have corresponding styles in the 103 XQA manual, but are covered by this supplement.

- 39500 XEST Single-needle, differential stretch feed, three-thread toe closing machine for women's seamless hosiery with a 1/16" (1.5mm) wide rolled down hem within the seam. Type 154 GAS needle, seam specification 504 SSp-1 (inv.) stitch range 20-100 per inch.
- 39500 XESV Single-needle, differential stretch feed, two-thread serging on all kinds of weights of trouser panels, especially synthetics. Type 154 GAS needle, seam specification 503 EFd-1, standard seam width 5/32" (4mm), stitch range sea at 7 per inch standard.
- 39500 XESW Same as 39500 XESV except seam specification 505 EFD-1, three-thread serging machine.
- 39500 CXEST Same as 39500 XEST except fitted with power AIR KLIPP® chain cutter.
- 39500 CXESV Same as 39500 XESV except fitted with power AIR KLIPP chain cutter.
- 39500 CXESW Same as 39500 XESW except fitted with power AIR KLIPP chain cutter.

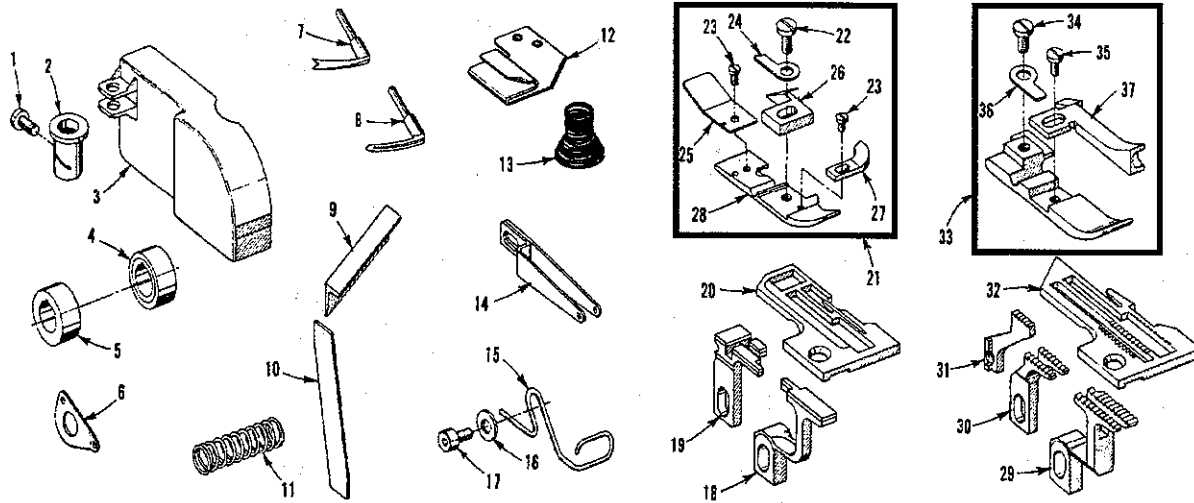
AIR KLIPP® is a registered trademark of Union Special Corporation.

Only those parts found on the "E" series, external oil pump 9M machines are illustrated on the following pages.



## EXTERNAL PUMP LUBRICATION SYSTEM

Ref. No.	Part No.	Description	Amt. Req.
1.	29480 ZE	Cooler Assembly, oil .....	1
2.	50393 BG	Bracket, mounting .....	2
3.	661-73	Screw .....	4
4.	50393 BF	Core, radiator .....	1
5.	661-75	Clamp, hose .....	4
6.	671 B-39	Tube, oil .....	2
7.	671 C-17	Reducer, oil line .....	2
8.	660-885	Clamp, hose .....	2
9.	671 B-34	Tube, oil, (2 pieces provided with 29480-ZE, cut to fit) .....	2
10.	50393 BE	Housing, oil cooler .....	1
11.	661-83	Fan, cooling .....	1
12.	661-82	Filter Assembly, air .....	1
13.	661-72	Screw .....	4
14.	661-74	Screw, ground wire .....	1
15.	661-85	Screw, cooler mounting .....	4
16.	670 E-424	Wiring Assembly .....	1
17.	670 E-423	Bushing, relief .....	1
18.	39582 FZ	Cover, top .....	1
19.	671F93C	Elbow, Compression, 5/16" O.D. tube fitting .....	1
20.	661-92	Code Ring, red .....	1
21.	39594 Y	Cap, oil fill .....	1
22.	660-705	"O" Ring .....	1
23.	39582 DS	Plate, oil drip .....	1
24.	22564 D	Screw .....	9
25.	39582 Y	Gasket, bottom cover .....	1
	39582 BZ	Top Cover Gasket .....	1
26.	39582-XG	Cover, bottom .....	1
27.	22569	Screw, bottom cover .....	14
28.	22586 R	Screw, bottom cover .....	1
29.	660-371	Fitting, straight .....	1
30.	671 F-16	Elbow, 90 degree female .....	1
31.	661-91	Code Ring, brown .....	1
32.	661-88	Adapter-Straight Compression, 5/16" O.D. tube fitting .....	1
33.	50393 AD	Filter Assembly, mounting block .....	1
34.	661-88	Adapter-Straight Compression, 5/16" O.D. tube fitting .....	2
35.	RM-2730 A	Screw .....	2
36.	35093 Y	Fitting, straight .....	1
37.	666-299	Filter, oil .....	1
38.	29480 AEU	Pump, oil .....	1
39.	22653B-24	Screw .....	4
40.	50393 AC	End Cover .....	1
41.	660-416	Retaining Ring .....	1
42.	50393 AH	Key .....	1
43.	35093 AV	Shaft .....	1
44.	C50093 U	Oil Pump Gear .....	1
45.	660-684	"O" Ring .....	1
46.	661-91	Code Ring, brown .....	1
47.	661-92	Code Ring, red .....	1
48.	661-88	Adapter - Straight Compression, 5/16" O.D. Tube-Fitting .....	2
49.	660-726	Oil Lip Seal .....	1
50.	28616 V	Motor/Pump Coupling .....	1
51.	RM2791-7	Nut .....	4
52.	50393 BC	Pump Housing - PRS .....	1
53.	C50094 P	Tube, oil .....	2
54.	50393 DY	Relief Valve Housing .....	1
55.	651-H	Nut .....	10
56.	RM3993-3	Washer .....	2
57.	50393 EA	Coupling Cover .....	1
58.	50393 DX	Spacer .....	1
59.	22653 B48	Screw .....	1
60.	50393 DW	Pump Bracket .....	1
61.	8372 A	Washer .....	9
62.	22653 B-36	Screw .....	1
63.	670H-60	Motor .....	1



MISCELLANEOUS PARTS FOR 39500 XEST, XESV, XESW, CXEST, CXESV, CXESW

Ref. No.	Part No.	Description	Amf. Req.
1.	G22569	Screw, locking cloth plate stud .....	1
2.	G39501 K	Stud, cloth plate .....	1
3.	39582 FC	Cover, feed, mechanism, styles XEST, XESV, XESW .....	1
-	39582 FH	Cover, feed, mechanism, styles CXEST, CXESV, CXESW .....	1
4.	39540 M-5 1/2	Eccentric, differential feed driving styles XESV, XESW, CXESV, CXESW .....	1
-	39540 M-24	Eccentric, differential feed driving styles XEST, CXEST .....	1
5.	39540 M-7	Eccentric, main feed driving, styles XESV, XESW, CXESV, CXESW .....	1
-	39540 M-28	Eccentric, main feed driving, styles XEST, CXEST .....	1
6.	39563 AA	Washer, needle clamp and thread eyelet, styles XESV, XESW, CXESV, CXESW .....	1
7.	39560 A	Spreader, upper, style XESV, CXESV .....	1
8.	39508 A	Looper, upper, marked "CC" styles XEST, CXEST .....	1
-	G39508 A	Looper, upper, styles SEXW, CXESW .....	1
9.	39570	Knife, upper, styles XESV, XESW, CXESV, CXESW .....	1
39570A	<del>G39570 A</del>	Knife, upper, styles XEST, CXEST <i>39570A CR # 63 243</i> .....	1
10.	39549	Knife, lower, styles XESV, XESW, CXESV, CXESW .....	1
-	G39549 N	Knife, lower, styles XEST, CXEST .....	1
11.	39550 X	Spring, lower knife holder, styles XEST, CXEST .....	1
12.	GA39503 A	Guide, edge, styles XESV, XESW, CXESV .....	1
-	39592 AR-2	Spring, needle thread tension, styles XESV, CXESV .....	1
13.	39592 AR-4	Spring, needle and looper thread tension, styles XEST, CXEST .....	3
-	39592 AR-4	Spring, looper thread tension, styles XESV, CXESV .....	1
-	39592 AR-5	Spring, looper thread tension, styles XESW, CXESW .....	2
-	39592 AR-8	Spring, needle thread tension, styles XESW, CXESW .....	1
14.	G39568 B	Eyelet, lower looper thread, styles XEST, CXEST .....	1
15.	99682 L	Guard .....	1
16.	95956	Washer .....	2
17.	99359	Screw .....	2
18.	G39526 AB	Feed dog, differential, plastic coated, styles XEST, CXEST .....	1
19.	G39505 JT	Feed dog, main, plastic coated, styles XEST, CXEST .....	1
20.	GB39524 JS	Throat plate, styles XEST, CXEST .....	1
21.	G39520 JS	Presser foot, styles XEST, CXEST .....	1
22.	22768 B	Screw .....	1
23.	22738 B	Screw .....	2
24.	39530	Spring, hinge .....	1
25.	G39530 JT	Shield, chain .....	1
26.	G39597 JS	Tongue, stitch .....	1
27.	39530 P	Guard, chip .....	1
28.	G39530 JS	Bottom .....	1
29.	G39526 JV	Feed Dog, differential, styles XESV, XESW, CXESV, CXESW .....	1
30.	G39505 JV	Feed dog, main, marked "HS", styles XESV, XESW, CXESV, CXESW .....	1
31.	39505 C	Feed dog, chaining, marked "C", styles XESV, XESW, CXESV, CXESW .....	1
32.	C39524 B-5/32	Throat plate, marked "BH", styles XESV, XESW, CXESV, CXESW .....	1
33.	G39520 JV	Presser foot, styles XESV, CXESV, CXESW .....	1
-	39520 L	Presser foot, style XESW .....	1
34.	33768 B	Screw .....	1
35.	22819	Screw .....	1
36.	39530	Spring hinge .....	1
37.	G39597 SV	Tongue, stitch, marked "XK", for presser foot No. G39520 JV .....	1
-	39597 L	Tongue, stitch, marked "DW", for presser foot No. 39520 L .....	1



# NOTES

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---



# NOTES

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

---

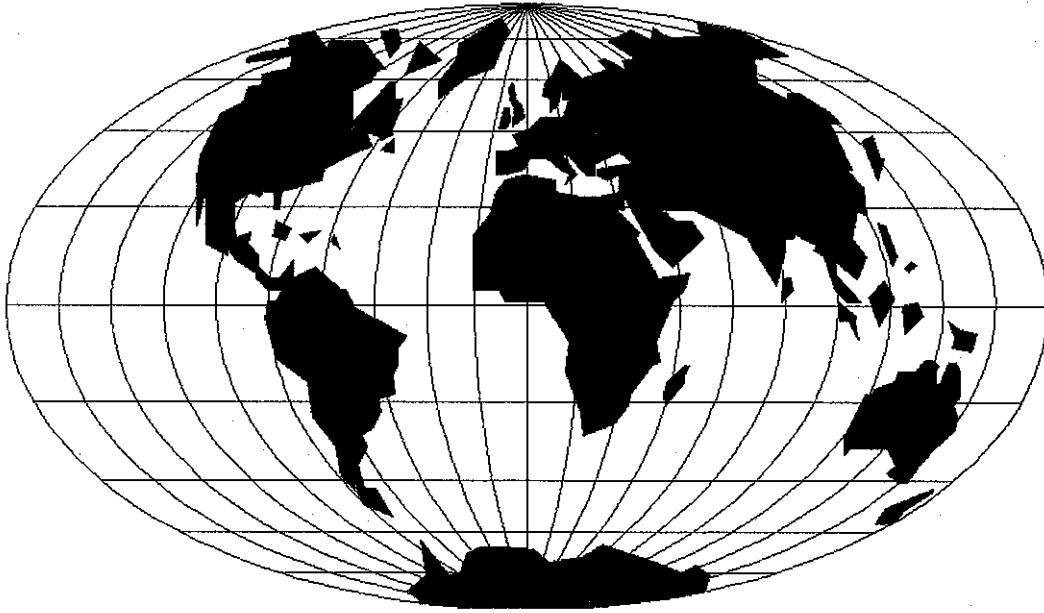
---

---

---

---





## WORLDWIDE SALES AND SERVICE

Union Special Corporation maintains sales and service facilities throughout the world. These offices will aid you in the selection of the right sewing equipment for your particular operation. Union Special Corporation representatives and service technicians are factory trained and are able to serve your needs promptly and efficiently. Whatever your location, there is a qualified representative to serve you.

---

**Corporate Office:** One Union Special Plaza  
Huntley, IL 60142  
Phone: 847•669•5101  
Fax: 847•669•1096

**European Distribution Center:** Union Special GmbH  
Raiffeisenstrasse 3  
D-71696 Möglingen, Germany  
Tel: 49•07141•247•0  
Fax: 49•7141•247•100

Brussels, Belgium  
Charlotte, N.C.  
El Paso, TX  
Hong Kong, China  
Huntley, IL  
Leicester, England  
Lille, France  
Miami, FL  
Milan, Italy  
Möglingen, Germany  
Montreal, Quebec  
Osaka, Japan  
Santa Fe Springs, CA

Other Representatives throughout  
all parts of the world.



*Union Special*<sup>®</sup>  
INDUSTRIAL SEWING EQUIPMENT