

SINGER
212U539A

**Operator's
Guide**

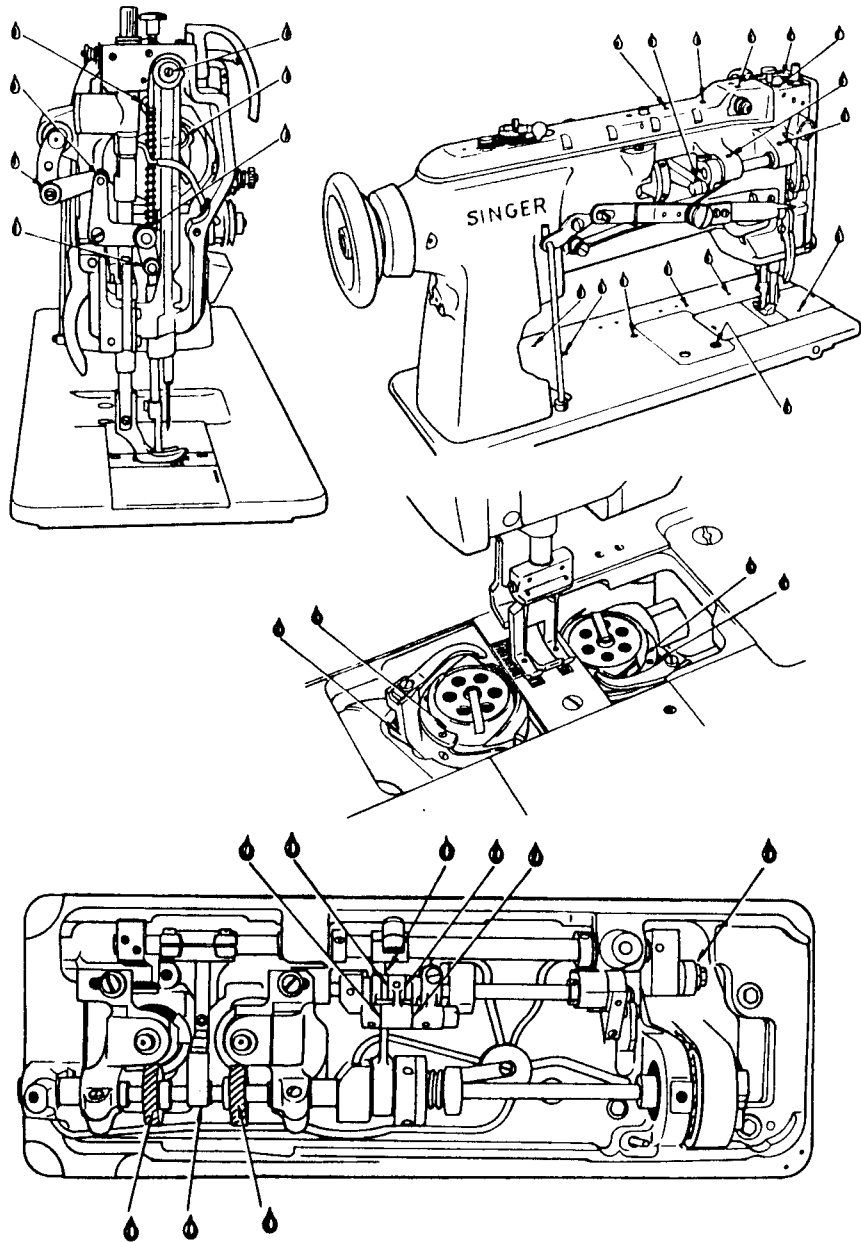
SINGER*

212 **U539A**

* A Trademark of THE SINGER COMPANY
Copyright ©1983 THE SINGER COMPANY
All Rights Reserved Throughout the World

LUBRICATION

Use Singer oil "Type A" or "Type C"



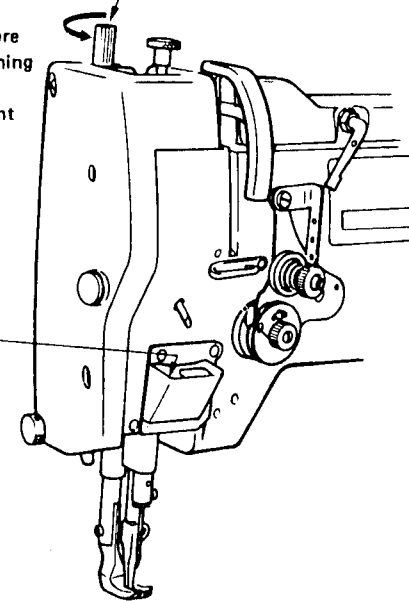
THREAD LUBRICATION

Fill thread lubricator reservoir with SINGER thread lubricant "type E"

Turn counter-clockwise for more lubricant when machine is running

Turn clockwise to stop lubricant flow when machine is idle

Lubricating pad



SPEED

Maximum Speed for this machine is 2,700 RPM

It is recommended to run the machine 500 RPM slower than maximum speed for the first 100 hours.

Recommended machine speed relative to the operating stroke of the alternating pressers.

Presser Foot Lift	Speed
2.4 mm	3,500 RPM
3.2 mm	3,300 RPM
4.0 mm	2,700 RPM
4.8 mm	2,400 RPM
5.5 mm	2,300 RPM
6.3 mm	2,200 RPM
7.1 mm	2,100 RPM

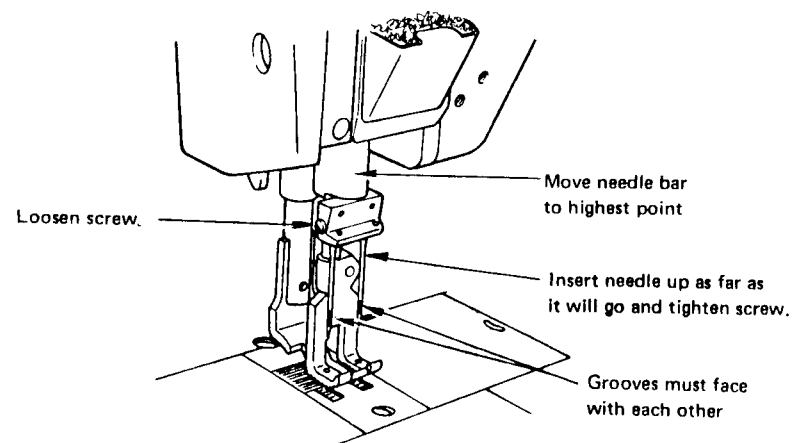
NEEDLES

Use Singer needles.

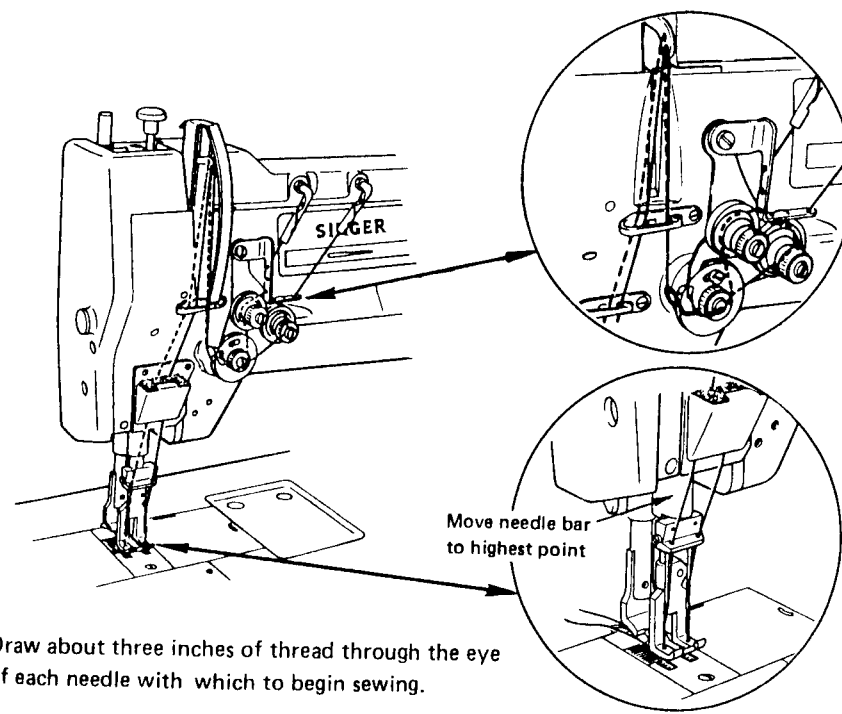
Needles for Machine 212U539A are catalog 3355

In sizes determined by size of thread and type of material being sewn.

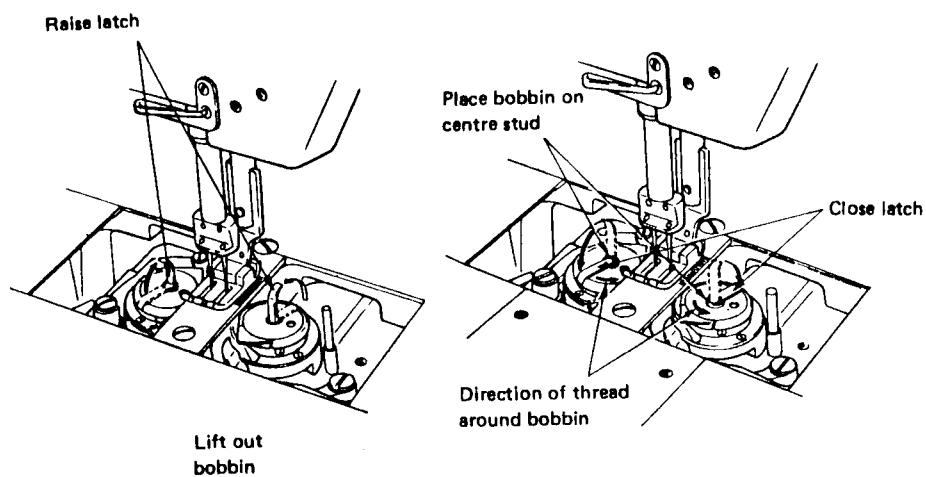
SETTING THE NEEDLES



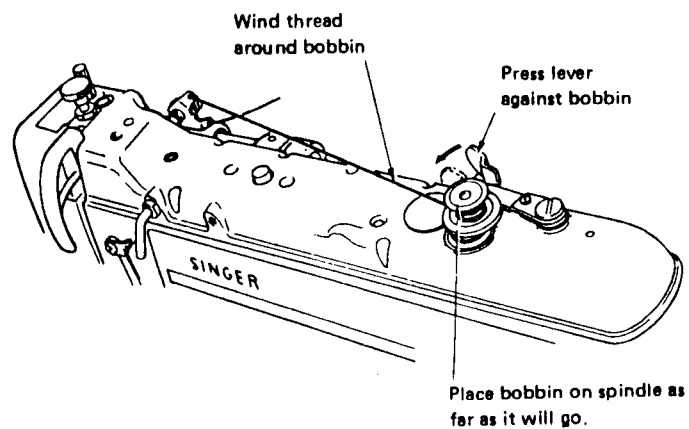
THREADING NEEDLES



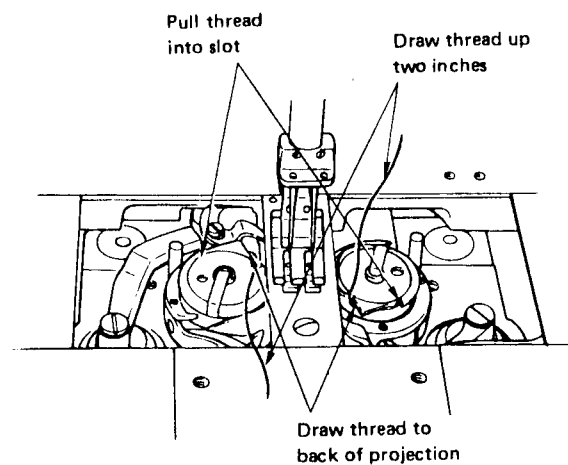
BOBBIN REMOVAL AND REPLACEMENT



WINDING THE BOBBIN

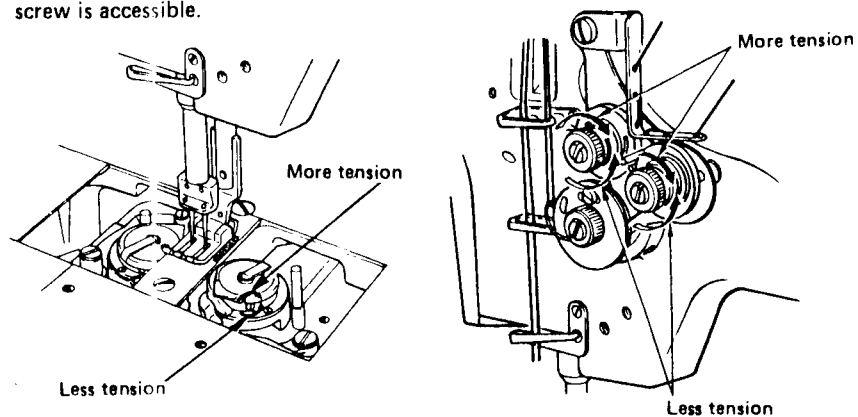


THREADING BOBBIN CASE



THREAD TENSIONS

Turn machine pulley until tension screw is accessible.

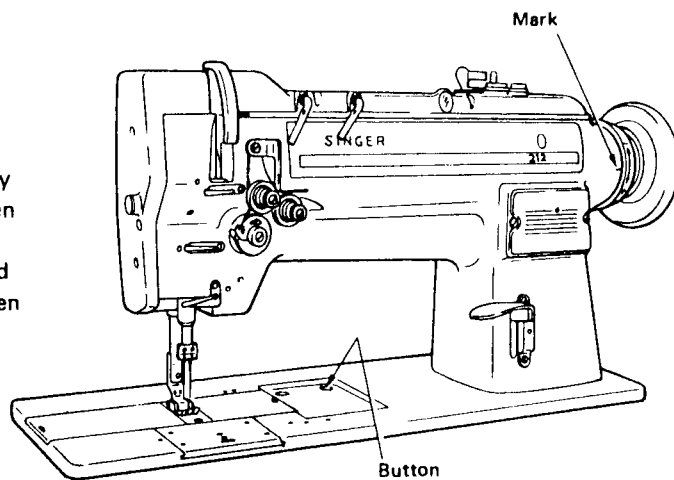


Tension on thread should be as light as possible while still sufficient to set stitch in material

Regulate needle thread tension only when presser foot is down.

STITCH LENGTH REGULATION

1. STOP MACHINE.
2. Depress button.
3. Turn pulley to you slowly until button drops into notch.
4. Turn machine pulley in direction (+) when a longer stitch is desired (less spi) and in direction (-) when a shorter stitch is desired (more spi).
5. Release button.

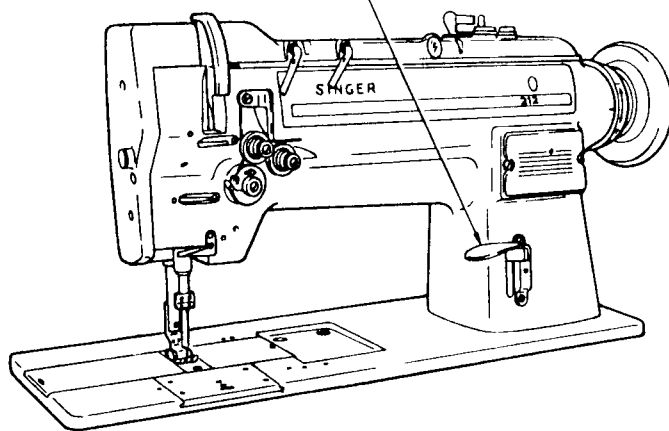


CAUTION:

Never depress the button while the machine is running. Make certain that the button is disengaged before starting machine.

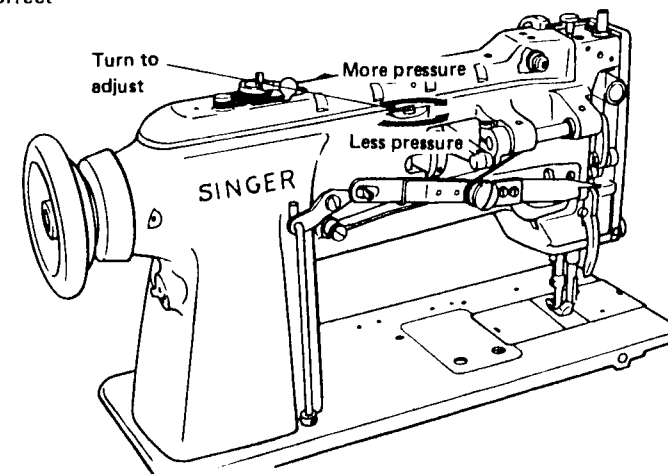
CHANGING TO REVERSE FEED

Push lever down for reverse feed and release for forward feed.



PRESSER FOOT PRESSURE

The pressure on the material should be as light as possible, while still sufficient to insure correct feeding.



CLEANING

Clean out any lint or other waste around the hook, between the feed rows on the underside of the throat plate and in the hook area of the oil pan.

