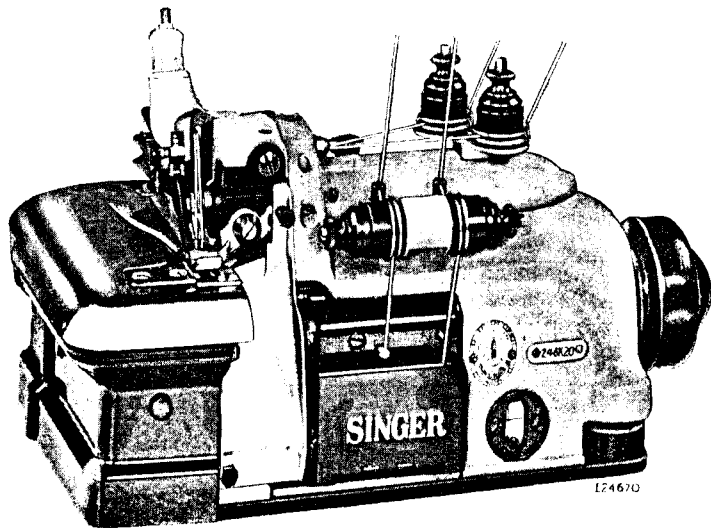


SINGER
246K20

INSTRUCTIONS
FOR USING
SINGER*
SEWING MACHINE
246K20

FOR TRIMMING AND OVEREDGING IN ONE OPERATION
TWO NEEDLES AND TWO LOOPERS
AUTOMATIC OILING SYSTEM



Special attention is called to the lubricating instructions on page 3

THE SINGER MANUFACTURING COMPANY

*A Trade Mark of THE SINGER MANUFACTURING COMPANY

DESCRIPTION

Machine 246K20 has two needles and two loopers and is fitted with a trimmer for simultaneously trimming and overedging bathing suits, house dresses and similar articles. It makes a strong **four-thread** chain stitch consisting of overedge stitching and a single line of re-inforcing stitching running parallel and close to the overedging on the upper side of the fabric. The overedge stitch comprises the thread from right hand needle and the two looper threads: the threads carried by the left hand looper and the left hand needle form the re-inforcing stitch which is interwoven with the overedge stitch on the underside of the fabric. A differential feed permits gathering and stretching or uniform feeding, as desired.

Clearance under presser foot is **1/4** inch.

Needle gauges are **.109 (7/64)** inch and **1/16** inch. Unless otherwise ordered, the machine will be furnished with needle gauge of **.109** inch.

The machine is equipped with a small "horn" beneath the throat plate to aid in tubular work.

The trimmer can be adjusted to trim from **3/32** inch to **7/32** inch from the needles. The knife trims ahead of the needles.

The machine can be fitted for a bight from **3/32** inch to **5/32** inch, depending upon the material and the thread in use.

Although the machine is regularly furnished with a foot lifter, a knee lifter will be furnished instead, when specified on order.

The presser foot can be readily thrown out of operating position, to prevent interference when threading the machine or replacing the needles.

The cloth plate can be swung out 170° to the left of the needles, to facilitate adjustment of the machine.

The loopers are independently driven, permitting variations in their adjustment in relation to each other and to the needles, to suit the work being sewn.

The splash lubricating system automatically and continuously oils the principal bearings, during the operation of the machine. This oiling system also includes an oil sight gauge in the front of the machine, to indicate the oil level to the operator at a glance, and an oil cooling tank in the rear of the machine.

When the machine is in operation, the top of the machine pulley must **always turn over away from the operator.**

TO OIL THE MACHINE

Use "**TYPE A**" OIL, sold by Singer Sewing Machine Company. For description of this oil, see inside front cover of this book.

APPLY "**TYPE A**" OIL
TO OIL FILLER CUP



KEEP OIL SIGHT
GAUGE
HALF FULL

CHECK OIL
LEVEL DAILY
BEFORE STARTING
MACHINE



Fig. 2. Oiling

Check the oil sight gauge **daily, before starting the machine.** Oil the machine, when necessary, as instructed in **Fig. 2,** above.

NEEDLES AND THREAD

Needles for this machine have a curved blade.

When distance between needles is **.109** (approximately **7/64**) inch, use needles of **Class and Variety 151 x 7,** in sizes 9, 11, 12, 14, 16 and 18.

When distance between needles is **1/16** inch: use needles of **Class and Variety 151 x 9** in sizes 9, 11 and 14.

These needles are made in standard finish in sizes 9 and 11 and in nickel finish for size 14 and up. Special sizes or finishes, such as **chrome-plated** needles for nylon materials, will be made on request.

The size of the needle to be used should be determined by the size of the thread, which must pass freely through the eye of the needle. The use of rough or uneven thread, or thread which passes with difficulty through the eye of the needle, will interfere with the proper formation of the stitch.

Orders for needles must specify the **quantity** required, the size number, also the **Class and Variety** numbers, separated by an **x.**

The following is an example of an intelligible order:

"100 No. 9, 151 x 7 Needles."

The best stitching results will be obtained in using the needles sold by Singer Sewing Machine Company.

TO SET THE NEEDLE
Using Socket Wrench No. 164197

Move needle carrier up to its highest point, then insert needles as instructed in steps 1 to 6 in Fig. 3.

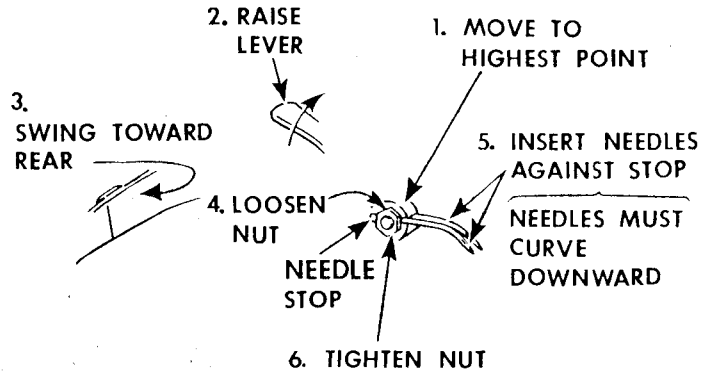


Fig. 3. Setting the Needle

When needles are correctly inserted in needle clamp, securely tighten needle clamping nut.

TO PREPARE FOR THREADING

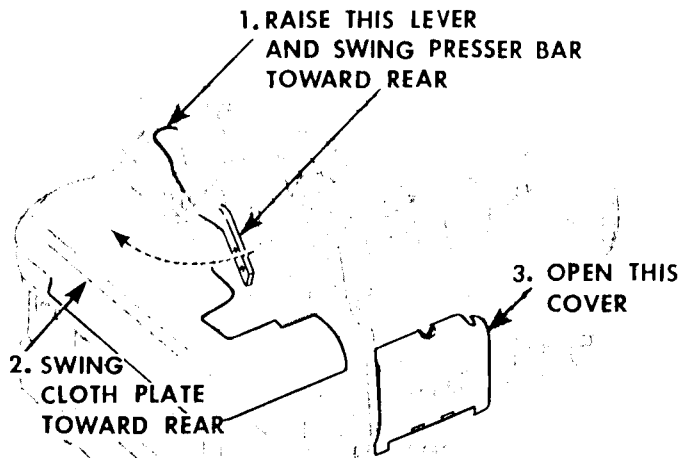


Fig. 4. Preparation for Threading

For convenience in threading, swing presser bar and cloth plate toward rear of machine and open front cover plate, as instructed in Fig. 4.

TO THREAD UNWINDER 151163

To thread this unwinder, pass each thread through threading points in the order shown in Fig. 5.

Broken (dash) line indicates right needle thread.
Double line indicates left needle thread.
Dotted line indicates right looper thread.
Solid line indicates left looper thread.

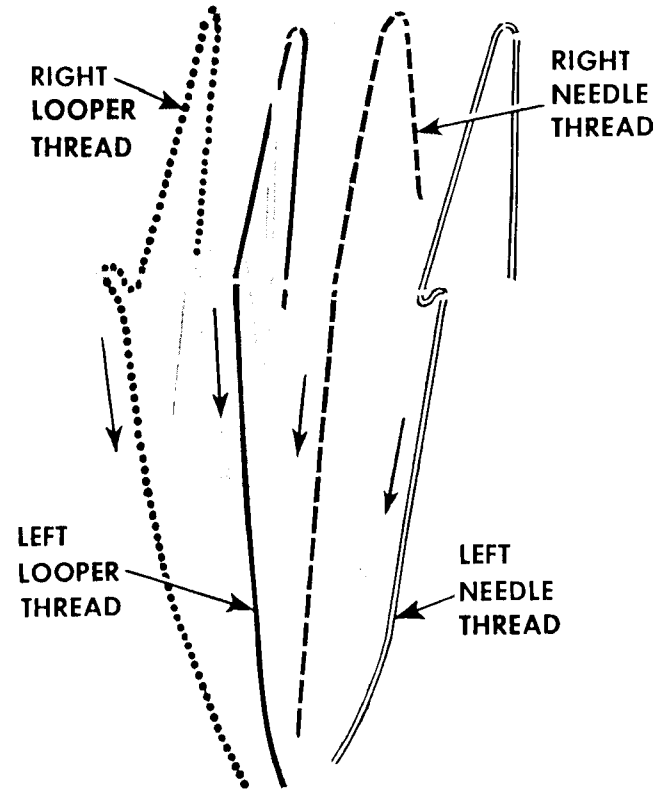


Fig. 5. Threading Unwinder 151163

TO THREAD THE MACHINE

Pass each thread through threading points in the order shown in Figs. 6 to 10.

Thread right needle thread, indicated by broken (dash) line, first.
Thread left needle thread, indicated by double (open) line, second.

6

Thread right looper thread, indicated by dotted line, next. Thread left looper thread, indicated by solid line, last.

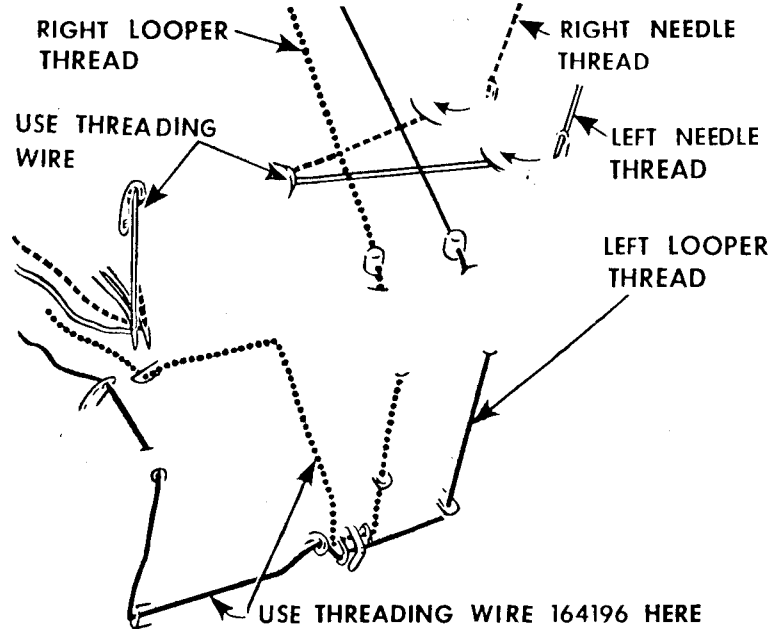


Fig. 6. Threading the Machine

NOTE : Use threading wire 164196 shown at right, to pass thread through threading tubes, as instructed in Fig. 6.

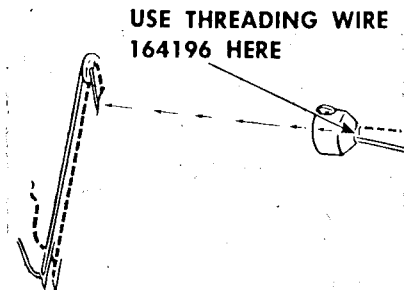


Fig. 8. Threading Needle Thread Eyelet

Draw about two inches of thread through each needle eye.

Fig. 7. Threading Wire 164196

THREADING NEEDLE THREADS :

Before passing needle threads through threading tubes, turn machine pulley over away from operator until needles are at their lowest position.

After threading needle thread eyelet, as shown in Fig. 8, raise needles to highest position and pass each needle thread from front to rear through the eye of its respective needle.

7

THREADING LOOPER THREADS (see Figs. 6, 9 and 10) :

CAUTION : When threading right looper, be sure there is no loose loop of thread on end of looper (see Fig. 9) to cause thread breakage.

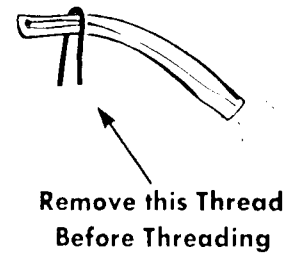


Fig. 9. Right Looper

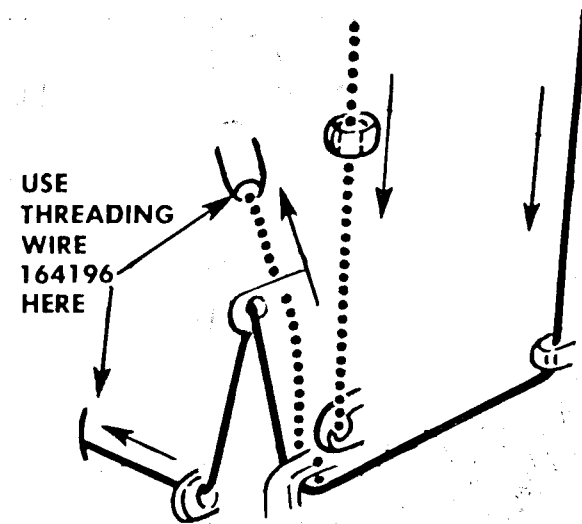


Fig. 10. Threading Looper Take-up

Before passing each looper thread through its threading tube, turn machine pulley over away from operator until eye of looper to be threaded is directly in line with threading tube.

Draw about two inches of thread from front to rear through eye of each looper.

TO REGULATE THE TENSIONS

Tensions on the needle threads should be just sufficient to set the stitches properly in the material.

For average sewing the tensions of the looper threads should be very light.

The thread tensions are regulated as instructed in Fig. 11, below.

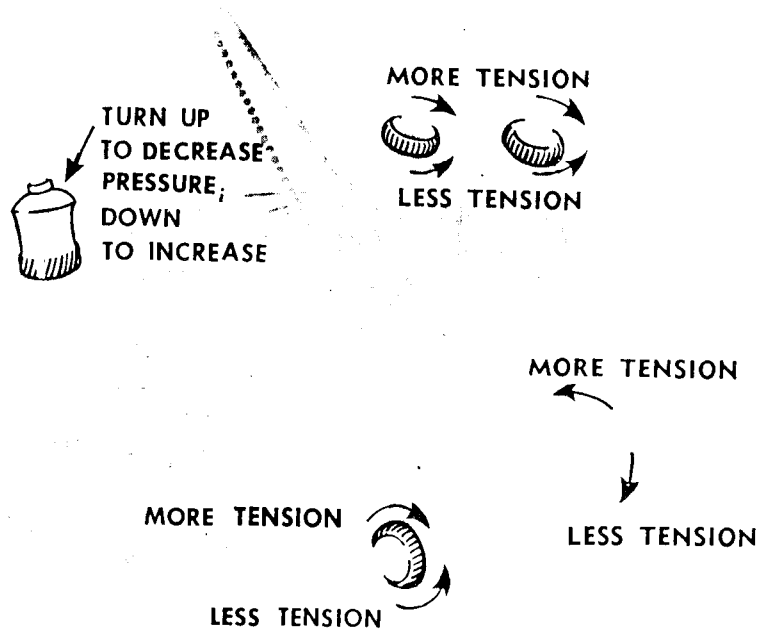


Fig. 11. Regulating Thread Tensions and Pressure on Material

TO REGULATE THE PRESSURE ON THE MATERIAL.

Always use the **lightest** pressure possible to permit higher working speeds.

Regulate the pressure on the material as instructed in Fig. 11.