

SINGER
19-18

USE ONLY **SINGER*** OILS and LUBRICANTS

*They insure freedom from lubricating trouble and
give longer life to sewing equipment*

The following are the correct lubricants for this machine:

TYPE B — MANUFACTURING MACHINE OIL, HEAVY
GRADE

When a stainless oil is desired, use:

TYPE D — MANUFACTURING MACHINE OIL, STAIN-
LESS, HEAVY GRADE

OTHER **SINGER** LUBRICANTS

TYPE E — STAINLESS THREAD LUBRICANT

For lubricating the needle thread of sewing machines for
stitching fabrics or leather where a stainless thread lubri-
cant is required.

TYPE F — MOTOR OIL

For oil lubricated motors and plain bearings in power
tables and transmitters.

NOTE: All of the above oils are available in 1 quart,
1 gallon and 5 gallon cans or in 55 gallon drums.

GEAR LUBRICANT

This specially prepared grease is recommended for gear
lubrication on manufacturing sewing machines.

BALL BEARING LUBRICANT

This pure grease is specially designed for the lubrication
of ball bearings and ball thrust bearings of motors and
electric transmitters, ball bearing hangers of power tables,
etc. Furnished in 1 lb. and 4 lb. tins.

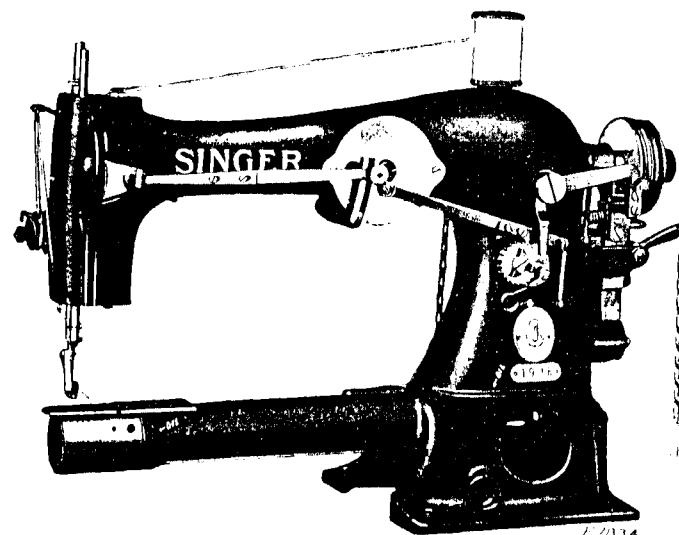
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INSTRUCTIONS

FOR USING

SINGER* SEWING MACHINE



19-18

OVERSEAMING LOCK STITCH

*A Trade Mark of

THE SINGER MANUFACTURING COMPANY

TO ALL WHOM IT MAY CONCERN:

The improper placing or renewal of the Trade Mark "SINGER" or any other of the Trade Marks of The Singer Manufacturing Company (all of which are duly Registered Trade Marks) on any machine that has been repaired, rebuilt, reconditioned, or altered in any way whatsoever outside a SINGER factory or an authorized SINGER agency is forbidden.

THE IMPORTANCE OF USING **SINGER** PARTS AND NEEDLES IN **SINGER** MACHINES

The successful operation of SINGER machines can only be assured if SINGER parts and needles are used. Supplies are available at all SINGER Shops for the Manufacturing Trade, and mail orders will receive prompt attention.

SINGER Needles should be used
in SINGER Machines.
These Needles and their Containers
are marked with the
Company's Trade Mark "SINGER."

Needles in Containers marked
"FOR SINGER MACHINES"
are NOT **SINGER** made needles.

DESCRIPTION

Machine 19-18 makes the lock stitch and is especially designed for tacking bows, buckles and ornaments on shoes, after lasting.

The machine has no feeding mechanism. Each bow or buckle is securely attached with fourteen overseaming stitches, the machine being instantly adjusted to make a stitch up to $\frac{1}{4}$ inch in length. At the completion of the fourteenth stitch the machine is automatically stopped by an efficient stop motion mechanism.

An advantage is afforded by the small diameter of the cylinder bed $1\frac{1}{8}$ inches - which permits attaching buckles or bows to shoes after they have been completed instead of before the lasting and in addition makes the machine useful for a large variety of work.

Two presser feet are regularly furnished with the machine. One of these presser feet, 17490, is narrow in shape, enabling the operator to have an unobstructed view of the buckle while it is being attached. The other presser foot, 17493, is wider and is furnished blank so that it can be filed to accommodate buckles or other ornaments beyond the capacity of presser foot 17490.

As regularly sent out, the machine is fitted with stitch ratchet wheel 17477 for making fourteen stitches to each tack. For tacks consisting of three stitches, use stitch ratchet wheel 22708; for tacks of eight stitches, use stitch ratchet wheel 17478, and for tacks of nine stitches, use stitch ratchet wheel 22707. Any one of these will be furnished, on order, in place of the regular ratchet wheel 17477.

Any of the above ratchet wheels can be supplied in addition to the ratchet wheel ordered with the machine, in which case additional charge will be made for the extra ratchet wheel or wheels.

This machine is also satisfactorily used for tacking buckles on knickers, vests, boy's pants, etc.

Speed

The maximum speed recommended for Machine 19-18 is 800 stitches per minute. When the machine is in operation, the driving pulley should always turn over toward the right.

To Oil the Machine

When the machine is received from the factory, it should be thoroughly cleaned and oiled. Use "TYPE B" or "TYPE D" OIL, sold only by Singer Sewing Machine Company. For description of these oils, see inside front cover.

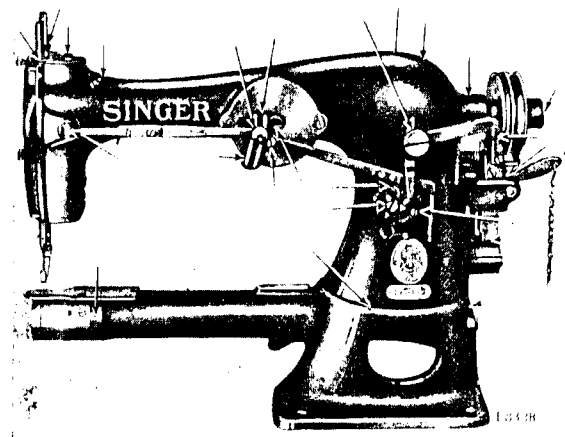


FIG. 2. OILING POINTS AT THE RIGHT OF THE MACHINE

Oil should be applied to all places where there are parts in movable contact and to all oil holes designated by arrows in Figs. 2, 3 and 4. When the machine is in continuous use, it should be oiled at least twice each day.

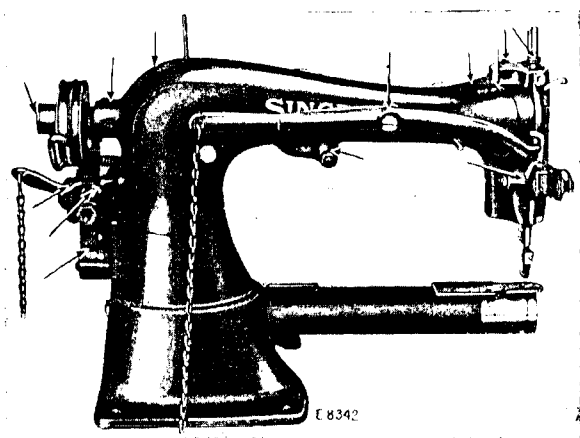


FIG. 3. OILING POINTS AT THE LEFT OF THE MACHINE

Remove the three screws which fasten the face plate to the machine, remove the face plate and apply oil to the oil holes and

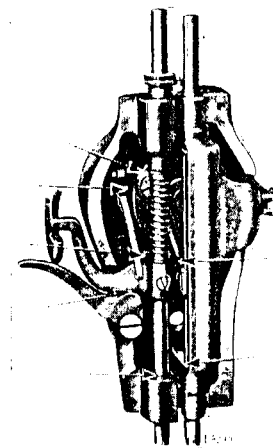


FIG. 4. END VIEW OF MACHINE, SHOWING OILING POINTS

bearings indicated by arrows in Fig. 4, then replace the face plate and its three screws.

Oil the shuttle bearing in the shuttle race each time a bobbin is replaced.

Needles

Needles for Machine 19-18 are of Class and Variety 31x1 and are furnished in size 17.

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. Do not use rough or uneven thread, or thread which passes with difficulty through the needle eye, as such thread interferes with the successful use of the machine.

Orders for needles must specify the *quantity* required, the *size* number, also the *class* and *variety* numbers separated by the letter x.

The following is an example of an intelligible order:

"100 No. 17, 31 x 1 Needles."

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

Thread

Left twist thread should be used in the needle. Either right or left twist can be used in the bobbin.

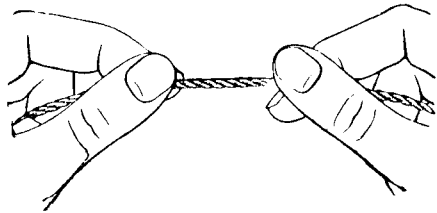


FIG. 5. HOW TO DETERMINE THE TWIST

Hold the thread as shown above. Turn the thread over toward you between the thumb and forefinger of the right hand; if left twist, the strands will wind tighter; if right twist, the strands will unwind.

To Remove the Bobbin

Open the bobbin case latch and draw the bobbin case toward you to remove it from the machine. While the latch remains open, the bobbin is retained in the bobbin case. Release the latch, turn the open end of the bobbin case downward and the bobbin will drop out.

To Wind the Bobbin

Fasten the bobbin winder to the table with its driving pulley at the right of the machine belt so that the pulley will drop away from the belt when sufficient thread has been wound upon the bobbin.

Place the bobbin on the bobbin winder spindle and push it up closely against the shoulder, having the small pin in the shoulder enter the slot in the bobbin.

Place the spool of thread on the pin of the bobbin winder spool stand. Pass the thread from the spool between the tension discs on the spool stand, then wind the end of the thread around the bobbin a few times and push the bobbin winder driving pulley over against the machine belt. When sufficient thread has been wound upon the bobbin, the bobbin winder will stop automatically. Bobbins can be wound while the machine is stitching.

To Thread the Bobbin Case

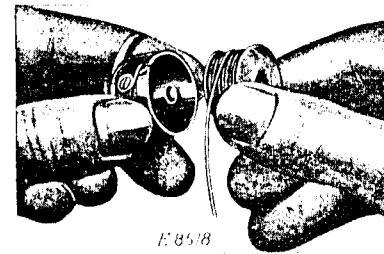


FIG. 6

Hold the bobbin between the thumb and forefinger of the right hand as shown in Fig. 6, the thread drawing on top from the right toward the left.

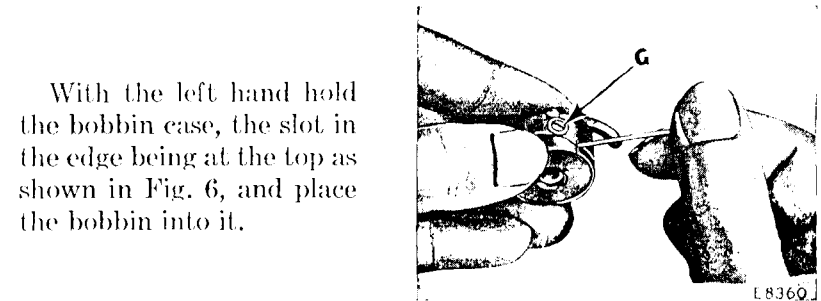


FIG. 7

With the left hand hold the bobbin case, the slot in the edge being at the top as shown in Fig. 6, and place the bobbin into it.

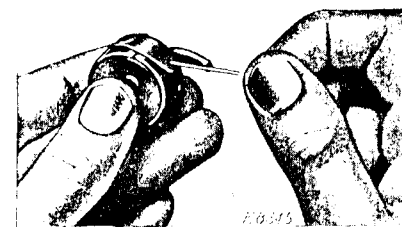


FIG. 8

Then pull the thread into the slot in the edge of the bobbin case as shown in Fig. 7, and draw the thread down under the tension spring and into the delivery eye at the end as shown in Fig. 8.

To Replace the Bobbin Case

After threading, take the bobbin case by the latch, holding it between the thumb and forefinger of the left hand as shown in

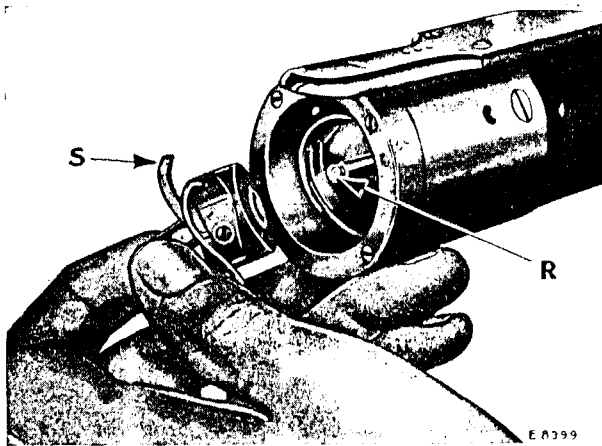


FIG. 9. REPLACING THE BOBBIN CASE

Fig. 9. Place the bobbin case on the center stud (R) of the shuttle body with the position finger (S) opposite the notch at the top of the shuttle race. Release the latch and press the bobbin case back until the latch catches the groove near the end of the stud. Allow about three inches of thread to hang free.

To Set the Needle

Loosen the set screw in the lower end of the needle bar and put the needle up into the bar as far as it will go with its long groove toward you and the eye directly in line with the arm of the machine, then tighten the screw.

To Thread the Needle

Pass the thread from the spool on the spool pin at the top of the machine, over toward you between the thread retainer discs

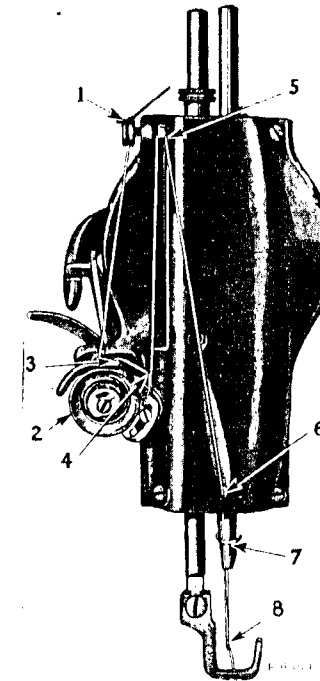


FIG. 10. THREADING THE NEEDLE

(1, Fig. 10), down and under from left to right between the tension discs (2), up back of the tension thread guard (3), down into the loop of the thread take-up spring (4), up and from left to right through the hole in the end of the thread take-up lever (5, Fig. 10), down through the hole (6) in the lower end of the face plate, into the thread guide (7) and away from you through the eye of the needle (8). Draw about three inches of thread through the eye of the needle with which to begin sewing.

To Commence Sewing

With the left hand take hold of the needle thread (leaving it slack between the hand and the needle) and with the right hand turn the driving pulley over from left to right until the needle moves down and up again to its highest point, thus catching the shuttle thread. Draw up the needle thread and the bobbin thread will come up with it through the hole in the throat plate; draw up the bobbin thread and lay both threads back under the presser foot, then place the material beneath the needle, lower the presser foot upon it and commence to sew, making sure that the pulley turns over from left to right.

To Regulate the Tensions

The tension on the needle thread should be regulated only when the presser foot is down. Having lowered the presser foot, turn the small thumb nut (F, Fig. 11) at the front of the tension discs over to the right to increase the tension. To decrease the tension, turn this thumb nut over to the left.

The tension on the bobbin thread is regulated by the screw (G, Fig. 7) in the bobbin case tension spring. To increase the tension, turn this screw over to the right. To decrease the tension, turn the screw over to the left.

When the tension on the bobbin thread has been once properly adjusted it is seldom necessary to change it, as a correct stitch can usually be obtained by varying the tension on the needle thread.

To Change the Length of the Overseaming Stitch

The length of the overseaming stitch or extent of the lateral vibrations of the needle is regulated by raising or lowering the rear end of the needle vibrating connection (E, Fig. 11) which is fastened to the sliding block located in the slotted lever at the right of the machine. To increase the length of stitch, loosen the thumb nut (B, Fig. 11) which locks the sliding block in position and raise the rear end of the needle vibrating connection (E). To shorten the stitch, lower the rear end of the needle vibrating connection (E). When the desired length of stitch is made, securely tighten the thumb nut (B) to lock the sliding block in position in the slotted lever.

To Regulate the Pressure on the Material

The pressure on the material is regulated by the thumb screw (A, Fig. 11) on the top of the machine. To increase the pressure,

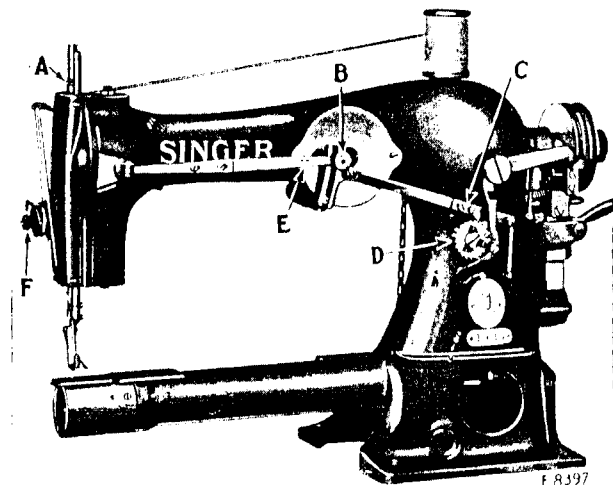


FIG. 11

turn the thumb screw (A) over to the right. To decrease the pressure, turn the thumb screw over to the left. The pressure should be only heavy enough to prevent the material from rising with the needle.

To Change the Stitch Ratchet Wheel

Take out the screw which holds the stitch ratchet wheel (D, Fig. 11) in position at the right side of the upright part of the arm and remove the stitch ratchet wheel.

Place the desired stitch ratchet wheel in position on the machine, being careful to have the pawls properly enter the teeth, then replace and securely tighten the screw which holds the ratchet wheel in position. After changing the stitch ratchet wheel, run the machine to its regular stopping position before commencing to sew.

When changing the ratchet wheel (D) for another having a different number of teeth, it may be necessary to change the adjustment of the ratchet wheel driving lever pawl (C, Fig. 11) so as to have the pawl (C) properly engage the teeth. To make this adjustment, loosen the two screws which hold the pawl (C) in position and move the pawl forward or backward, as required, then securely tighten the two screws.