

SINGER
246-12

USE SINGER OILS and LUBRICANTS

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

*The following is the correct lubricant for
Machines of Class 246:*

TYPE A—MANUFACTURING MACHINE OIL, LIGHT GRADE

OTHER SINGER LUBRICANTS

TYPE E—THREAD LUBRICANT

For lubricating the needle thread of sewing machines for stitching fabrics or leather where a thread lubricant is required.

TYPE F—MOTOR OIL

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

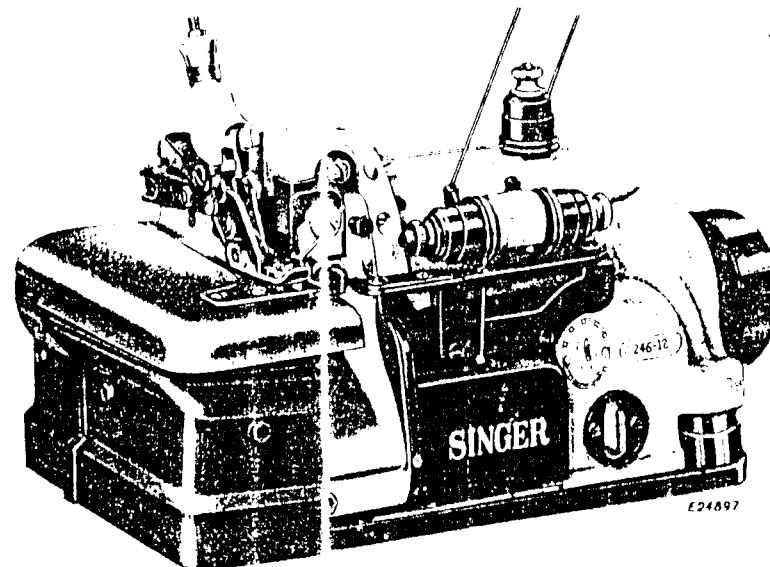
NOTE: All of the above oils are available in 1 quart, 1 gallon and 5 gallon cans.

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.

20739

INSTRUCTIONS FOR USING SINGER SEWING MACHINE 246-12 FOR PANTS SERGING AUTOMATIC OILING SYSTEM



Special attention is called to the lubricating instructions on page 4.

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 "SIMANCO." 1

Needles in Containers marked
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DESCRIPTION

Machine 246-12, designed for high speed pants serging, has one needle, one looper and one spreader and makes the two-thread serging stitch (Federal Stitch Type #503). It will stitch material up to 3/16 inch in thickness.

The machine can be fitted to make a three-thread tight stitch (Federal Stitch Type #504) by substituting a right hand looper with controller #164151 for the regular spreader and controller furnished with the machine. The machine can also be changed to make a purl-on-the-edge stitch (Federal Stitch Type #505) by substituting take-ups 164287 and 164288, Figs. 13 and 15, page 11 for the regular take-ups.

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

The trimmer can be adjusted to trim up to 1/4 inch from the needle.

The machine can be fitted for a bight up to 1/4 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 thrown out of operating position when threading the machine or replacing the needle.

The fittings for this machine are designed so that the control of the thread-chain is retained as long as the presser foot is engaged with the feed dog, enabling the operator to break the chain manually without losing control of the chain or distorting the thread loops.

The looper and the spreader are independently driven, permitting variations in their adjustment in relation to each other and to the needle, 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 and an oil cooling tank in the rear of the machine. See X-Ray View of machine on pages 6 and 7.

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 and oil the machine, when necessary, as instructed in Fig. 2, above.

NEEDLES AND THREAD

Needles for this machine are of curved blades, Class and Variety 151 x 1, in sizes 9, 11, 14 and 16. Needles of Class and Variety 151 x 3, in sizes 5, 6 and 7, are recommended for sewing nylon. Special sizes or finishes, such as chrome-plated needles, 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 1 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 #164197

Move needle carrier up to its highest point, then insert needle as instructed in steps 1 to 7 in Fig. 3.

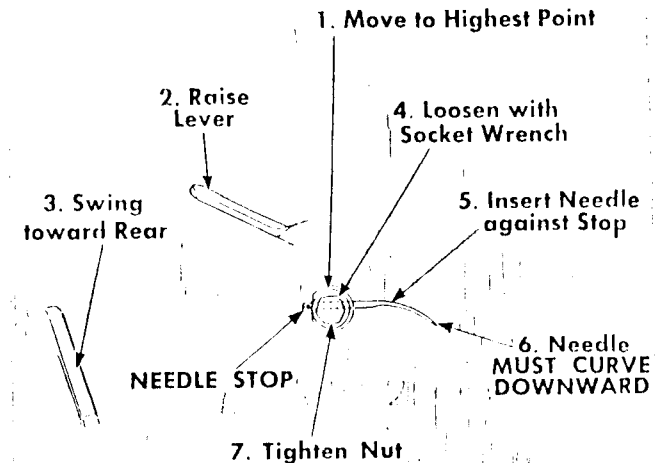


Fig. 3. Setting the Needle

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

TO PREPARE FOR THREADING

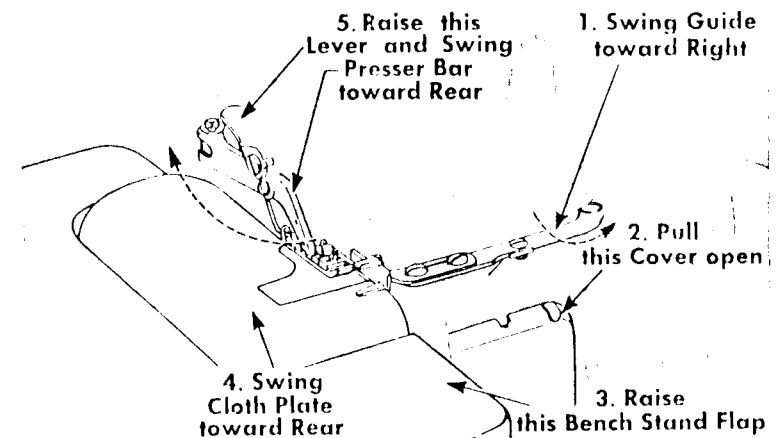


Fig. 4. Preparation for Threading

For convenience in threading, swing presser bar, cloth plate and edge guide out of position and open front cover plate and bench stand flap, as instructed in Fig. 4.

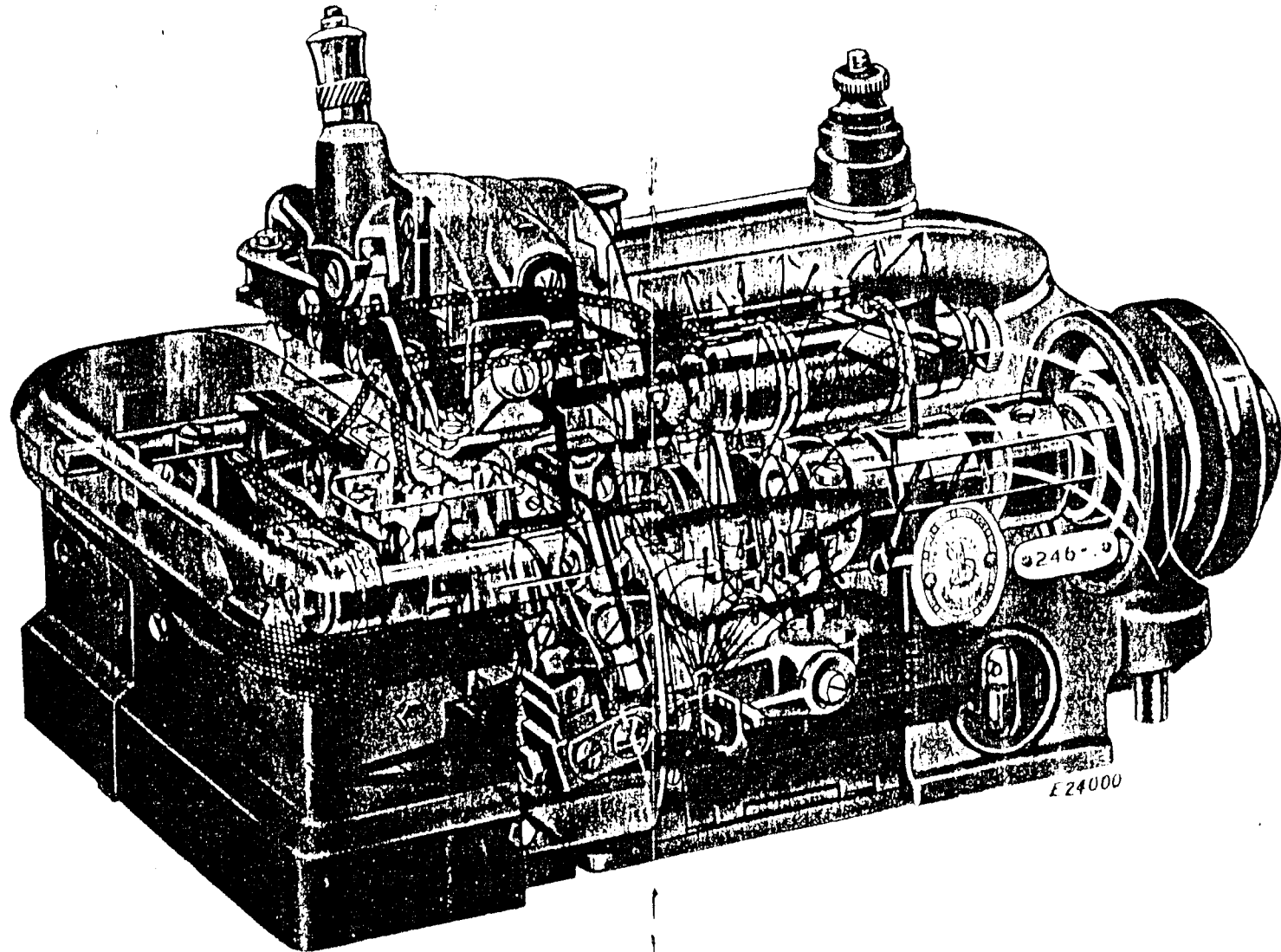


FIG. 5. SHOWING AUTOMATIC LUBRICATION SYSTEM
(Lubrication Shown In Solid Black)

TO THREAD UNWINDER 151031
For Two-Thread Serging Stitch

To thread this unwinder, pass each thread through threading points in the order shown in Fig. 6. Solid line indicates the looper thread. Double line indicates the needle thread.

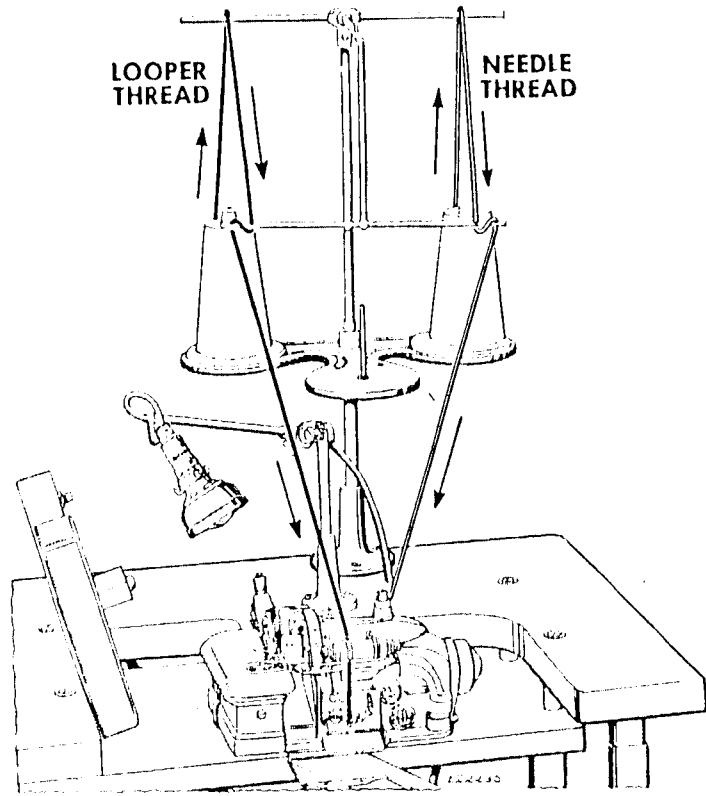


Fig. 6. Threading Unwinder 151031

NOTE: When sewing with nylon thread, thread unwinder 228076 may be ordered if desired.

TO THREAD THE MACHINE
For Two-Thread Serging Stitch

To thread the machine, pass each thread through threading points as shown in Figs. 7 and 8. Solid line indicates looper thread. Double line indicates needle thread.

USE THREADING WIRE 164196 HERE

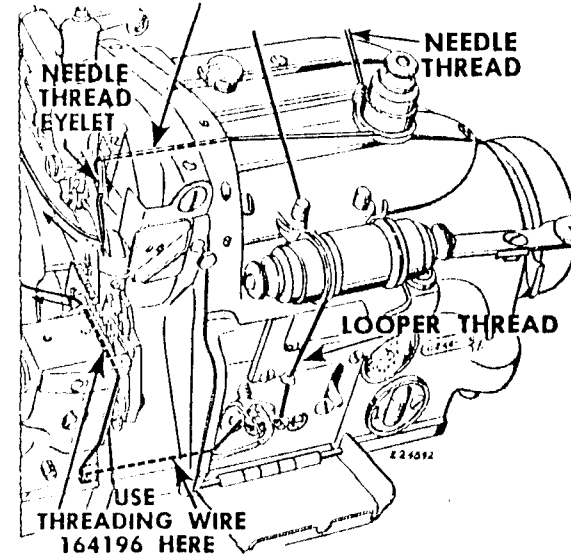


Fig. 7. Threading the Machine

NEEDLE THREAD: Before passing needle thread through its threading tube, turn machine pulley over toward you until needle is at its lowest position.

Note particularly the correct position and method of threading needle thread eyelet as shown in Fig. 7.

After threading needle thread eyelet, raise needle to its highest position and pass the thread from front to rear through the needle eye.

LOOPER THREAD: Turn machine pulley over from you until eye of looper is directly in line with the tube underneath the throat plate.

BOTH THREADS: Use threading wire 164196, shown below, to pass each thread through its threading tube, as instructed in Fig. 7.

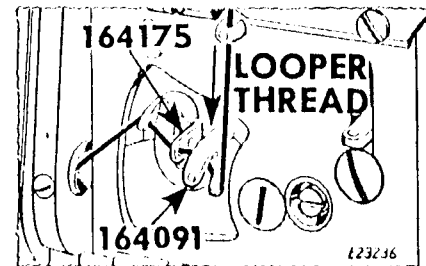


Fig. 8. Threading Looper Take-up

Draw about two inches of thread through needle eye and through looper eye, with which to commence sewing.

Fig. 9. Threading Wire 164196

**TO THREAD THE MACHINE
For Three-Thread Tight Stitch**

Pass the threads through the threading points, as shown in Figs. 10 through 13.

IMPORTANT:

The needle thread should be completely threaded first.

The right looper thread should be completely threaded next.

The left looper thread should be completely threaded last.

Note particularly the correct position of the needle thread eyelet, shown in Fig. 11 and of fitting and threading the looper take-up, as shown in Fig. 13.

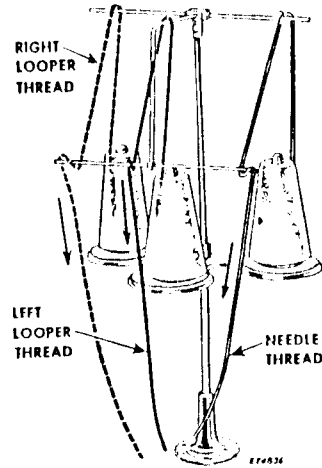


Fig. 10. Threading Unwinder 151031

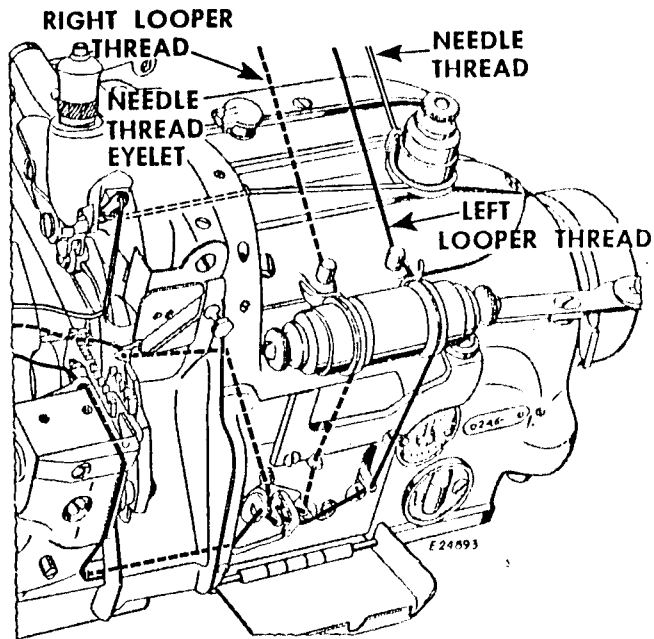


Fig. 11. Threading the Machine

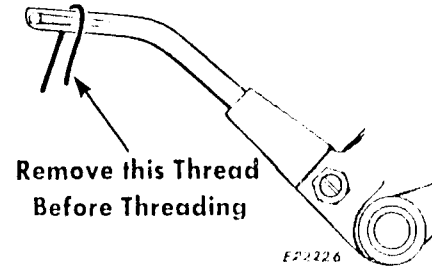


Fig. 12. Right Looper

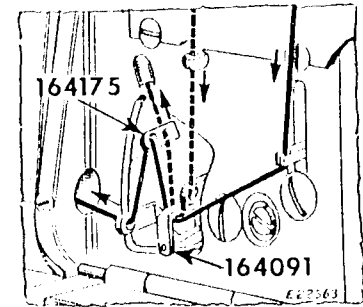


Fig. 13. Threading Looper Take-up (Three-Thread Tight Stitch)

CAUTION: When threading right looper, be sure that there is no loose loop of thread on end of looper (see Fig. 12) to cause thread breakage.

**TO THREAD THE MACHINE
For Three-Thread Purl-on-the-Edge Stitch**

The machine and the thread unwinder are threaded for three-thread purl-on-the-edge stitch in the same manner as for three-thread tight stitch (see Figs. 10 to 13) with the following exceptions:

The needle thread eyelet must be positioned and threaded as shown in Fig. 14.

The looper take-up must be positioned and threaded as shown in Fig. 15.

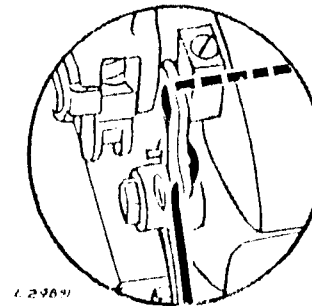


Fig. 14. Threading Needle Thread Eyelet (Purl-on-the-Edge Stitch)

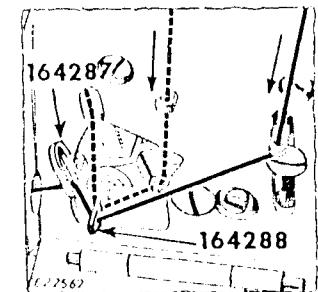


Fig. 15. Threading Looper Take-up (Purl-on-the-Edge Stitch)

TO REGULATE THE TENSIONS

The tension on the **needle thread** should be **just sufficient to set the stitch properly** in the material.

For average sewing the tension of the looper thread should be **very light**.

The thread tensions are regulated as instructed in **Fig. 16**.

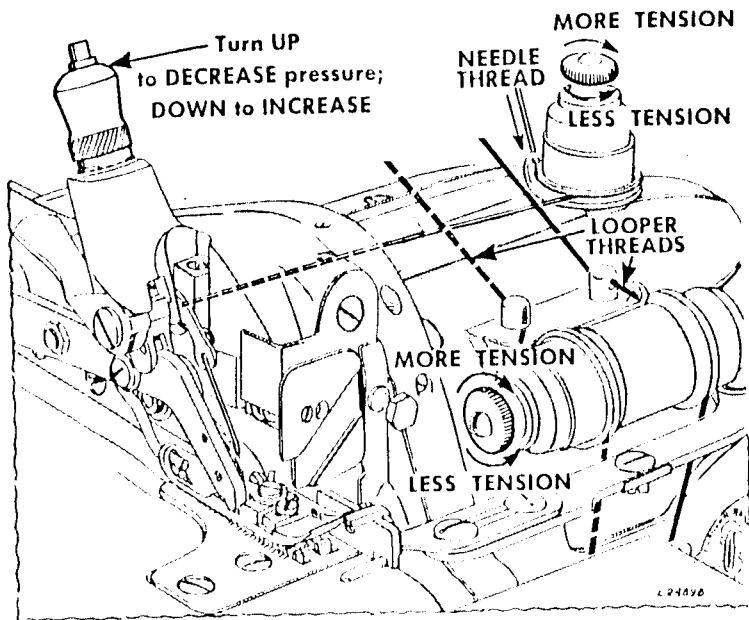


Fig. 16. Regulating Thread Tensions and Pressure on Material

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. 16**.

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