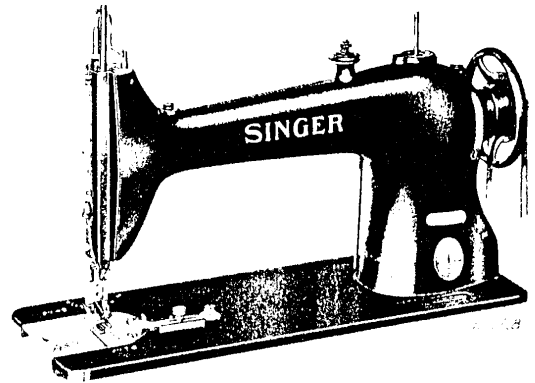


SINGER

55-20

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INSTRUCTIONS
FOR USING AND ADJUSTING
SINGER SEWING MACHINE
55-20



SINGLE NEEDLE
SINGLE THREAD CHAIN STITCH

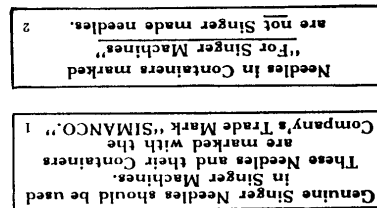
THE SINGER MANUFACTURING CO.

To all whom it may concern:

"The placing or renewal of the name "Singer" (Reg. U. S. Pat. Off.) or any of the trade marks of The Singer Manufacturing Company 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 GENUINE SINGER PARTS AND NEEDLES IN SINGER MACHINES

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



To Change the Sidewise Position of the Loopers Relative to the Needle

The looper should be set so that its point comes as close as possible to the center of the clearance in the needle without striking it on the upward stroke of the needle bar. To adjust the looper, loosen the set screw (M, Fig. 3) and move the looper toward or away from the needle as required, then securely tighten the screw (M). Make certain that the screw (M) rests on the flat provided for it on the looper shaft.

To Set the Slack Thread Regulator

The purpose of the slack thread regulator (6, Fig. 4) is to regulate the amount of thread drawn through the tension discs at the finish of the upward stroke of the needle bar. To adjust, loosen the screw which holds the slack thread regulator to the top of the presser bar and move the regulator up or down until its horizontal arm is 5/8 inch from the top of the machine casting, then tighten the screw. This adjustment should only be made when the presser foot is raised all the way up, in which position, the distance from the bottom of the presser foot to the throat plate should be 7/16 inch.

To Time the Feeding Mechanism

The feeding mechanism should be timed so that the feed dog starts its feeding movement when the needle bar commences its upward stroke and finishes before the needle enters the goods. If it is necessary to time the feed, loosen the thumb screw of the cover plate on the back of the upright part of the arm and turn up the cover plate. Loosen the two feed eccentric set screws inside the arm and turn the balance wheel until the feed is correctly timed as instructed above. Then securely tighten the two set screws.

To Raise or Lower the Feed Dog

The feed dog should be set so that when it is raised to its highest point, the full depth of the teeth project above the upper surface of the throat plate. If the feed dog is not set at the correct height, loosen screw (A, Fig. 3) and raise or lower the feed dog as required, then securely tighten the screw (A).

To Set the Needle Bar at the Correct Height

See that the needle is pushed up into the needle bar as far as it will go. Set the needle bar so that when it reaches the lowest

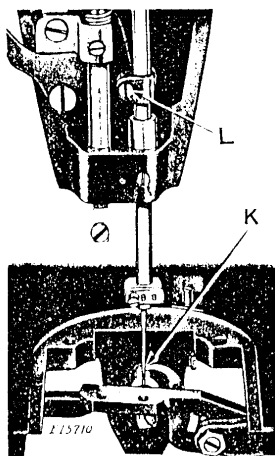


Fig.5 Needle Bar Set at Correct Height

position on its downward stroke, the distance from the top of the needle bar to the top of the machine casting will be $7/8$ inch.

If the needle bar is not set at the correct height, remove the face plate and loosen the needle bar connecting stud clamp screw (L, Fig.5). Raise or lower the needle bar to the required height, then securely tighten the screw (L).

To Time the Looper

With the needle bar at its lowest position, turn the balance wheel toward you so that the needle bar moves up $1/8$ inch. In this position, the point of the looper should be at the center of the needle and slightly above the needle eye as shown at (K, Fig.5).

If the looper is out of time, loosen the two screws (B, Fig.3) on the looper shaft and move the looper as required. Then tighten the screws (B).

DESCRIPTION

Machine 55-20 is especially designed for basting materials up to $3/8$ inch in thickness, and is adjustable for stitches from $1/4$ inch to $1/2$ inch in length.

The working space at the right of the needle is $10 \frac{1}{8}$ inches.

This machine is provided with a single needle and a gear-driven rotary looper, and produces the single-thread chain-stitch. It is regularly equipped with a compensating presser foot and an adjustable guide for basting a wide range of fabrics.

The compensating presser foot adapts itself to any variations in the thickness of the material being sewn.

The adjustable guide is hinged and may be turned aside when not in use.

Speed

The machine can be operated at speeds up to 3000 stitches per minute when producing stitches $1/4$ inch in length, or 2800 stitches per minute for $1/2$ inch stitches, depending upon the nature of the material being sewn. The machine should be run at less than these maximum speeds until the parts which are in movable contact have become glazed by their action upon each other.

INSTRUCTIONS FOR ADJUSTERS AND MACHINISTS

To insure easy running and prevent unnecessary wear of the parts which are in movable contact, the machine requires oiling and, when in continuous use, the machine should be oiled at least once each day.

To Oil the Machine

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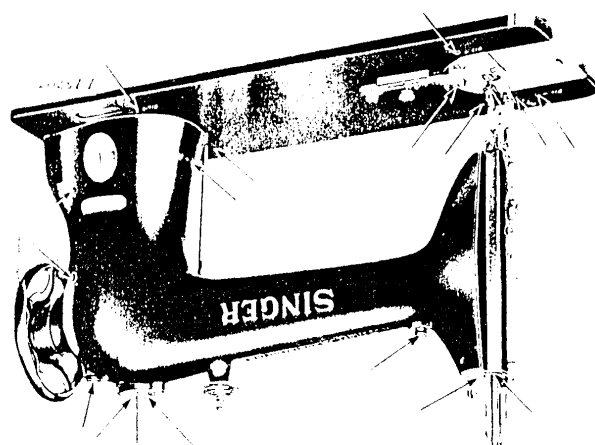


Fig. 2 Front View of Machine Showing Oiling Points

Apply oil to all oil holes in the arm and bed of the machine as indicated by the arrows in Fig. 2. Also apply oil to the oil hole at the top of the lifting lever at the rear side of the machine. Remove the face plate and apply oil to all places in movable contact. Keep all wicking saturated with oil. Turn the machine back on its hinges and apply oil to the parts underneath the machine indicated by the unlabeled arrows in Fig. 3. Occasionally check the grease in gear case (D) and, if low, replenish with Singer Gear Lubricant through the hole at (E) after the removal of the screw. If the machine runs hard after standing for some time, use a little kerosene or benzine on the wearing parts, run rapidly, wipe clean, and then oil as instructed. The machine should always be cleaned and oiled before using.

To Adjust the Work Guide

To adjust the work guide, loosen the thumb screw (G, Fig. 4) and move the guide to the right or left as may be required, then firmly tighten the thumb screw (G, Fig. 4).

The work guide is hinged and can be turned aside, out of the way, when not in use.

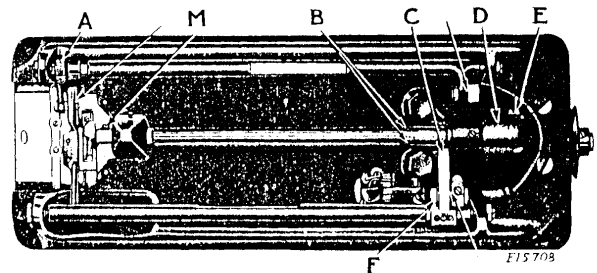


Fig. 3 Base View of Machine

Needles

Needles for Machine 55-20 are of Class and Variety 16x259 and are made in sizes 18, 19, 21 and 22.

The size of the needle to be used is 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 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. 19 16x259 Needles"

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

To Set the Needle

Turn the balance wheel over toward you until the needle bar moves up to its highest position, loosen the set screw in the needle clamp and insert the needle up into the clamp as far as it will go, with the short groove of the needle toward the upright part of the machine arm and with the eye of the needle directly in line with the arm of the machine.