**BRIEF DESCRIPTION**

Single needle, lockstitch machines featuring a unique “walking foot” (Unison Feed) mechanism and cylinder bed.

**APPLICATION**

Binding knit gloves, mattresses, sandals, shoe tongues, button straps, dress shields, shoe uppers, canvas shoes, etc.

**SPECIFICATIONS**

<table>
<thead>
<tr>
<th></th>
<th>108U20</th>
<th>108U30</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vibrating and Lifting Presser Foot Lift</td>
<td>0.10” (2.5mm)</td>
<td>0.14” (3.5mm)</td>
</tr>
<tr>
<td>Bed Dimension at End of Cylinder</td>
<td>1-13/16” (46.0mm)</td>
<td></td>
</tr>
<tr>
<td>Space at Right of Needle</td>
<td>5-3/4” (146.0mm)</td>
<td></td>
</tr>
<tr>
<td>Clearance under Presser Foot</td>
<td>7/32” (5.6mm)</td>
<td></td>
</tr>
<tr>
<td>Max. Stitch Length</td>
<td>8 S.P.I. (3.2mm)</td>
<td></td>
</tr>
<tr>
<td>Max. Speed (RPM)</td>
<td>2,700</td>
<td>2,100</td>
</tr>
<tr>
<td>Needle</td>
<td>Cat. 1451 (135X1)</td>
<td></td>
</tr>
<tr>
<td>Binder (Attached)</td>
<td>Part No. 224710, 0.025-7/16” (standard)</td>
<td></td>
</tr>
<tr>
<td>Binder Tape Guide (Attached)</td>
<td>Part No. 208329, 7/16” (standard)</td>
<td></td>
</tr>
</tbody>
</table>
NEEDLE

Use Singer needle
Catalog 1451 (135X1)

THREADING NEEDLE

Thread only with the needle bar in highest position.
BOBBIN REMOVAL

OPEN LATCH AND PULL BOBBIN FROM HOOK

BOBBIN WINDER

WIND THREAD AROUND BOBBIN

LOosen to adjust for even winding

TENSION CONTROL

PRESS LEVER, THEN START MACHINE

LOosen to adjust for amount of thread

PLACE BOBBIN ON SPINDLE AS FAR AS IT WILL GO
REPLACEMENT AND THREADING BOBBIN

PLACE BOBBIN ON CENTER STUD

THREAD DRAWING ON TOP TOWARD YOU

DRAW THREAD INTO NOTCH

Draw thread up and over bobbin case toward the back of the machine.

Draw up needle thread and bobbin thread will come up.
STITCHING MARGIN

After stitching margin is adjusted, two screws should be tightened firmly.

TO INCREASE MARGIN
MOVE BINDER TO THE LEFT
SCREW

THREAD TENSION

Tension on threads should be as light as possible, while still sufficient to set stitch correctly in material.

Bobbin Thread

Needle Thread

Regulate needle thread tension only when presser feet are down.
STITCH LENGTH REGULATION

Turn regulating dial to desired stitch length.

PRESSER FOOT PRESSURE

The pressure on material should be as light as possible while still sufficient to insure proper feeding.
LUBRICATION

Twice Daily
(More frequently
with severe use)

Use SINGER “TYPE B” or
“TYPE D” OIL.