INSTRUCTION MANUAL

FOR

SINGER®

MACHINES

20U 73
73B
83
83B

THE SINGER COMPANY
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1. APPLICATION

This SINGER Artisan Zigzag Machine is for:
- Zigzag and ornamental stitching in a variety of width and stitch length.
- Perfect straight stitching.
- Superfine control of stitch length insures perfect satin stitching.

Model 20U73/73B (9mm Bight)
20U83/83B (12mm Bight)

This machine is manufactured for artisan zigzag sewing and is suited for sewing light weight and medium weight materials.

2. NOTES ON SAFETY

The machine must only be commissioned in full knowledge of the instruction manual and operated by persons with appropriate training.

Before putting into service, also read the safety notes and the instruction manual of the motor supplier.

The machine must be used only for the purpose intended. Use of the machine without the safety devices belonging to it is not permitted.

When gauge parts are exchanged (e.g., needle, presser foot, needle plate, feed dog and bobbin), during threading, when the workplace is left unattended, and during service work, the machine must be isolated from the mains by switching off the main switch of disconnecting the main plug.

On mechanically operated clutch motors without start inhibitor, it is necessary to wait until the motor has stopped.

General servicing work must be carried out only by appropriately trained persons.

Repairs, conversion and special maintenance work must only be carried out by technicians or persons with appropriate training.

For service or repair work on pneumatic systems, the machine must be isolated from the compressed air supply system. Exceptions to this are only adjustments and function checks made by appropriately trained technicians.

Work on the electrical equipment must be carried out only by electricians or appropriately trained persons.

Work on parts and systems under electric current is not permitted, except as specified in regulations ENS0110.

Conversions or changes to the machine must be made only on adherence to all safety regulations.

For repairs, only replacement parts approved by us must be used.

Commissioning of the sewing head is prohibited until such time as the entire sewing unit is found to comply with EC regulations.

Meanings of the symbols:

Danger spot
Items requiring special attention

Danger of injury to operator or service staff
Be sure to observe and adhere to these safety notes!

Earth

3. COMMISSIONING

To avoid disturbances or damages, it is absolutely necessary to observe the following instructions:

Before you put the machine into operation for the first time, clean it thoroughly and oil it well (see page 2).

Have the mechanic check whether the motor can be used with existing mains voltage or not, and that junction box is correctly connected. Do not start the machine if the voltage is not correct!

When the machine runs, the balance wheel must rotate toward the operator. If it does not, have the electrician change the wires on the motor.
4. INSTALLING THE BELT GUARD

Above table surface
Align the belt guard so that hand wheel and V-belt move freely, then screw it down in this position (see Fig.1).

Below table surface
Install belt guard so that motor pulley and V-belt will rotate freely without interference.

5. LUBRICATION

Switch off the machine,
Set sewing head upright again using both hands.
Danger of crushing between sewing head and table top.

CAUTION

- Rotating hook and area under throat plate.
- Turn hand wheel over toward you until oil hole in rotating hook appears sight.
- Apply one or two drops of oil to the oil hole (see Fig.2)
- Loosen and remove screws and remove face plate by sliding it downward.
- Remove screws and lift off arm top cover.
- Clean and oil the places indicated.
- Apply sufficient oil to all oil felt shown in Fig.3
- Apply a small amount of grease to gear teeth indicated with arrow "Grease" in Fig.3.
- Also apply a drop of oil to all other oiling points shown with marks.
- Keep oil pad (A) under arm top cover saturated with oil.

CHOICE OF OIL

(1) For (2073/73B/83/82B) machines
- Only use oil with a viscosity of 45.0 mm²/sec at 38°C and a density of 0.868 g/cm³ at 15°C.
- We recommend SINGER B-oil.
6. NEEDLE AND THREAD

Selection of the proper needle depends not only on the machine model, but also on the material and thread used. For selection of proper needle and thread sizes to be used on the various machine models please refer to the table below.

<table>
<thead>
<tr>
<th>Application of class</th>
<th>For light-weight materials</th>
<th>For medium-weight materials</th>
<th>For medium-heavy weight materials</th>
</tr>
</thead>
<tbody>
<tr>
<td>Max. thread size (Nm)-Synthetic*</td>
<td>120</td>
<td>60</td>
<td>30</td>
</tr>
<tr>
<td>Needle size (1/100mm)</td>
<td>10</td>
<td>12-16 (80-100)</td>
<td>18-19 (110-120)</td>
</tr>
<tr>
<td>Needle catalog (Needle system)</td>
<td>1910-05 (135x9)</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*or an equivalent size of other types of thread
7. INSERTING THE NEEDLE

1. Open bed slide.
2. Raise latch (1) (see Fig.5).
3. Lift out bobbin case (2) (see Fig.5).

8. TO REMOVE THE BOBBIN CASE

Use needle cat. No. 1910-05 needle system (135X9) only.
Raise needle bar to its highest position by turning hand wheel toward you.
Loosen needle set screw (1) (See Fig.4) insert the needle in the needle bar and push it up as far as it will go.
Make sure its long groove faces toward the front. Tighten needle set screw (1) securely.

9. TO WIND THE BOBBIN

Thread the pre-tension for bobbin winding

Switch off the machine.
Do not operate machine with throat plate left open.

Switch off the machine.
Do not guirle or hold thread when winding the bobbin.
1. Stop motion of needle by loosening stop-motion screw (1), Fig.6. Hold hand wheel with left hand and turn stop-motion screw toward you with right hand.

2. Place bobbin on bobbin winder spindle (3), Fig.7, pushing it on as far as it will go.
   
   Pre-tension (1) [see Fig.7].
   +...........More tension.
   .........Less tension.

3. Push latch (2) in the direction indicated by arrow (A), then start the machine (see Fig.7).
   
   Bobbin winder spindle (3), rotate in the direction indicated by arrow (B) (see Fig.7).

   To adjust the amount of thread on bobbin, loosen screw (4) on latch (2) and swing the latch (2) away from you or toward you, as required.

   For more thread on bobbin, swing latch (2) away from you.

   For less thread on bobbin, swing latch (2) toward you.
   If thread winds unevenly on bobbin, loosen screw (5) and move pre-tension (1) up or down, as required, and tighten screw (5).

10. THREADING THE BOBBIN CASE.

11. TO REPLACE THE BOBBIN CASE.

Hold bobbin case by latch (1) and place it on spindle of bobbin case holder (2) so that position knob [3] enters notch (4) at right of bobbin case holder (see Fig.12).

Release latch and press bobbin case firmly in place to assure proper position. Close bed slide.

NOTE: When straight stitching, a better result can be obtained if bobbin thread is not threaded through bobbin case thread guide (1), Fig.11.

1. Hold bobbin case so that thread unwind in the direction shown in Fig.8, and put bobbin in bobbin case.

2. Pull thread into notch (1), and draw it under tension spring (2) (see Fig.9).

3. Draw thread out from slot (2) on end of spring (1), (Fig.10) and pass it through bobbin case thread guide (1), Fig.11. Allow about 4 inches of thread to hang freely from bobbin.

CAUTION
Switch off the machine. Do not run machine without closing bed slide. Danger of injury!
12. THREADING THE NEEDLE

- Fig. 13.

1. Lead thread from the thread unwinder through all the threading points A (Fig. 14), B (Fig. 15), C (Fig. 13), D (Fig. 13), E (Fig. 13), and F (Fig. 16) in the order shown.
2. Thread the needle from front to back, as shown in Fig. 16.
3. Draw about 3 inches of thread through eye of needle.

13. TO ADJUST STITCH LENGTH

- Fig. 17.

Regulating the stitch length:
- To regulate the stitch length, turn feed regulating dial (1) Fig. 17, toward left or right as required.
  + ...To lengthen
  - ...To shorten

Changing to reverse feed:
- Push lever (2) Fig. 17, down for reverse feed and release for forward feed.
- To regulate the reverse stitch length, turn thumb screw (3) Fig. 17, toward left or right as required.
  + ...To lengthen
  - ...To shorten

14. TO ADJUST PRESSER FOOT PRESSURE

- Fig. 18.

To regulate the presser foot pressure, turn knurled thumb screw (1) Fig. 18, toward left or right as required.
  + ...More pressure
  - ...Less pressure
15. TO ADJUST NEEDLE THREAD TENSION

Regulate needle thread tension within tension regulating knob (1), Fig.19.

- More tension
- Less tension

16. REGULATING THE TAKE-UP SPRING

Using a screwdriver in slot of stud (1), Fig.20, regulate take-up spring tension by turning stud (1), as required.

- More tension
- Less tension

To adjust the amount of take-up spring movement, loosen screw (2), Fig.20, and set take-up spring height by turning the entire tension assembly (3) toward left or right, as required. Securely tighten screw (2).

17. TO ADJUST BOBBIN THREAD TENSION

Regulate bobbin thread tension with tension regulating screw (1), Fig.21.

- More tension
- Less tension

18. NEEDLE POSITION SELECTOR

CAUTION

Switch off the machine.

Left, Center and Right needle position settings are available for placement of both straight and zigzag stitching (see Fig.22).

To position, push lever in and move to desired setting.

Do not make any needle position adjustment while the needle is in the fabric.
19. STITCH WIDTH REGULATOR

The width of zigzag stitch is controlled with the spring biased stitch width regulating lever (1, Fig. 23).

Maximum zigzag width:
- 20U73/73B: 0.9 mm
- 20U83/83B: 0.12 mm

Do not make any needle position adjustment while the needle is in the fabric.

20. HOW TO CONTROL THE WIDTH OF ZIGZAG STITCH

To obtain minimum to maximum width (20/73/73B: 0.9mm, 20U83/83B: 0.12mm) zigzag stitch, first loosen thumb screw (2), Fig. 24, to permit the stitch width regulator (3), Fig. 24 to return to its zero position (see A, Fig. 24) and retighten thumb screw (2).

Then loosen thumb screw (1), Fig. 24, turn stitch width regulator (3) clockwise as far as it will go and while holding the regulator (3) in this position (see B, Fig. 24), retighten thumb screw (1).

You can now regulate the stitch width regulator within the range of zero to maximum.

21. NEEDLE BAR FRAME CLAMPING DEVICE

When straight stitching, a better sewing result can be obtained by locking the needle bar frame immovable with the clamping device (see Fig. 25).

A: Clamp
B: Release

CAUTION
Switch off the machine.
22. FITTING FOR STRAIGHT AND ZIGZAG STITCHING

Fig. 26.

606652/2U75313B
606402/3J313B
606651/2U75313B
c0088/2U7313B
c0092/2U7313B

General Purpose Presser Foot (1), Throat Plate (2) and Feed Dog (3) as shown in Fig. 26, are used for straight and zigzag stitching.

23. CHANGING THE THROAT PLATE AND FEED DOG

Fig. 27.

606693
c00297

c00495

24. TO MOUNT THREAD UNWINDER

Fig. 29.

Fasten thread unwinder (1) to table (2) with wood screws (3) as shown in Fig. 29.
25. TO USE THE SPOOL CAP

When using a reel type thread spool, fit the spool cap (1) supplied with the machine onto the thread spool (3) (see Fig.30).

Set height of spool rest so there is approximately 2 mm clearance between top end of spool pin and the tip of the slotted spigot of the spool cap (see Fig.30).

The spool cap should never be fitted on the spool pin (5). Forcing it onto the spool pin may result in breaking the slotted spigot of the spool cap (see Fig.30).

26. TO USE THE ANTI-SPILL SLEEVE

When using synthetic threads that easily spill off the cone (1), slip the anti-spill sleeve (2) furnished with the machine over the thread from the bottom of cone (1) leaving the thread end to hang free at the top of anti-spill sleeve (2) as shown in Fig.31.

27. KNEE LIFTER

TO MOUNT KNEE LIFTER

Fasten knee lifter bracket (1) to underside of table (2) 145 mm from table cut-out as shown in Fig.32.

KNEE OPERATING PRESSER FOOT LIFT

CAUTION

Switch off the machine. Set sewing head upright again using both hands. Danger of crushing between sewing head and table top.

Fig.30.

Fig.31.

Fig.32.

Fig.33.
Bell cranks (1) and (2) shown in Fig.33 are fastened to the underside of the bed. Bell crank (1) is used for lifting and lowering the presser foot with knee, and bell crank (2) is used for controlling the stitch width (see Fig.33).

To raise or lower the presser foot with knee, loosen screw (4) holding the knee lifter shaft arm (3) and move knee lifter shaft arm (3) just under the bell crank (1), and firmly tighten screw (4) (see Fig.33).

Loosen the lock nut holding screw (7) and turn screw (7) as required, so that the bent end (6) of knee lifter shaft arm (3) will be almost horizontal when knee lifter knee plate (5) is pushed as far as it will go in the direction indicated with arrow (A), then firmly tighten the lock nut (see Fig.33).

With knee lifter shaft arm (3) set in position as described above, loosen screw (8) and move knee lifter shaft arm (3) up or down as required, so that height (10) from its bent end (5) to bracket (9) is 54 mm (see Fig.33).

Raise presser foot (12) with presser foot lifter (11). Then loosen the lock nut holding screw (14) and turn screw (14) as required, so that knee lifter knee plate (5) when pushed in the direction indicated with arrow (B), will not at a point (presser foot (12) raised approx. 9 mm from throat plate (13) surface) where presser bar lifter (11) will drop down from its raised position when presser bar is lifted a little higher than its normal up position. Then firmly tighten the lock nut (see Fig.33).

When knee lifter knee plate (5) is pushed in the direction indicated with arrow (B), the presser foot (12) will rise and when knee plate (5) is released, presser foot (12) will be lowered (see Fig.33).

KNEE OPERATING STITCH WIDTH CONTROL

Bell cranks (1) and (2) shown in Fig.34 are fastened to the underside of the bed. Bell crank (1) is used for lifting and lowering the presser foot with knee and bell crank (2) is used for controlling the stitch width.

To control the stitch width with knee, loosen screw (4) holding the knee lifter shaft arm (3) and move knee lifter shaft arm (3) just under the bell crank (2) and firmly tighten screw (4) (see Fig.34).

Loosen the lock nut holding screw (7) and turn screw (7) as required, so that the bent end (6) of knee lifter shaft arm (3) will be almost horizontal when knee lifter knee plate (5) is pushed as far as it will go in the direction indicated with arrow (A). Then firmly tighten the lock nut (see Fig.34).

With knee lifter shaft arm (3) set in position as described above, loosen screw (8) and move knee lifter shaft arm (3) up or down as required, so that height (10) from its bent end (6) to brackets is 67 mm (see Fig.34).

Loosen stitch width regulating plate thumbs screws (11) and (12) so that stitch width regulator (13) can be moved from zero to maximum stitch width (25/73/73B: 9mm, 20U/83/83B: 12mm) (see Fig.34). Loosen the lock nut holding screw (14) and turn screw (14) as required, so that knee lifter knee plate (5) when pushed in the direction indicated with arrow (B), will stop at the maximum stitch width position of stitch width regulator (13). Then firmly tighten the lock nut (see Fig.34).

Stitch width will become wider when knee lifter knee plate (5) is pushed in the direction indicated with arrow (B) and will become smaller when knee plate is released (see Fig.34).

28. FITTINGS FOR BUTTONHOLE STITCHING

Buttonhole Foot (1), General Purpose Throat Plate (2) and Feed Dog (3) as shown in Fig.35 are used for buttonhole stitching.
29. FITTING FOR HEM SEWING

Hemmer Foot (1), Straight Stitch Troat Plate (2) and Feed Dog (3) as shown in Fig.36 are used for hem sewing.

30. FITTINGS FOR ZIPPER AND CORD SEWING

Zipper Foot (1), General Purpose (2) or Straight Stitch (3) Throat Plate and General Purpose (4) or Straight Stitch (5) Feed Dog as shown in Fig.37 are used for zipper and cord sewing.

31. CARING FOR YOUR MACHINE

Your SINGER machine will serve you perfectly for many years if you take a few moments of your time to keep it clean. How often you will need to clean and lubricate the machine will depend on how often you will use it. When in regular use, the machine should be cleaned periodically to remove lint and fluff which may have accumulated around the working parts. A machine in continuous use should be oiled frequently, especially when the machine is operated at maximum recommended speed.

With a soft cloth, clean; (See Fig.38)

1) Thread retainer
2) Take-up lever
3) Thread guard
4) Tension discs
5) Needle bar
6) Presser bar
7) Machine arm and bed
With a lint brush, clean; (See Fig.36)

9) Feed dog
10) Rotating loom and area under throat plate.

Turn handwheel over toward you until oil hole in rotating hook appears in sight.

Apply one or two drops of oil to the oil hole.
### 32. TROUBLESHOOTING CHART

Whenever sewing difficulty is encountered, check and make adjustments as follows.

<table>
<thead>
<tr>
<th>Problem</th>
<th>Cause</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Needle thread breaks</td>
<td>1. Is machine properly threaded?</td>
<td>1. Correct needle threading</td>
</tr>
<tr>
<td></td>
<td>2. Are thread guides or tension disc area lint-free?</td>
<td>2. Remove lint and fluff from bobbin case and hook</td>
</tr>
<tr>
<td></td>
<td>3. Is needle-thread tension too tight?</td>
<td>3. Adjust needle thread tension</td>
</tr>
<tr>
<td></td>
<td>4. Is needle bent or have a blunt point?</td>
<td>4. Insert new needle</td>
</tr>
<tr>
<td></td>
<td>5. Is needle inserted correctly?</td>
<td>5. Insert needle correctly</td>
</tr>
<tr>
<td></td>
<td>7. Is thread free of slubs and knots?</td>
<td>7. Remove slubs and knots</td>
</tr>
<tr>
<td></td>
<td>9. Is thread tangled or caught?</td>
<td>9. Untangle thread from bobbin case and hook</td>
</tr>
<tr>
<td></td>
<td>10. Is thread tension correct?</td>
<td>10. Adjust needle and bobbin case thread tension</td>
</tr>
<tr>
<td></td>
<td>11. Does bobbin rotate smoothly?</td>
<td>11. Check whether bobbin thread is wound correctly</td>
</tr>
<tr>
<td></td>
<td>13. Is needle bent or have blunt needle point?</td>
<td>13. Insert new needle</td>
</tr>
<tr>
<td></td>
<td>15. Is threading correct?</td>
<td>15. Correct needle threading</td>
</tr>
<tr>
<td></td>
<td>17. Is needle bent?</td>
<td>17. Insert new needle</td>
</tr>
<tr>
<td></td>
<td>20. Is the fabric pulled while sewing?</td>
<td>20. Do not pull fabric while sewing</td>
</tr>
<tr>
<td>Fabric fails to feed</td>
<td>21. Is feed regulating dial properly adjusted?</td>
<td>21. Lengthen stitch length by feeding regulating dial</td>
</tr>
<tr>
<td></td>
<td>22. Is presser foot pressure adjusted properly?</td>
<td>22. Adjust correct presser foot pressure</td>
</tr>
<tr>
<td></td>
<td>25. Is thread tension too tight?</td>
<td>25. Adjust needle tension properly</td>
</tr>
<tr>
<td>Rotating heavy Noisy</td>
<td>26. Is there any lint or fluff on feed dog?</td>
<td>26. Remove lint and fluff from feed dog</td>
</tr>
<tr>
<td></td>
<td>27. Is there any lint in rotating hook?</td>
<td>27. Remove lint and fluff from rotating hook</td>
</tr>
<tr>
<td>Machine fails to start</td>
<td>28. Are electrical plugs properly connected?</td>
<td>28. Turn on power switch</td>
</tr>
<tr>
<td></td>
<td>29. Is power and light switch turned on?</td>
<td>29. Connect plug to power source</td>
</tr>
</tbody>
</table>

*If you still have difficulty in seeing even after making adjustments, contact your nearest Service Center.*
### 33.SPECIFICATIONS

<table>
<thead>
<tr>
<th></th>
<th>73/73B</th>
<th>83/83B</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine class</td>
<td>73/73B</td>
<td>83/83B</td>
</tr>
<tr>
<td>For sewing</td>
<td>Light to medium</td>
<td></td>
</tr>
<tr>
<td>Stitch type</td>
<td>301 (lock stitch), 304 (Zigzag lock stitch)</td>
<td></td>
</tr>
<tr>
<td>Max. speed*</td>
<td>2,500 r.p.m.</td>
<td>2,000 r.p.m.</td>
</tr>
<tr>
<td>Max. stitch bight</td>
<td>9.0mm</td>
<td>12.0mm</td>
</tr>
<tr>
<td>Max. stitch length</td>
<td>5.0mm</td>
<td>5.0mm</td>
</tr>
<tr>
<td>Needle bar stroke</td>
<td>34.8mm</td>
<td></td>
</tr>
<tr>
<td>Presser bar lift (manual)</td>
<td>6.35mm</td>
<td></td>
</tr>
<tr>
<td>Presser bar lift (knee lifter)</td>
<td>9.0mm</td>
<td></td>
</tr>
<tr>
<td>Needle catalog (needle system)</td>
<td>CAT.1910-05 (135X9)</td>
<td></td>
</tr>
<tr>
<td>Needle size</td>
<td>See page 3 table &quot;NEEDLE AND THREAD&quot;</td>
<td></td>
</tr>
<tr>
<td>Machine pulley</td>
<td>74mm effective dia. for V-belt</td>
<td></td>
</tr>
<tr>
<td>Oil</td>
<td>SINGER &quot;B&quot; Oil</td>
<td></td>
</tr>
<tr>
<td>Workspace width</td>
<td>211mm</td>
<td></td>
</tr>
<tr>
<td>Workspace height</td>
<td>130mm</td>
<td></td>
</tr>
<tr>
<td>Bedplate dimensions</td>
<td>399mmX178mm</td>
<td></td>
</tr>
<tr>
<td>Net weight (head only)</td>
<td>19.5Kg</td>
<td>20.0Kg</td>
</tr>
<tr>
<td>Gross weight (with accessories)</td>
<td>21Kg</td>
<td>21.5Kg</td>
</tr>
<tr>
<td>Noise**</td>
<td>n=1,600 r.p.m. &lt;76 dBA</td>
<td></td>
</tr>
</tbody>
</table>

* Maximum speed will vary depending on fabric, threads and sewing condition.

** Noise measurement according to DIN 45634-45-A-1.

### Relationship between zigzag bight and maximum speed

<table>
<thead>
<tr>
<th>Machine class</th>
<th>73/73B</th>
<th>83/83B</th>
</tr>
</thead>
<tbody>
<tr>
<td>Zigzag bright</td>
<td>0mm–5mm</td>
<td>5mm–9mm</td>
</tr>
<tr>
<td>Max. speed</td>
<td>2,500 r.p.m</td>
<td>2,000 r.p.m</td>
</tr>
</tbody>
</table>

Part No.606625(1100)  
Printed in China