SINGER
246-1 TO 246-5
INSTRUCTIONS
FOR ADJUSTING
FEED DOGS, NEEDLE CARRIER,
LEFT and RIGHT LOOPERS
on
SINGER* Machines
246-1, 246-2, 246-3 and 246-4
USING GAUGE No. 164459
and on Machine 246-5
USING GAUGE No. 164460

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TO SET THE FEED DOGS AT THEIR CORRECT HEIGHT

(See Fig. 1)

To check the height of the feed dogs, swing the presser foot K out to the left. Place the gauge J2 over the feed dogs and firmly resting upon the throat plate U2, as shown in Fig. 1. Turn the machine pulley over from you until the feed dogs are at their highest point, in which position the feed dogs should just touch the bottom face K2 of the gauge J2.

Fig. 1. Setting the Feed Dogs

To set the feed dog B2, swing the cloth plate and the feed eccentric cover out to the left, then loosen the adjusting screw M2 and move the feed dog B2 up or down, as required. Then tighten the screw M2.

To set the rear feed dog A2, loosen the adjusting screw O2 and move the feed dog A2 up or down, as required. Then tighten the screw O2.

TO SET THE NEEDLE CARRIER AT THE CORRECT HEIGHT

(See Figs. 2 and 3)

To check the height of the needle carrier, turn the machine pulley over from you until the needle carrier Z reaches its highest position. Remove the needle and the throat plate, swing the presser foot and cloth plate out to the left and turn the machine pulley over from you until the needle carrier Z reaches its lowest position. Slip the "LOW" end of the gauge J2 between the needle carrier and the throat plate slot, as shown in Fig. 2.

Fig. 2 Checking the Needle Carrier Height
At this setting, the needle carrier Z should just touch the top surface Q2 on the "LOW" end of the gauge J2.

If the left looper passes the needle at the above setting, loosen the left adjusting screw A3 and tighten the right adjusting screw B3 until the tip of the left looper Z2 returns to the correct position. Then tighten the screw A3 and recheck the sideways position of the left looper in relation to the needle, as described above.

The left looper must rub lightly on the needle, as it passes behind the needle in its movement toward the right. To set the left looper correctly behind the needle, remove the throat plate U2, Fig. 2 and the chip guard and turn the machine pulley over from you until the point of the left looper just passes the needle. Loosen the adjusting screw Y2 and the set screw X2 and move the looper holder C3 until the left looper Z2 almost touches the needle from the rear. Tighten the set screw X2 and then slowly tighten the adjusting screw Y2 until the left looper Z2 actually rubs on the needle. Then replace the throat plate U2, Fig. 2, and chip guard.

TO SET THE LEFT LOOPER IN RELATION TO THE NEEDLE

(See Figs. 4 and 5)

To install the left looper, remove the throat plate U2, Fig. 2, and the chip guard. Loosen the set screw W2 in the left looper holder C3, and set the looper all the way down into its holder. Then securely tighten the set screw W2.

To set the left looper the correct distance to the left of the needle, turn the machine pulley over from you until the needle carrier Z, after reaching its lowest position, rises sufficiently to permit the "HIGH" end of the gauge J2 to pass between the needle carrier and the throat plate seat, as shown in Fig. 4. At this setting the needle carrier Z should just touch the top surface U4 on the "HIGH" end of the gauge and the tip of the left looper Z2 should just touch the left side of the needle. If the left looper does not reach the needle at this setting, loosen the right adjusting screw B3, and tighten the left adjusting screw A3, until the tip of the left looper meets the needle.

TO SET THE RIGHT LOOPER IN RELATION TO THE NEEDLE

(See Figs. 6 and 7)
5. The right looper, when passing behind the left looper, should brush lightly on the front of the needle. To adjust this position of the right looper D3, loosen the nut on the stud H3 and move the right looper D3 in the right looper carrier S3, as required, then securely tighten the nut on the stud H3. Recheck and adjust the height and the right and left position of the right looper, as described above.

When all the settings of the right looper have been properly adjusted, check each setting again and make sure all set screws and nuts are securely tightened. Then replace looper thread plate and chip guard.