SINGER
246-31
Introducing the NEW SINGER®
246-31

Compact and modern in design, the SINGER 246-31 Machine produces quality two thread overedge stitching in nylon, rayon and other similar fine materials.

It is designed particularly to produce high quality blind stitch hemming, seamming and welting on small tubular articles and is especially well suited to such operations on garments for small children and infants.

The differential feed mechanism incorporated in the 246-31 may be adapted to either gather or stretch the material or to feed it uniformly for all these stitching operations.

The 246-31 has the speed and ease of handling you like—stitching fast smoothly and quickly reaching speeds up to 3500 stitches per minute. Trimming and overedging are simultaneous.

All parts of the machine are continually and automatically lubricated, when the machine is in operation, from an oil cooling reservoir in conjunction with a special system of tubes and wicking. Clean filtered oil is returned to the reservoir. Oil level is easily checked through a "window" on machine front.

*A Trademark of the SINGER MANUFACTURING COMPANY
BEFORE YOU DO ANYTHING ELSE

Oil your machine! For best results, use SINGER "TYPE A" OIL sold by Singer Sewing Machine Company, as instructed in Fig. 2.

POUR "TYPE A" OIL INTO OIL FILLER CUP

Fig. 2. Oiling

At least twice each day
Check the oil level in the reservoir. Never allow oil level to drop below "HALF-FULL" mark on oil sight gauge. See Fig. 2.

NEEDLES
The correct type—As you know, the needles you use have a very direct effect on quality, strength and appearance of stitching produced by your machine. From the standpoint of efficient machine performance, the correct needle is just as necessary as many of the parts inside your machine.

That's why it's so important—for best sewing results and for trouble free operation—to use only the SINGER needles recommended here.

For general purposes—use Class and Variety 151 x 1 in Sizes 9, 11, 14 and 16.

For sewing nylon—use Class and Variety 151 x 3 in Sizes 5, 6 and 7.

And the correct size—In selecting a needle of the right size among sizes shown—whether in standard or chromium finish—the eye must be large enough to allow the thread you are using to pass through freely without binding or chafing. A simple test is to thread a short length of sewing thread through the needle eye, hold the thread taut in a vertical position and twirl the needle about the thread. If the size is correct, the needle should slip down the thread easily.

Check for damaged needle frequently, to avoid poor stitching and possible damage to your machine—

Bent needle—may cause skipped stitches and running-off seam margins.

Hook or burr on needle point—may cause skipping and picking or fraying of the material you are sewing.

Clogged needle eye and grooves—will also cause skipped stitches.

HERE'S HOW TO . . .

Set the Needle

Turn the machine pulley over away from you until the needle carrier moves to its highest point.

After loosening needle clamping nut, insert needle into needle clamp as far as it will go, as instructed in steps 1 to 6 in Fig. 3.

Fig. 3. Setting the Needle

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

Prepare for Threading

Open front cover plate and swing presser bar and cloth plate out of position, as instructed in Fig. 4.

Fig. 4. Preparation for Threading
Thread the Unwinder

Pass each thread through threading points in the order shown in Fig. 5. Solid line indicates the looper thread. Double line indicates the needle thread.

Fig. 5. Threading Unwinder 151031 for Two-Thread Stitch

THREAD THE MACHINE
for Two-Thread Stitch

Thread the needle thread completely first. Thread the looper thread last.

Pass each thread through threading points as shown in Figs. 7 and 8. Double line indicates needle thread. Solid line indicates looper thread.

NOTE: Use Threading Wire 164196, shown in Fig. 6, to pass each thread through its threading tube. Fig. 6. Threading Wire 164196

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

Fig. 6. Threading Wire 164196

NEEDLE THREAD EYELET

USE THREADING WIRE 164196 HERE

Fig. 7. Threading the Machine for Two-Thread Stitch

Observe the correct method of threading needle eyelet 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 away from you until eye of looper is directly in line with threading tube.

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

Fig. 8. Threading Looper Take-up for Two-Thread Stitch
IT IS EASY TO REFIT THE MACHINE . . .
For Three-Thread Tight Stitch

 Equip machine with right looper 164055 in place of spreader and with needle thread controller 164151.

 Thread the unwinder and the machine, as shown in Figs. 9 to 11.

 Thread the needle thread completely first (double line).

 Thread right looper thread completely next (dotted line).

 Thread left looper thread completely last (solid line).

 Fig. 9. Threading Unwinder 151031

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

 Observe the correct method of threading needle eyelet shown in Fig. 10. After threading needle thread eyelet, raise needle to its highest position and pass the thread from front to rear through the needle eye.

 LOOPER THREADS: Turn machine pulley over away from you until eye of looper to be threaded is directly in line with threading tube.

 Fig. 10. Threading Machine for 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.

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

 TO PREPARE . . .
For Three-Thread Purl-on-the-Edge Stitch

 NOTE: The machine must be equipped with left and right loopers, with needle thread controller 164381 and with the fittings 164857 and 164288 shown in Fig. 14.

 Fig. 11. Threading Looper Take-up (Three-Thread Tight Stitch)

 Fig. 12. Right Looper

 USE THREADING WIRE 164196 HERE

 Fig. 13. Correct Position of Needle Thread Eyelet

 Fig. 14. Threading Looper Take-up for Purl-on-the-Edge Stitch
Thread the **unwinder** and the **machine** as instructed in Figs. 9 to 11, pages 6 and 7, with the following exceptions:

- The needle thread eyelet must be positioned and threaded as shown in Fig. 13, page 7.
- The looper take-up must be threaded as shown in Fig. 14, page 7.

**WHAT TO DO ABOUT 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 threads should be very light.

The thread tensions are regulated as instructed in Fig. 15.

### MORE PRESSURE

![Diagram showing more pressure and tension](image)

### MORE TENSION

LESS PRESSURE

LESS TENSION

MORE TENSION

**Fig. 15. Regulating Thread Tensions and Pressure on Material**

. . . **AND PRESSURE ON MATERIAL**

Always use the lightest pressure possible to permit higher working speeds.

Regulate the pressure of the presser foot on the material as instructed in Fig. 15.

Your pressure is correct when the work moves steadily and smoothly without stalling.

**Do**

- When turning the machine pulley, **always** turn it over away from you.
- Clean out any lint or other waste around the loopers and between the feed rows on the under side of the throat plate.
- Always use lightest tensions and lightest pressure on material to permit high working speeds.

**Don't**

- Don't allow oil level in the oil reservoir to drop below the "HALF-FULL" mark.
- Don't operate machine until it has been thoroughly cleaned, oiled and correctly adjusted.
- Don't forget to remove loop of thread from right looper before threading.

**The Same!**

To get replacements that are the same as parts in new machines . . .

**BUY PARTS AND NEEDLES MADE BY SINGER**

**TO BE DOUBLY SURE . . .**

of new machine performance, make sure that all replacement parts and needles are precisely identical to those in new SINGER machines.

Look for the trademark

**SINGER** or **SIMANCO**

1. on every package or container
2. on the needle or numbered part

---

TO ALL WHOM IT MAY CONCERN: The improper placing or renewal of the trademark 'SINGER' or any other of the trademarks of the Singer Manufacturing Company (all of which are Trademarked) on any machine that has been repaired, rebuilt, reconditioned, or altered in any way whatever, even outside a SINGER factory or on any unauthorized SINGER agency is forbidden.

Needles in containers marked "For Singer Machines" are NOT made by SINGER.

Form 20937

Printed in U. S. A.