SINGER
55-20
To change the Sidewise Position of the Looper

The looper should be set so that its point comes as close as possible to the center of the crease in the needle without striking it on the upper stroke of the needle bar.

If the looper does not set at the center of the crease, loosen screw<br>
surfaces of the looper plate. The angle depth of the teeth project above the upper surface of the looper plate should be set so that when it is pressed to its<br>
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To Raise or Lower the Feed Dog

If the feed dog is not set at the correct height, turn screw<br>
through base plate above. Turn screw to the correct height, until the<br>
feed is set at an angle and turn the handle. When the feed is set at an angle the feed dog should be set to where it is pressed to its
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To Time the Feeding Mechanism

The thread should be 7/16 inch from the bottom of the presser foot to the thread plate. The presser foot is raised if the thread is lighted above, in which position the feed light is on. The presser foot is lowered when the feed is lighted and the thread is on the feed light. The feed light is on when the feed is set at an angle and the feed dog should be set so that it is pressed to its
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To Set the Stack Thread Regulator

Rests on the bar provided for it on the looper shaft. (Fig. 2) Make selection for the correct lever by lining the looper thread or away from the crease and adjust the lever to the opposite side of the crease from the looper. To advance the lever, turn the screw 90 degrees and move the lever to the opposite side of the crease. To retract, move the screw 90 degrees to the opposite side of the crease.

The Importance of Using Genuine Singer Parts and Needles

The successful operation of Singer machines can only be maintained if genuine Singer parts and needles are used. Singer parts and their names
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The importance of using genuine Singer parts and needles cannot be over emphasized. Any machine that has been replaced, partly or in whole, with parts of the trade marks of the Singer Mfg. Co. or any of the trade marks of the Singer Mfg. Co. is not a genuine Singer. If any part of the Singer Mfg. Co., so marked, is found in a machine it is not a genuine Singer. The placing of the name "Singer" on a machine is not sufficient to make it a genuine Singer. The placing of the name "Singer" on a machine, whether or not it is genuine, is not sufficient to make it a genuine Singer. The placing of the name "Singer" on a machine, whether or not it is genuine, is not sufficient to make it a genuine Singer.
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 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).

Fig.5 Needle Bar Set at Correct Height

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 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 2600 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.

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).
ADJUSTERS AND MACHINISTS

FOR

INSTRUCTIONS

CLEANED AND OILED BEFORE USE.

The machine should always be

Cleaned and Oiled before use. The machine should always be

 Furious before use. The machine should always be

After removing the thread, thread the bobbin with thread and apply oil to the

Occasionally check the grease in the gear case (b) and, if low,

Replenish with Singer gear lubricant through the hole at (c) after

In Fig. 2.

Parts underneath the machine indicated by the rectangles or arrows

Turn the machine back on its handle and apply oil to the

Move the machine back on its handle and apply oil to the

Apply oil to all oil holes in the rim and bed of the machine

Fig. 2. Front View of Machine Showing Oil Holes

Once each day, and when in continuous use, the machine should be oiled at least

Parts which are in moving contact, the machine requires oiling

To insure easy running and prevent unnecessary wear on the
To Adjust the Work Guide

To adjust the work guide, loosen the thumb screw (0, Fig. 4) and move the guide to the right or left as may be required, then firmly tighten the thumb screw (0, 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 56-20 are of Class and Variety 163259 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 163259 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.