

SL 718-2

For WHITE
machine

INSTRUCTION MANUAL

PARTS LIST

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I. GENERAL CHARACTERISTICS

All standard series can be operated up to a speed of 2,500 R.P.M. depending on materials and threads.

All models except "A" can be operated either 1 to 1 (NO SKIP) or 2 to 1 (SKIP) stitch as desired by quick change lever. All models have stitch range of 3mm to 8mm (3 to 8 S.P.I.) and sewing capacity of 7mm (9/32").

The machine model "A" has the small cylinder of fine tubular work. All models are regularly fitted with swing-out work plates for flat or tubular work.

Sizes available are :

Singer	#8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
Metric	60	65	70	75	80	85	90	95	100	105	110	120	125	130	140
Singer	#8	10	12	14	15	16	18								
Metric	60	70	80	90	95	100	110								

II. SETTING-UP MACHINE

Place machine head on machine table so that the machine pulley groove is centered to the belt hole cutout on table. Place machine so that the knee lever extends and clears the front of the table edge. Mark the bolt holes through the holes in the machine base. Remove machine and bore 6.2mm (1/4") holes in table top. Set machine to bolt holes with felt pad under machine and securely fasten machine with bolts provided in accessory pack.

Drive motors recommended are clutch motors either 1/4 H.P. or 1/3 H.P. with rated R.P.M. of 1400/1425 R.P.M. at 50 cycles (Hertz) or 1725/1750 R.P.M. at 60 cycles. To drive machine at rated speed use maximum 90mm (3.5") outside diameter motor pulley at 50 cycles and 75mm (2.9") outside diameter motor pulley at 60 cycles. It is recommended that new machines be run at below rated speeds at the beginning therefore motor pulleys which are 5mm (1/4") smaller in diameter than the foregoing sizes be used for the first month to run-in the machine.

After the machine has been bolted to the table connect the driving belt from the motor pulley to the machine pulley. The machine pulley must turn in a direction away from the operator. Next insert the Knee Lifter Knee Pad Rod into the Knee Lifter Rock Shaft Sleeve and tighten the two set screws located at the front section of the sleeve. (See Fig. 1)

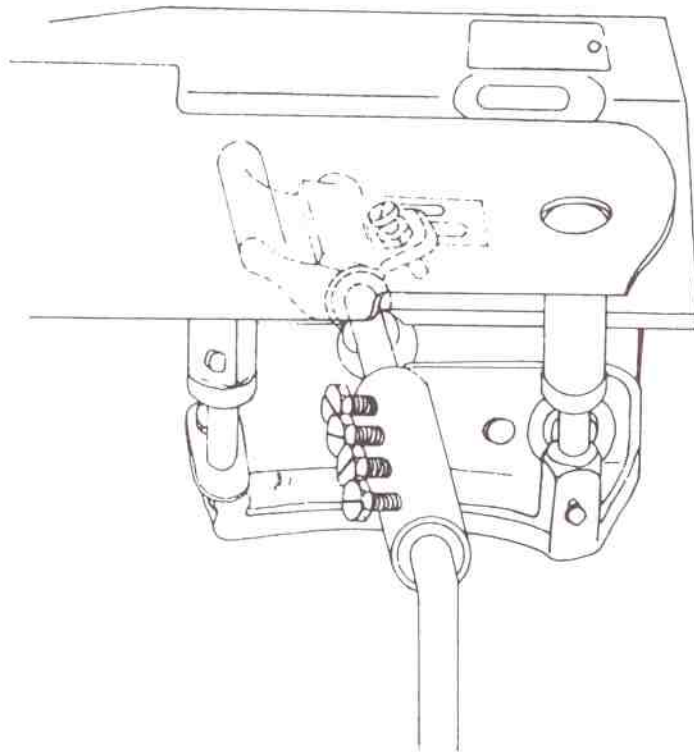


Fig. 1

III. OILING THE MACHINE

Oiling holes are marked in red paint. A drop or two of oil should be inserted at each oil hole. Remove Arm Side Cover and oil the Feed Lever Eccentric and the Feed Lever Rocker Pin Hole. Also oil the Ball of the Needle Drive Shaft. Replace the Arm Side Cover. (See Fig. 2)

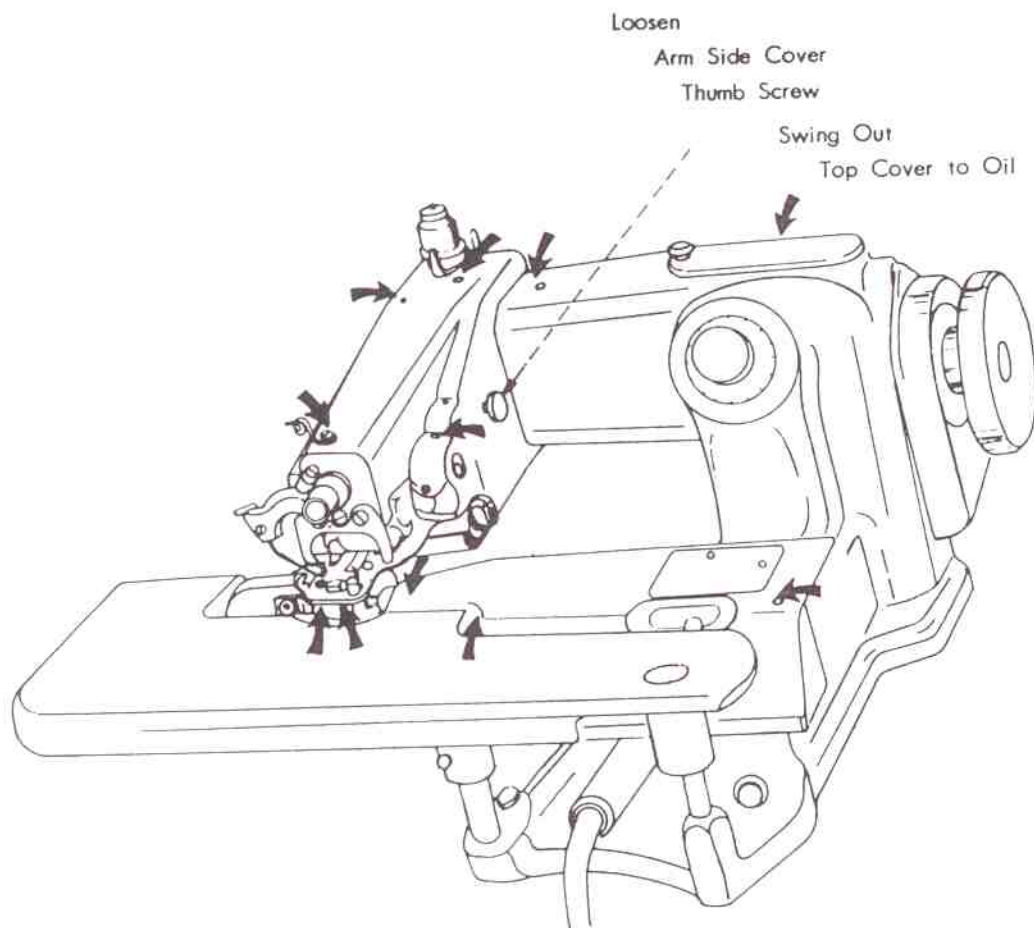


Fig. 2

IV. THREADING MACHINE

Thread the machine as shown (Fig. 3). Make sure that the thread passes between the two tension discs at point (A). The thread should be passed through the needle eye from the underside of the needle. Cut the excess thread after threading the needle so that approximately 100mm (4") of thread end is left. Adjust tensions to suit the thread and material being used.

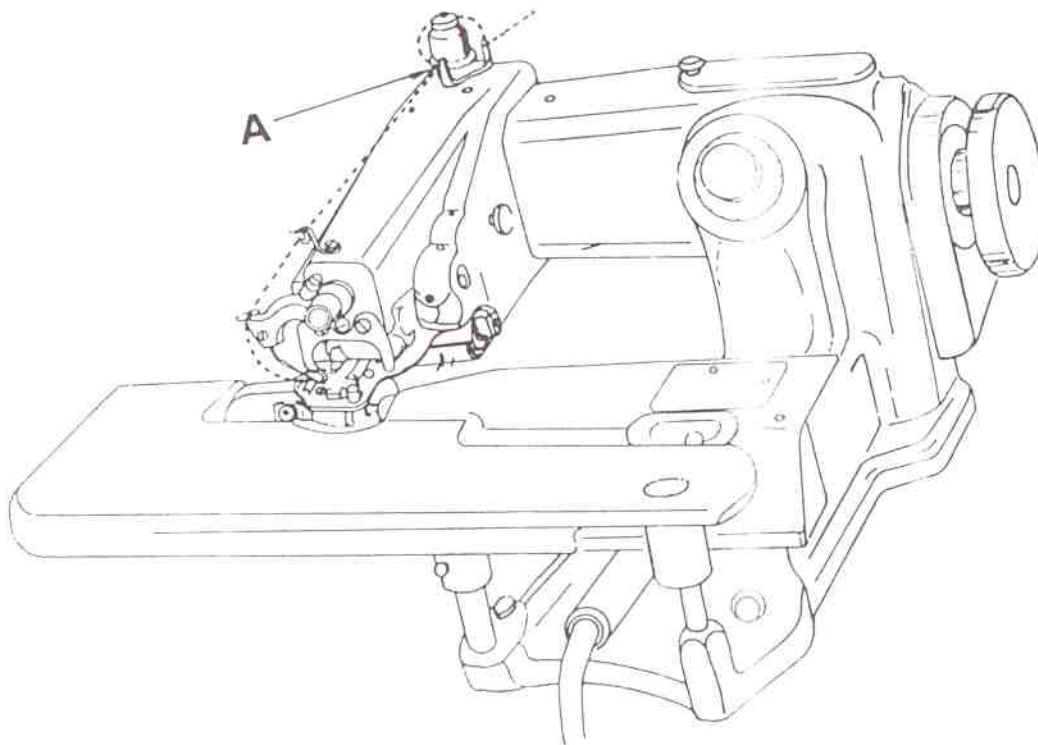


Fig. 3

V. REPLACING THE NEEDLE

Turn handwheel away from you until the Needle Lever is at its highest position on its left hand stroke. Loosen Needle Clamp Screw (A), remove old needle and insert new needle as far as it will go into the needle clamp groove.

Tighten Clamp Screw. (See Fig. 4).

The needle point must slightly touch the needle guide (B).

Turn the Hand Wheel slowly to check that the point of the needle just touches the rib also. This should be checked with the machine set at the non-skip (1-1) stitch position on skip stitch machines.

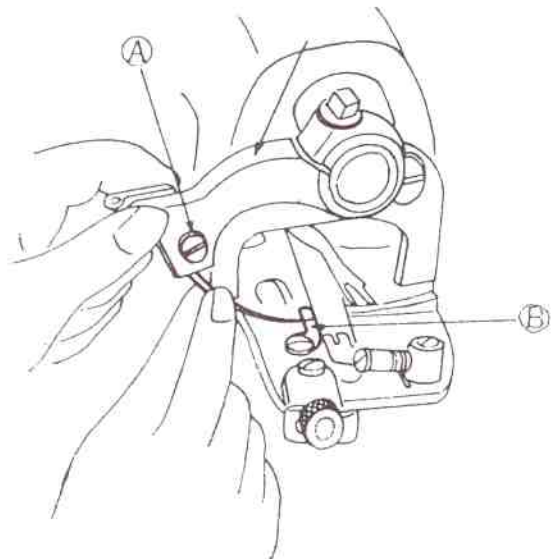


Fig. 4

VI. ADJUSTING FOR NEEDLE PENETRATION

The Penetration Dial is located at the front of the machine arm. Turn the Dial clockwise (LESS) for less penetration of the needle through the material being stitched and turn counter-clockwise (MORE) for greater penetration. The calibrated numbers on the Dial can be noted and used for reference position for same types of materials for quick adjustment.

(See Fig. 5)

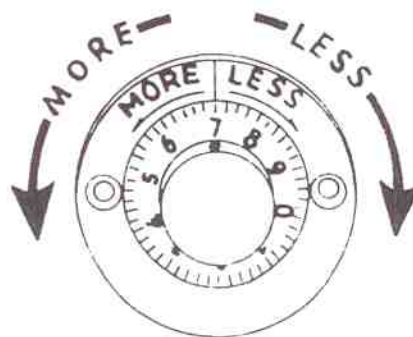


Fig. 5

VII. SKIP STITCH DEVICE

An indicator plate is located at the front right hand side of the feed frame on skip stitch machines with the markings "2-1, 1-1". To obtain skip stitching move lever to the "2-1" position. To obtain non-skip stitching move lever to "1-1" position. (See Fig. 6). Depress knee lever when moving skip stitch lever.

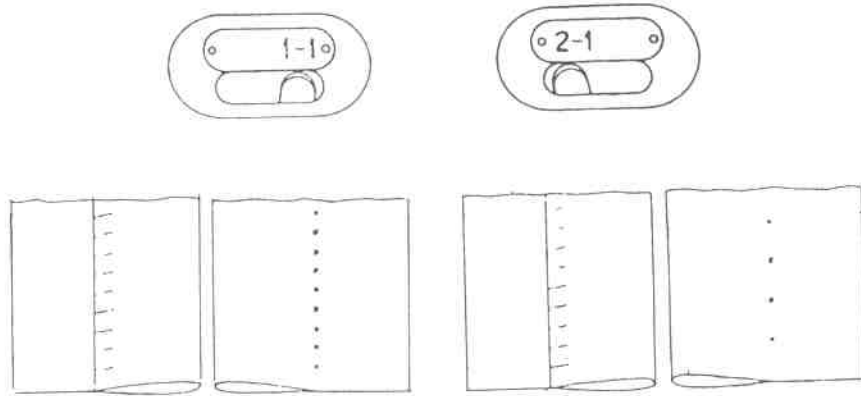


Fig. 6

VIII. REGULATING STITCH LENGTH

Remove the Arm Side Cover. Loosen Clamp Screw of Stitch Adjusting Collar and while holding collar firmly turn hand wheel to desired stitch length. The desired calibration mark on the Stitch Adjusting Collar should be lined up with the line mark on the shoulder of the Stitch Eccentric. Tighten the Clamp Screw after setting to the desired stitch length. The higher the number on the collar the longer the stitch. (See Fig. 7)

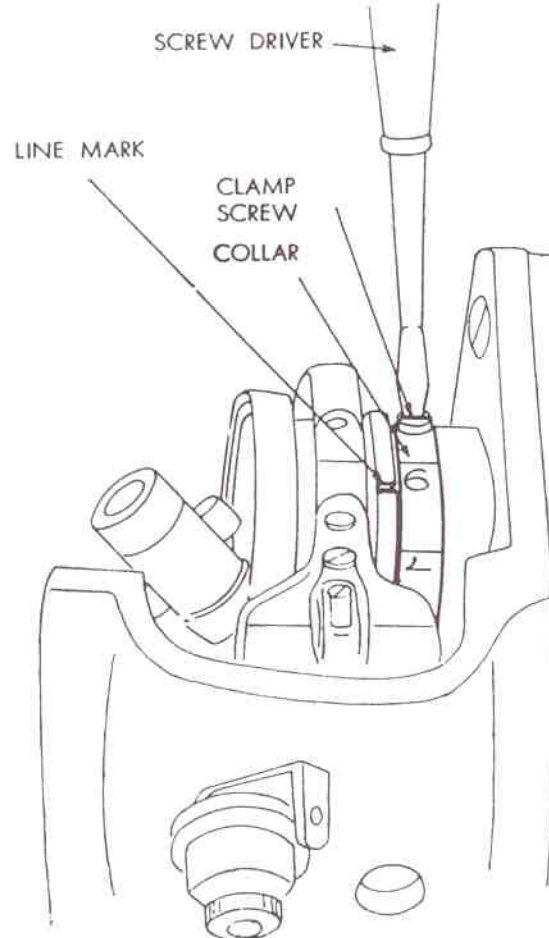


Fig. 7

IX. PREPARING TO SEW AND HANDLING MATERIAL

In order to achieve uniform and neat appearing hems on the garment pieces to be hemmed, pressing or pre-creasing is recommended. However through training and experience neat hems can be produced by hand folding and guiding. In stitching hems the following steps should be followed.

- a. Position the needle lever to its extreme left hand stroke.
- b. Fold the hem of the material to the desired width. Turn under the edge of the material to achieve a single fold.
- c. Hold material firmly at the rear and front to hold the folded hem. Depress the knee lifter and place the material under the feeding foot and align the edge to be hem to the edge guide. When this alignment is made the edge of the hem to be stitched should be centered in the curve of the presser foot shoe.

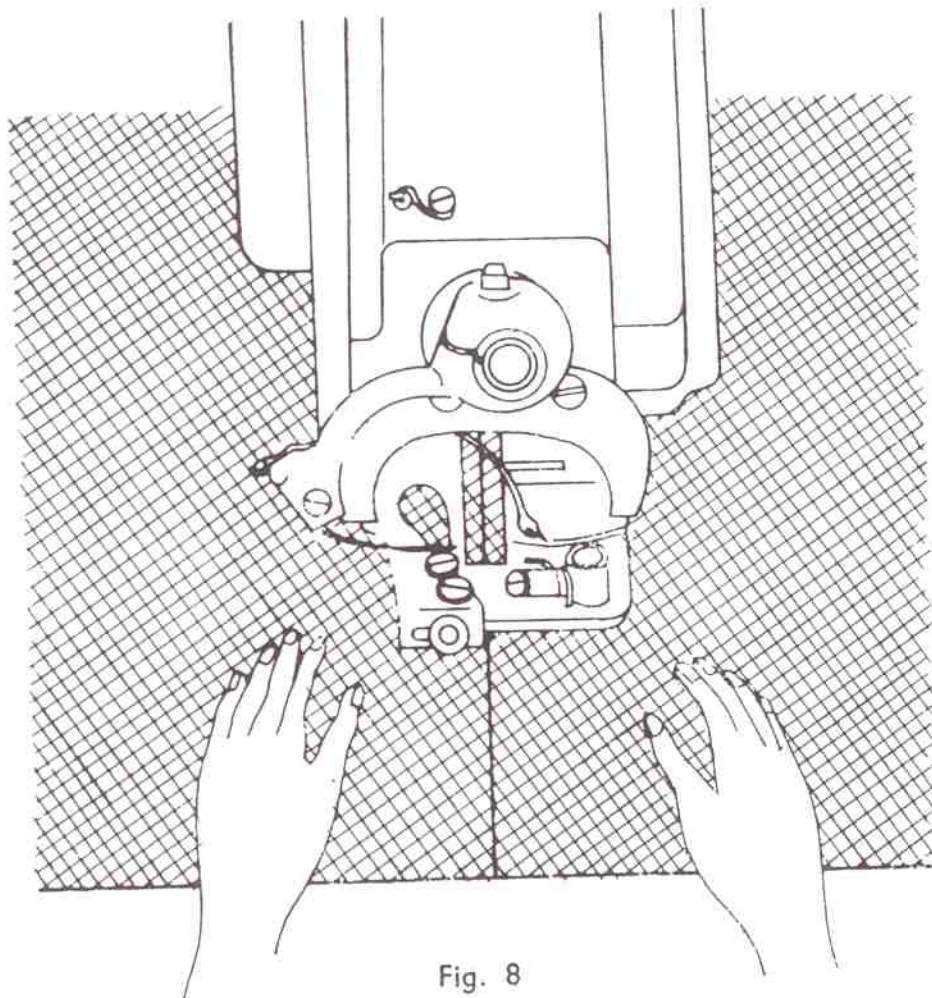
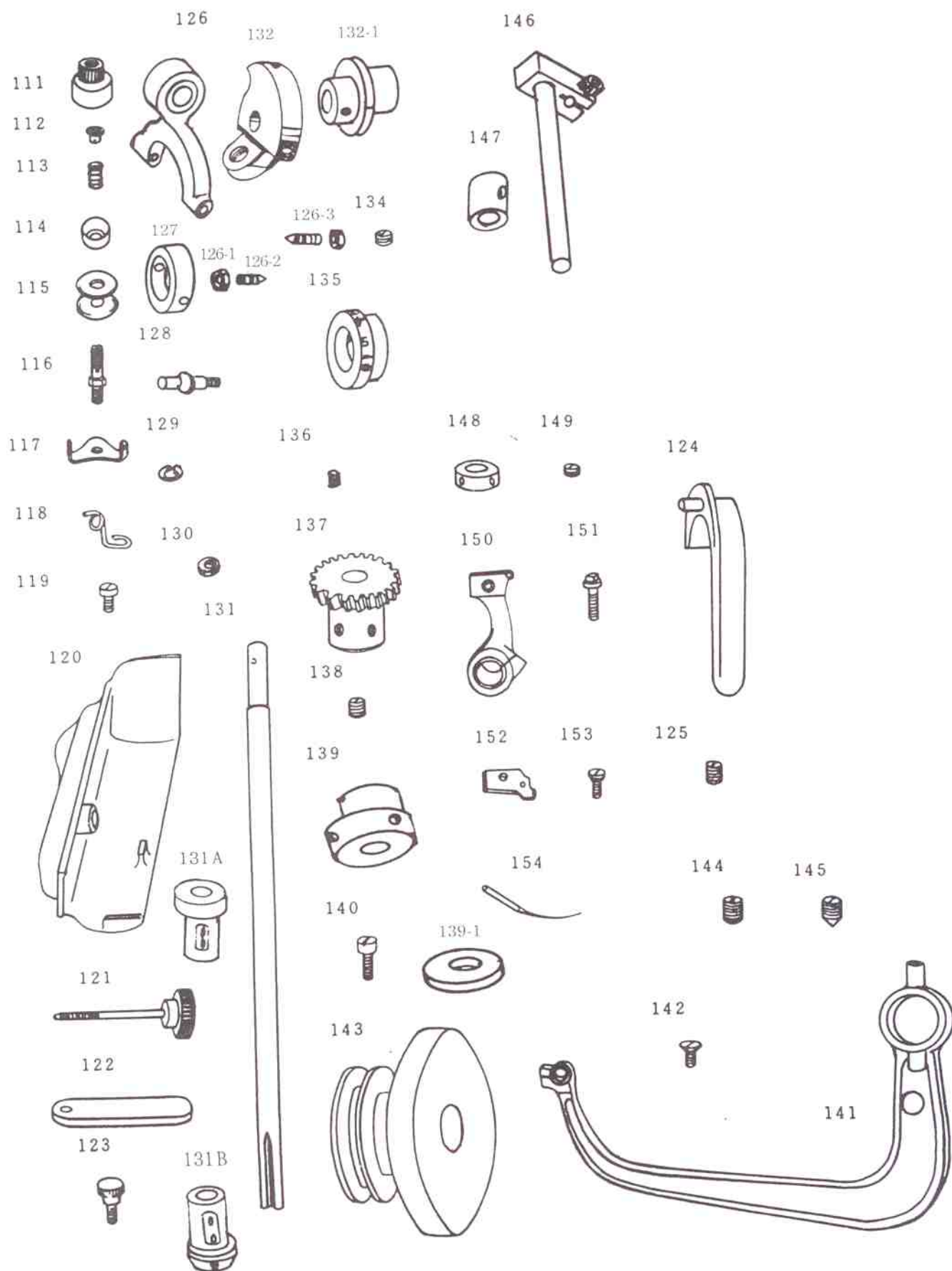


Fig. 8

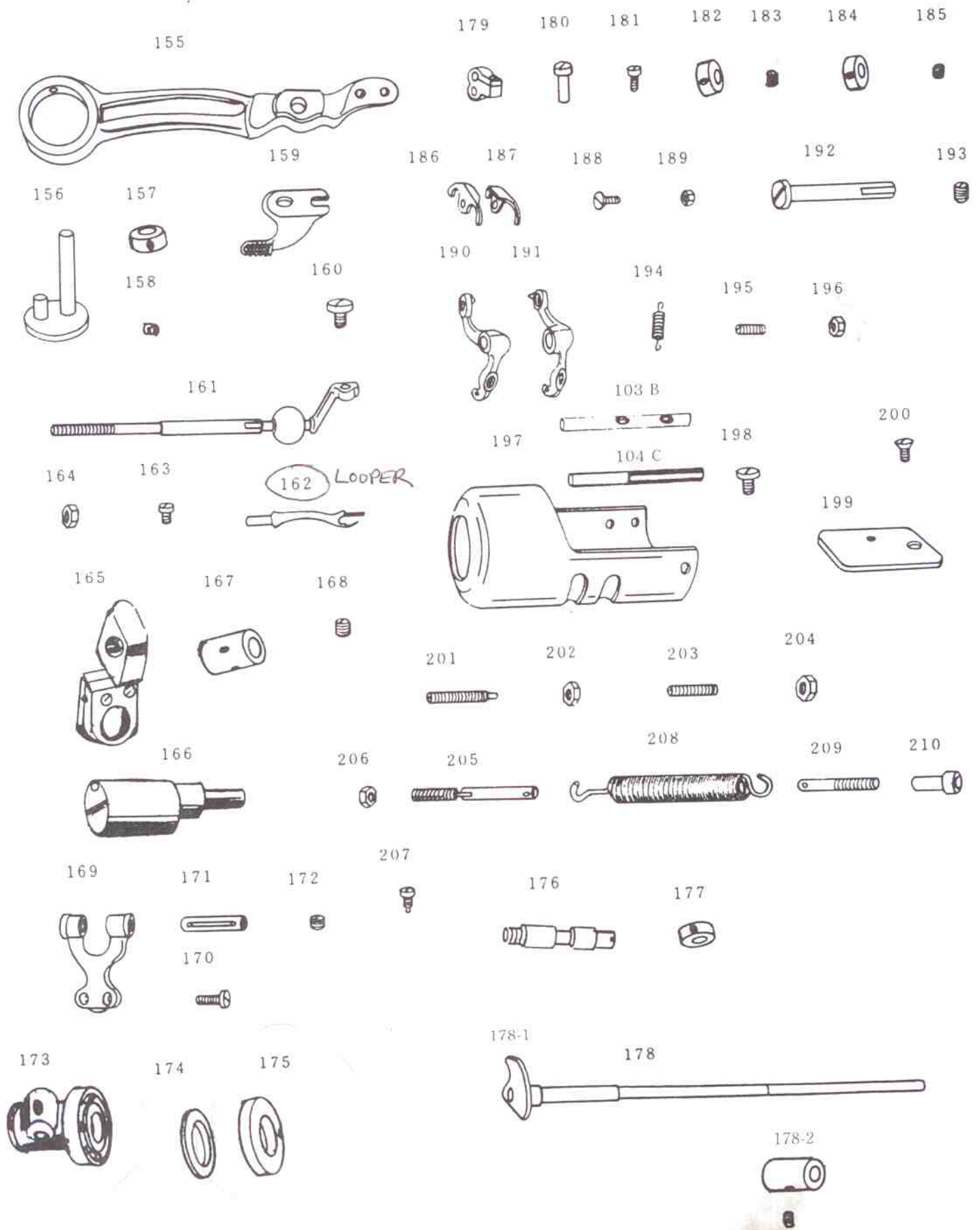
- d. Begin sewing and continue until the seam is completed. To achieve correct and straight stitching guide the edge by keeping the folded edge to the edge guide. Watch this part only as this will keep the edge straight. It is not necessary to watch the needle or the stitching. (See Fig. 8)
- e. After completing the hemming operation, turn hand wheel to position the needle lever to its extreme left hand stroke, depress the knee lever to release the material and pull the work away from you or straight back with a sharp pull. This will break the thread for easy removal of the work and also leave enough thread for starting the next seam.

Note: When the machines are packed at the factory the timing of the looper, feed and needle are set correctly and no adjustments are necessary except for thread tensions and penetration to suit the threads and materials to be used.

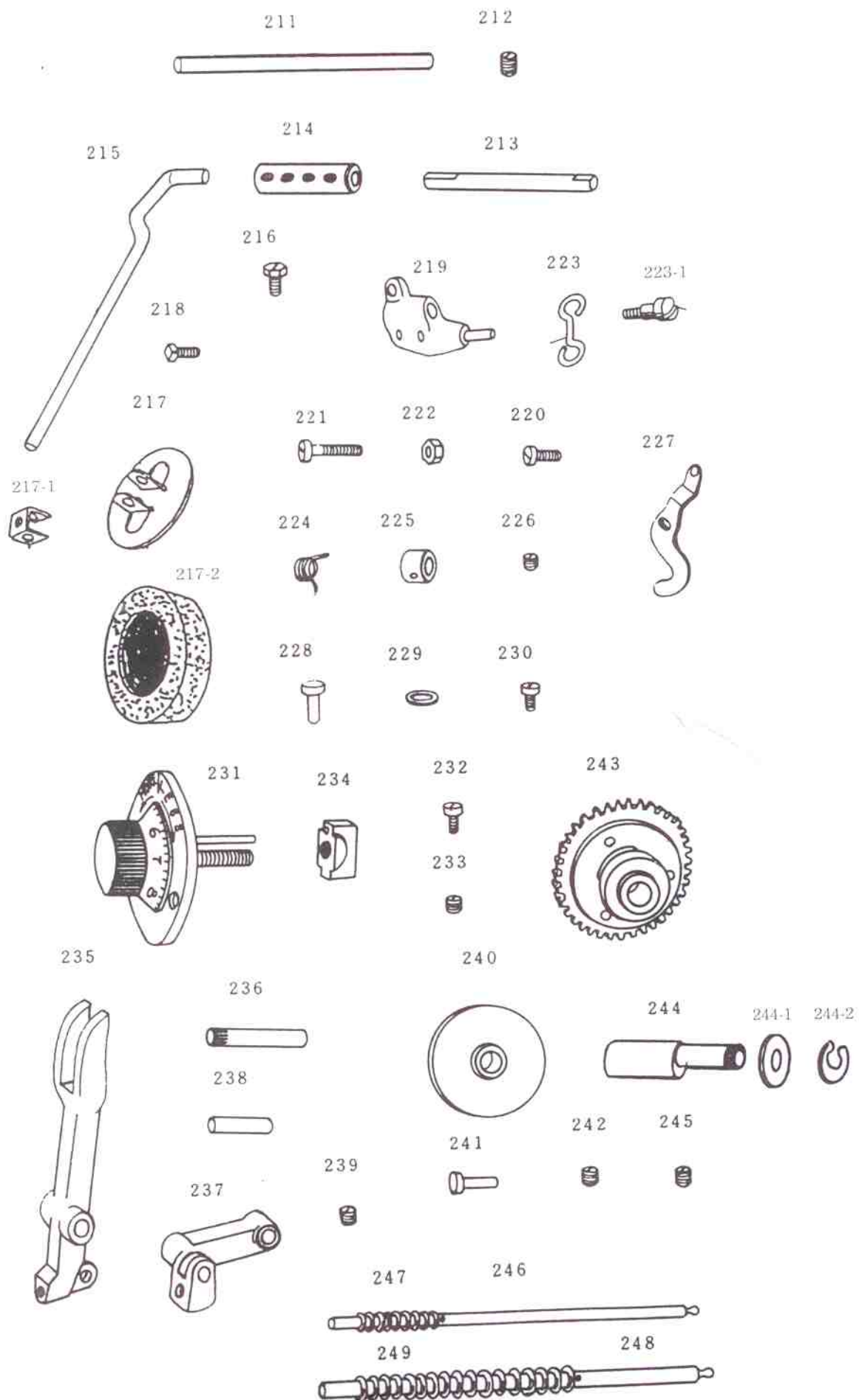
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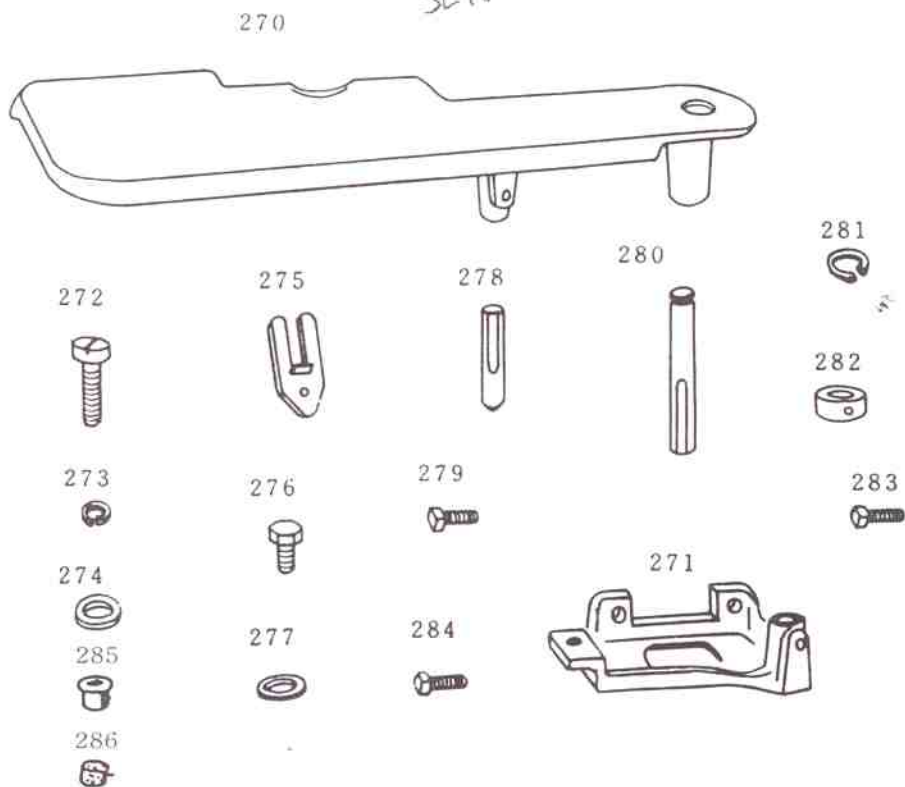
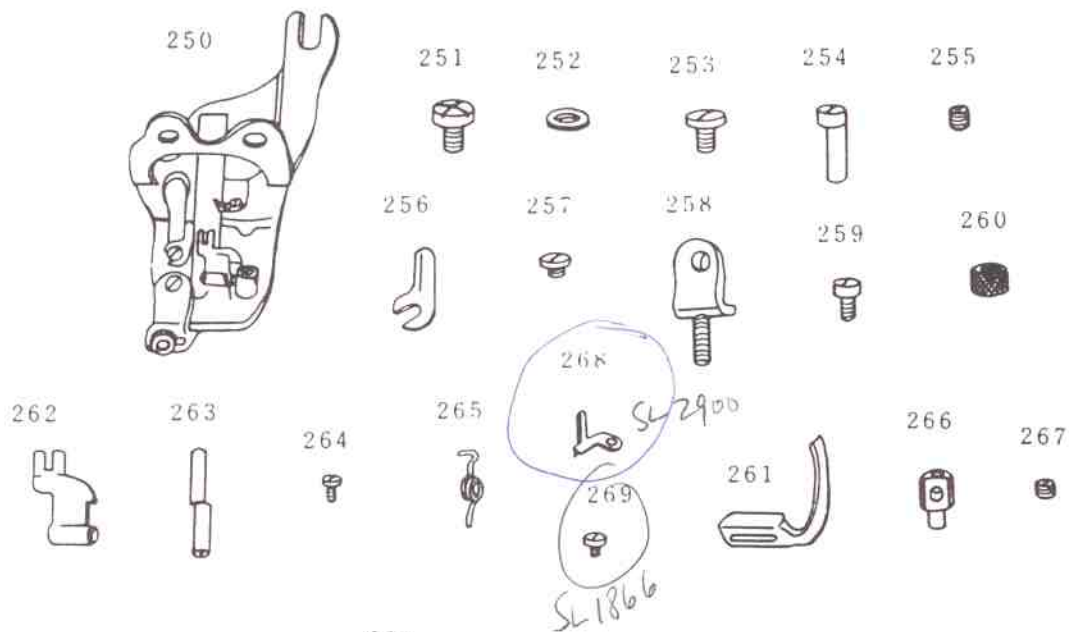
PART NO.	DESCRIPTION
111	Thread Tension Nut
112	Ratchet
113	Spring
114	Cover
115	Tension Discs
116	Tension Post
117	Thread Guide
118	Front Thread Guide
119	Screw-Front Thread Guide Attaching
120	Side Cover
121	Screw-Side Cover Attaching
122	Cover Plate
123	Screw-Cover Plate Attaching
124	Belt Guard
125	Screw-Belt Guard Set
126	Needle Shaft Connection
127	Screw-Needle Connection
128	Eccentric Ball Stud
129	Eccentric Ball Guard
130	Screw-Eccentric Ball Guard Attaching
131	Main Shaft
132	Needle and Feed Eccentric
133	Screw-(Cone Point) Feed Eccentric Set
134	Screw-(Flat) Eccentric Set-Lock
135	Stitch Regulating Collar
136	Screw-Stitch Regulating Collar-Clamp
137	Gear-Skip Stitch Drive
138	Screw-Skip Stitch Drive Gear Set
139	Rib Connection Eccentric
140	Screw-Rib Lever Eccentric Lock
141	Rib Connection Lever
142	Screw-Rib Connecting Lever Clamp
143	Hand Wheel
144	Screw-Handwheel Set (Cup Point)
145	Screw-Handwheel Set (Cone Point)
146	Needle Shaft
147	Screw-Needle Shaft Clamp
148	Collar-Needle Shaft
149	Screw-Needle Shaft Collar Set
150	Needle Lever
151	Screw-Needle Lever Clamp
152	Needle Clamp
153	Screw-Needle Clamp Attaching
154	Needle



PART NO.	DESCRIPTION
155	Feed Lever
156	Rocker Pin Assembly
157	Collar-Rocker Pin
158	Screw-Rocker Pin Collar-Clamp
159	Feed Dog
160	Screw-Feed Dog-Attaching
161	Looper Rod
162	Looper
163	Screw-Looper Clamp
164	Nut-Looper Rod-Lock
165	Looper Rod Carrier
166	Stud-Looper Rod Carrier
167	Eccentric Block
168	Screw-Eccentric Block-Set
169	Looper Rod Fork
170	Screw-Looper Rod Fork-Clamp
171	Looper Rod Fork Pin
172	Screw-Looper Rod Fork Pin-Set
173	Bearing Case
174	Bearing
175	Retaining Ring-Bearing
176	Stud-Looper Rod Sleeve
177	Nut-Looper Rod Sleeve Stud
178	Rib Shaft
179	Crank-Rib Shaft
180	Stud-Rib Shaft Crank
181	Screw-Rib Shaft Crank-Clamp
182	Rib Shaft Collar-Left
183	Screw-Rib Shaft Collar-Clamp
184	Rib Shaft Collar-Right
185	Screw-Rib Shaft Collar-Clamp
186	Platten-Left
187	Platten-Right
188	Screw-Platten to Bracket-Attaching
189	Nut-Platten to Bracket Attaching Screw
190	Platten Bracket-Left
191	Platten Bracket-Right
192	Stud-Platten Bracket Pivot
193	Screw-Platten Bracket Pivot Stud-Set
194	Spring-Platten Bracket
195	Screw-Platten Bracket-Limit
196	Nut-Platten Bracket Limit Screw-Lock
197	Cylinder
198	Screw-Cylinder Attaching
199	Window Plate
200	Screw-Window Plate Attaching
201	Screw-Feed Frame-Limit
202	Nut-Feed Frame Limit Screw-Lock
203	Screw-Skip Stitch Compensating
204	Nut-Skip Stitch Compensating Screw-Lock
205	Spring Link Assembly
206	Nut-Spring Link Assembly-Retaining
207	Screw-Spring Link-Locating
208	Main Spring
209	Link Screw-Main Spring
210	Nut-Main Spring Adjusting



PART NO.	DESCRIPTION
211	Shaft-Feed Frame Rocker
212	Screw-Feed Frame Shaft-Set
213	Knee Lifter Rod Shaft
214	Knee Lifter Rod Sleeve
215	Knee Lifter Rod
216	Knee Lifter Rod Sleeve Screw
217	Knee Pedal
218	Screw-Knee Pedal-Lock
219	Lift Arm
220	Screw-Lift Arm Clamp
221	Screw-Lift Arm Limit
222	Nut-Lift Arm Limit Screw-Lock
223	Knee Lifter Stop Bracket Hook
224	Spring-Knee Lifter Rod-Return
225	Collar-Knee Lifter Rod
226	Screw-Knee Lifter Rod Collar-Set
227	Lever-Skip Regulating
228	Stud-Skip Regulating Lever
229	Spring Washer-Skip Regulating Lever Stud
230	Screw-Skip Regulating Lever Stud-Lock
231	Regulating Dial Assembly
232	Screw-Regulating Dial Assembly Attaching
233	Screw-Dial & Ratchet Assembly-Lock
234	Regulating Dial Shoe
235	Regulating Fork
236	Pin-regulating Fork-Pivot
237	Support Arm-Cam Roller
238	Pin-Roller Support Arm-Pivot
239	Screw-Roller Support Arm Pivot Pin-Set
240	Cam Roller
241	Pin-Cam Roller-Support
242	Screw-Cam Roller Support Pin-Set
243	Skip Eccentric Gear Assembly
244	Carrier Stud-Skip Eccentric Gear
245	Screw-Skip Eccentric Gear Carrier Stud-Set
246	Push Rod (1/4")
247	Spring-Push Rod (1/4")
248	Push Rod (3/8")
249	Spring-Push Rod (3/8")



PART NO.	DESCRIPTION
250	Complete Presserfoot Assembly
251	Screw-Presserfoot Clamp
252	Washer-Presserfoot Clamp Screw
253	Screw-Presserfoot Bridge
254	Eccentric Pin
255	Screw-Eccentric Pin Set
256	Needle Guide
257	Screw-Needle Guide-Attaching
258	Holder-Front Guide
259	Screw-Front Guide Holder-Attaching
260	Nut-Front Guide Clamp
261	Front Guide
262	Shoe-Presser Foot
263	Pivot Pin-Presserfoot Shoe
264	Screw-Pivot Pin
265	Spring-Presserfoot Shoe
266	Shoe Post
267	Screw-Presserfoot Shoe Pivot Pin-Set
268	Chain-Off Pin
269	Screw-Chain-Off Pin Clamp
270	Swing Plate
271	Bracket-Swing Plate-Support
272	Screw-Swing Plate Support Bracket-Attaching
273	Washer (Lock)-Swing Plate Supp't.Brkt.Screw
274	Washer (Flat)-Swing Plate Supp't.Brkt.Screw
275	Stop Plate
276	Screw-Stop Plate Attaching
277	Wash-Stop Plate Attaching Screw
278	Stop Pin Assembly
279	Screw-Stop Pin-Lock
280	Pivot Pin -Swing Plate
281	Retaining Ring-Swing Plate Pivot Pin
282	Collar-Swing Plate Pivot Pin
283	Screw-Swing Plate Pivot Pin Collar-Set
284	Screw-Swing Plate Pivot Pin-Lock