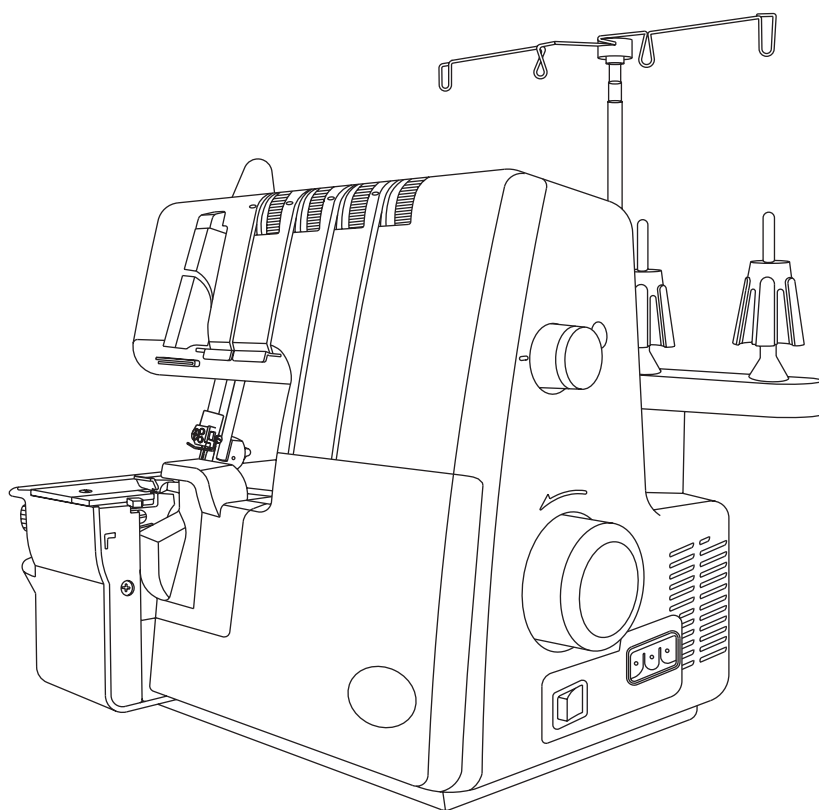


INSTRUCTION BOOK



PREFACE

Thank you for your purchase of this Overlock Sewing Machine. This machine, that is intended for household use will provide you with excellent performance in sewing from light to heavy material (lawn to denim).

Please refer to this Instruction Book for proper use and optimum service. To get the most out of your sewing machine, read the entire Instruction Book before attempting to operate the machine. Then familiarize yourself with the machine by following the Instruction Book page by page.

To ensure that you are always provided with the most modern sewing capabilities, the manufacturer reserves the right to change the appearance, design or accessories of this sewing machine when considered necessary without notification or obligation.

IMPORTANT SAFETY INSTRUCTIONS

When using this machine, basic safety precautions should always be followed including the following.
Read all instructions before using the machine.



DANGER -To reduce the risk of electric shock:

- * The machine should never be left unattended when plugged in. Always unplug the machine from the electric outlet immediately after using and before cleaning.
- * Always unplug before re-lamping. Replace bulb with the same type rated 15 watts. Be sure to replace the face plate which covers the light bulb before operating the machine.



WARNING -To reduce the risk of burns, fire, electric shock or injury to persons:

- * Be sure that the electrical voltage of the electric outlet (wall receptacle) is the same as the rated voltage of the motor.
- * Use this machine only for its intended use as described in this Instruction Book. Use only attachments recommended by the manufacturer as contained in the Instruction Book.
- * To disconnect, turn all controls to the off ("0") position, then remove plug from outlet.
- * Disconnect the power line plug from the socket outlet or switch the machine off when making any adjustments in the needle area, such as threading needle and loopers, changing needle, changing throat plate or changing presser foot, etc.
- * Always unplug the machine from the electrical outlet when removing covers, lubricating, or when making any other user servicing adjustments mentioned in the Instruction Book.
- * Do not attempt to adjust the motor belt. Contact your nearest Service Center should any adjustment be required.
- * Handle the foot controller with care and avoid dropping it on the floor. Be sure not to place anything on top of the controller.
- * Always use the proper throat plate. The wrong plate can cause the needle to break.
- * Do not use bent needles.
- * When sewing, keep fingers away from all moving parts. Special care is required around the sewing machine needle.
- * Do not pull or push fabric while stitching. It may deflect the needle causing it to break.
- * For double insulated machines, when servicing, use only identical replacement parts. See instructions for Servicing of Double-Insulated Appliances.
- * Never operate the machine if it has a damaged cord or plug, if it is not working properly, if it has been dropped or damaged, or dropped into the water. Return the machine to the nearest authorized dealer or Service Center for examination, repair, electrical, or mechanical adjustment.
- * Never operate the machine with any air openings blocked. Keep ventilation openings of the machine and foot controller free from the accumulation of lint, dust and loose cloth.
- * Never drop or insert any object into any opening.

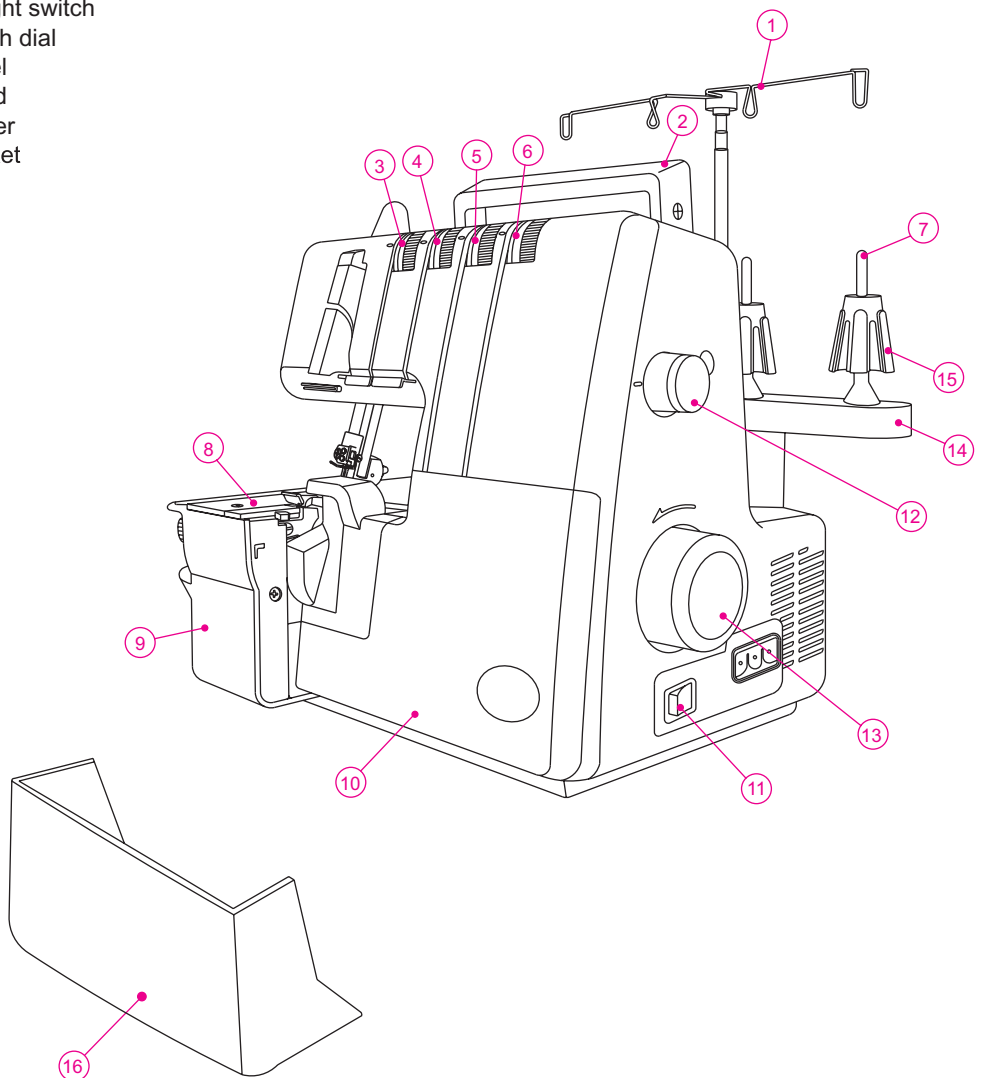
- * Do not use outdoors.
- * Do not operate where aerosol (spray) products are being used or where oxygen is being administered.
- * Do not allow to be used as a toy. Close attention is necessary when the machine is used by or near children.
- * Do not expose the machine or machine plastic case to sunlight directly. Also, do not keep it in a very warm or damp place.
- * Do not touch the machine, foot controller and power line cord with wet hand, wet cloth or with anything wet.
- * Do not connect power line cord to one of the many cords connected to one power outlet with adapters.
- * Use machine on flat and stable table.
- * Be sure to close the looper cover before operating the machine.
- * Keep presser foot and needles away from children's reach.
- * Be sure the light bulb has cooled off before changing with a new one.
- * Do not dismantle or modify the machine yourself.
- * Be sure to turn off the power switch and disconnect the power line plug before caring for your machine as instructed in the Instruction Book.
- * **SERVICING OF DOUBLE-INSULATED PRODUCTS.** In a double-insulated product, two systems of insulation is provided instead of grounding. No grounding means is provided on a double-insulated product, nor should a means for grounding be added to the product. Servicing of a double-insulated product requires, extreme care and knowledge of the system, and should be done only by qualified service personnel, Replacement parts for a double-insulated product must be identical to those parts in the product. A double-Insulated product is marked with the word "DOUBLE-INSULATION" or "DOUBLE-INSULATED".

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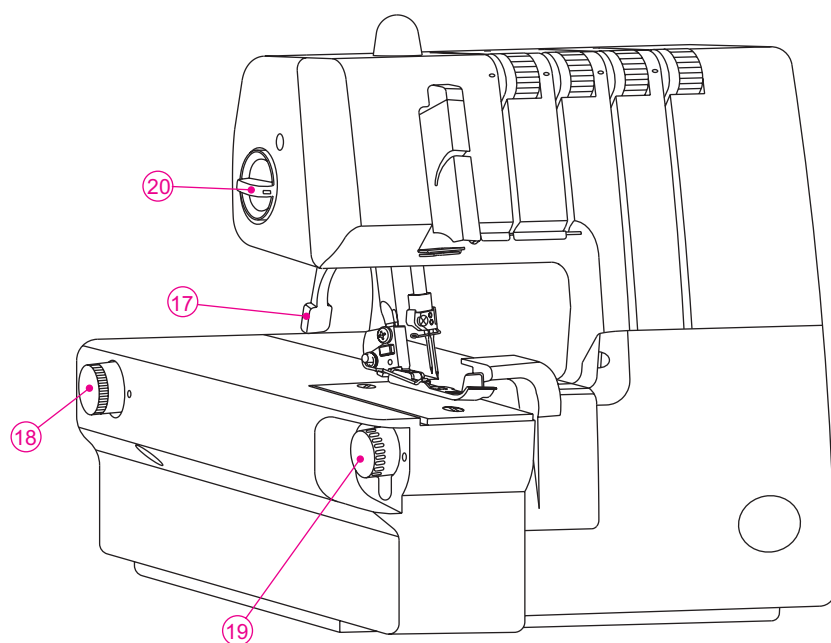
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1. PRINCIPAL PARTS

1. Thread guides and holder
2. Handle
3. Left needle thread tension dial (orange)
4. Right needle thread tension dial (blue)
5. Upper looper thread tension dial (green)
6. Lower looper thread tension dial (red)
7. Spool pin
8. Throat plate
9. Cloth plate
10. Looper cover
11. Power & light switch
12. Stitch length dial
13. Hand wheel
14. Spool stand
15. Spool holder
16. Clean pocket



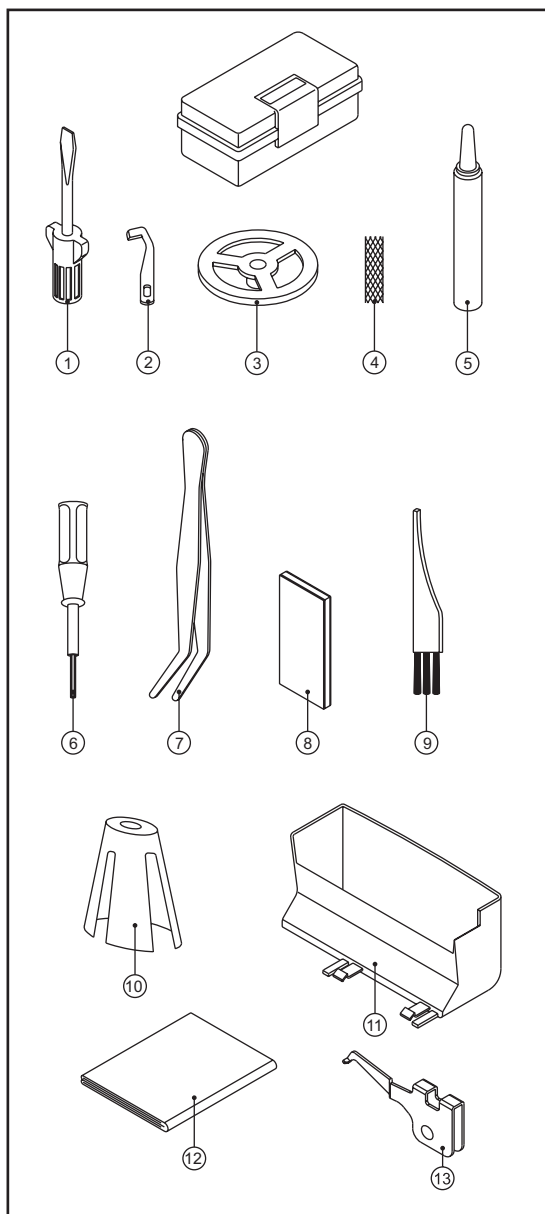
- 17. Presser bar lifter and tension release
- 18. Differential feed adjusting dial
- 19. Cutting width dial
- 20. Foot pressure adjusting dial



2. ACCESSORIES

Accessories are contained in the accessory case

- | | |
|---------------------------------|---|
| 1. Screw driver (large size) | 1 |
| 2. Knife (stationary) | 1 |
| 3. Thread Unwinder spool cap | 4 |
| 4. Anti-spill net | 4 |
| 5. Oiler | 1 |
| 6. Allen Screw driver (small) | 1 |
| 7. Tweezers | 1 |
| 8. Needle set | 1 |
| 9. Brush | 1 |
| 10. Spool holder | 1 |
| 11. Clean pocket | 1 |
| 12. Machine cover | 1 |
| 13. 2-thread converter (option) | 1 |



3. NEEDLE INFORMATION

- This overlock uses a flat shank industrial needle that eliminates the possibility of inserting the needle backwards.
- Do not attempt to use a standard household sewing machine needle of any size or type in this overlock.

HAX1 (130/705H)
Overlock needle

4. HOW TO OPEN LOOPER COVER



Caution:

Be sure to turn off power switch.

- ① Push the cover to the right as far as it will go.
- ② Pull cover down toward you.

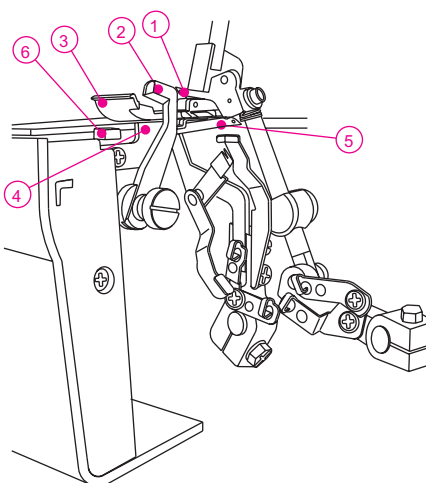


Caution:

Be sure looper cover is closed when sewing.

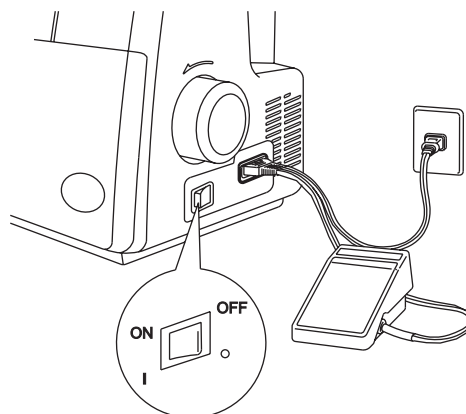
5. PRINCIPAL PARTS BEHIND THE LOOPER COVER

1. Upper looper
2. Moveable Upper knife
3. Presser foot
4. Fixed position lower knife
5. Lower looper
6. Rolled Hem lever



6. PREPARATION PRIOR TO SEWING

- Connect the controller/electric plug to the machine receptacle.
- Plug power line into electric outlet.
- Power Switch: Push "I" mark side to turn "ON"
Push "O" mark side to turn "OFF"
- To run the machine and control the speed, press the controller.
- The harder you press, the faster the machine will sew.
- To stop the machine from sewing, remove your foot from the controller.



WARNING:

Use only foot controller provided with this machine.
(Type 4C-316B for U.S.A. & CANADA only)
Be sure to make reference to "Warning" on following Page.

POLARIZED PLUG INFORMATION (FOR U.S.A. & CANADA ONLY)

This appliance has a polarized plug (one blade wider than the other). To reduce the risk of electric shock, this plug is intended to fit in a polarized outlet only way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit contact a qualified electrician to install the proper outlet. Do not modify the plug in any way.



Warning:

- * Be sure that the electrical voltage of the electric outlet (wall receptacle) is the same as the rated voltage of the motor.
- * Handle the foot controller with care and avoid dropping it on the floor. Be sure not to place anything on top of it when not in use.
- * Disconnect the power line plug from the electric outlet when changing needles, presser feet or when leaving the machine unattended. This eliminates the possibility of starting the machine by accidentally pressing the controller.

7. REMOVAL AND REPLACEMENT OF CLEAN POCKET

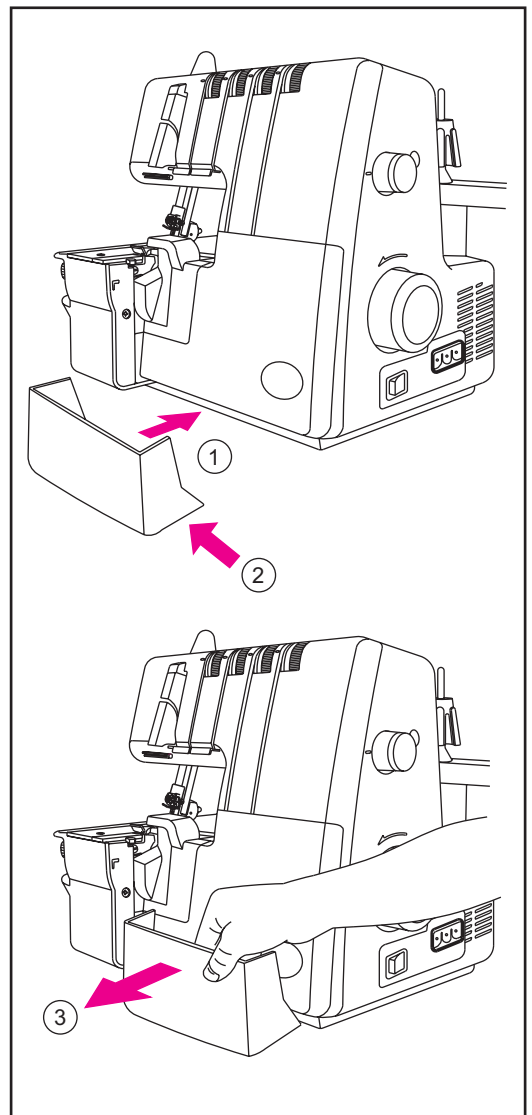
Replacement

- Insert the clean pocket under the looper cover.

Be sure the left side of clean pocket is mounted near the cutter where the scraps drop.

Removal

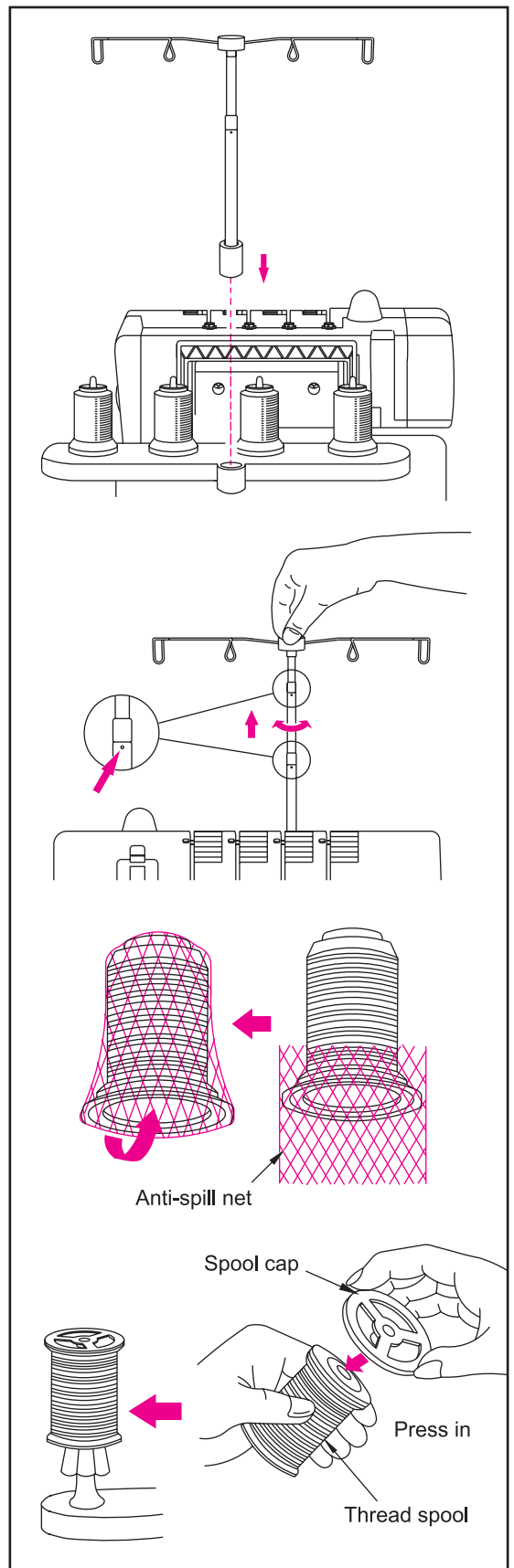
- To remove, hold the clean pocket as shown and pull it outward



8. PREPARATION FOR THREADING

Setting Up the Thread Guide Holder

- Take out the thread guide from the top of Styrofoam, and insert it as shown on the right illustration.
- This machine is shipped with the thread guide holder on the top of styrofoam.
- Fully extend the thread guide holder.
- The two joints on the telescope will click into place when they are correctly positioned.
- Center the thread guides above the spool pins.
- Place thread over the cone adapters on the spool pins.



Anti-spill Net

- When using synthetic threads that easily spill off the cone, slip the anti-spill net furnished with the machine over the thread from the bottom of the cone leaving the thread end hanging free at the top the anti-spill net as shown at right.

Spool Cap

- When using a regular thread spool, fit the spool cap supplied with the machine onto the thread spool as shown at right.

9. HOW TO DISENGAGE MOVABLE UPPER KNIFE

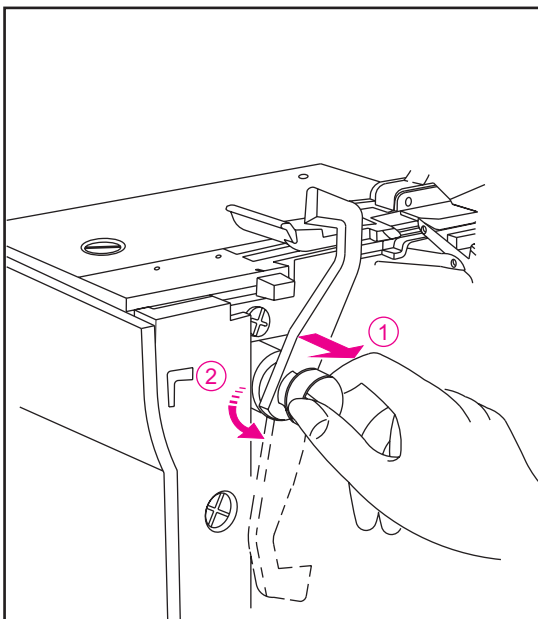


Caution:

Be sure to turn off power switch.

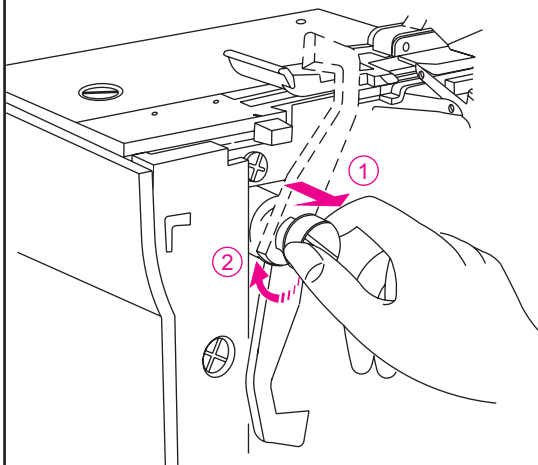
To place movable knife in nonworking position

- Open loop cover (page 8).
- Pull the movable knife holder to the right as far as it will go.
- Turn the holder toward counter clockwise until the knife clicks into a lock position.



To place movable knife in working position

- Open loop cover.
- Pull the movable knife holder to the right as far as it will go.
- Turn the holder clockwise until the knife clicks into the working position



Caution:

Always close loop cover before operating machine.

10. TO CONVERT UPPER LOOPER TO 2-THREAD CONVERTER



Caution:

Be sure to turn off power switch

When not threading the upper looper, the 2-thread converter must be engaged into the upper looper eye.

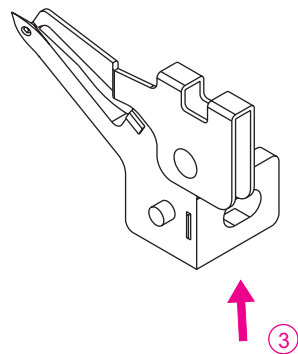
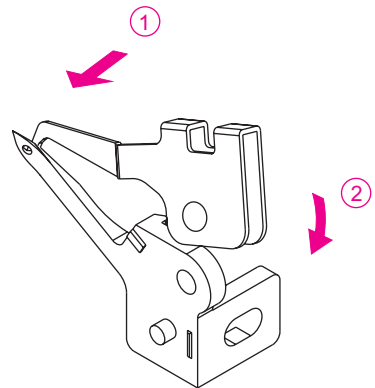
To Use the 2-thread converter

- ① To engage the 2-thread converter, insert the sharp part into the eye of upper looper.
- ② A raised point located in the trough of 2-thread converter must be inserted and fixed in the eye of the 2-thread converter.

- When using the upper looper, the 2-thread converter must be disengaged.

To Disengage to Upper Looper

- ③ To disengage the 2-thread converter, raise the handle of upper looper according to picture ③.

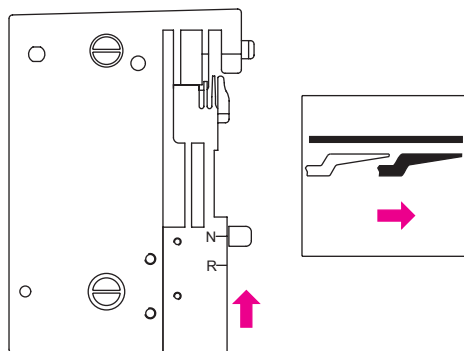


11. STANDARD OVEREDGE AND ROLLED HEM STITCHING

To Sew Standard Overedge

- Set seam width finger knob to N to move seam width finger to standard overedge sewing position.

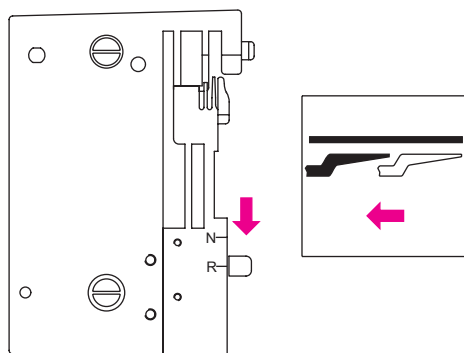
Note: Be sure to push seam width finger knob as far as it will go in the direction of setting N.



To Sew Rolled Hem

- Set seam width finger knob to R to retract the seam width finger and set it for rolled hem.

Note: Be sure to push seam width finger knob as far as it will go in the direction of setting R.



12. HOW TO REMOVE AND INSERT NEEDLES

Needle Position

- With this machines, two needles can be inserted to the needle clamp as shown in the drawing but only one or two needles are to be used for sewing.

- The Instruction Book refers to different needle positions by illustrating the needle clamp at right.

Note: When both the left and right overedge needles are inserted, the left needle will be slightly higher than the right.

To Remove Needle (s)



Caution:

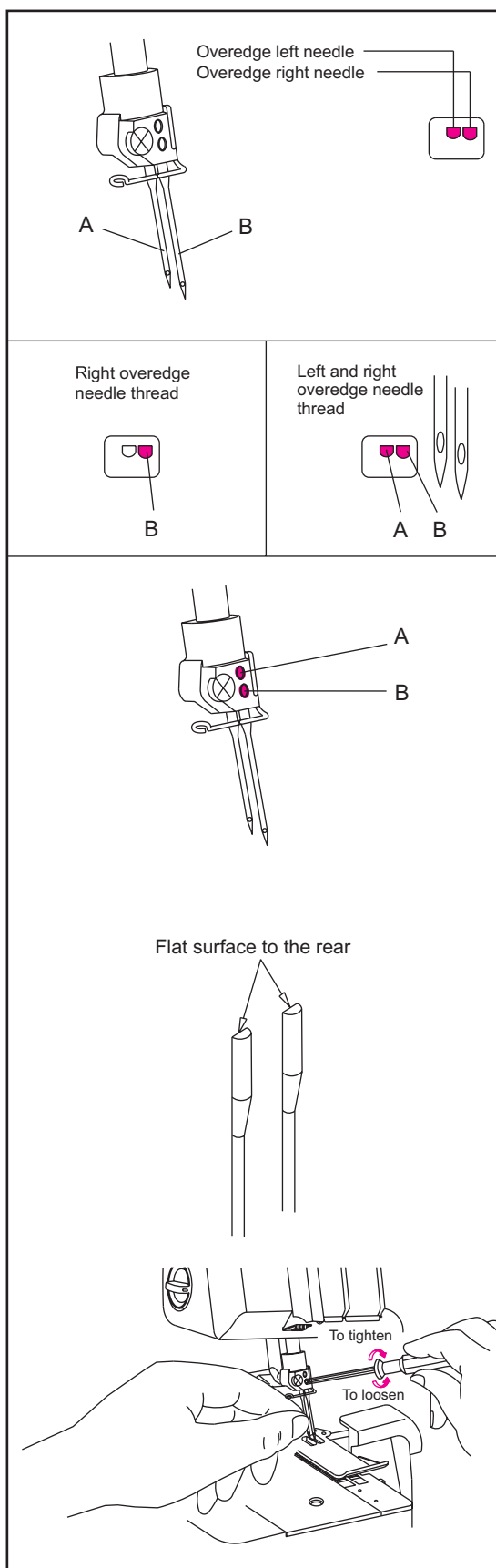
Be sure to disconnect the machine from the electric outlet before removing needle(s).

- Turn the hand wheel toward you until the needles are at their highest position.
- Place a thick piece of fabric [such as felt] under the presser foot. Lower the needles halfway into the fabric.
- Loosen, but do not remove the needle set screws with the small allen screwdriver. Hold the needles with your fingers and raise the needle bar. The needles will remain in the fabric.
 - A. Overedge left needle
 - B. Overedge right needle

To Insert Needles (s)

- Hold the needle with the flat surface to the back.
- Insert the needle into the needle socket as far as it will go.
- When inserting a needle, if you first lower it down into the hole in the throat plate it will line up with the needle socket. Then direct it upwards

Note: When inserting needles into the A or B sockets it is necessary to loosen both A & B Allen Screws. After inserting the needles equally tighten both Screws.



13. THREADING THE MACHINE

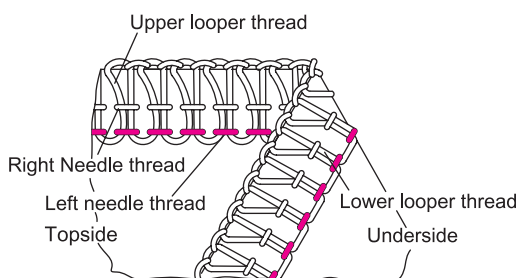
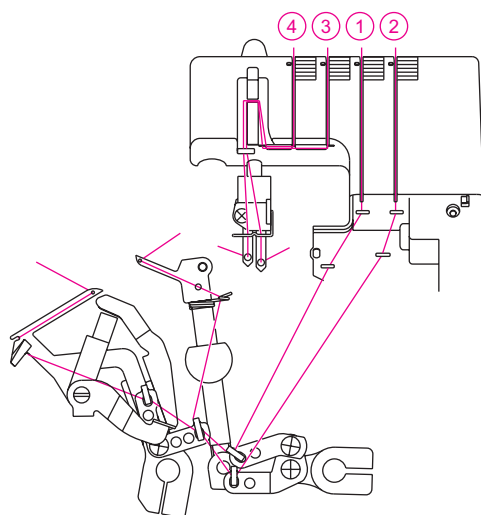
Threading Diagram: **Overlock and Safety Stitches**

- A color coded threading diagram is located inside the looper cover for quick reference.
- Thread the machine in the order 1 to 4 as shown at right.

Note: Threads go through the take-up lever cover for Overlock as shown.

Tension Color Code: **Overlock and Safety Stitch**

- | | |
|-----------------------------|--------|
| 1. Upper looper thread..... | Green |
| 2. Lower looper thread..... | Red |
| 3. Left needle thread..... | Orange |
| 4. Right needle thread..... | Blue |



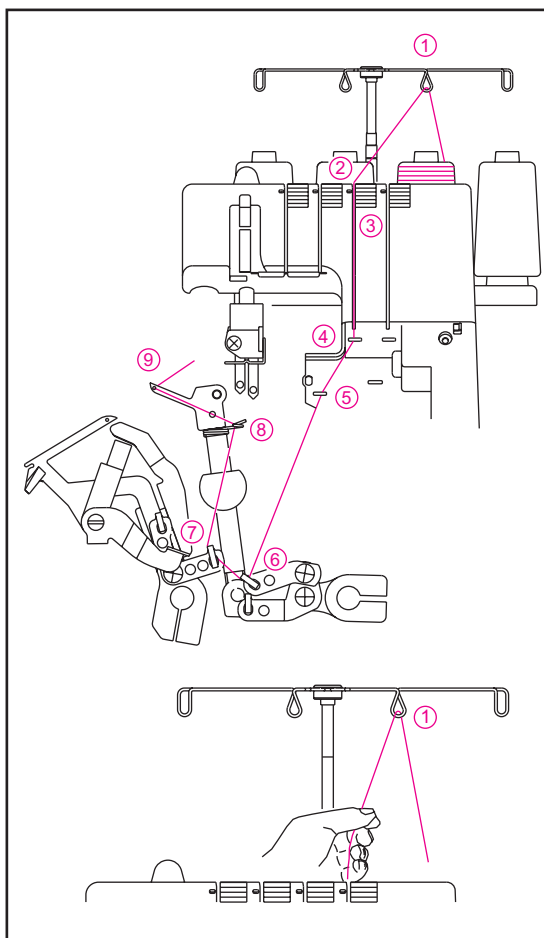
To Thread The Machine Correctly



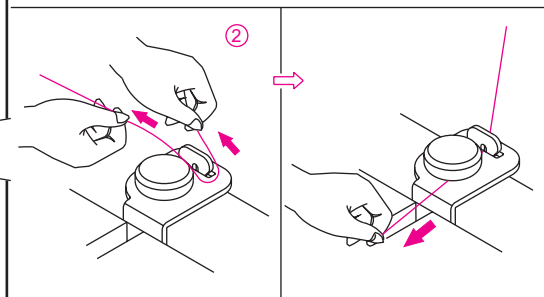
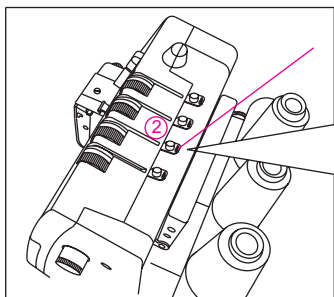
Caution:
Be sure to turn off power switch.

1) Threading the **Upper Looper** (Green)

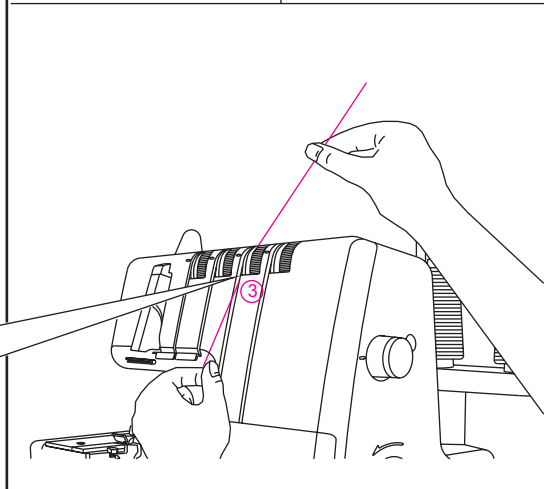
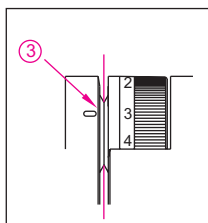
- Thread the upper looper as indicated 1~9.
- Raise Presser foot to release tension discs.
- Pass thread from back to the front through the thread guide 1.



- Thread the top cover thread guide by pulling the thread towards the left until it slips under guide. Then pull thread along the right side of button as illustrated.



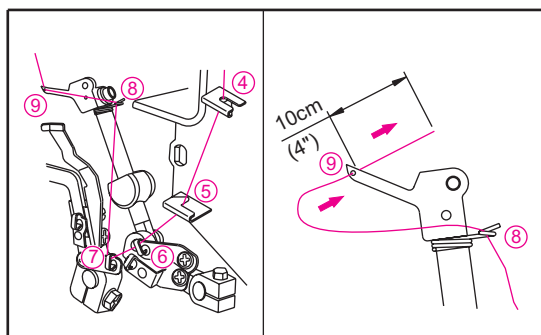
- While holding thread with fingers, pass it between the tension discs and pull thread down to make certain it is properly located in between the tension discs 3.



- Thread the looper area of the machine following the green color coded thread guides (4~9).
- Thread the hole in the upper looper from front to back 9. Note: Make sure thread passes behind lower looper.

Note: Use tweezers provided in the accessory case to aid in threading the looper.

- Pull about 10cm(4 inches) of thread through the looper and place to the back of the throat plate.

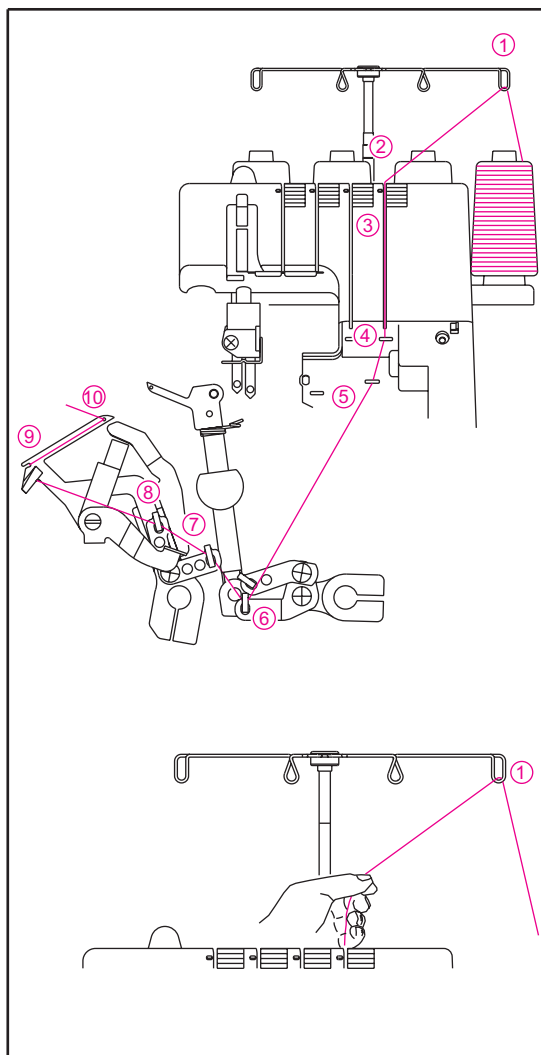


2) Threading the **Lower Looper (Red)**

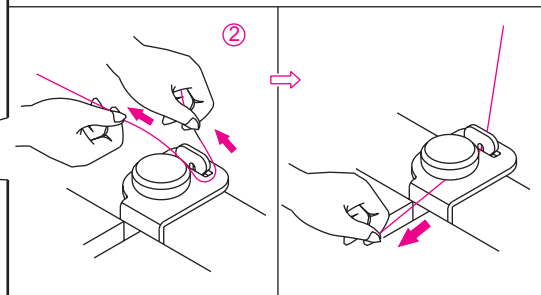
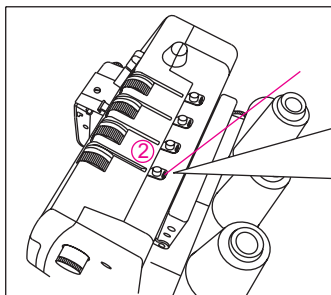
- Thread the lower looper as indicated 1~10.

- Raise Presser foot to release Tension discs

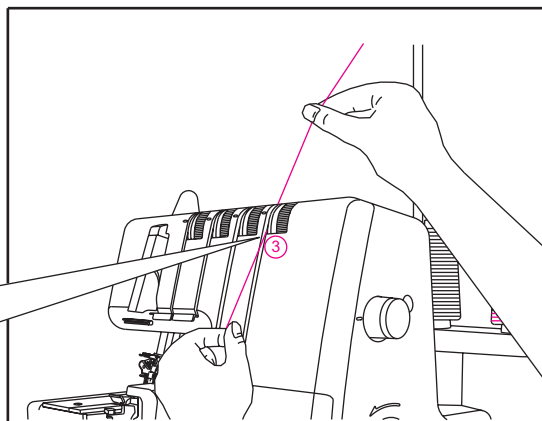
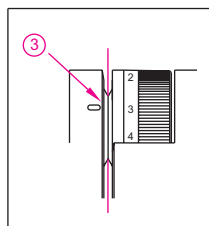
- Pass thread from back to the front through the thread guide 1.



- Thread the topcover thread guide by pulling the thread towards the left until it slips under guide. Then pull thread along the right side of button as illustrated.



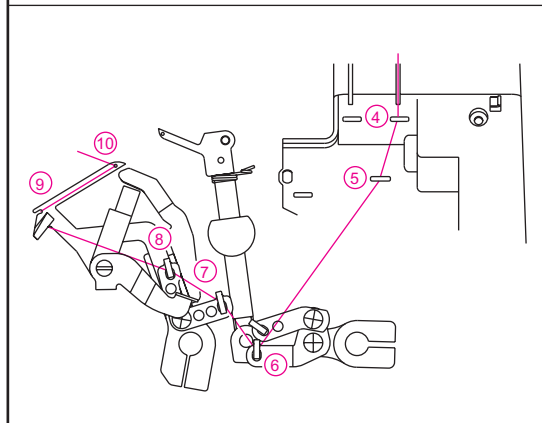
- While holding thread with finger, pass it between the tension discs and pull thread down to make certain it is properly located in between the tension discs 3.



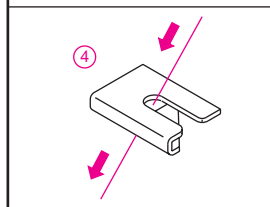
- Turn the hand wheel toward you until the lower looper extends out 5~10mm from the throat plate edge.

- Thread the looper area of the machine following the red color coded thread guides 4~10.

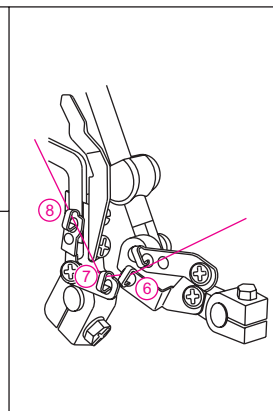
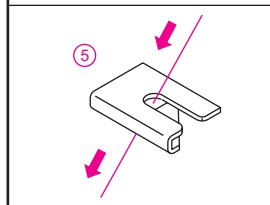
Note: Use tweezers provided in the accessory case to aid in threading the looper.



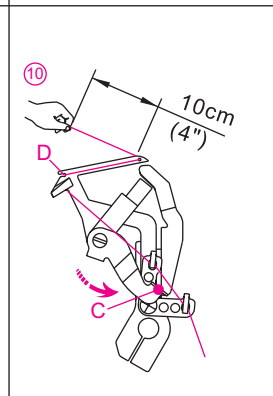
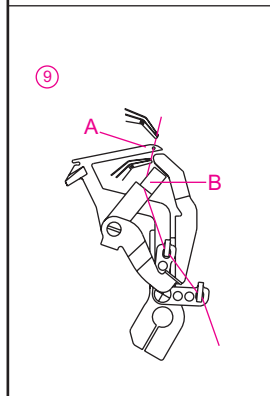
- Place the thread with the point of the tweezers slightly from left and to the right of threading guide 4.



- Place the thread with the point of the tweezers slightly from front and to the back of threading guide 5.



- Thread the looper eye (A) from front to back. Pull about 10cm (4 inches) of thread. Position thread into V cutout (B) on threader. Firmly hold thread tail with left hand and pull Threader lever (C) up into place (D).



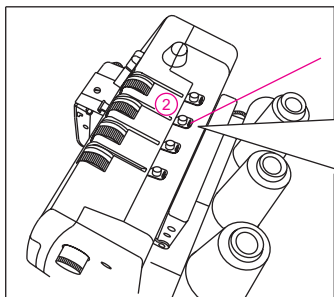
3) Threading the **Overedge Right Needle (Blue)** (B on needle clamp)

- Thread the right needle as indicated 1~9.

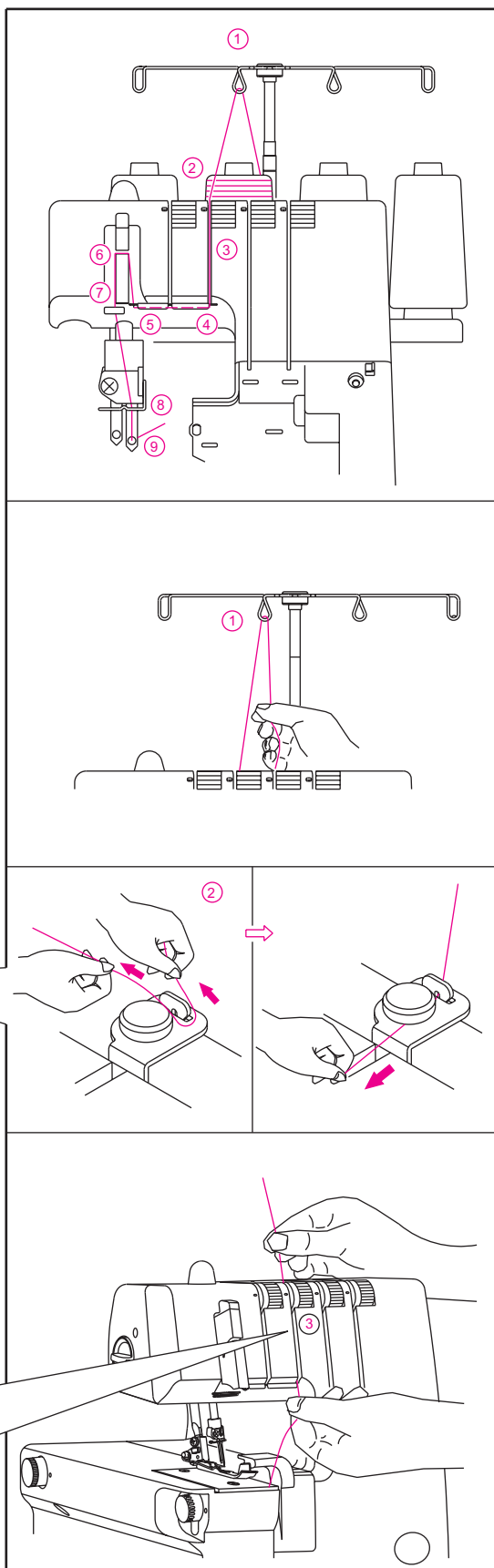
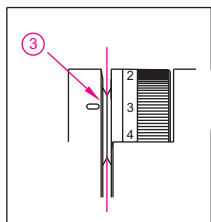
- Raise Presser foot to release Tension discs.

- Pass thread from back to the front through the thread guide 1.

- Thread the top cover thread guide by pulling the thread towards the left until it slips under guide. Then pull thread along the right side of button as illustrated.



- While holding thread with finger, pass it between the tension discs and pull thread down to make certain it is properly located in between the tension discs 3.



- Continue to thread points 4~8.

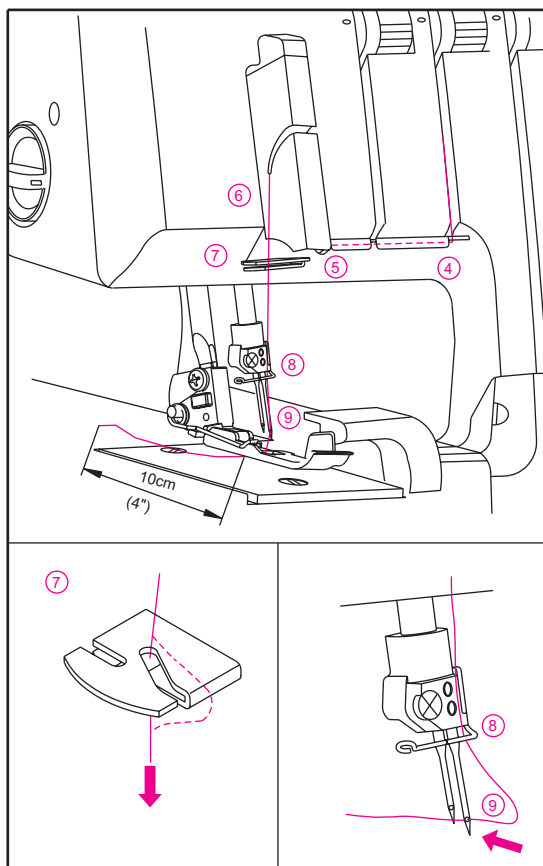
Note: Slip thread into the rear slot on the thread guide 5 and bottom slot of take-up lever cover 6. Then slip thread into the right slot on the thread guide 7, and into the right slot on the thread guide 8.

Before threading eye of needle, slip thread behind thread guide located on the bottom of the needle clamp.

- Thread the eye of the right needle 9.

Note: Use of tweezers in the accessory case will make needle eye threading easy.

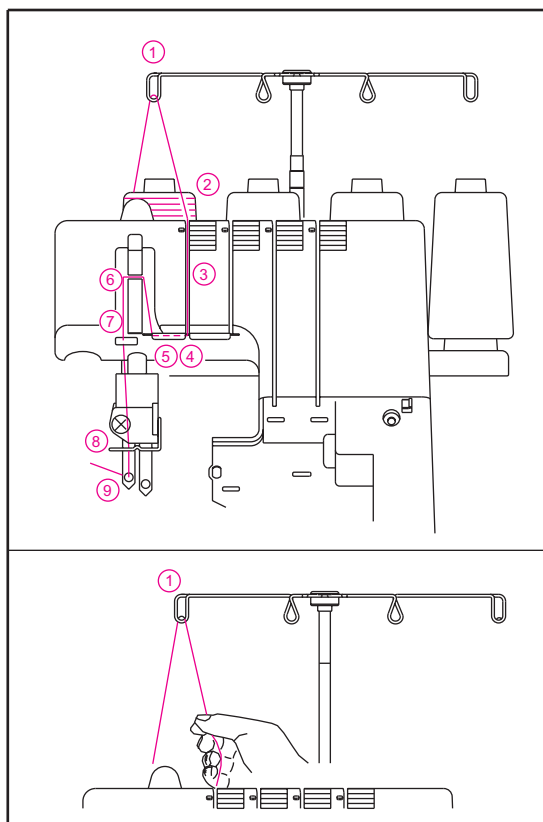
- The position of the thread must be behind the thread guide.
- Draw about 10cm(4 inches) of thread through needle eye towards the rear of machine.
- Place the thread to the back, under the presser foot.



4) Threading the **Overedge Left Needle (Orange)** (A on needle clamp)

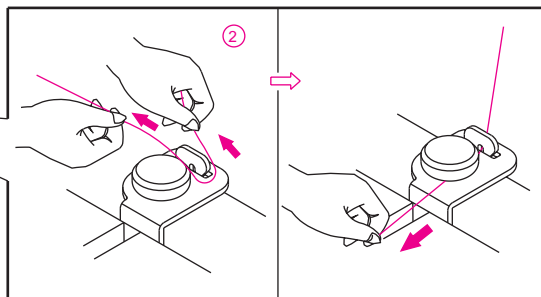
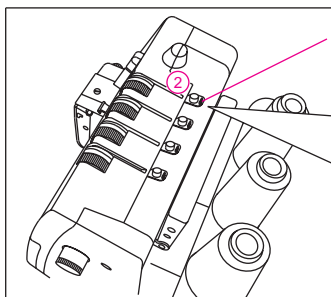
- Thread the left needle as indicated 1~9.

- Raise Presser foot to release Tension discs.

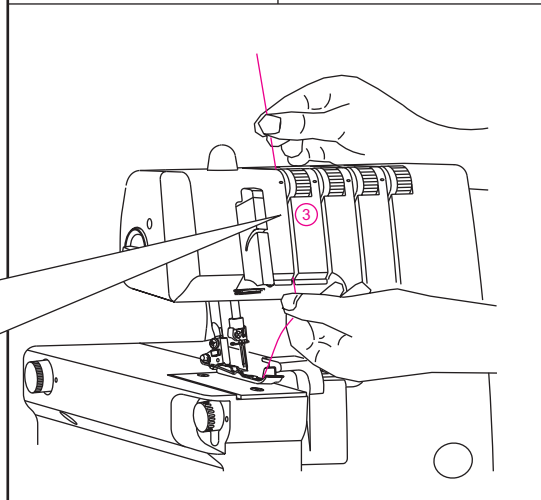
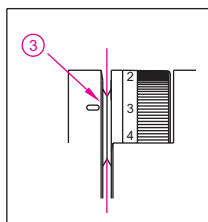


- Pass thread from back to the front through the thread guide 1.

- Thread the top cover threadguide by pulling the thread towards the left until it slips under guide. Then pull thread along the right side of button as illustrated.



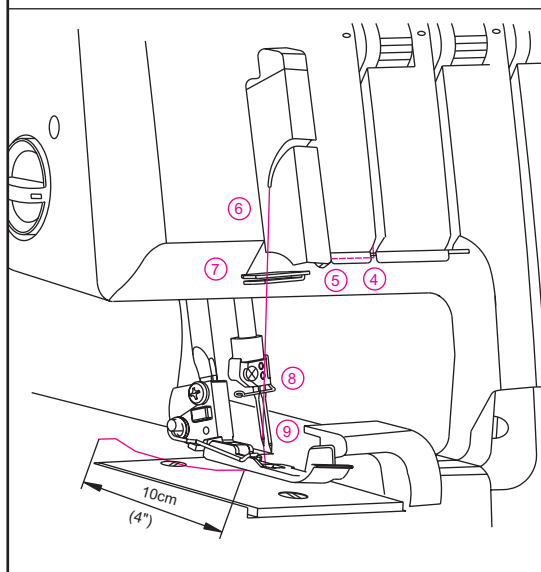
- While holding thread with fingers, pass it between the tension discs and pull thread down to make certain it is properly located in between the tension discs 3.



- Continue to thread points 4~8.

Note: Slip thread into the front slot of the thread guide 5 and into the lower slot of take-up lever cover 6.

Then continue by slipping thread into the Left slot of the thread guides 7 and 8.

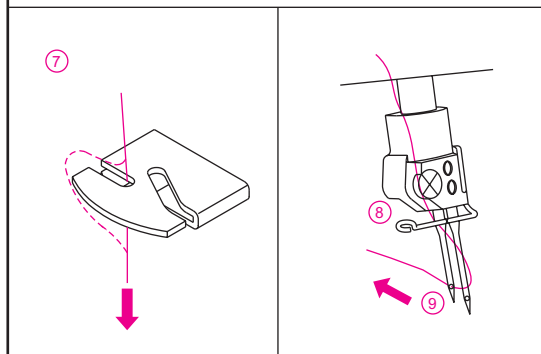


Before threading eye of needle, slip thread behind thread guide located on the bottom of the needle clamp.

- Thread the eye of the left needle 9.

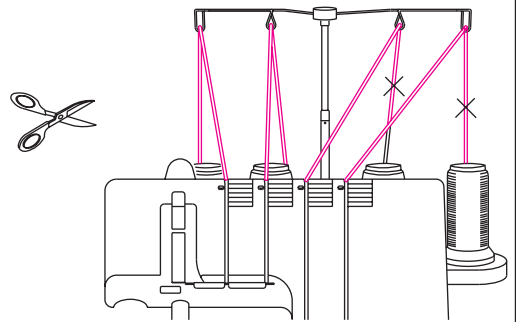
Note: Use of tweezers in the accessory case will make needle eye threading easy.

- The position of the thread must be behind the the thread guide.
- Draw about 10cm (4 inches) of thread through needle eye to hang free.
- Place the thread to the back, under the presser foot.

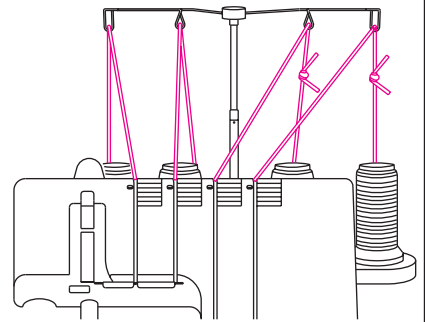


14. HOW TO CHANGE THREADS: TIE ON METHOD

- To change thread type or color, clip thread near the spool.

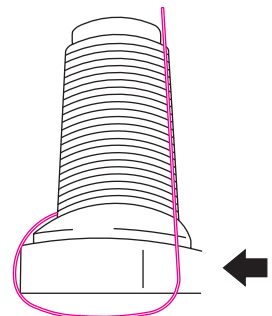


- Place new thread on stand.
- Tie new thread and old thread ends together with a square knot. Clip thread tails to 2~3cm (1 inch) length. If clipped too short, threads may come untied.
- Firmly pull both thread to test knot security.



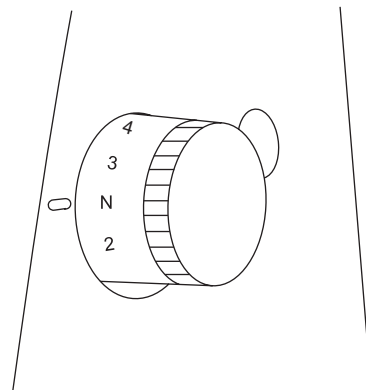
- Raise Presser foot to release Tension discs.

- Pull the threads through the machine one at a time.
- If threads do not pull easily, check for tangles on thread guides or looping under thread stand.
- When pulling thread through the needles, **STOP** when the knot is in front of the needle.
- Cut the thread, and insert it through the needle.



15. HOW TO ADJUST THE STITCH LENGTH

- The stitch length dial should be set on the N setting for most sewing conditions.
- Adjust the stitch length to N~ 4 when sewing heavy weight fabrics.
- Adjust the stitch length to 2~N when sewing lightweight fabrics to obtain excellent seams without puckering.



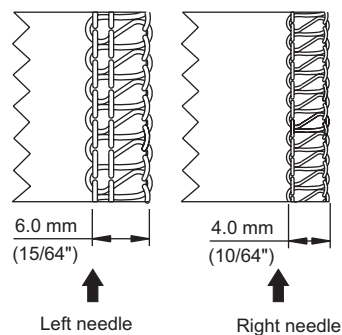
16. HOW TO ADJUST THE SEAM WIDTH

- Overedge seam width can be achieved by repositioning the needle position and also with the width adjustment knob.

Width Adjustment by Changing Needle Position

- Overedge seam width can be adjusted by changing the needle position.

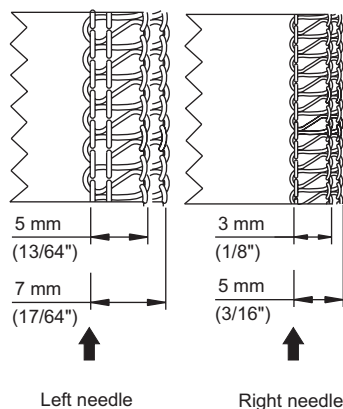
- When using left needle.....6 mm
(15/64 inch)
- When only right needle is used.....4 mm
(10/64 inch)



Width Adjustment with Adjustment Knob

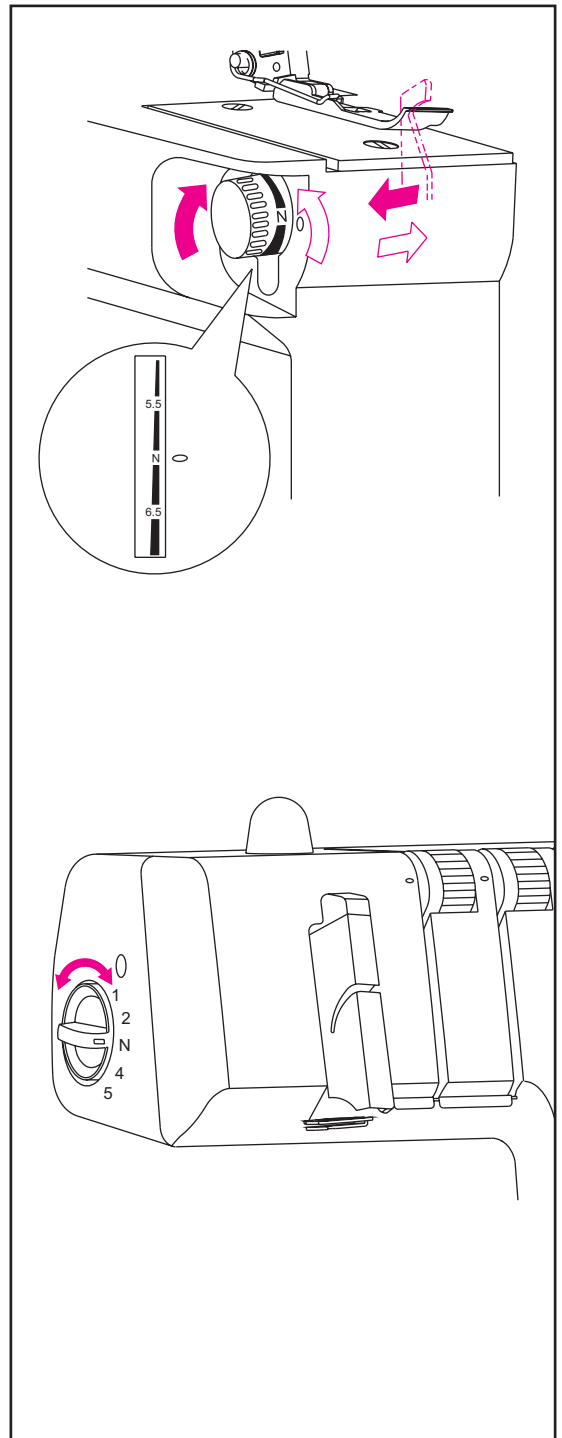
- Use of width adjustment knob will permit further adjustment within the width range shown below.

- When using left needle.....5 ~ 7 mm
(13/64 ~ 17/64 inch)
- When only right needle is used.....3.0 ~ 5.0 mm
(1/8 ~ 3/16 inch)



Width adjustment knob

As shown on the illustration, turn the dial counter clockwise to increase width of cutting, and clockwise to decrease width of cutting.



17. HOW TO ADJUST THE PRESSER FOOT PRESSURE

- The presser foot pressure of this machine is pre-adjusted at the factory to suit the sewing of medium weight fabrics.
- Most of the materials do not require adjustment of presser foot pressure. However, there are some instances where adjustment is necessary, such as when sewing lightweight and heavyweight fabrics.
- In such case, N for normal, 1 for the lightest pressure, and 5 for the heaviest.
- For lightweight fabric...Decrease the pressure
- For heavyweight fabric...Increase the pressure

18. DIFFERENTIAL FEED

- Differential feed is a system which "stretches" or "gathers" the fabric, when the amount of feed of front feed dogs in relation to the rear feed dogs is changed.
- The differential feed ratio ranges from 1:0.6~1:2.0. Adjustment is made by means of the differential feed adjusting dial pictured at right.
- Use of differential feed is very effective in overedging stretch fabrics and fabrics cut on the bias.
- Setting "N" is differential feed adjusting dial setting for ratio 1:1.

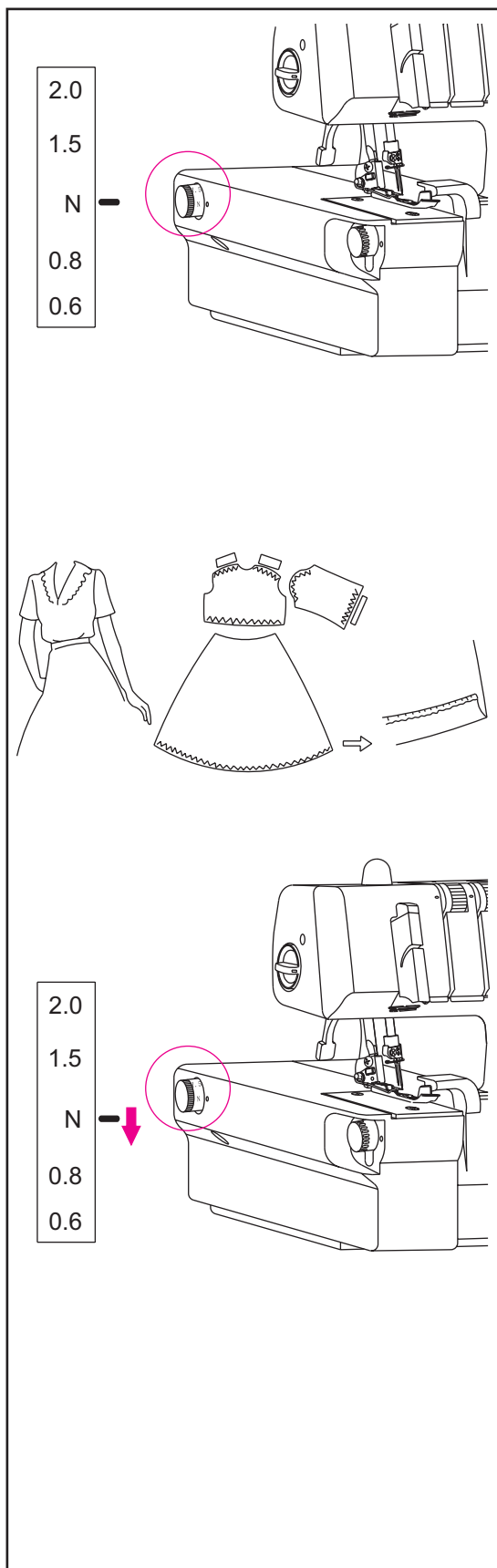
Gathered Overedge

- Gathered overedge is most suited for shirring sleeves, yokes, front and back bodices, skirt hems, etc. in stretch fabrics such as knits and jersey before assembling into garment.

To set the differential feed adjusting dial for gathering

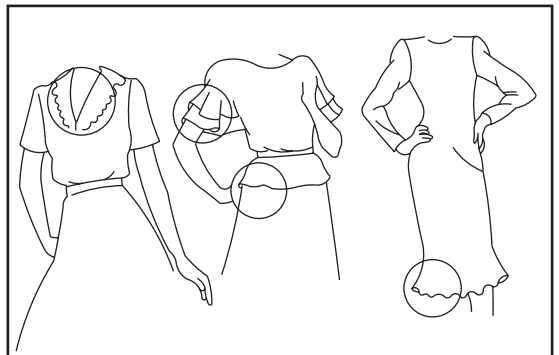
- Set differential feed adjusting dial below setting "N". Setting of adjusting dial depends on material being sewn as well as the amount of desired gather. Therefore set dial to suit the fabric and test sew before sewing your garment.

Note: For normal overedge stitching, set differential feed adjusting dial to graduation "N".



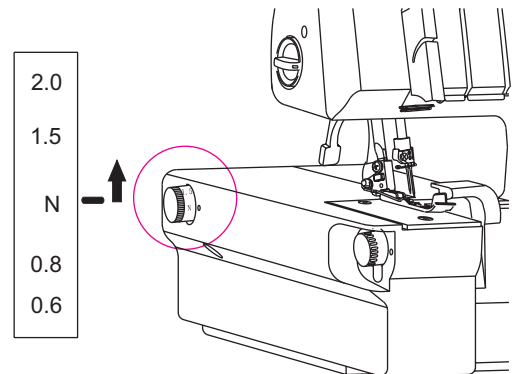
Stretch Overedge

- Stretch overedge is ideal for sewing decorative collars, sleeves, skirt hems, etc. on loosely knit and woven fabrics.



To set the differential feed adjusting dial for stretch

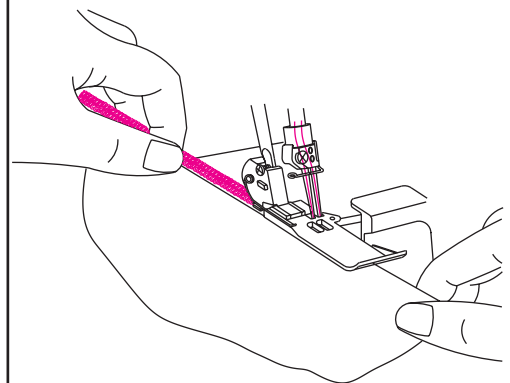
- Set differential feed adjusting lever knob above setting "N".



- To sew a seam, apply gentle tension to the fabric by holding the seam lightly in front and back of the presser foot.

Note: *if amount of "stretch" is not correctly set in relation to the fabric being sewn, the fabric is apt to shift away from the needle resulting in improperly sewn overedge seam. In such case, reset differential feed adjusting dial closer to the center mark.

*Be sure to reset the differential feed adjusting dial to graduation "N" for normal overedge stitching.



19. CHAINING OFF AND TEST SEWING

- When the machine is completely threaded, bring all of the threads across the throat plate and slightly to the left under the presser foot.
- Hold the threads and apply a slight tension.
- Turn the hand wheel toward you 2 or 3 complete turns to start the thread chain.
- Lower presser foot.
- Continue holding the chain and press on the foot controller until the chain is 5~7.5 cm (2~3 inches) in length.
- Place fabric under the front of the presser foot and sew a test sample.

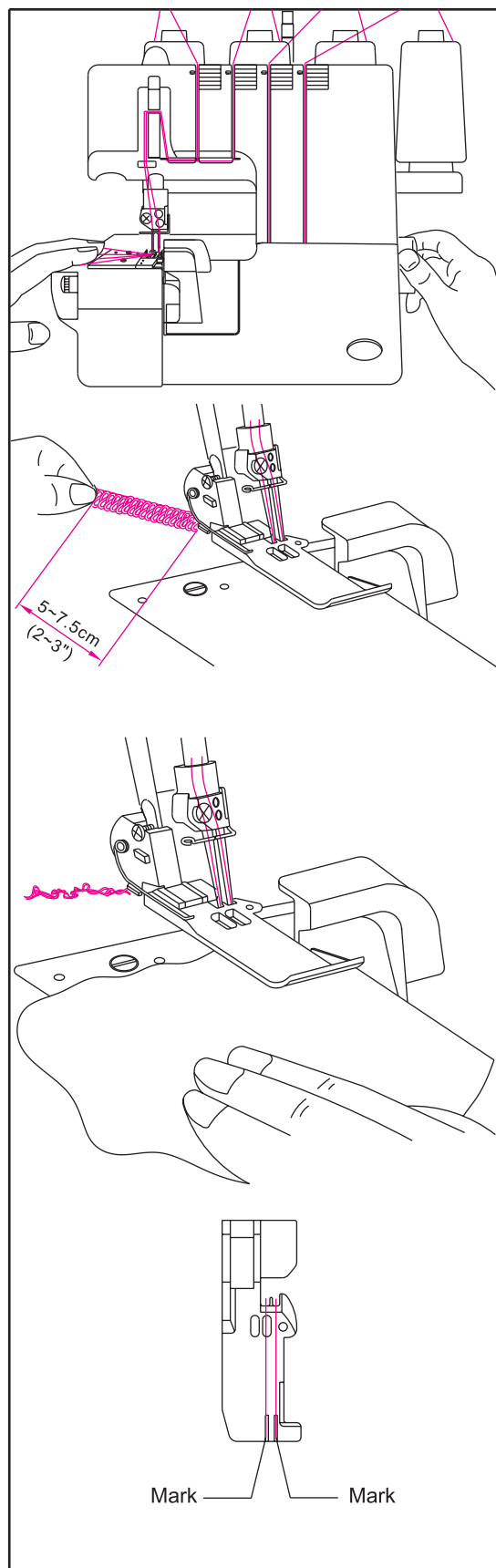
Note: Do not pull on the fabric while sewing as this may deflect the needle, causing it to break.

- At the end of the sample, continue to run the machine with the presser foot down until the chain reaches 15 ~20 cm (6~8 inches) in length.

Note: In case it is difficult to chain off when chain stitching, pull the fabric lightly backward.

- Cut thread.

Note: Anytime you have rethreaded the machine always chain off and sew a text sample to test tensions and make adjustments as necessary.

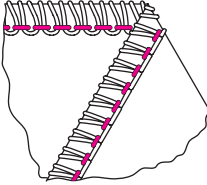
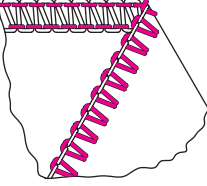
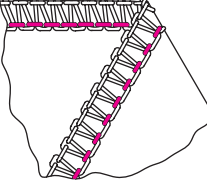
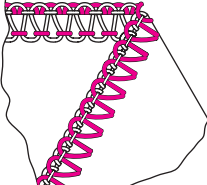
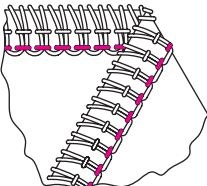
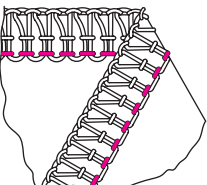
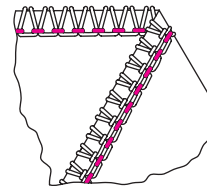


Information

- A mark to indicate the needle location is provided on the presser foot fitted on this machine. Use this mark as a guide when sewing.

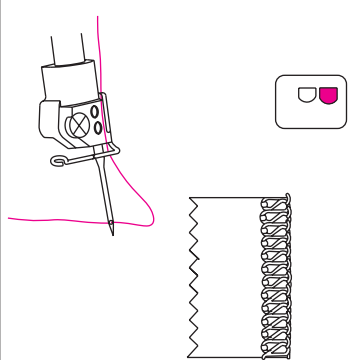
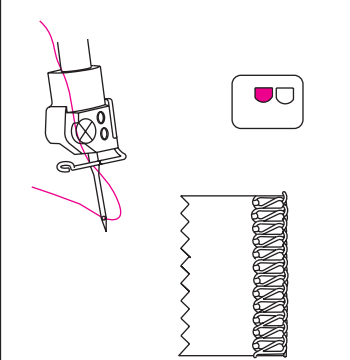
20. SELECTION OF STITCHES

This machine is capable of producing various types of stitches according to the combination of needle positions, threading methods, tension adjustment and the use of convertible right looper/converter.

Stitch Type			Reference Page
1. Two-thread Wrapped Edge Overlock		1-needle 2-thread stitch is used for seaming lightweight or stretch fabrics. It is also ideal for rolled and blind hemming. A 4 mm and 6 mm overlock seam width can be obtained by changing the needle position.	31
2. Two-thread Overedge		1-needle 2-thread stitch is used for overedging common fabrics. It is also ideal for flatlock (butted or lapped) seams and blind hemming. A 4 mm and 6 mm overedge seam width can be obtained by changing the needle position.	32
3. Three-thread Overlock		1-needle 3-thread stitch is used for overedging and seaming on common fabrics. A 4mm and 6 mm overlock seam width can be obtained by changing the needle position.	33
4. Three-thread Flatlock		1-needle 3-thread stitch is used for butted or lapped seams and ornamental stitching with decorative thread. Also, a 4 mm and 6 mm flatlock width can be obtained by changing the needle position.	34
5. Three-thread Ultra-Stretch Mock Safety Stitch		2-needle 3-thread stitch that is ideal for lightweight, extremely stretchy fabrics such as tricot and spandex.	35
6. Four-thread Ultra-Stretch Mock Safety Stitch		2-needle 4-thread stitch that is ideal for medium to heavyweight stretchy fabrics such as double knits and swim wear.	36
7. Three-thread Rolled Hem		1-needle 3-thread stitch is used for sewing narrow rolled hems.	38

* Depending on the needle positions used, this machine can sew 2-thread (option-2-thread converter is needed) and 3-thread standard width 4 mm overedge and a 6 mm wide overedge seams.

Also, for overedging heavyweight fabrics, the seam width can be increased still more by turning the overedge seam width adjustment knob. (See page 23)

Overedge width	4.0 mm	6.0 mm
Needle used	Overedge right needle	Overedge left needle
Needle thread tension dial	Blue	Orange
		

21. HANDY REFERENCE CHART

	Stitch Type		Tension Dial : Numbers shown are average settings on medium weight fabric with Standard#60 polyester spun thread				Page
			Orange	Blue	Green	Red	
1	Two - Thread Wrapped Edge Overlock	4.0mm 		6.5		4.0	31
		6.0mm 	8.5			3.0	31
2	Two - Thread Overedge	4.0mm 		1.0		5.5	32
		6.0mm 	1.0			5.0	32
3	Three - Thread Overlock	4.0mm 		4.0	4.0	4.0	33
		6.0mm 	4.0		3.5	3.5	33
4	Three - Thread Flatlock	4.0mm 		0.0	4.5	7.0	34
		6.0mm 	0.0		4.5	7.0	34
5	Three - Thread Ultra - Stretch mock Safety Stitch		8.5	4.0		3.0	35
6	four - Thread Ultra - Stretch mock Safety Stitch		4.0	4.0	4.0	4.0	36
7	Three-Thread Rolled Hem	4.0mm 		5.0	4.0	7.0	38

The thread tension becomes tighter as the dials are turned to higher numbers. The tension settings shown on this page as well as throughout the Instruction book are suggested guides. Adjust thread tensions to suit the fabric and size of thread of thread used. For best results make tension adjustments in small increments of no greater than half a number at a time.

22. SUGGESTED TENSION SETTING

1) 2-thread Wrapped Edge Overlock

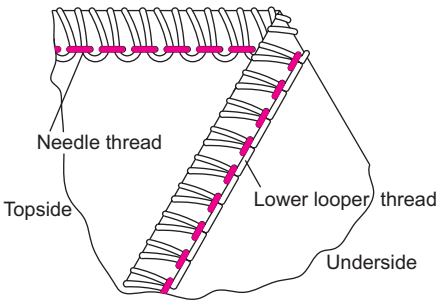
Note: * These are suggested tension settings only.

- * Tension settings are effected by;
1) Type and thickness of fabric
2) Needle size
3) Size, type and fiber content of thread

Correct Balance

- Set each tension dial to setting shown at right and test sew on a sample of your fabric.

NEEDLE POSITION		
SEAM WIDTH FINGER KNOB	N	
STITCH LENGTH	2 ~ 4	
CONVERTER	USE	

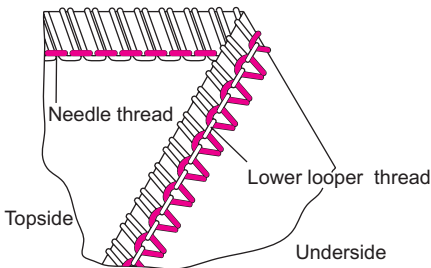


Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight		6.5	Converter	4.0

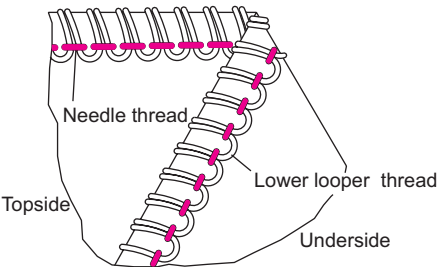
Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight	8.5		Converter	3.0

How to Balance

- When the lower looper thread tension is too tight or needle thread tension is too loose;
-Turn the lower looper thread tension dial (red) toward a lower number.
-Or, turn the needle thread tension dial (orange or blue) toward a higher number.



- When the lower looper thread tension is too loose;
-Turn the lower looper thread tension dial (red) toward a higher number.



2) 2-thread Overedge

Note: * These are suggested tension settings only.

* Tension settings are effected by;

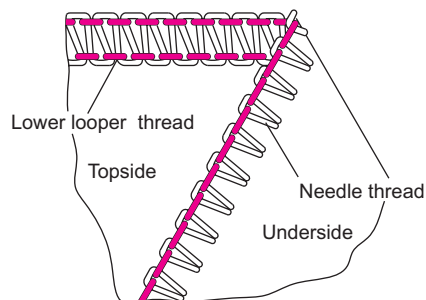
- 1) Type and thickness of fabric
- 2) Needle size
- 3) Size, type and fiber content of thread

* See page 25 for instructions on converting upper looper to spreader.

Correct Balance

- Set each tension dial to settings shown at right and test sew on a sample of your fabric.

NEEDLE POSITION		
SEAM WIDTH FINGER KNOB	N	
STITCH LENGTH	2~4	
CONVERTER	USE	

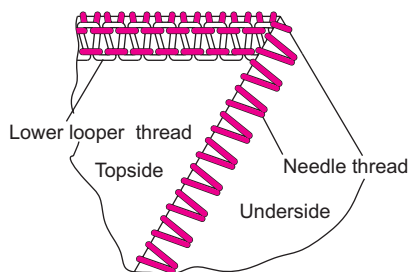
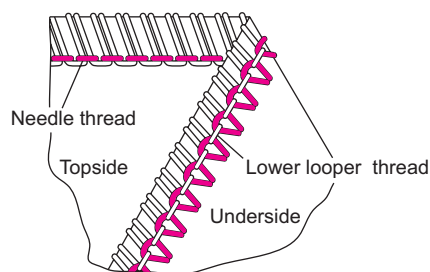


Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight		1.0	Converter	5.5

How to Balance

- When the lower looper thread lies on the underside of the fabric;
 - Turn the lower looper thread tension dial (red) toward a higher number.
 - Or, turn the needle thread tension dial (orange or blue) toward a lower number.

- When the needle thread tension is too loose;
 - Turn the needle thread tension dial (orange or blue) toward a higher number.
 - Or, turn the lower looper thread tension dial (red) toward a lower number.



3) 3-thread Overlock

Note: * These are suggested tension settings only.

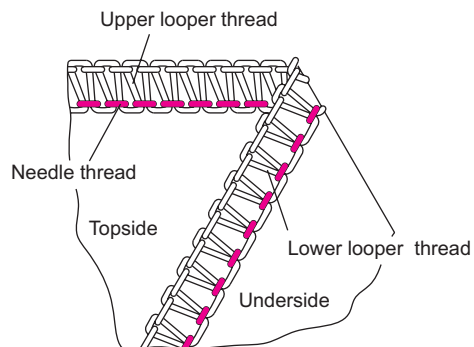
* Tension settings are effected by;

- 1) Type and thickness of fabric
- 2) Needle size
- 3) Size, type and fiber content of thread

Correct Balance

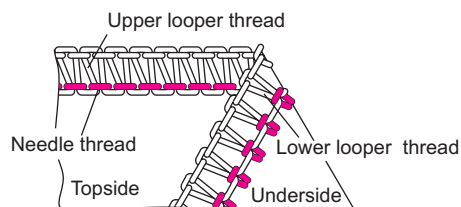
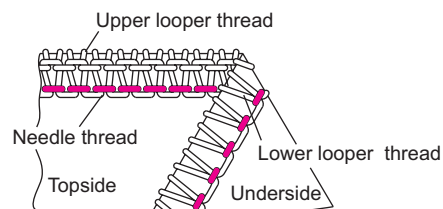
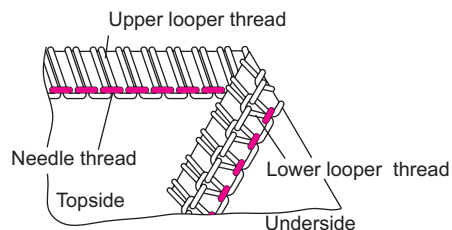
- Set each tension dial to settings shown at right and test sew on a sample of your fabric.

NEEDLE POSITION		
SEAM WIDTH FINGER KNOB	N	
STITCH LENGTH	2~4	
CONVERTER	N/A	



Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight		4.0	4.0	4.0

Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight	4.0		3.5	3.5



How to Balance

- When the upper looper thread lies on the underside of the fabric;
 - Turn the upper looper thread tension dial (green) to a higher number.
 - Or, turn the lower looper thread tension dial (red) to a lower number.
- When the lower looper thread appears on the top of the fabric;
 - Turn the lower looper thread tension dial (red) toward a higher number.
 - Or, turn the upper looper thread tension dial (green) to a lower number.
- When the needle thread is too loose, turn the needle tension dial (orange or blue) to a higher number.

4) 3-thread Flatlock

Note: * These are suggested tension settings only.

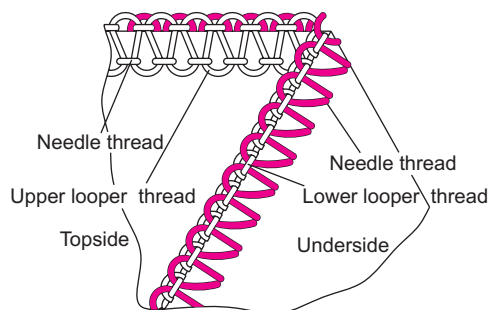
* Tension settings are effected by;

- 1) Type and thickness of fabric
- 2) Needle size
- 3) Size, type and fiber content of thread

Correct Balance

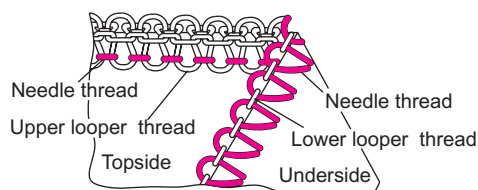
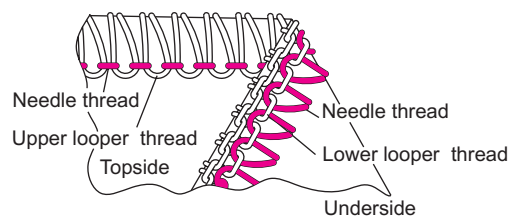
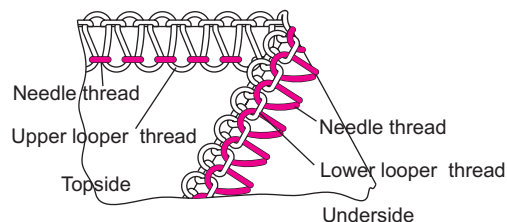
- Set each tension dial to settings shown at right and test sew on a sample of your fabric.

NEEDLE POSITION		
SEAM WIDTH FINGER KNOB	N	
STITCH LENGTH	2~4	
CONVERTER	N/A	



Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight		0	4.5	7.0

Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight	0		4.5	7.0



How to Balance

- When the lower looper thread tension is too loose;
 - Turn the lower looper thread tension dial (red) toward a higher number.
 - Or, turn the needle thread tension dial (orange or blue) toward a lower number.
- When the upper looper thread tension is too loose;
 - Turn the upper looper thread tension dial (green) toward a higher number.
 - Or, turn the needle thread tension dial (orange or blue) toward a lower number.
- When the needle thread tension is too loose;
 - Turn the needle thread tension dial (orange or blue) toward a higher number.
 - Or, turn the upper looper thread tension dial (green) toward a lower number.

5) 3-thread Ultra Stretch Mock Safety Stitch

Note: * These are suggested tension settings only.

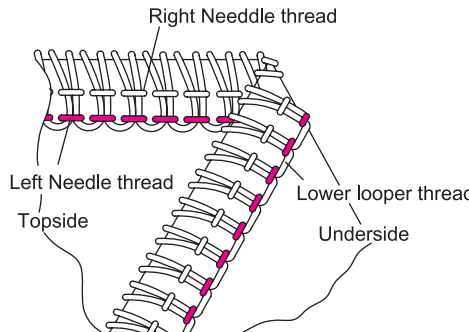
* Tension settings are effected by;

- 1) Type and thickness of fabric
- 2) Needle size
- 3) Size, type and fiber content of thread

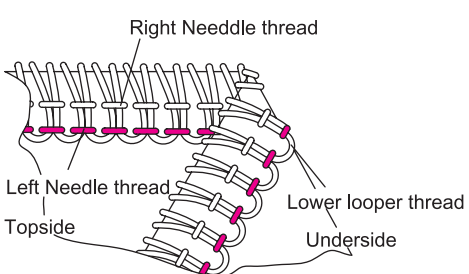
Correct Balance

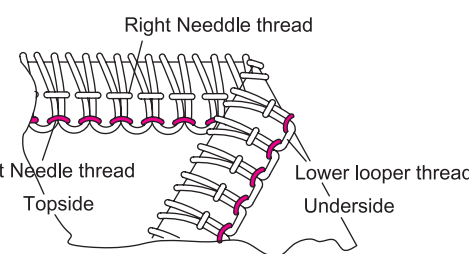
- Set each tension dial to settings shown at right and test sew on a sample of your fabric.

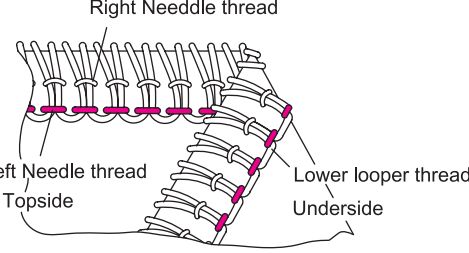
NEEDLE POSITION	
SEAM WIDTH FINGER KNOB	N
STITCH LENGTH	2~4
CONVERTER	USE



Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight	8.5	4.0	Converter	3.0







How to Balance

- When the lower looper thread tension is too loose;
-Turn the lower looper thread tension dial (red) toward a higher number.
- When the left needle thread tension is too loose;
-Turn the left needle thread tension dial (orange) toward a higher number.
- When the right needle thread tension is too loose;
-Turn the needle thread tension dial (blue) toward a higher number.

6) 4-thread Ultra Stretch Mock Safety Stitch

Note: * These are suggested tension settings only.

* Tension settings are effected by;

- 1) Type and thickness of fabric
- 2) Needle size
- 3) Size, type and fiber content of thread

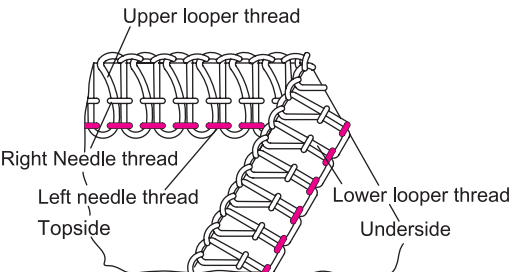
Correct Balance

- Set each tension dial to settings shown at right and test sew on a sample of your fabric.

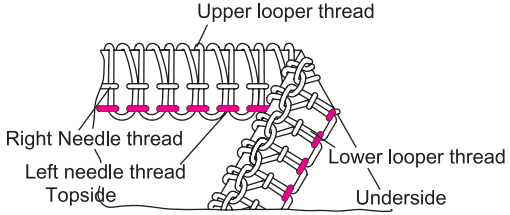
How to Balance

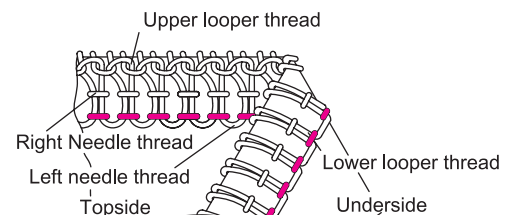
- When the upper looper thread lies on the underside of the fabric;
 - Turn the upper looper thread tension dial (green) toward a higher number.
 - Or, turn lower looper thread tension dial (red) to a lower number.
- When the lower looper thread appears on the top of the fabric;
 - Turn the lower looper thread tension dial (red) toward a higher number.
 - Or, turn the upper looper thread tension dial (green) toward a lower number.
- When the left needle thread tension is too loose;
 - Turn the needle thread tension dial (orange) toward a higher number.
- When the right needle thread tension is too loose;
 - Turn the right needle thread tension dial (blue) toward a higher number.

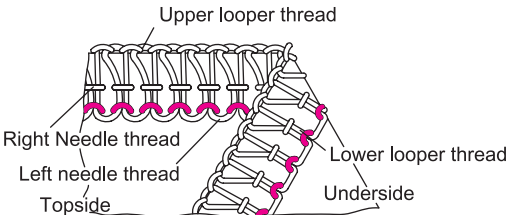
NEEDLE POSITION	
SEAM WIDTH FINGER KNOB	N
STITCH LENGTH	2~4
CONVERTER	N/A

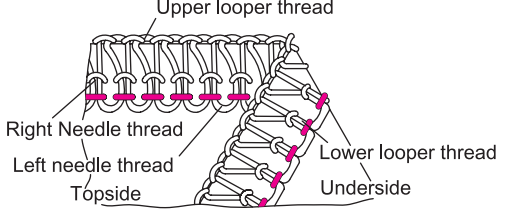


Fabric	Tension Dial			
	Orange	Blue	Green	Red
Medium weight	4.0	4.0	4.0	4.0









23. HOW TO SEW A ROLLED HEM

- This machine can sew four types of rolled hems.
- Rolled hemming is done by rolling and overedging the fabric edge.
- Light weight fabrics such as lawn, voile, organdy, crepe, etc. perform the best.
- Rolled hemming is not suited for heavy or stiff fabrics.

NOTE: Rolled hemming can only be performed with the overedge right needle.

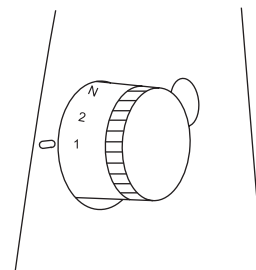
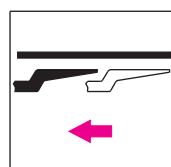
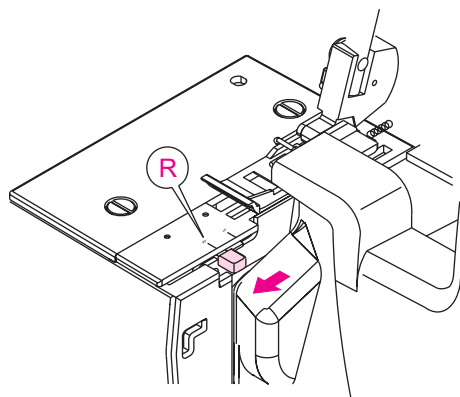
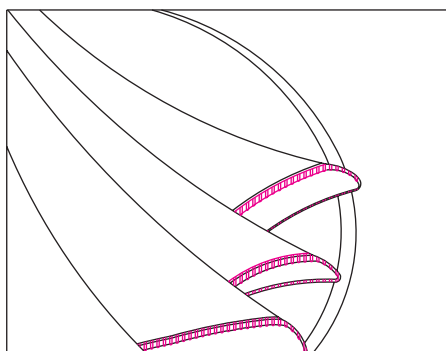
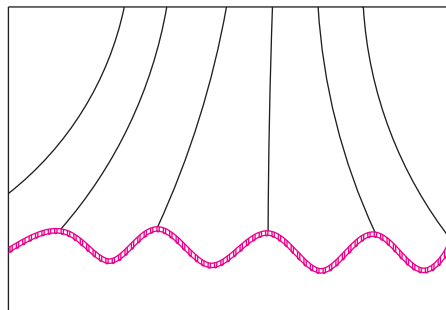
Machine Set up



Caution:

Be sure to turn off power switch.

- Remove the overedge left needle.
- Move seam width finger knob to setting R.
- Align left face of seam width finger support plate with R mark on throat plate by turning seam width adjustment knob, as required.
- Set stitch length dial to "1~2" and a fine seam will be sewn.
- Needle: HAx1 (130/705H)
- Thread: A variety of thread combinations can be Used for rolled hemming.



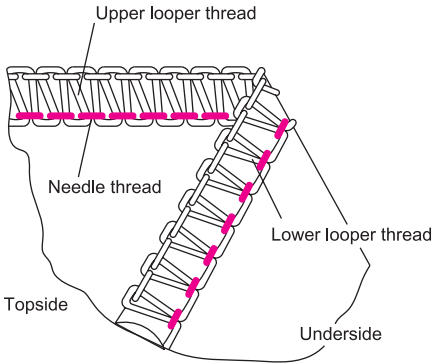
Note: For a beautiful rolled hem thread the upper looper with wooly nylon and the needle and lower looper with lightweight regular thread.

1) 3-thread Standard Rolled Hem Stitching

Correct Balance

- Set each tension dial to settings shown at right and test sew on a sample of your fabric.

NEEDLE POSITION	
SEAM WIDTH FINGER KNOB	R
STITCH LENGTH	1~2

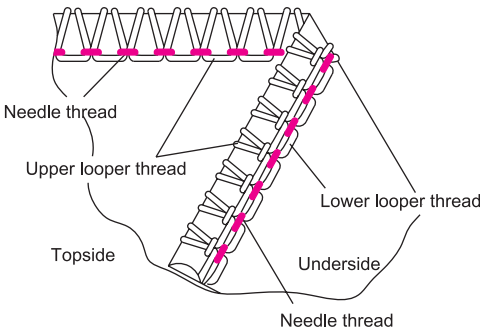


Light Weight fabric	Tension Dial			
	Orange	Blue	Green	Red
Polyester		4.0	5.0	4.0
Woolly nylon		4.0	0	4.0

2) 3-thread Upper Looper Thread Wrapped Rolled Hem Stitching

Correct Balance

- Set each tension dial to settings shown at right and text sew on a sample of your fabric.



Light Weight fabric	Tension Dial			
	Orange	Blue	Green	Red
Polyester		5.0	4.0	7.0
Woolly nylon		5.0	0	7.5

Note: For a beautiful rolled hem thread the lower looper with wooly nylon and the needle with lightweight regular thread.

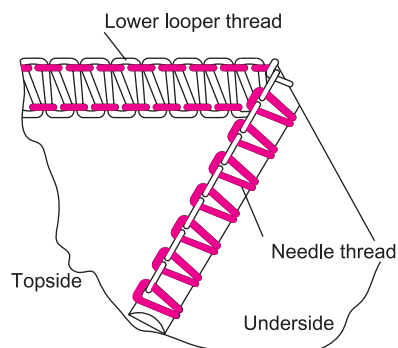
- Convert upper looper to spreader (See page 12)

3) 2-thread Standard Rolled Hem Stitching

Correct Balance

- Set each tension dial to setting shown at right and test sew on a sample of your fabric.

NEEDLE POSITION	
SEAM WIDTH FINGER KNOB	R
STITCH LENGTH	1~2

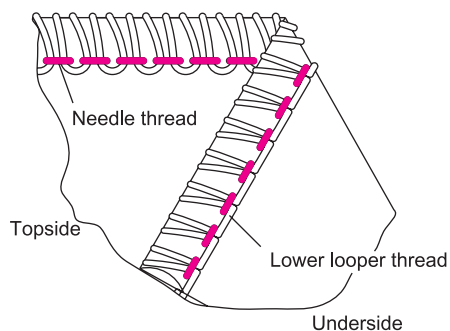


Light Weight fabric	Tension Dial			
	Orange	Blue	Green	Red
Woolly nylon		3.5		3.0

4) 2-thread Lower Thread Wrapped Rolled Hem Stitching

Correct Balance

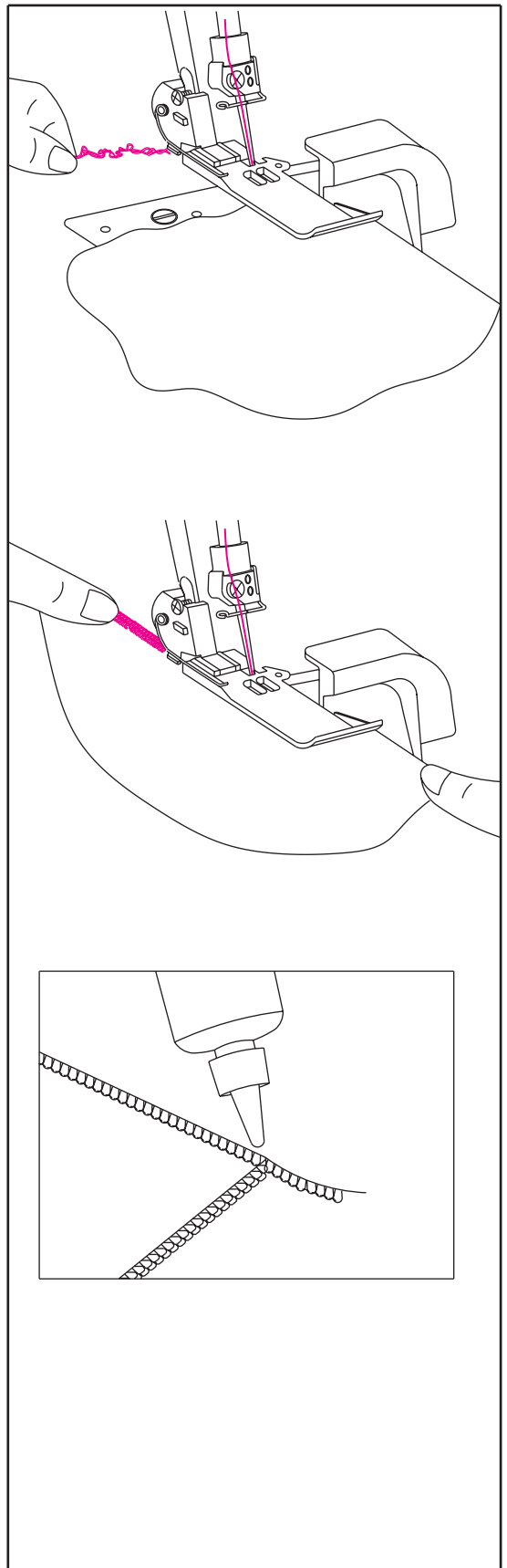
- Set each tension dial to setting shown at right and test sew on a sample of your fabric.



Light Weight fabric	Tension Dial			
	Orange	Blue	Green	Red
Polyester		4.5		4.0
Woolly nylon		4.5		2.5

Additional Information About Rolled Hemming

- Hold the thread chain when you begin sewing to keep it from curling into the seam.
- Place a slight tension on the material in the sewing direction and a finer seam finish can be obtained.
- The minimum overedge stitch width that can be obtained for rolled hemming is approximately 1.5 mm (1/16 inch) since the cutting width cannot be set below 3.5 mm (9/64 inch).



To Secure the Rolled Hem Thread Chain

- Apply a small drop of liquid seam sealant to the end of the seam. Allow to dry, then cut the chain close to the stitches.

Note: Test the liquid seam sealant for color fastness before use.

24. STITCH VARIATIONS AND SEWING TECHNIQUES

How to Sew a Flatlock Decorative Seam

- A flatlock stitch is achieved by adjusting the tension of the 2-thread (option) or 3-thread overlock stitch, sewing the seam, and then pulling the fabric apart to flatten the seam.
- The flatlock stitch can be used as a construction and decorative stitch or for ornamentation only.

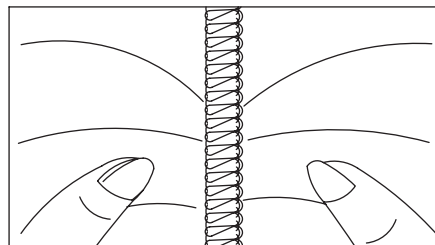
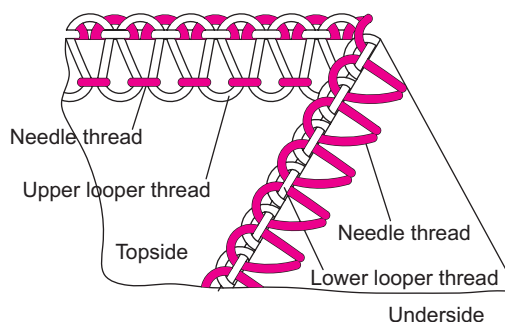
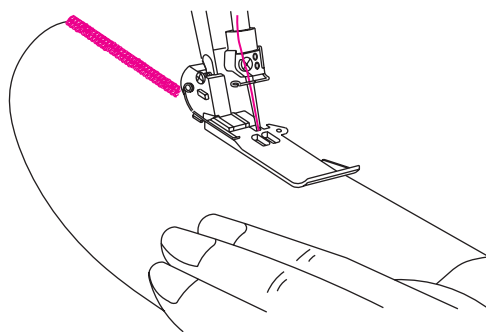
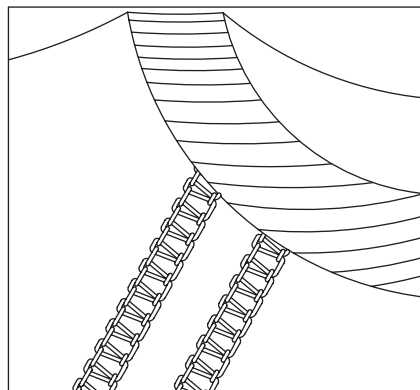
1) Machine Set Up

- Use either overedge right needle or overedge left needle.
- Begin with the machine threaded and tension balanced for the 2-thread overedge (page 32) or 3-thread flatlock stitch (page 34).

2) Flatlocking a Seam

- Place the fabric wrong sides together to sew a decorative stitch on the right side of the garment.
- Sew the seam, trimming the excess fabric.
- The needle thread (orange or blue) will form a V on the underside of the fabric.
- The lower looper thread will pull into a straight line at the fabric edge.

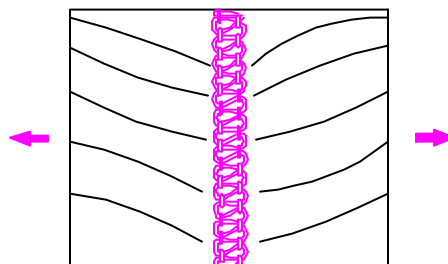
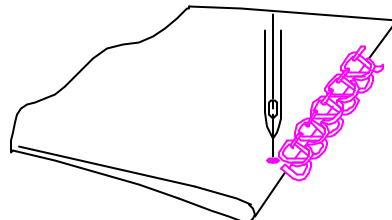
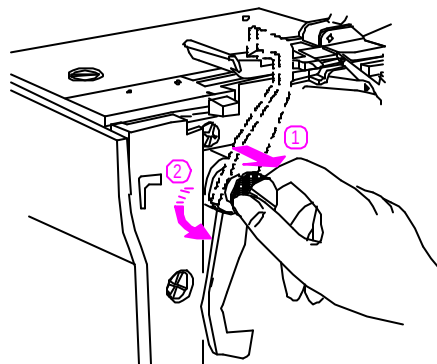
- Pull on opposite sides of the seam to pull the stitches flat.



3) Decorative Flatlocking

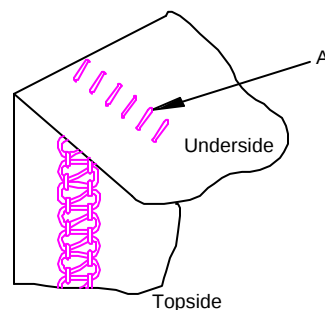
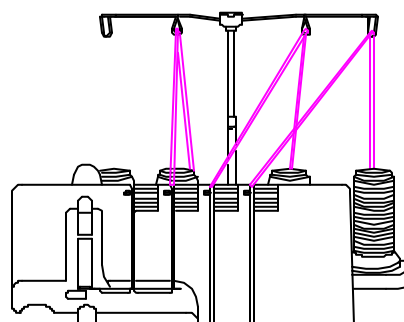
- Place the movable upper knife in the nonworking position (page 11). The fabric is not trimmed on this stitch.

- Fold fabric wrong sides together.
- Position the fabric so the seam is sewn with part of the stitch extending off the fabric.
- Pull on opposite sides of the stitch to flatten.



4) Additional Information About Flatlocking

- The tensions must be correctly adjusted for the fabric to pull flat.
- The upper looper thread is the prominent thread in the flatlock stitch. Place a decorative thread in the upper looper and inconspicuous threads in the lower looper and needle.
- For a ladder stitch, sew seam with right sides together. The needle thread will be the prominent thread that creates the ladder. (A)



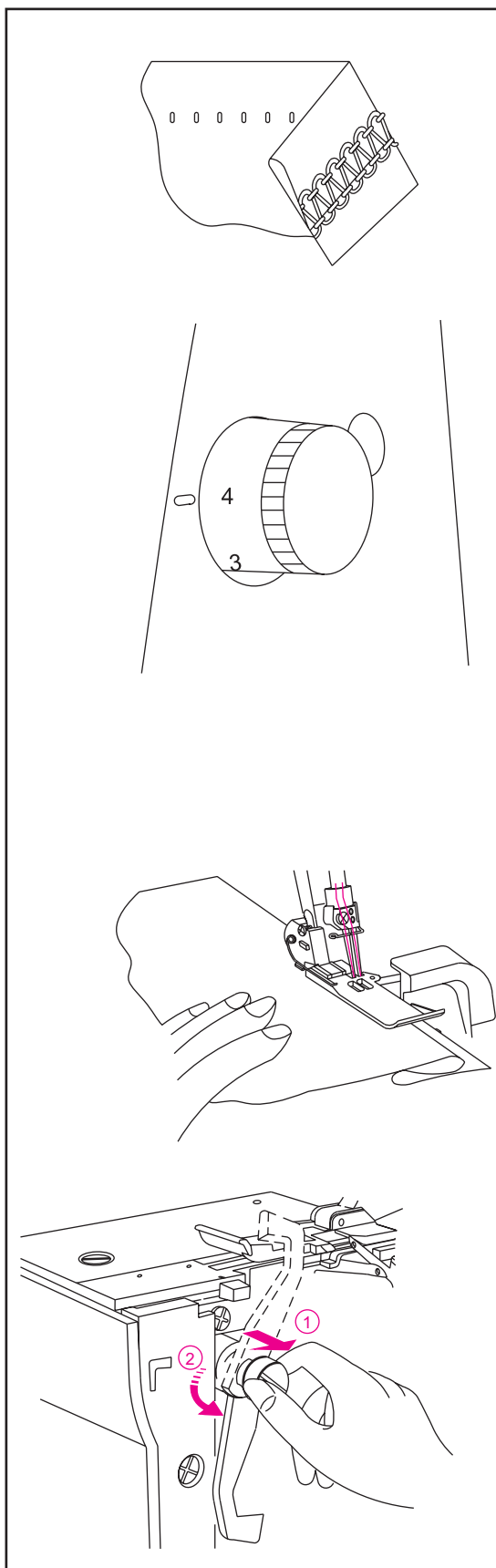
How to Sew an Overlock Blind Hem

- The excess fabric is trimmed and the hem is sewn and the raw edges are overlocked in one operation.
- The overlock blind hem is best suited for sewing knit wear. It provides a durable finish that is almost invisible.
- Use overedge right needle and adjust machine for a narrow 3-thread overlock stitch. (See page 33)

Note: The three-thread flatlock stitch can also be used.
(See page 34)

- Set the stitch length dial at 4
- Fold the hem to the wrong side of the fabric, then back to the right side with 6 mm (1/4 inch) beyond the fold.
- Stitch on the extended hem edge, allowing the machine needle to barely catch the edge of the fold.

Note: An optional blindstitch foot is available.
(See page 50)



How to Sew Pin Tucks

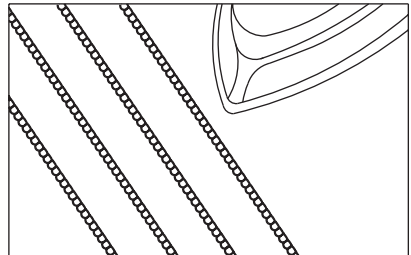
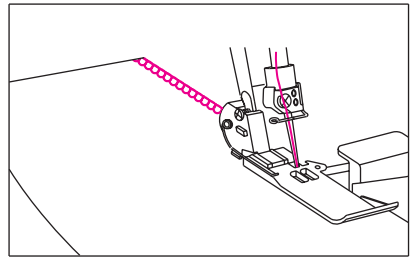
- Sew decorative pin tucks on the fabric before cutting out the garment.
- Use overedge right needle and adjust machine for a narrow 3-thread overlock stitch. (See page 33)

Note: The rolled hemstitch can also be used for this technique.

- Place the movable upper knife in the nonworking position. (See page 11)
- Mark the fabric with the desired number of pin tucks using a water-soluble fabric marker

- Fold the fabric with the wrong sides together and sew.

- Press the pin tucks in the same direction.



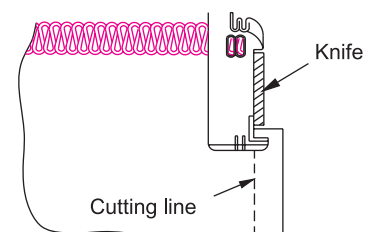
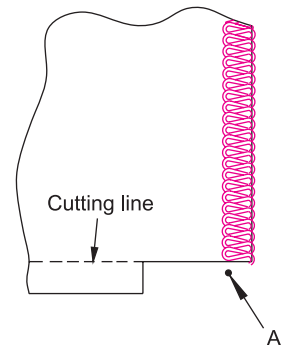
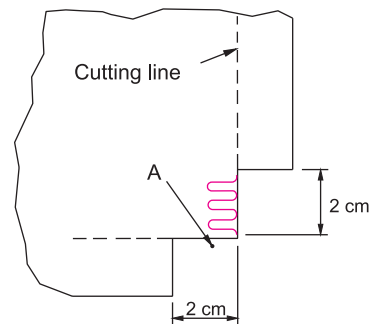
Turning Square Corners

(1) Outside Corner

- Cut out approximately 2cm (51/64 inch) from the corner, in line with the overedge seam edge.
- Sew one stitch beyond point (A) and stop.
- Raise needle and presser foot.
- Pull the fabric to the rear of the machine just enough to release the thread caught on the finger of the throat plate.

Note: Presser foot has been removed to show detail.

- Turn the fabric and lower the presser foot so that the knife is positioned in line with the cut edge.
- Pull slack threads up, then start to sew.



(2) Inside Corner

- Cut inside corner up to seam line as shown
- Sew along seam line.
- Sew up to end of fold. (Leave needle in fabric)
- Raise presser foot. (Leave needle in fabric)
- Spread fold and re-fold so that seam line is straight.

Pin Placement

- Insert pins to the left of the presser foot. The pins will be easy to remove and are away from the cutting action of the knives.

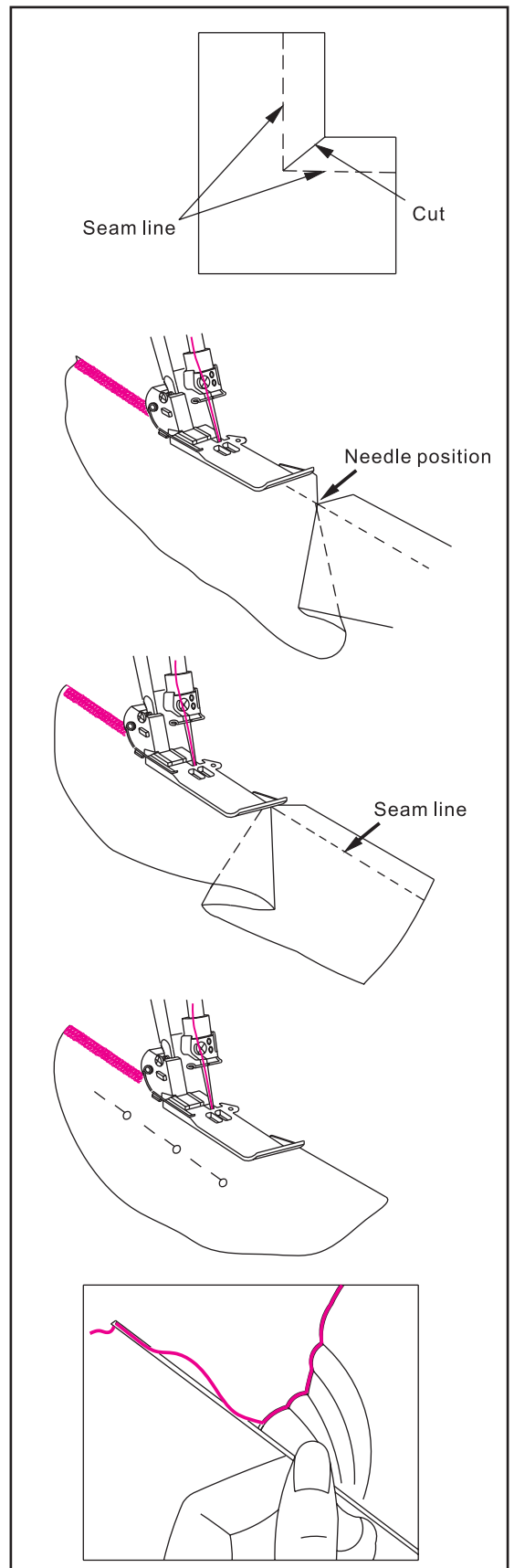


Caution:

Sewing over pins will damage and /or destroy the cutting edge of the knives.

Securing the Thread Chain

- Thread a large eye, hand sewing needle (such as a tapestry needle) with the thread chain.
- Insert the needle into the end of the seam to secure thread.



25. MACHINE MAINTENANCE

An overlock machine requires more maintenance than a conventional machine for two reasons:

- 1) A lot of lint is produced due to the cutting action of the knives.
- 2) An overlock runs at a very high speed and needs to be oiled frequently to lubricate the internal working parts.

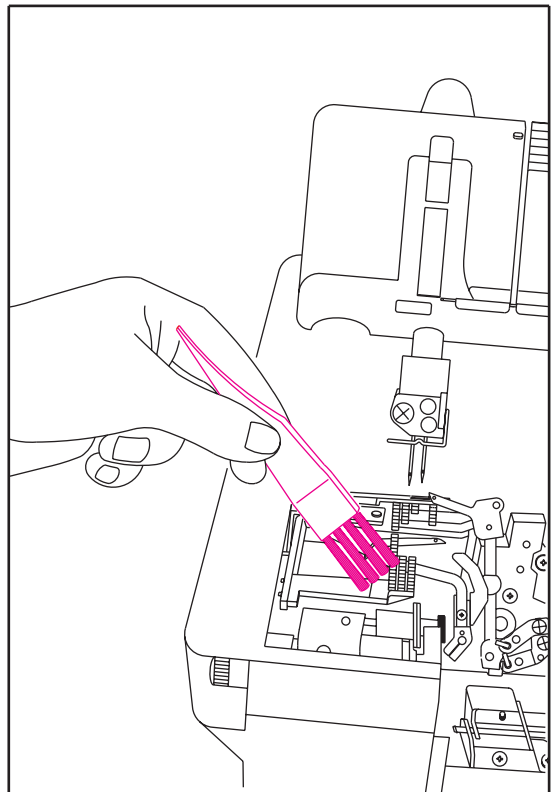
Cleaning the Machine



Danger:

Before cleaning your machine, disconnect power line plug from the wall receptacle.

- Clean the lint from the looper and knife area often with a dry lint brush.



Oiling the Machine

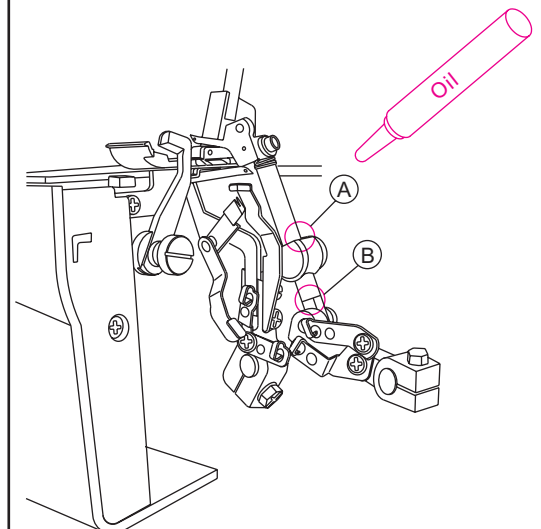


Danger:

Before lubricating your machine, disconnect power line plug from the wall receptacle.

- The oiling points shown in the diagram, should be oiled periodically.

Note: Use only sewing machine oil. Do not use any other oil or damage could result.



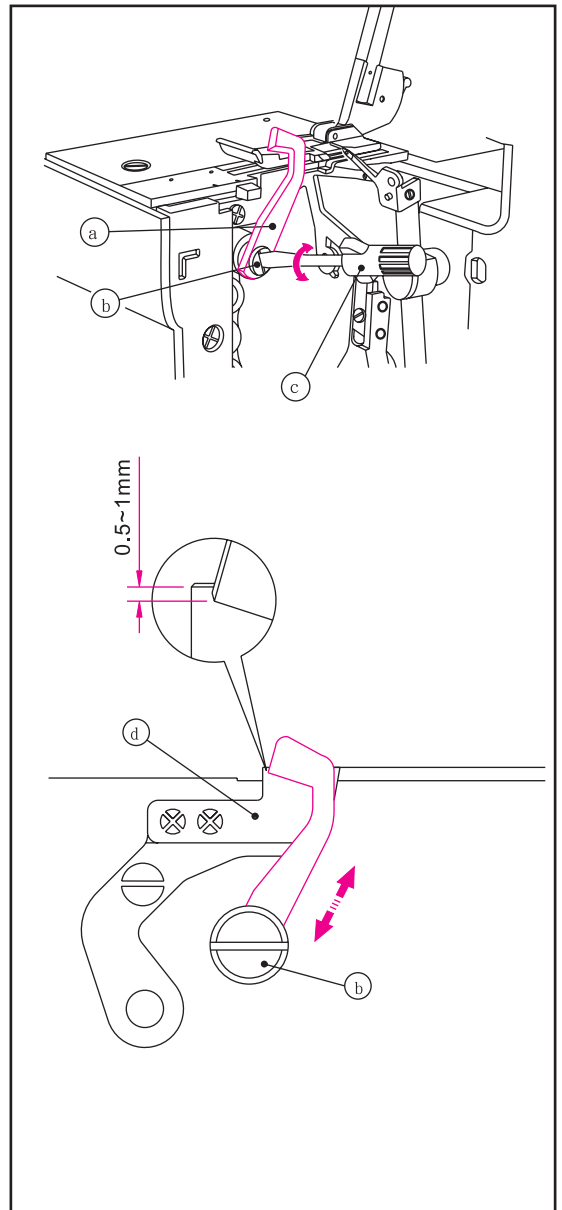
How to Replace the moveable upper Knife



Danger:

Before replacing the stationary knife, disconnect power line plug from the wall receptacle.

- The stationary knife should be changed when it becomes dull.
- The stationary knife can be replaced according to the directions provided, however if there are any difficulties experienced, consult your dealer representative to make the replacement.
- Be sure that the power line plug is disconnected from the electric source.
- Open the looper cover and set the moveable upper knife (a) in the working position.
- Loosen the stationary knife set screw (b) and remove the stationary knife (a).
- Turn the hand wheel to lower the stationary knife holder to its lowest position.
- In this position, put a new stationary knife in the groove of the stationary knife holder, making sure that the edge of the stationary knife is approximately 0.5 to 1.0 mm below the surface of the fixed cutting blade (d).
- Tighten stationary knife set screw (b).



How to Exchange Light Bulb



Danger:

Always unplug before re-lamping.

- Light bulb is available at your dealer shop. Take old bulb to the dealer shop and ask for same bulb.
- If voltage indicated on the electrical rating plate of your machine is 120V, ask for light bulb conforming to following specification.
 - Bayonet type: 110~120V, 15W
 - Glass shape: T-20
 - Lamp cap: E12
 - Overall length: 48mm
- Remove light cover screw and while pushing the cover lightly to the rear, swing cover to the left and remove from machine as shown in the illustration. Turn bulb to the left to remove. To replace the bulb, push bulb into the socket and turn to the right.



Caution:

Be sure the light bulb has cooled off before changing with a new one.

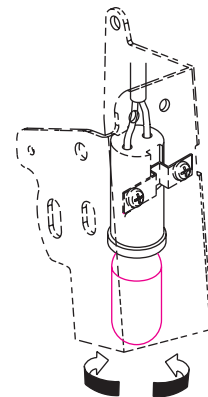
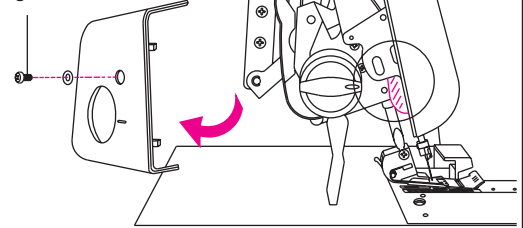


Warning:

Replace the light cover first before connecting the power line plug.

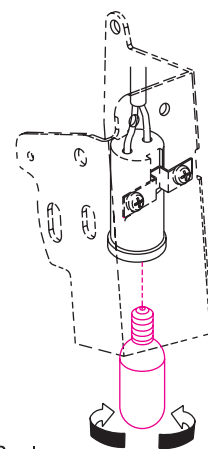
- If voltage indicated on the electrical rating plate of your machine is 220-240V, ask for light bulb conforming to following specification.
 - Edison type (screw type): 220 ~240V, 15W
 - Glass shape: T-22
 - Lamp cap: E14
 - Overall length: 56mm
- Remove light cover screw and while pushing the cover lightly to the rear, swing cover to the left and remove from machine as shown in the illustration. Turn bulb to the left to remove. To replace the bulb, screw bulb into the socket and turn to the right.

Light cover screw



Replace

Remove



Replace

Remove

26. OPTIONAL ACCESSORIES

- The following optional presser feet specially prepared for this machine are available at extra-charge.

Note: Do not use presser foot made for other machines. Use of such presser foot may result in interference with the needle and knife and can be hazardous.

- The snap-on type presser foot of this machine permits easy removal and replacement.



Caution:

Be sure to disconnect the power line plug or turn off the power switch when changing the presser foot.

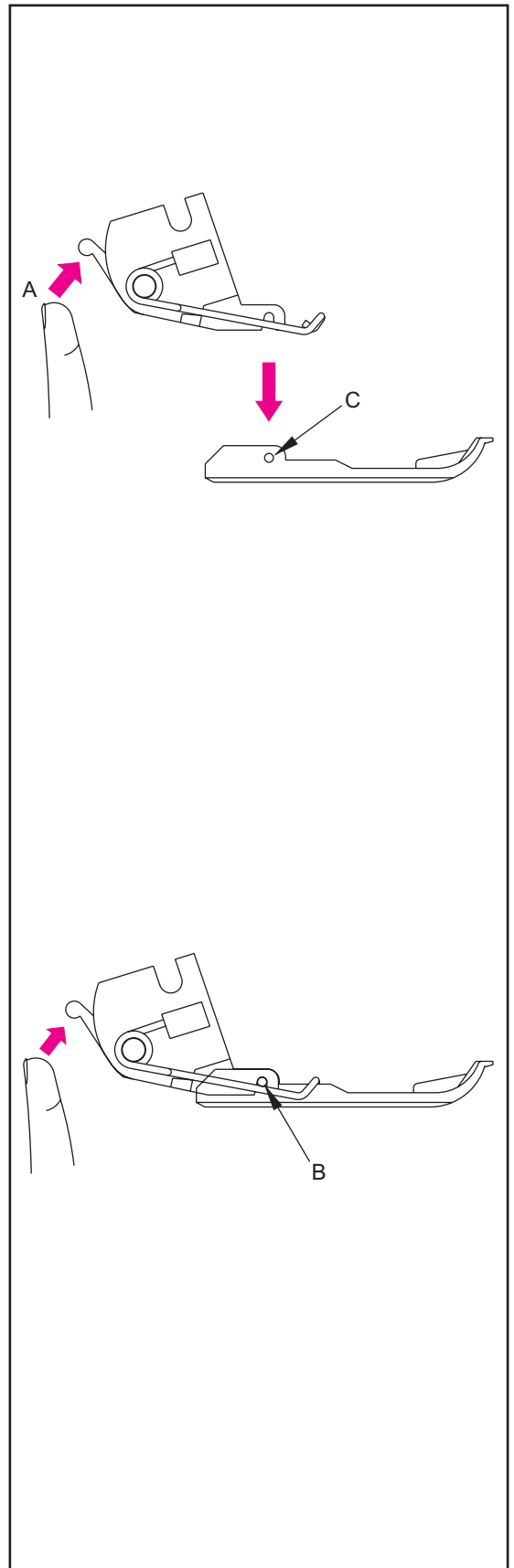
Snap-On Type Presser Foot

Removal

- Raise presser foot and raise needle bar to its highest position.
- Press red colored lever (A) located on back of clamp under the presser foot shank, raise presser bar lifter to its High Lift position and while holding the presser bar lifter in this position, remove the presser foot plate.

Replacement

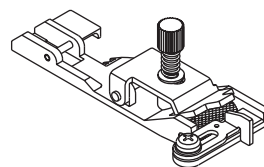
- Place presser foot plate on throat plate under presser foot shank so that hinge pin (C) will fit in slot (B) of the shank. Then lower presser bar lifter.
- If presser foot plate can not be placed under presser foot shank easily, raise presser bar lifter to its High Lift position and while holding it in this position, place presser foot plate under presser foot shank. Then lower presser bar lifter.
- Raise presser bar lifter and make sure the presser foot plate is properly attached to the presser foot shank.



Optional Presser Feet

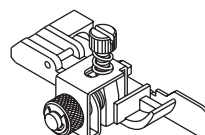
1) Elastic Foot

- This foot is used for attaching elastic tape to the garment and the amount of contraction of the elastic tape can be adjusted as required.



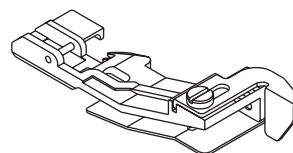
2) Blind Hem Foot

- This foot is for sewing cuffs on knit fabrics, skirt and trouser seams where seam should not be visible.



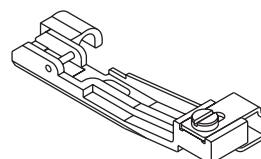
3) Shirring Foot

- This foot is most suited for gathering when sewing tiered skirts, yokes, cuffs and frills on skirts, etc.
- This foot is also suited for sewing two fabrics together and gathering the bottom fabric in one operation.



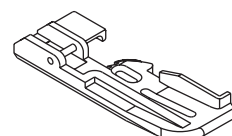
4) Pearl/Sequin Foot

- This foot is used for sewing on beads, etc.



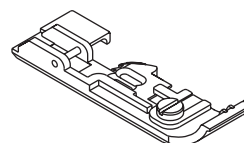
5) Piping/ Cording Foot

- This sewing foot is suited for sewing welting between two plies of fabric.



6) Taping Foot

- This sewing foot is suited for sewing on tapes, etc.



27. TROUBLESHOOTING CHART

Problem	Solution	Page
Fabric does not feed well	- Lengthen stitch length.	23
	- Increase presser foot pressure for heavy weight fabric.	24
	- Decrease presser foot pressure for lightweight fabric.	24
Needle breaks	- Insert needle correctly.	14
	- Do not pull fabric while sewing.	27
	- Tighten needle set screw.	14
	- Use a larger needle on heavy fabrics.	14
Thread breaks	- Check threading.	15~21
	- Check for tangled or caught thread.	22
	- Insert needle correctly.	14
	- Insert new needle, current needle may be bent or have a blunt point.	7
	- Use only high quality thread.	52
	- Loosen thread tension.	26~36
Stitch skip	- Insert new needles, current needles may be bent or have a blunt point. Use only Singer Branded Style 2022 Needles	7
	- Tighten needle set screw.	14
	- Insert needles correctly.	14
	- Change type or size of needles.	14
	- Check threading.	15~21
	- Increase presser foot pressure.	24
	- Use a high quality thread.	52
Irregular stitches	- Balance thread tension.	31~36
	- Check for tangled or caught thread.	22
	- Check threading.	15~21
Fabric puckers	- Loosen thread tension.	31~36
	- Check for tangled or caught thread.	22
	- Use high quality lightweight thread.	52
	- Shorten stitch length.	23
	- Decrease presser foot pressure for lightweight fabrics.	24
Irregular trimming	- Check alignment of knives.	47
	- Replace one or both knives.	47
Fabric jams	- Close looper cover before sewing.	8
	- Check for tangled or caught thread.	22
	- Compress thick layers of fabric with conventional machine before sewing with overlock.	
Machine does not operate	- Connect machine to power source.	8

28. RELATIONSHIP BETWEEN CLOTH, THREAD AND NEEDLE

Type of Fabric	Type of Thread	Needle Singer Cat. #2022
WOVEN		
Lightweight Lawn, Organdy, Voile, Crepe, etc.	Cotton: #100 Silk/ Rayon: #100 Spun: #80 ~ #90 Polyester: #80 ~ #100	#11/80
Medium Weight Muslin, Seersucker, Satin, Gabardine, Broadcloth, etc	Cotton: #60 ~ #80 Silk/ Rayon: #50 Spun: #60 ~ #80 Polyester: #60 ~ #80	#14/90, #11/80
Heavy Weight Oxford, Denim, Tweed, Serge, Corduroy	Cotton: #40 ~ #60 Silk/ Rayon: #40 ~ #60 Spun: #60 ~ #80 Polyester: #50 ~ #80	#14/90
KNIT		
Tricot	Spun: #80 ~ #90 Polyester: #60 ~ #80	#11/80
Jersey	Spun: #60 ~ #80 Polyester: #60 ~ #80 Cotton: #60 ~ #80	#14/90, #11/80
Wool (woven, knit)	Spun: #60 ~ #80 Polyester: #50 ~ #60 Woolly nylon Woolly Polyester	#14/90, #11/80

29. SPECIFICATION

Item	Specification
Sewing speed	1,300 spm maximum
Stitch length (feed amount)	1~4 mm (standard: rolled hemming 1-2, ordinary overedge N=2.5)
Differential feed ratio	1:0.6 ~ 1:2 (with differential feed machine)
Overedge stitch width	Rolled hemming 1.5 mm, ordinary overedge 3.0 ~ 9.8 mm (standard 4 mm)
Needle bar stroke	27 mm
Pressure foot rise	4.5 mm
Needle	HAX1 (130/705H)
Number of threads	2~4
Machine dimensions (mm)	
Width	360
Depth	290
Height	300
Weight (kg)	7.9 kgs