

SINGER

885-6 & 885-16

CP
THE SINGER COMPANY

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885-6

885-16

HEEL SEAMER AND UNDERTAPER

885-6 & 885-16

INDUSTRIAL PRODUCTS DIVISION

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MECHANIZED SYSTEMS DEPARTMENT

CLIFTON LABORATORY

CLIFTON, N.J..

1000-14

THE SINGER 885-6

HEEL SEAMER AND UNDERTAPER

This unit has been sewed-off with the thread, tape and shoe uppers supplied as samples of the work to be accomplished. It was then thoroughly inspected and dis-assembled for shipment in four cases as follows:

- 1 Case containing the stand, table and motor.
- 1 Case containing the 300W101 Machine
- 1 Case containing the 300W205 Machine
- 1 Case containing the accessories, attachments and hardware (occasionally this is contained in two cases)

Unpack each unit and inspect for damage during shipment.

Insert machines in the cutouts provided in the table. The puller feed machine is inserted in the rear cut-out. Be sure to use machine cushions under each corner of each machine. Machines should be level and firm on the cushions.

Lubricate machines according to the Instruction Manual Form 2901W, Pages 6 and 7.

Mount the tape reel on table.

Mount stainless steel workplate and front plate to front machine.

Mount splitting guide (lower) to the bed of rear machine.

Fasten splitting guide (upper) arm to the bracket which is already on the machine head and properly positioned. A line is scribed on the bracket to indicate the position of the splitting guide (upper) arm.

The machines are still threaded. Pay particular attention to the manner in which the thread breakage indicator switches on the rear machine are threaded.

HEEL SEAMER AND UNDERLAPPER

Thread Breakage Indicator Switches

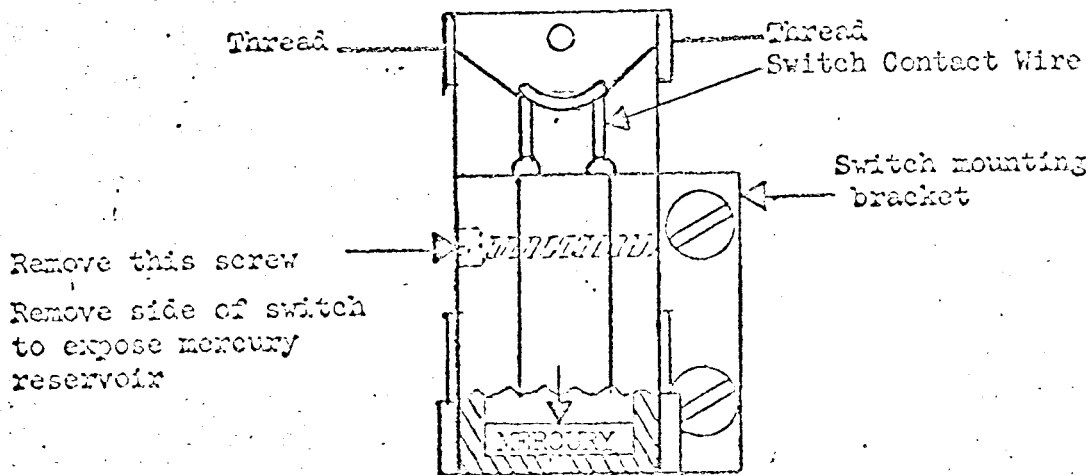
The mercury contact has been removed from the switches located on the rear machine for shipping purposes. The mercury and a dropper are packed with the accessories.

Remove the long screw located at the side of each switch.

Remove one side of each switch. This will expose the mercury reservoir.

Fill the mercury reservoir in each switch to an approximate height of $\frac{1}{8}$ Inch or 3.1 Millimeters.

Replace the side of each switch and replace the long screw which holds the switch together.



Fill this reservoir with approximately $\frac{1}{8}$ Inch or 3.1 Millimeters of mercury.

Final Machine Preparation

Insert the plugs for the Singer lights and the thread breakage system in the appropriate receptacles on both machines.

Thread the tape through the tube and under the presser foot of the rear machine.

Thread both machines.

Connect the power cord to the main supply line.

Check the rotation of the machines. They should rotate counter clockwise when viewed from the handwheel end of the machine.

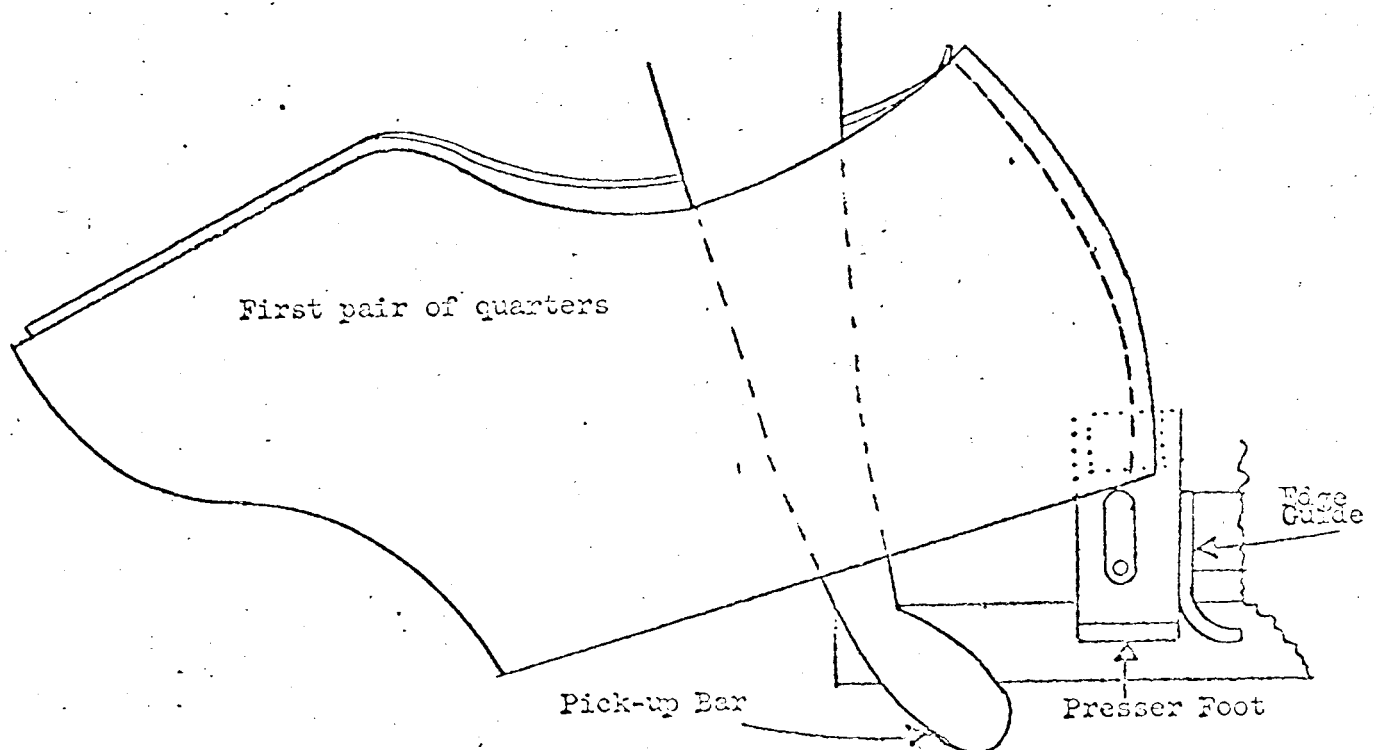
After threading the machines and obtaining the proper rotation, they are ready to operate.

THE SINGER 385-6HEEL SEAMER AND UNDERTAPERStarting the Operation

Start the machines and make a thread chain (from the front machine) long enough to reach the roller presser of the rear machine. Insert the thread chain under the presser foot and under the roller presser of the rear machine.

Insert a pair of quarters under the presser foot of the front machine.

Operate the machine until the quarters have just passed the back end of the needle hole in the presser foot. Stop the machine.



When the first pair of quarters are under the presser foot heel, the toe of the presser foot is raised and the second pair of quarters can be fed into the machine without raising the presser foot manually.

Continue to feed the front machine until the first pair of quarters can be inserted under the presser foot of the rear machine.

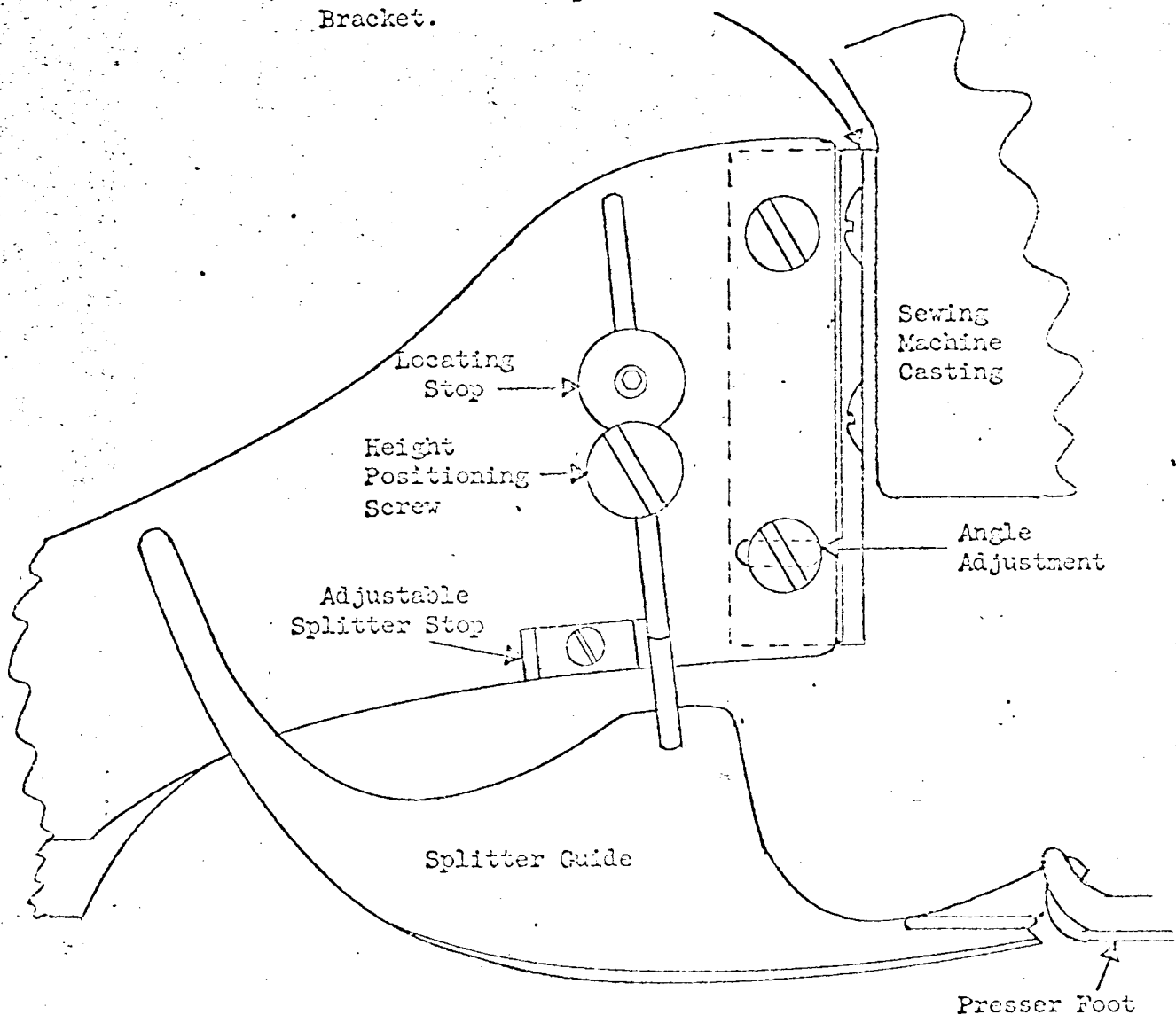
It may be necessary to assist the splitting attachment with the first pair of quarters. After the first pair, however, the splitting attachment will continue to feed the quarters to the rear machine.

The feeding of the front and rear machine has previously been synchronized. It may occasionally be necessary to remove slack which develops between the front and rear machine. This is accomplished by holding the handwheel of the front machine and stepping on the auxiliary treadle, which is at the right side of the regular treadle. This will operate the rear machine without operating the front machine.

THE SINGER 835-6

Mounting of Splitter Arm Guide (upper) on Rear Machine.

This bracket is mounted on machine and a line is scribed to indicate the location of the Splitter Arm Guide Bracket.

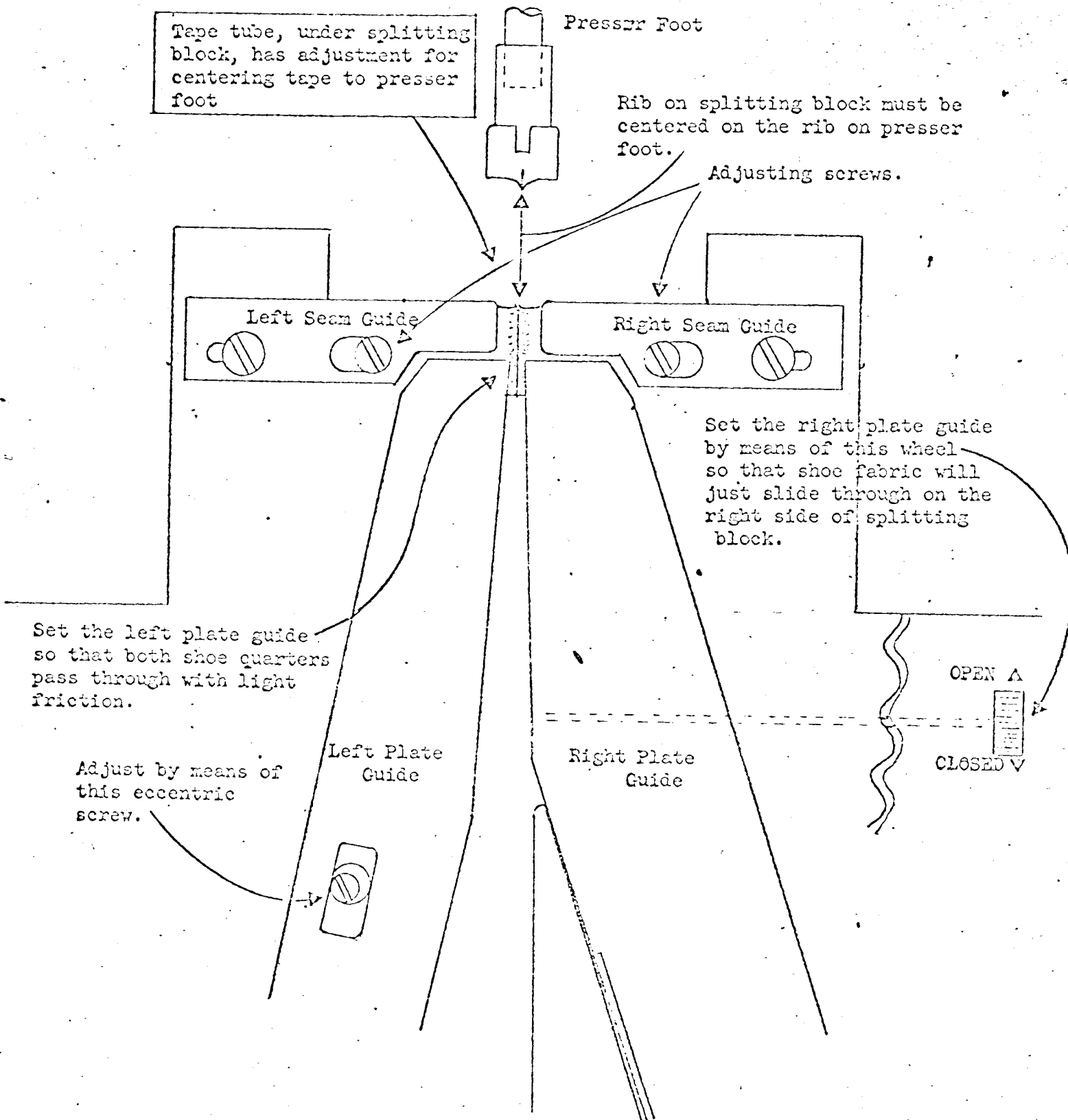


Threading Loopers on Rear Machine

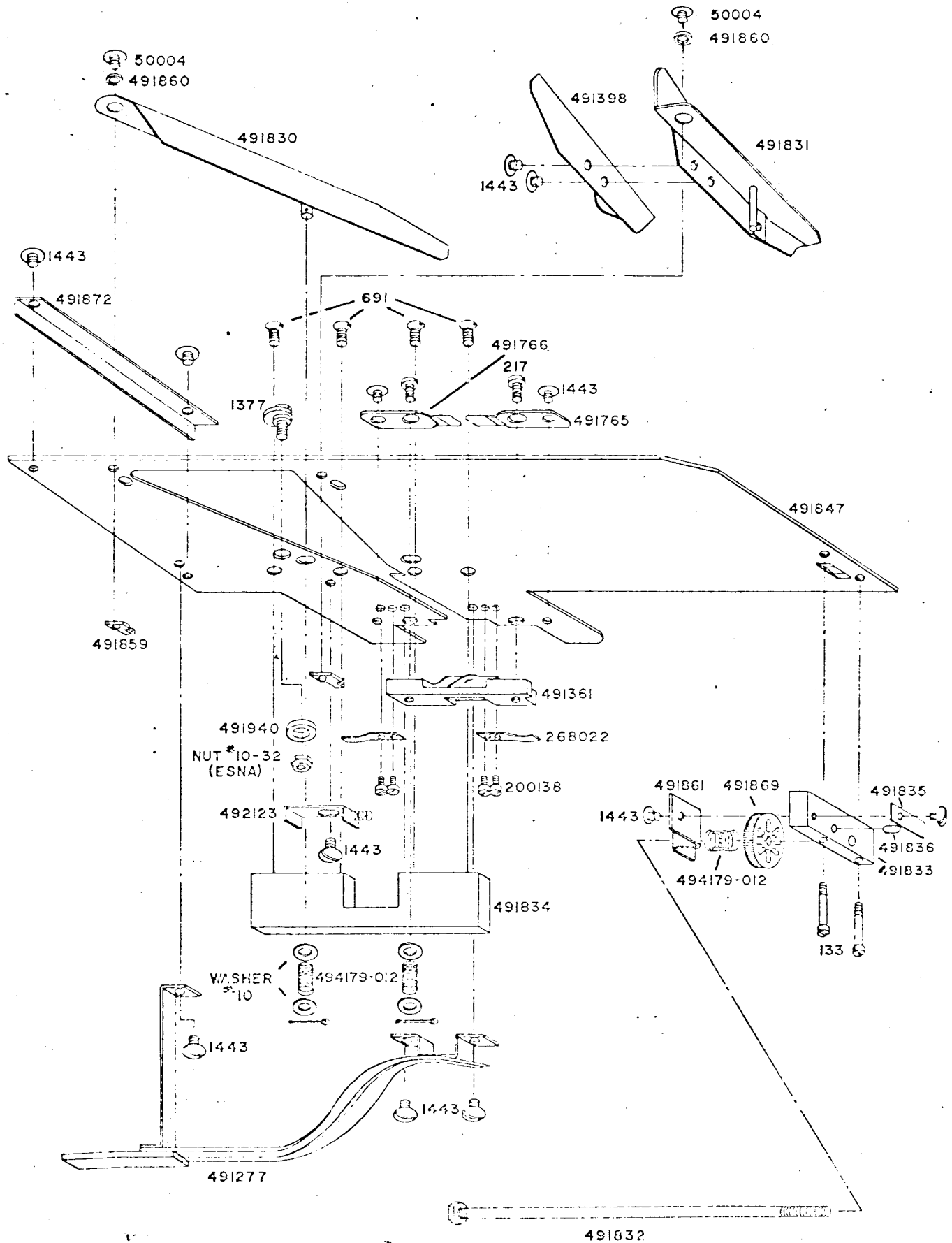
Loosen Height Positioning Screw. Move Splitter Guide up and away from presser foot. Remove complete Splitter Guide Assembly from bed of machine. Remove slide plate to expose loopers.

HEEL SEAMER AND UNDERTAPER

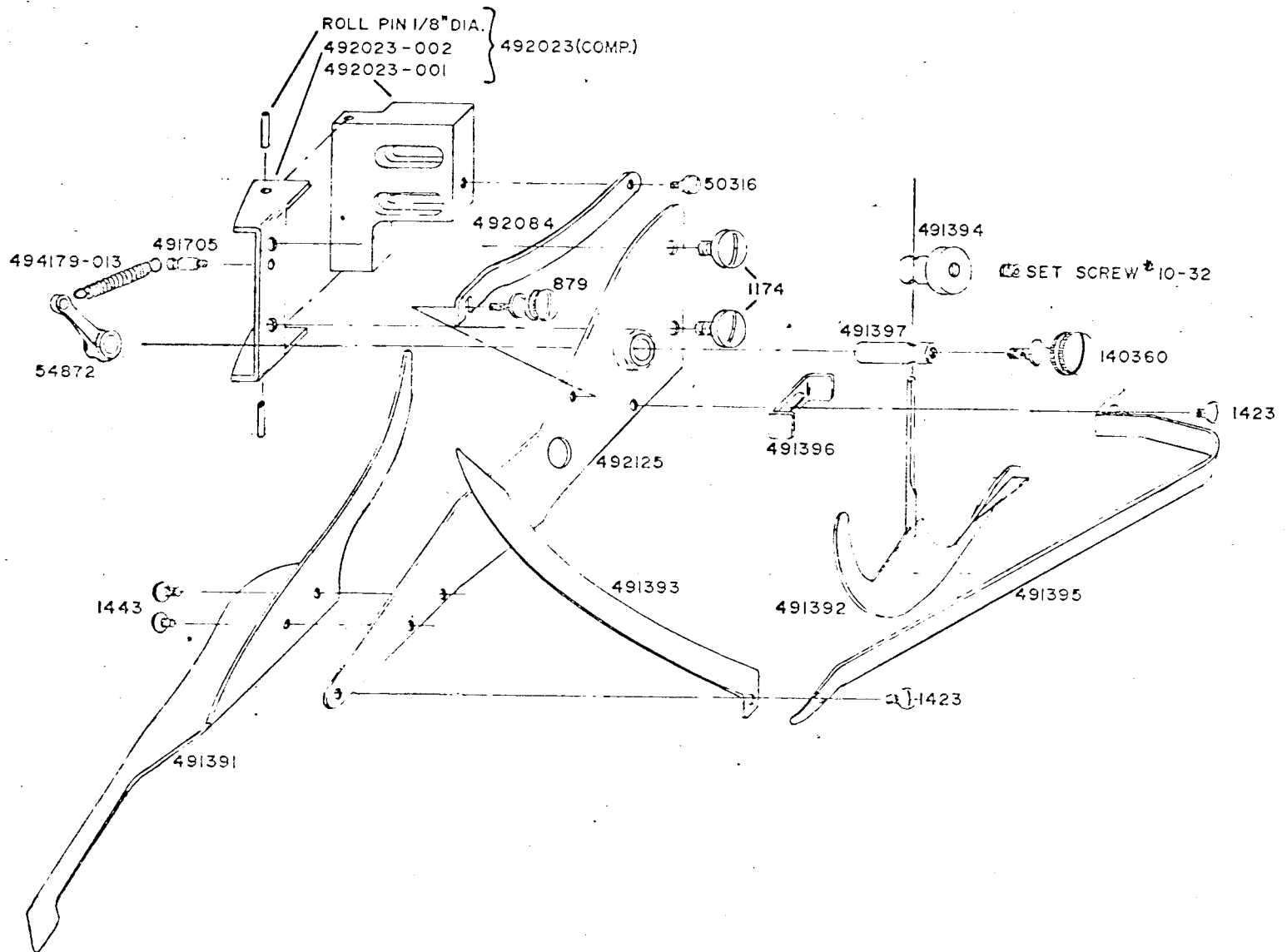
Splitter Guide Assembly (Lower)



SPLIT SEAM REAR SPLITTER ASSEMBLY 491270 (COMP.)



SPLIT SEAM REAR UPPER ASSEMBLY
491722(COMP.)



HEEL SEAMER AND UNDERTAPER

491270 - Split Seam Rear Splitter Assembly (Comp.)

- 133 - Screw (2)
- 217 - Screw (2)
- 691 - Screw (4)
- 1377 - Screw (1)
- 1443 - Screw (12)
- 50004 - Screw (2)
- 200138 - Screw (4)
- 268022 - Slide Spring (2)
- 491277 - Tape Tube
- 491361 - Splitting Block
- 491398 - Seam Control Guide
- 491765 - Right Seam Guide
- 491766 - Left Seam Guide
- 491830 - Left Plate Guide
- 491831 - Right Plate Guide
- 491832 - Right Plate Guide Adjusting Bar
- 491833 - Right Plate Guide Adjusting Bar Holding Block
- 491834 - Bridge Slide Plate Brace
- 491835 - Ratchet Spring
- 491836 - Ratchet Pin
- 491847 - Bridge Slide Plate
- 491859 - Guide Plate Adjusting Nut (2)
- 491860 - Guide Plate Bushing (2)
- 491861 - Bracket
- 491869 - Right Plate Guide Adjusting Bar Wheel
- 491872 - Bridge Slide Plate Trim Angle

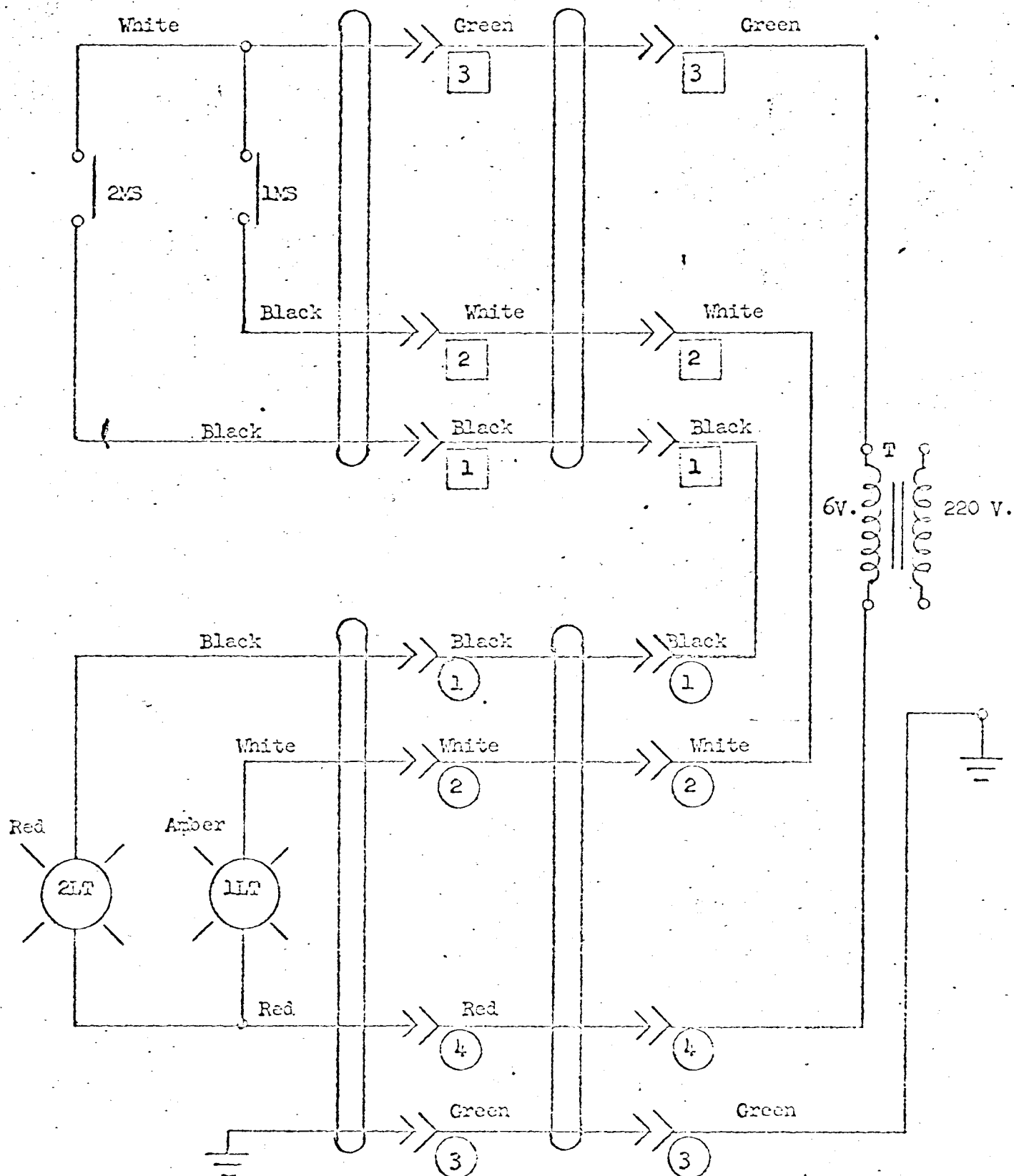
THE SINGER 585-6HEEL SEAMER AND UNDERTAPER

491940 - Guide Plate Adjusting Nut Screw Bushing
492123 - Left Plate Guide Tension Spring
494179-012 - Spring (3)
#10-32 - Lock Nut (Esna)
#10 - Flat Washer (4)
491722 - Split Seam Rear Upper Assembly (Comp.)
879 - Screw, Thumb (1)
1174 - Screw (2)
1423 - Screw (2)
1443 - Screw (2)
50316 - Screw, Shoulder (1)
54872 - Splitter Guide Spring Arm
140360 - Screw, Thumb (1)
491391 - Pick-up Bar
491392 - Splitter Guide
491393 - Left Arm Guide
491394 - Splitter Guide Locating Stop
491395 - Right Arm Guide
491396 - Splitter Stop (Adjustable)
491397 - Splitter Guide Spring Arm Shaft
491705 - Spring Post
492023 - Hinge Assembly (Comp.)
492034 - Hinge Latch
492125 - Splitter Arm Guide, Upper
494179-013 - Spring
#10-32 - Set Screw

HEEL SEAMER AND UNDERTAPER

Miscellaneous Parts

206 - Screw (2) for 491274
200053 - Screw (2) for 491722
200062 - Screw (1) for 491358
201110 - Screw (2) for 491359
201110 - Screw (2) for 491360
259658 - Tape Reel Base
491203 - Presser Foot (Front Machine) (Rubbed Seam)
491259 - Upper Puller Feed Roller
491274 - Material Guide
491279 - Lower Presser Roller
491287 - Throat Plate (Front Machine)
491288 - Feed Dog (Front Machine)
491306 - Presser Foot (Front Machine) (Split Seam)
491307 - Feed Dog (Rear Machine)
491308 - Throat Plate (Rear Machine)
491358 - Puller Feed Guard
491359 - Rear Guard (Rear Machine)
491360 - Bridge Slide Plate Support Bracket
491372 - Presser Foot (Rear Machine)
491582 - Auxiliary Presser Bar Spring
491852 - Tape Reel Arm
491876 - Tape Guide
492124 - Tape Reel Disc (2)
494202-002 - Mercury Switch Contact Wire
494334-001 - Mercury (3 ounce bottle)

Schematic: Thread Breakage Indicator.

- 4 Prong Connector
 ○ 5 Prong Connector

Red light indicates needle thread

Amber light indicates looper thread