

SINGER
246K44 AND 246K61

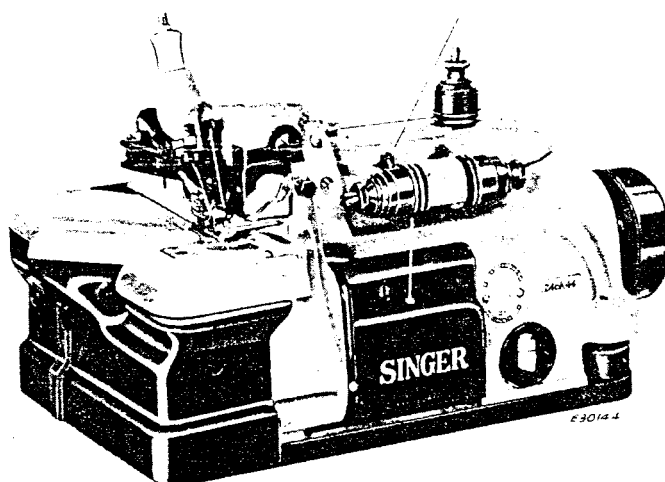
SERVICE MANUAL AND PARTS LIST

FOR

SINGER^{*}

BLIND STITCH HEMMERS

246k44 and 246k61



Machine 246K44

CAUTION—See that machine reservoir is filled with oil, as instructed on Page 6, before using machine.

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(Service Manual and Parts List for 246K44 and 246K61 Machines)

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Page 34:-

81441-003 Machine Frame, complete. Nos. 624, 1143, 140396(805), 164077,
164207, two 187(805), three 140395(805) and four 447

Page 42:-

164954-010 Machine Frame
81441-010 Machine Frame complete, Nos. 624, 1143, 140396(805), 164077, 164207,
two 187(805) three 140395(805) and four 447.

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DESCRIPTION

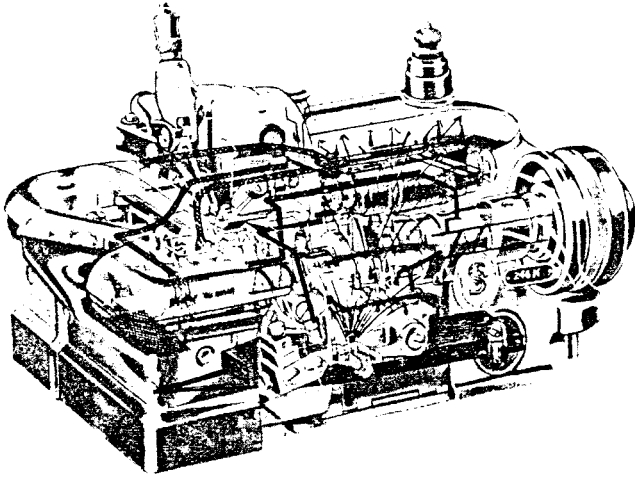


Fig. 2. X-ray View of Class 246K Machine
(Lubricating System Shown in Solid Black)

Designed particularly for high quality blind stitch hemming or welting (**Stitch Type 503**), **Machines 246K44** and **246K61** produce high speed overedging and simultaneous trimming in nylon, rayon, balbriggan knit goods and other similar materials.

Available for **two-thread** and **three-thread** operations, these powerful but compact machines are capable of producing four different overedge stitches: **Stitch Types 502, 503, 504** and **505**.

Adaptable for gathering, stretching or feeding the work uniformly, these machines have proven themselves in an almost endless list of overedge operations including blind stitch hemming, serging, gathering, ruffling, binding, scalloping, cuffing, side-seaming, yoking, ornamental edging, closing, cording, welting and inserting.

GENERAL CHARACTERISTICS

Curved needles:

Catalogue #1261 (151 x 7) regular.

Catalogue #1263 (151 x 3) tapered blade.

Looper and spreader (or loopers) **independently driven**, permitting variations in their adjustment in relation to each other and to the needle, to suit the work required.

Either left or right twist of thread may be used in needle and in loopers.

Adjustable trimmer cuts cleanly; operating in advance of needles. Trimmings guided into chip chute to avoid interference with work and with mechanism.

Presser foot can be swung toward left to facilitate threading or replacement of needle.

Cloth plate can be swung to the left for convenience, when stitching small tubular pieces or when making machine adjustments.

Splash lubricating system, shown in **Fig. 2**, automatically and continuously oils principal bearings during operation.

Oil cooling reservoir in rear of machine.

Oil level indicator gauge in direct view of operator.

Oils recommended, see inside front cover.

Machine pulley 164231 for 3/8 inch V-belt; **also** used for 5/16 inch round belt.

Machine pulley should always turn over away from operator when machine is in motion.

ACCESSORIES AND TOOLS

Foot lifter. Knee lifter supplied instead, when specified on order.

Threading wire 164196.

Tweezers 164204.

Socket wrench 164197 (for needle clamping nut).

Flat, open-end wrench 10875 (for feed eccentric nut).

Screwdriver 85318.

Wrench 8909 (for spreader carrier guide bar oil plug screw nut).

Thread unwinder 151031 for two- or three-thread.

Thread unwinder 228705 (two-thread) or **228706** (three-thread) for nylon threads will be supplied instead of regular unwinder, upon specific order.

SPECIAL FEATURES

Machine 246K44

- ... blindstitch hemming or welting.
- ... light and medium weight fabrics.
- ... one needle, one looper, one spreader.
- ... differential feed.
- ... tubular operation is accommodated by a small "horn" extension of the throat plate support.
- ... regularly fitted for two-thread stitch (Type #503, see Fig. 3).
- ... machine can also perform two thread over-edge stitching (Stitch Type #502), by merely altering the thread tensions until the stitch formation changes from that shown in Fig. 3 to that shown in Fig. 4. See page 10 for instructions on threading.
- ... machine will be fitted on specific order for three-thread tight needle thread stitch (Type #504, see Fig. 5). Refer to page 11 for instructions on threading.
- ... fittings available to produce the three-thread purl-on-the-edge stitch (Type #505, see Fig. 6), upon specific order. See page 12 for instructions on threading.
- ... trimmer, adjustable.
- ... two feed eccentrics 164915, bronze, regularly supplied for 14 stitches to the inch.
- ... presser foot (wire) hemming guide 164517 for 3/4 inch hem regularly supplied. This hemmer also available for hems 1/4 inch to 1-1/2 inches in width, in steps of 1/8 inch. See pages 14 and 15 for illustrations of other hemmers available at additional charge on specific order.
- ... maximum speed 6000 stitches to the minute.

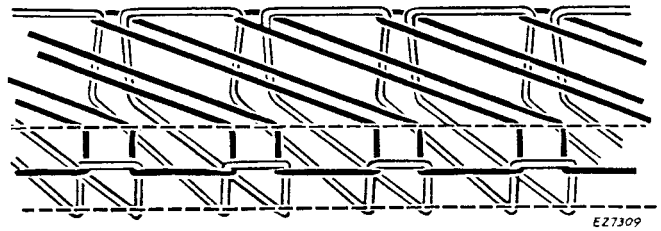


Fig. 3. Stitch Formation
(Stitch Type #503)

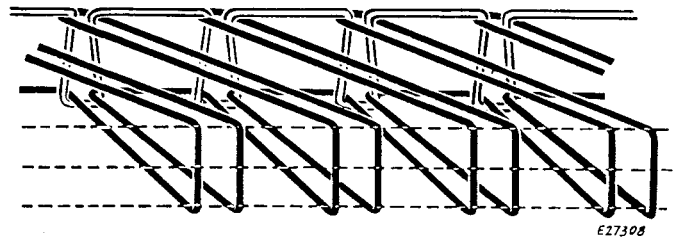


Fig. 4. Stitch Formation
(Stitch Type #502)

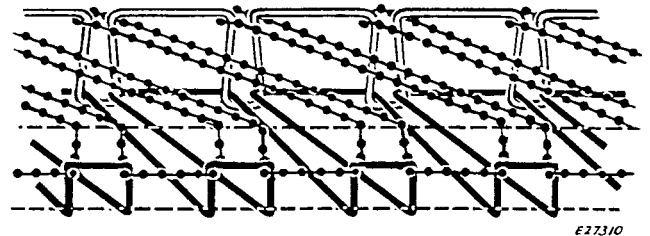


Fig. 5. Stitch Formation
(Stitch Type #504)

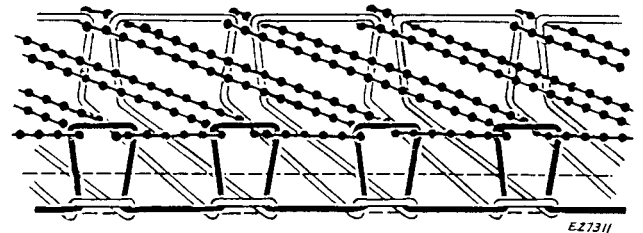


Fig. 6. Stitch Formation
(Stitch Type #505)

Machine 246K61

Similar to Machine 246K44, except—

- ... it is equipped with a smaller throat plate support for convenience when sewing smaller tubular articles; especially, when sewing garments for small children and infants.
- ... other parts—throat plate, presser foot, edge guide, etc.—are adapted for this purpose. See pages 14 and 15 for information about hemming attachments available upon specific order.

... maximum speed 6000 stitches to the minute.

INSTALLATION OF MACHINE AND BASE ON TABLE

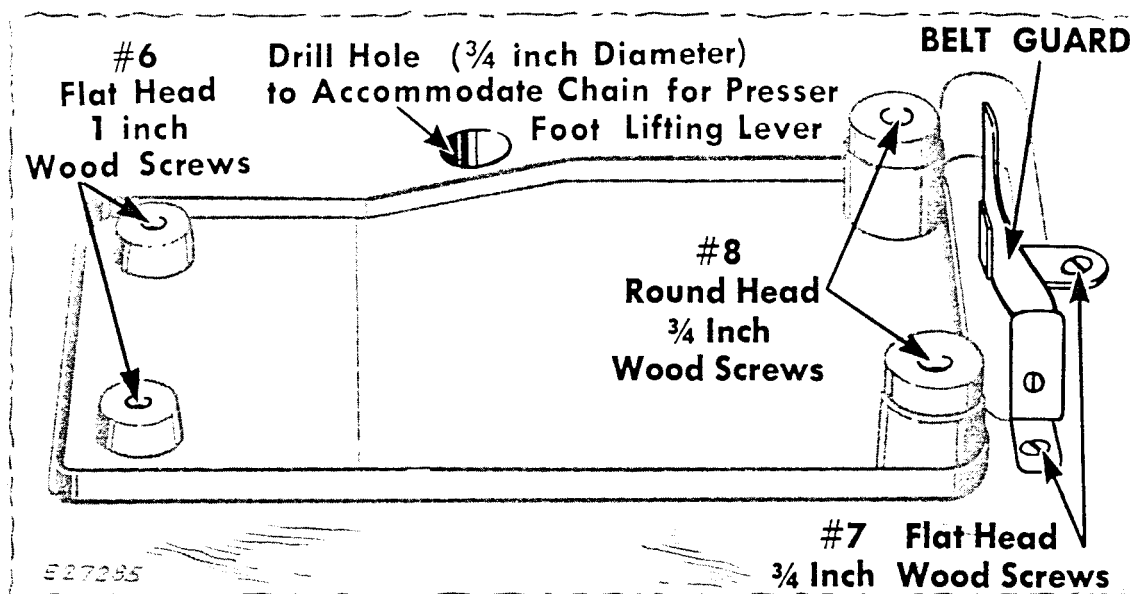


Fig. 7. Machine Base on Table, Showing Position and Drill Sizes of Holes Required for Installation

Place machine and base on table top with belt groove of machine pulley in line with belt groove of driving pulley.

Spot position of hole behind machine base, directly below chain slot on presser foot lifting lever.

Remove machine from base. Draw outline of machine base in position on top of table.

Drill hole spotted earlier, $\frac{3}{4}$ inch in diameter, to accommodate chain for presser foot lifting lever.

Using base and belt guard as template, spot and drill six holes in table for wood screws, as shown in Fig. 7.

Fasten machine base and belt guard to table with the six wood screws, described in Fig. 7.

Set machine on rubber cushions at four corners of base.

FOOT LIFTER:

As the stand recommended for **Class 246K Machines** with foot lifter includes a suitable foot lifter treadle, foot lifter chain **6439**, without the treadle, will be sent with the machine. If, however, the machine is fitted to a stand or other equipment which does not have a suitable treadle, orders should state that foot lifter treadle **4885** is required and it will also be supplied, without extra charge.

CAUTION

All of the oil is drained from the machine before it is shipped from the factory.

DO NOT START THE MACHINE UNTIL IT HAS BEEN THOROUGHLY LUBRICATED AS INSTRUCTED ON PAGE 6.

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SPEED

Maximum speed recommended for these machines is **6000 stitches to the minute**. **5500 stitches to the minute** is recommended for **long runs** or while sewing **long stitches**.

Maximum **efficient** speed is dependent upon the nature of the operation, the ability of the operator and the type of material being sewn.

It is advisable to operate these machines at more moderate speeds the first few days, after which they can be run at top speed.

When the machine is in operation, top of **machine pulley** must always **turn over away from the operator**.

NEEDLES AND THREAD

Needles are of curved blade, Catalogue #1265 (151 x 7) regular, in sizes 9 to 12, 14, 16, 18, 19 and 21. Needles of Catalogue #1263 (151 x 3) with tapered blade, in sizes 5, 6, 7, 9 and 11 are available.

Selection of needles can make a great difference in the ease and quality of the work. It is important that each needle be just right for machine, thread and work being done.

Choose your needle carefully. The correct size will permit thread to pass freely through needle eye; avoiding strain and breakage of thread.

Either right twist or left twist thread may be used.

If trouble occurs during sewing:

Inspect needle point. A hook or burr may cause poor stitching or some materials may be cut when short stitches are used.

Check curvature of each needle, as instructed below. Unless needle has the correct curvature, it may cause skipping of stitches.

Orders for needles must specify the Quantity required, the Size number, also the Catalogue number . . .

For example . . .

"100 Size 9, Catalogue #1265 (151 x 7) Needles."

The best stitching results will be obtained when using needles sold by Singer Sewing Machine Company.

CURVATURE OF NEEDLE BLADE

(Gauge 164588, for needles of Sizes 7 to 16 only)

Before making any stitching adjustments, the curvature of each needle blade should be checked in the following manner:

Using Gauge 164588, shown in Fig. 9, insert shank of needle, with its **flat side up**, in the groove **A**. Push the needle along the groove as far as it will go against stop **B**. Tighten clamping screw **C**.

Swing the indicator **D**, slowly to and fro, along the curve of the needle blade, observing the distance between the needle blade and the tip of the indicator.

The tip of the indicator should just make contact at the needle eye and should clear needle blade, at upper end of curve, by approximately .005 to .006 inch. Use feeler gauge.

Reject any needle that cannot pass this test.

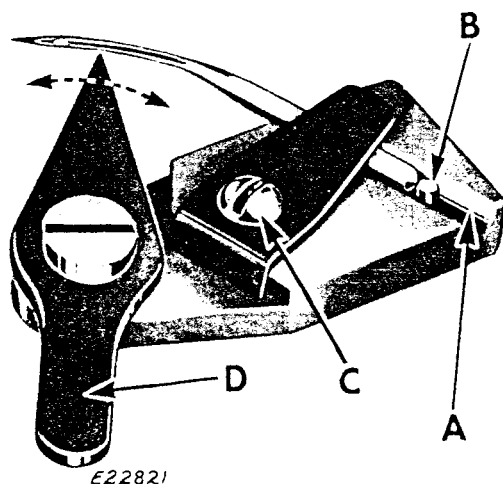
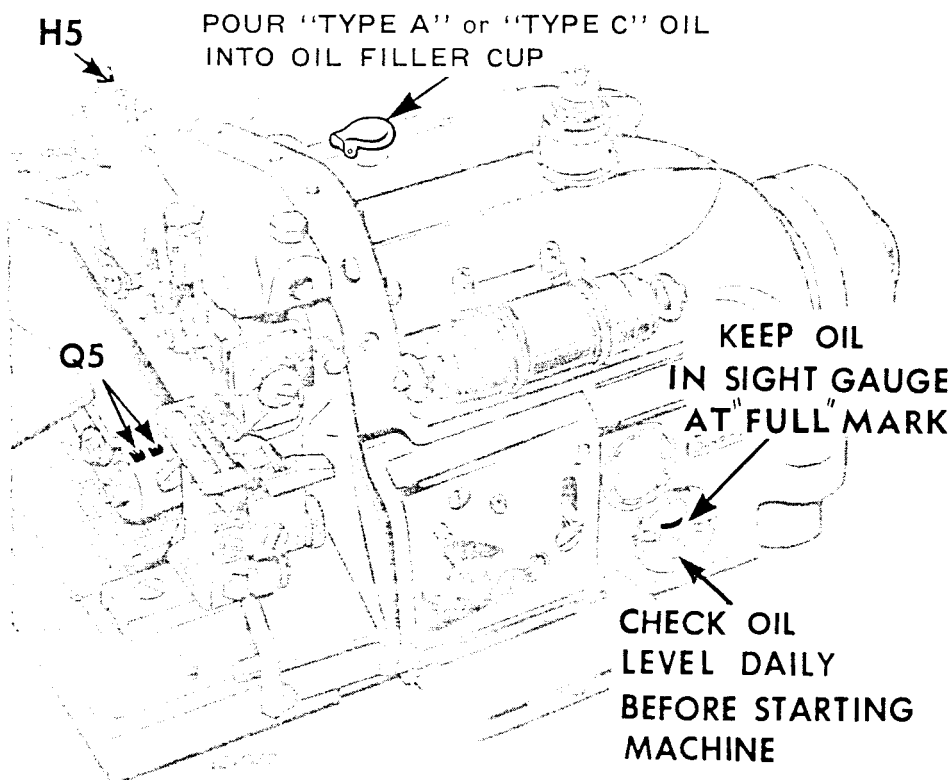
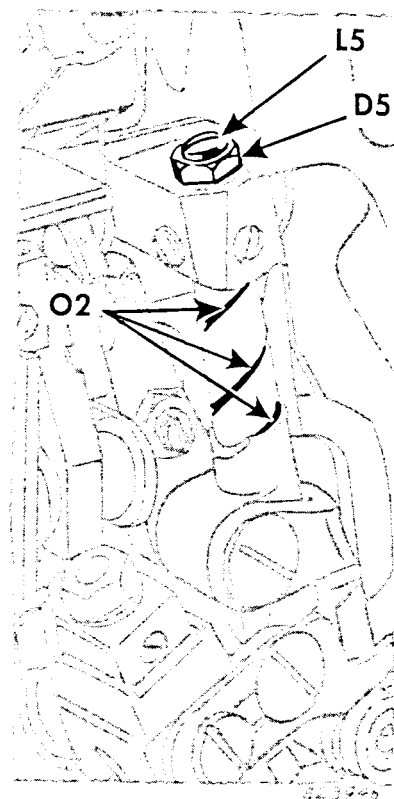


Fig. 9. Checking Needle Curvature

LUBRICATION



Filling Oil Reservoir



Oil Flow Adjustment

Fig. 8. Lubrication of Machine

Use "TYPE A" or "TYPE C" OIL, sold by Singer Sewing Machine Company. For description of oil, see inside front cover of this book.

Apply this oil to oil filler cup on top of machine, pouring oil into reservoir until oil in the sight gauge is at "FULL" mark, as indicated in Fig. 8.

Check oil sight gauge daily before starting machine and oil machine, when necessary, as instructed in Fig. 8 above.

WHEN A MACHINE HAS BEEN IDLE FOR A CONSIDERABLE TIME (OR AFTER A MAJOR INSTALLATION OF PARTS): Clean the machine thoroughly. Then apply a few drops of oil to oil grooves of feed bar connections Q5, Fig. 8 and to spreader carrier connection guide bar at O2, Fig. 8 behind upper knife carrier and chip guard. Apply a drop of oil to presser bar at H5, Fig. 8. Check oil level in reservoir, as instructed in Fig. 8.

AFTER MACHINE IS INSTALLED AND BEFORE STARTING THE MACHINE:

Remove the chip guard from the front of the machine.

Check the oil flow on spreader carrier connection guide bar at O2, Fig. 8.

To adjust amount of oil flow on guide bar at O2, loosen lock nut D5 and turn adjusting screw L5, Fig. 8 clockwise as far as possible. Oil flow is now shut off completely.

Back off screw L5 (turning screw anti-clockwise) 1/2 turn. Check lubrication again.

To increase oil flow, turn screw L5 anti-clockwise a small amount and recheck lubrication.

If oil flow is too great turn screw L5 clockwise about 1/4 turn and recheck.

Never operate machine when oil flow is SHUT OFF at L5.

When correct oil flow is obtained, lock the nut D5, Fig. 8. Replace the chip guard.

Remove belt and check freeness of machine by turning machine pulley by hand. Replace belt.

Finally "run-in" the machine for approximately 15 minutes at a moderate speed.

SETTING THE NEEDLE

Using Socket Wrench 164197

Move needle clamp up to its highest position.

Insert needle, as instructed in **Steps 1 to 5** in **Fig. 10**.

When needle is correctly inserted in needle clamp, securely tighten needle clamping nut. (See **Step 6, Fig. 10**.)

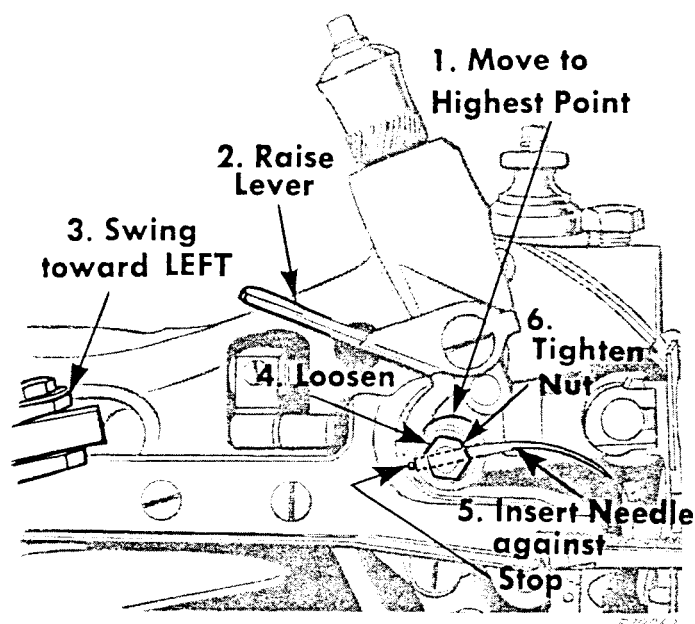


Fig. 10. Needle Correctly Set in Needle Clamp

PREPARATION FOR THREADING

For convenience in threading . . .

. . . Open front cover plate, as instructed in **Step 1, Fig. 11**.

. . . Swing cloth plate toward left (**Step 2**.)

. . . **Machine 246K61**, only: Flip edge guide up and out of way.

. . . **All Machines**: Release presser bar as instructed in **Step 4**, and swing presser bar toward left.

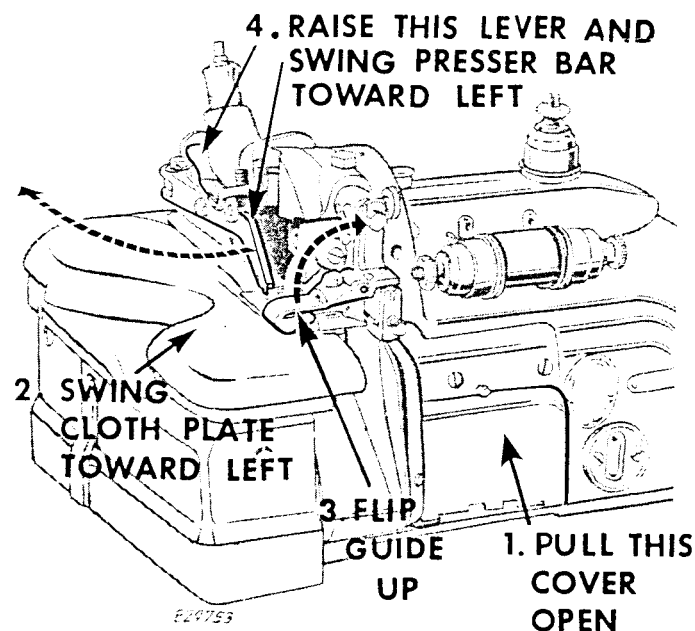


Fig. 11. Preparation for Threading

TO THREAD UNWINDER

Select the unwinder suitable for the type of stitch and work to be accomplished.

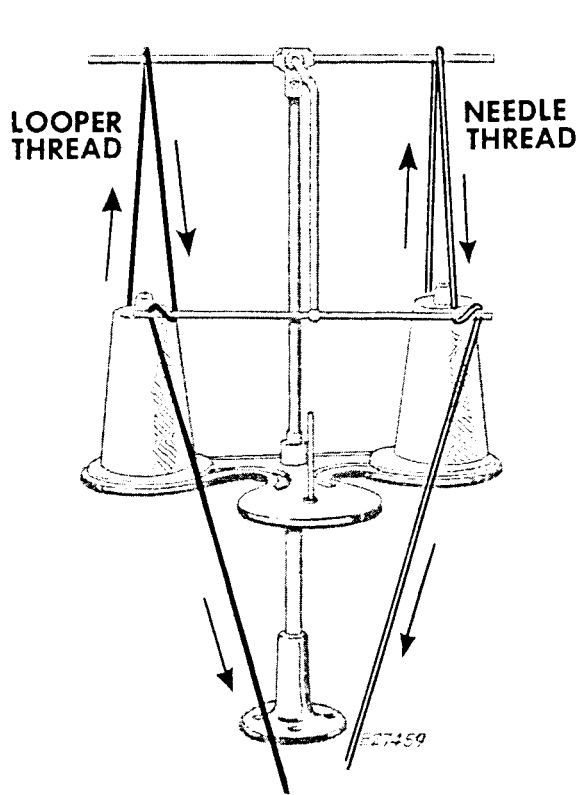


Fig. 12. Unwinder 151031 Threaded for Two-Thread Stitch

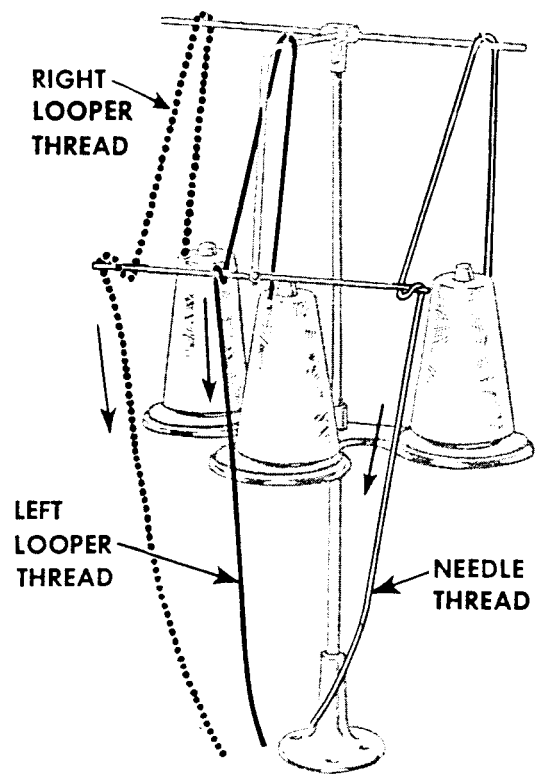


Fig. 13. Unwinder 151031 Threaded for Three-Thread Stitch

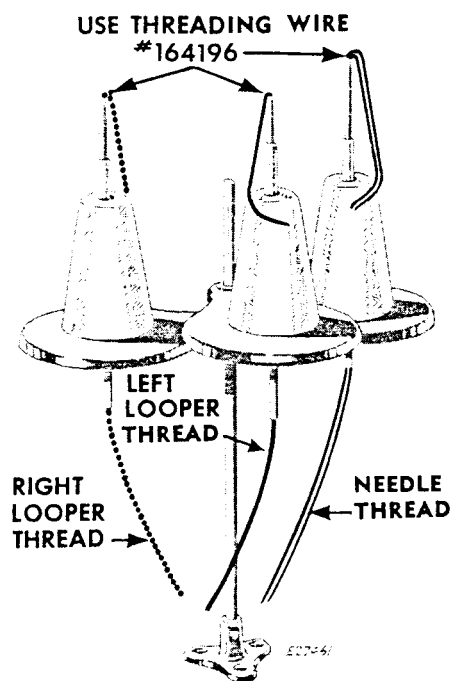


Fig. 14. Unwinder 228706 (for Nylon Thread) Threaded for Three-Thread Stitch

TO THREAD THE MACHINE
FOR TWO-THREAD STITCH (TYPES #502 AND #503)
 (Stitch Type #503 regular for these machines)

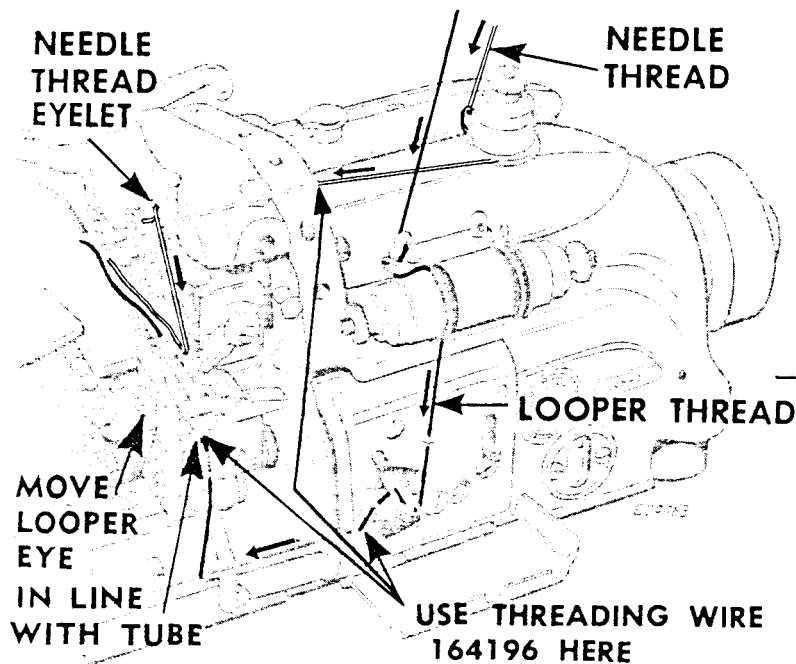


Fig. 15. Threading the Machine
(Two-Thread Stitch)

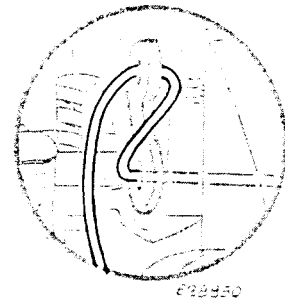


Fig. 16. Threading Needle Thread
Eyelet

Fig. 17. Threading Wire 164196

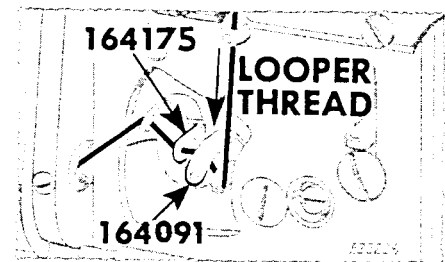


Fig. 18. Threading Looper Take-up

Machine should be equipped with needle thread controller 164381, Fig. 45, page 22 and with looper thread take-up 164175 and looper thread stripper-and-take-up 164091, shown in Fig. 18.

To thread the machine, pass each thread through threading points in the order shown in Figs. 15, 16 and 18. **Double** line indicates **needle** thread. **Solid** line indicates **looper** thread.

Use threading wire 164196, shown in Fig. 17, to pass threads through threading tubes, at points indicated in Fig. 15. Draw four or more inches of thread through eyelet in threading wire and pass threading wire through required threading tube.

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

Note method of threading needle thread eyelet as shown in Fig. 16.

After threading needle thread eyelet, raise needle to its highest position and pass thread from front to rear through needle eye.

When threading needle, double back the end of the thread and twist it; making thread stiff enough to thread the needle eye easily.

LOOPER THREAD:

Before threading looper turn machine pulley over from you until **eye of looper is directly in line with threading tube** underneath throat plate.

Pass looper thread through threading points, as shown in Figs. 15 and 18.

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

TO THREAD THE MACHINE FOR THREE-THREAD TIGHT NEEDLE THREAD STITCH (TYPE #504)

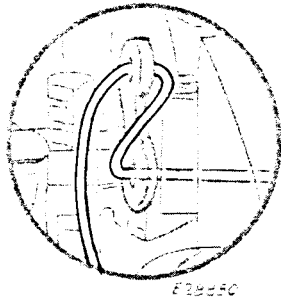


Fig. 19. Threading Needle Thread Eyelet (Tight Stitch)

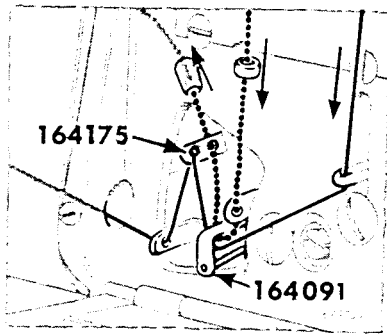


Fig. 20. Threading Looper Take-up (Three-Thread Tight Stitch)

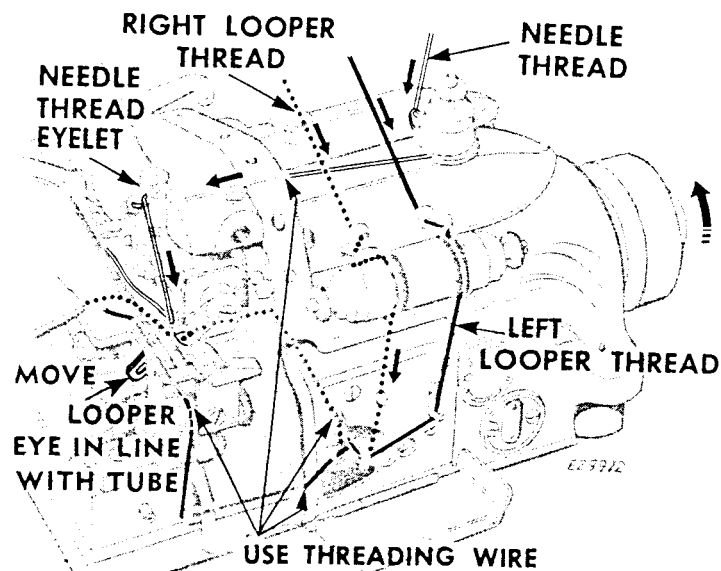


Fig. 21. Threading the Machine (Three-Thread Tight Stitch)

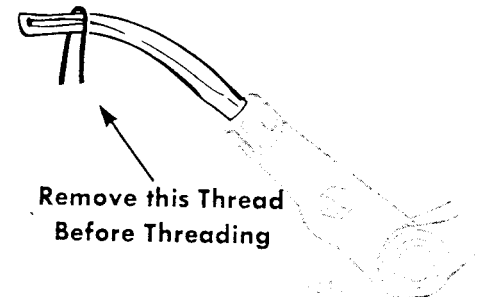


Fig. 22. Right Looper

Machine should be equipped with **left and right loopers**, with needle thread controller 164151, Fig. 44, page 22 and with looper thread take-up 164175 and looper thread stripper-and-take-up 164091, shown in Fig. 20.

Pass each thread through threading points as shown in Figs. 19, 20 and 21.

IMPORTANT:

Thread the **needle thread (double line)** completely first.

Thread right looper thread (**dotted line**) completely next.

Thread the **left looper thread (solid line)** last.

Use threading wire 164196, shown in Fig. 17, to pass threads through threading tubes, at points indicated in Fig. 21. Draw four or more inches of thread through eyelet in threading wire and pass threading wire through required threading tube.

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

Observe the correct position and method of threading needle thread eyelet as shown in Fig. 19.

After threading needle thread eyelet, raise needle to its highest position and pass the thread from front to rear through needle eye.

LOOPER THREADS: Pass each looper thread through its threading points, as shown in Figs. 20 and 21.

Before threading **left looper**, turn machine pulley over from you until the **eye of left looper is directly in line** with the threading tube underneath throat plate.

When threading **right looper**, be sure that there is **no loose loop of thread on end of looper** (see Fig. 22) to cause thread breakage.

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

TO THREAD THE MACHINE FOR THREE-THREAD PURL-ON-THE-EDGE STITCH (TYPE #505)

The machine should be equipped with **left** and **right** loopers, with needle thread controller **164381**, Fig. 45, page 22 and with take-up parts **164857** and **164288**, shown in Fig. 24.

The machine is threaded for three-thread purl-on-the-edge stitch in the same manner as for three-thread tight stitch (see Fig. 19 and instructions on page 11) with the following exceptions:

Needle thread eyelet, shown in Fig. 23, may be raised or lowered, as required. To change the position of the eyelet, loosen screw **R5**, Fig. 23. Move eyelet to desired position and securely re-tighten screw **R5**.

The needle thread eyelet must be threaded as shown in Fig. 23.

The looper thread take-up must be threaded as shown in Fig. 24.

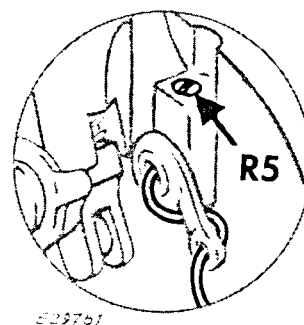


Fig. 23. Threading Needle Thread Eyelet (Purl Stitch)

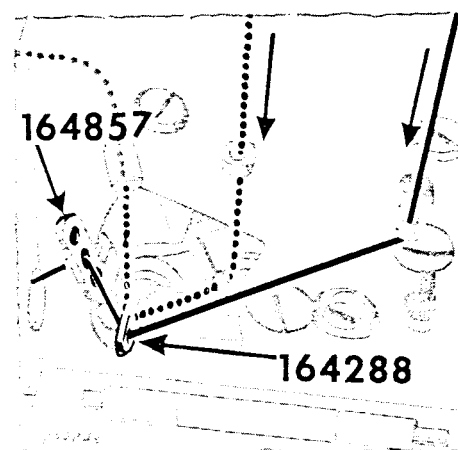


Fig. 24. Threading Looper Take-up (Purl-on-the-Edge Stitch)

SUGGESTIONS FOR EFFICIENT OPERATION

Always turn machine pulley over away from you.

Never allow oil level in oil reservoir to drop below the "FULL" mark on the oil sight gauge.

Clean out any lint around the loopers and between the feed rows of the feed dog.

Frequently inspect area beneath presser bar housing and behind upper knife lever cover and remove accumulation of lint.

Always use lightest tensions and lightest pressure possible.

Don't forget to remove loop of thread from right looper **before** threading.

REGULATION

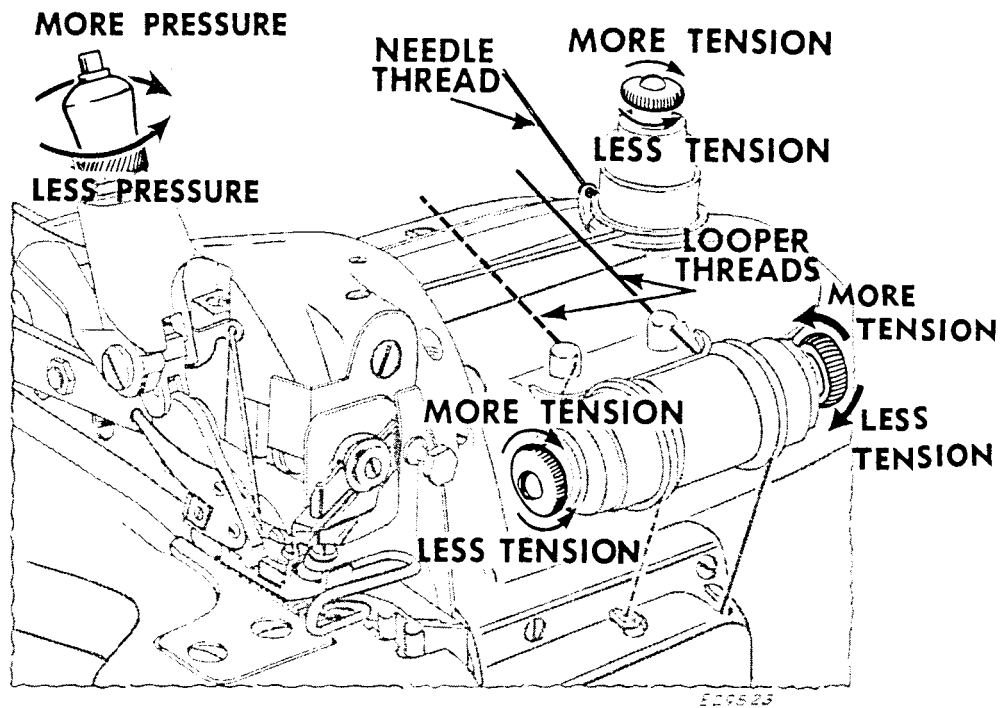


Fig. 25. Regulating Tension of Threads and Pressure of Presser Foot on Material

THREAD TENSIONS

Tension on needle thread should be just sufficient to set stitch correctly. (See Figs. 3 to 6 on page 4 for correct stitch formation.)

For average sewing, tension on looper thread should be very light.

Regulate thread tensions as instructed in Fig. 25.

PRESSURE OF PRESSER FOOT

Correct pressure of presser foot helps feed the work properly.

Always use lightest pressure possible.

Regulate the pressure of the presser foot on the material as instructed in Fig. 25.

NOTE: The instructions on the following pages are for Service Representatives.

To insure proper timing and avoid unnecessary repetition, these instructions should be followed in the order given.

Although these machines are regularly supplied with presser foot wire hemming guide 164517 for 3/4 inch hem, as shown in Fig. 26, hemmers of this type are also available for hems 1/4 inch to 1-1/2 inches in width. Other hemming attachments that fasten to bracket on presser bar housing are illustrated in Fig. 28.

TO CHANGE PRESSER FOOT WIRE HEMMING GUIDE:

Remove screw P with washer C and guide O, Fig. 26, from presser foot.

Replace desired guide with washer C on presser foot and fasten with screw P, Fig. 26.

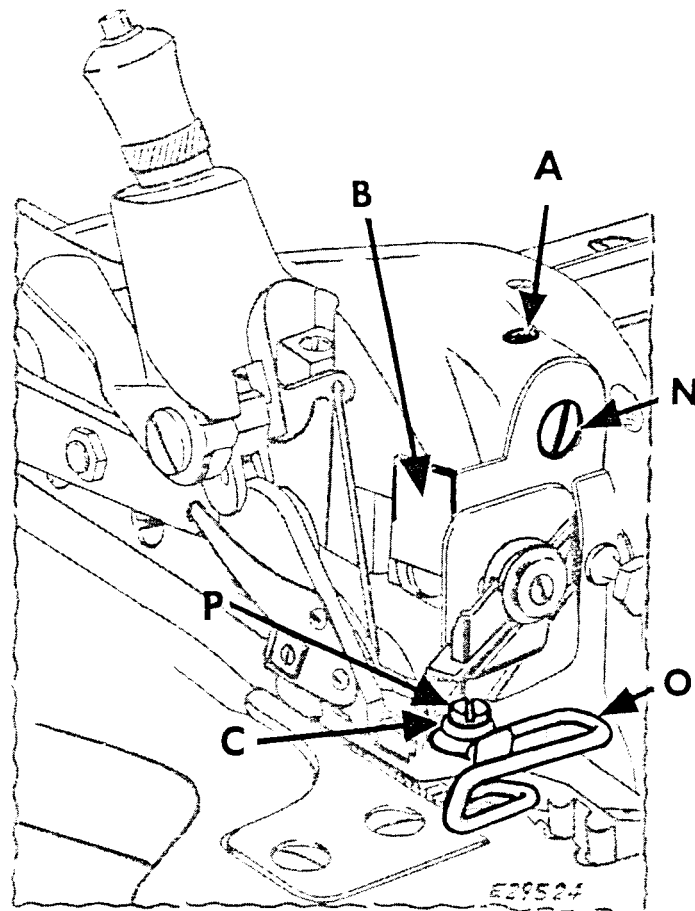


Fig. 26. Machine with Hemming Guide 164517

TO CHANGE FROM PRESSER FOOT WIRE HEMMING GUIDE TO HEMMING ATTACHMENT THAT IS FASTENED TO PRESSER BAR HOUSING:

Remove screw P with washer C. Remove guide O. Loosen screw A. Remove screw N and guard assembly B, Fig. 26.

Insert bracket support D, Fig. 27 in housing and tighten screw A on top of housing.

Remove screw W, Fig. 27 from bracket.

Install one of the hemming attachments, shown in Fig. 28, in bracket so that hemmer is suspended (to left) over throat plate and screw W slips through screw hole X, Fig. 28 in attachment. Securely tighten screw W.

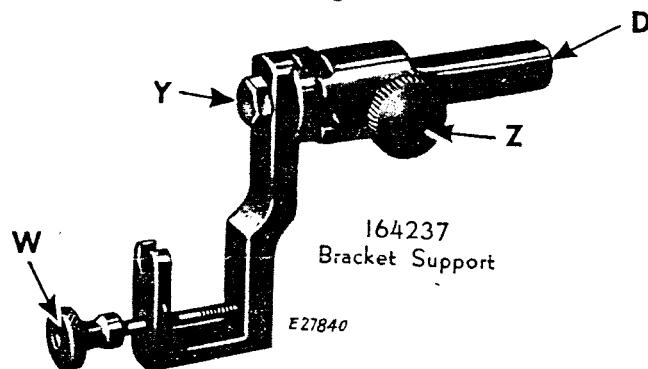


Fig. 27. Bracket Support for Hemming Attachments

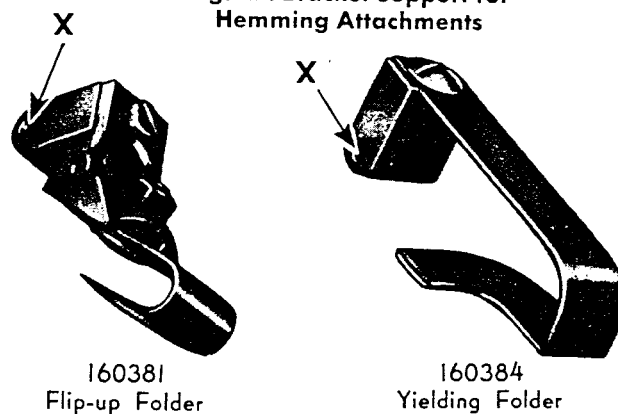


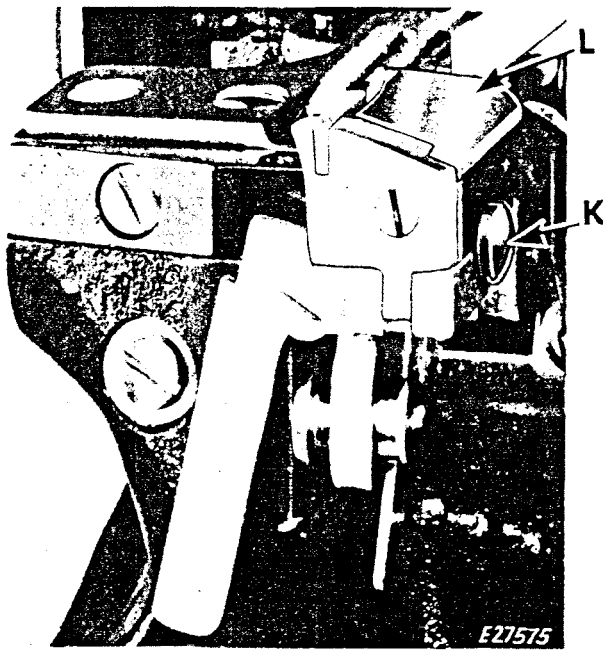
Fig. 28. Additional Blind Stitch Hemming Attachments Available

TO ADJUST THE ATTACHMENT TO CONFORM TO WIDTH OF BIGHT:

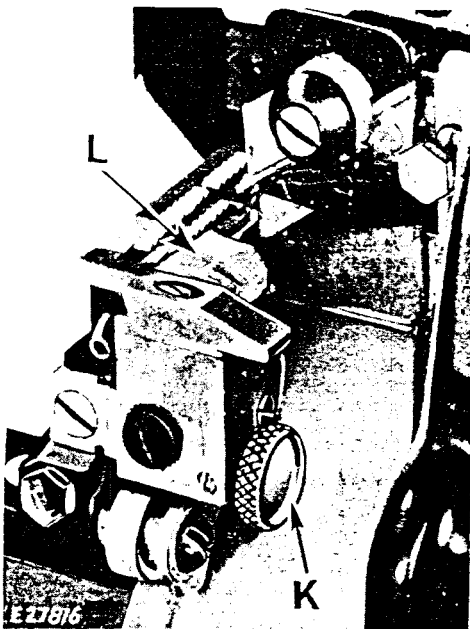
Loosen hexagon-head screw **Y**, **Fig. 27** and turn adjusting screw **Z**, over away from the operator for a narrower bight or over toward the operator for a wider bight.

FLOATING EDGE GUIDE

The floating edge guide **L**, **Figs. 29** and **30** should be adjusted to conform to thickness of material being sewn.



**Fig. 29. Floating Edge Guide
on Machine 246K44**



**Fig. 30. Floating Edge Guide
on Machine 246K61**

To adjust, turn screw **K**, **Figs. 29** and **30** over away from operator to accommodate a lesser thickness or over toward operator to suit a greater thickness of material.

TO CONTROL LENGTH OF STITCH

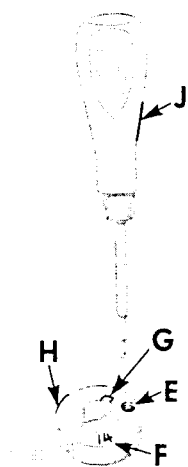


Fig. 31. Feed Eccentric Extractor 164203 and Eccentric 164915, bronze

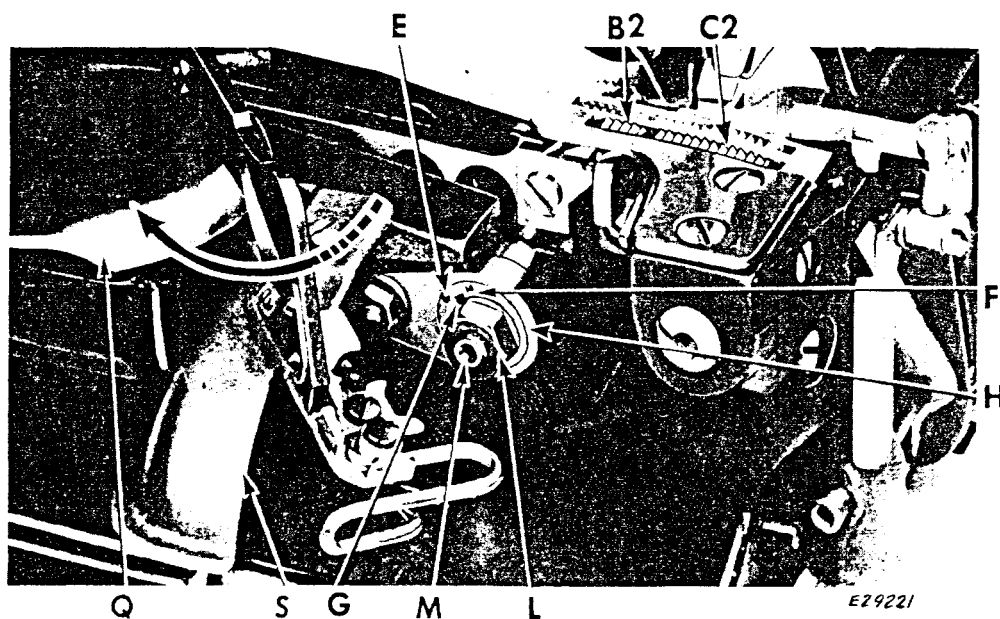


Fig. 32. Changing Length of Stitch

The length of stitch is determined by the feed eccentrics in use—

Each feed eccentric is marked with the number of stitches it makes, as shown at **F**, Figs. 31 and 32.

Feed Eccentric **164915, bronze**, can be supplied to make 4 to 16, 18, 20, 22, 24, 28, 32, 36, 40, 45, 50, 60, 70, 80 and 100 stitches to the inch.

Unless otherwise ordered only **two** feed eccentrics making approximately 14 stitches to the inch will be supplied.

REMOVING FEED ECCENTRICS:

Swing cloth plate **Q**, presser bar and feed eccentric cover **S**, Fig. 32 out to the left.

Using Wrench **10875**, remove hexagon head nut **L** and washer from the shaft **M**, Fig. 32.

Screw the feed eccentric extractor **J**, Fig. 31 into threaded hole **E** of outer eccentric. Pull gently with extractor **J** to remove outer eccentric. Inner eccentric can then be removed, in the same manner.

INSTALLING FEED ECCENTRICS:

When replacing each feed eccentric, be sure that the stamped number is on outside face of eccentric, as shown at **F**, Fig. 32.

The keyway on the eccentric should fit over key at **G** on shaft **M**, Fig. 32. Line-up front and back feed bars and install eccentrics. When the feed eccentrics are in position, replace the washer and hexagon-head nut **L**. Screw the hexagon-head nut securely on the shaft **M**.

FEED CONTROLS

THE DIFFERENTIAL FEED consists of **two** feed dogs **B2** and **C2**, Fig. 32 independently actuated by **two** feed eccentrics. The **inner** feed eccentric (which is placed on the shaft **first**) controls the movement of the **front** feed dog **C2**. The **outer** feed eccentric (which is placed on the shaft **last**) controls the movement of the rear feed dog **B2**.

To feed the work evenly: use two feed eccentrics marked for the **same** stitch length.

To gather: for **front** feed dog use feed eccentric that is marked for **longer** stitch length than that used for rear feed dog. Place eccentric marked for **longer** stitch length on shaft **first**.

To stretch the material while sewing: for **front** feed dog use feed eccentric that is marked for a **shorter** stitch length than that used for rear feed dog. Place eccentric marked for **shorter** stitch length on shaft **first**.

TO SET THE FEED DOGS AT THE CORRECT HEIGHT

Using Gauge 164592 for Machine 246K44
and Gauge 164859 for Machine 246K61
(See Fig. 33)

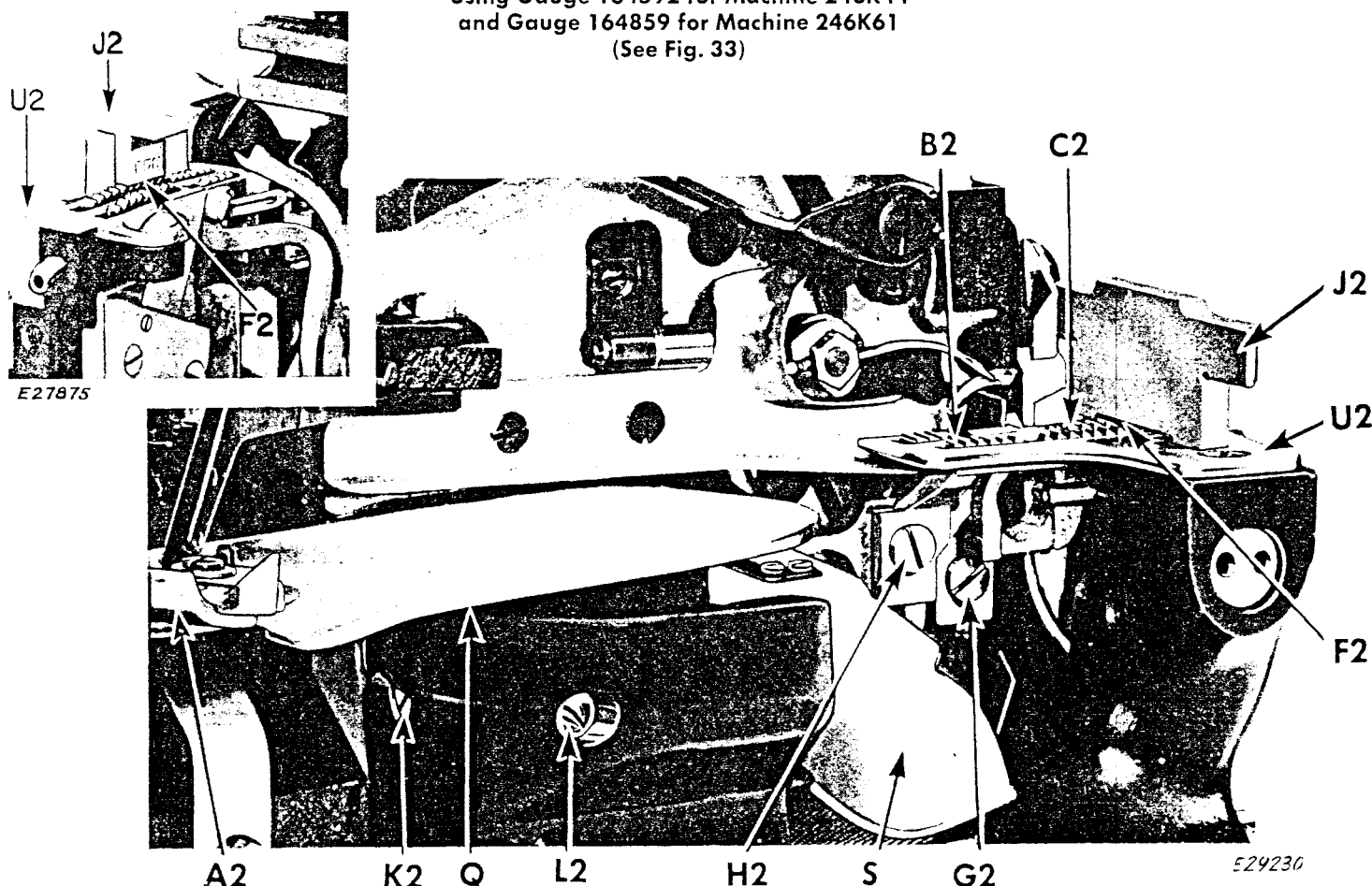


Fig. 33. Setting the Feed Dog
(See inset at top left of above illustration for position of
Gauge 164859 on Machine 246K61)

CHECKING HEIGHT OF FEED DOGS:

Swing the presser foot out to the left, and turn the machine pulley over from you until the feed dogs are at their highest position.

Machine 246K44:

Place the gauge J2, over the front feed dog, as shown in Fig. 33.

Machine 246K61:

Correct position of Gauge 164859 for these machines is shown at J2 in inset at top left corner of Fig. 33.

All Machines:

Gauge J2 must rest firmly upon the throat plate U2. At this setting, front feed dog should just touch the bottom face F2 of the gauge.

Set rear feed dog at same height as front feed dog.

ADJUSTMENT:

Swing the cloth plate Q and the feed eccentric cover S out to the left.

Loosen the adjusting screw G2 and raise or lower the front feed dog C2, as required. Then tighten screw G2.

Loosen adjusting screw H2 and raise or lower the rear feed dog B2, as required. Then tighten screw H2.

TO TILT THE FEED

See Fig. 33

When it is desired to tilt the feed, first set it at the correct height as described above. Then loosen the hinge pin set screw K2 at the rear of the machine just $\frac{1}{2}$ turn.

To tilt the feed up in the rear and down in the front of the needle, slowly turn the hinge pin L2 over toward the rear of the machine, until the desired amount of tilt is obtained.

To tilt the feed down in the rear and up in the front of the needle, slowly turn the hinge pin L2 over toward the front of the machine, until the desired amount of tilt is obtained. Then tighten the screw K2.

TO SET THE NEEDLE CLAMP AT THE CORRECT HEIGHT

Using Gauge 164592 for Machine 246K44
and Gauge 164859 for Machine 246K61
(See Figs. 34 to 36)

CHECKING HEIGHT OF NEEDLE CLAMP:

Turn the machine pulley over from you until the needle clamp **R2** reaches its highest position.

Swing the presser foot and cloth plate out to the left.

Machine 246K44: Remove the needle and the throat plate.

Machine 246K61: Remove needle, but DO NOT REMOVE THROAT PLATE.

Both Machines: Remove floating edge guide. (See page 15.)

Turn the machine pulley over from you until the needle clamp **R2** reaches its lowest position.

Slip "LOW" end of the gauge **J2** between the needle clamp and throat plate seat **V2**, on Machine 246K44, as shown in Fig. 34, or between needle clamp **R2** and throat plate **U2**, on Machine 246K61 as shown in Fig. 35.

At this setting, the needle clamp **R2** should just touch top surface **Q2** on "LOW" end of gauge **J2**.

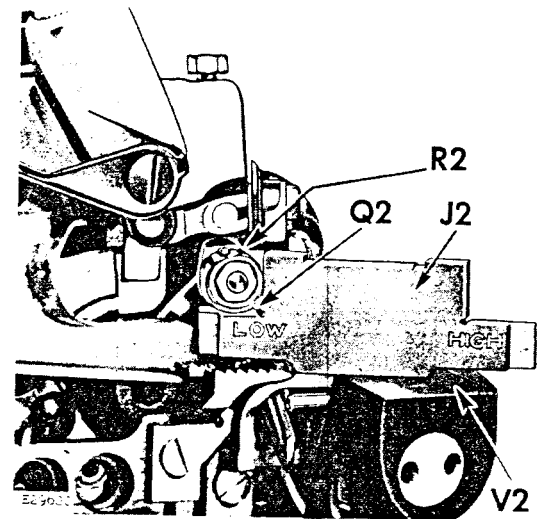


Fig. 34. Checking the Needle Clamp Height

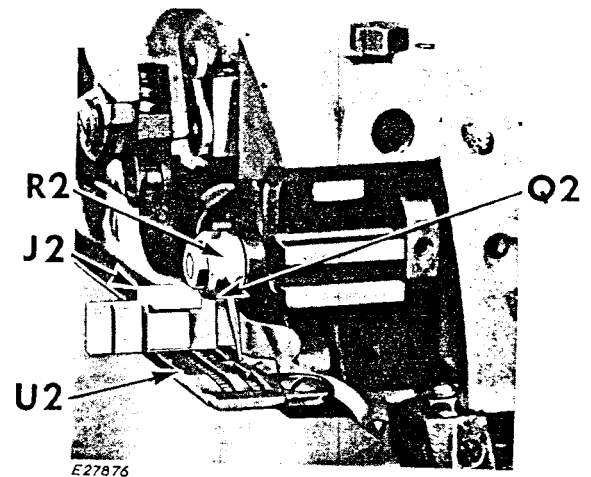


Fig. 35. Position of Gauge 164859 on Machine 246K61

ADJUSTMENT:

Remove the top frame cover and loosen the clamping screw **T2** and the two screws **P2** and **Y**, Fig. 36.

Raise or lower the needle clamp **R2**, Figs. 34 and 35 as required.

To secure the needle clamp in the correct position, first securely tighten the screw **T2**, then tighten the two screws **P2** and **Y**.

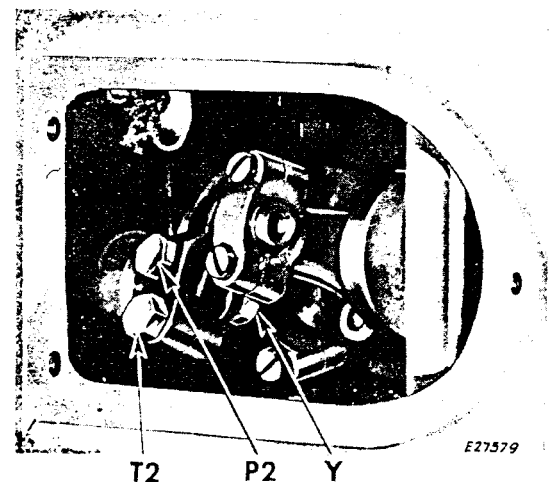
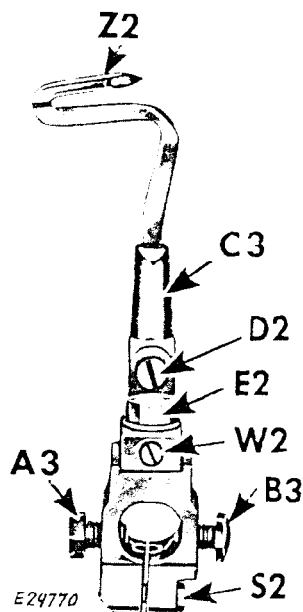


Fig. 36. Adjusting the Needle Clamp

TO SET THE LEFT LOOPER IN RELATION TO THE NEEDLE

Using Gauge 164592 on Machine 246K44
and Gauge 164859 on Machine 246K61
(See Figs. 37 and 38)



PREPARATION:

Machine 246K44: Remove throat plate.

Machine 246K61: DO NOT REMOVE THROAT PLATE.

All Machines: Remove chip guard.

Loosen set screw **D2**, Fig. 37 in left looper holder **C3**.

Set left looper **Z2** all the way down into its holder.

Securely tighten set screw **D2**.

CHECKING LEFT TO RIGHT POSITION:

Machine 246K44: Place gauge **J2** on throat plate seat **V2** as shown in Fig. 38.

Machine 246K61: Place gauge on throat plate **U2**, as shown in inset at bottom left of Fig. 38.

Both Machines: Turn machine pulley over away from you until needle clamp reaches its lowest position and then rises sufficiently to permit "HIGH" end of gauge **J2** to just pass beneath needle clamp **R2**. Gauge will then be resting upon throat plate seat on **Machine 246K44** or on throat plate on **Machine 246K61**. At this setting the needle clamp **R2** should just contact top surface **U4** of gauge and the tip of left looper **Z2** should be between center and left side of needle.

SETTING LEFT TO RIGHT POSITION:

Loosen screw **S2**.

To move left looper **Z2** toward **left**, loosen screw **A3** and tighten screw **B3** an equal amount, as required.

To move left looper **Z2** toward **right**, loosen screw **B3** and tighten screw **A3** an equal amount, as required.

Recheck setting. When correct setting is obtained, securely tighten clamping screw **S2**.

CHECKING FRONT TO REAR POSITION:

Turn machine pulley so that loopers move through one complete sewing cycle. Observe looper movement.

The left looper **must rub lightly on the needle** as it passes toward the right.

SETTING FRONT TO REAR POSITION:

Turn machine pulley over away from you until point of looper **Z2** just reaches needle.

Loosen set screw **E2** just enough to allow movement of looper holder **C3**.

Loosen set screw **W2**.

Move looper holder **C3** toward rear of machine. Turn set screw **W2** inward until proper relation between left looper and needle is obtained.

Securely tighten screw **E2**.

Replace throat plate and chip guard.

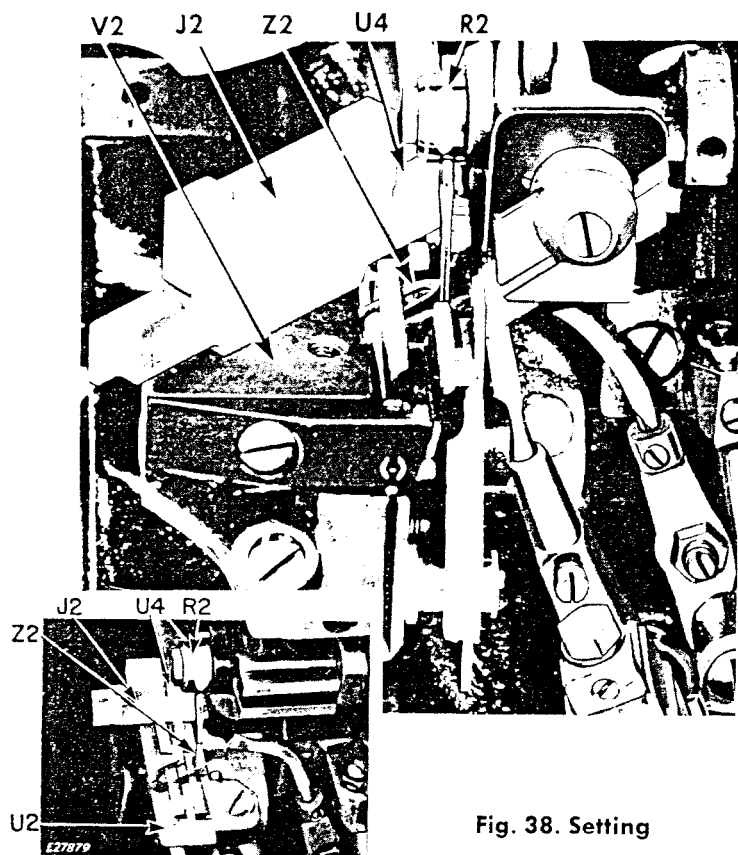


Fig. 38. Setting

Before this setting is attempted, check needle with needle gauge **164588** as instructed on **page 7**. Then set the needle correctly as instructed on **page 8**.

These machines are regularly fitted with **ONLY one looper** (the "left" looper).

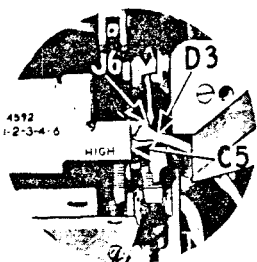


Fig. 39. Spreader,
Machine 246K44

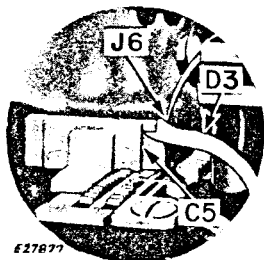


Fig. 40. Spreader,
Machine 246K61

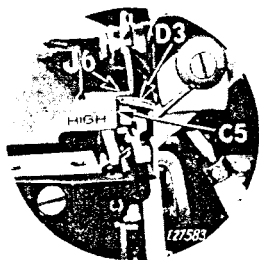


Fig. 41. Right Looper,
Machine 246K44

TO SET THE SPREADER OR THE RIGHT LOOPER IN RELATION TO THE NEEDLE

Using Gauge 164592 on Machine 246K44

and Gauge 164859 on Machine 246K61

(See Figs. 39 to 43)

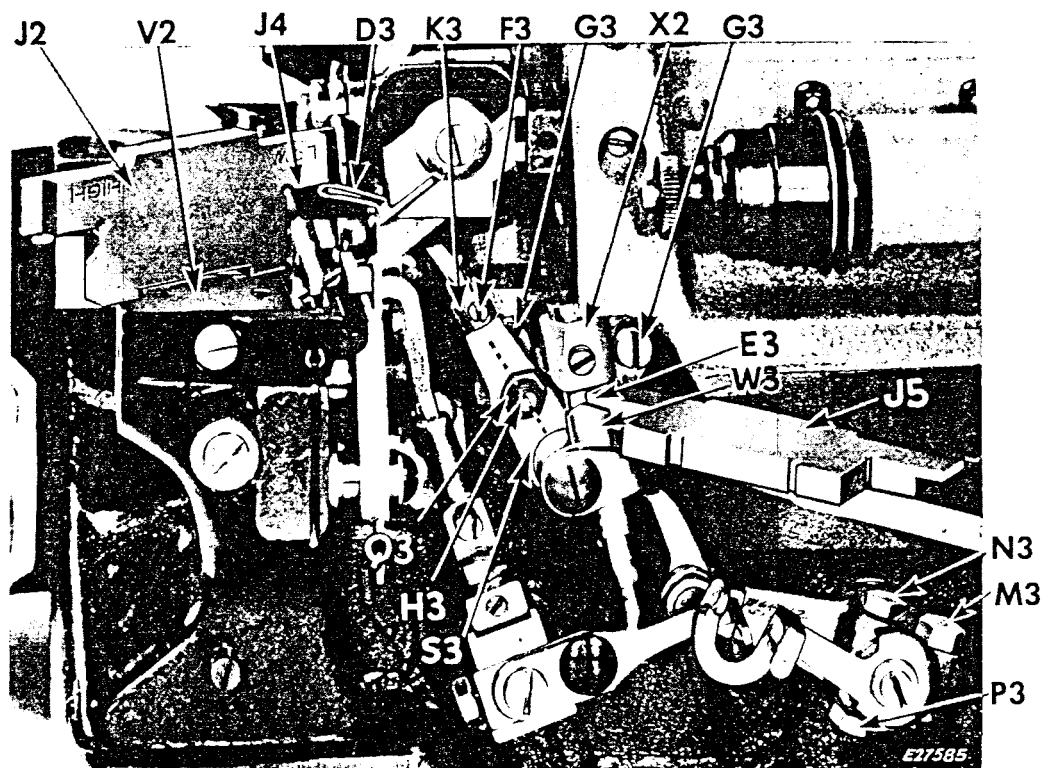


Fig. 42. Adjustments for Spreader
or Right Looper

PREPARATION:

Spreader 164252 (Figs. 39 and 40) is used for two-thread stitches.

Right looper 164055 (Fig. 41) is used for three-thread stitch.

Check the needle with needle gauge 164588 as instructed on page 7.

Set the needle in the machine as instructed on page 8.

Swing presser foot and cloth plate to the left.

Remove chip guard and looper thread plate, complete.

CHECKING CLEARANCE BETWEEN SPREADER CARRIER CONNECTION AND GUIDE BAR BRACKET:

Turn machine pulley until spreader (or right looper) D3 is at its extreme left position.

Check distance E3 between spreader carrier connection W3 and guide bar bracket X2, Fig. 42 with gauge, as shown at J5, Fig. 42. Check this distance with "HIGH" and "LOW" ends of gauge.

Use Gauge 164859 for Machine 246K61 (see J5, Fig. 43, page 21).

CLEARANCE ADJUSTMENT:

Loosen clamping screw M3, and screws N3 and P3.

Raise or lower spreader carrier connection W3, as required.

Securely tighten clamping screw M3.

Tighten screws N3 and P3.

TO SET THE RIGHT LOOPER OR THE SPREADER (CONTINUED)

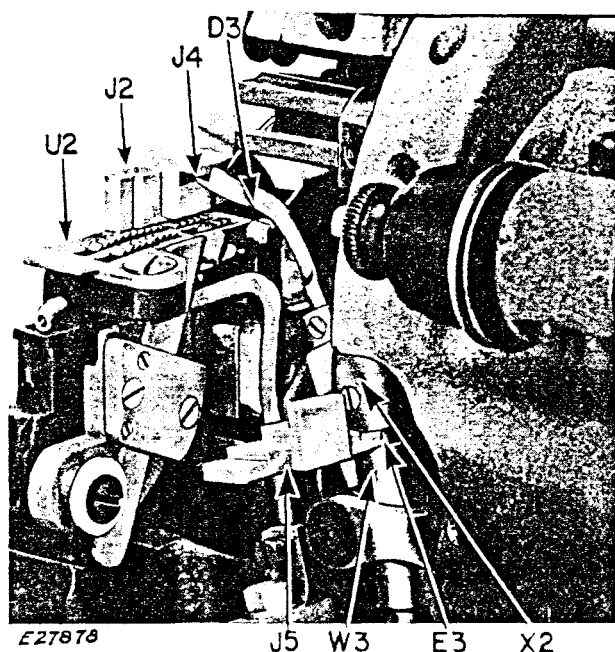


Fig. 43. Position of Gauge 164859 on Machine 246K61

CHECKING RIGHT TO LEFT POSITION:

Hold gauge so that end marked "HIGH" on gauge just touches left side of needle, as shown at J6 in Figs. 39, 40 and 41.

When spreader (or right looper) D3 is at its extreme left position it should just touch surface C5 on gauge, as shown in Figs. 39, 40 and 41.

At this setting bracket X2, Fig. 42 should be approximately at midpoint of its extreme left to right positions on casting.

ADJUSTMENT OF RIGHT TO LEFT POSITION:

Loosen the two screws G3, Fig. 42 and move bracket X2, as required, to bring spreader (or right looper) D3 in correct contact with gauge surface C5, Figs. 39, 40 and 41.

Securely tighten two screws G3.

CHECKING HEIGHT:

Machine 246K44:

Place gauge J2 firmly upon throat plate seat V2 with end marked "LOW" toward needle, as shown in Fig. 42.

Machine 246K61:

Place gauge J2 firmly upon throat plate U2, with end marked "LOW" toward needle, as shown in Fig. 43.

Both Machines:

When spreader (or right looper) D3 is at its extreme left position its highest point should just touch undersurface J4 on gauge, as shown.

ADJUSTMENT FOR HEIGHT (See Fig. 42, page 20):

When installing a spreader (or a right looper) loosen nut Q3, Fig. 42 and turn screw H3 anti-clockwise to align the screwdriver slot in head of screw H3 with centre-line of spreader carrier S3, as shown in Fig. 42. Then loosen screw F3. Place collar K3 on spreader shank and insert the spreader in holder G3, as shown in Fig. 42.

Adjust the height of the spreader (or right looper) in the following manner—

Loosen screw F3 and nut Q3.

Raise or lower spreader (or right looper) D3 in carrier as required.

Press collar K3 firmly against top of carrier S3.

Securely tighten screw F3 and nut Q3.

CHECKING FRONT TO REAR POSITION:

Turn machine pulley over away from operator through one full revolution. Observe position of spreader (or right looper) in relation to needle during this full movement.

Spreader (or right looper) D3 should pass behind left looper head and in front of needle; brushing lightly on needle.

ADJUSTMENT OF FRONT TO REAR POSITION:

Loosen nut Q3, Fig. 42.

Turn spreader (or right looper) D3 in carrier S3 as required.

Securely tighten nut Q3.

Recheck each setting and securely fasten all parts loosened earlier.

TO SET THE NEEDLE THREAD CONTROLLER

(See Figs. 44 and 45)

Needle Thread Controller 164151 (J3, Fig. 44) is used for **three-thread TIGHT** stitch.

Needle Thread Controller 164381 (J3, Fig. 45) is used for **two-thread** stitch and for **purl-on-the-edge** stitch.

FUNCTION:

The needle thread controller **J3** should aid in the setting of the stitch by **taking up the slack of needle thread** as the needle finishes its downward stroke; thus setting the stitch as the needle thread loop is shed from the loopers.

When needle is at its highest position, needle thread should run under clearance **U3** of needle thread controller **J3**, as shown in Fig. 44 or in fork **U3** of controller **J3**, as shown in Fig. 45.

VARIATIONS: The desired setting for needle thread controller may vary with changes in thread, special fittings or materials in use.

ADJUSTMENT:

Swing presser bar **A2** and cloth plate **Q** out to the left.

Remove screws **X5** and oil splash guard **Z5**.

Turn machine pulley over away from operator until needle is at its highest position.

Loosen two screws **V3** and move needle thread controller **J3** **toward the front to tighten the stitch** or **toward the rear to loosen the stitch** as required. Then tighten the two screws **V3** and recheck the stitch setting.

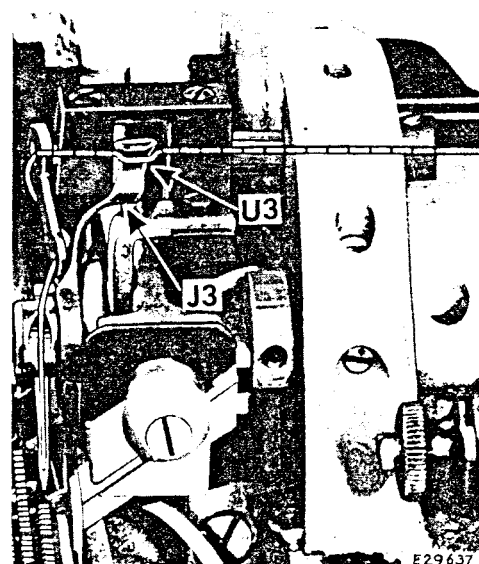


Fig. 44. Needle Thread Controller 164151 in Correct Relation to Needle Thread

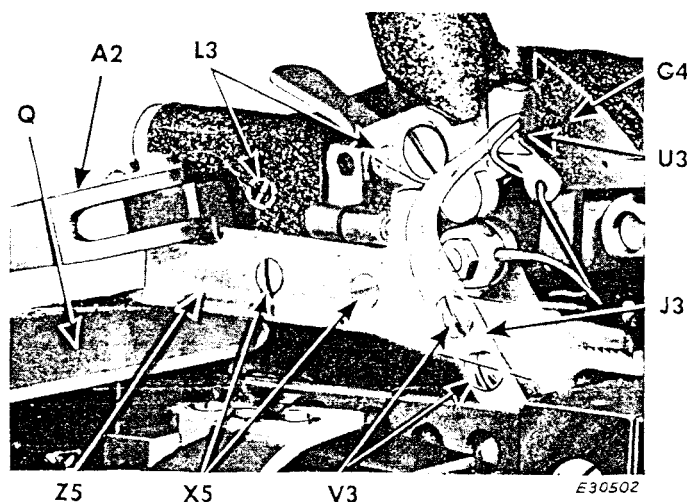


Fig. 45. Needle Thread Controller 164381 in Correct Relation to Needle Thread

Figs. 44 and 45 show the correct position of the needle thread as it passes the needle thread controller **J3**. To check this condition, remove two screws **L3** and presser bar housing **G4**.

After making certain that needle thread is in the correct position, replace presser bar housing **G4** and fasten with two screws **L3**.

Replace splash guard **Z5** with two screws **X5**.

TO ADJUST THE LOOPER THREAD TAKE-UP

(See Figs. 46 and 47)

ADJUSTING LOOPER THREAD TAKE-UP (LEFT) X3 FOR MORE OR LESS THREAD:

Remove the chip guard **W**, **Fig. 47** and open the front cover plate **M2**. Loosen the two screws **T3**, **Fig. 46** and raise or lower the right end of the left take-up **X3**, as required.

Securely tighten the screws **T3** and replace the chip guard **W**.

SETTING LOOPER THREAD EYELET (LEFT):

The looper thread eyelet **F4** should be normally at the **midpoint** of the slot **K4**, **Figs. 46 and 47**.

To adjust the looper thread eyelet, loosen the screw **E4** and raise or lower the eyelet **F4** to the proper location. Then securely tighten the screw **E4**.

SETTING LOOPER THREAD TAKE-UP (RIGHT):

To set the right take-up **A4**, open the front cover plate and loosen the screw **N5**, **Figs. 46 and 47**. Raise or lower the right take-up **A4**, as required. Do not permit take-up **A4** to hit cover **M2** nor to interfere with other moving parts. Then securely tighten the screw **N5** and close the cover plate **M2**.

SETTING LOOPER THREAD STRIPPER:

The looper thread stripper **B4** normally should be at the **midpoint** of the top and bottom extremes of its adjustment, as shown in **Figs. 46 and 47**.

To set the looper thread stripper, open the front cover plate **M2** and loosen the screw **H4**. Raise or lower the stripper **B4**, as required. Then securely tighten the screw **H4** and close the cover plate **M2**.

Make certain that none of the above adjustments cause take-up components to strike one another or the cover **M2**.

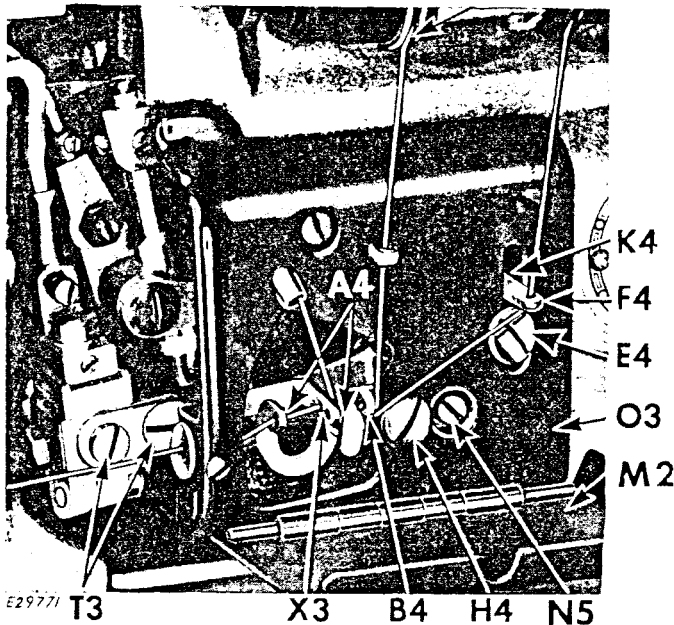


Fig. 46. Looper Thread Take-up Adjustments

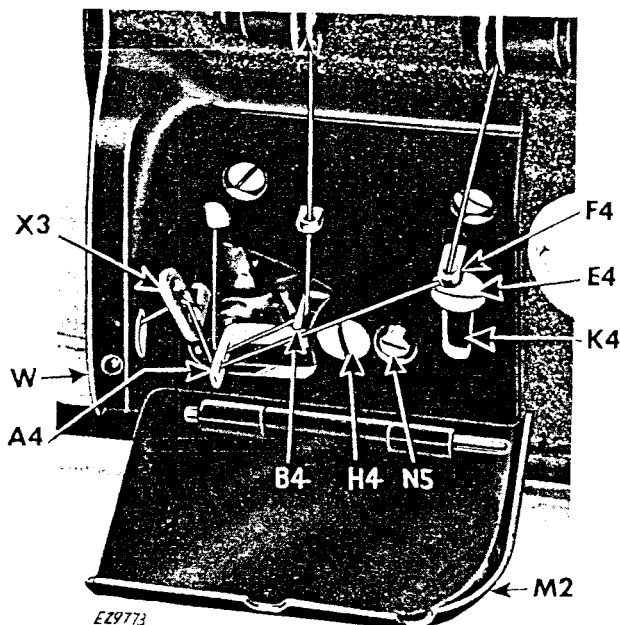


Fig. 47. Take-up for Purl-on-the-edge Stitch

TO REMOVE AND REPLACE THE KNIVES

REMOVING STATIONARY KNIFE L4:

Machine 246K44: Loosen the screw **V4**, Fig. 48 and draw the knife **L4** upward and out.

Machine 246K61: Loosen the two screws **V4**, Fig. 49 and draw the knife **L4** upward and out.

REPLACING STATIONARY KNIFE L4:

Push the knife **L4**, Figs. 48 and 49 downward into the knife holder **S4**, until the cutting edge of the knife **L4** is flush with the top surface of throat plate.

Machine 246K44: Securely tighten screw **V4**, Fig. 48.

Machine 246K61: Securely tighten two screws **V4**, Fig. 49.

REMOVING MOVABLE KNIFE D4 (See Fig. 51, page 25):

Remove the clamp screw **Q4**, with the chip ejector **O4**, knife guard **C4** and the knife clamp **Z3**. Lift the knife **D4** from the knife holder **P4**.

REPLACING MOVABLE KNIFE D4 (See Fig. 51, page 25):

Slip the knife in knife holder **P4**, replace the knife clamp **Z3**, the knife guard **C4**, the chip ejector **O4**, and the clamp screw **Q4**. Press the movable knife **D4** downward against the stationary knife **L4** and securely tighten the clamp screw **Q4**.

Turn the machine pulley over from you, until the lowest point **X4**, Fig. 50, of the cutting edge of the movable knife **D4**, just reaches the cutting edge of the stationary knife **L4**, as shown in Fig. 50. Loosen the set screw **T4**, Figs. 48 and 49, sufficiently to release the spring behind the stationary knife **L4**, permitting the stationary knife to make a light spring contact with the movable knife **D4**. Then securely tighten the set screw **T4**.

TO ADJUST THE TRIMMER

SETTING HEIGHT OF STATIONARY KNIFE:

Machine 246K44: Loosen screw **V4**, Fig. 48.

Machine 246K61: Loosen two screws **V4**, Fig. 49.

Raise or lower knife **L4**, Figs. 48 and 49 in the knife holder **S4**, until the cutting edge of the knife is at the same level as top surface of throat plate **U2**.

Machine 246K44: Securely tighten screw **V4**, Fig. 48.

Machine 246K61: Securely tighten two screws **V4**, Fig. 49.

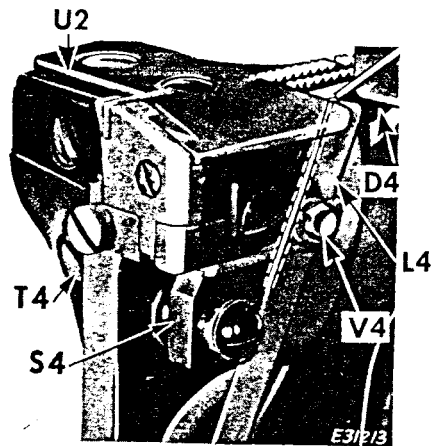


Fig. 48. (Machine 246K44)
Removal and Replacement
of Stationary Knife

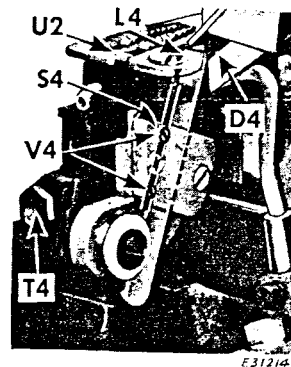


Fig. 49. (Machine 246K61)
Removal and Replacement
of Stationary Knife

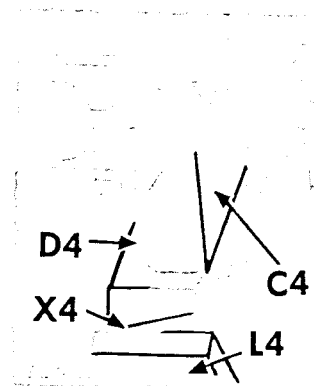


Fig. 50. Contact Point
of Knives

WIDTH OF BIGHT:

The position of the stationary knife blade **L4** in relation to the needle determines the width of bight.

For some types of work, the width of bight must conform to the width of the chaining-off finger.

TO ADJUST THE TRIMMER (CONTINUED)

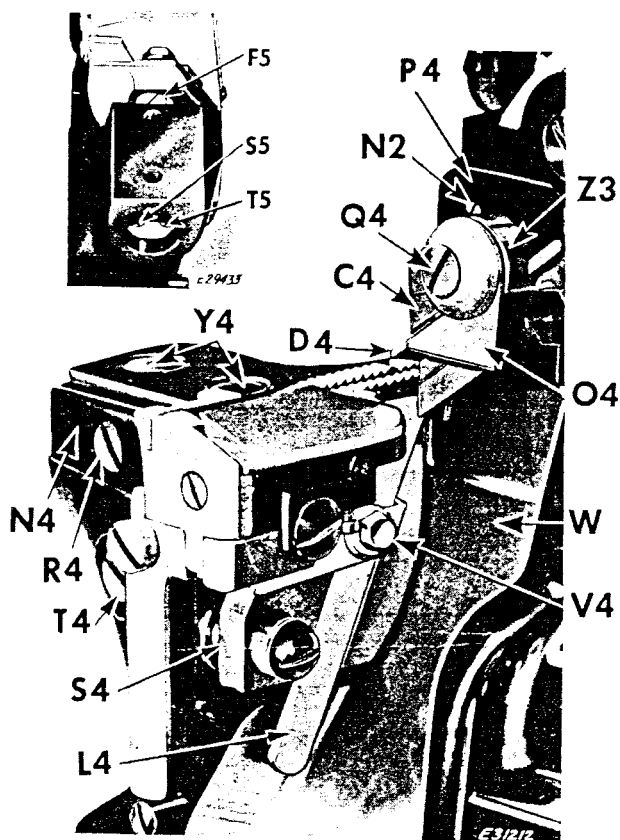


Fig. 51. Trimmer Adjustment

Before setting stationary knife L4 for width of light, loosen screw Q4, Fig. 51 and slide movable knife D4 up in its holder out of possible contact with stationary knife. Tighten screw Q4.

SETTING STATIONARY KNIFE FOR WIDTH OF BIGHT:

Loosen the screw T4, Figs. 48 and 49 and move the stationary knife holder S4 toward the left or right, as required. Securely tighten the screw T4.

Return movable knife D4 to its correct position; setting it in relation to the stationary knife as described next.

SETTING MOVABLE KNIFE IN RELATION TO STATIONARY KNIFE SETTING (See Fig. 51):

Remove the clamp screw Q4, the chip ejector O4, the knife guard C4 and the knife clamp Z3. Loosen the screw N2 and move the knife holder assembly P4 toward the right or left as required to

bring the cutting edge of the movable knife D4, at its lowest position, slightly below the cutting edge of the stationary knife L4, as shown in Figs. 48 and 49. Securely tighten the screw N2, Fig. 51. Then replace the knife clamp Z3, the knife guard C4, the chip ejector O4, and the clamp screw Q4. Then lightly press the movable knife D4 downward against the stationary knife L4 and tighten the screw Q4.

Loosen the screw T4, Figs. 48 and 49, sufficiently to release the spring behind the stationary knife L4 permitting the stationary knife to make a tight spring contact with the movable knife D4. Then securely tighten the screw T4.

When knives require sharpening they may be removed as instructed on page 24 and sharpened as instructed on page 26.

ANGULAR ADJUSTMENT:

To trim efficiently, knives must **contact each other at all points** along cutting edges.

To adjust, remove two screws Y4, Fig. 51 and remove throat plate; remove screw R4 and guide N4.

NOTE: On machines equipped with a needle guard, this guard must also be removed. When replacing needle guard, set it so that needle will just brush guard as needle descends.

Remove front feed dog. Loosen screws F5, S5 and T5 shown in inset at top left of Fig. 51.

Align lower knife L4 with upper knife D4 and securely tighten screw F5.

Tighten screws S5 and T5.

TO SHARPEN THE TRIMMER KNIVES

(See Figs. 52 and 53)

Knife Grinding Machine 701-9 (belt driven), is necessary for sharpening the knives used on **Machines of Class 246K**. The use of this grinder insures the correct bevel of the cutting edge of each knife.

If this Knife Grinder is not available, knives that require a new edge should be returned to your SINGER Service Representative or to a SINGER factory for sharpening.

Do not attempt to sharpen these knives by hand.

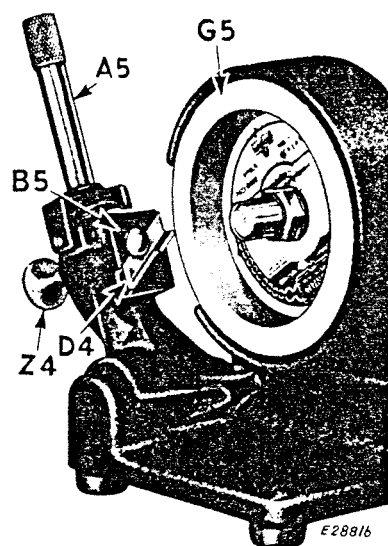


Fig. 52. Sharpening the Movable Knife

SHARPENING MOVABLE KNIFE D4:

Insert knife **D4**, Fig. 52 in knife holder **B5**, Fig. 52 on front of lever arm **A5**, Fig. 52. Allow approximately $\frac{1}{16}$ inch of the knife to extend beyond holder for grinding. Then tighten thumb screw **Z4**, Fig. 52.

Turn thumb nut **E5**, Fig. 52 over from you until the knife **D4** clears the grinding face **G5**, Fig. 52. While moving lever arm **A5** alternately back and forth, turn thumb nut **E5** as required, to bring the cutting edge of the knife **lightly** against the grinding face of the wheel.

Continue the back and forth motion of the lever arm, grinding off only enough to sharpen the cutting edge.

The movable knife is thus ground to a shearing edge, requiring no special setting in the machine to shear.

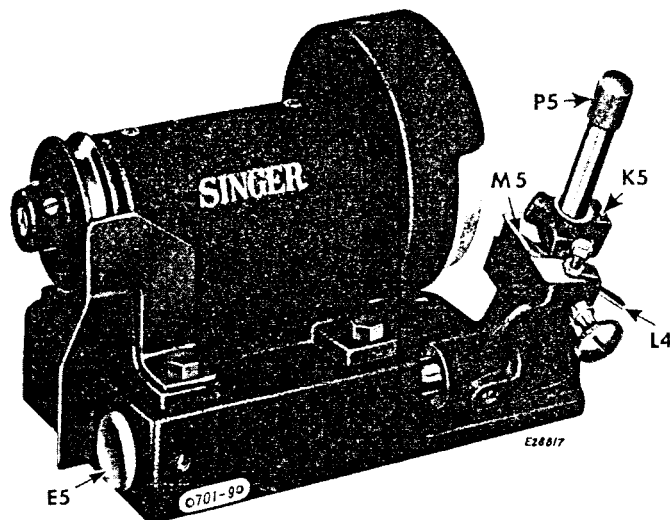


Fig. 53. Sharpening the Stationary Knife

SHARPENING STATIONARY KNIFE L4:

Insert knife **L4**, Fig. 53 in knife holder **K5**, on rear of lever arm, so that its bevel **M5** is parallel with grinding face **G5** of grinding wheel. Allow approximately $\frac{1}{16}$ inch of the knife to extend beyond holder for grinding. Then by turning knurled end **P5**, Fig. 53 of lever arm, screw lever arm into knife holder **K5**, securing the knife. Sharpen the stationary knife as instructed above.

PARTS LIST

FOR

SINGER*

BLIND STITCH HEMMERS

246k44 and 246k61

INSTRUCTIONS FOR ORDERING

In ordering from this List, the part number **MUST BE** quoted exactly as shown in the first column. A number always indicates the same part in whatever List it may appear, or for whatever machine. The code numbers (where shown) indicate the style of finish, as follows:—

Code No.	Description
801	Hardened, Polished, Nickel Plated and Buffed.
802	Polished, Nickel Plated and Buffed.
803	Hardened only.
804	Polished only.
805	Soft, not Polished.
806	Hardened and Polished.
807	Bright Rumbled and Nickel Plated.
808	Blued.
809	Nickel Plated only.
810	Hardened and Nickel Plated.
811	Brass Plated.
812	Oxidized.
813	Phosphate Coating Formed on Surface of Iron or Steel.
814	Cadmium Plated.
815	Copper Plated.
816	Zinc Plated.
817	Silver Plated.
818	Polished and Nickel Plated.
819	Black Oxide for Iron and Steel.
820	Black Nickel Plated only.
821	Chromium Plated.
822	Buffed and Chromium Plated.
823	Hardened, Polished, Buffed and Chromium Plated.
824	Hardened, Bright Rumbled and Nickel Plated.
825	Hardened, Bright Rumbled, Nickel Plated, Bright Rumbled and Chromium Plated.
826	Alumilite (Plain).
827	
828	Polished, Nickel Plated and Chromium Plated.
829	Hardened, Polished, Nickel Plated and Chromium Plated.
830	Heat Treated for Toughness.
831	Heat Treated for Toughness and Polished.
832	Heat Treated for Toughness and Nickel Plated.
833	Heat Treated for Toughness and Black Oxide.
834	Heat Treated for Toughness, Polished, Nickel Plated, Buffed and Chromium Plated.
835	
836	
837	
838	
839	Chrome Nickel, Satin Finish.
840	Hardened and Chrome Nickel, Satin Finish.
841	Hardened and Phosphate Coating Formed on Surface of Steel.
842	Hardened and Zinc Plated.
843	Hardened, Polished and Nickel Plated.
844	Hardened, Polished, Copper and Nickel Plated and Buffed.
845	Copper and Nickel Plated and Polished.
846	Copper and Nickel Plated only.
847	Hardened, Copper and Nickel Plated.
848	Copper and Brass Plated.
849	Copper Plated and Oxidized.
850	Hardened and Black Oxide for Iron and Steel.
851	Hardened, Polished, Nickel Plated, Buffed and Chromium Plated.
852	Polished, Nickel Plated, Buffed and Chromium Plated.
853	Hardened and Chromium Plated.
854	Polished and Chromium Plated.
855	Bright Rumbled, Nickel Plated, Bright Rumbled and Chromium Plated.

INSTRUCTIONS FOR ORDERING—Continued.

Code No.	Description	Code No.	Description
856	Nickel and Chromium Plated.	734	Pale Red.
857	Copper and Chromium Plated.	735	Emerald Green.
858	Heat Treated for Toughness, Nickel and Chromium Plated.	736	Green Metallic.
859	Heat Treated for Toughness, Copper Plated and Oxidized.	737	Light Beige Satin Matte.
860	Nickel Plated and Buffed only.	738	Copper Tan.
861	Alumilite (dyed)—Black.	739	Buff.
862	" (")—Light Almond Green.	740	White.
863	" (")—Dark Brown.	741	Dark Fawn.
864	" (")—Russet Brown.	742	Plum.
865	" (")—Dark Green.	743	Birch Brown.
866	" (")—Medium Gold.	744	Satin Black.
867	Nickel-Satin Finish.	745	Gold Buff.
868	Hardened and Nickel-Satin Finish.	746	Blue-Grey.
		747	Medium Gold.
		748	Sand.
		749	Khaki.
		750	Flame Red.
		751	Brite Green.
		752	Sage Green.
		753	Mist Green.
		754	Ice Green Metallic.
		755	Dark Beige Metallic.
		756	Shell Pink.
		757	Surf Green.
		758	Colonial Rose.
		759	Cream.
		760	Oak Brown.
		761	Deep Fawn.
		762	Medium Green.
		763	Light Green Metallic.
		764	Light Gold.
		765	Persimmon.
		766	Mahogany Brown.

PARTS MARKED THUS (+) ARE FURNISHED ONLY WHEN THE REPAIRS ARE MADE AT FACTORY.

Parts Complete for Machine No. 246K44

FOR TRIMMING, OVEREDGING AND BLIND STITCH HEMMING OR WELTING LIGHT AND MEDIUM WEIGHT FABRICS. ONE NEEDLE. ONE LOOPER. ONE SPREADER. TWO-THREAD OVEREDGE STITCH (TYPE 503), GATHERING FEED. TRIMMER. SPEED UP TO 6000 S.P.M. DEPENDING ON MATERIAL USED AND OPERATION PERFORMED.

Part No.	Plate	Description
164347	3057	Chain Cutter
164860	3065	" " Holder
164861	3065	" " Knife
665-809	3065	" " Screw
164862	3065	Chain Cutter, complete, Nos. 665-809, 164860 and 164861
NOTE.—No. 164862 is regularly furnished with this machine unless No. 164347 is specified on order.		
51362-830	3065	Chain Cutter Screw (2) (used for both Chain Cutters)
164001	3067	Chip Guard
1209-809	3067	" " Screw (lower)
140509-809	3067	" " " (upper)
164518	3057	Cloth Guide
160748	3057	" " Bracket
208-809	3057	" " " Screw (for 246K44 Machine only)
140061-810	3057	" " Hinge Screw
164519	—	Cloth Guide (swing-out), complete, Nos. 140061-810, 160748 and 164518 (for 246K44 only)
164513	3046	Cloth Plate
164512-701	3046	" " Extension
51408-809	3046	" " " Screw
1700-809	3046	" " " " Nut
931084	3046	" " " " Lock Washer
164205	3046	" " Lock Spring
1700-809	3046	" " " " Nut
931084	3046	" " " " Lock Washer
1250-830	3046	" " " " Screw Stud
164104	3067	" " Plunger
164105	3067	" " " Spring
624-830	3067	" " " Set Screw
164106	3046	" " Position Collar with two 624-830
624-830	3046	" " " " Set Screw
164514	—	Cloth Plate with Extension, complete, Nos. 164205, 164512-701, 164513, two each 1700-809, 51408-809 and 931084
160746	3057	Edge Guide (floating)
160395	24899	" " (") Spring
904-830	3057	" " (") " Screw
220-809	3057	" " (") " " Lock Screw
160747	3057	" " (fixed)
240-809	3057	" " (") Screw
50589-810	3057	" " Adjusting Screw
160398	3057	" " Bracket with 220-809 and 904-830
160399	3057	" " Support and Throat Plate Guide with 853-830
1454-809	24899	" " " " " " " " Screw

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
160749	3057	Edge Guide (floating), complete, Nos. 208-809, 240-809, 50589-810, 160395, 160398, 160399, 160746, 160747 and 164519
164003	3068	Feed Bar Hinge Pin (eccentric)
1389-830	3068	" " " " Set Screw
164004	3068	" " Slide Block (back)
1628-803	3068	" " " " (") Nut
17022	3068	" " " " (") " Washer
164005	3068	" " " " (front)
164687	3068	" (back) Bar with 164010
164017	3068	" (") " Connection
164008	3068	" (") " " Bearing
164009	3068	" (") " " Hinge Screw Stud
1671-803	3068	" (") " " " " " Nut
164010	3068	" (") " " " " " Position Pin
164495	3057	" (") Dog Section (left)
164243	3057	" (") " " (right)
1100-830	3057	" (") " " (") Screw
164496	3057	Feed (back) Dog, complete, Nos. 1100-830, 164243 and 164495
1454-806	24899	Feed (back) Dog Screw
164915	3068	" (") Eccentric
NOTE.—Feed (back) Eccentric No. 164915 is furnished in 4 to 16, 18, 20, 22, 24, 28, 32, 36, 40, 45, 50, 60, 70, 80 and 100 stitches to the inch. Unless otherwise stated No. 164915 (14 stitches to the inch) is supplied regularly.		
164006	3068	Feed (front) Bar with 164010
164007	3068	" (") " Connection
164018	3068	" (") " " Bearing
164009	3068	" (") " " Hinge Screw Stud
1671-803	3068	" (") " " " " " Nut
164010	3068	" (") " " " " " Position Pin
164208	—	Feed (back) and (front) Bars, complete, Nos. 164005 to 164008, 164017, 164018, 164687, two each 1671-803, 164004 and 164009
164497	3057	Feed (front) Dog
1454-806	24899	" (") " Screw
164915	3068	" (") Eccentric
NOTE.—Feed (front) Eccentric No. 164915 is furnished in 4 to 16, 18, 20, 22, 24, 28, 32, 36, 40, 45, 50, 60, 70, 80 and 100 stitches to the inch. Unless otherwise stated No. 164915 (14 stitches to the inch) is supplied regularly.		
164520	3067	Feed Eccentric Cover
164704	3067	" " " " Bracket
164705	—	" " " " " 164704 with 164023
157-803	3067	" " " " " Screw
629-810	3067	" " " " " Hinge Screw
164401	3067	" " " " " Latch Spring
227-809	3067	" " " " " " Screw
164023	3067	" " " " " Oil Wick
164706	3067	Feed Eccentric Cover, complete, for use with eccentrics of 4 stitches and above Nos. 629-810, 164401, 164520, 164705 and two 227-809
164949	3066	Feed Lifting and Knife (movable) Eccentric

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
164455	3069	Finger Guard (for 246K44 Machine only)
164456	3069	" " Adaptor (for 246K44 Machine only)
1259-830	3055	" " " Screw (for 246K44 Machine only)
1423-809	3069	" " " Screw (for 246K44 Machine only)
164550	3055	Knife (movable) (2) (1 in machine, 1 sent as spare)
164027	3065	" (") Clamp
140050-803	3065	" (") " Screw
164028	3065	" (") Guard (lower)
164458	3055	" (") " (upper)
164029	3065	" (") Holder
198-809	3065	" (") " Screw
164030	3065	" (") " " Bearing
164950	3065	" (") Lever with 620-830
164951	—	" (") " 164950 with 132583, 164035, 164136 and 164963
164032	3065	" (") " Bearing
447-830	3065	" (") " " Set Screw (long)
624-830	3065	" (") " " " (short)
164373-728	3055	" (") " Cover and Presser Bar (upright) Housing with 1259-830
50073-809	3055	" (") " " and Presser Bar (upright) Housing Screw (2)
164374	—	Knife (movable) Lever Cover and Presser Bar (upright) Housing, complete, Nos. 50060-810, 164137 to 164139, 164142 to 164144, 164194 and 164373-728
164180	3065	Knife (movable) Lever Guide
164181	3065	" (") " " Holder with two 140239-830
164210	3065	Knife (movable) Lever Guide Holder 164181 with 197-809, 164177, 164180 and 164182
140239-830	3065	Knife (movable) Lever Guide Holder Set Screw
164182	3065	" (") " " " Thread Tube
447-830	3065	" (") " " " " Set Screw
197-809	3065	" (") " " " Screw
132583	3065	" (") " " Hinge Pin with 132584
132584	3065	" (") " " " Oil Wick
620-830	—	" (") " " " Set Screw
164034	3065	" (") " " " Stud
164035	—	" (") " " " 164034 with 164036 and 164269
164036	3065	" (") " " " Oil Wick (long)
164269	—	" (") " " " " (short)
447-830	3065	" (") " " " " Set Screw (back)
1143-830	3065	" (") " " " " " (top)
164728	3065	" (stationary) (2) (1 in machine, 1 sent as spare)
164744	3055	" (") Clamping Gib
140788-803	3055	" (") " " Screw
3146	3055	" (") " " " Washer
164746	3055	" (") Holder
164747	—	Knife (stationary) Holder (adjustable), complete, Nos. 742-806, 164745 and 164746
164748	—	Knife (stationary) Holder (adjustable) with Gib, complete, Nos. 3146, 140788-803, 164744 and 164747

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
164590	3055	Knife (stationary) Holder Adjusting Stud
190-805	3055	" (") " " " Cap Screw
39541	3055	" (") " " " " Washer
164745	3055	" (") " Body with two 50611-803
50611-803	3055	" (") " Position Screw
742-806	3055	" (") " Screw
164042	3065	" (") " Sleeve
140088-805	3065	" (") " " Screw
175032	3055	" (") " " " Washer
164043	3055	" (") " Spring
164525	3055	" (") " " Stud
164462	3065	Lint Stripper with 735-830
735-830	3065	" " Set Screw
164894	3069	Looper
164046	3069	" Carrier with 460-830, 50379-806 and 164202
164660	3069	" " Holder with 1083-803, 140393-830 and 140596-830
164661	—	" " " 164660 with 1324-803, 59456 and 164046
1083-803	3069	" " " Clamping Screw
140596-830	3069	" " " Set Screw (left)
140393-830	3069	" " " " " (right)
1324-803	3069	" " " Screw
460-830	3069	" " " Set Screw
59456	3069	" " " Washer
164048	3069	" Driving Shaft
164049	3069	" " " Bushing (back)
140394-805	3069	" " " " (") Cap Screw
164293	3069	" " " " (") " " Washer (fibre)
164737	3069	" " " " (front)
164051	3069	" " " Crank with 1083-803
1083-803	3069	" " " Clamping Screw
164052	3066	" " " Connection with two each 171-830 and 140159-830
164215	—	" " " " 164051 with 164052
171-830	3066	" " " " Connection Cap (lower) Screw
140159-830	3066	" " " " " (upper) Screw
164067	3069	" " " " Key
1324-803	3069	" " " " " Screw
45057	3069	" " " " " " Washer
164053	3069	" " " " Thrust Bearing
164739	3069	" " " Oil Ring (rubber)
164740	3069	" " " " " Spacer
50379-806	3069	" Set Screw
164202	3069	" Stop Pin
165055	—	" Thread Tube
853-830	3057	" " " Set Screw
+164954-728	—	Machine Frame
+164955	—	Machine Frame, complete, Nos. 140396-805, 164077, 164954-728, 164057 and three 140395-805
164074	24813	Machine Frame Bottom Cover

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
164075	24813	Machine Frame Bottom Cover Gasket
914-803	24813	" " " " Screw (13)
*165056-701	—	" " Bracket
*165057	—	" " " 165056-701 with 164207 and two 187-805
164207	3053	" " " Key
187-805	3053	" " " Screw
140396-805	3053	" " " Screw (large)
164077	3053	" " " (") Washer (fibre)
164229	3053	" " " (") " (felt)
140395-803	3053	" " " (small)
164515-701	24813	" " Cover (back)
50571-809	24813	" " (") Screw (long) (2)
914-809	24813	" " (") " (short)
164516-701	24813	" " (") 164515-701 with 1637-810 and 140228-803
164081	3053	" " Oil Lead
140088-805	3053	" " " Screw
1698-809	3053	" " " Nut
164082	3053	" " Plug Bracket
140346-830	3053	" " " Set Screw
164083	3053	" " Screen
206-809	3053	" " " Screw (3)
164608	3053	" " Splash Guard (internal)
164605	3053	" " " (") Oil Pad
164606	3053	" " " (") " Fastener
164609	3053	Machine Frame Oil Splash Guard (internal), complete, Nos. 164605, 164606 and 164608
164085-809	3055	Machine Frame Oil Splash Guard (top)
51023-818	3055	" " " " (") Screw (2)
164086	3053	" " " Tube with 164087
447-830	3053	" " " Set Screw
164087	3053	" " " Wick
164956	3066	" " Rotary Shaft
164957	—	Machine Frame Rotary Shaft 164956 with 164097, 164215 to 164217, two each 164093 and 164232
139026	3066	Machine Frame Rotary Shaft Ball Bearing
164092	3066	" " " " " Housing
51369-803	3066	" " " " " Screw (3)
164093	3066	" " " " " Sleeve (two pieces)
164232	3066	" " " " " Guide
164958	3066	" " " " " Bushing (front)
164959	—	" " " " " (") Oil Ring (rubber)
164960	—	" " " " " (") Oil Ring Spacer
1036-830	3066	" " " " " (") Set Screw
164961	3066	" " " " " (intermediate)
51332-803	3066	" " " " " (") Set Screw
164096	3066	" " " " " Counterbalance with 1036-830
1036-830	3066	" " " " " Set Screw
164097	3066	" " " " " Key

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
51649-803	3066	Machine Frame Rotary Shaft Nut
131056	3066	" " " " Washer
164098	3066	" " " " Oil Return and Ball Bearing Grease Retainer
164099	3066	" " " " Screw Stud
164100	3066	" " " " Thrust Bearing
164101-728	3067	" " Top Cover
164214	—	Machine Frame Top Cover 164101-728 with 330-809, 164103 and two 164418
164102	3067	Machine Frame Top Cover Gasket
164103	3067	" " " " Oil Lead
330-809	3067	" " " " " " Screw
51369-809	3067	" " " " " " Screw (3)
164231	3066	" Pulley (round and "V" belt) with two 448-830
164071-701	3066	" " Cap
140416-819	3066	" " " Screw
448-830	3066	" " Set Screw
Catalogue 1265	—	Needle, size 11 (151 x 7)
164109	3055	Needle Clamp
51720-803	3055	" Clamping Nut
164110	3055	" Driving Shaft with 164118
164275	—	" " " 164110 with 51720-803, 164109 and 164117
164111	3055	" " " Bushing
164112	3055	" " " " Cap
164113	3055	" " " " Oil Lead
452-830	3055	" " " " " " Hole Plug Screw
164114	3055	" " " Crank with 1083-803 and two 140596-830
164115	3055	" " " " Ball
1083-803	3055	" " " " Clamping Screw
164217	3066	" " " " Connection with 164115, two each 157-830 and 171-830
157-830	3066	" " " " Connection Cap (lower) Screw
171-830	3066	" " " " " " (upper) Screw
140596-830	3055	" " " " Set Screw
165058	—	" Guard (for 246K44 Machine only)
165059	—	" " Holder (for 246K44 Machine only)
1083-805	—	" " " Screw (for 246K44 Machine only)
50225-809	—	" " " Screw (for 246K44 Machine only)
164117	3055	" Holder
164118	3055	" Stop Pin
164119	3066	Oil Agitator
164120-701	3053	" Cooler with two 164125
164121	3053	" " Cover
164123	3053	" " " 164121 with 164135
164122	3053	" " " Gasket
145-809	3053	" " " Screw
164124	3053	" " Gasket
164125	3053	" " Oil Pipe
164126	3053	" " " Tube with 138269 and 164128
164736	—	" " " " 164126 with 51630 and 164127

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
164127	3053	Oil Cooler Oil Tube Coupling
51630	3053	" " " " Lock Nut
*138269	—	" " " " Sleeve
164128	—	" " " " Wick
51139-809	3053	" " " " Screw (long) (2)
1324-809	3053	" " " " (short)
164135	3053	" Cup for filling machine
164607	3065	" Deflector
164131	3053	" Sight Gauge Background Disc
164132	3053	" " " " " " Gasket
164133	3053	" " " " Window
164132	3053	" " " " Gasket
164134	3053	" " " " Retainer
164132	3053	" " " " " " Gasket
1485-809	3053	" " " " " " Screw (2)
164136	3065	Presser Bar Bracket
164137	3055	" " " " Lifting Bracket with 462-830, 624-830 and 51846
51846	3055	" " " " Roller and Stud
624-830	3055	" " " " Set Screw (long)
462-830	3055	" " " " " " (short)
164138	3055	" " " " Lever
164139	3055	" " " " Spring
140228-803	24813	" " " " Stop Screw
1637-810	24813	" " " " " " Nut
164962	3065	" " (swing-out)
164141	3065	" " (") Lifting Screw Stud
1700-809	3065	" " (") " " " Nut
164142	3055	" " (") Opening Lever
50060-810	3055	" " (") " " Hinge Screw
140510-803	3065	" " (") Pivot Screw
164351	3065	" " (") " " Locking Plate
51362-830	3065	" " (") " " " " Screw
164143	3055	" " (upright)
164144	3055	" " (") Spring
164416	—	" " (") " (heavy)
NOTE.—No. 164144 is supplied with machine.		
*164352	24899	Presser Foot Body (back)
*164508	24899	" " " (front)
164509	3057	" " " (hinged) Nos. 164352, 164355 and 164508
164355	24899	" " " Hinge Pin
164356	3057	" " Chaining-off Finger
164147	3057	" " Clamping Plate
50225-809	3057	" " " " " " Screw
164511	3057	Presser Foot (hinged), complete, Nos. 164147, 164356, 164509, 164510 and two 50225-809
164517	3057	Presser Foot Hemming Guide for 1/4", 3/8, 1/2", 5/8", 3/4", 7/8", 1", 1 1/8", 1 1/4", 1 3/8" and 1 1/2" Gauges (for 246K44 Machine only)
NOTE.—When ordering No. 164517 gauge required must be stated. Unless otherwise specified No. 164517 will be furnished in 3/4" gauge.		
164510	3057	Presser Foot Hemming Guide Clamping Washer (for 246K44 Machine only)
164194	3055	Pressure Regulating Thumb Screw

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
164252	3069	Spreader
164056	3069	" Carrier with 50370-830
164828	3069	" " Connection
164829	—	Spreader Carrier Connection Guide Bar Nos. 1700-809, 50420-830, 164785, 164786 and 164828
164952	3069	Spreader Carrier Connection Guide Bar Bracket with 462-830 and 51369-803
51369-803	3069	Spreader Carrier Connection Guide Bar Bracket Clamping Screw
914-803	3069	" " " " " " " " Screw (left)
1057-830	3069	" " " " " " " " " (right)
164785	3069	" " " " " " " " Oil Controlling Screw Seat (brass)
50420-830	3069	" " " " " " " " Plug Screw
1700-809	3069	" " " " " " " " " " Nut
164786	3069	" " " " " " " " Wick
462-830	3069	" " " " " " " " Set Screw
164061	—	" " " " " " " " Hinge Stud with 1019-830
1443-809	3069	" " " " " " " " Cap Screw
164397	3069	" " " " " " " " Adjusting Pin
1019-830	—	" " " " " " " " " " Set Screw
132565	3069	" " " " " " " " Hinge Pin
165000	—	" " " " " " " " Oil Pad (felt)
50370-830	3069	" " " " " " " " Set Screw
164062	3069	" " " " " " " " Driving Lever with 1083-803 and two 140596-830
1083-803	3069	" " " " " " " " Clamping Screw
164953	—	Spreader Driving Lever 164062 with 1443-809, 1700-809, 132565, 164056, 164061, 164068, 164397, 164829 and 164952
140596-830	3069	Spreader Driving Lever Set Screw
164063	3069	" " " " " " " " Shaft
164049	3069	" " " " " " " " Bushing (back)
140394-805	3069	" " " " " " " " (") Cap Screw
164293	3069	" " " " " " " " (") " " Washer (fibre)
164738	3069	" " " " " " " " (front)
164066	3069	" " " " " " " " Crank with 1083-803
1083-803	3069	" " " " " " " " Clamping Screw
164052	3066	Spreader Driving Shaft Crank Connection with two each 171-830 and 140159-830
164216	—	Spreader Driving Shaft Crank 164066 with 164052
171-830	3066	" " " " " " " " Connection Cap (lower) Screw
140159-830	3066	" " " " " " " " " " (upper) Screw
164067	3069	" " " " " " " " Key
1324-803	3069	" " " " " " " " " " Screw
45057	3069	" " " " " " " " " " Washer
164053	3069	" " " " " " " " Thrust Bearing
164739	3069	" " " " " " " " Oil Ring (rubber)
164740	3069	" " " " " " " " Spacer
164068	3069	" " " " " " " " Locking Screw Stud
1700-809	3069	" " " " " " " " Nut
164219	3069	" " " " " " " " Position Collar with 904-830
904-830	3069	" " " " " " " " Set Screw
2102	3067	Tension (heavy) Disc
164155	3067	" (") Regulating Thumb Nut

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
50133-803	3067	Tension (heavy) Screw Stud
164156	—	" (") " " 50133-803 with 164155
164161	3067	" (") Spring
59537	3067	" (") " Bushing
164158	3067	" (") " Cover
164162	3067	Tension (heavy), complete, Nos. 59537, 164156, 164158, 164161 and two 2102
2102	3067	Tension (light) Disc
164155	3067	" (") Regulating Thumb Nut
50133-803	3067	" (") Screw Stud
164156	—	" (") " " 50133-803 with 164155
164157	3067	" (") Spring
59537	3067	" (") " Bushing
164158	3067	" (") " Cover
164160	3067	Tension (light) complete, Nos. 59537, 164156 to 164158 and two 2102 (2)
164285	3067	Tension (looper thread) Thread Guide (left)
164286	3067	" (" ") " " (right)
164159	3067	" (needle thread) Thread Guide
164418	3067	" Thread Eyelet
164167-701	24761	Thread (looper) Plate with 624-830
164168	24761	" (") " Cover
164206	—	" (") " " 164168 with 164169 and 164170
164169	24761	" (") " " Hinge
164170	24761	" (") " " Pin
164171	24761	" (") " " Spring
332-809	24761	" (") " " Screw
896-830	24761	" (") " Screw (2)
164173	24761	" (") " Thread Bushing
50318-818	24761	" (") " " Screw
164174	—	Thread (looper) Plate, complete, Nos. 1423-809, 1443-809, 1607-809, 50318-818, 164163 to 164167-701, 164173, 164206, two each 332-809 and 164171
164091	3069	Thread (looper) Stripper and Take-up with 164555
164163	24761	" (") " " " Eyelet (adjustable)
1443-809	24761	" (") " " " " (") Screw
164555	—	" (") " " " Guide Wire
187-805	3069	" (") " " " Screw
17022	3069	" (") " " " Washer
164175	3069	" (") Take-up
164176	3069	" (") " Plate
190-805	3069	" (") " Screw (lower)
1443-809	24761	" (") " " (upper)
164164	24761	" (") Thread Eyelet (movable)
1423-809	24761	" (") " " Screw
164165	24761	" (") " " (stationary)
1607-809	24761	" (") " " (") Nut
164166	24761	" (") Tube
624-830	24761	" (") " Set Screw
164381	3065	" (needle) Controller

PARTS FOR MACHINE No. 246K44

Part No.	Plate	Description
164963	3065	Thread (needle) Controller Lever
1443-809	3065	" (") " Screw (2)
164177	3065	" Eyelet (needle thread)
140239-830	3065	" " (" ") Set Screw
164358	3057	Throat Plate
1094-806	24899	" " Screw (2)

Parts Special to Machine No. 246K61

FOR TRIMMING, OVEREDGING AND BLIND STITCH HEMMING OR WELTING NYLON, RAYON, KNIT GOODS AND OTHER FABRICS. ONE NEEDLE. ONE LOOPER AND ONE SPREADER. TWO-THREAD OVEREDGE STITCH (TYPE No. 503) STITCHES MATERIALS UP TO 1/8" THICKNESS. MAXIMUM SPEED 6000 S.P.M. DEPENDING UPON MATERIAL USED AND OPERATION PERFORMED.

This Machine is the same as 246K44 with the following exceptions:

Part No.	Plate	Description
164234	24899	Blind Stitch Hemming Attachment Adjusting Slide (cylindrical)
140456-810	24899	" " " " " Thumb Screw
140457-809	24899	" " " " " " Locking Screw
164235	24899	" " " " " Hinge Bracket
164236	24899	" " " " " Support
164237	24899	Blind Stitch Hemming Attachment Support, complete, Nos. 140456-810, 140457-809, 140458-803, 164234 to 164236 and 164238
164238	24899	Blind Stitch Hemming Attachment Support Cap
1259-830	3055	" " " " " Set Screw
140458-803	24899	" " " " " Thumb Screw
160376	24899	" " " " " (for 1/2" to 2" in steps of 1/8")
NOTE.—No. 160376 3/4" will be supplied unless otherwise specified on order.		
160377	24899	Blind Stitch Hemming Attachment Folder Hinge
160378	24899	" " " " " " Bracket with 904-830
59480	24899	" " " " " Hinge Pin
904-830	—	" " " " " " Set Screw
160574	—	Blind Stitch Hemming Attachment Folder Holder, complete, Nos. 335-809, 1628-810, 59480 and 160377 to 160380
160379	24899	Blind Stitch Hemming Attachment Folder Screw Stud
1628-810	24899	" " " " " " " Nut
160380	24899	" " " " " " Stop Plate
335-809	24899	" " " " " " " Screw
160381	24899	Blind Stitch Hemming Attachment with Folder, complete, Nos. 160376 and 160574
164832	3046	Cloth Plate
164858	3046	" " " Support
1083-809	3046	" " " " Screw
164833	—	Cloth Plate with Extension, complete, Nos. 1083-809, 51408-809, 164205, 164512-701, 164832, 164858, two each 1700-809 and 931084
161201	24899	Edge Guide (floating)
95-850	24899	" " (") Hinge Screw

PARTS SPECIAL TO MACHINE No. 246K61

Part No.	Plate	Description
140810-819	24899	Edge Guide (floating) Regulating Thumb Screw
161202	—	" " (") " " Locking Insert (brass)
904-830	24899	" " (") " " Screw Locking Insert Set Screw
160395	24899	" " (") Spring
51220-830	24899	" " (") " Screw
1607-819	24899	" " (") " Nut
161203	24899	" " (") and Edge Guide Support and Throat Plate Guide Bracket with 904-830
161204	—	Edge Guide (floating) and Edge Guide Support and Throat Plate Guide Bracket 161203 with 140810-819 and 161202
161205	24899	Edge Guide (floating) and Edge Guide Support and Throat Plate Guide Bracket, complete, Nos. 95-850, 198-850, 1607-819, 51220-830, 160395, 161201, 161204 and 161206
997-850	24899	Edge Guide (floating) and Edge Guide Support and Throat Plate Guide Bracket Screw
161206	24899	Edge Guide Support and Throat Plate Guide
198-850	24899	" " " " " " " Screw
164892	3068	Feed (back) Bar with 164010
164834	24899	" (") Dog Section (left)
164835	24899	" (") " " (right)
164836	24899	Feed (back) Dog, complete, Nos. 1100-830, 164834 and 164835
164893	—	Feed (back) and (front) Bars, complete, Nos. 164005 to 164008, 164017, 164018, 164892, two each 1671-803, 164004 and 164009
164837	24899	Feed (front) Dog
164838	3068	" Eccentric Cover
164839	3068	Feed Eccentric Cover, complete, for use with eccentrics of 4 stitches and above Nos. 629-810, 164401, 164705, 164838 and two 227-809
164840	3065	Knife (stationary) Clamp
164841	3065	" (") " Plate with two 904-830
904-830	3065	" (") " " Adjusting Screw
1313-806	3065	" (") " " Screw
797-803	3065	" (") Clamping Screw
164842	3065	" (") Holder
164843	3065	" (") " 164842 with 797-803, 164840, 164841 and two 1313-806
59456	3065	Knife (stationary) Holder Sleeve Screw Washer
164844	24899	" (") " Wedge
1209-819	24899	" (") " " Screw
164845	24899	Looper Thread Tube
906-830	—	" " " Set Screw
+164964	—	Machine Frame, complete, Nos. 140396-805, 164077, 164849, 164954-728 and three 140395-805
+164848-701	—	Machine Frame Bracket
+164849	—	" " " 164848-701 with 164207 and two 187-805

PARTS SPECIAL TO MACHINE No. 246K61

Part No.	Plate	Description
164850	24899	Presser Foot Chaining-off Finger
164851	24899	Presser Foot (hinged) complete, Nos. 164147, 164509, 164850 and two 50225-809
164852	24899	Throat Plate
164853	24899	" " Support with 906-830
164855	—	" " " 164853 with 997-850, 1209-819, 59456, 140088-805, 161205, 164042 and 164843 to 164845
898-819	24899	Throat Plate Support Screw

MACHINES Nos. 246K44 and 246K61

FOR

THREE-THREAD TIGHT-STITCH (TYPE 504)

The following parts are required to convert machines for above:

Part No.	Plate	Description	
164055	—	Looper (right hand)	in place of 164252
164151	—	Thread (needle) Controller	in place of 164381

THREE-THREAD PURL ON EDGE STITCH (TYPE 505)

The following parts are required to convert machines for above:

164055	—	Looper (right hand)	in place of 164252
164288	—	Thread (looper) Take-up (right)	in place of 164091
164857	—	" (") "	in place of 164175

Fittings

FOR

MACHINE No. 246K44

For Rayon, Balbriggan and Nylon.

For Two-Thread Blind Stitch
(Wire Hemming Fittings)

Part No.	Plate	Description
164531	—	Feed (back) Dog Section (left)
164532	—	" (") " complete, Nos. 1100-830, 164243 and 164531
164533	—	" (front) Dog

Accessories

Part No.	Plate	Description
164203	3070	Feed Eccentric Extractor NOTE.—(Only supplied when specified on order and at an extra charge).
164592	3070	Gauge for 246K44 Machine
164859	3070	" " 246K61 "
NOTE.—Gauges 164592 and 164859 are only supplied when specified on order and at an extra charge.		
Catalogue		
1265	—	Needles, six, size 11 (151 x 7)
120342	3070	Oiler
164198	3070	Presser Bar Lifting Chain Spring (under table)
85318	3070	Screw Driver
—	—	Tin of Oil (1 pint)
164196	3070	Threader (6)
164204	3070	Tweezers
164197	3070	Wrench (socket)
8909	3070	" (flat) for 246K61 Machine
10875	3070	" (") " 246K44 "

BELT GUARD (ADJUSTABLE)

(Supplied with Machine)

164183	3049	Belt Guard
164199	3049	" " Bracket (back)
164200	3049	" " " (front)
51326-809	3049	" " Screw
164201	3049	Belt Guard (adjustable) complete, Nos. 164183, 164199, 164200, two each 51326-809 and wood screws 3/4" No. 7 F.H.

CHIP CHUTE

(Supplied only when specified on order at no extra charge)

168198	3049	Chip Chute with four wood screws 3/8" No. 6 F.H. Blacked
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FOOT LIFTER PARTS

The Stands recommended for machines of Class 246K include a suitable treadle. If machine is fitted on a stand or other equipment which does not include a foot lifter treadle, orders should state that No. 4885 is to be supplied and it will be furnished without extra charge.

6439	3049	Chain 36" to 45" with 56864 and 56865 NOTE.—When ordering No. 6439, give length required.
4879	3049	Chain Connecting Link
56864	3049	" Hook (large)
56865	3049	" " (small)
4881	3049	Treadle
4882	3049	" Shaft
4883	—	" Spring
4884	3049	" Stand
4885	3049	Treadle, complete, Nos. 4879, 4881 to 4884 and two wood screws 1" No. 16 F.H.

KNEE LIFTER PARTS

(Will be supplied in place of Foot Lifter if specified on order)

Part No.	Plate	Description
59324	3059	Chain (8" long) with 56865
56865	3059	" Hook (small)
2763	3059	Rock Shaft
12242	3059	" " Hanger with two wood screws 1" No. 10
143283	3059	" " Knee Arm
143284	3059	" " " " Hub with 356-803 and 140351-830
140351-830	3059	" " " " " Clamping Screw
356-803	3059	" " " " " Set Screw
143285	—	Rock Shaft Knee Arm, complete, Nos. 2767, 143283 and 143284
2767	3059	" " " " Plate with 356-803
356-803	3059	" " " " " Set Screw
6337	3059	" " " " Lifting Bracket with two 356-803
164729	3059	" " " " " Hook
356-803	3059	" " " " " Set Screw
356-803	3059	" " " " " Set Screw
2770	3059	" " " " Stop Dog with 356-803
356-803	3059	" " " " " Set Screw
164727	3059	Knee Lifter, complete, Nos. 2763, 6337, 59324, 143285, 164729, two each 2770 and 12242

MACHINE BASE

(Supplied with Machine)

164184	3049	Machine Base with two each wood screws 3/4" No. 8 R.H. and 1 1/4" No. 6 F.H.
164188	3049	Machine Cushion (large) (2)
164189	3049	" " (small) (2)
140418-805	3066	" " Screw Stud (back)
657-805	3066	" " " " (front)

THREAD UNWINDER No. 151031

FOR THREE SPOOLS

(Supplied with Machine)

228692	24764	Spool Pin
201528-819	—	" " Nut
82538	—	" " Washer
151023	24764	Spool Rest with 858-830, three each 82538, 201528-819 and 228692
150203	24764	" " Cushion (felt)
858-830	24764	" " Hub Set Screw
151024	24764	" " Rod
1122-803	24764	" " " " Set Screw
151025	24764	" " Stand with two 1122-803 and three wood screws 1" No. 12 F.H.

THREAD UNWINDER No. 151031—Continued

Part No.	Plate	Description
151026	24764	Thread Guide (lower)
50311-803	24764	" " (") Holder Set Screw
151027	24764	" " (") Support with 50311-803
151028	24764	" " (upper, hollow)
151029	24764	" " (") Holder with four 453-830
151030	24764	" " Rod
453-830	24764	" " " Set Screw
453-830	24764	" " " Set Screw
151031	24764	Thread Unwinder, complete, Nos. 151023 to 151027, 151029, 151030, two each 150203 and 151028

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164660	34	164850	43	201528	46
164661	34	164851	43	228692	46
164687	32	164852	43	931084	31
164704	32	164853	43		
164705	32	164855	43		
164706	32	164857	44		
164727	46	164858	41		
164728	33	164859	45		
164729	46	164860	31		