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Introducing the New SINGER Sewing Machine Model 591!

The most dependable, lightest running machine of its kind. This machine will produce top quality straight-line single-needle lock stitching in fabrics as fine as ladies’ lingerie or as heavy as men’s overcoating.

With an oil reservoir, a pump and a minimum of wicking, all parts requiring oil are kept constantly lubricated. Oil flow can be checked easily through a “window” on arm top cover.

Quiet and smooth in operation, the Model 591 was designed for your comfort, making sewing more pleasant, quicker and more profitable to you.
OILING THE MACHINE

Oil your machine! For best results, use SINGER® TYPE "A" or "C" Oil. TYPE "C" Oil is used when an oil is desired which will produce minimum staining of fabrics even after a long period of storage.

Tip machine back on its hinges and fill the oil reservoir as illustrated in Fig. 2.

When a machine is NEW or has been idle for several weeks, it is advisable to oil the needle bar, take-up bearings, and all other parts which are in movable contact. The automatic lubricating system will function efficiently after running the machine at 2500 to 3000 revolutions per minute for 10 to 15 minutes and continue to lubricate all bearings.

CAUTION: Correct lubrication is indicated by a continuous stream of oil passing the oil flow window while machine is running, as shown in Fig. 3.

Should this oil flow become erratic, STOP the machine and check the reservoir oil level. Fill if needed.

At least twice each month, check the oil level in the reservoir. Never allow the oil level to drop below LOW mark, shown in Fig. 2.
OILING THE PULLER FEED
591D303A

In addition to the automatic oil wicking system, it is recommended that a few drops of SINGER TYPE “C” oil be applied every two weeks to the location shown in Fig. 4.

NEEDLES

The needles you use have a very direct effect on the quality, strength and appearance of the stitching produced by your machine. This is why it is so important to use SINGER needles according to the following chart.

<table>
<thead>
<tr>
<th>CATALOG NO.</th>
<th>CLASS and VARIETY</th>
<th>SIZES</th>
</tr>
</thead>
<tbody>
<tr>
<td>1901</td>
<td>135 x 7</td>
<td>8, 9, 10, 11, 12, 13, 14, 16, 17, 18, 19, 20, 21, 22, 23 and 24</td>
</tr>
<tr>
<td>1955</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
Note:
Needles for 591D305A. Use catalog number 1515 and corresponding needle bar for the 1/16" and 3/32" trim margins.

A bent needle will cause your machine to skip stitches and drift away from a desired sewing direction.
A hook or burr on the needle point will result in a blurred finish and may cut the material.

THREAD
In the Class 591, use ONLY left twist thread in the needle. Either right or left twist thread can be used in the bobbin. To determine the thread twist, hold the thread as shown below. Then roll the thread held by the right hand over toward you — if the strands of the thread wind tighter, the thread is left twist; if the strands unwind or separate, the thread is right twist.

![Fig. 5](image)

From the library of: Superior Sewing Machine & Supply LLC
INSERTING THE NEEDLE

Turn the machine pulley over toward the operator until the needle bar moves to its highest point.

After loosening the needle clamping screw, insert needle UP into needle bar AS FAR AS IT WILL GO, as instructed in Fig. 6.

The long groove of the needle MUST face the left end of the machine, as shown in Fig. 6.

Securely tighten the needle clamping screw.

THREADING THE MACHINE

First, turn machine pulley over toward you until needle is at its highest point, then pass the needle thread from the thread stand through the threading points in the order shown in Fig. 7, with the exception of 591C200A and 591C-300A machines.

For threading the 591C200A and 591C300A machines, see Fig. 8.

Draw about two inches of thread through the eye of needle with which to start sewing.
REMOVING THE BOBBIN CASE AND BOBBIN

Turn machine pulley over toward you until the thread take-up lever is at its highest point.

Open slide plate and reach under the bed of the machine with left hand and remove the bobbin case as shown in Fig. 9.

Releasing the latch will allow bobbin removal as shown in Fig. 9.
Place bobbin on spindle A of bobbin winder pushing it on as far as it will go and pass thread from the thread stand through threading points as shown in Fig. 10.

Wind end of thread around the bobbin a few times. Press latch B against bobbin, pushing driving pulley over against machine pulley, then start the machine.

The bobbin winder will stop automatically when the amount of thread for which it is regulated is wound upon the bobbin. For more thread on bobbin, loosen screw C and swing latch B away from you: for less thread on bobbin, swing latch B toward you. Tighten screw C.

When winding a bobbin with fine thread, a light tension should be used. Adjust the knurled nut D, Fig. 10, to regulate the tension.

If thread winds unevenly on bobbin, loosen set screw holding pre-tension stud E and move tension bracket up or down, as required. Tighten the set screw.

Bobbins can be wound while the machine is stitching.

Note: It is recommended that winding of bobbin be held to approximately 80% of its winding capacity. Also, do not use too much tension on the thread when winding since too tight thread tension may cause deformation of the bobbin and result in damaging the needle.
THREEDING THE BOBBIN CASE

Hold the bobbin so that thread will unwind in the direction shown in Fig. 11.

Hold the bobbin case as shown in Fig. 11 and place the bobbin into it and thread as shown in Fig. 12.

REPLACING THE BOBBIN CASE

After threading, take bobbin case by latch in left hand and place bobbin case on center stud of bobbin case holder, as shown in Fig. 13 and release latch. Press bobbin case firmly into place. Allow about two inches of thread to hang free.
PREPARING TO SEW

Hold end of needle thread with left hand very lightly. Then turn the machine pulley over toward you slowly until the needle moves down and up. Pull on the needle thread and the bobbin thread will come up through the hole in the throat plate as shown in Fig. 14. Place both threads under the presser foot prior to sewing.

SEWING

Place the material under the presser foot and lower the presser foot. You are now ready to sew — quickly, smoothly and easily.

Stop the machine when the needle bar has just started to come down for best material removal. Raise the presser foot, draw the work behind the presser foot and cut the threads close to the work.
SETTING THREAD TENSIONS

Normally, tension on the needle and bobbin threads should be balanced so that if you were to look at a cross section of a line of stitching, the needle and bobbin threads would be locked in the center of the thickness of the material as shown in Fig. 15-A. Incorrect settings will produce the conditions as shown in Figs. 15-B and 15-C.

Regulate the needle thread tension as shown in Fig. 16. Be sure the presser foot is down when making tension adjustments.

Tension on the needle thread should be just enough to set the stitch properly in the material. See Fig. 15-A.

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

Should regulation of the tension on the bobbin thread be necessary, remove the bobbin case and adjust as shown in Fig. 17.
ADJUSTING THE TAKE-UP SPRING

The tension and the range of movement of the take-up spring A may require different settings depending upon the size of thread and material used. Heavier thread or material require more tension; delicate materials require less tension. Also the movement of take-up spring should be increased to ensure correct thread control.

Using a large screwdriver in slot of stud B, turn stud either over toward left to decrease tension, or over to right to increase tension, as shown in Fig. 18.

To set the take-up spring height, loosen screw C (Fig. 19) and turn entire tension assembly either over toward left to lower take-up spring and decrease its movement, or over toward right to raise take-up spring and increase its movement. Securely tighten screw C.

ADJUSTING THE THREAD GUARD

To obtain perfectly locked stitches depending upon the thickness of material or the length of stitch, it may be necessary to adjust the thread guard D either to the left or to the right, as shown in Fig. 19.

* For heavy material or long stitches, move thread guard to the right.
* For lightweight material or short stitches, move thread guard to the left.
ADJUSTING PRESSER FOOT PRESSURE

Correct presser foot pressure helps feed the work properly.

The pressure on the material should be as light as possible, while still sufficient to insure proper feeding.

Adjust the pressure as shown in Fig. 20 and tighten nut firmly.

ADJUSTING STITCH LENGTH

The stitch length regulating dial A controls the number of stitches per inch. The numbers on the dial represent the number of stitches per inch. To regulate the length of stitch, turn dial A as shown in Fig. 21.

To change the direction of feed for back tacking, depress feed reverse lever B quickly to lowest position until back tack is completed.
ADJUSTING THE AMOUNT OF FEED OF THE FEED ROLLER 591D303A

Adjust the machine to the desired stitch length, then set the adjustable crank A on the puller feed device to a matching stitch length or slightly larger if required by the application. (Fig. 22).

ADJUSTING THE PRESSURE OF THE FEED ROLLER 591D303A

Pressure of the feed roller should be as light as possible, while still sufficient to insure proper feeding.

Adjust the pressure by turning the feed roller pressure spring adjusting seat A as shown in Fig. 23.
The trimmer knife can be disengaged for sewing operations which do not necessitate edge trimming.

To disengage, push pivot pin A in the direction shown in Fig. 24 until the knife mounting block B is held immovable by the disengagement spring C.

**HINTS FOR PERFECT OPERATION**

* Keep the oil level in the oil reservoir at the HIGH mark.
* When turning the machine pulley, always turn it over toward you.
* Always keep the bed slide closed when the machine is in operation.
* Clean out any lint or other waste around the hook and between the feed rows on the underside of the throat plate.
* Don’t try to “help” the machine by pulling the fabric.
* Don’t press the knee lifter while the machine is running.
* Don’t run the machine when threaded unless there is material under the presser foot.
## SPECIFICATIONS

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<tr>
<th>Machine</th>
<th>591D</th>
<th>591C</th>
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<tr>
<td></td>
<td>200A</td>
<td>240A</td>
</tr>
<tr>
<td>Type of Feed</td>
<td>Drop Feed</td>
<td>Compound Feed</td>
</tr>
<tr>
<td>Equipped with</td>
<td>Low Inertia Presser Foot</td>
<td>Puller Feed</td>
</tr>
<tr>
<td>For Sewing</td>
<td>Light to Medium</td>
<td>Medium to Medium Heavy</td>
</tr>
<tr>
<td>Needle Bar Stroke</td>
<td>30,5 mm (1.20&quot;)</td>
<td>36,5 mm (1.44&quot;)</td>
</tr>
<tr>
<td>Max. Speed*</td>
<td>5,500 SPM</td>
<td>5,000 SPM</td>
</tr>
<tr>
<td>Max. Stitch Length**</td>
<td>4.2 mm (6 SPI)</td>
<td>5.1 mm (5 SPI)</td>
</tr>
<tr>
<td>Presser Bar Lift (By Hand)</td>
<td>7.2 mm (0.28&quot;)</td>
<td>6.7 mm (0.26&quot;)</td>
</tr>
<tr>
<td>Presser Bar Lift (By Knee)</td>
<td>12.7 mm (0.50&quot;)</td>
<td>12.2 mm (0.48&quot;)</td>
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Note: *The machine should be operated at a speed slower than the maximum recommended speed depending on the material being sewn and the type of work being done.

**Depending on fittings being used.
The Same!

To get replacements that are the same as parts in new machines . . . .

BUY PARTS AND NEEDLES MADE BY SINGER

TO BE DOUBLY SURE . . . .

of new machine performance, make sure that all replacement parts and needles are precisely identical to those in new SINGER machines.

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SINGER

1. on every package or container
2. on the needle or numbered part

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