

**SINGER**  
**885-6 & 885-16**

CP

THE SINGER COMPANY

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885-6

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HEEL SEAMER AND UNDERTAPER

885-6 & 885-16

INDUSTRIAL PRODUCTS DIVISION

\* \* \*

MECHANIZED SYSTEMS DEPARTMENT

CLIFTON LABORATORY

CLIFTON, N.J.

1000-14

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THE SINGER 885-6

HEEL SEAMER AND UNDERTAPER

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

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

Unpack each unit and inspect for damage during shipment.

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

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

Mount the tape reel on table.

Mount stainless steel workplate and front plate to front machine.

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

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

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

HEEL SEAMER AND UNDERLAPPER

Thread Breakage Indicator Switches

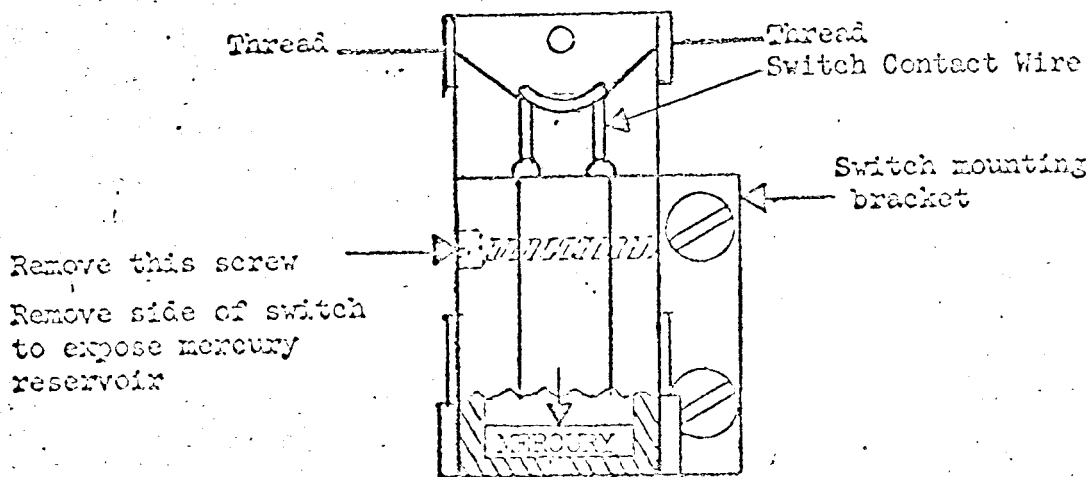
The mercury contact has been removed from the switches located on the rear machine for shipping purposes. The mercury and a dropper are packed with the accessories.

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

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

Fill the mercury reservoir in each switch to an approximate height of 1/8 Inch or 3.1 Millimeters.

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



Final Machine Preparation

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

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

Thread both machines.

Connect the power cord to the main supply line.

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

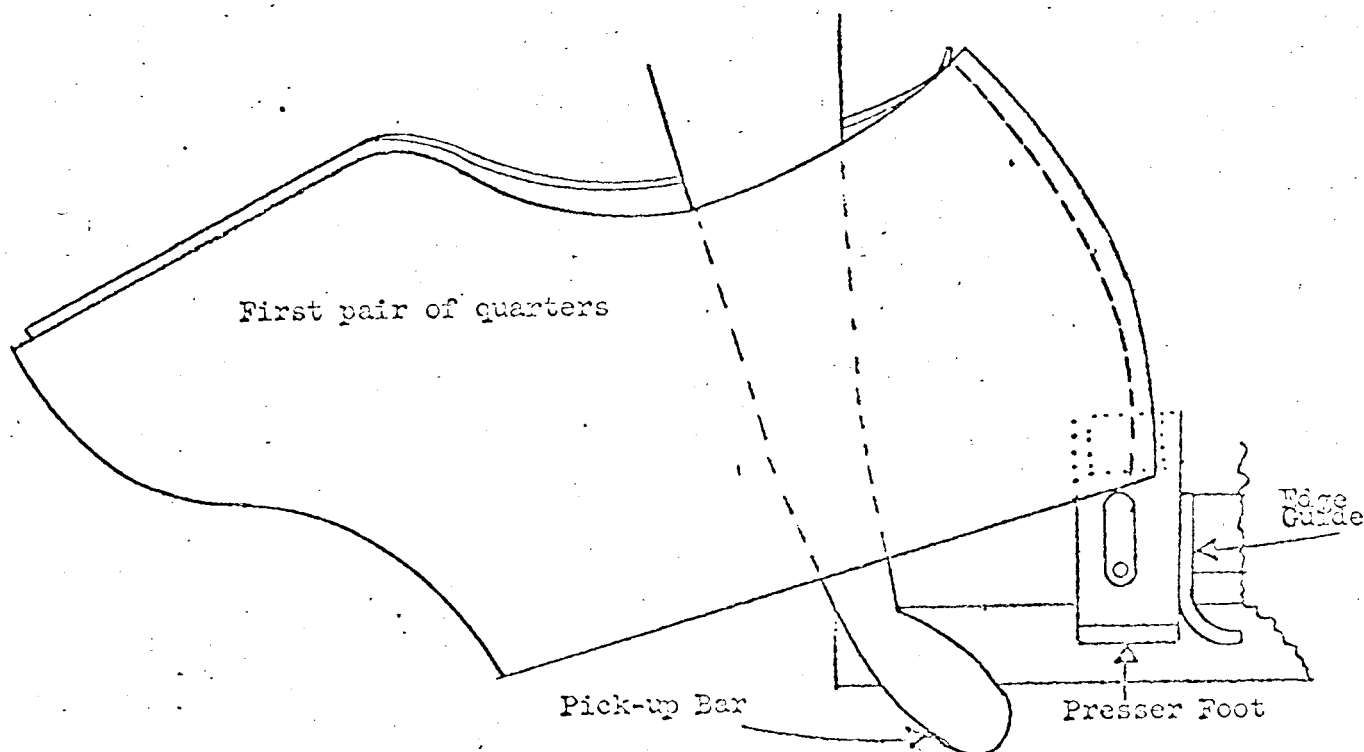
After threading the machines and obtaining the proper rotation, they are ready to operate.

THE SINGER 385-6HEEL SEAMER AND UNDERTAPERStarting the Operation

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

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

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



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

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

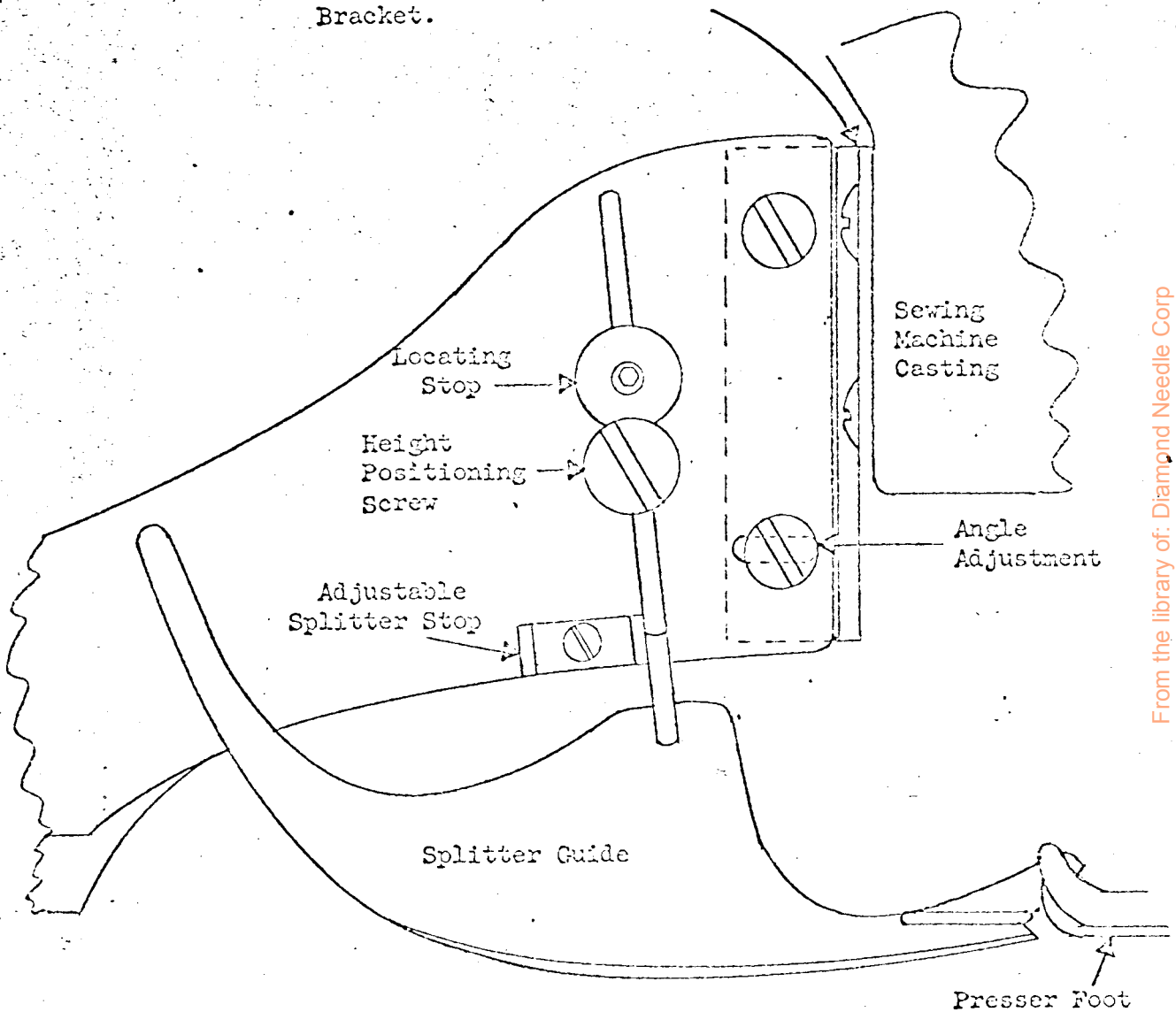
It may be necessary to assist the splitting attachment with the first pair of quarters. After the first pair, however, the splitting attachment will continue to feed the quarters to the rear machine.

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

THE SINGER 235-6

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

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

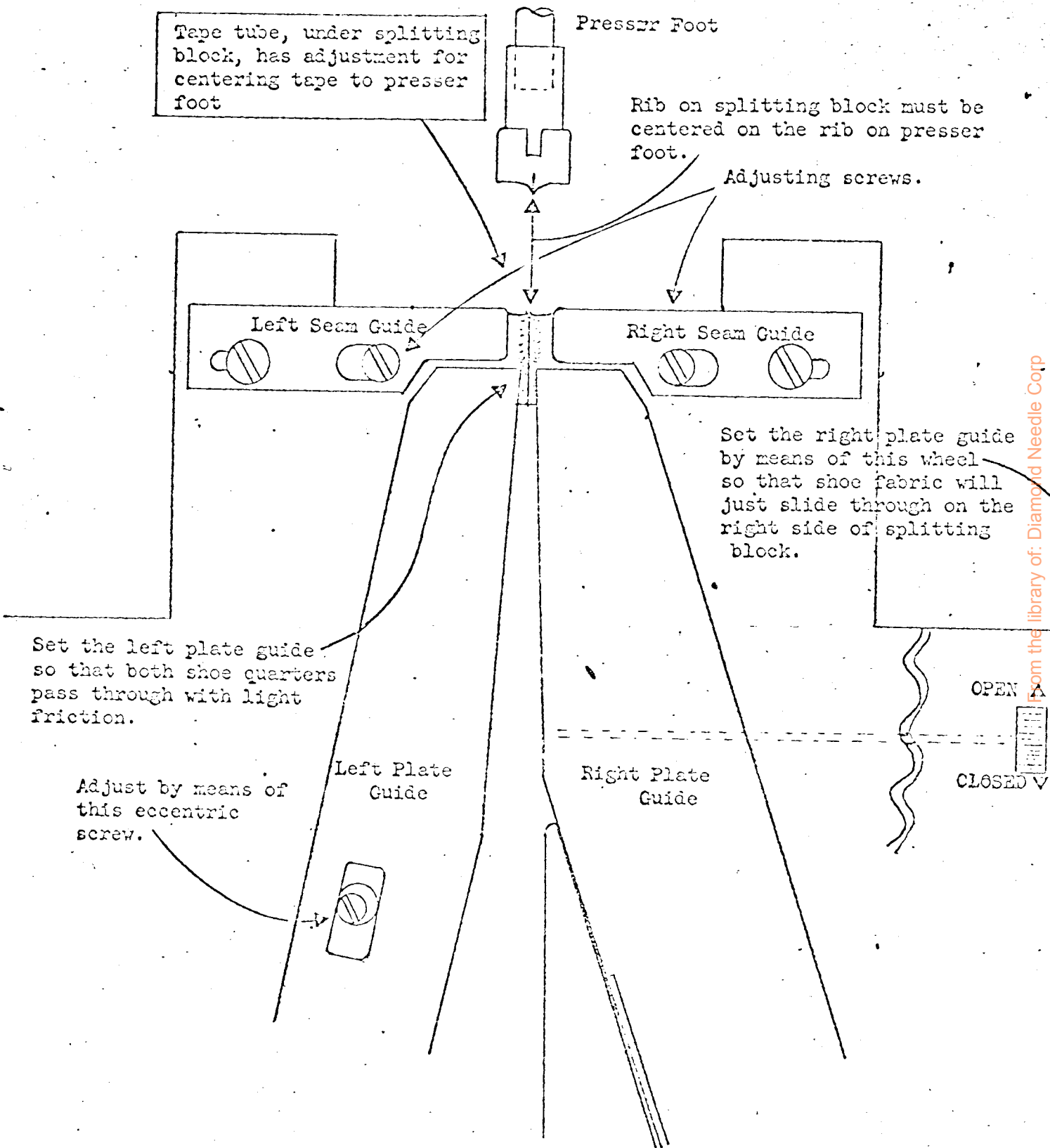


Threading Loopers on Rear Machine

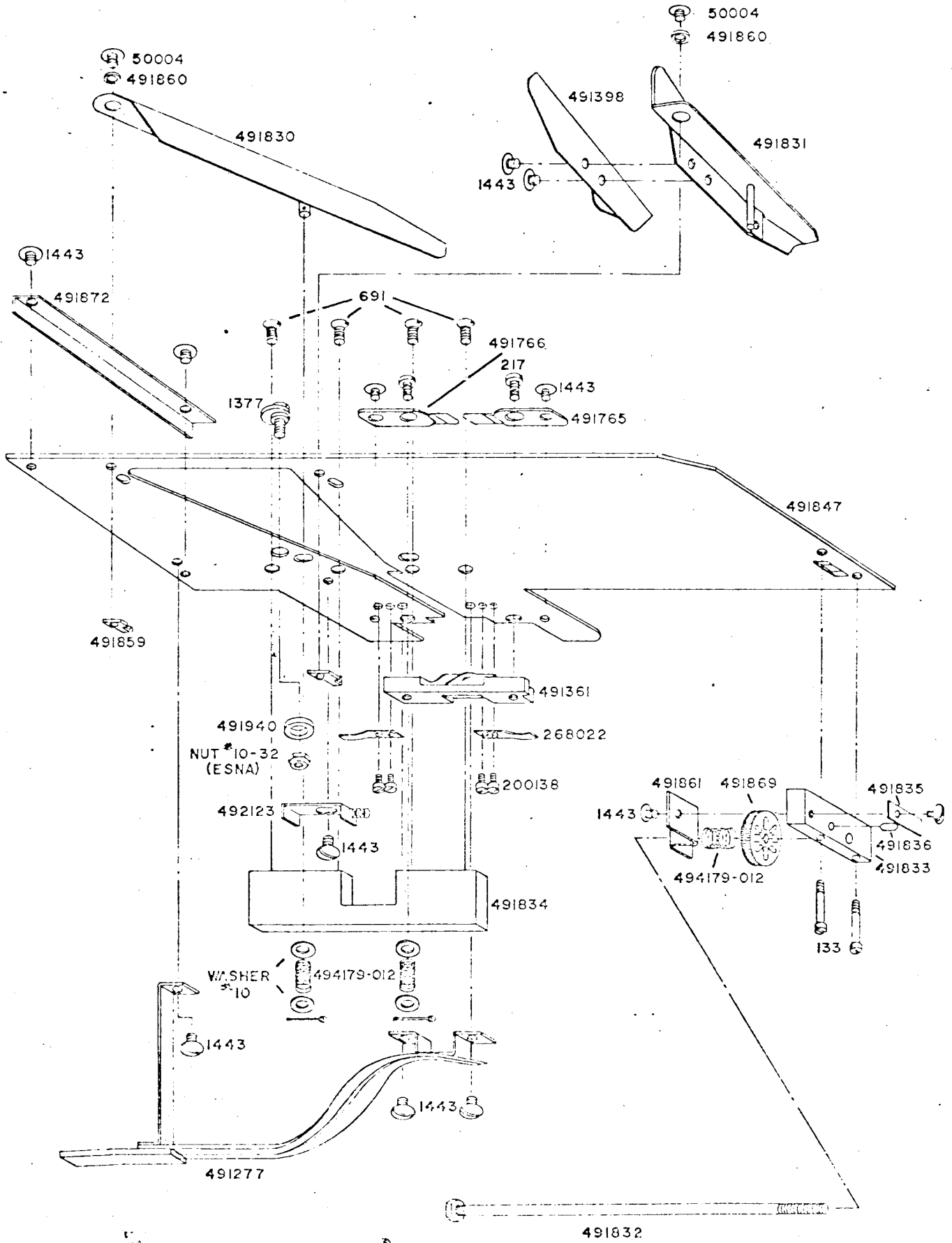
Loosen Height Positioning Screw. Move Splitter Guide up and  
away from presser foot. Remove complete Splitter Guide Assembly.  
from bed of machine. Remove slide plate to expose loopers.

HEEL SEAMER AND UNDERTAPER

Splitter Guide Assembly (Lower)



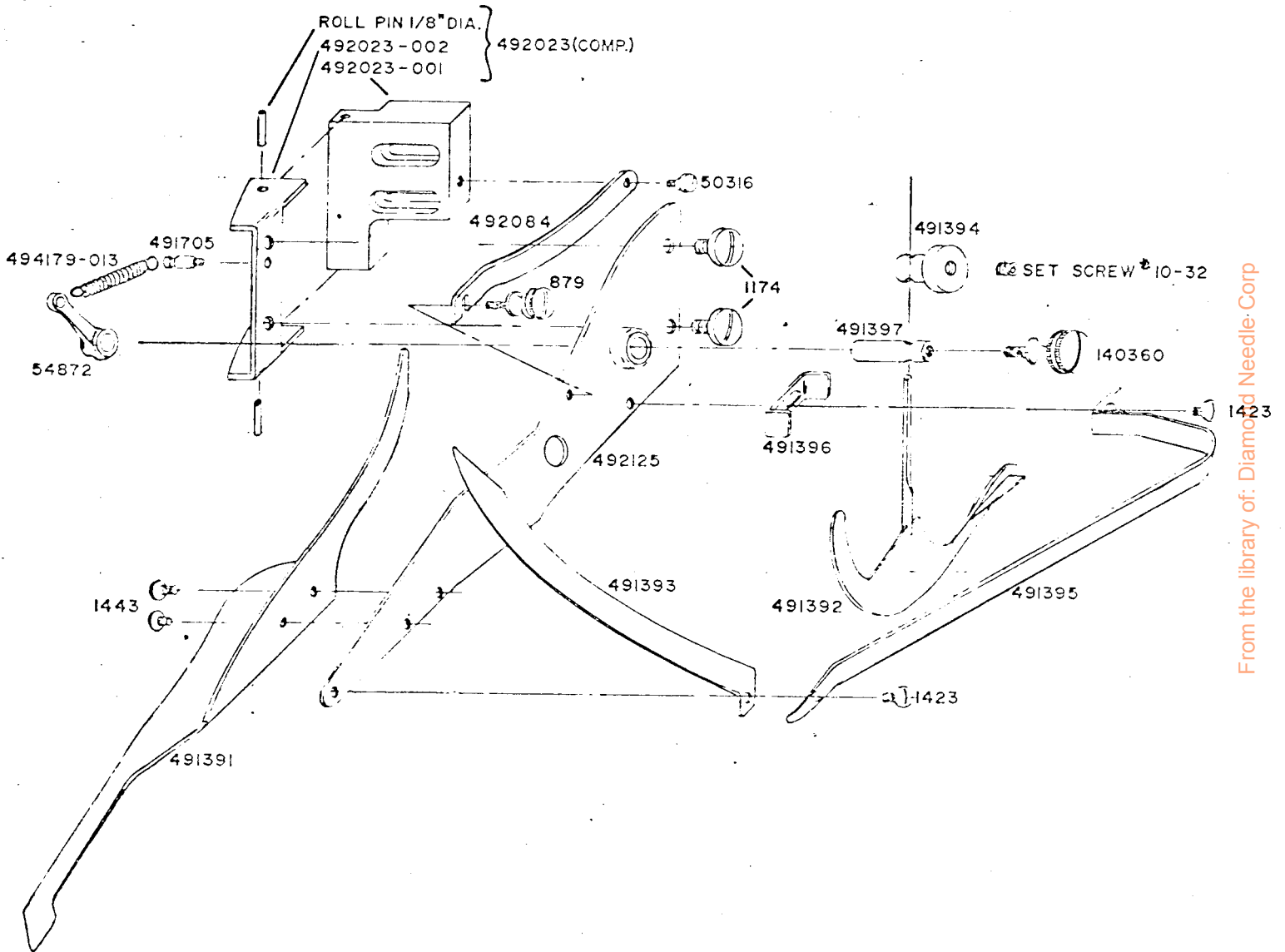
SPLIT SEAM REAR SPLITTER ASSEMBLY  
491270 (COMP.)



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SPLIT SEAM REAR UPPER ASSEMBLY  
491722 (COMP.)



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HEEL SEAMER AND UNDERTAPER

- 491270 - Split Seam Rear Splitter Assembly (Comp.)
- 133 - Screw (2)
  - 217 - Screw (2)
  - 691 - Screw (4)
  - 1377 - Screw (1)
  - 1443 - Screw (12)
  - 50004 - Screw (2)
  - 200138 - Screw (4)
  - 268022 - Slide Spring (2)
  - 491277 - Tape Tube
  - 491361 - Splitting Block
  - 491398 - Seam Control Guide
  - 491765 - Right Seam Guide
  - 491766 - Left Seam Guide
  - 491830 - Left Plate Guide
  - 491831 - Right Plate Guide
  - 491832 - Right Plate Guide Adjusting Bar
  - 491833 - Right Plate Guide Adjusting Bar Holding Block
  - 491834 - Bridge Slide Plate Brace
  - 491835 - Ratchet Spring
  - 491836 - Ratchet Pin
  - 491847 - Bridge Slide Plate
  - 491859 - Guide Plate Adjusting Nut (2)
  - 491860 - Guide Plate Bushing (2)
  - 491861 - Bracket
  - 491869 - Right Plate Guide Adjusting Bar Wheel
  - 491872 - Bridge Slide Plate Trim Angle

THE SINGER 585-6HEEL SEAMER AND UNDERTAPER

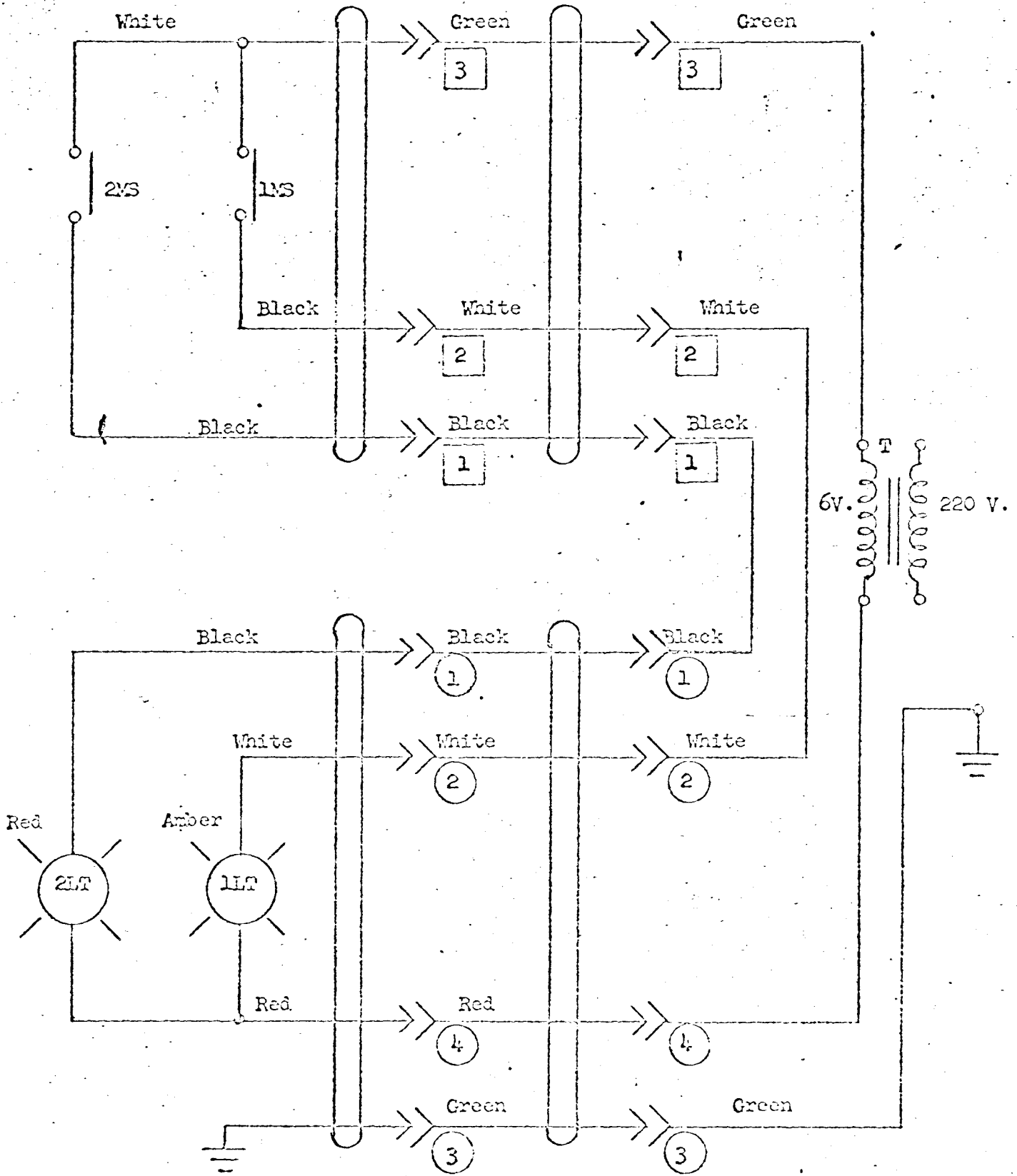
491940 - Guide Plate Adjusting Nut Screw Bushing  
492123 - Left Plate Guide Tension Spring  
494179-012 - Spring (3)  
#10-32 - Lock Nut (Esna)  
#10 - Flat Washer (4)  
491722 - Split Seam Rear Upper Assembly (Comp.)  
879 - Screw, Thumb (1)  
1174 - Screw (2)  
1423 - Screw (2)  
1443 - Screw (2)  
50316 - Screw, Shoulder (1)  
54872 - Splitter Guide Spring Arm  
140360 - Screw, Thumb (1)  
491391 - Pick-up Bar  
491392 - Splitter Guide  
491393 - Left Arm Guide  
491394 - Splitter Guide Locating Stop  
491395 - Right Arm Guide  
491396 - Splitter Stop (Adjustable)  
491397 - Splitter Guide Spring Arm Shaft  
491705 - Spring Post  
492033 - Hinge Assembly (Comp.)  
492034 - Hinge Latch  
492125 - Splitter Arm Guide, Upper  
494179-013 - Spring  
#10-32 - Set Screw

HEEL SEAMER AND UNDERTAPER

Miscellaneous Parts

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

Schematic: Thread Breakage Indicator.



- 4 Prong Connector
- 5 Prong Connector

Red light indicates needle thread  
 Amber light indicates looper thread