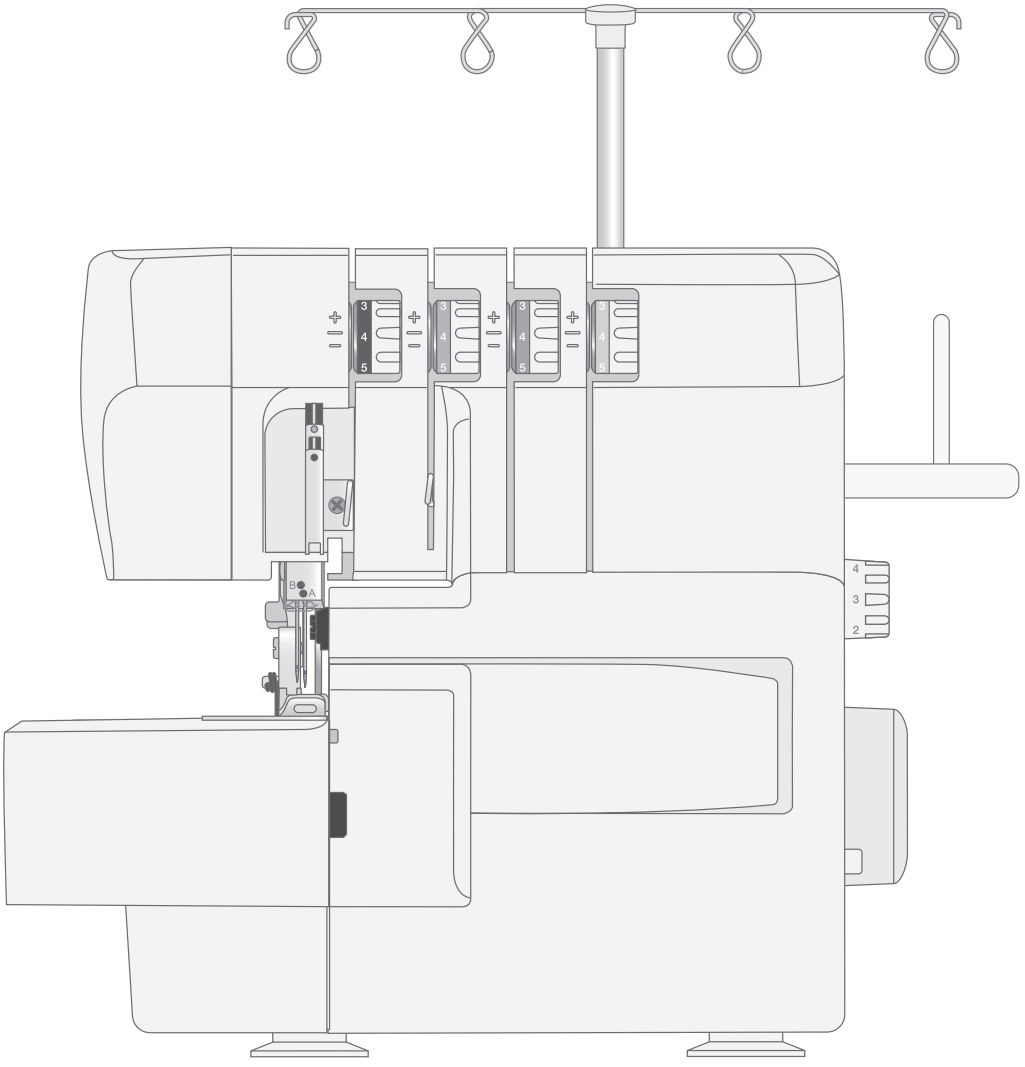
INSTRUCTION MANUAL

HD0420/HD0425



SINGER®

For Household Sewing Machines and Overlock Machines

IMPORTANT SAFETY INSTRUCTIONS

Read all instructions before using this sewing machine.

When using an electrical appliance, basic safety precautions should always be followed, including the following:

Keep the instructions at a suitable place close to the machine. Make sure to hand them over if the machine is given to a third party.

This appliance is intended for use by adults. The appliance can be used with adult supervision by (i) children aged from 8 to 12 years and (ii) persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge if they have been given instruction concerning use of the appliance in a safe way and understand the hazards involved. Cleaning and user maintenance shall not be made by children without supervision. It is not allowed for anyone to play with the machine. Children up to 8 years are not allowed to use the machine.

DANGER - TO REDUCE THE RISK OF ELECTRIC SHOCK:

- A sewing machine should never be left unattended when plugged in. The electrical socket, to which the machine is plugged in should be easily accessible. Always unplug this sewing machine from the electric outlet immediately after using and before cleaning, removing covers, lubricating or when making any other user servicing adjustments mentioned in the instruction manual.

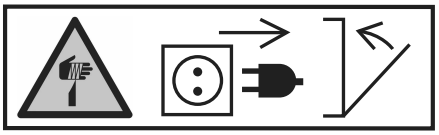
WARNING –TO REDUCE THE RISK OF BURNS, FIRE, ELECTRIC SHOCK, OR INJURY TO PERSON:

- Do not allow to be used as a toy. Close attention is necessary when this sewing machine is used by or near children.
- Use this sewing machine only for its intended use as described in this manual. Use only attachments recommended by the manufacturer as contained in this manual.
- Never operate this sewing machine if it has a damaged cord or plug, if it is not working properly, if it has been dropped or damaged, or dropped into water. Return the sewing machine to the nearest authorized dealer or service center for examination, repair, electrical or mechanical adjustment.
- Never operate the sewing machine with any air openings blocked. Keep ventilation openings of the sewing machine and foot control free from the accumulation of lint, dust, and loose cloth.
- Keep fingers away from all moving parts. Special care is required around the sewing machine needle.
- Always use the proper needle plate. The wrong plate can cause the needle to break.
- Do not use bent needles.
- Do not pull or push fabric while stitching. It may deflect the needle causing it to break.
- Wear safety glasses.
- Switch the sewing machine off (“0”) when making any adjustment in the needle area, such as threading needle, changing needle, threading bobbin, or changing presser foot, etc.
- Never drop or insert any object into any opening.
- Do not use outdoors.
- Do not operate where aerosol (spray) products are being used or where oxygen is being administrated.
- To disconnect, turn all controls to the off (“0”) position, then remove plug from outlet.
- Do not unplug by pulling on cord. To unplug, grasp the plug, not the cord.
- The foot control is used to operate the machine. Never place other objects on the foot control.
- Do not use the machine if it is wet.
- If the LED lamp is damaged or broken, it must be replaced by the manufacturer or its service agent or a similarly qualified person, in order to avoid a hazard.
- If the cord connected with the foot control is damaged, it must be replaced by the manufacturer or its service agent or a similarly qualified person, in order to avoid a hazard.
- Only use the external power supply (if applicable), the foot controller and cords supplied with your machine. No other can be used. If damaged or lost, make sure to replace with identical parts. Replacement should be carried out by the manufacturer, its service agent or a similarly qualified person, to ensure safety and avoid a hazard.

For Overlock Machines only:

- Never operate without a cutter cover or a securely installed coverstitch table.

- **CAUTION** — Your machine has moving parts, to reduce the risk of injury, switch off before doing service or maintenance. Close the cover before operating the machine.



SAVE THESE INSTRUCTIONS

Federal Communication Commission Interference Statement

For the USA and Canada

Responsible party:	Singer Sourcing Limited LLC 300 2nd Ave. S, Suite 300, Nashville, TN 37201, USA
Product name:	SINGER® Heavy Duty 0420™/0425™ household sewing machine

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions: (1) This device may not cause harmful interference, and (2) this device must accept any interference received, including interference that may cause undesired operation.

To satisfy radio frequency exposure requirements, a separation distance of 8" (20 cm) or more should be maintained between this device and persons during device operation. To ensure compliance, operations at closer than this distance is not recommended. The built-in antenna used for this transmitter must not be co-located in conjunction with any other antenna or transmitter.

This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates, uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment into an outlet on a circuit different from that to which the receiver is connected.
- Consult the authorized SINGER® retailer or an experienced radio/TV technician for help.

The included interface cable should be used in order to ensure compliance with the limits for a Class B digital device.

⚠ *Any changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate this equipment.*

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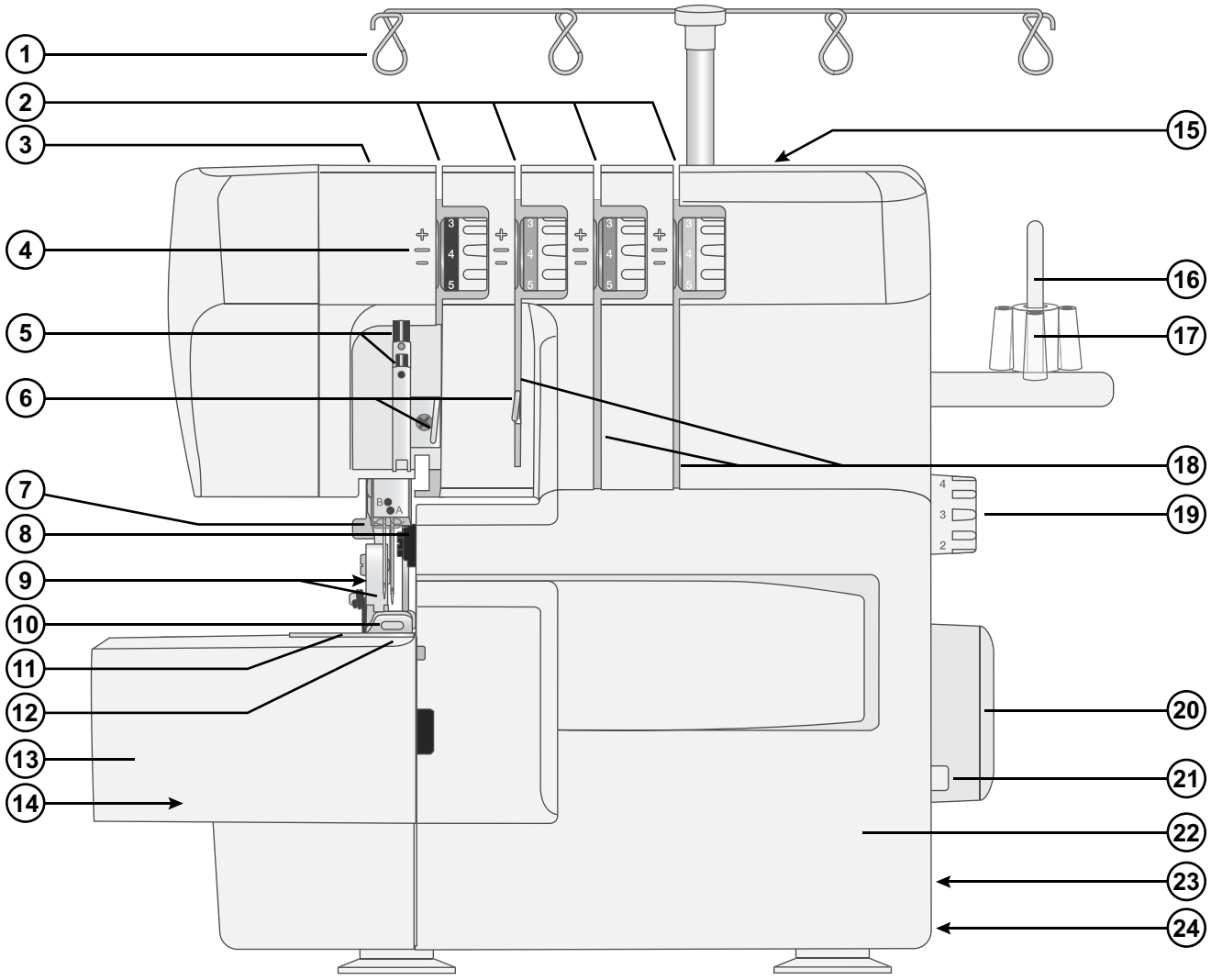
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INTRODUCTION

Machine Overview

Front of Machine

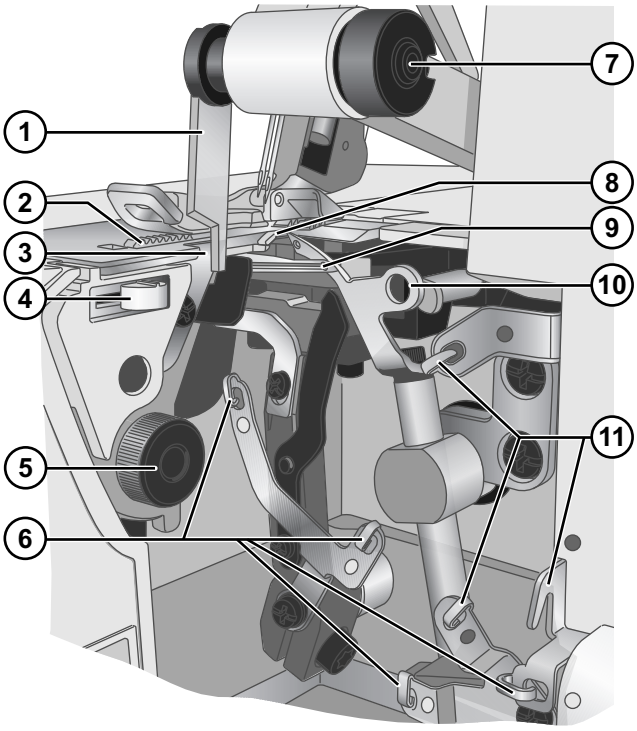


1. Telescopic thread stand
2. Pretension thread guides
3. Presser foot pressure adjustment dial
4. Thread tension adjustment dials

   Left needle thread tension — orange
   Right needle thread tension — blue
   Lower looper tension — green
   Upper looper tension — red
5. Threading paths (needle threads)
6. Thread guides (needle threads)
7. Presser foot lifter
8. Upper cutter position knob (found behind the front cover)
9. Presser foot release button and presser foot ankle
10. Presser foot
11. Needle plate
12. Cutting width indicator
13. Flat bed extension
14. Free arm (found when the flat bed extension is removed)
15. Handle
16. Spool stand and spool pins
17. Cone holders
18. Threading slots
19. Stitch length dial
20. Handwheel
21. Differential feed lever
22. Front cover
23. Power switch
24. Foot control and power cord socket

Looper Area

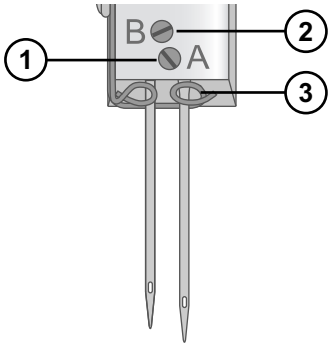
1. Upper cutter
2. Feed teeth
3. Stationary cutter
4. Stitch finger lever
5. Cutting width dial
6. Lower looper thread guides (green markings)
7. Upper cutter position knob
8. Stitch finger
9. Lower looper
10. Upper looper
11. Upper looper thread guides (red markings)



Needle Area

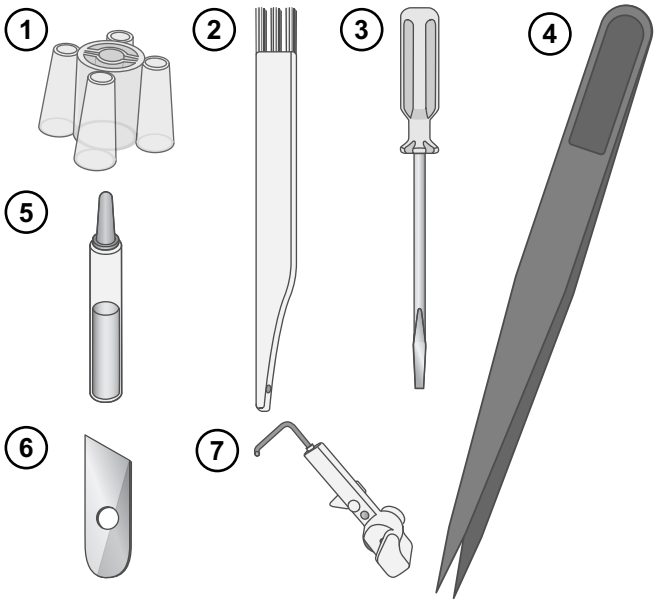
1. Right needle screw
2. Left needle screw
3. Needle thread guides

Note: When using two needles, the left needle is positioned a little higher up than the right needle (they are not supposed to be level).



Accessories

1. Cone holders x 4
2. Brush
3. Screw driver
4. Tweezers
5. Oil
6. Knife blade for stationary cutter
7. Upper looper converter
8. Needle pack (not pictured)
9. Foot control (not pictured)
10. Soft dust cover (not pictured)
11. Thread stand and thread stand attachment screw (not pictured)



PREPARATION

Unpack the Machine

After lifting the machine out of the box and removing all packing material, wipe the machine, particularly around the needle and needle plate to remove any oil before sewing.

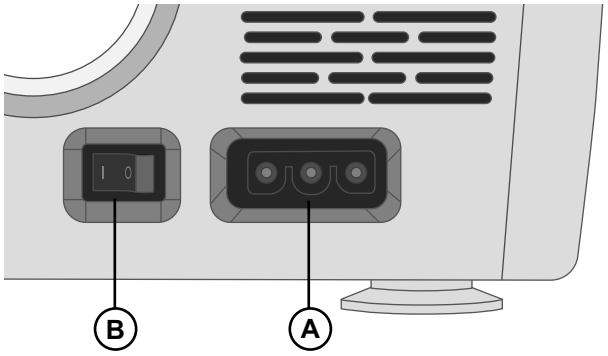
Note: Your Heavy Duty 0420™/0425™ machine is adjusted to provide the best stitch result at normal room temperature. Extreme hot and cold temperatures can affect the sewn results.

Connect the Foot Control and the Power Supply

Among the accessories you will find the foot control/ power cord.

Note: Consult a qualified electrician if you are in doubt about how to connect the machine to the power source. Unplug the power cord when the machine is not in use.

Note: Before plugging in the foot control, check to ensure that it is type "HKT7/HKT72C/HKT7-2" (see underside of foot control).



Before plugging your machine in, make sure the voltage is the same as indicated on the plate under the machine. Specifications vary from country to country.

- Connect the power cord to the rear socket on the bottom right side of the machine (A). Plug the cord into the wall socket.
- Press the ON/OFF switch (B) to "I" to turn on power and light.

Press the foot control to start sewing. Use the foot control to adjust the sewing speed. The harder you press, the faster the machine will sew. To stop the machine from sewing, remove your foot from the control.

Push the power switch to "O" to turn off the machine.

Note: When the front cover is open the safety switch is activated and prevents the machine from sewing, even if the foot control is pressed.

Telescopic Thread Stand

Mount the Thread Stand

When delivered, the thread stand is not mounted on the machine, but found separately in the box. To mount the thread stand, follow the below instruction.

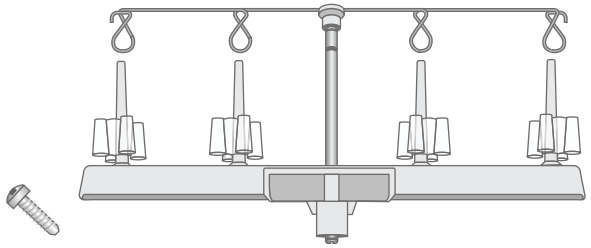
Place the machine with the back side towards you.

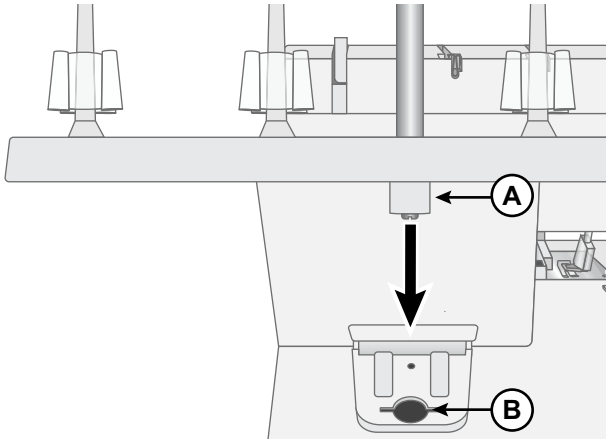
Insert the knob of the thread stand (A) into the slot (B) at the back of the machine.

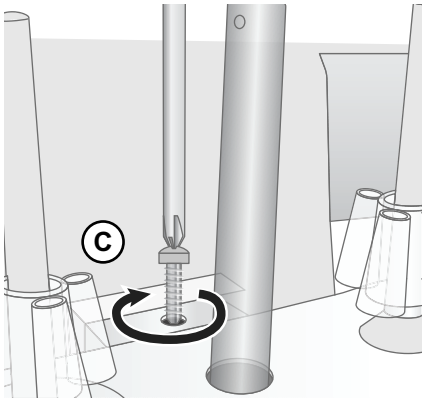
Insert the thread stand screw in the hole on the spool stand (C) and tighten.

Extend the telescopic thread stand to its full height, then turn slightly until it clicks into place.

Place the thread spools or cones over the cone holders on the spool pin.







Open and Close the Front Cover

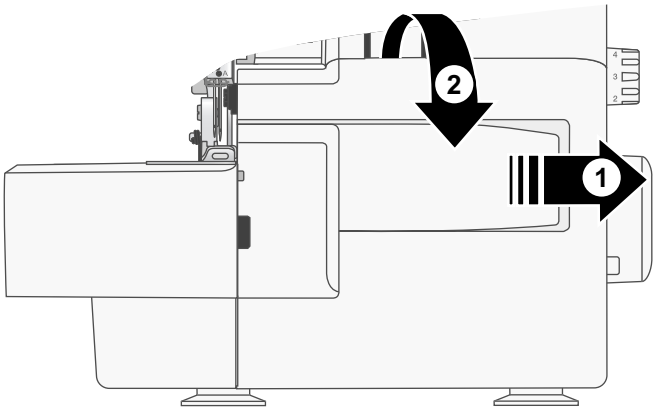
Open the Front Cover

First push the cover to the right as far as it will go (1) and then pull it downward toward you (2).

Close the Front Cover

First pull the cover upward and then slide it to the left until it locks.

Note: The front cover has a safety switch and the machine will not sew if the front cover is open.



Use the Free Arm / Remove the Flat Bed Extension

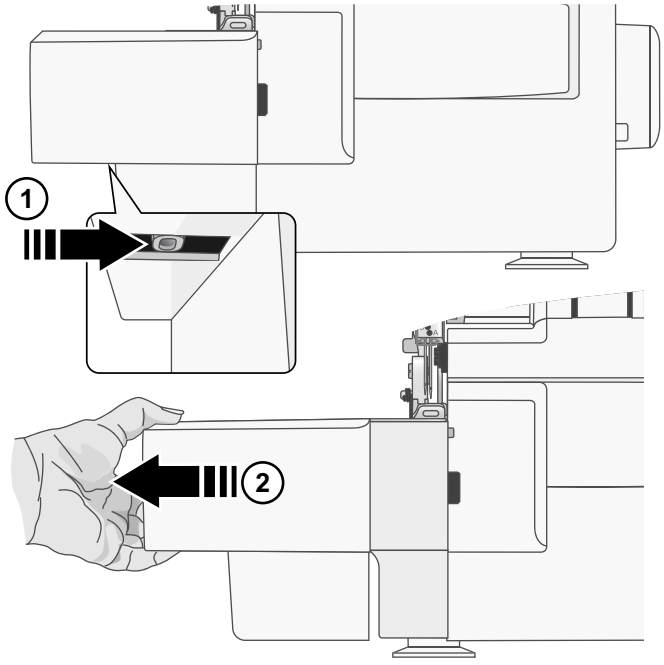
To use free arm, remove the flat bed extension. The free arm is convenient for sewing trousers legs and other small areas such as children's garments.

Remove the Flat Bed Extension

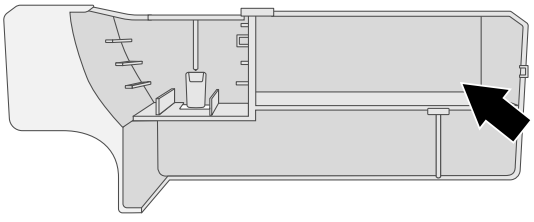
On the underside of the flat bed extension is a hook button that holds the flat bed extension in place. To remove the flat bed extension, push the hook button towards the machine (1). At the same time pull the extension to the left to remove it (2).

Attach the Flat Bed Extension

Place the flat bed extension around the free arm. Fit the projections of the flat bed extension with the corresponding grooves on the machine. Push the flat bed extension towards the machine to lock in place.

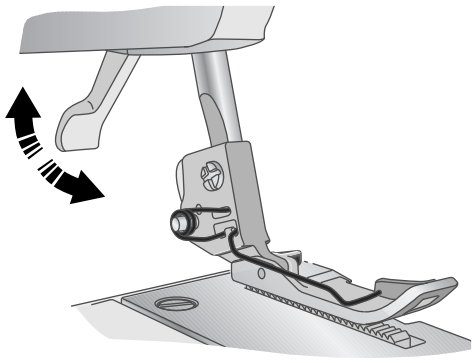


Inside the flat bed extension is a space that can be used to store accessories.



Presser Foot Lifter

Raise and lower the presser foot with the presser foot lifter positioned behind the presser foot.

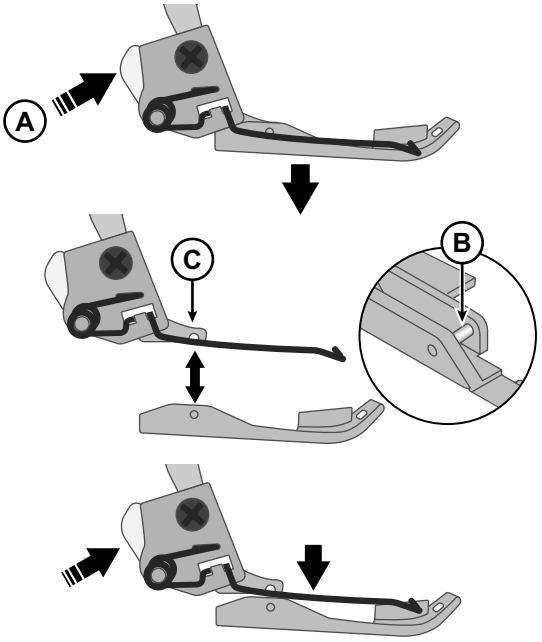


Change the Presser Foot

Turn off the main power switch and unplug the machine.

1. Raise the presser foot.
2. Turn the handwheel toward you until the needles are in the highest position.
3. Push the button on the back of the presser foot ankle (A), and the foot will come off.
4. Place the new foot with the pin (B) right underneath the groove of the ankle (C) and lower the presser foot. Push the button at the back of the presser foot ankle (A) and the foot will snap into place.

Note: Optional feet are not included.



Needle Information

This overlock uses a flat shank needle that eliminates the possibility of inserting the needle backwards.

Use SINGER® Overlock needles EL x 705 sizes 100/16, 90/14 and 80/12. A package of 90/14 needles are supplied with this machine.

Read more about when to use different needle sizes on page 10.

You can sew using one or two needles depending on what stitch to use.

Checking the Needles

To make sure the needle is not bent, place the flat side of the needle onto something flat (needle plate, glass etc.). The gap between the needle and the flat surface should be consistent. Never use a bent or blunt needle.

Change the Needles

⚠ *Turn off the main power switch and unplug the machine.*



Change the needle often. As a general rule, needles should be changed every 6-8 hours of actual stitching time.

1. Turn the handwheel toward you until the needles are at the highest position.

   Loosen, but do not remove the needle clamp screw (s) with the screwdriver while you are holding the needle(s).

   Remove the selected needle.

2. Hold the new needle with the flat surface to the back.

   Insert the needle into the needle clamp as far as it will go.

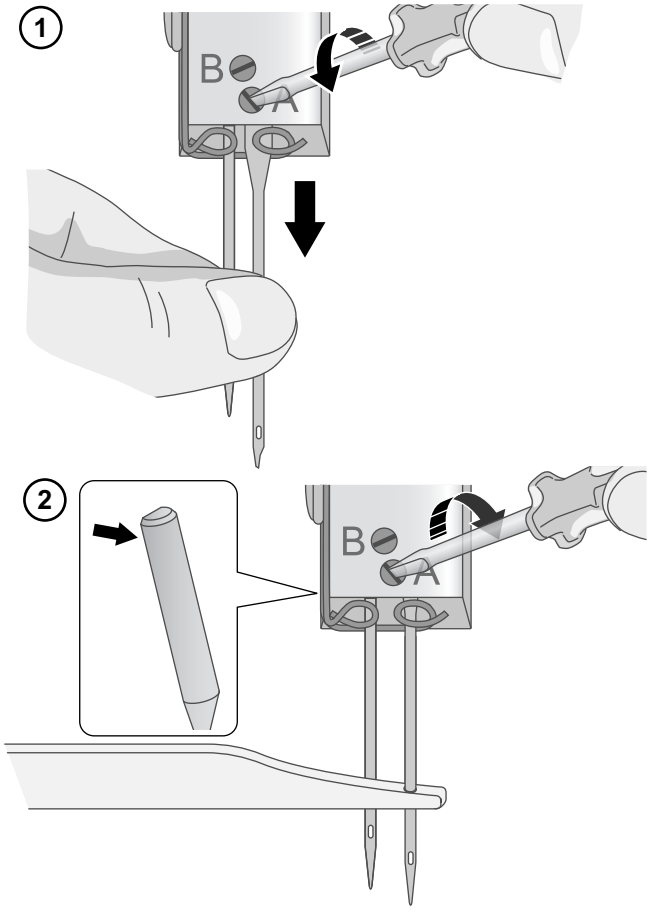
   Note: We recommend using the hole in the shaft of the brush to hold the needle.

   Securely tighten the needle clamp screw using the screwdriver.

Note: Do not over-tighten the screw as this may cause the needle clamp to be damaged.

Note: When using only one needle, slightly tighten the other needle clamp screw. This is to prevent losing the needle clamp screw.

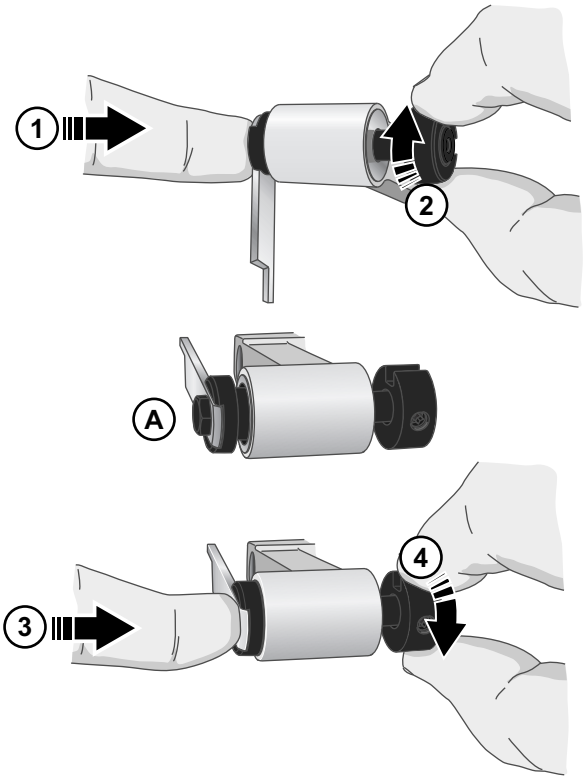
Note: When using both needles, the left needle is positioned a little higher up than the right needle (they are not supposed to be 'level', like a twin needle).



Upper Cutter Position

⚠ *Turn off the main power switch and unplug the machine.*

Note: Always have the upper cutter in the cutting position when sewing, because this machine must trim off any excess fabric to form the stitch over the fabric edge. An exception to this is when sewing decorative flatlock seams. Then the upper cutter needs to be disengaged.



Disengage the Upper Cutter

Turn the handwheel toward you until the upper cutter is raised to the highest position. Open the front cover.

1. Push the upper cutter holder to the right as far as it will go.
2. Turn the knob away from you until the cutter clicks into the disengaged horizontal position (A).

Note: If the cutter stops in the up position, turn the handwheel toward you until the cutter clears the top of the machine. Continue to rotate the cutter to the horizontal position.

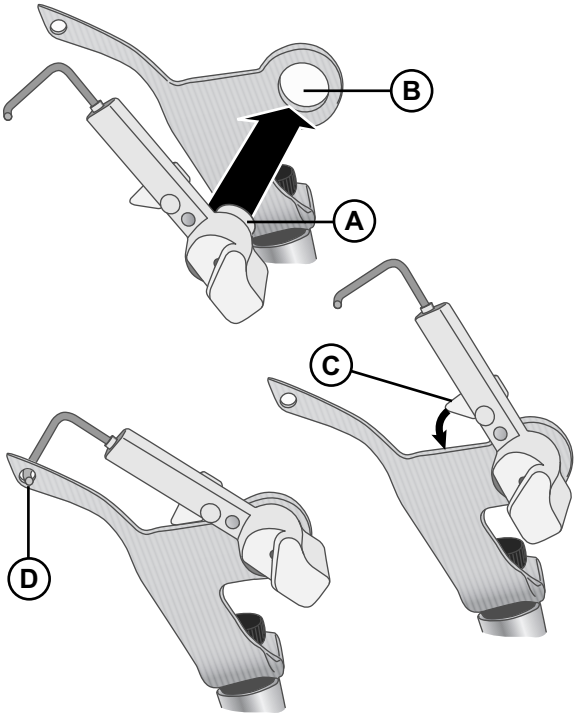
Engage the Upper Cutter

Turn the handwheel toward you until the upper cutter is raised to the highest position. Open the front cover.

3. To activate the upper cutter, press the knob to the right.
4. Turn the knob away from you, until the cutter clicks into the cutting position.

Upper Looper Converter

When sewing 2–thread stitches, only the lower looper is threaded. When attached, the upper looper converter catches the lower looper thread and guides it to the correct position in relation to the needle(s).



Attach the Upper Looper Converter

1. Open the front cover.
2. Bring the upper looper to its lowest position by turning the handwheel toward you.
3. Insert the pin (A) of the converter in the hole (B) of the upper looper.
4. Put the positioning rib (C) in contact with the upper edge of the looper.
5. Push the tip of the converter backwards carefully, and insert the pointed edge of the converter from behind into the eye (D) of the upper looper.

Remove the Upper Looper Converter

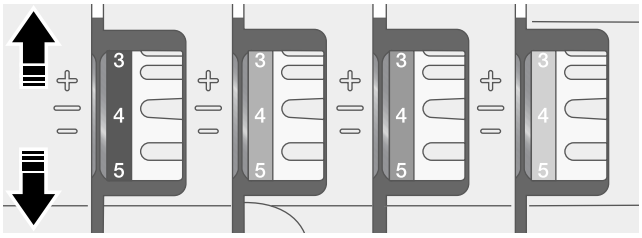
Carefully push the tip of the upper looper converter backwards and remove the pointed edge from the eye of the upper looper. Remove the converter by pulling it outwards.

Thread Tension Fine Tuning Dials

Thread tension recommendations are given for each stitch but it may have to be fine tuned depending on:

- Type and thickness of the fabric
- Size, type and fiber content of the thread

The tension can be adjusted individually for each thread. For best results, make tension adjustments in small increments. Move the tension dial towards "+" to increase the tension, and towards "-" to decrease the tension. Always test sew on a sample of your fabric before sewing on your project. Find more information on how to adjust thread tension on page 27.

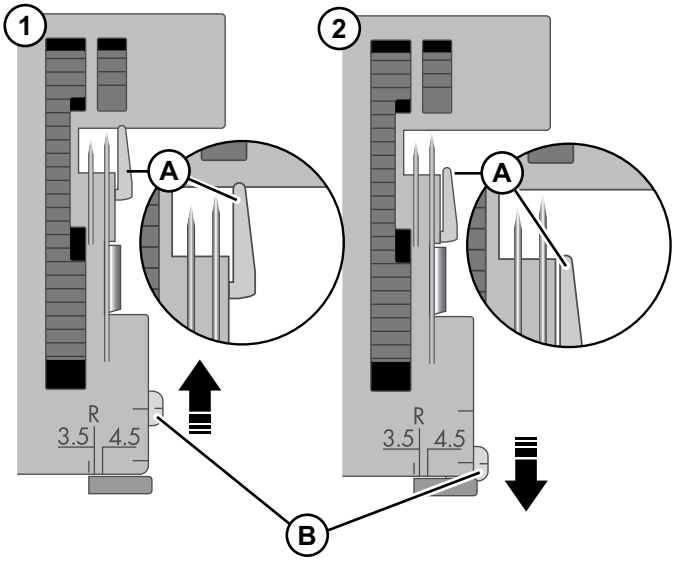


Stitch Finger

The stitch finger (A) is used to stabilize the fabric edge when forming stitches. The stitch finger should be active for all standard overlock sewing (1). The stitch finger is activated when the stitch finger lever (B) is set to "S".

To sew rolled edge you need to retract the stitch finger. To do that move the stitch finger lever (B) towards you, until it is set to "R" (2).

When moving the stitch finger lever, be sure to push the lever as far as it will go in each direction.



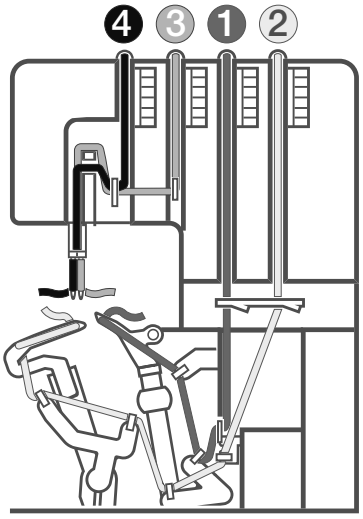
THREADING

General Threading Information

A color coded diagram is located inside the front cover for quick reference (see illustration to the right). Always start threading the loopers and then the needles from right to left (follow the order listed below).

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

Note: To make the threading easier, raise the presser foot and set the thread tension dials to zero. Then the thread tension discs release the tension and make the threading easier. Do not forget to adjust the tension according to recommendations given for each stitch before starting to sew. See Stitch Overview, page 16.



Important:

If the threads break during sewing, re-thread all thread paths in the order listed below.

1. Unthread the needle(s)

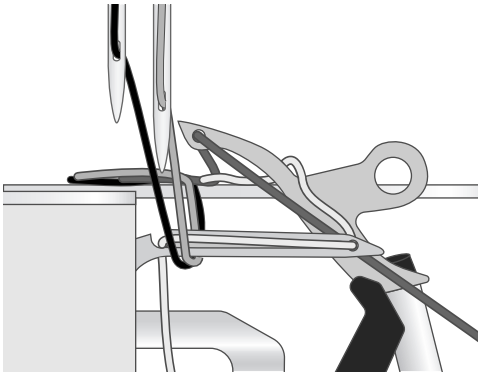
2. Unthread upper and lower looper

3. Thread the upper looper

4. Thread the lower looper

5. Thread the needle(s) from right to left

Note: The illustration to the right show how the threads run when the machine is correctly threaded and the handwheel is turned one full turn.



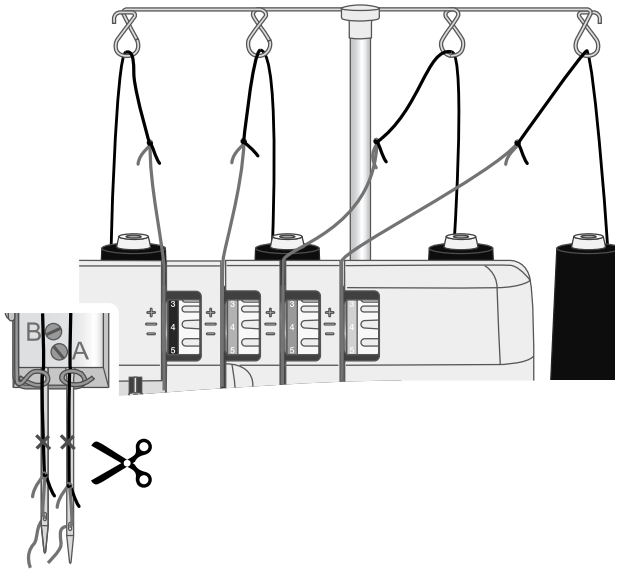
What Needle and Thread to Use with Different Fabrics

Light Fabric (voile, crepe, georgette, etc.)	*Medium Fabric* (cotton, chino, wool, satin, etc.)	*Heavy Fabric* (denim, jersey, tweed, etc.)
Needles size #12/80 needles, suitable for overlock machines (SINGER® Overlock needles #2022)	*Needles* size #14/90 needles, suitable for overlock machines (SINGER® Overlock needles #2022)	*Needles* size #16/100 needles, suitable for overlock machines (SINGER® Overlock needles #2022)
Thread Thread suitable for overlock machines		

Changing Thread

The following is an easy way to change threads:

1. Cut the thread near the spool, behind the guides on the telescopic thread stand.
2. Remove the thread spool and place the new thread on the spool pin.
3. Tie the end of the new thread to the end of the old thread. Cut the thread tails to 2-3 cm (approx. 1") in length and firmly pull both threads to test knot security.
4. Raise the presser foot, and set the thread tension dials to zero.
5. Pull the threads through the machine one at a time until the knots are in front of the needle. If the threads do not pull easily, check for tangles on thread guides or looping under thread stand.
6. Cut the thread behind the knot and thread the needle.

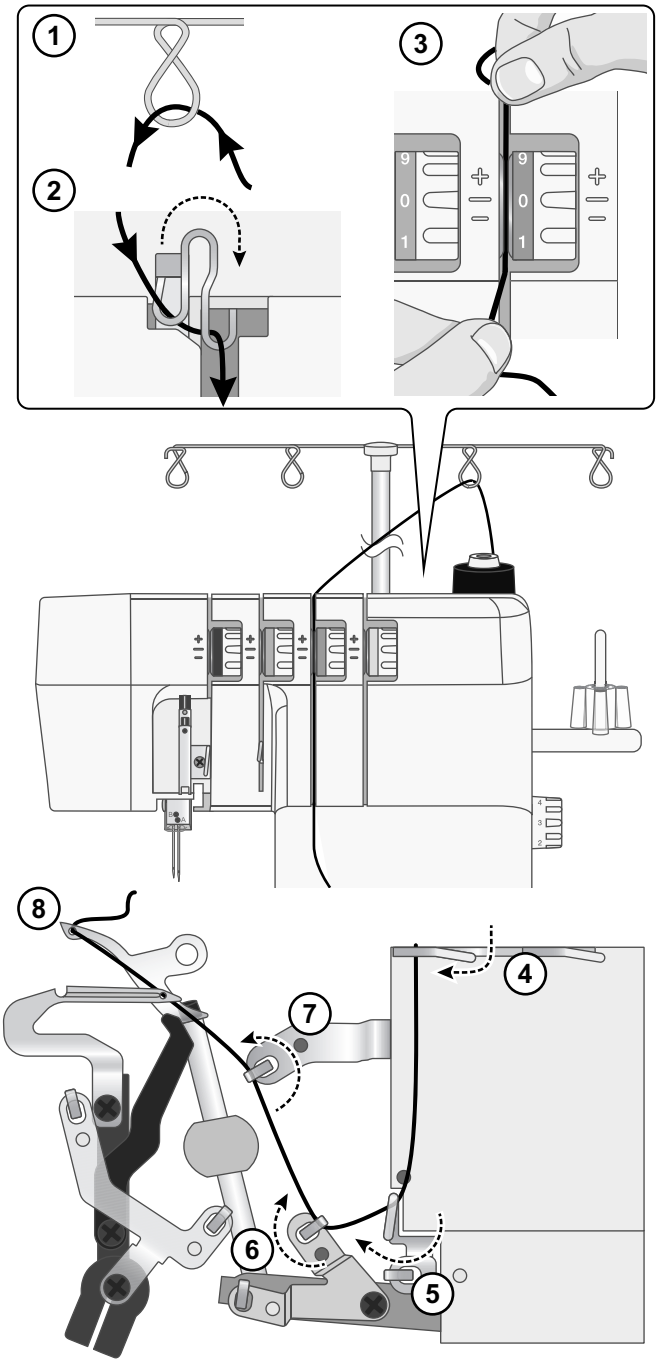


Threading the Upper Looper

(Red)

When threading the upper looper, follow the thread path marked with a red dot.

- To make the threading easier, raise the presser foot and set the thread tension dials to zero. Then the thread tension discs release the tension and make the threading easier. Do not forget to adjust the tension according to recommendations given for each stitch before starting to sew. See Stitch Overview, page 16.
- Open the front cover. Turn the handwheel toward you until the upper looper is nearly in the highest position. There is no exact position they need to be placed in, but the threading is easier if the loopers are in a position where they are both visible and easily accessible.
- Pass the thread from back to front through the thread guide on the thread stand (1). Use the tweezers to make the threading easier.
- With the thread end to the right, pull the thread from below into the pre tension thread guide (2).
- While holding the thread with both hands, pass it between the tension discs and pull it down to make certain it is properly placed between the tension discs (3).
- Place the thread from right to left into the thread guide (4).
- Thread the looper area of the machine following the red color coded thread guides (5–7). Use the tweezers to make the threading easier.
- Use the tweezers to bring the thread behind the lower looper and thread into the hole in the upper looper from front to back (8).
- Pull about 10 cm (4") of thread through the looper and place it to the back of the needle plate.

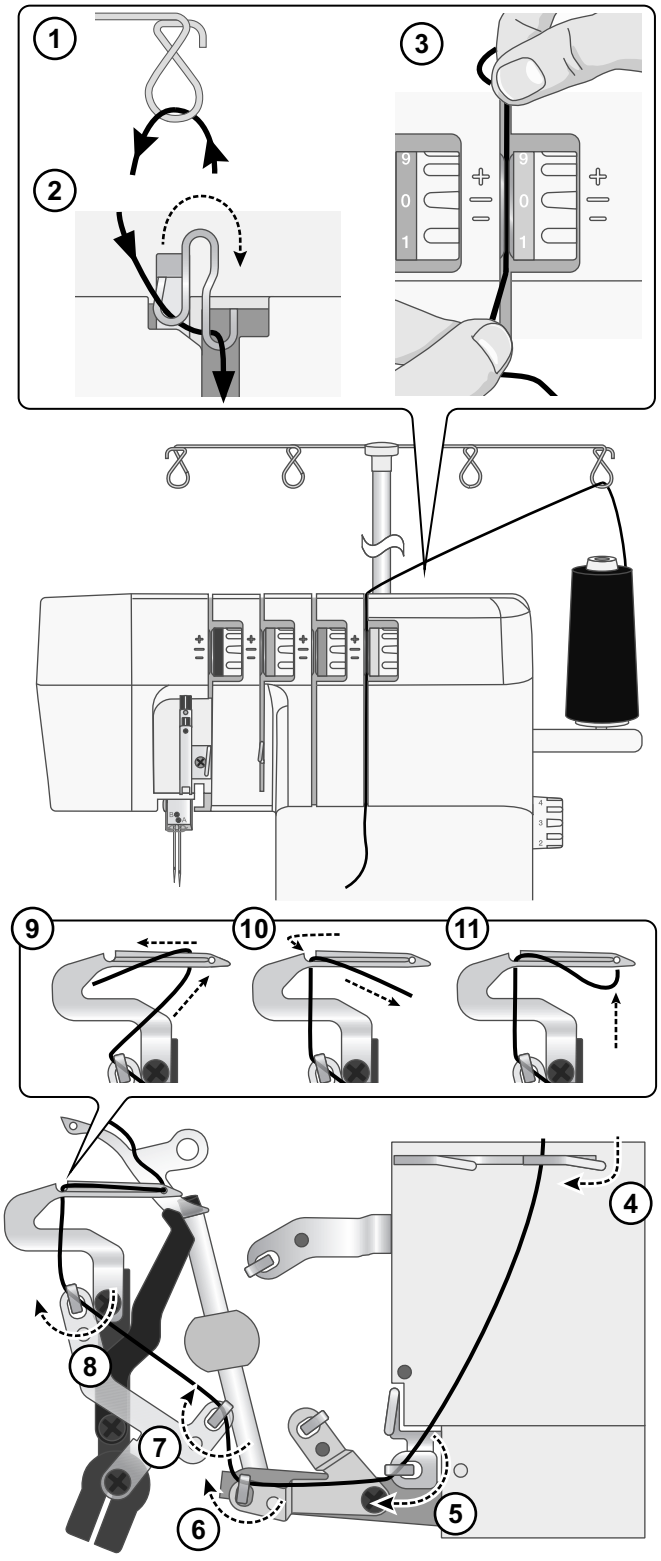


Threading the Lower Looper

(Green)

When threading the lower looper, follow the thread path marked with a green dot.

- Pass the thread from back to front through the thread guide on the thread stand (1). Use the tweezers to make the threading easier.
- With the thread end to the right, pull the thread from below into the pre tension thread guide (2).
- While holding the thread with both hands, pass it between the tension discs and pull it down to make certain it is properly placed between the tension discs (3).
- Place the thread from right to left into the thread guide (4).
- Thread the looper area of the machine following the green color coded thread guides (5-8). Use the tweezers to make the threading easier.
- Pass the thread behind and over the tip of the lower looper (9). Pull the thread gently to the left until it will slip into the slot in the lower looper (10).
- Pass the thread from front to back through the hole in the lower looper (11). The thread should be positioned in the groove of the lower looper.
- Pull about 10 cm (4″) of thread through the looper and place it over the upper looper and to the back of the needle plate.

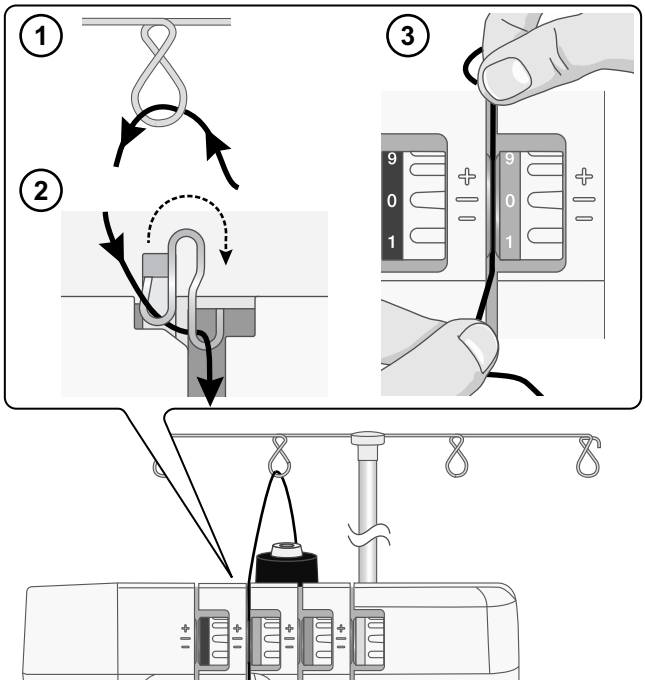


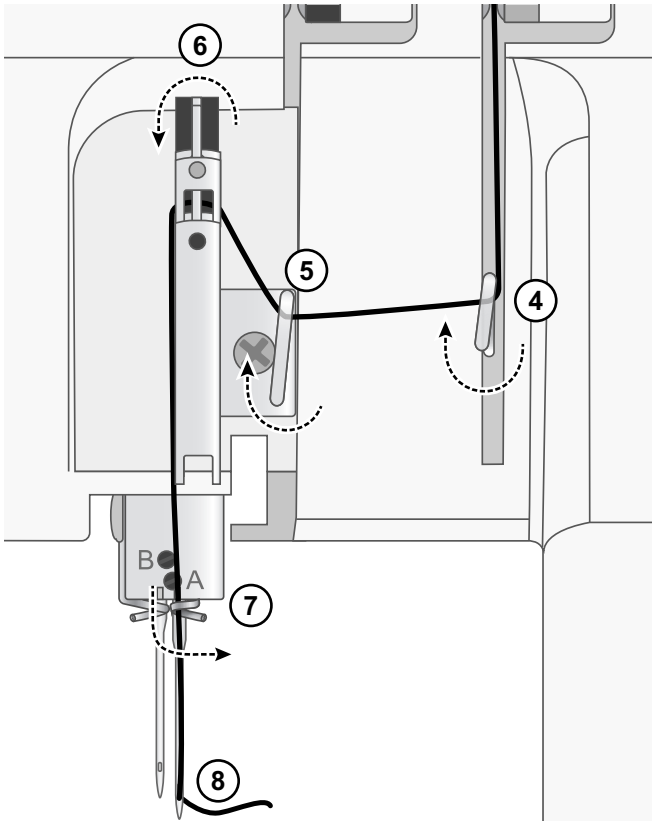
Threading the Right Needle

(Blue)

When threading the right needle, follow the thread path marked with a blue dot.

- Pass the thread from back to front through the thread guide on the thread stand (1). Use the tweezers to make the threading easier.
- With the thread end to the right, pull the thread from below into the pre tension thread guide (2).
- While holding the thread with both hands, pass it between the tension discs and pull it down to make certain it is properly placed between the tension discs (3).
- Bring the thread down and under the thread guides (4–5), continue up and around the upper threading path (6).
- Place the thread from the left, behind and into in the right needle thread guide (7).
- Thread the eye of the right needle (8). Use tweezers to make needle eye threading easier.
- Pull about 10 cm (4") of thread through needle eye to hang free.
- Place the thread to the back, under the presser foot.



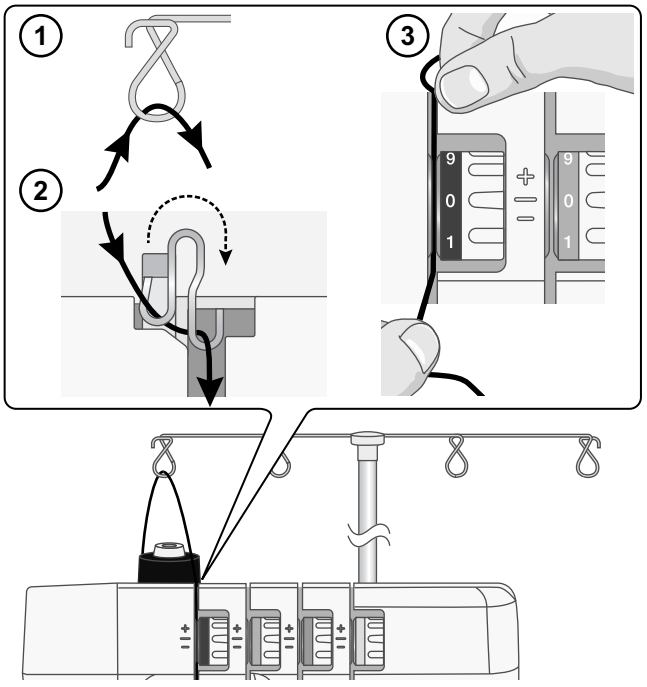


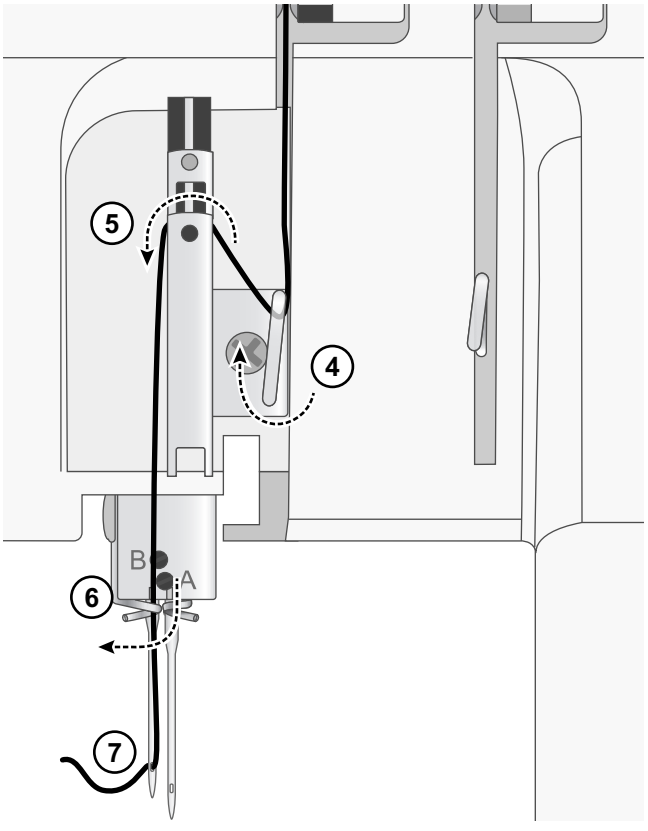
Threading the Left Needle

(Orange)

When threading the left needle, follow the thread path marked with a orange dot.

- Pass the thread from back to front through the thread guide on the thread stand (1). Use the tweezers to make the threading easier.
- With the thread end to the right, pull the thread from below into the pre tension thread guide (2).
- While holding the thread with both hands, pass it between the tension discs and pull it down to make certain it is properly placed between the tension discs (3).
- Bring the thread down and under the thread guide (4), continue up and around the lower threading path (5).
- Place the thread from the right, behind and into in the left needle thread guide (6).
- Thread the eye of the left needle (7). Use tweezers to make needle eye threading easier.
- Pull about 10 cm (4") of thread through needle eye to hang free.
- Place the thread to the back, under the presser foot.





STITCHES AND SEWING TECHNIQUES

Stitch Overview

On your overlock machine, different stitches are obtained by combining different needle positions, threading methods, tension settings, and the use of the upper looper converter.

See Threading, page 10, for references on how to set your machine.

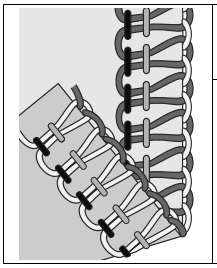
The settings shown in the table below are our recommendations based on normal conditions. It may be necessary to adjust the thread tension depending on the stitch, type of fabric and thread you are using. For best results make tension adjustments in small increments of no greater than half a number at a time. Always test sew on a sample of your fabric before sewing on your project.

Icon Explanation

- Needle position
- Left needle
- Right needle
- Stitch length
- Differential feed
- Cutting width
- Stitch finger activated
- Upper looper converter
- Right needle thread tension
- Left needle thread tension
- Upper looper thread tension
- Lower looper thread tension

4–Thread Overlock

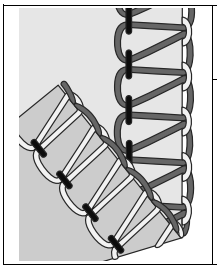
For all seams where stretch or give is needed, such as neck edges, side seams, sleeves, etc.



						Thread Tension			
	2.5	1–2	3–4.5	S	—	2.5–3.5	2.5–3.5	2.5–5	2.5–4

3–Thread Overlock, Wide (and Narrow)

For overcasting a single layer of light to medium fabric. Use heavier threads in the loopers to create decorative edges.
Note: Use the right needle instead for a narrow stitch. Recommended thread tension settings within brackets in the chart.

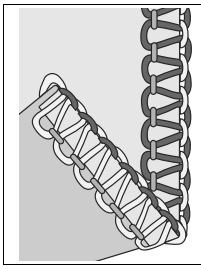


						Thread Tension							
	2.5	1–1.5	R (3.5)	S	—	2.5–3.5	(—)	—	(2.5–3)	3–3.5	(3–4)	2.5–3	(3)

3–Thread Narrow Edge

For edging lightweight fabrics. It gives a nice finish on silky scarves, pillow ruffles and napkins. Thread the upper looper with a decorative thread, such as 40 weight rayon for a beautiful satin edge.

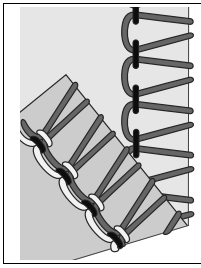
Note: Not recommended for heavy weight fabrics.

							Thread Tension			
	F	1	3	R	—	—	3	5–6	3–5

3–Thread Wrapped Overlock, Wide

For sewing two layers of stretchy fabrics together. Add additional stretch by using a stretchy type thread in the lower looper. Change the thread tension accordingly.

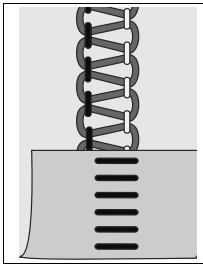
Note: Not recommended for light, medium, heavy woven fabrics or light stretch fabrics.

							Thread Tension			
	3	1	R (3.5)	S	—	4–5	—	0	8

3–Thread Flatlock, Wide (and Narrow)

For sewing fabrics together with a decorative effect either with the flatlock side or the ladder stitch side. Create varying effects by threading the loopers with decorative thread, such as 40 weight rayon.

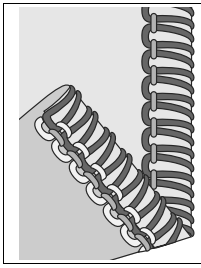
Note: Use the right needle instead for a narrow stitch. Recommended thread tension settings within brackets in the chart.

							Thread Tension							
	3	1	3–R (3.5)	S	—	0.5	(—)	—	(0)	5–6	(5)	7	(7)

3–Thread Rolled Edge

For edging lightweight fabrics. It gives a nice finish on silky scarves, pillow ruffles and napkins. For a beautiful rolled edge, thread the loopers with a decorative lightweight thread, such as 40 weight rayon, for a beautiful satin edge and the needle and lower looper with lightweight regular thread.

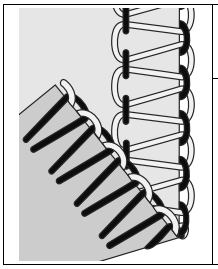
Note: Not recommended for heavy weight fabrics.

							Thread Tension			
	F	1–1.5	R (3.5)	R	—	—	2–3	4–8	6–8

2–Thread Overlock, Wide (and Narrow)

For overcasting a single layer of light to medium weight fabrics (upper looper converter required).

Note: Use the right needle instead for a narrow stitch. Recommended thread tension settings within brackets in the chart.



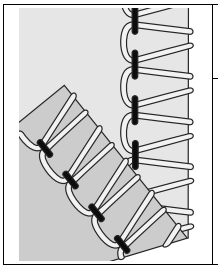
						Thread Tension							
	2.5	1–1.5	R (3.5)	S		0–0.5	(—)	—	(1.5)	—	(—)	4–5	(4–5)

2–Thread Wrapped Overlock, Wide (and Narrow)

For sewing two layers of stretchy fabrics together. Add additional stretch by using a stretchy type thread in the lower looper. Change the thread tension accordingly.

Note: Not recommended for light, medium, heavy woven fabrics or light stretch fabrics.

Note: Use the right needle instead for a narrow stitch. Recommended thread tension settings within brackets in the chart.

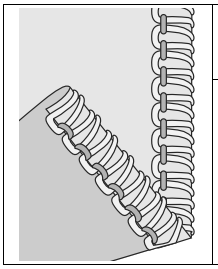


						Thread Tension							
	2–3	1	R (3.5)	S		4.0	(—)	—	(4.5)	—	(—)	1.5	(2)

2–Thread Rolled Edge

For edging lightweight fabrics. It gives a nice finish on silky scarves. Thread the looper with a decorative lightweight thread, such as 40 weight rayon for a beautiful satin edge (upper looper converter required).

Note: Not recommended for medium or heavy weight fabrics.



						Thread Tension			
	F	1	3	R		—	2.0	—	4.5

Start Sewing

1. Set up your machine according to the settings recommended for respective stitch in the Stitch Overview (page 16).

   When the machine is completely threaded, close the front cover and bring all of the threads over the needle plate and slightly to the left under the presser foot.

   Ensure that the upper cutter moves against the stationary cutter correctly by turning the handwheel slowly toward you. If the upper cutter does not move correctly, check if there are any fabric or waste thread stuck between the blades.

   Hold the threads and apply a slight tension.

   Turn the handwheel toward you 2 or 3 complete turns to start making a thread chain. Check if all threads wind around the stitch finger of the needle plate. If the threads do not wind around the finger, make sure each thread is threaded correctly.

2. Continue holding the thread chain while pressing the foot control. Sew until the chain is 5-8 cm (2"-3") in length.

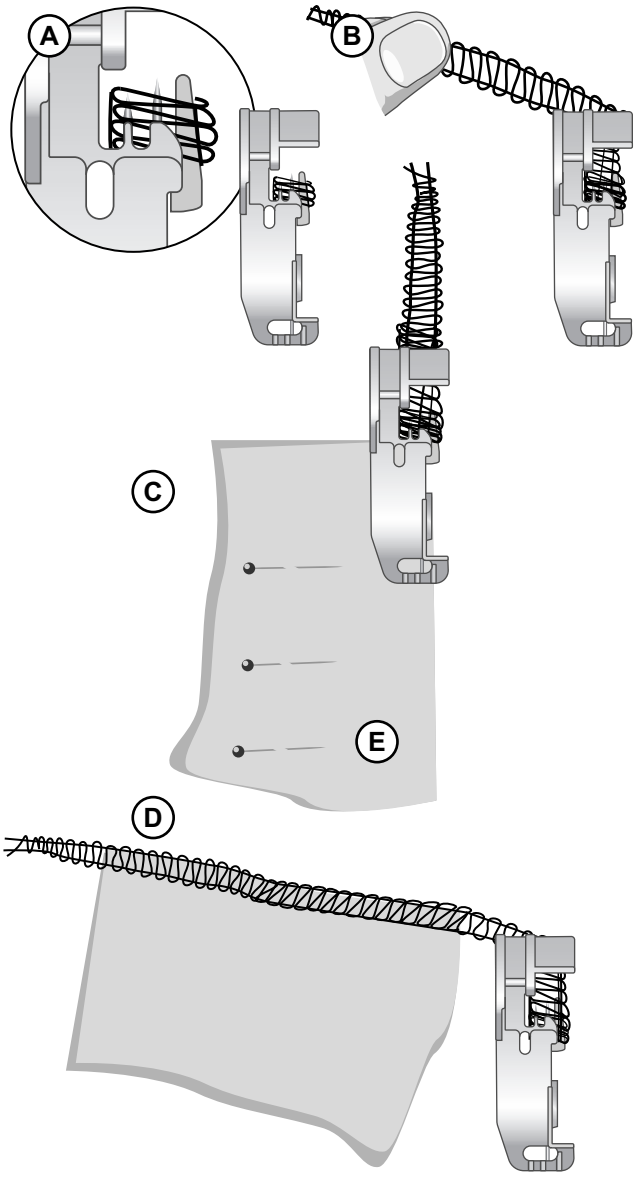
3. Place fabric under the front of the presser foot and sew a test sample. Guide the fabric slightly while sewing. Do not pull on the fabric as this may deflect the needle, causing it to break.

   Note: Insert straight pins to the left of the presser foot. The pins will be easy to remove and are away from the cutters.

   Warning: *Sewing over pins will damage and might destroy the edge of the cutters.*

4. When you reach the end of the fabric, continue sewing while drawing the finished fabric gently backwards and to the left. This is called chaining off. It prevents the threads from coming undone and prepares for next sewing.

   Cut off the thread chain 2-5 cm (1"-2") behind the presser foot.



Securing Thread Chain

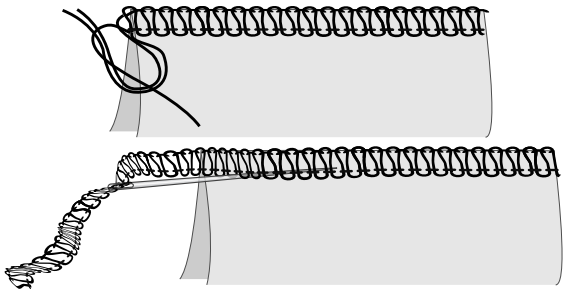
Tie a Knot

To avoid the thread chain from ravelling, separate and tie the thread ends together.

Use a Sewing Needle

Thread the chain into a large eyed, hand sewing needle.

Insert the needle into the end of the seam and pull the chain into the seam to secure the threads.



Use the Machine at the Start of a Seam

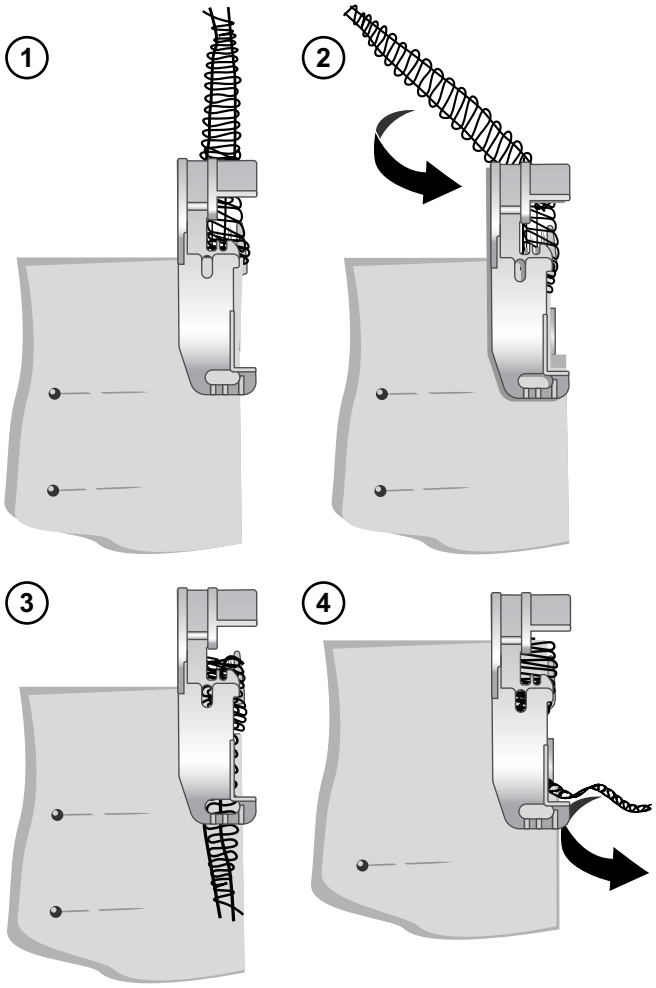
1. Before placing the fabric in the machine, sew a thread chain approximately 2"-3" (5-8 cm) long.

   Place your fabric in front of the presser foot. Sew a few stitches and stop.

2. Raise the presser foot and bring the thread chain to the left around and under the presser foot.

   Place the thread chain between the presser foot and upper knife, holding it in position as you lower the presser foot to sew.

3. After sewing approximately 1" (2.5 cm), move the chain to the right and under the upper knife, cutting the chain as you sew.

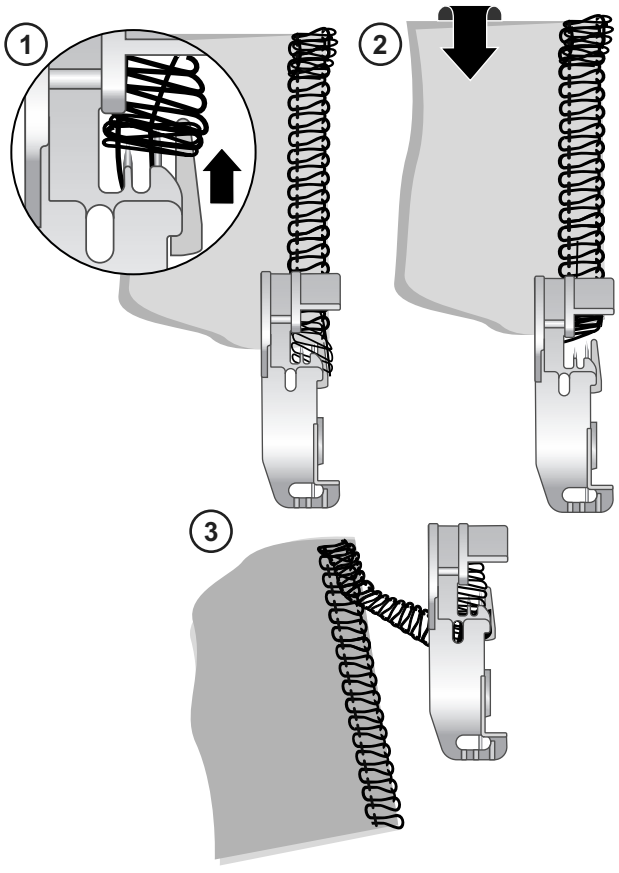


Use the Machine at the End of a Seam

1. Serge one stitch off the end of the seam.

   Raise the needle and presser foot, and gently pull the threads off the stitch finger.

2. Turn the fabric over so that the under side is up.
3. Serge approximately 1"(2.5 cm) over the stitching and angle off the fabric.



Cutting the Seams Open

Cut the upper looper thread with a seam ripper (not included with the machine) to cut the seams.

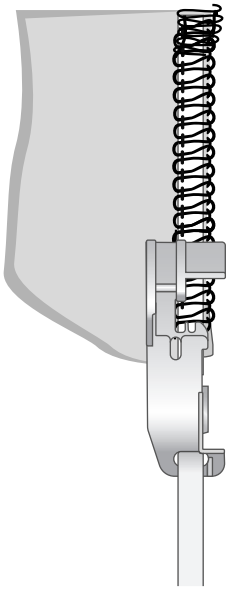


Corded Seams

Corded seams can be used to strengthen stitches when joining elastic fabrics such as knits. Cording prevents knit fabrics from stretching and also stabilizes the seams.

Insert the cord/ribbon into the opening in the presser foot.

Position the cord/ribbon under the presser foot and to the back. The cord/ribbon will be attached in the stitch as the seam is sewn.

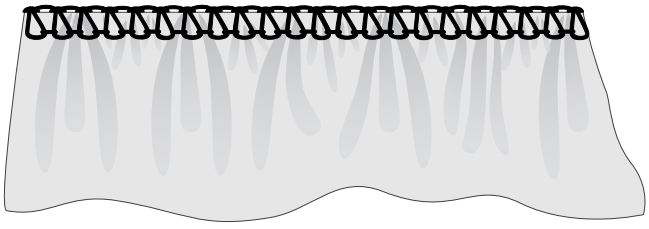


Gathering with Differential Feed

The differential feed can be used to gather lightweight fabrics. Use it for sleeves, making ruffles, and more.

Set the differential feed between 1–2 to obtain the best gathering effect for your project. Always try on a scrap piece of your fabric first. See Differential Feed, page 25, to learn how to adjust the differential feed.

Tip: *For even more gathering effect, you could also increase the stitch length and/or increase the needle thread tension.*



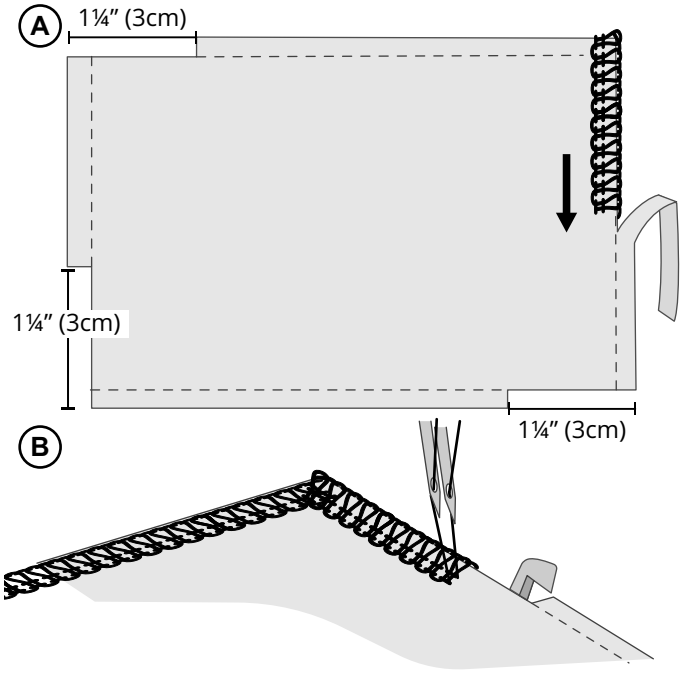
Sewing Corners

Outer Corners

Trim three of the corners approximately 1¼" (3 cm) as illustrated (A). Start sewing at the corner that is not trimmed.

When you reach a corner, stop the machine. Raise the needle and the presser foot. Remove the threads from the stitch finger. Turn the fabric and align the cutting line with the upper knife (B).

Lower the presser foot lifter. Continue to sew from where the previous stitches on the corner ended.

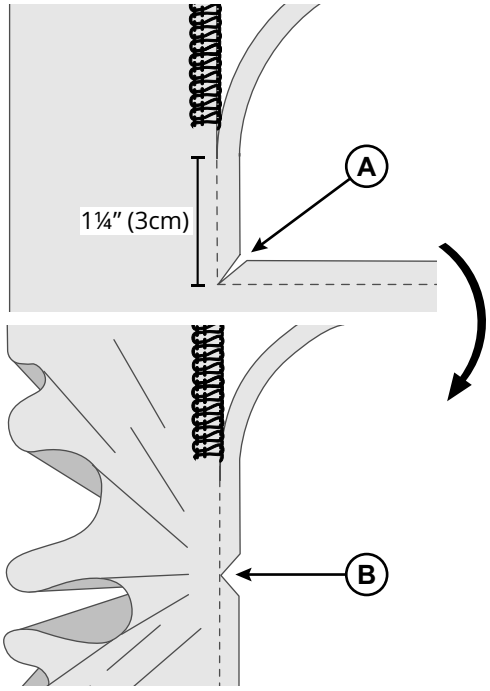


Inner Corners

Cut the inner corner as illustrated (A). Sew and stop approximately 1¼" (3 cm) before the inner corner.

Turn the fabric so that the cutting lines are straight (B).

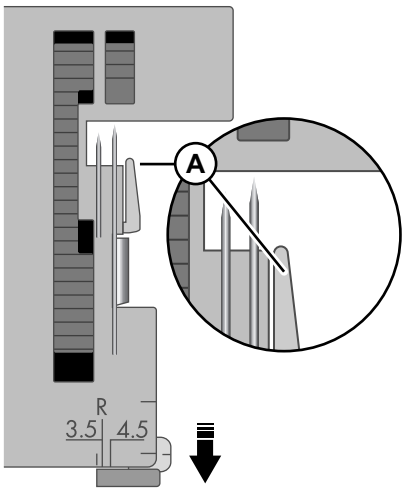
Continue sewing.



Rolled Edge Sewing

The rolled edge stitch is appropriate for light weight fabrics such as lawn, voile, organdy, crepe, etc. The rolled edge is achieved by adjusting the thread tension to make the fabric edge roll under the fabric while overlocking. Adjust the thread tension to change the degree of rolling. To sew rolled edge you need to deactivate the stitch finger (see page 9).

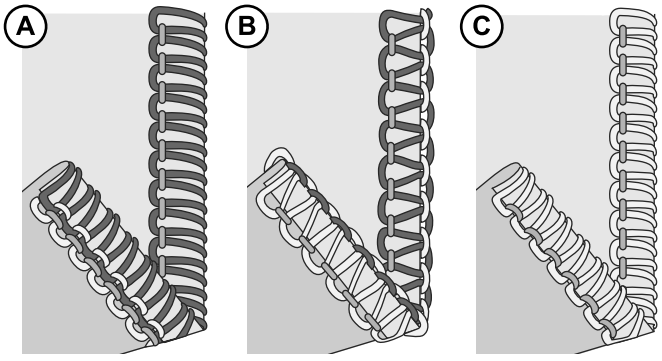
Tip: For a beautiful rolled edge, thread the upper looper with a decorative thread and the needle and lower looper with lightweight regular thread



3–Thread Rolled Edge (A) / Narrow Edge (B)

A variant of the rolled edge stitch (B) is the narrow edge (C). It can be obtained by adjusting the thread tension according to "3–Thread Rolled Edge" (page 17) and/or "3–Thread Narrow Edge" (page 17).

1. Use the right needle thread and the upper and lower looper threads.
2. Deactivate the stitch finger.
3. Set the stitch length dial to "F–2" for a fine seam.
4. Set the thread tension according to "3–Thread Rolled Edge" (page 17) or "3–Thread Narrow Edge" (page 17).
5. Make a thread chain and test sew on a sample of your fabric before sewing on your project. Hold the thread chain while beginning to sew to keep it from curling into the seam.



2–Thread Rolled Edge (C)

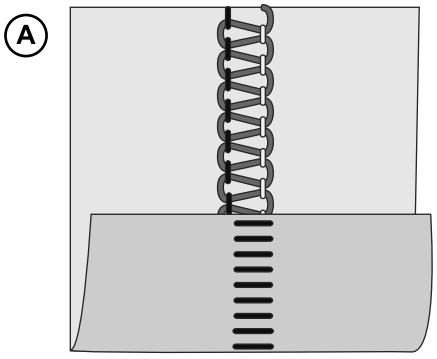
1. Attach the upper looper converter (see page 8).
2. Use the right needle thread and lower looper thread.
3. Deactivate the stitch finger.
4. Set the stitch length dial to "F" for a fine seam.
5. Set the thread tension according to the stitch table on page 18.
6. Make a thread chain and test sew on a sample of your fabric before sewing on your project. Hold the thread chain while beginning to sew to keep it from curling into the seam.

Flatlock Sewing

A Flatlock (A) is made by adjusting the tension of the 2–thread overlock or 3-thread overlock stitch, sewing the seam and pulling the fabrics apart to flatten the seam. The tensions must be adjusted correctly for the fabric to pull flat properly.

A Flatlock can be used both as a decorative construction stitch, sewing two pieces together (Standard Flatlock), or for decoration only on one piece of fabric (Decorative Flatlock).

There are two ways to sew a Flatlock. Either with the wrong sides of the fabric together to create a decorative look, or with the right sides together, to create a Ladder Stitch.



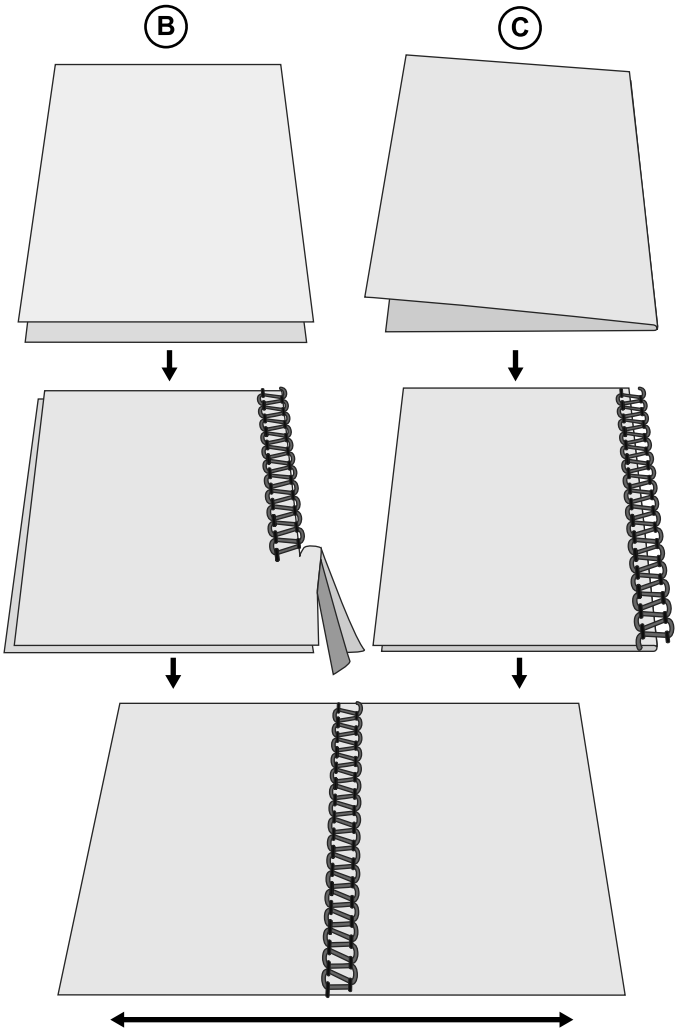
Standard Flatlock, Wide (B)

1. Use the left needle.
2. Thread the lower and upper looper and the left needle.
3. Set the thread tension according to "3–Thread Flatlock, Wide (and Narrow)" on page 17.
4. Place the wrong sides of the two pieces of fabric together to sew a decorative stitch on the right side of the project.
5. Sew the seam, trimming the excess fabric. The needle thread will form a V on the underside of the fabric. The lower looper thread will pull into a straight line at the fabric edge.
6. Unfold the fabric and pull on opposite sides of the seam to pull the stitches flat.

Decorative Flatlock, Wide (C)

1. Deactivate the upper cutter (page 8). The fabric should not be trimmed on this stitch.
2. Follow steps 1-3 above.
3. Fold the fabric piece, wrong sides together, to sew a decorative stitch on the right side of the project.
4. Position the fabric so the seam is sewn with part of the stitch extending off the fabric.
5. Unfold the fabric and pull on opposite sides of the stitch to flatten.

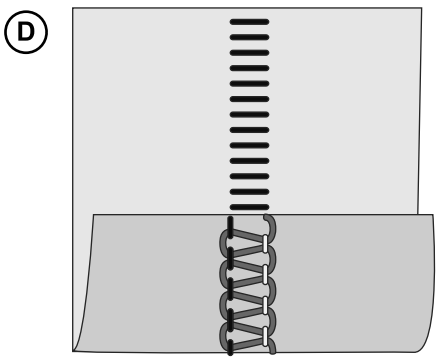
Tip: The upper looper thread is the prominent thread in the flatlock stitch. Place a decorative thread in the upper looper and regular threads in the lower looper and needle.



Ladder Stitch (D)

A ladder stitch is a flatlock stitch but sewn with the right sides of the fabric together. The needle thread will be the prominent thread that creates the ladder.

When sewing follow the instructions for "Decorative Flatlock, Wide (C)" above.



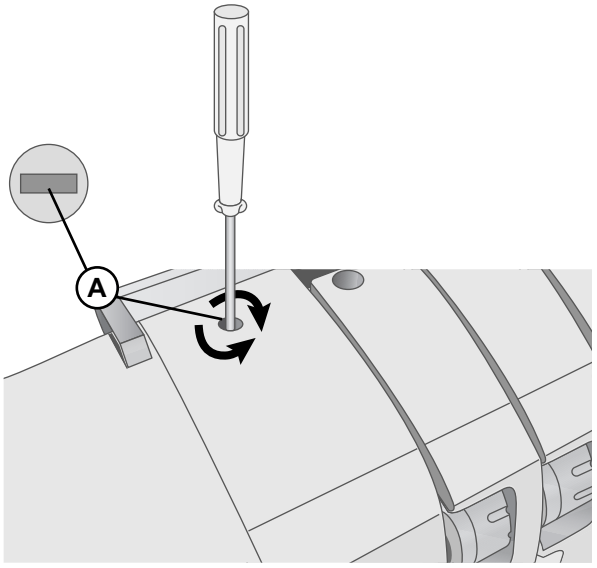
STITCH ADJUSTMENTS

Presser Foot Pressure

The presser foot pressure for sewing based on normal conditions is preset at the factory. When sewing in different fabric weights, adjustment might be needed. Generally, decrease the presser foot pressure when sewing in light weight fabric and increase it when sewing in heavy weight fabrics. Always test sew on a sample of your fabric before sewing on your project.

Increase or decrease the pressure in small increments by turning the presser foot pressure screw.

Insert the screwdriver into the slot (A) of the screw found in the presser foot pressure access hole on the top left of your machine. Adjust the pressure by turning the screw clockwise/counter clockwise according to the below.



Less pressure: Turn the presser foot pressure screw in a counter- clockwise direction.

More pressure: Turn the presser foot pressure screw in a clockwise direction.

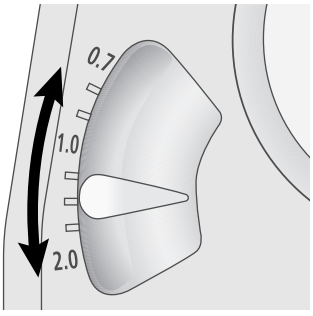
Back to standard setting: Turn the screw counter clockwise until it stops against the top cover. Then turn the screw clockwise six turns to re-set the standard presser foot pressure.

Differential Feed

The differential feed system consists of two sets of feed teeth arranged one behind the other. Both feed teeth work independently of each other to give perfect results when sewing on speciality fabrics. When the amount of feed by the front feed teeth is changed in relation to the feed by the rear feed teeth it will "stretch" or "gather" the fabric.

Use the differential feed to prevent stretching of knit fabrics and puckering of lightweight fabrics.

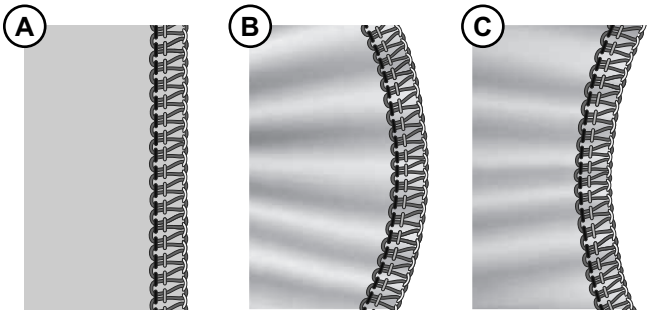
The differential feed should be set to 1.0 for overlock stitching on normal fabric. To adjust the differential feed, turn the dial.



Normally, the seam and fabric should lay flat (A).

If the sewn fabric stretches (B), adjust the value toward 2.0.

If the sewn fabric is gathered (C), adjust the value toward 0.7.

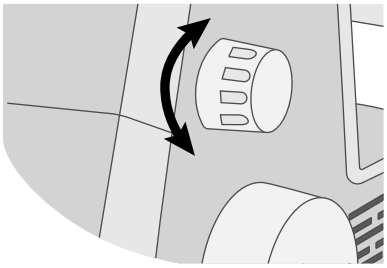


Tip: When overedging light woven or loosely knit fabrics, such as silk and silky knitwear, adjust the differential feed to a number between 0.7 and 2.0. When sewing, apply gentle tension to the fabric by holding the seam lightly in front and back of the presser foot. The setting depends on the material being sewn as well as the wished amount of stretching. Therefore, test sew with different settings before sewing on your garment.

Stitch Length

The stitch length can be adjusted between F (0.8 mm) and 4 mm. Stitch length should be set to "3" for most sewing conditions, but it may have to be adjusted depending on fabric type. Adjust the stitch length to 4 mm when sewing on heavyweight fabrics. Adjust the stitch length to 2 mm when sewing on lightweight fabrics.

To adjust the stitch length, turn the stitch length dial to the desired value.



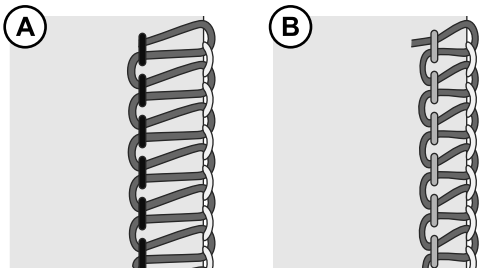
Stitch Width

The stitch width can be increased or decreased by changing the needle position or by adjusting the cutting width.

Adjustment Using Needle Position

When only the left needle, or when both needles are used the stitch width is 5.7 mm (A).

When only the right needle is used the stitch width is 3.5 mm (B).



Adjustment Using Cutting Width Dial

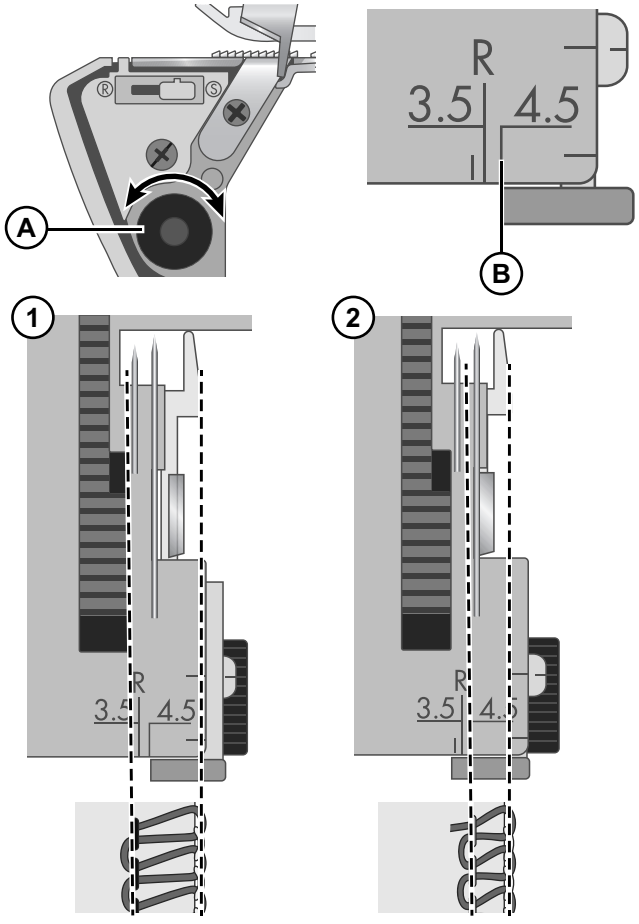
The cutting width can be fine tuned by turning the cutting width adjustment knob (A). The set value is indicated by the cutting width indicator on the needle plate (B). By doing so, the upper cutter position and cutting width can be adjusted within the range shown below. As you turn the cutting width adjustment knob, you can see how the stitch finger and stationary cutter moves.

Turn the knob to adjust the desired cutting/seam width, using the graduations on the needle plate as a guideline.

1. When only the left needle is used: 5.2 - 6.7 mm
2. When only the right needle is used: 3.0 - 4.5 mm

Tip: It is easier to adjust the cutting width if the upper cutter is disengaged (see page 8).

Tip: Use wider seams on loosely woven fabrics and more narrow stitches in dense fabric.



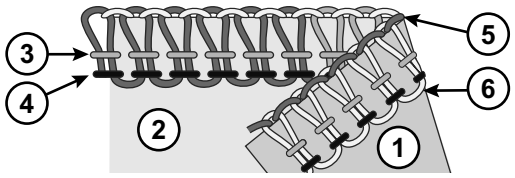
Thread Tension Settings

Thread tension is recommended for each stitch (Stitch Overview, page 16), but it may have to be fine tuned depending on:

- Type and thickness of the fabric
- Needle size
- Size, type and fiber content of the thread

See page 9 for how to adjust the thread tension settings.

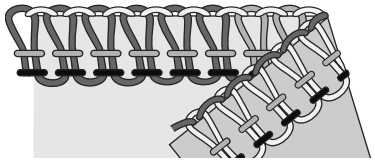
The below describes how the tension settings can be adjusted for 4–thread overlock stitch.



1. Wrong side of fabric
2. Right side of fabric
3. Right needle thread
4. Left needle thread
5. Upper looper thread
6. Lower looper thread

Correct Tension

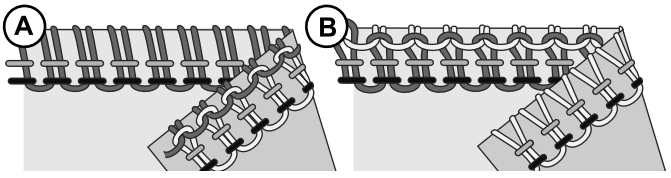
Lower looper thread and upper looper thread should be well balanced with the same tension (both looper threads should cross at the edge of the fabrics). Needle threads should not be too loose or too tight, but equally balanced tension.



Upper Looper Tension

When the upper looper thread is too loose (A): Tighten the thread tension of the upper looper or loosen the thread tension of the lower looper.

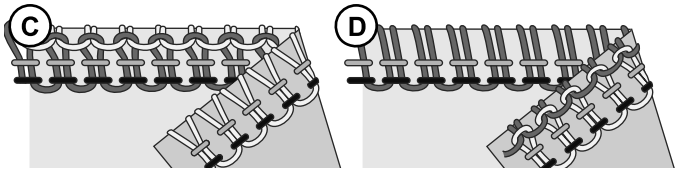
When the upper looper thread is too tight (B): Loosen the thread tension of the upper looper or tighten the thread tension of the lower looper.



Lower Looper Tension

When the lower looper thread is too loose (C): Tighten the thread tension of the lower looper or loosen the thread tension of the upper looper.

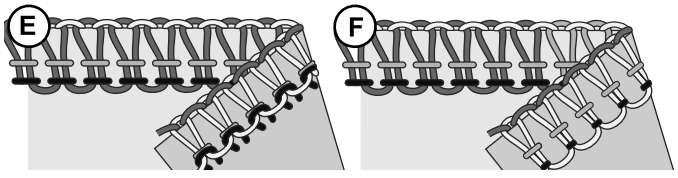
When the lower looper thread is too tight (D): Loosen the thread tension of the lower looper or tighten the thread tension of the upper looper.



Left Needle Tension

When the left needle thread is too loose (E): Tighten the thread tension of the left needle or loosen both looper threads.

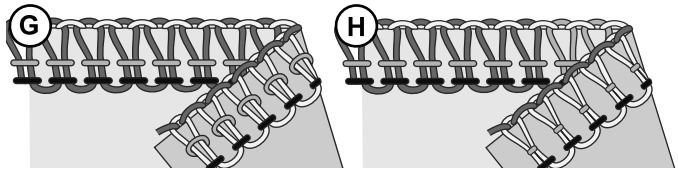
When the left needle thread is too tight (F): Loosen the thread tension of the left needle.



Right Needle Tension

When the right needle thread is too loose (G): Tighten the thread tension of the right needle.

When the right needle thread is too tight (H): Loosen the thread tension of the right needle.



MAINTENANCE

⚠ *Turn off the main power switch and unplug the machine before doing any maintenance.*

Cleaning

An overlock requires more frequent maintenance than a conventional sewing machine since a lot of lint is produced when the cutters are cutting the fabric.

Open the front cover.

With a forward brushing movement, use the lint brush to remove any lint.

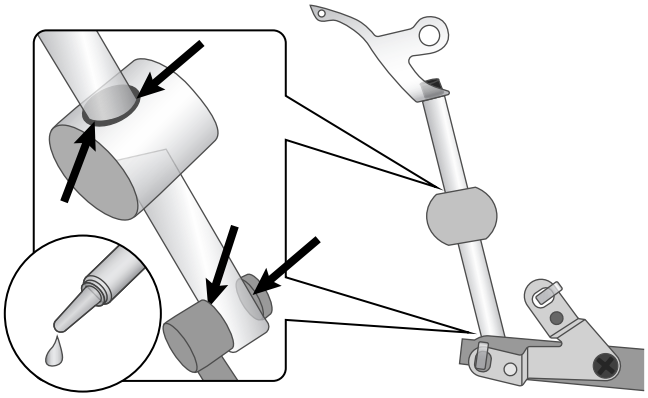
Oiling

An overlock runs at a very high speed and needs to be oiled frequently to lubricate the internal working parts. To keep the machine running smoothly and quietly the moving parts must be lubricated often. We recommend lubricating after every 24 hours of use.

Note: Use sewing machine oil. Do not use any other oil, it could damage the machine.

Open the front cover. Place a few drops of oil at the locations marked in the illustration.

Wipe the machine surface to remove all excess oil before sewing.

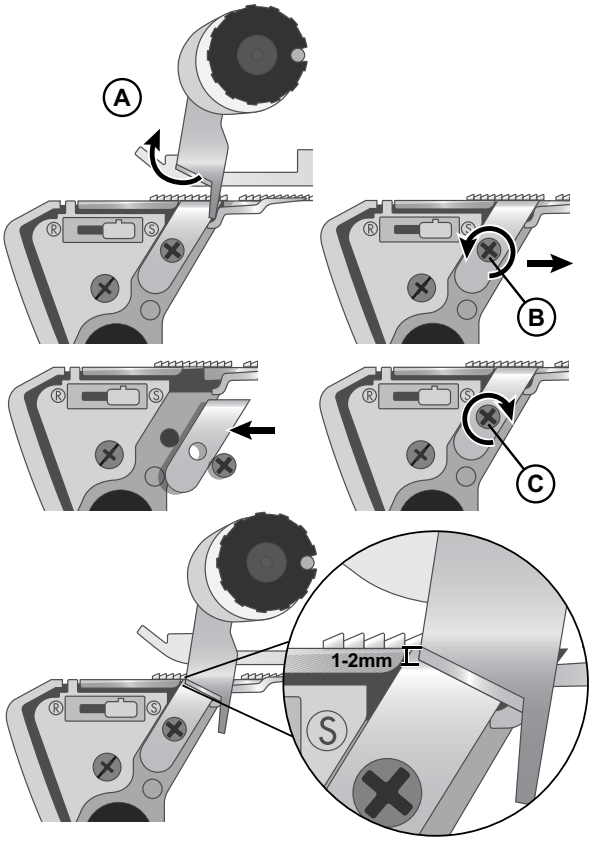


Replacing the Stationary Cutter

⚠ *Turn off the main power switch and unplug the machine.*

The stationary cutter should be changed when it becomes blunt. Change it by following the below instructions. If you are having any difficulties, consult your service agent to make the necessary adjustments.

- Open the front cover. Disengage the upper cutter (see page 8).
- Loosen the stationary cutter set screw (A) and remove the stationary cutter blade (B).
- Place a new stationary cutter blade in the groove of the stationary cutter holder.
- Tighten the upper cutter set screw (A).
- Return the movable upper cutter to its working position.
- Turn the handwheel so the needles are in their lowest position.
- Make sure the front edge of the upper cutter should be 1–2 mm lower than the cutting edge of the stationary (C). If not, adjust the knife blade.



Storage

When the machine is not in use, be sure to keep it unplugged. Cover the machine with the soft dust cover to protect it and store the machine, so it is not exposed to direct sunlight or humidity.

Servicing

If you have any questions regarding service and/or operation, contact our Customer Care department.

Trouble Shooting

Machine Does Not Run

Possible Cause: Machine not properly connected to power source.

Solution: *Check that machine has been properly connected to power source (page 3).*

Possible Cause: The front cover is open.

Solution: *Close the front cover.*

Fabric Does Not Feed Well

Possible Cause: Stitch length is set too short for the fabric being sewn.

Solution: *Increase the stitch length setting (page 26).*

Possible Cause: Differential feed is not set in the correct position for the fabric being sewn.

Solution: *Adjust the differential feed (page 25).*

Possible Cause: Presser foot pressure not correctly set for fabric being sewn.

Solution: *Adjust presser foot pressure (page 25).*

Needle Breaks

Possible Cause: Needle may not be properly inserted in the needle clamp.

Solution: *Insert needle so that it is all the way up in the needle clamp, then tighten the screw securely (page 7).*

Possible Cause: Manually pulling fabric from behind presser foot while sewing which causes needles to deflect.

Solution: *Refrain from pulling fabric manually; allow feed teeth to draw fabric under presser foot.*

Possible Cause: Needle may not be the correct size for the fabric being sewn.

Solution: *Use a needle size that is compatible for the fabric (page 10).*

Thread Breaks

Possible Cause: Machine may not be threaded correctly; threads threaded in the incorrect sequence.

Solution: *Check that machine is threaded in correct order (page 10).*

Possible Cause: Thread is not unreeling smoothly off the thread spool.

Solution: *Check the thread spool to ensure thread is not getting caught.*

Possible Cause: Needle(s) may have a bent, dull or broken point.

Solution: *Replace needle(s) (page 7).*

Possible Cause: The needle is inserted incorrectly.

Solution: *Insert the needle correctly (page 7).*

Possible Cause: Using thread that is poor quality or has uneven filament.

Solution: *Use good quality thread with a smooth, even filament.*

Possible Cause: Thread tension is set too tight.

Solution: *Loosen thread tension (page 27).*

Possible Cause: Thread is caught in one of the thread guides.

Solution: *Check threading path to ensure all threads are feeding smoothly.*

Stitches Skipping

Possible Cause: Needle(s) may have a bent, dull or broken point.

Solution: *Replace needle(s) (page 7).*

Possible Cause: Needle may not be properly seated in the needle clamp.

Solution: *Insert needle so that it is all the way up in the needle clamp, then tighten the screw securely.*

Possible Cause: Needle may not be the correct size for the fabric being sewn.

Solution: *Use a needle size that is compatible for the fabric (page 10).*

Possible Cause: Machine may not be threaded correctly or threads were threaded in the incorrect sequence.

Solution: *Check that machine is threaded in correct order as shown in machine manual (page 10).*

Possible Cause: Using thread that is poor quality or has uneven filament.

Solution: *Use good quality thread with a smooth, even filament.*

Irregular Stitches

Possible Cause: Stitches are not balanced.

Solution: *Adjust thread tensions and possibly cutting width (page 27/page 26).*

Possible Cause: Thread is not unreeling smoothly off the thread spool.

Solution: *Check the thread spool to ensure thread is not getting caught.*

Possible Cause: Machine may not be threaded correctly or threads threaded in the incorrect sequence.

Solution: *Check that machine is threaded in correct order as shown on (page 10).*

Fabric Puckers

Possible Cause: Thread tensions are set too tightly.

Solution: *Loosen thread tensions (page 27).*

Possible Cause: Thread is not unreeling smoothly off the thread spool.

Solution: *Check the thread spool to ensure thread is not getting caught.*

Possible Cause: Using thread that is poor quality or has uneven filament.

Solution: *Use good quality thread with a smooth, even filament.*

Possible Cause: Stitch length is set too short.

Solution: *Adjust stitch length to a longer setting (page 26).*

Possible Cause: Differential feed is not set in the correct position for the fabric being sewn.

Solution: *Adjust the differential feed (page 25).*

Irregular Trimming

Possible Cause: Upper cutter is not in proper position.

Solution: *Check alignment of the upper and stationary cutter (page 28).*

Possible Cause: Cutter is damaged or worn out.

Solution: *Replace the cutter (page 28).*

Fabric Jams

Possible Cause: Upper cutter is not in proper position.

Solution: *Check alignment of the upper and stationary cutter (page 28).*

Possible Cause: Thread is not unreeling smoothly off the thread spool.

Solution: *Check the thread spool to ensure thread is not getting caught.*

Possible Cause: Too much fabric thickness.

Solution: *Compress thick layers with conventional sewing machine before sewing on your overlock machine.*

Technical Specification

Sewing Speed Maximum 1200 ± 150rpm	**Stitch Length** 1~4 mm	**Foot Control Type** HKT7/HKT72C/HKT7-2
Needles SINGER® EL #2022 #90/14	**Stitch Width** 3–6.7 mm	**Presser Foot Rise** 5–7 mm
Number of Needles 1–2	**Differential Feed Ratio** 0.7–2.0	**Weight** 6.7kg
Number of Threads 2–4	**Type of Lamp** LED light	**Machine Dimensions** Width: ≈309 mm Depth: ≈286 mm Height: ≈276 mm
Protection Class II (Europe)	**Power Rating** Machine: 110Watt	**Rated Voltage** 240 V/50Hz, 230 V/50Hz, 220 V/50-60Hz, 127 V/60 Hz, 120 V/60 Hz, 100V/50-60Hz
Non-Load Power Consumption 0.5W		

We reserve the right to change the machine equipment and the assortment of accessories without prior notice, or make modifications to the performance or design. Such modifications, however, will always be to the benefit of the user and the product.

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Please note that on disposal, this product must be safely recycled in accordance with relevant National legislation relating to electrical/ electronic products. Do not dispose of electrical appliances as unsorted municipal waste, use separate collection facilities. Contact your local government for information regarding the collection systems available. When replacing old appliances with new ones, the retailer may be legally obligated to take back your old appliance for disposal free of charge.

If electrical appliances are disposed of in landfills or dumps, hazardous substances can leak into the groundwater and get into the food chain, damaging your health and well-being.





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Manufacturer
VSM GROUP AB, **SVP Worldwide**
Soldattorpsgatan 3
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