

INSTRUCTION MANUAL
ILLUSTRATED PARTS LIST

FOR

SINGER

MACHINES

2691D 200A
300A

THE SINGER COMPANY

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INSTRUCTION MANUAL

BEFORE OPERATION

1. Never operate the machine unless its oil pan has been filled with oil.
2. After setting up the machine, check the direction of motor rotation. To check it, turn the handwheel by hand to bring the needle down, and turn the power switch ON while observing the handwheel. (The handwheel should turn counterclockwise as observed from the handwheel side.)
3. Do not use a larger motor pulley for the first one month.
4. Confirm that the voltage and phase (single or 3-phase) are correct by checking them against the ratings shown on the motor nameplate.

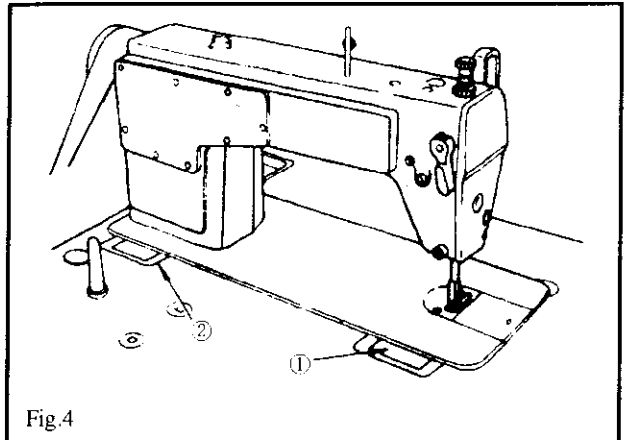
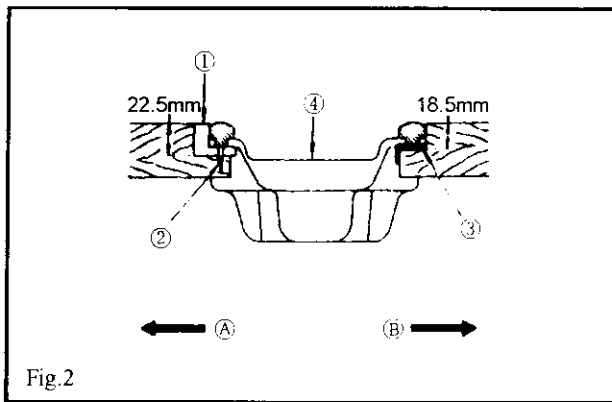
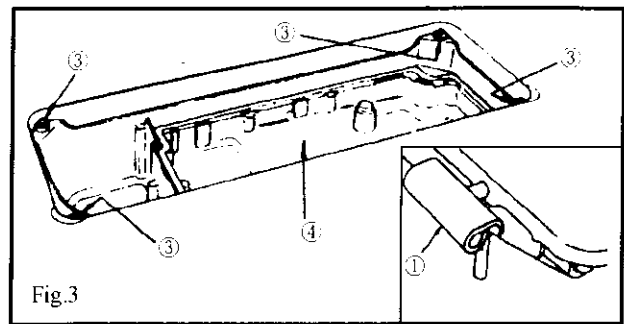
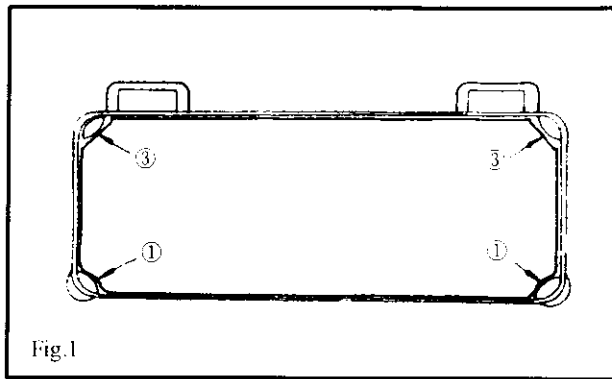
OPERATION PRECAUTIONS

1. Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
2. Do not put your fingers into the thread take-up cover while the machine is operating.
3. Be sure to turn the power switch OFF before tilting the machine head or removing the V belt.
4. When an operator leaves from the machine, make sure to turn off the power.
5. During operation, be careful not to allow your or any other person's head or hands to come close to the handwheel, V belt, bobbin winder or motor. Also, do not place anything close to them. Doing so may be dangerous.
6. If your machine is provided with a belt cover, finger guard or any other protectors, do not operate your machine with any of them removed.
7. Don't clean the face of machine head with thinner.

1. INSTALLATION (Fig.1, Fig.2, Fig.3, Fig.4)

* Installing the oil pan

- 1) The oil pan should rest on the four corners of the machine table groove.
- 2) Fix two rubber seats ① on side Ⓐ (operator's side) using nails ② as illustrated above. Fix two cushion seats ③ on side Ⓑ (hinged side) using nails ②. Then place oil pan ④ on the fixed seats. (Fig.1, Fig.2)
- 3) Fit hinge ① into the opening in the machine bed, and fit the machine head to table rubber hinge ② before placing the machine head on cushions ③ on the four corners. (Fig.3, Fig.4)



2. LUBRICATION (Fig.5 , Fig.6)

1. Information on lubrication (Fig.5)

* Before starting the machine

- 1) Fill oil pan ① with sewing machine oil (SINGER "C": oil) up to HIGH mark ④.
- 2) When the oil level lowers below LOW mark ③, refill the oil pan with the specified oil.
- 3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ② if the lubrication is adequate.
- 4) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.

* Precaution

When you first operate your machine after set up or after an extended period of disuse, run your machine at 3,000 s.p.m. to 3,500 s.p.m. for about 10 minutes for the purpose of break-in.

2. Adjusting the amount of oil supplied to the face plate parts (Fig.6)

- 1) Adjust the amount of oil supplied to the thread take-up and needle bar crank ② by turning adjust pin ①.
- 2) The minimum amount of oil is reached when marker dot ④ is brought close to needle bar crank ② by turning the adjust pin in direction ⑤.
- 3) The maximum amount of oil is reached when marker dot ④ is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction ⑥.

LUBRIFICATION (fig 5)

1- information sur la lubrification (fig 5)

- Avant de démarrer la machine

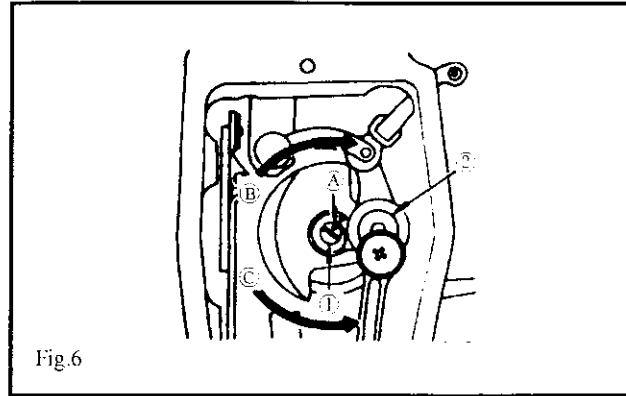
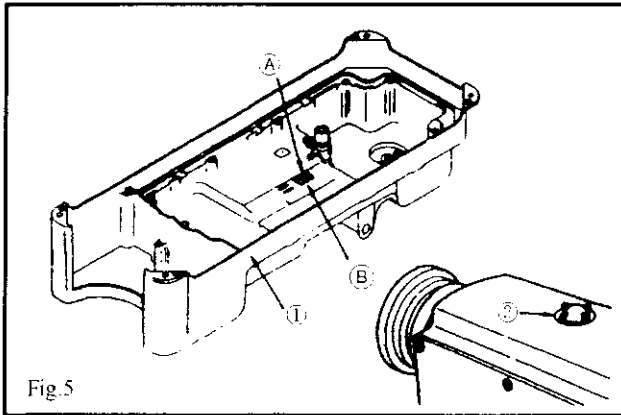
- 1- remplir la cuve avec de l'huile de machine à coudre Singer (Singer « C » huile) jusqu'à la marque HIGH (haute) (A)
- 2- quand le niveau de l'huile descend sous la marque (B), remplir à nouveau la cuve avec l'huile spécifiée.
- 3- Quand vous allez utiliser la machine après la lubrification, vous verrez l'huile en mouvement à travers la petite fenêtre latérale (éclaboussures visible), ce qui vous permettra de constater que le processus de lubrification est adéquat.
- 4- Notez que la fréquence des éclaboussures ne doit pas être mise en relation avec la quantité d'huile présente dans la cuve.

Précaution :

Quand vous utilisez la machine pour la première fois, ou après une longue période de non-utilisation, laissez tourner la machine à une vitesse comprise entre 3000 et 3500 points par minute, durant environ 10 minutes pour permettre aux parties mécaniques de se rôder.

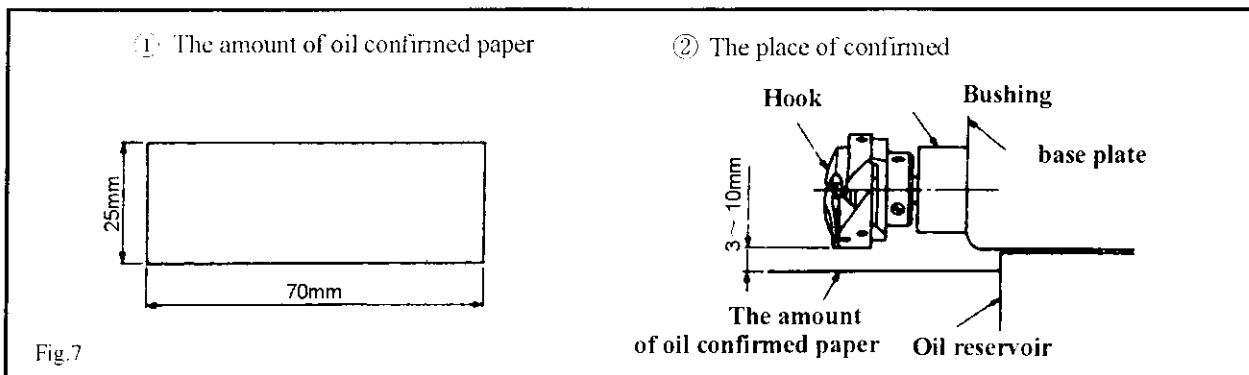
2- Ajustement de la quantité d'huile disponible sur les pièces faciales en mouvement. (Fig 6)

- 1- ajuster la quantité d'huile disponible au niveau de la prise du fil et de la manivelle de la barre d'aiguille (2) en faisant tourner la **goupille** (1)
- 2- la quantité minimum d'huile est atteinte lorsque le marqueur (A) est porté près de la manivelle de la barre d'aiguille, en faisant tourner la **goupille** (1) dans la direction (B)
- 3- la quantité maximum d'huile est atteinte lorsque le marqueur (A) est porté à la position opposée à la manivelle de la barre d'aiguille, en faisant tourner la **goupille** (1) dans la direction (C)



3. ADJUSTING THE AMOUNT OF OIL SUPPLIED TO THE HOOK (Fig.7, Fig.8, Fig.9)

- 1) After cooling, the machine may be idling for three minutes (operating continued properly).
- 2) The amount of oil confirmed paper must be inserted in the state when the machine is operating. (Fig.7)
- 3) Oil in the oil pan is confirmed within HIGH and LOW.
- 4) The amount of oil confirmed is for five seconds (please use the clock with the second)
- * The proper amount of oil manual (Fig.8)
- 1) The amount of oil can be adjusted according to the different sewing process but it must be suitable amount.
- * Otherwise the hook will generate heat or the sewing material will be contaminated.
- 2) Use the amount of confirmed paper for three times to observe the amount of oil. Adjust the screw until the mark on the paper hasn't changed.
- * Adjusting the amount of oil supplied to the hook (Fig.9)
- 1) More oil is supplied as oil amount adjust screw mounted on the hook driving shaft is turned toward + in direction A. As the oil amount adjust screw is turned toward-in direction B, the amount of oil supplied will be decreased.
- 2) After adjusted, the machine must be idling for thirty seconds. It can be confirmed the state of oil supplied.



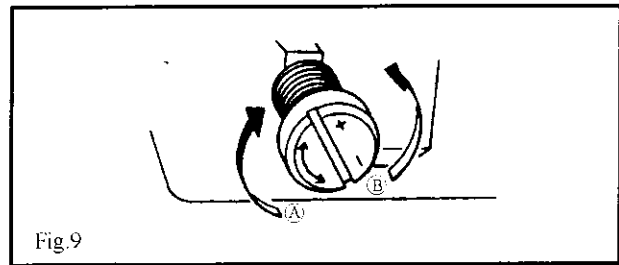
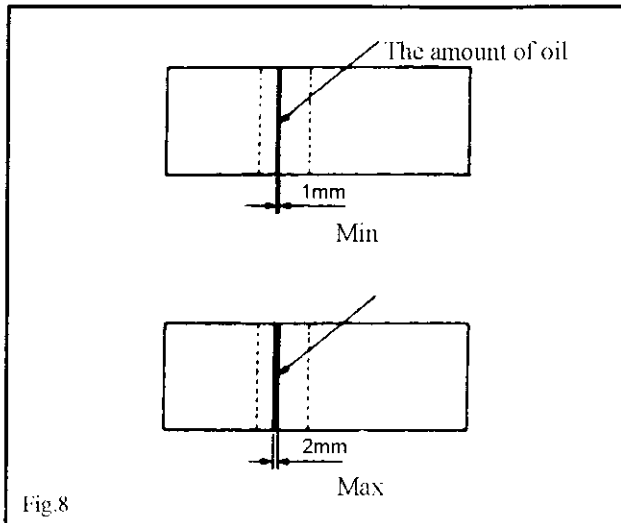
AJUSTEMENT DE LA QUANTITE D'HUILE DISPONIBLE AU NIVEAU DU CROCHET (fig 7 fig 8 fig 9)

- 1- Avant de faire l'appoint, laissez refroidir en laissant la machine inactive durant 3 minutes (la machine peut rester sous tension).
 - 2- Le **papier témoin (du niveau d'huile)** doit être inséré quand la machine est en opération. (fig 7)
 - 3- Le niveau d'huile dans la cuve à huile est confirmé par haut (high) et bas (low)
 - 4- La quantité d'huile confirmée est pour 5 secondes (utiliser une montre avec les secondes)
- la quantité d'huile correcte (fig 8)
- 1- La quantité d'huile peut être ajustée en tenant compte des différents procédés de couture, mais elle doit être toujours comprise entre le minimum et le maximum.
- * autrement le crochet risque de chauffer, ou le matériel cousu risque d'être souillé.
- 2- Utilisez le **papier témoin (du niveau d'huile)** au moins 3 fois afin de bien observer la quantité d'huile
Ajuster la vis jusqu'à atteindre la marque sur le **papier témoin (du niveau d'huile)**
- Ajustement de la quantité d'huile au niveau du crochet (fig 9)
- 1- Plus d'huile sera disponible en tournant la vis montée sur l'arbre du crochet dans la direction (A). Quand la vis d'ajustement est tournée dans la direction (B), la quantité d'huile disponible diminuera.
 - 2- Après ajustement, la machine doit être laissée inactive durant 30 secondes. Cela permettra de confirmer le niveau d'huile obtenu.

- | |
|--|
| (1) le papier témoin (du niveau d'huile)
(2) la place du témoin |
|--|

Hook = crochet Bushing = bague Base plate = base plate The amount of oil confirmed paper = le papier témoin (du niveau d'huile) Oil reservoir = réservoir d'huile
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Fig 7

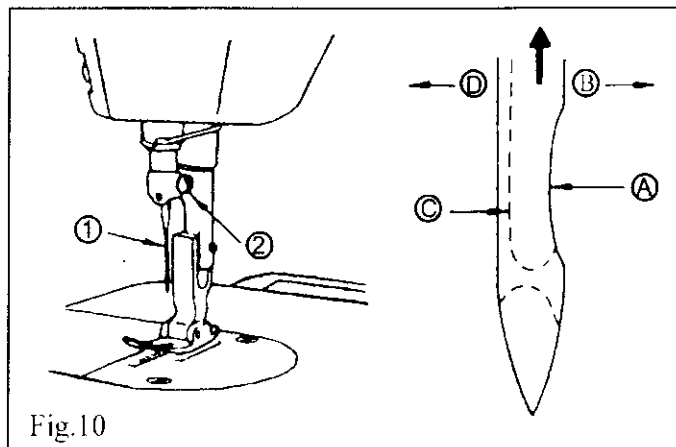


4. ATTACHING THE NEEDLE (Fig.10)

* Turn the motor power OFF before starting to attach the needle.

A needle of 1955-01 (DP × 5) #14 should be used. Select a proper needle size according to the count of thread and the type of material used.

- 1) Turn the handwheel until the needle bar reaches the highest point of its stroke.
- 2) Loosen screw ②, and hold needle ① with its indented part (A) facing exactly to the right in direction (B).
- 3) Insert the needle in the direction of the arrow until it will go no further.
- 4) Securely tighten screw ②.
- 5) Check that long groove (C) of the needle is facing exactly to the left in direction (D).

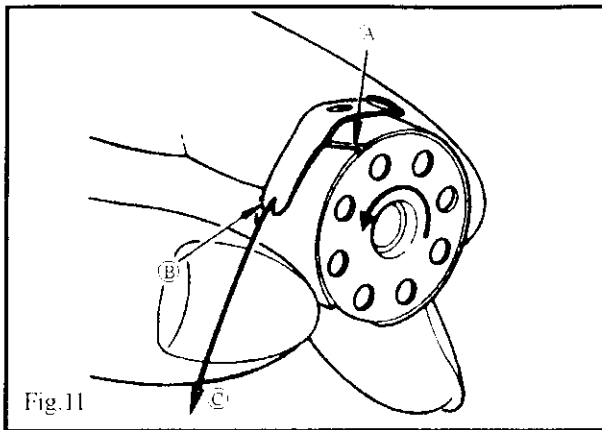


FIXATION DE L'AIGUILLE (fig 10)

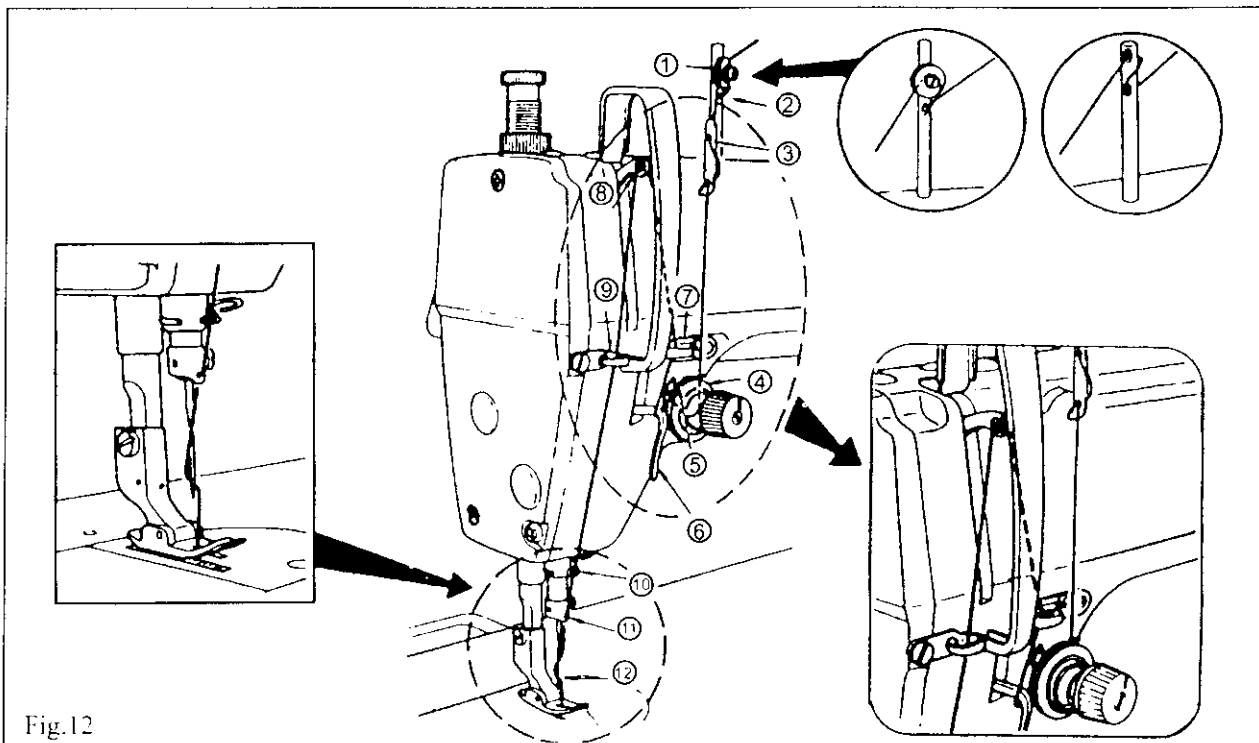
- Eteindre le moteur avant de démarrer l'opération de changement de l'aiguille.
 - Une aiguille du système 1955-01 (ou DPx5) en grosseur 14 (ou diamètre 90)
 - Sélectionnez le diamètre de l'aiguille le mieux adapté au type de fil à coudre et de matière que vous allez utiliser.
- 1- tourner le volant jusqu'à ce que la barre d'aiguille atteigne son point le plus haut.
 - 2- Desserrer la vis (2) et tenir l'aiguille (1) avec la partie du dégagement (A) placée exactement à droite dans la direction (B)
 - 3- Insérer l'aiguille dans la direction de la flèche jusqu'à ce qu'elle ne bouge plus.
 - 4- Serrer la vis pour maintenir correctement l'aiguille (2)
 - 5- Vérifier que la rainure longue © de l'aiguille soit placée exactement à gauche dans la direction (D)

5. SETTING THE BOBBIN INTO THE BOBBIN CASE (Fig.11)

- 1) Hold the bobbin in a way that the thread open end is directed to the left as observed from you, and set the bobbin into the bobbin case.
- 2) Pass the thread through thread slit **A**, and pull the thread in direction **C**. By so doing, the thread will pass under the tension spring and come out from notch **B**.
- 3) Check that the bobbin rotates in the direction of the arrow when thread **C** is pulled.



6. THREADING THE MACHINE HEAD (Fig.12)



PLACEMENT DE LA CANETTE DANS LE BOITIER A CANETTE

(fig 11)

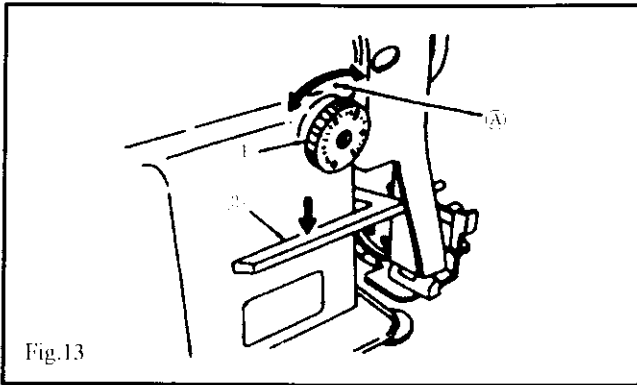
- 1- tenir la canette dans une manière telle que la fin du fil soit dirigée vers la gauche comme observé lors de la mise en place de la canette dans le boîtier à canette.
- 2- Passer le fil à travers la fente (A), et tirer le fil dans la direction (C). En faisant cela le fil passera sous le ressort de tension et viendra hors de l'encoche. (B)
- 3- Verifier que la canette tourne dans la direction de la flèche une fois que le fil © est tiré.

ENFILAGE DE LA TETE DE MACHINE

(fig 12)

7. ADJUSTING THE STITCH LENGTH (Fig.13)

- 1) Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot **A** on the machine arm.
- 2) The dial calibration is in millimeters.
- 3) When you want to decrease the stitch length, turn stitch length dial ① while pressing feed lever ② in the direction of the arrow.



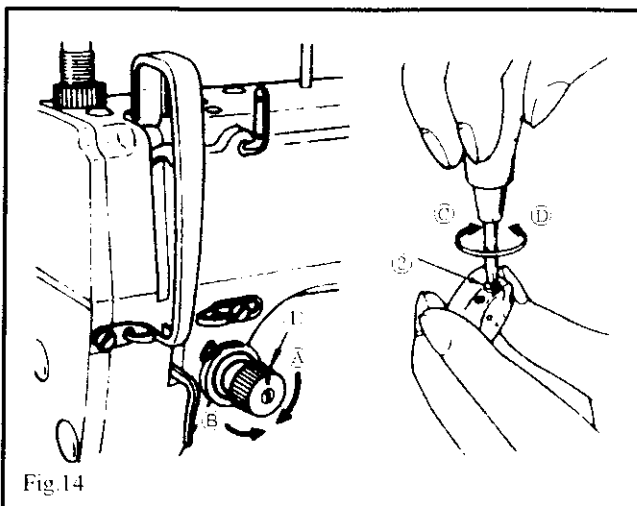
8. THREAD TENSION (Fig.14)

1. Adjusting the needle thread tension

- 1) Adjust the needle thread tension using tension adjust nut ① according to the sewing specifications.
- 2) As you turn nut ① clockwise (in direction **A**), the needle thread tension will increase.
- 3) As you turn nut ① counterclockwise (in direction **B**), the tension will decrease.

2. Adjusting the bobbin thread tension

- 1) As you turn tension adjust screw ② clockwise (in direction **C**), the bobbin thread tension will increase.
- 2) As you turn screw ② counterclockwise (in direction **D**), the bobbin thread tension will decrease.



ADAPTATION DE LA LONGUEUR DE POINT

(fig 13)

1- tourner le bouton de réglage de longueur de point (1) dans la direction de la flèche, et aligner vous sur la chiffre désiré (A) marqué sur le bras de la machine.

2- les longueurs de point sont calibrée en millimètre.

3- quand vous souhaitez réduire la longueur du point, tourner le bouton de réglage (1) pendant que vous presser le levier de la griffe (2) dans la direction de la flèche.

TENSION DU FIL A COUDRE

1- ajustement de la tension du fil à l'aiguille

1- ajuster la tension du fil à l'aiguille en jouant sur la molette de réglage de tension (1) en tenant compte des spécifications de couture.

2- quand vous tournez la molette de réglage (1) dans le sens des aiguilles d'une montre (dans la direction (A)), la tension du fil à l'aiguille augmentera.

3- quand vous tournez la molette de réglage (1) dans le sens contraire des aiguilles d'une montre (dans la direction (B)), la tension du fil à l'aiguille diminuera.

4- ajustement de la tension du fil à l'aiguille

2- ajustement de la tension du fil à la canette

1- quand vous tournez la vis de réglage (2) dans le sens des aiguilles d'une montre (dans la direction (C)), la tension du fil à la canette augmentera

2- quand vous tournez la vis de réglage (2) dans le sens contraire des aiguilles d'une montre (dans la direction (D)), la tension du fil à la canette diminuera.

9. THREAD TAKE-UP SPRING (Fig.15)

1. Changing the stroke of thread take-up spring ①

1) Loosen setscrew ②.

2) As you turn tension post ③ clockwise (in direction Ⓐ), the stroke of the thread take-up spring will be increased.

3) As you turn the knob counterclockwise (in direction Ⓑ), the stroke will be decreased.

2. Changing the pressure of thread take-up spring ①

1) Loosen setscrew ②, and take out tension asm. ⑤.

2) Loosen setscrew ④.

3) As you turn tension post ③ clockwise (in direction Ⓐ), the pressure will be increased.

4) As you turn the post counterclockwise (in direction Ⓑ), the pressure will be decreased.

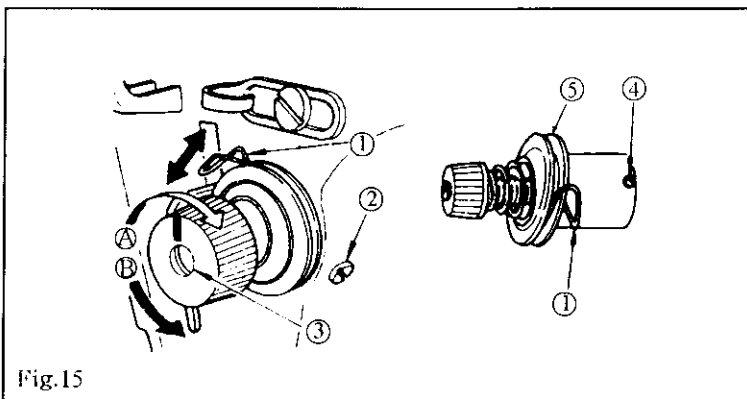


Fig.15

10. HAND LIFTER (Fig.16)

1) To stop the machine with its presser foot up, turn hand lifter ① in direction Ⓐ.

2) The presser foot will go up about 5.5mm and stop.

3) The presser foot will go back to its original position when hand lifter ① is turned down in direction Ⓑ.

4) Using the knee lifter, you can get the standard presser foot lift of about 10mm and a maximum lift of about 13mm.

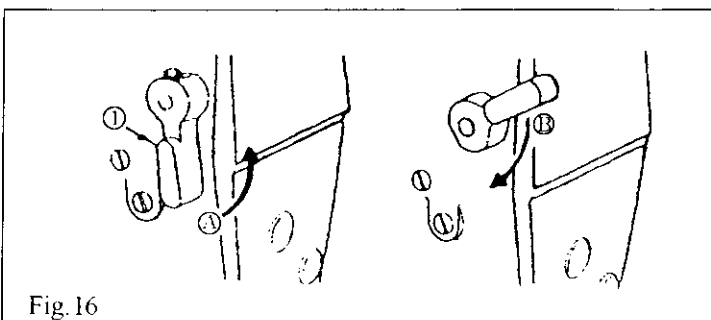
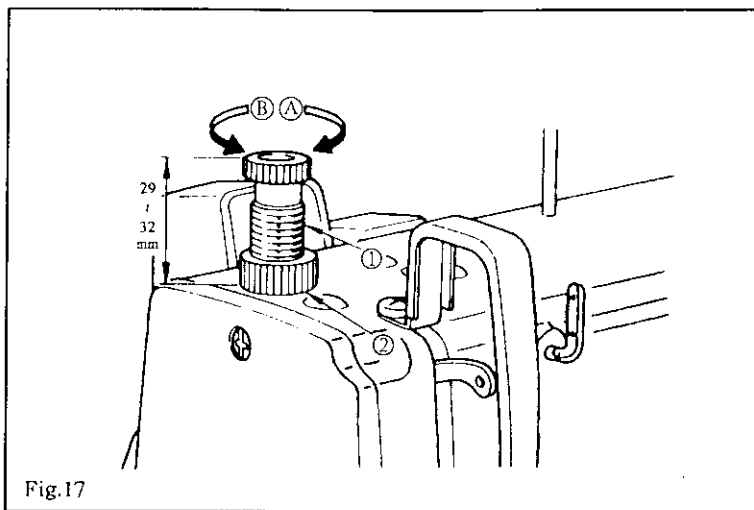


Fig.16

11. PREASSER FOOT PRESSURE (Fig.17)

- 1) Loosen nut ②. As you turn presser spring regulator ① clockwise (in direction Ⓐ), the presser foot pressure will be increased.
- 2) As you turn the presser spring regulator counterclockwise (in direction Ⓑ), the pressure will be decreased.
- 3) After adjustment, tighten nut ②.
- 4) For general fabrics, the standard height of the presser spring regulator is 29 to 32 mm (5kg). (For the model 2691D300A it is 7kg)



12. ADJUSTING THE FEED TIMING (Fig.18)

- 1) Loosen two setscrews ② and ③ on feed eccentric cam ①, properly position the eccentric cam. Then retighten the setscrews.
 - 2) To obtain the standard feed timing, when the feed dog is dropping from the throat plate, align the top of the feed dog with the top of the hole on the needle and the top of the throat plate.
 - 3) To advance the feed timing in order to prevent uneven material feed, move the feed eccentric cam in the direction of the arrow.
 - 4) To delay the feed timing in order to increase stitch tightness, move the feed eccentric cam in the opposite direction from the arrow.
- * If moving the feed eccentric cam to far, the needle will be break.

REGLAGE DU PIED PRESSEUR

(fig 17)

1- relâcher l'écrou (2). Comme vous tourné le régulateur du ressort (1) dans le sens des aiguilles d'une montre (dans la direction (A)), la pression du pied presseur augmentera.

2- Comme vous tourné le régulateur du ressort (1) dans le sens contraire des aiguilles d'une montre (dans la direction (B)), la pression du pied presseur diminuera.

3- Après ajustement, bien resserrer l'écrou (2)

4- pour les tissus standards, la hauteur du régulateur du ressort de pression est de 29 à 32 millimètre (5 Kg). Pour le modèle 2691D300A elle est de 7 Kg.

AJUSTEMENT DES GRIFFES D'ENTRAÎNEMENT ??????

- 1- relâcher les 2 vis de fixation (2) et (3) sur la came d'entraînement excentrique, ensuite positionner correctement la came d'entraînement, et puis bien resserrer les de vis de fixation.
 - 2- Pour obtenir un bon réglage de séquence d'entraînement des griffes, quand la griffe est en position basse sur la plaque, il faut aligner le dessus de la griffe avec le dessus du chas de l'aiguille et la dessus de la plaque.
 - 3- Pour avancer la séquence d'entraînement des griffes, afin d'éviter une superposition irrégulière du matériel, il faut bouger la came d'entraînement excentrique dans la direction de la flèche.
 - 4- Pour retarder la séquence d'entraînement des griffes, afin d'augmenter le serrage des points de couture, il faut bouger la came d'entraînement excentrique dans la direction opposée à la flèche.
- Attention : si vous bouger la came d'entraînement trop loin, l'aiguille cassera.

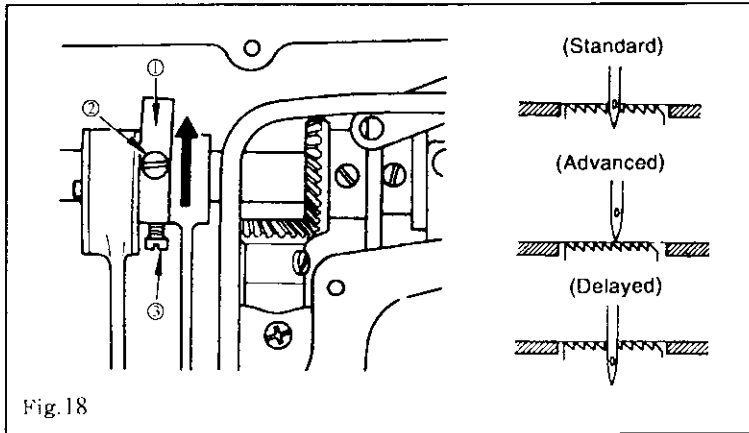


Fig.18

13. HEIGHT OF THE FEED DOG (Fig.19)

- 1) The feed dog is factory-adjusted so that it juts out from the throat plate surface 0.75mm to 0.85mm.
For the 2691D300A, 0.95mm to 1.05mm.
- 2) If the feed dog juts out too much, puckering may result when sewing light-weight materials.
(Recommended protrusion: 0.7mm to 0.8mm.)
- 3) To adjust the height of the feed dog:
 - (1) Loosen screw ② of crank ①.
 - (2) Move the feed bar up or down to make adjustment.
 - (3) Securely tighten screw ②.

* Precaution

If the screw is tighten too securely, the crank will be abraded.

a Feed dog b Throat plate

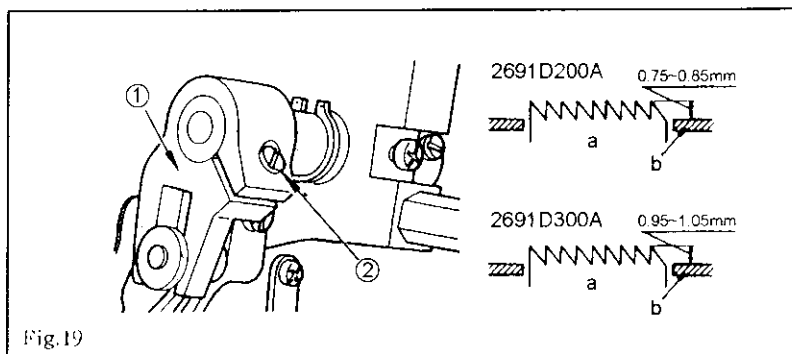


Fig.19

14. NEEDLE-TO-HOOK RELATIONSHIP

1. Adjust the timing between the needle and the hook as follows:

1) Turn the handwheel to bring the needle bar down to the lowest point of its stroke, and loosen setscrew ①.

* Adjusting the needle bar height

2) Align marker line (A) on needle bar ② with the bottom end of needle bar lower bushing ③, then tighten setscrew ①.

* Adjusting position (a) of the hook

3) Loosen the two hook setscrews, turn the hand wheel, and align marker line (B) on the needle bar ② with the bottom end of needle bar lower bushing ③.

4) After making the adjustments mentioned in the above steps align hook blade point ⑤ with the center of needle ④. Provide a clearance of 0.04mm to 0.1mm between the needle and the hook, then securely, tighten the hook setscrews.

* Precaution

If the clearance is too small, the tip of the hook will be abraded. If it is too big, it will lead to skip over.

* Note that the type of hook to be substituted for, when replacing the hook, shall be in conformity with the very type of the hook installed in the sewing machine of original assemblage.

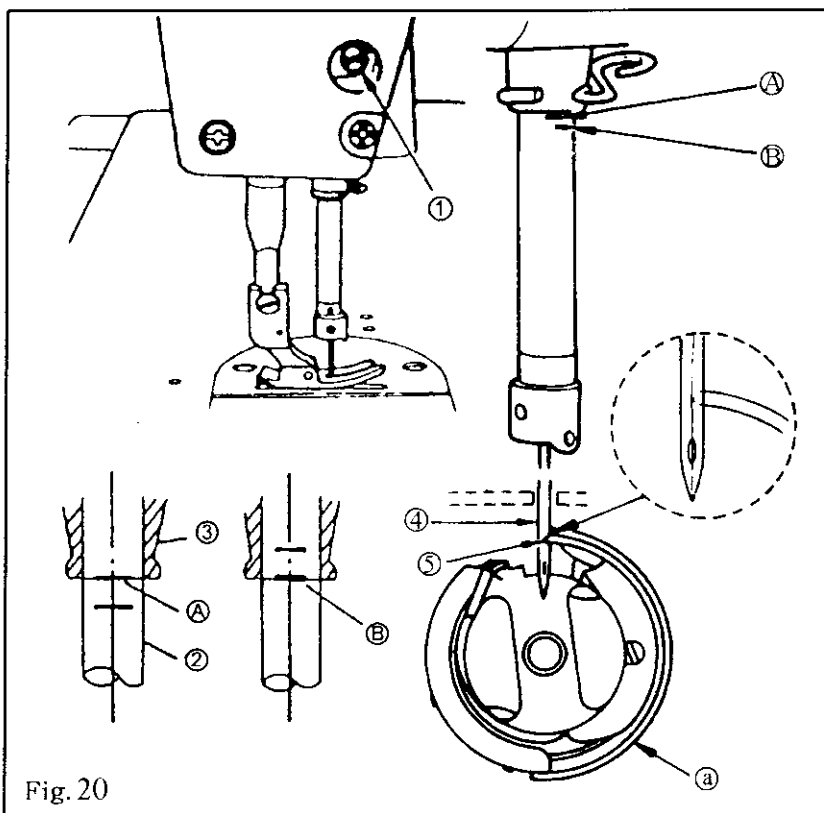
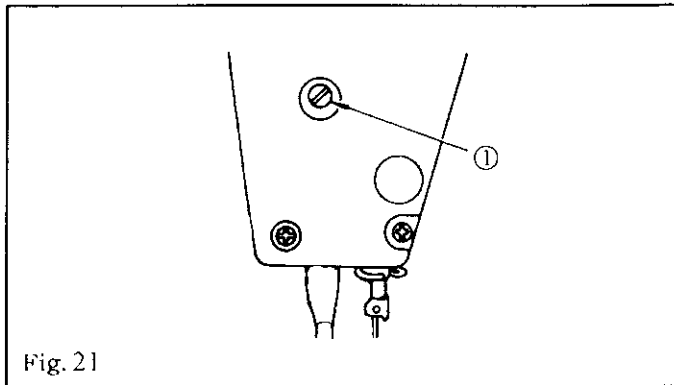


Fig. 20

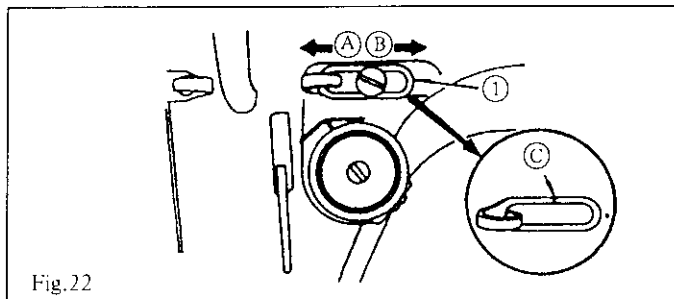
15. ADJUSTING THE HEIGHT OF THE PRESSER BAR (Fig.21)

- 1) Loosen setscrew ①, and adjust the presser bar height and the angle of the presser foot.
- 2) After adjustment, securely tighten the setscrew.



16. ADJUSTING THE THREAD TAKE-UP STROKE (Fig.22)

- 1) When sewing heavy-weight materials, move thread guide ① to the left in direction ④ to increase the length of thread pulled out by the thread take-up.
- 2) When sewing light-weight materials, move thread guide ① to the right in direction ⑤ to decrease the length of thread pulled out by the thread take-up.
- 3) When the marker line ③ on the thread guide ① is aligned with the center of the screw, it is standard.

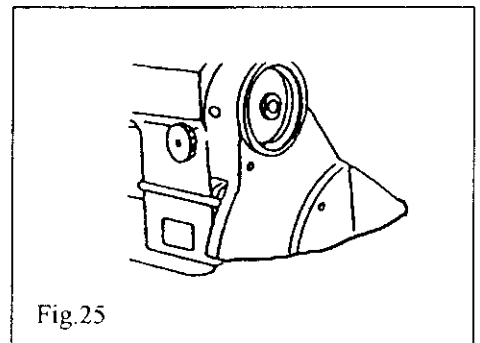
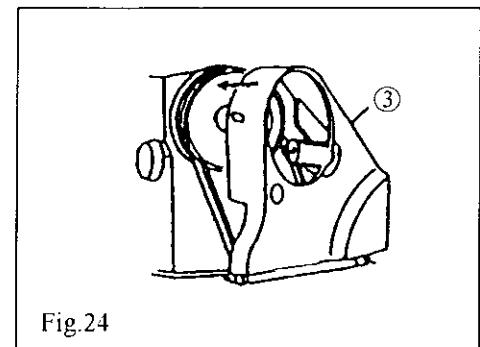
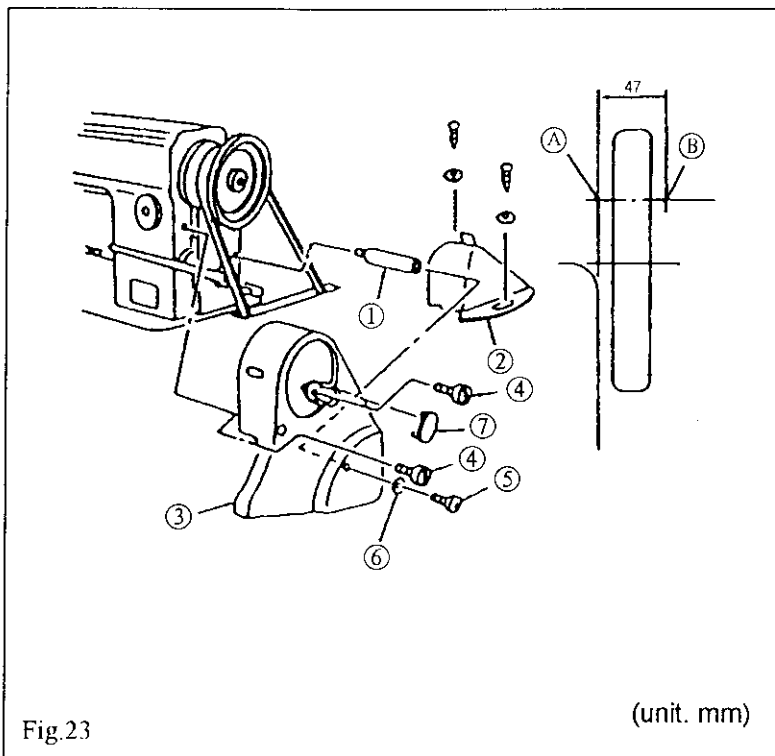


17. INSTALLING THE BELT COVER AND THE BOBBIN WINDER

(Fig. 23, Fig. 24, Fig. 25)

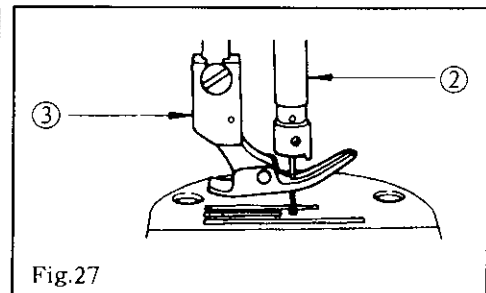
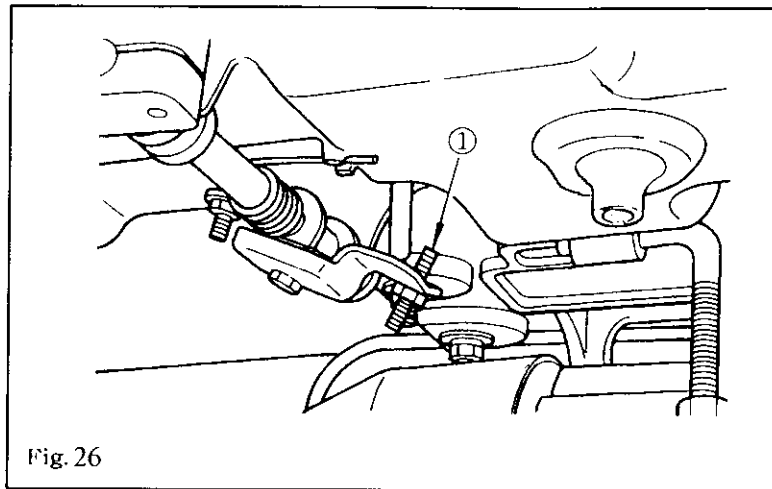
1. Installing procedure

- 1) Drill two wooden screw guide holes **A** and **B** in the machining table.
- 2) Insert support **1** in the tapped hole in the arm.
- 3) Install the front belt cover **3**, get the hand wheel in the middle of the hole.
- 4) Install the back belt cover **2** at **A** and **B**.
- 5) Using the screws **4**, **5** and washer **6**, fix the front belt cover **3** on the support the tightening torque for the screw **4** is about 30 kgfcm, for the screw **5** is about 25 kgfcm.
- 6) Fix the cover **7**.
- 7) Move the back belt cover **2** backward until its rubber touches the front belt cover **3**, then move further more 0.5 ~ 1mm, fix it using the wooden screws and washers.



18. ADJUSTING THE HEIGHT OF THE KNEE LIFTER (Fig.26, Fig. 27)

- 1) The standard height of the presser foot lifted using the knee lifter is 10mm.
- 2) You can adjust the presser foot lift up to 13mm using knee lifter adjust screw ①.
- 3) When you have adjusted the presser foot lift to over 10mm, be sure that the bottom end of needle bar ② in its lowest position does not hit presser foot ③.



19. SPECIFICATIONS

	Model 2691D200A	Model 2691D300A
Application	For medium-weight materials	For heavy-weight materials
Sewing speed	Max. 5,500 s.p.m.	Max. 5,000 s.p.m.
Stitch length	Max. 5mm	Max. 5mm
Presser foot lift (by knee lifter)	10mm (standard) 13mm (max.)	10mm (standard) 13mm (max.)
Needle	1955-01 (DP × 5)#14	1955-01 (DP × 5)#18
Lubricating oil	SINGER "C" oil	