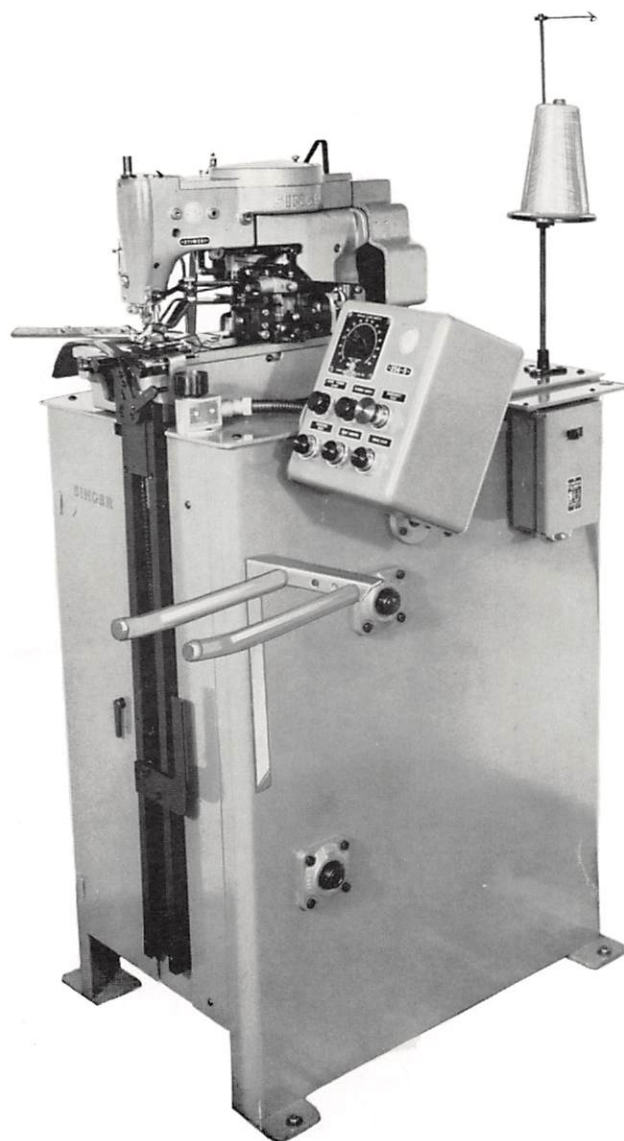


INSTRUCTIONS FOR USING  
**SINGER\***  
AUTOMATIC SEQUENTIAL BUTTONHOLE UNIT  
MACHINE No. 256-5



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**THE SINGER COMPANY**

## DESCRIPTION OF UNIT 256-5

- Composed of Sewing Machine No. 271W201 mounted on a steel cabinet which houses Electro-Mechanical Device No. 257464.
- Designed to make straight purl stitch buttonholes with square barred ends in fabrics such as cotton, linen, silk and rayon...ideal for shirts, dresses, pajamas, etc.
- Automatically spaces, sews and cuts a pre-determined number of buttonholes per garment...all in a single operation.
- Space between buttonholes adjustable from 2-1/2" to 5-1/4".
- Distance of buttonhole to facing edge adjustable from 3/8" to 1".
- Knives supplied will cut buttonholes 9/16" long, unless otherwise ordered.
- Machine regularly equipped with stitch gear for 120 stitches per buttonhole. Stitch gears for 60 to 360 stitches will be furnished when specified.

## TO OIL THE MACHINE

See Instruction Form supplied with 271W201 Machine.

## THREAD

Use right twist thread in the needle. Either left or right twist may be used on the bobbin.

Use heavier thread in the needle than that used on the bobbin. For example, use No. 40/6 cord cotton thread in the needle and No. 80/3 cord cotton thread on the bobbin.

## NEEDLES

Use needles of Class and Variety Cat. 1526 (71x1) made in sizes 9, 10, 11, 12, 13, 14, 16, 17, 18, 19, 21, 22 and 23. Size of needle is determined by size of thread used. Thread must pass freely through needle eye.

## TO REMOVE BOBBIN

See Instruction Form supplied with 271W201 Machine.

## TO THREAD AND REPLACE BOBBIN CASE

See Instruction Form supplied with 271W201 Machine.

## TO PREPARE TO SEW

NOTE: With machine set to sew 120 stitches per buttonhole, the average paper bobbin will complete approximately 240 buttonholes.



Fig. 2. Control Panel and Starting Switch

1. After determining the number of buttonholes a full bobbin will sew, press button A, Fig. 2 and set red stop dial B to this pre-determined number. Release button A. Then set black counter arrow C directly over stop dial B.
2. Turn on Main Power Switch D, Fig. 2...the "MAIN POWER START" Indicator, Fig. 2, will light.
3. Press "DRIVE START" Fig. 2...motor will start and magnetic clutch will engage. The unit is now ready to sew.

## TO START SEWING

NOTE: Be sure cabinet door is closed before starting to sew.

4. Place garment under work clamp with facing edge against guide E, Fig. 3 and end of garment at guide F.
5. Close upper gripper jaw G, Fig. 3 by pushing lever H to the right.
6. Apply a slight amount of tension to the garment to remove all slack between gripper jaws and work clamp.
7. Press Auto Start J, Fig. 3...Work clamp lowers and machine starts to sew.

When stitching of buttonhole is completed, the knife descends to cut buttonhole, the work clamp raises, the garment is fed to the next position and another buttonhole is started...all automatically.



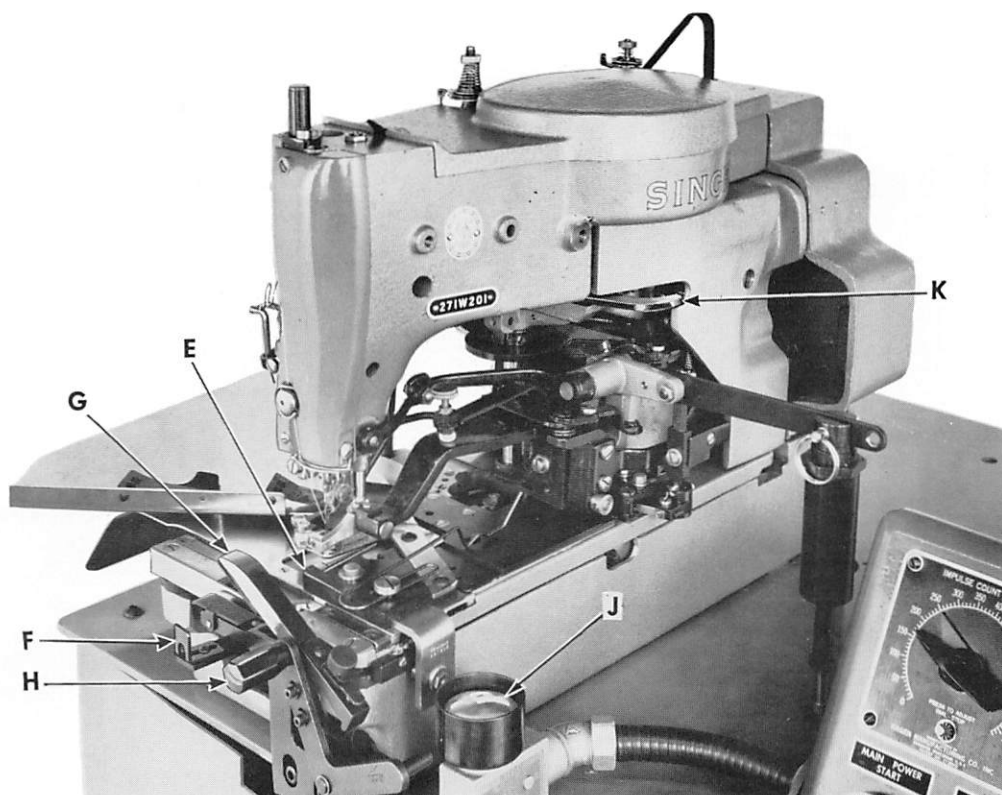


Fig. 3. To Start Sewing

8. At the completion of the cycle (garment finished), the work clamp raises and gripper jaw G, Fig. 3 opens to release garment.
9. Re-load with next garment...press Auto Start J, Fig. 3 and machine will automatically complete the second garment.
10. After the pre-set number of buttonholes has been sewn, counter arrow C, Fig. 2 reaches "O" on dial, "BOBBIN EMPTY" indicator Fig. 2 lights and Auto Start J, Fig. 3 becomes inoperative (operator cannot start a new cycle).
11. Remove empty bobbin, replace with full bobbin, re-set counter arrow C, Fig. 2 and the machine is again ready to sew. (See Step 4.)

NOTE: If needle thread breaks at any point during the stitching cycle, the machine will automatically stop without the knife descending. The operator then has the choice of (a) going back to complete the unfinished buttonhole or (b) continuing on to the next buttonhole.

- (a) To complete unfinished buttonhole, re-thread machine and operate hand ratchet lever K, Fig. 3 until work clamp moves garment to desired position. Pull manual starting lever L, Fig. 4 and the machine will complete the unfinished buttonhole, then automatically continue its regular cycle.
- (b) To continue on to next buttonhole, merely re-thread machine and press "INDEXING RE-SET"...machine will continue its regular cycle and the unfinished buttonhole can be repaired later.

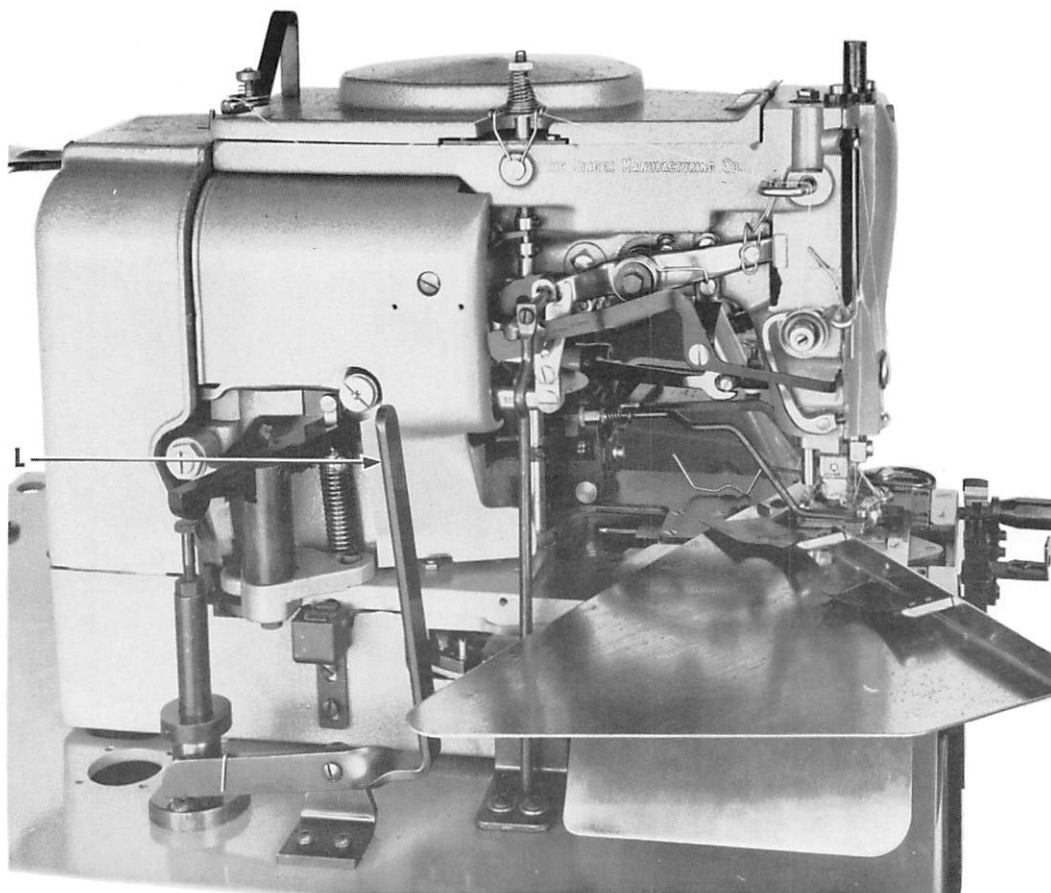


Fig. 4. Manual Starting Lever

#### TO ADJUST DISTANCE BETWEEN BUTTONHOLE AND FACING EDGE OF GARMENT

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The distance from buttonhole to facing edge of garment is adjustable from  $\frac{3}{8}$ " to 1". To adjust, loosen the two screws in edge guide E, Fig. 3 and move guide to left or right as desired, then tighten the screws.

#### TO ADJUST DISTANCE BETWEEN FIRST BUTTONHOLE AND LEADING EDGE OF GARMENT

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Loosen Allen screw which holds guide B, Fig. 2 and move guide in or out as desired, then tighten the screw.

#### TO ADJUST SPACE BETWEEN BUTTONHOLES

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1. Loosen the 6 gib screws in slide M, Fig. 5 only enough to permit slide block N, Fig. 5 to be moved by means of adjusting screw P.
2. Using "T" wrench supplied, turn adjusting screw P until slide block is approximately centered in its slideway.
3. Loosen the two hex head screws in face of index cam and set adjustable lobe Q to desired eccentricity.



NOTE:  $1/16''$  of eccentricity equals approximately  $3/8''$  of space between buttonholes. Therefore, a  $5/8''$  offset of lobe Q will produce  $3-3/4''$  of space between the corresponding end of each buttonhole.

After setting lobe Q, tighten the two hex head screws.

4. Before tightening the 6 gib screws, test spacing on a sample piece of material. If necessary, make "fine" adjustment by means of screw P. Turn screw P clockwise to increase spacing or counter-clockwise to decrease spacing.

NOTE: One complete turn of screw P equals approximately  $1/64''$  of space.

5. Tighten the 6 gib screws in slide M, Fig. 5 and lock these screws in place by means of their respective lock nuts.

#### TO STOP MACHINE AT ANY POINT DURING ITS CYCLE

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Press "EMERGENCY STOP" Fig. 2.

When desired, machine can be started again without disturbing its cycle simply by pressing "DRIVE START" Fig. 2.

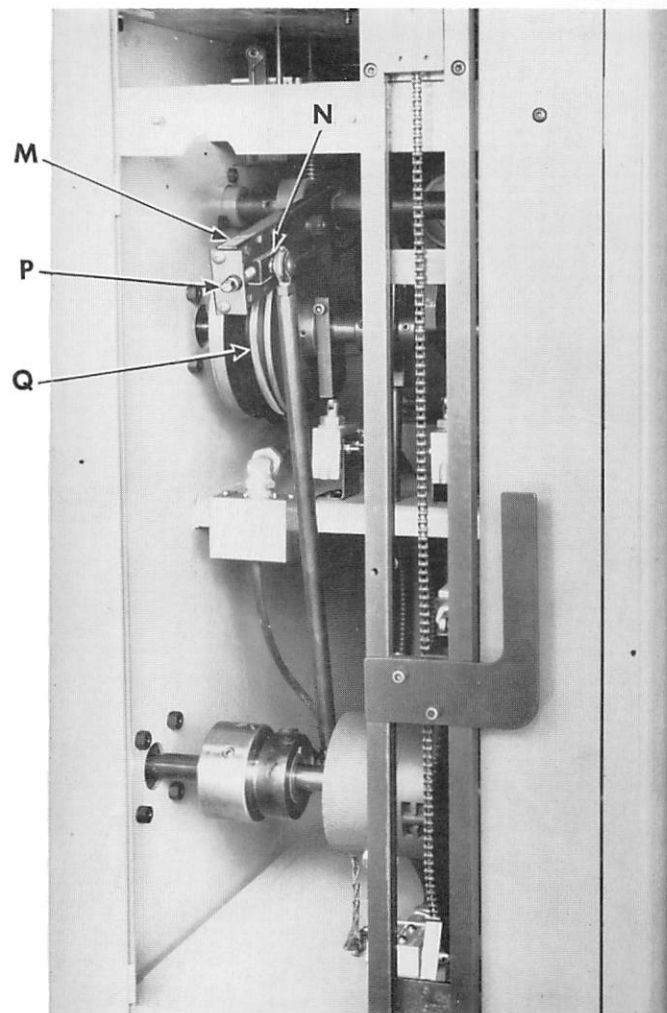


Fig. 5. Adjusting Space between Buttonholes