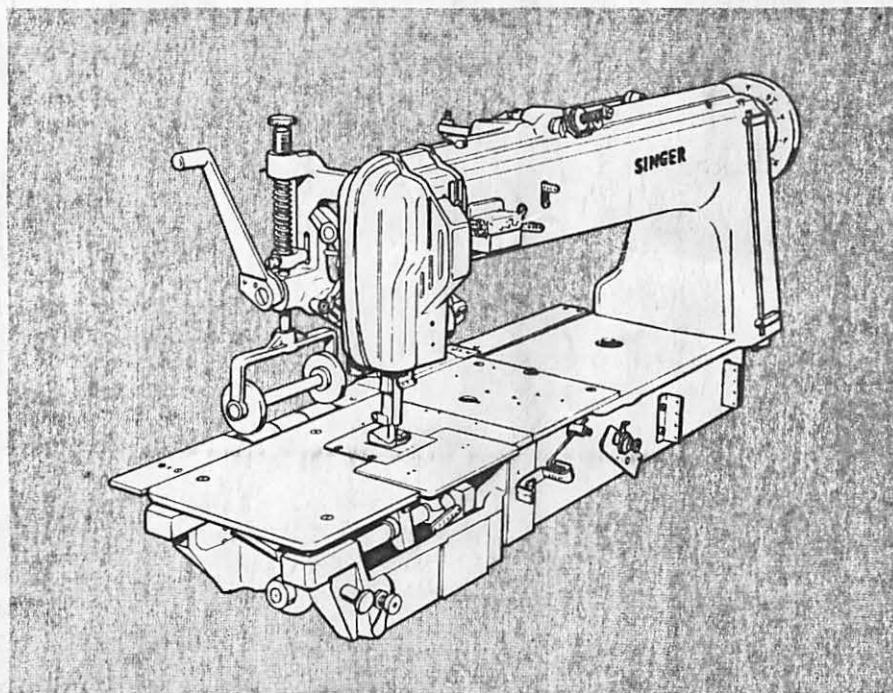


Form 21490 (167)
Supplement to
Form 21331 and 21488

PARTS LIST AND INSTRUCTIONS FOR ADJUSTING
SINGER*
PULLER FEED KIT No. 32709
FOR USE WITH 320W194 MACHINE



THE SINGER COMPANY

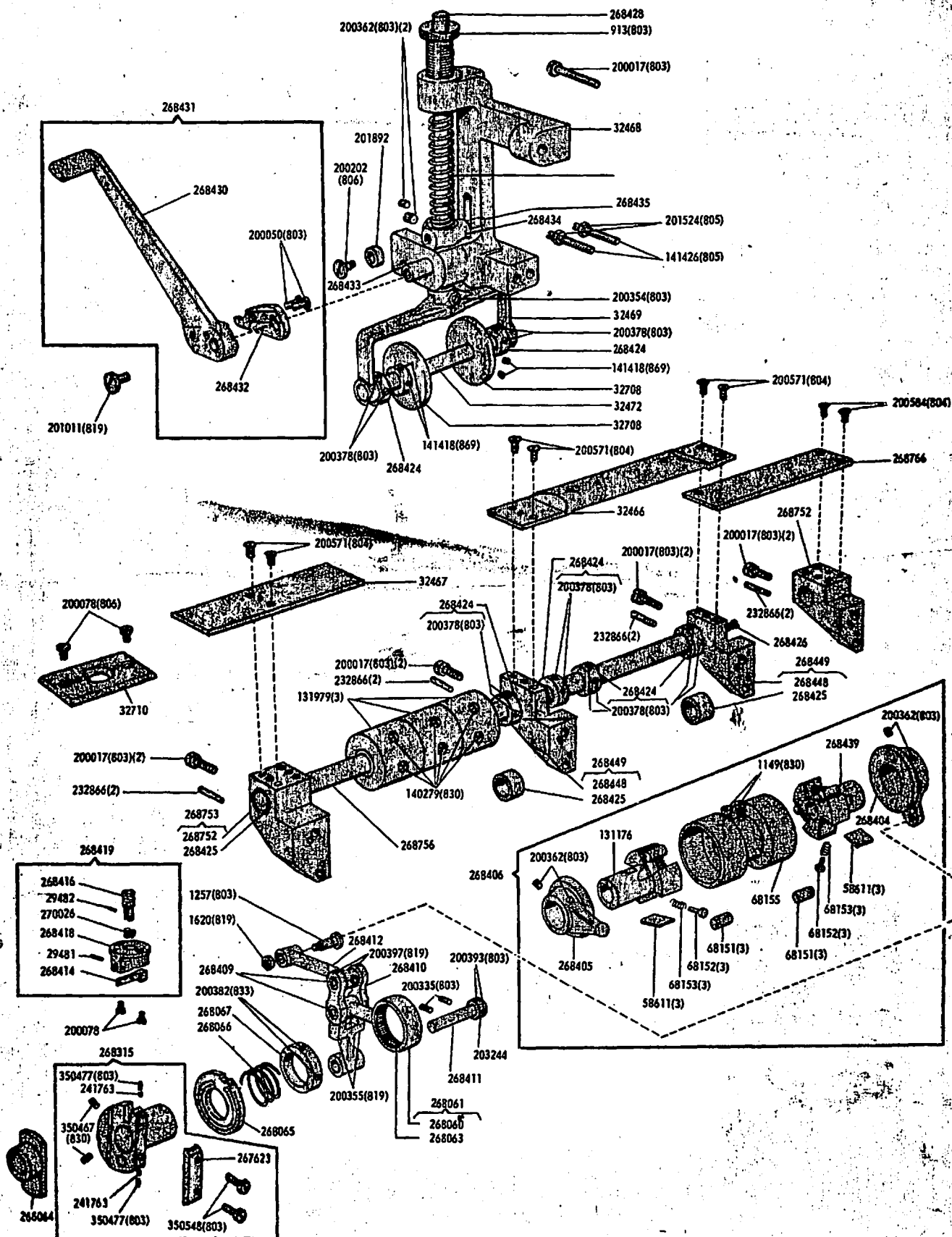
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**NUMERICAL LIST OF PARTS
FOR PULLER FEED KIT NO. 32709**

PART NO.	DESCRIPTION	PART NO.	DESCRIPTION
913(803)	Puller Feed Roll (upper) Bar Spring	200202(806)	Puller Feed Roll (upper) Bar Lifter
1149(830)	Puller Feed Clutch Sleeve Set Screw (2)	200335(803)	Roller Screw Stud
1257(803)	Puller Feed Driving Link Hinge Screw	200335(803)	Puller Feed Driving Lever Hinge
1620(819)	Puller Feed Driving Link Hinge Screw Nut	200354(803)	Stud Set Screw (2)
29481	Anti-Reversing Roller Clutch Releasing	200355(819)	Puller Feed Roll (upper) Bracket Set Screw
29482	Latch Hinge Pin	200355(819)	Puller Feed Driving Connection Hinge
29482	Anti-Reversing Roller Clutch Releasing	200362(803)	Pin Set Screw
32466	Latch Stud Pin	200362(803)	Puller Feed Clutch Driving Flange
32467	Puller Feed Cover Plate (center)	200362(803)	Set Screw (2)
32468	Puller Feed Cover Plate (left)	200362(803)	Puller Feed Clutch Retaining Flange
32468	Puller Feed Roll (upper) Bar Bracket with	200378(803)	Set Screw (2)
32469	268433	200378(803)	Puller Feed Roll (upper) Shaft Collar
32472	Puller Feed Roll (upper) Bracket with	200378(803)	Set Screw (4)
32708	200354(803)	200378(803)	Puller Feed Roll (lower) Shaft Collar
32710	Puller Feed Roll (upper) Shaft	200382(803)	Set Screw (8)
58611	Puller Feed Roll (upper, nylon) with two	200382(803)	Puller Feed Driving Eccentric Adjusting
68151	141418(869) (2)	200386(803)	Disc Spring Collar Set Screw (2)
68152	Anti-Reversing Roller Clutch Releasing	200386(803)	Puller Feed Clutch Retaining Flange
68153	Latch Stud Socket Support	200393(803)	Holding Screw (2)
68155	Puller Feed Clutch Roller Wear Plate (6)	200393(803)	Puller Feed Driving Lever Hinge Stud
131176	Puller Feed Clutch Roller (6)	200397(819)	Collar Set Screw (2)
131979	Puller Feed Clutch Roller Plunger (6)	200397(819)	Puller Feed Driving Link Hinge Pin
140279(830)	Puller Feed Clutch Roller Spring (6)	200571(804)	Set Screw
141418(869)	Puller Feed Clutch Sleeve with	200584(804)	Puller Feed Cover Plate Screw (6)
141426(805)	two 1149(830)	201011(819)	Puller Feed Cover Plate (right) Screw (2)
200017(803)	Puller Feed Roll (lower) Clutch Brake	201524(805)	Puller Feed Roll (upper) Bar Lifter
200017(803)	Puller Feed Roll (lower) with two	201892	Cap Screw
200050(803)	140279(830) (3)	203244	Puller Feed Roll (upper) Bar Bracket
200078(806)	Puller Feed Roll (lower) Set Screw (6)	232866	Support Screw Nut (2)
	141418(869) Puller Feed Roll (upper, nylon) Set Screw (4)	241763	Puller Feed Roll (upper) Bar Lifter Roller
	141426(805) Puller Feed Roll (upper) Bar Bracket	267623	Puller Feed Driving Lever Hinge Stud
	Support Screw (2)	268060	Collar with two 200393(803)
	200017(803) Puller Feed Roll (upper) Bar Bracket Screw	268061	Bed Hinge Connection Bracket Position Pin (8)
	200017(803) Bed Hinge Connection Bracket Screw (8)		Puller Feed Driving Eccentric Friction Plate
	200050(803) Puller Feed Roll (upper) Bar Lifter		Screw Set Screw Packing (2)
	Cam Plate Screw (2)		Puller Feed Driving Eccentric Friction Plate
	200078(806) Anti-Reversing Roller Clutch Releasing		Puller Feed Driving Connection
	Latch Stud Socket Support Screw (2)		Puller Feed Driving Connection 268060
			with 268063

PART NO.	DESCRIPTION	PART NO.	DESCRIPTION
268063	Puller Feed Driving Connection Needle Bearing	268428	Puller Feed Roll (upper) Bar
268064	Puller Feed Driving Eccentric	268430	Puller Feed Roll (upper) Bar Lifter
268065	Puller Feed Driving Eccentric Adjusting Disc	268431	Puller Feed Roll (upper) Bar Lifter 268430 with 268432 and two 200050(803)
268066	Puller Feed Driving Eccentric Adjusting Disc Spring	268432	Puller Feed Roll (upper) Bar Lifter Cam Plate
268067	Puller Feed Driving Eccentric Adjusting Disc Spring Collar with two 200382(833)	268433	Puller Feed Roll (upper) Bar Lifter Stop Pin
268315	Puller Feed Driving Flange with 267623, two each 241763, 350467(830), 350477(830) and 350548(803)	268434	Puller Feed Roll (upper) Bar Position Bracket with 268435 and two 200362(803)
268404	Puller Feed Clutch Driving Flangewi with two 200362(803)	268435	Puller Feed Roll (upper) Bar Position Bracket Stud
268405	Puller Feed Clutch Retaining Flange with two 200362(803)	268436	Puller Feed Roll (upper) Bar Spring
268406	Puller Feed Clutch complete with 68155, 131176, 268404, 268405, 268439, and six each 58611, 68151, 68152 and 68153	268439	Puller Feed Clutch Retaining Spider
268409	Puller Feed Driving Connection Hinge Pin (2)	268448	Puller Feed Roll (lower) Shaft Bracket (2)
268410	Puller Feed Driving Lever with two each 200355(819) and 200397(819)	268449	Puller Feed Roll (lower) Shaft Bracket 268448 with 268425(2)
268411	Puller Feed Driving Lever Hinge Stud	268752	Bed Hinge Connection Bracket (right)
268412	Puller Feed Driving Link	268753	Bed Hinge Connection Bracket (left) with 268425
268414	Puller Feed Regulating Latch	268756	Puller Feed Roll (lower) Shaft with 268426
268416	Puller Feed Regulating Stud	268766	Puller Feed Cover Plate (right)
268418	Puller Feed Regulating Stud Socket	270026	Puller Feed Regulating Stud Spring
268419	Puller Feed Regulating Stud Socket 268418 with 29481, 29482, 268414, 268416 and 270026	350467(830)	Puller Feed Driving Flange Set Screw (2)
268424	Puller Feed Roll (lower) Shaft Collar with eight 200378 (4)	350477(803)	Puller Feed Driving Eccentric Friction Plate Screw Set Screw
268424	Puller Feed Roll (upper) Shaft Collar with four 200378 (2)	350548(803)	Puller Feed Driving Eccentric Friction Plate Screw (2)
268425	Puller Feed Roll (lower) Shaft Needle Bearing (2)	32709	Puller Feed Kit complete, Nos. 913(813), 1257(803), 1620(819), 32466, 32467, 32468, 32469, 32472, 32710, 200202(806), 201011(819), 201892, 203244, 268061, 268064, 268065, 268066, 268067, 268315, 268406, 268410, 268411, 268412, 268419, 268428, 268431, 268434, 268436, 268752, 268753, 268756, 268766, two each 32708, 141426(805), 200335(803), 200386(803), 200584(804), 201524(805), 268409, 268449, three 131979, four 200078(806), six each 200571(804), 268424, eight 232866 and nine 200017(803)
268426	Puller Feed Roll (lower) Shaft Oil Packing (wick)		

TO ADJUST THE PULLER FEED:

The Puller Feed Kit installed on the SINGER 320W194 long arm; alternating presser machine is factory-set to feed material slightly faster than does the compound feed of the machine so that the resultant "pulling" action of the feed rolls produces a slight tension on the material between these rolls and the compound feed itself.

The puller feed mechanism is actuated by an eccentric on the bed-shaft. When changing stitch length, the amount of its feeding movement can be regulated automatically in relation to the compound feed movement as follows:

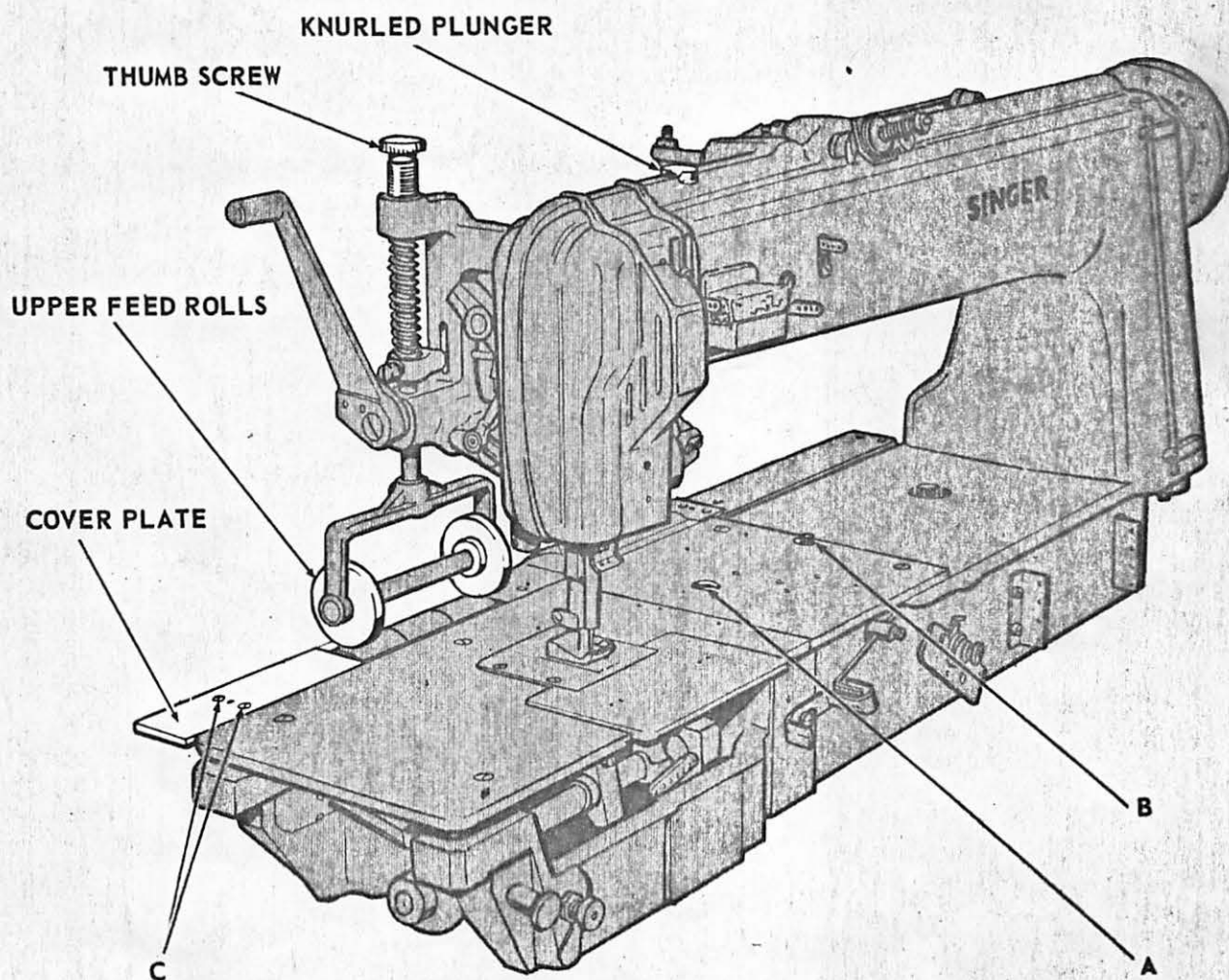
Press in on the knurled plunger at the top of the machine and, at the same time, turn the machine hand-wheel over toward the operator until the plunger

enters a notch in the adjustable eccentric on the arm shaft.

Turn plunger to right or left to lock it in position.

Press buttons A and B simultaneously (shown in the bed of the machine) and **HOLD**. At the same time, turn the hand-wheel over toward the operator to increase stitch length, away from the operator to shorten stitch length as desired. The letter-designation on the stitch indicator plate opposite the arrow shows stitch length attained.

Release button A and B and turn the knurled plunger to the left or right until it springs outward and releases the eccentric. The machine is then ready for operation.



TO REGULATE UPPER FEED ROLL PRESSURE

The pressure of the upper feed rolls on the material should be sufficient only to pull material from the compound feed of the machine, keeping it taut without slipping.

To increase this pressure, turn the thumb screw to the right (downward); to decrease, turn the thumb screw to the left (upward).

TO CHANGE LOWER FEED ROLLS

Remove the two screws, C, take off cover plate, and

loosen screws 1 through 11

Slide the puller-feed shaft to the right far enough to allow removal of the lower feed rolls.

Place new feed rolls on the shaft, and slide shaft with collars back (left) to original positions.

Tighten all screws (1-11) securely, making sure that screw numbers 3, 4, 9, 10 and 11 are tightened on a flat on the shaft. Then check puller feed adjustment.

