INSTRUCTION MANUAL

for

SINGER

MACHINE

7225J

THE SINGER COMPANY

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Application

Semi-automatic jeans pocket setter
for attaching hip pocket on jeans

Notes on Safety

- The machine must only be commissioned
  in full knowledge of the instruction
  manual and operated by persons with
  appropriate training.
- Before putting into service also read
  the safety notes and the instruction
  manual of the motor supplier.
- The machine must be used only for the
  purpose intended.
- Use of the machine without the safety
  devices belonging to it is not permitted.
- When gauge parts are exchanged
  (e.g. needle, presser foot, needle
  plate, feed plate and bobbin), during
  threading, when the workplace is left,
  and during service work, the machine
  must be isolated from the mains by
  switching off the air switch or
  disconnection the main plug.
- When changing the pocket clamp,
  the main switch and air supply must be
  turned off.
- When machine is in operation, do not
  touch the feed system (pocket clamp
  mechanism) because there is danger
  of injury.
- General servicing work must be carried
  out only by appropriately trained
  persons.
- Repairs, conversion and special
  maintenance work must only be carried
  out by technicians or persons with
  appropriate training.
- For service or repair work on pneumatic
  systems the machine must be isolated
  from the compressed air supply system.
  Exceptions to this are only adjustments
  and function checks made by
  appropriately trained technicians.
- Work on the electrical equipment must
  be carried out only by electricians
  or appropriately trained persons.
- Work on parts and systems under
  electric current is not permitted,
  except as specified in regulations
  EN50110.
- Conversions or changes to the machine
  must be made only on adherence to all
  safety regulations.
- For repairs, only replacement parts
  approved by us must be used.
- Commissioning of the sewing head is
  prohibited until such time as the
  entire sewing unit is found to comply

Meanings of the symbols:

⚠️ Danger spot!
- Items requiring special
  attention.

⚠️ Danger of injury to
operative or service staff.
- Be sure to observe and
adhere to these safety
notes!

Commissioning

⚠️ To avoid disturbances or
damage it is absolutely
necessary to observe the
following instructions:

- Before you put the machine into
operation for the first time
  clean it thoroughly, and oil it
  well (see page 2 ).
- Have the mechanic check whether
  the motor can be used with the
  existing main voltage or not, and
  that junction box is correctly
  connected. Do not start the
  machine if the voltage is
  not correct!
Oiling

When oil in oil window ① is at low mark ⑬, fill to high mark ⑰ from oil hole ②. In new machines or those that have been idle for long time, adequately lubricate ⑲, ⑶ - ⑱ needle bar and thread take-up components and oil wicks in various places.

When oil in oil window ④ is at low mark ⑳, fill to high mark ⑴ from oil hole ⑵.

Remove shuttle bobbin case, shuttle race ring and shuttle body from shuttle race body and clean the parts once every day.

When thread lubricating reservoir ② is used, fill with silicone oil from oil hole ⑱. In this case, check to see silicone oil sticks to needle thread passed through thread guide ⑳.

Only use oil with a viscosity of 20.0 mm²/sec. at 38 C and a density of 0.888 g/cm³ at 15 C.

We recommend SINGER C-Oil.

Switch off the machine.
Eye Guard

Assemble eye guard to face plate with screw ① as shown in the sketch.

Switch off the machine

Do not run machine without eye guard! Danger of injury!
Operation of Machine

Operate the machine in accordance with following procedure.

1. Supply air.
   Normally, the air pressure should be set to 0.5 MPa (= 5 kgf/cm²).

2. Turn on main switch.

3. Following will be displayed on LCD screen.
   MEM.CHK&PRG.LOAD
   WAIT 12 SEC

   Wait 12 seconds.

4. Following will be displayed on LCD screen.
   AFTER MOVE WORK
   PUSH ORG.POS KEY

   Following will be displayed on LCD screen.
   MOVE OK?
   ORG.POS

   Move pocket clamp to a position where it can be returned to original position with the cursor (see sketch).

7. Push [ ENTER ] key
   Pocket clamp will move to original position, then it will rise and inverse clamp will move forward.

8. Following will be displayed on LCD screen.
   0: SEWING MODE
   1: PATTERN MODE


10. Following will be displayed on LCD screen.
    INPUT PATTERN
    NAME: _

11. Input pattern name.
12. Place material in position on the machine and turn on outer clamp and inner clamp switches to lower the pocket clamp. (Machine will not sew unless both outer and inner clamps have been lowered.)

13. Push start switch.

Machine will start sewing.

When pattern is completed, the thread will be trimmed and pocket clamp will return to original position and machine will stop completing one cycle.
Belt Guard

The belt guard is assembled to the machine head when the machine leaves the factory. For protection against danger, the belt guard should not be removed when operating the machine.

Do not run machine without belt guard! Danger of injury!

Inserting the Needle

Use Cat. 3651-05 (MR4.0) needle only.

Set the needle bar at its highest point. Loosen needle set screw ①. Insert the needle in the needle holder and push it up as far as it will go. Make sure its long groove faces toward the front. Tighten needle set screw ① securely.

Switch off the machine

Winding the Bobbin

Adjust the thumb nut ① to regulate the tension for bobbin winding.
Thread the needle from front to back. When using silicone oil, pass thread through thread guide ②.

Switch off the machine.

Do not run machine without take-up lever guard ①. Danger of injury!

Do not operate without cylinder cover ①! Danger of injury!

Switch off the machine.
Regulating the Needle Thread Tension

Regulating the Pretension

Regulating the Bobbin Thread Tension

Machine Care

Clean hook and hook area daily, or more frequently if machine is in continuous operation.

Set machine upright again using both hands. Danger of crushing between sewing head and table top.

Switch off the machine.
Specifications

Stitch type: 301 (lockstitch)

Maximum speed: 2,300 s.p.m. (at 3.0mm stitch length)

Stitch length: 0.1 to 10mm

Maximum sewing window: Max. across arm (X): 250mm
                        Max. up arm (Y): 190mm

Maximum clamp lift: 30mm

Needle: Cat. No. 3651-05 (MR4,0)

Shuttle: 1.7 times shuttle

Motor Pulley Dia: 60mm

Memory Medium: 2HD 3.5" floppy disk

Total Number of Stitches: 80,000 stitches

Electricity: AC200, 220, 240V ± 10% 1∮ 50/60Hz 1KVA

Air Pressure: 5 - 6 kgf/cm² (0.49 - 0.59 MPa)

Air Consumption: 3Nl/min.

Overall dimensions: 1,284mm (L) X 1,200mm (W) X 1,210mm (H)

Weight: 190 kg

Option

- Stacker
- Auto-loading device
- Creasing unit
- Needle thread breakage detector
- Air-blow parts for label attaching.