

Model

Model

**817 & 817N**

**BLINDSTITCH MACHINES**

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**Operator  
Manual and  
Instruction**

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## 1. GENERAL CHARACTERISTICS:

All Model 817 and 817N types of blindstitch machines can be operated up to a speed of 2,500 R.P.M. depending on materials and threads used and skill.

Model 817N machines have the small cylinder of fine tubular work. All models are regularly fitted with swing-out work plates for flat or tubular work.

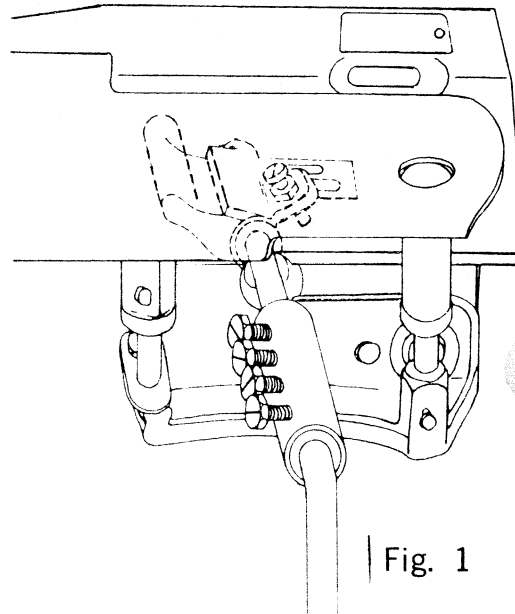
## 2. INSTALLATION:

Position machine head on machine table so that the machine pulley groove is centered to the belt hole cutout on table. Position machine so that the knee lever extends and clears the front of the table edge. Mark the bolt holes through the holes in the machine base. Remove machine and drill 6.2mm (1/4") holes in table top. Set machine to bolt holes with felt pad under machine and securely fasten machine with bolts provided in accessory pack.

Drive motors recommended are clutch motors either 1/4 H.P. or 1/3 H.P. with rated R.P.M. of 1400/1425 R.P.M. at 50 cycles (Hertz) or 1725/1750 R.P.M. at 60 cycles. To drive machine at rated speed use maximum 90mm (3.5") outside diameter motor pulley at 50 cycles and 75mm (2.9") outside diameter motor pulley at 60 cycles. It is recommended that new machines be run at below rated speeds at the beginning therefore motor pulleys which are 5mm (1/4") smaller in diameter than the foregoing sizes be used for the first month to run-in the machine.

After the machine has been bolted to the table connect the driving belt from the motor pulley to the machine pulley. The machine pulley must turn in a direction away from the operator. Next insert the Knee Lifter Knee Pad Rod into the Knee Lifter Rock Shaft Sleeve and tighten the two set screws located at the front section of the sleeve.

(See Fig. 1)



### 3. OILING THE MACHINE

Oiling holes are marked in red paint. A drop or two of oil should be inserted at each oil hole. Remove Arm Side Cover and oil the Feed Lever Eccentric and the Feed Lever Rocker Pin Hole. Also oil the Ball of the Needle Drive Shaft. Replace the Arm Side Cover. (See Fig. 2)

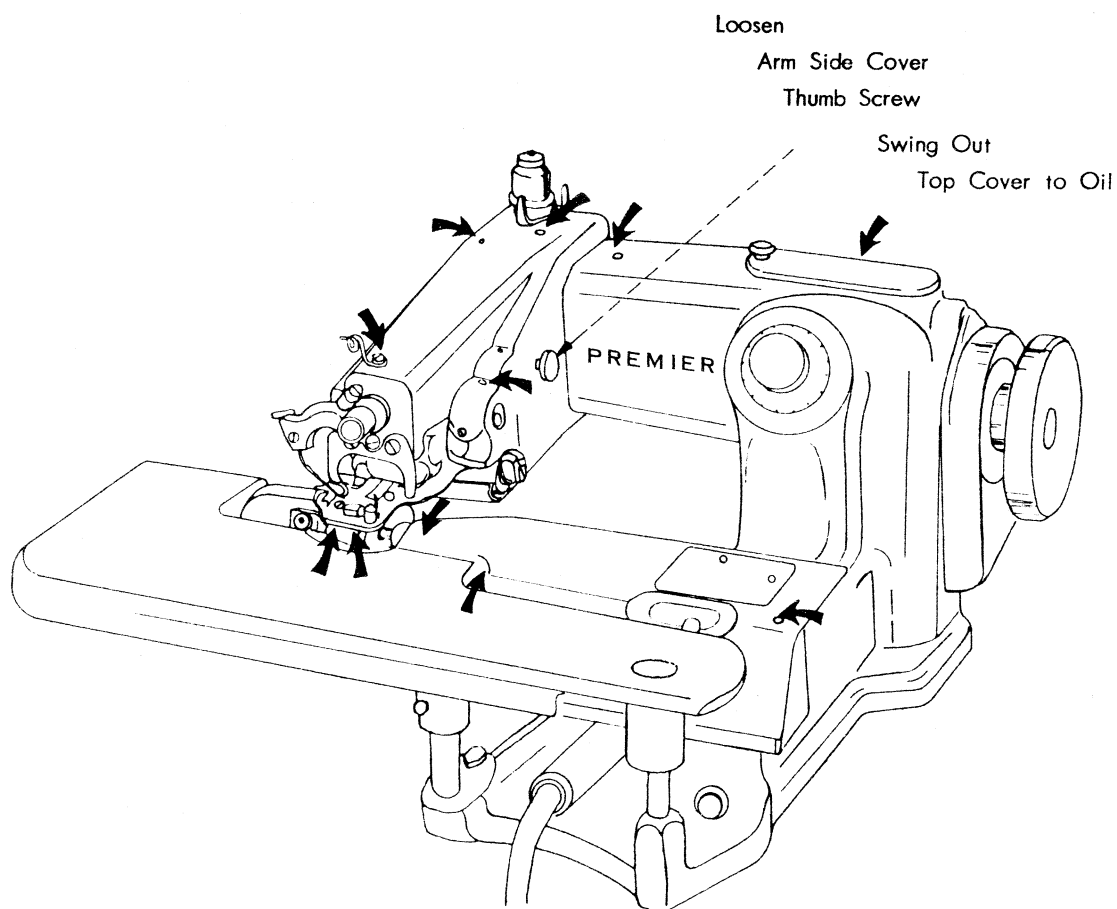


Fig. 2

#### 4. THREADING THE MACHINE

Thread the machine as shown (Fig. 3). Make sure that the thread passes between the two tension discs at point (A). The thread should be passed through the needle eye from the underside of the needle. Cut the excess thread after threading the needle so that approximately 100mm (4") of thread end is left. Adjust tensions to suit the thread and material being used.

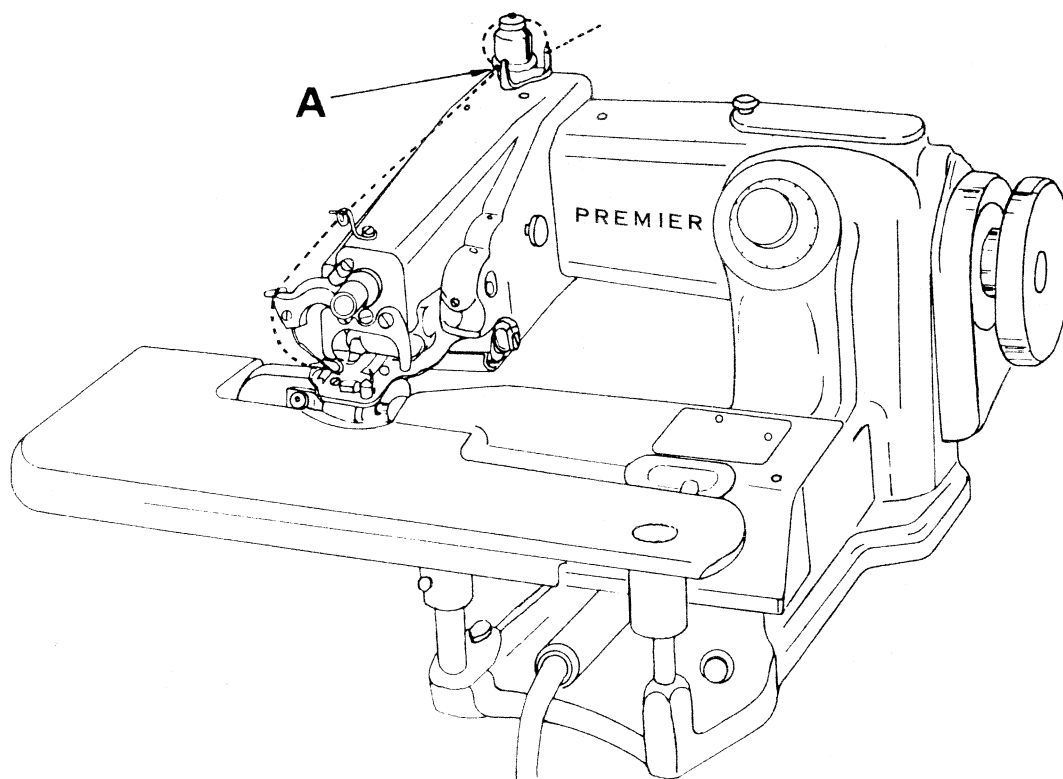


Fig. 3

## 5. REPLACING THE NEEDLE

Grasp the Hand Wheel and turn away from operator until the Needle Lever is at its highest position on its left hand stroke. Loosen Needle Clamp Screw (A), remove old needle and insert new needle as far as it will go into the needle clamp groove. Tighten Clamp Screw. (See Fig. 4) The needle point must slightly touch the needle guide. (B).

Turn the Hand Wheel slowly to check that the point of the needle just touches the rib also. This should be checked with the machine set at the non-skip (1-1) stitch position on skip stitch machines.

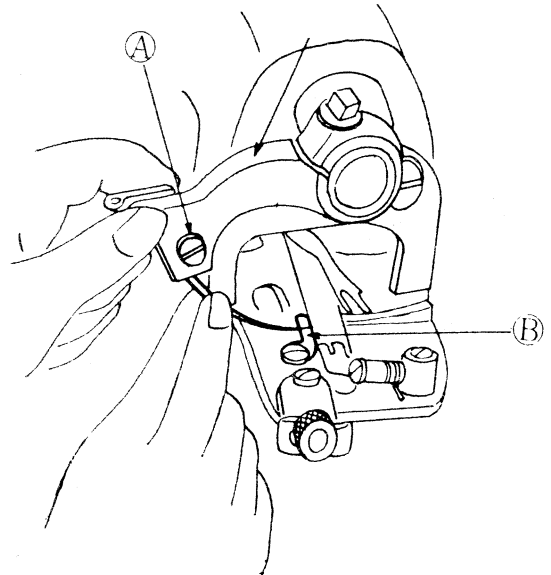


Fig. 4

## 6. ADJUSTING FOR NEEDLE PENETRATION

The Penetration Dial is located at the front of the machine arm. Turn the Dial clockwise (LESS) for less penetration of the needle through the material being stitched and turn counter-clockwise (MORE) for greater penetration. The calibrated numbers on the Dial can be noted and used for reference position for same types of materials for quick adjustment.

(See Fig. 5)

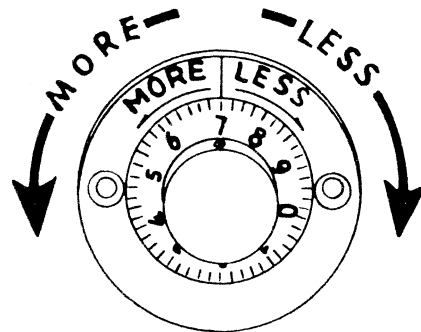


Fig. 5

## 7. ADJUSTING FOR SKIP STITCH

An indicator plate is located at the front right hand side of the feed frame on skip stitch machines with the markings "2-1, 1-1". To obtain skip stitching move lever to the "2-1" position. To obtain non-skip stitching move lever to "1-1" position. (See Fig. 6). Depress knee lever when moving skip stitch lever.

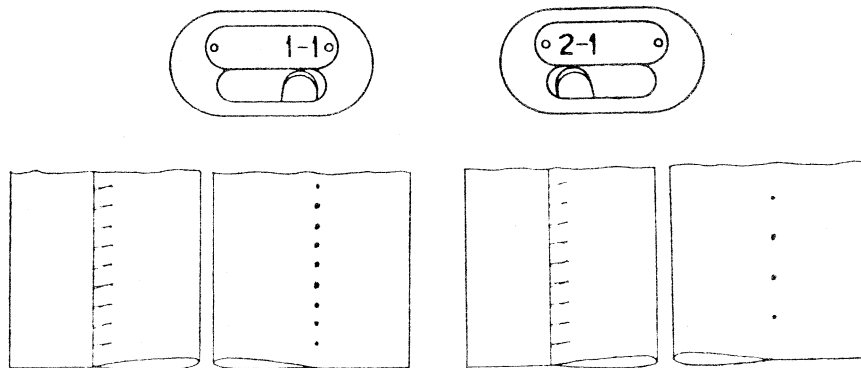


Fig. 6

## 8. ADJUSTING THE STITCH LENGTH

Remove the Arm Side Cover. Loosen Clamp Screw of Stitch Adjusting Collar and while holding collar firmly turn hand wheel to desired stitch length. The desired calibration mark on the Stitch Adjusting Collar should be lined up with the line mark on the shoulder of the Stitch Eccentric. Tighten the Clamp Screw after setting to the desired stitch length. The higher the number on the collar the longer the stitch. (See Fig. 7)

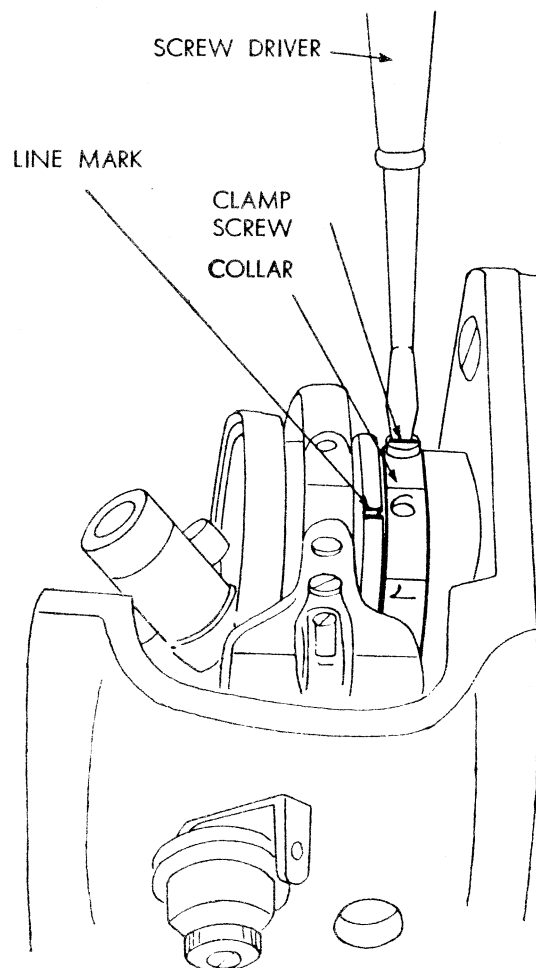


Fig. 7

## 9. PREPARING TO SEW AND HANDLING MATERIAL

In order to achieve uniform and neat appearing hems on the garment pieces to be hemmed, pressing or pre-creasing is recommended. However through training and experience neat hems can be produced by hand folding and guiding.

In stitching hems the following steps should be followed.

- a. Position the needle lever to its extreme left hand stroke.
- b. Fold the hem of the material to the desired width. Turn under the edge of the material to achieve a single fold.
- c. Hold material firmly at the rear and front to hold the folded hem. Depress the knee lifter and place the material under the feeding foot and align the edge to be hemmed with the edge guide. When this alignment is made the edge of the hem to be stitched should be centered in the curve of the presser foot shoe.

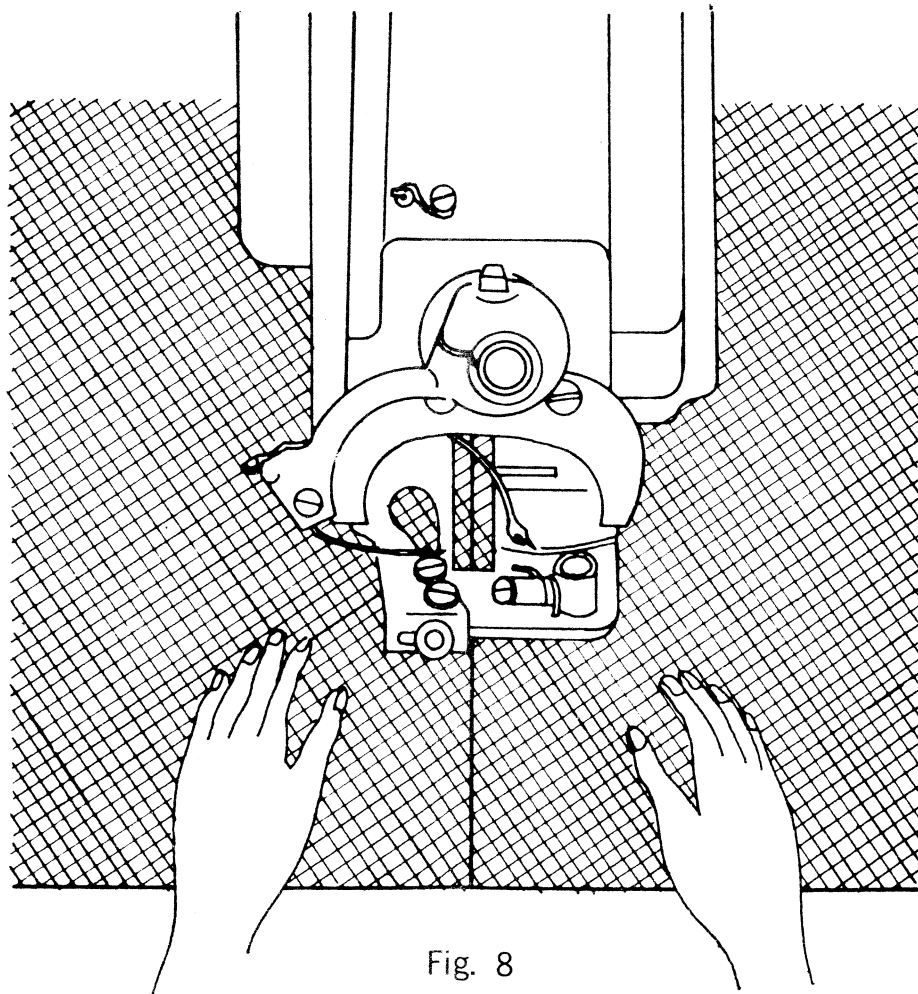



Fig. 8

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- d. Begin sewing and continue until the seam is completed. To achieve correct and straight stitching, guide the edge by keeping the folded edge to the edge guide. Watch this part only as this will keep the edge straight. It is not necessary to watch the needle or the stitching. (See Fig. 8)
  - e. After completing the hemming operation, turn hand wheel to position the needle lever at its extreme left hand stroke, depress the knee lever to release the material and pull the work away from you straight back with a sharp pull. This will break the thread for easy removal of the work and also leave enough thread for starting the next seam.

Note: When the machines are packed at the factory the timing of the looper, feed and needle are set correctly and no adjustments are necessary except for thread tensions and penetration to suit the threads and materials to be used.



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# **Consolidated Sewing Machine Corp.**

## **MAIN OFFICE**

131 West 25th Street  
New York, NY 10001  
Tel: (212) 741-7788  
Fax: (212) 741-7787

## **BRANCH OFFICE**

7855 NW 29th Street, Bay 166  
Miami, FL 33122  
Tel: (305) 471-0200  
Fax: (305) 471-0243