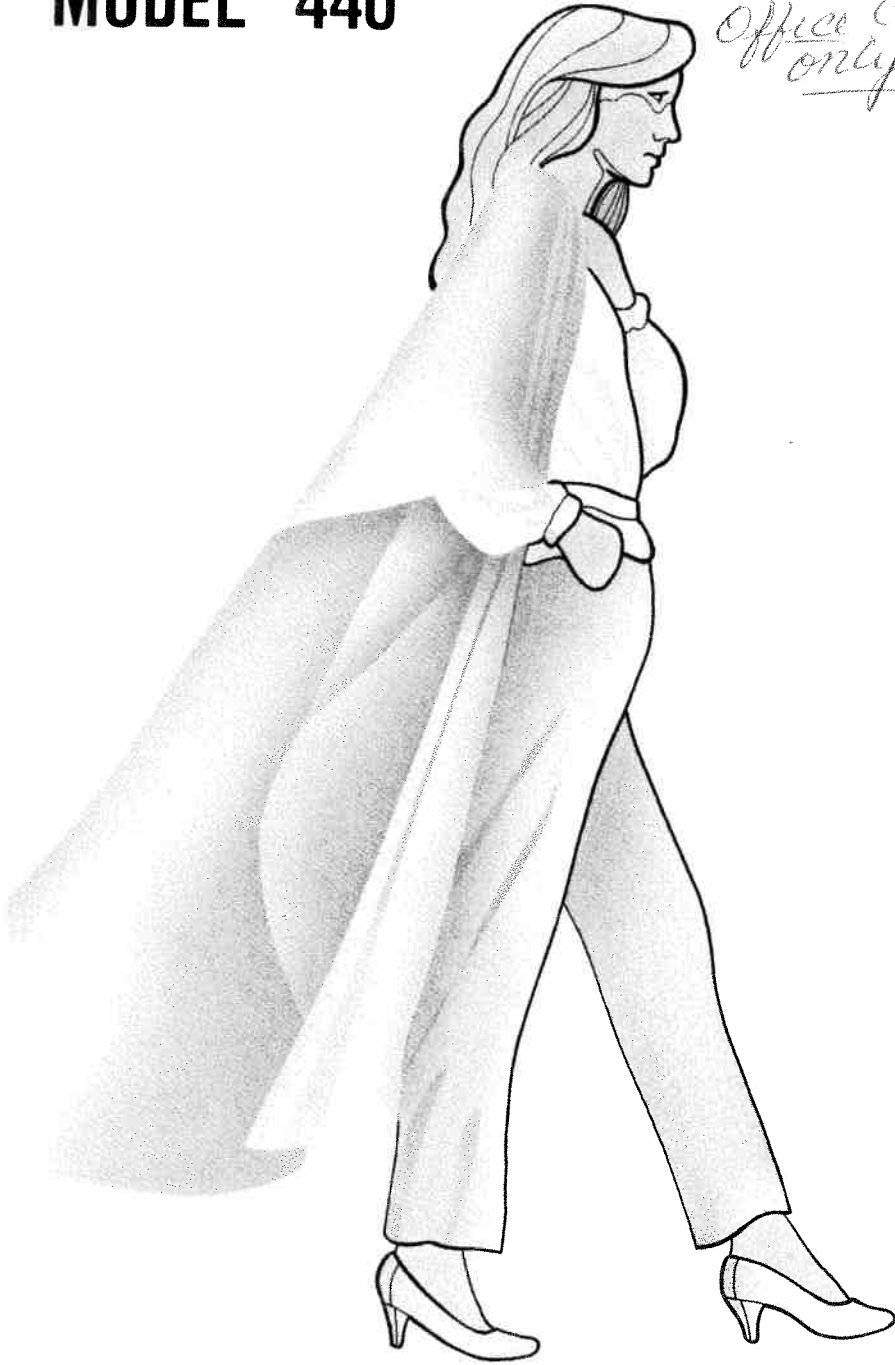


# HANDBOOK FOR HUSKYLOCK

**MODEL 440**

*Do Not Use  
Office Copy  
only*



# WIRING INSTRUCTION

Only for the British market!  
When changing plug wiring  
should be effected according  
to the instruction below.

## Check the voltage

Before connecting the sewing machine to an electrical supply ensure that the voltage marked on the rating label of the machine is the correct voltage for your electrical supply. If it is not, do not use the machine but refer back to your dealer.

## Connecting to your Electricity supply

The sewing machine has a flexible two core mains lead permanently connected to the foot control. At the free end of the lead a suitable plug should be fitted.


## Important

The wires in the mains lead of this appliance are coloured in accordance with the following code:

**BLUE: NEUTRAL    BROWN: LIVE**

As the colours of the wires in the mains lead of this appliance may not correspond with the coloured markings identifying the terminals in your plug, proceed as follows:

The wire which is coloured blue must be connected to the terminal which is marked with the letter N or coloured black. The wire which is coloured brown must be connected to the terminal which is marked with the letter L or coloured red.

If using a 3-pin plug do not make any connection to the terminal marked with the letter E or by the earth symbol  or coloured green or green and yellow. Your Husqvarna sewing machine is double insulated and no earth connection is necessary.

If a 13 amp fused plug is used, it should be fitted with a 3 amp fuse. It is in your own interest to ensure that the plug is correctly fitted to the mains lead. If in doubt consult a qualified electrician, as Husqvarna Limited cannot regard the repair of faults on the plug connection as a service that can be given free of charge under the terms of the guarantee.

This appliance conforms with the requirements of E.E.C. directive No. 76/889 relating to radio interference.

**Thank you very much for your  
purchase of an Overlock  
sewing machine.**

You have just purchased an overlock sewing machine for sewing all kinds of fabrics—cotton, wool, rayon, tricot, jersey, knitted goods—thick or thin.

You cannot be other than satisfied with its perfect and beautiful stitches and its long operating life.

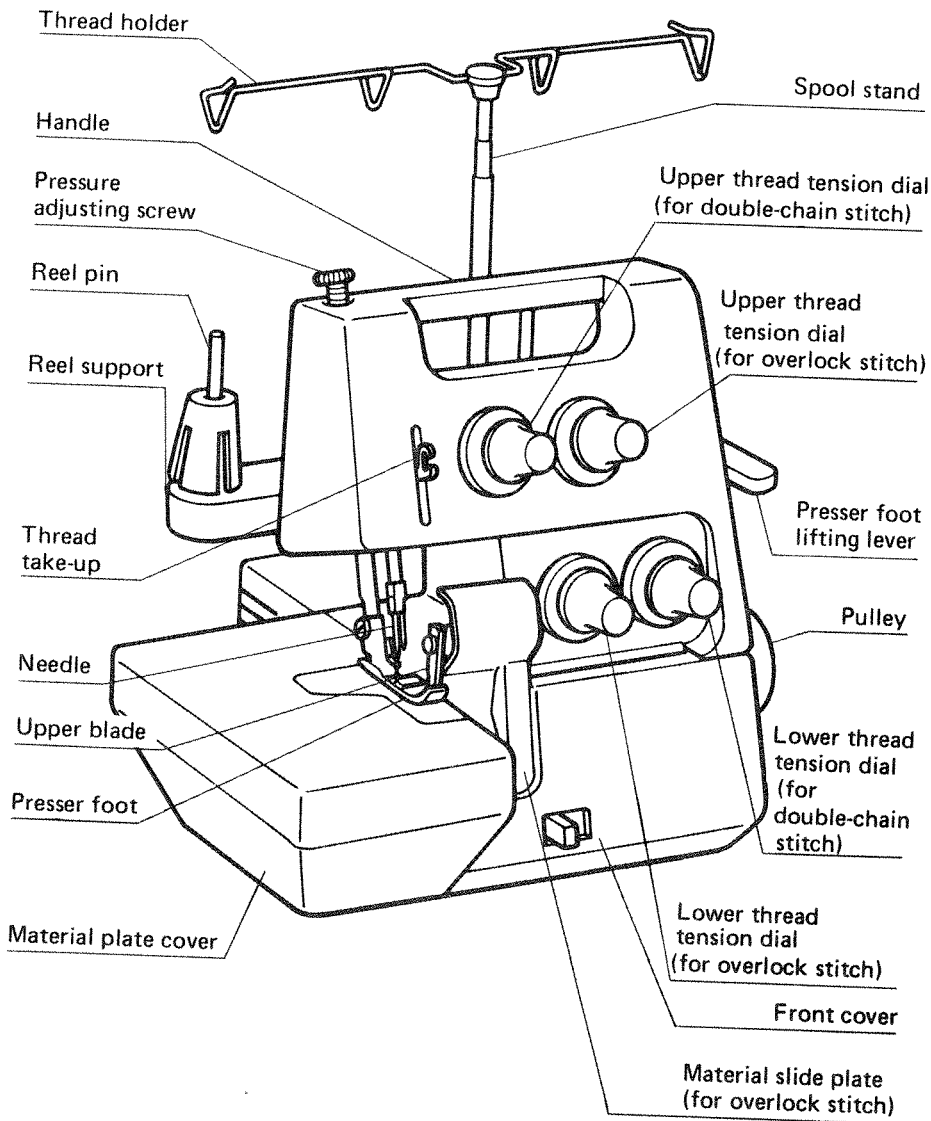
But, however excellent this sewing machine may be, it cannot operate its fullest capacity unless it is handled correctly.

Please read the following instructions carefully so that your new sewing machine will give you complete sewing enjoyment for years to come.

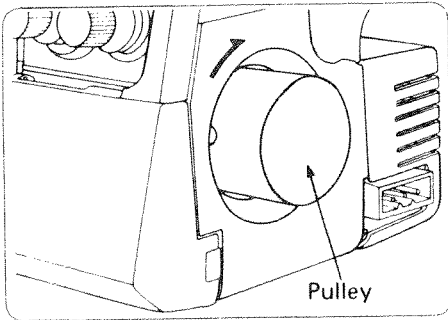
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# Names of parts and their functions.



### Direction of Revolution

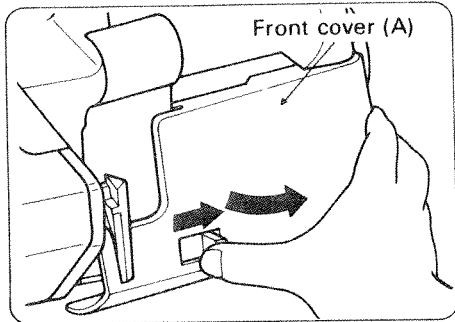


\*The motor of this machine runs in a clockwise direction (arrow direction), which is the opposite direction to the motor of an ordinary home sewing machine.

### Opening and closing the front cover

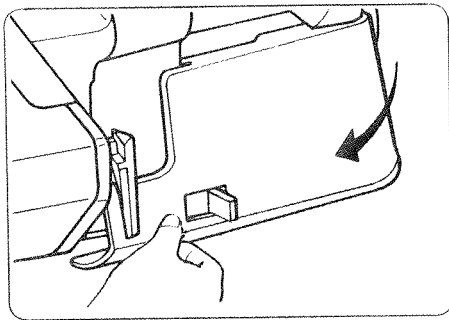
When threading, you will need to open the front cover.

Note: When sewing, be sure to close the front cover.



#### To open the front cover

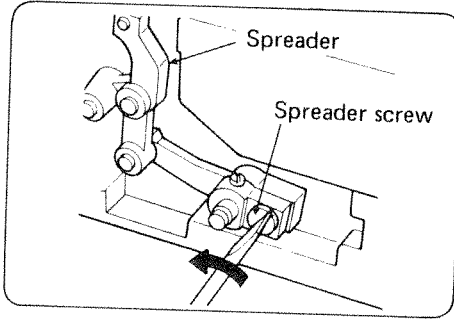
Move the knob on the front cover in the direction of the arrow and pull it open.



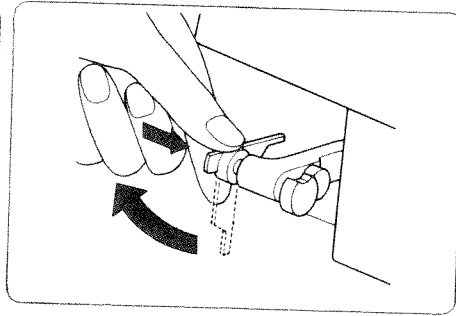
#### To close the front cover

Push the front cover by hand as shown in the left figure.

## Replacing the material guide for double-chain stitching

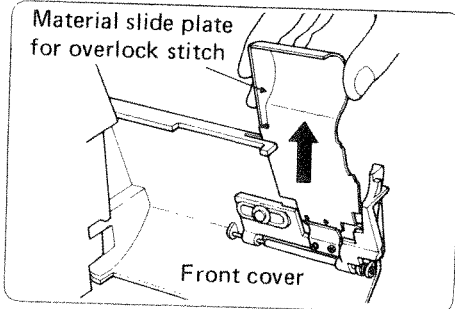


1. Open the front cover and disengage the spreader by loosening the spreader screw.

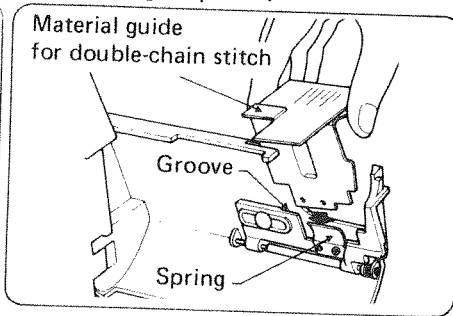


2. Turn the upper blade until it is locked.

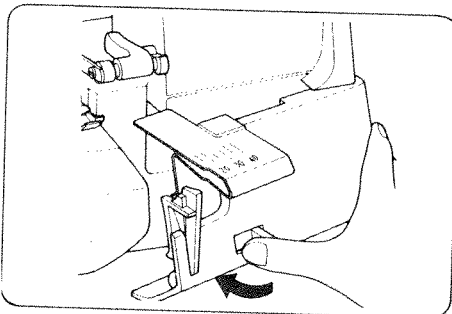
Disengage the upper blade by turning it upward.



3. Remove material slide plate for overlock stitch.

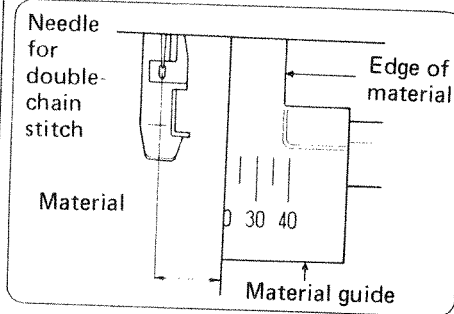


4. Insert the material guide for double-chain stitch.



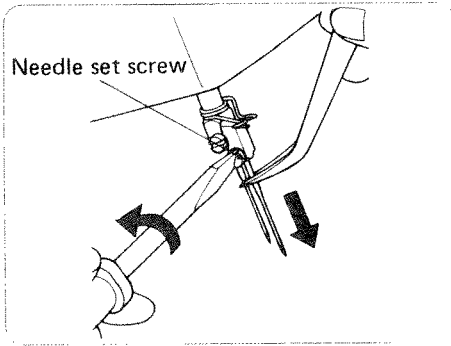
5. Close the front cover.

### How to use material guide



## Needle

\*TE X 1 (#11 & #14) or DB X 1 (#9, #11, #14) can be used with this machine.  
TE X 1 (#11) is mounted on the machine.

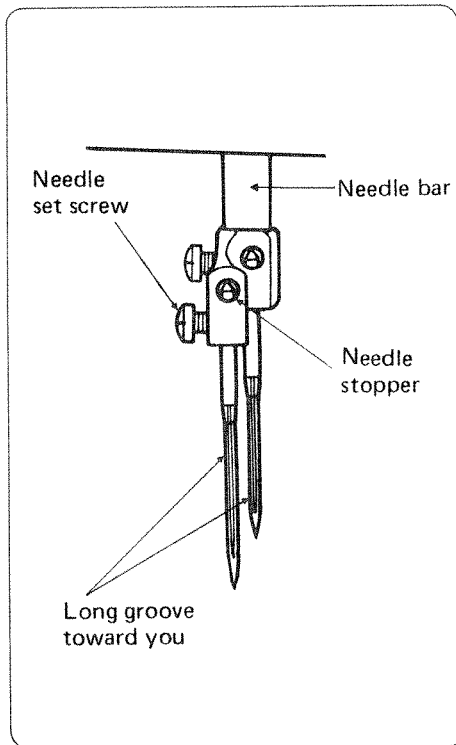


### To remove the needle

- (1) Turn the pulley clockwise by hand until the needle is raised to the highest position.
- (2) Loosen the needle set screw with the screwdriver (turn left) and remove the needle.

### NOTE:

When removing the needle, hold the needle with the tweezers to avoid dropping it.



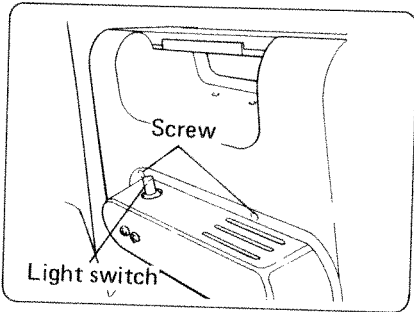
### To fit the needle

- (1) Turn the pulley until the needle bar is raised to the highest position.
- (2) Hold the needle with its long grooved side to the front and insert it as far as the needle stop.
- (3) Tighten the needle set screw securely, taking care that the needle is set in the correct position.



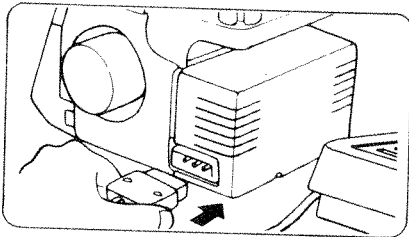
# Operating

\* If your machine is provided with the light;



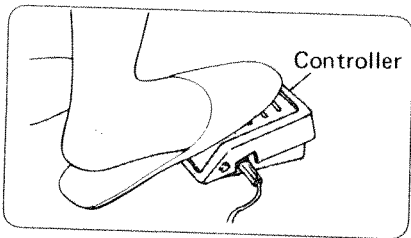
## Changing the light bulb

Undo the two upper screws on the back of the machine, remove the cover and screw the light bulb out. Insert the new bulb and screw the cover in place. Use light bulbs designed for 15 W as indicated on the lamp holder.



## Preparation

\* Insert the three-pin plug into the socket of the motor and insert the power supply plug into the electric outlet.



## Operation

When the pedal is lightly depressed, the machine runs at low speed and as it is depressed further, the machine will pick up speed. When the pedal is released, the machine will stop.

## NOTES ON THE MOTOR

- ☆ The normal operating speed of this sewing machine is 1,500 stitches per minute, which is quite fast compared to the normal operating speed of 300 to 800 stitches per minute for the ordinary foot-operated home sewing machine. It should be noted that the motor of this sewing machine runs in the opposite direction to the motor in an ordinary home sewing machine.
- ☆ The motor has bearings made of a special sintered oil-impregnated alloy wrapped in oil-soaked felt to withstand long hours of continuous operation.
- ☆ Continuous operation of the sewing machine warms up the motor and the controller to some extent, but not enough to adversely affect its performance.  
The motor and controller are equipped with ventilating holes, which must not be covered up with cloth or paper during use.
- ☆ When the motor is running, sparks can be seen through the ventilating hole in the motor bracket on the side opposite to the pulley. These sparks are produced by the carbon brushes and the commutator, and are of no significance.

### For England

**Safety regulations for domestic sewing machines in conformity with "CEE Publication No. 10, Part II, Section C, Article 7.1".**

When the machine is not in use, or when threading or replacing needle or blades, the machine must be disconnected from the power supply by removing the plug from the wall socket.

Use bulbs designed for max. 15 W (wattage).

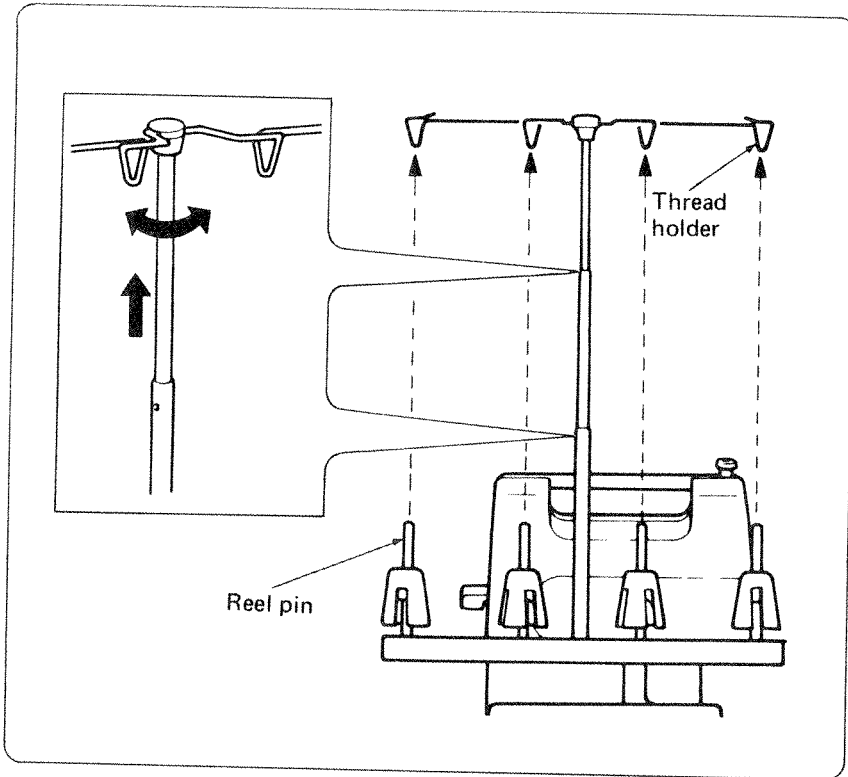
The machine has an interference suppressor for radio and television, complying with Directive No. 76/889 E.E.C. and C.I.S.P.R.

### CAUTION

**WHEN THREADING, REPLACING NEEDLE OR BLADES, OR WHEN MACHINE IS NOT IN USE, IT IS RECOMMENDED THAT THE ELECTRIC SUPPLY PLUG IS DISCONNECTED TO AVOID ANY POSSIBLE HAZARDS.**

# Threading

## Preparation

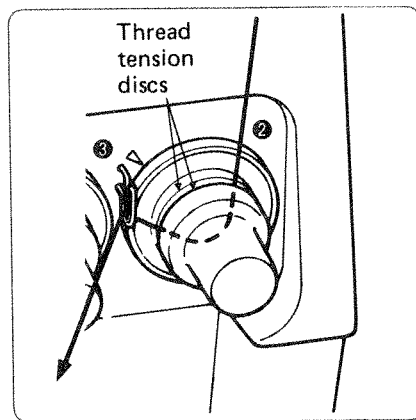
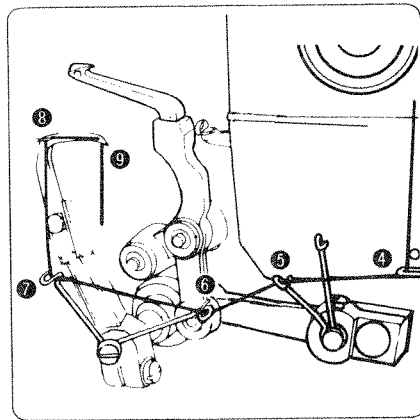
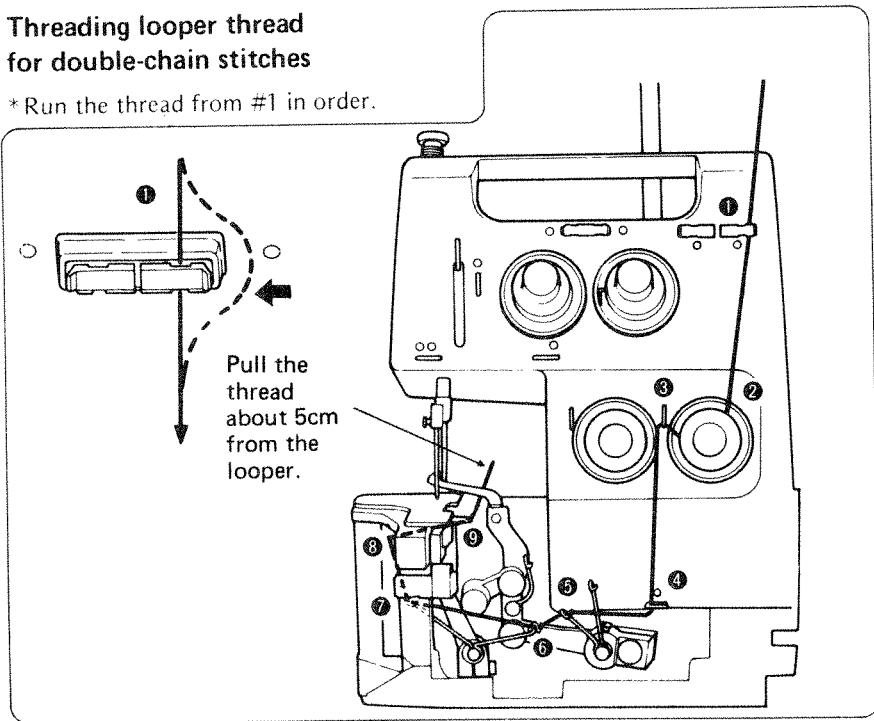


Raise the spool pin right up and set it by the positioning stopper at the joint of the upper and lower sections of the pin. Make sure that the thread holders are right above the reel support.

\* Incorrect threading makes sewing impossible. So set the threads correctly as shown below. To facilitate threading, there are coloured indication marks on the front panel of this machine.

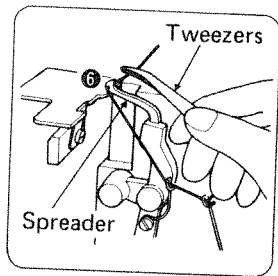
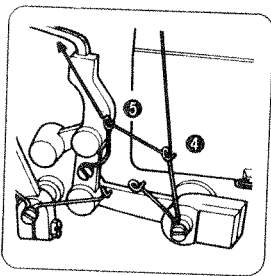
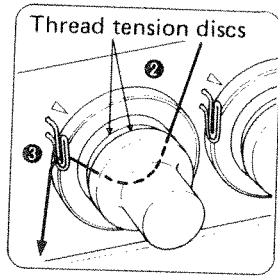
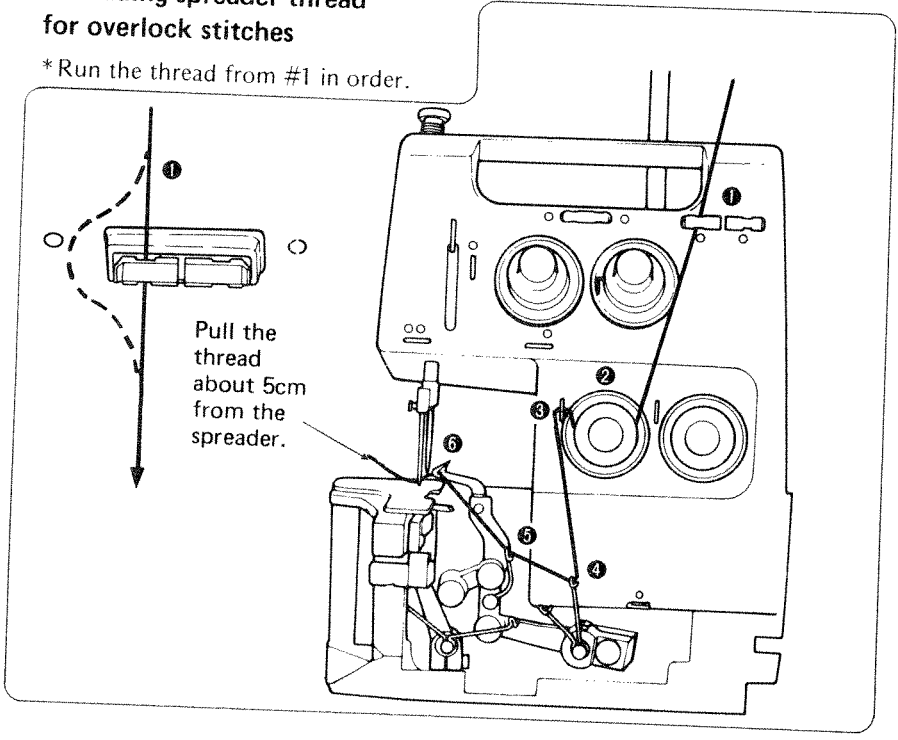
### Threading looper thread for double-chain stitches

\* Run the thread from #1 in order.



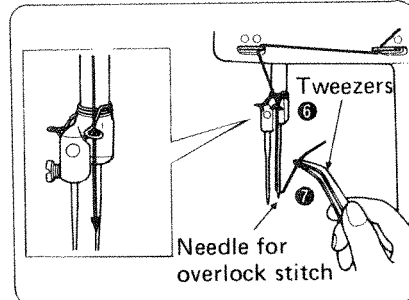
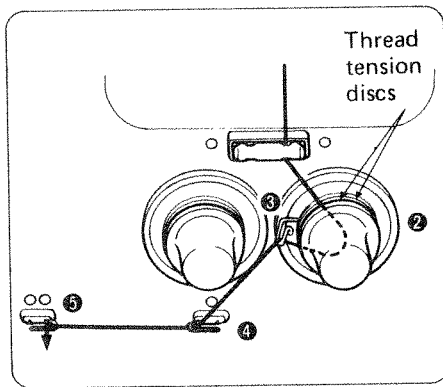
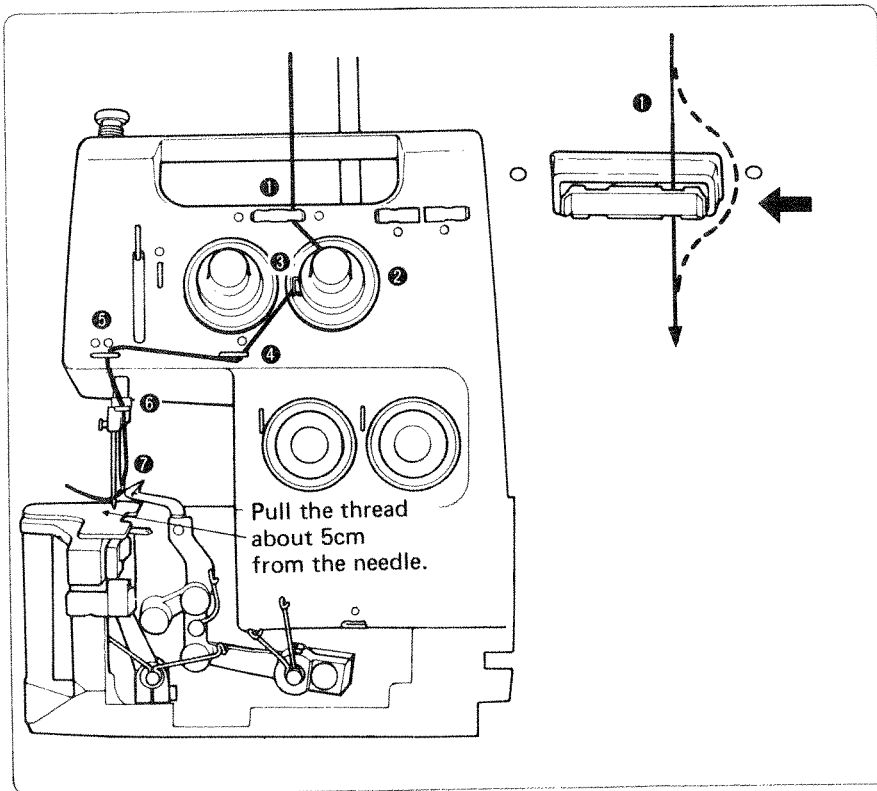
# Threading spreader thread for overlock stitches

\* Run the thread from #1 in order.



## Threading needle thread for overlock stitches

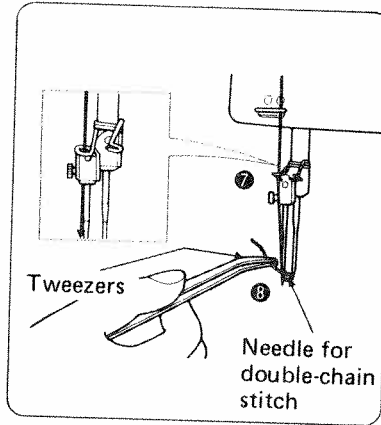
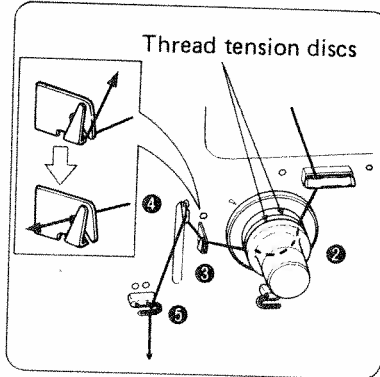
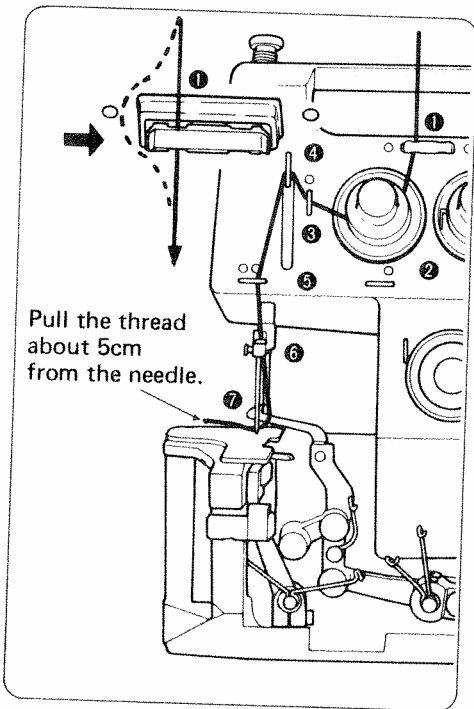
\*Run the thread from #1 in order.



**NOTE:**  
Thread the rear needle.

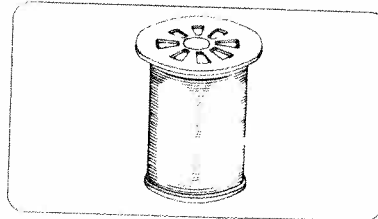
## Threading needle thread for double-chain stitches

\*Run the thread from #1 in order.

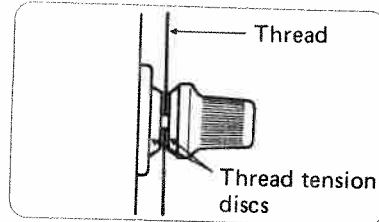


### NOTE:

When you use a wooden thread reel, use the spool thread cap as illustrated in the right picture.

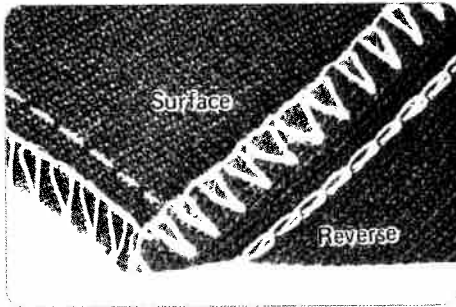


Make sure that each thread runs between the two parts of the thread tension discs.



# Kinds of Stitches

☆ This sewing machine can form three kinds of stitches with simple steps as mentioned below.

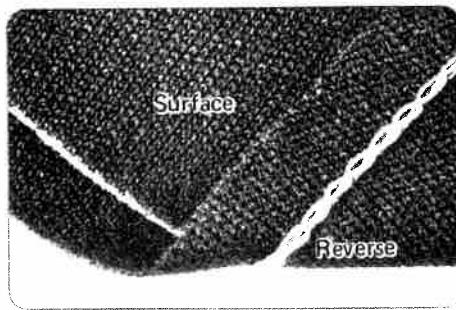


## 1. Safety stitch

Use all the four threads for producing safety stitches, which neatly fit all kinds of materials varying in thickness.

\*See Pages 7-11 for the threading procedure.

**Use:** For sewing sleeves onto the body of shirts, blouses, and dresses; and for sewing up their bodies.



## 2. Double-chain stitch

Beautiful double-chain stitches can be made with only the double-chain stitch needle thread and double-chain stitch looper thread.

\*See Pages 8 and 11 for the threading procedure.

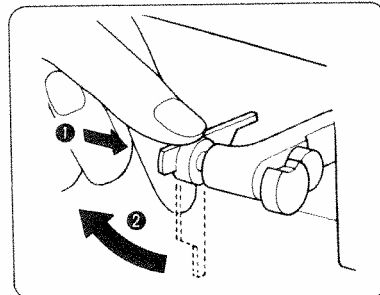
**Use:** For sewing up the parts of knitted and jersey garments.

When sewing double-chain stitches, disengage the upper blade and spreader according to the following steps.

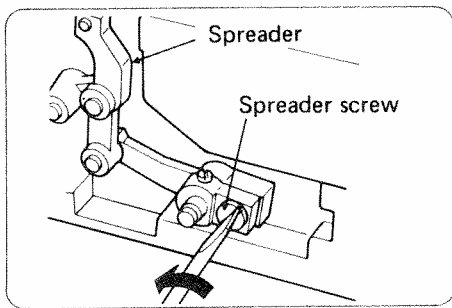
### How to disengage the upper blade:

Lower the needle to its lowest position.

- (1) Push the upper blade holder to the right as far as it will go.
- (2) Keeping pressure to the right push blade up and away from you.

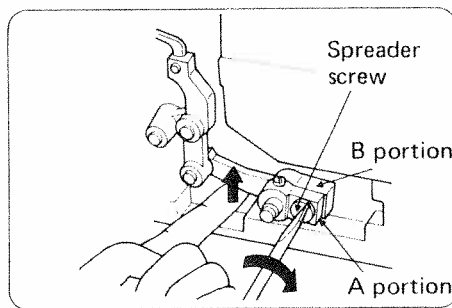




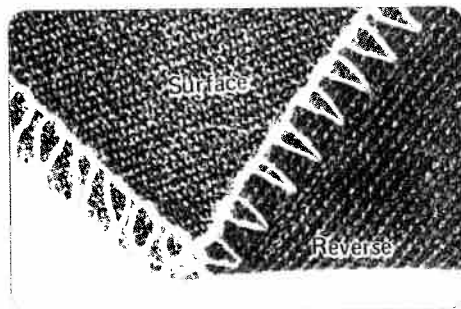


**How to disengage the spreader:**

Turn the pulley to raise the needle to the highest position and turn the spreader screw with the screwdriver to the direction the arrow points to, and then the spreader for overlock stitch can be removed.



In case of overlock stitch or safety stitch, turn the pulley until the needle is raised to its highest position and tighten screw setting A and B portion to be parallel by finger.



**3. Overlock stitch**

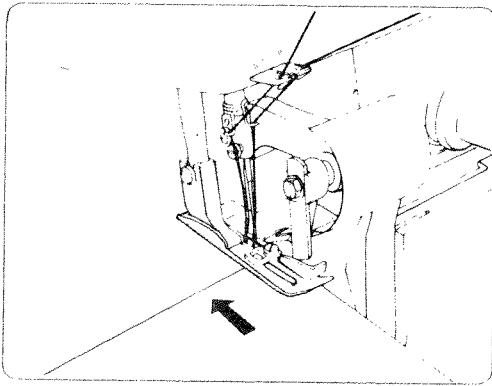
Beautiful overlock stitches will be formed by use of only the overlock stitch needle thread and overlock stitch spreader thread.

\*See Pages 9 and 10 for the threading procedure.

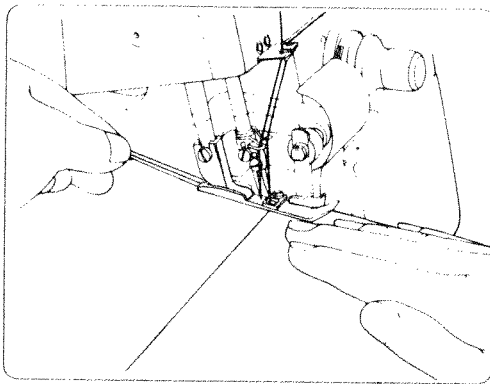
**Use:** For overlock stitching suits, blouses, slacks, etc.

## Test-sewing

\*Test-sew after threading.



- (1) Place material for test-sewing well under the presser foot.



- (2) Hold the two needle threads with your left hand, turn the pulley slowly a few turns in a clockwise direction with your right hand, and observe how the threads entwine themselves before starting sewing.

## Chaining-off

\*After test-sewing, hold the foot control depressed slightly for a while (chaining off.) The four threads will entwine themselves like a chain and will feed automatically.

### NOTE:

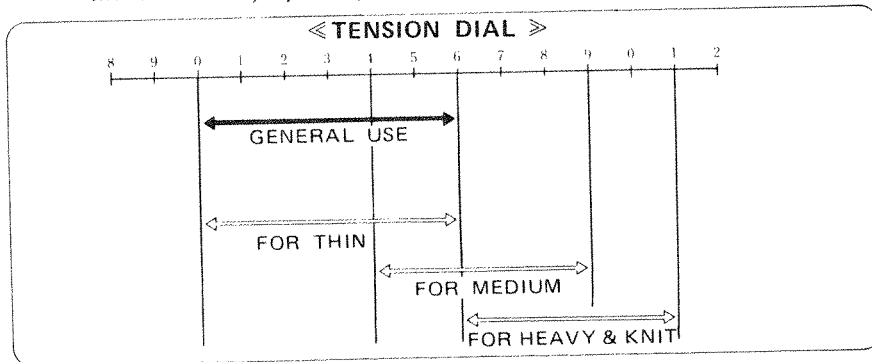
If the balance of the thread tension for the four threads is not correct, uneven chaining-off will result. In this case, pull the threads slightly.

# Ratio Chart of Sewing Material, Needle and Thread

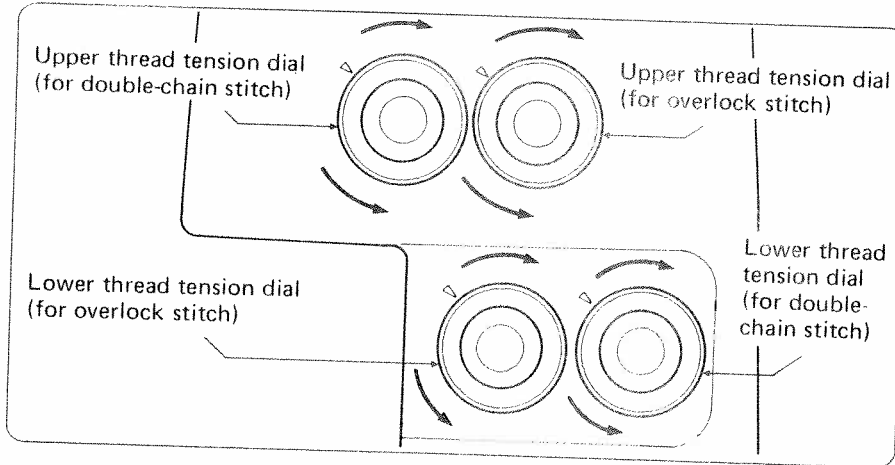
Sewing Material	Kinds of Stitches	Stitch Length	Thread	Needle	Tension Dial
Fine	Safety Stitch	2.0-3.0mm	Cotton : 80-100 Silk : 80-100	No.11	1-4
	Double-chain Stitch	2.0-3.0mm			
	Overlock Stitch	3.0-4.0mm			
Medium	Safety Stitch	2.5-3.5mm	Cotton : 60- 80	No.11 No.14	3-6
	Double-chain Stitch	2.0-3.0mm	Silk : 50- 80		
	Overlock Stitch	3.0-4.0mm	Synthetic : 50- 80		
Heavy	Safety Stitch	2.5-3.5mm	Cotton : 40- 60	No.14	5-9
	Double-chain Stitch	2.5-3.5mm	Silk : 40- 60		
	Overlock Stitch	3.0-4.0mm	Synthetic : 30- 60		
Knit	Safety Stitch	3.0-4.0mm	Cotton : 40- 60	No.11 No.14	
	Double-chain Stitch	2.5-3.5mm	Silk : 40- 60		
	Overlock Stitch	3.0-4.0mm	Synthetic : 30- 60		

**NOTE:**

1. The calibration on the tension dial is like the figure below.
2. Do not pull the tension dial knob.
3. When the tension dial is moved to the right, it will show "2".
4. The thread tension shown in the above chart is based on standard sewing conditions. Depending on the sewing conditions, adjust the thread tension referring to "Thread Tension" on page 16.
5. When you hem on two layers of material or more, some tension adjustment is needed, especially for sewing over bulky seams.



# Thread Tension



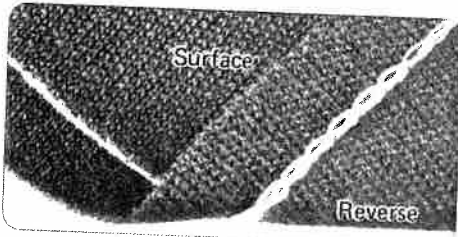
\*The thread tension of this machine can be adjusted by four thread tension adjusting dials of the two needle threads, looper thread and spreader thread. The correct thread tension varies with the kind of fabric, thickness of threads, etc. So, adjust the thread tension as required in each particular case. By turning the dials clockwise the tension will increase and by turning counterclockwise the tension will slacken.

## Adjusting the thread tension

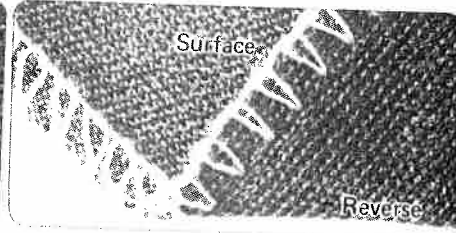
- (1) Select the correct tension, referring to the above illustration.
- (2) If you cannot find the proper tension, refer "An example" on the following page.

## Correct Thread Tension

(A) Double-chain stitch

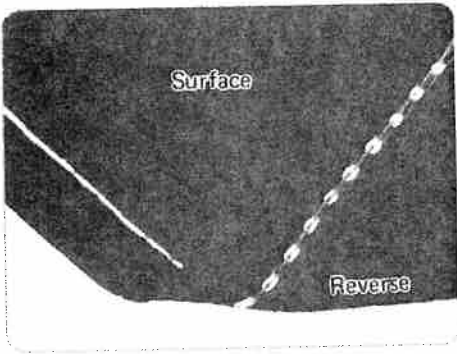


(B) Overlock stitch

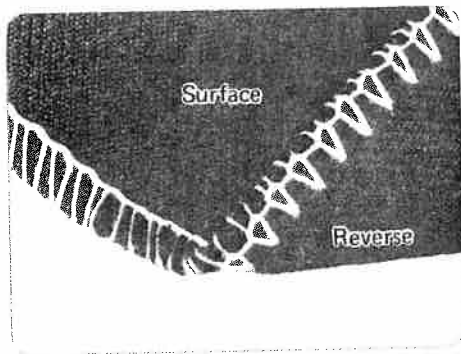


- \* Adjust the four tension dials together in order to get a perfect sewing stitch.
- \* Less tension of looper thread for double-chain stitch is required.

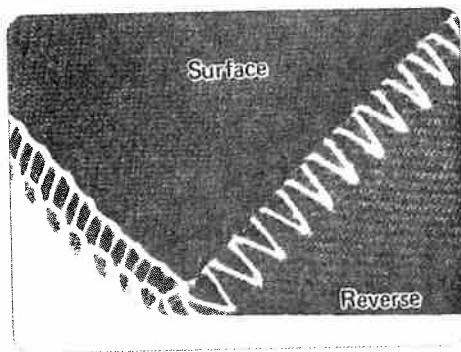
An example



- ☆ **If the needle thread for double-chain stitch is weak in tension ...**  
Turn the upper thread tension (for double-chain stitch) clockwise.  
(See the photo at left.)



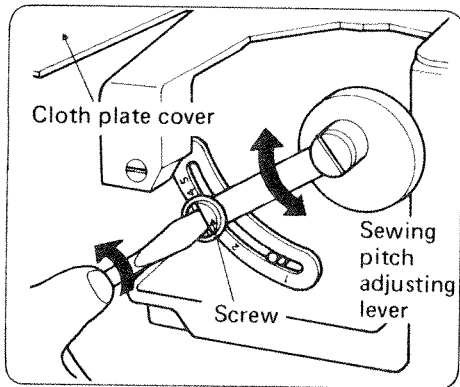
- ☆ **If the needle thread for overlock stitch is strong in tension or if the spreader thread for overlock stitch is weak in tension ...**  
Either loosen the upper thread tension (for overlock stitch) or tighten the lower thread tension (for overlock stitch).



- ☆ **If the needle thread for overlock stitch is weak in tension or if the spreader thread for overlock stitch is strong in tension ...**  
Either tighten the upper thread tension (for overlock stitch) or loosen the lower thread tension (for overlock stitch).

# Sewing Pitch and Size of Bite

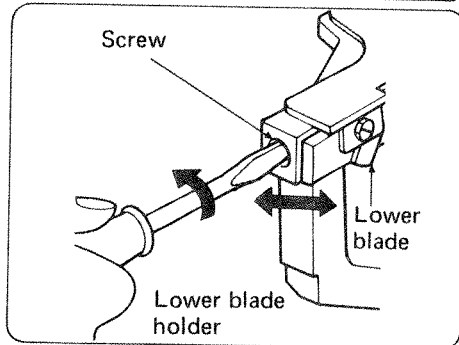
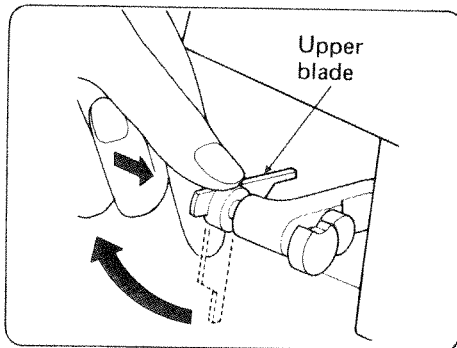
## Sewing Pitch (Stitch length)



\*When you change the sewing pitch, open the cloth plate cover. Loosen the adjusting screw and set the lever to the proper position, then tighten the adjusting screw. You can adjust the sewing pitch from minimum 2 mm to maximum 5 mm.

## Size of Bite (Stitch width)

\*The size of bite can be adjusted as follows:



### To adjust cutting width by knife:

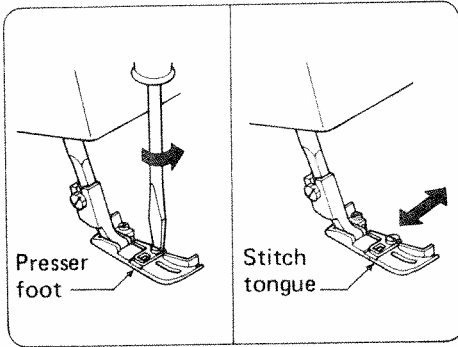
- (1) Open the front cover.
- (2) Move the upper knife to the right.
- (3) Loosen the set screw for lower knife holder.
- (4) Move the lower knife holder to the left or to the right.

\*If the lower knife holder is moved to the left, the width between the needle position and cutting line narrows.

If the lower knife holder is moved to the right, the width widens.

- (5) Tighten the set screw temporarily.

**NOTE:** After adjusting cutting width, check stitch tongue.

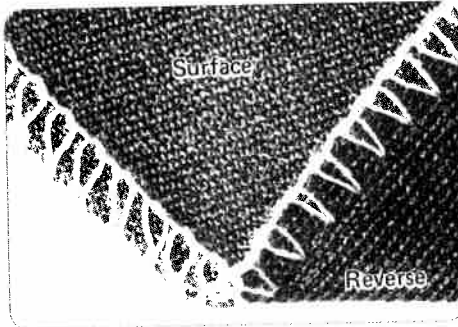


### To adjust the stitch tongue:

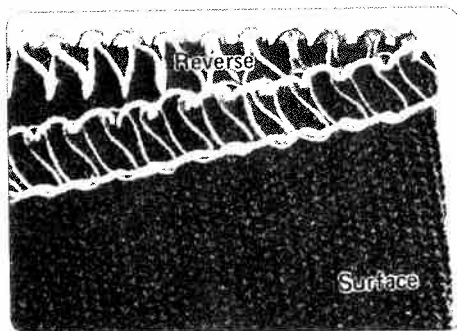
- (1) Loosen the set screw for movable stitch tongue.
  - (2) Move the stitch tongue to the left or to the right in accordance with the cutting width of the knives.
- \* If the stitch tongue is moved to the left, the size of bite narrows and, on the contrary, if moved to the right, it widens.
- \* You can adjust the size of bite from 3 mm to 5 mm.
- (3) Return the upper knife to the original position and test-sew.

### NOTE:

Be sure to tighten the screws for the lower knife holder and the movable stitch tongue after adjustment.

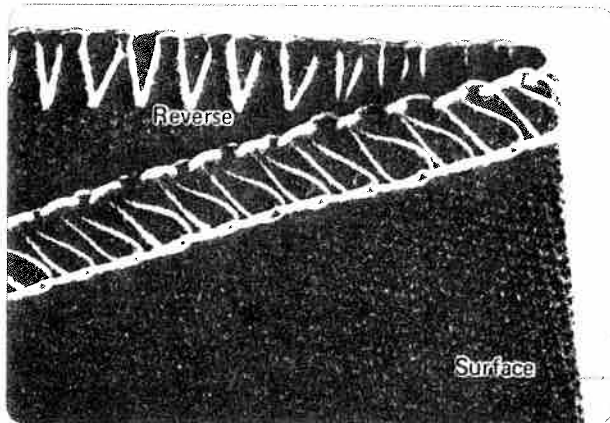


### If the cutting width is narrower than bight size:



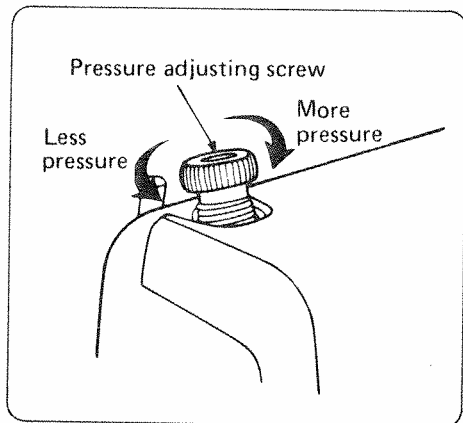
\* Loosen the screw for lower knife holder, move the holder to right, then adjust the bight size and cutting width. Or, loosen the set screw for movable stitch tongue and move it to left.

**If the cutting width is wider than the bight size**



\*In this case, the cloth will be rolled. Loosen the set screw for the stitch tongue and move stitch tongue to right. Then, adjust the bight size and the cutting width. Or loosen the screw for lower knife holder and move the holder to left.

**Presser foot pressure**

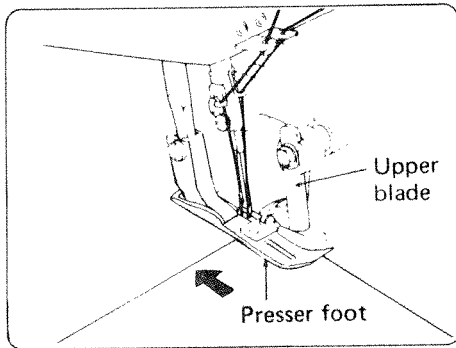


\*The pressure of the presser foot can be adjusted by turning the pressure adjusting screw. Since this machine has already been adjusted to a pressure suitable to light and medium-fabrics, no further adjustment is necessary except when you are sewing very heavy or very light materials. Usually, when sewing very light materials, the presser foot pressure should be slack and when sewing very heavy materials, it should be tight.



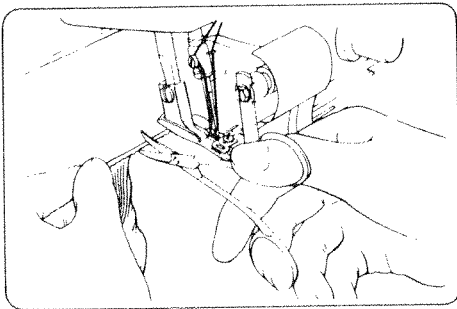
# Sewing

## To start sewing



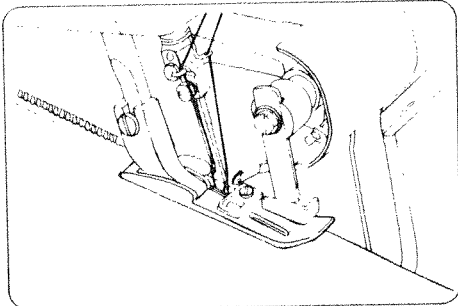
- \*Place the cloth well underneath the presser foot before starting to sew. Sew a few stitches first slowly by turning the pulley by hand.
- \*The cloth will be fed automatically. You need only guide it in the required direction.

## To remove the work



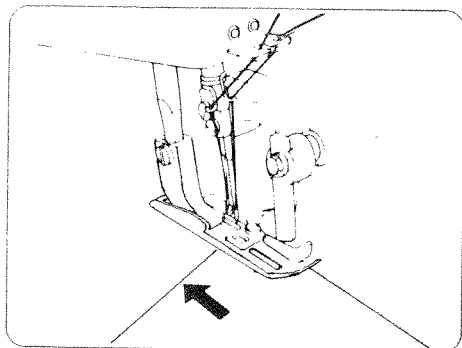
- \*When the work has been sewn to the end, keep the machine running at low speed until 5 cm of chaining-off is obtained. Then cut the stitches off at a point close to the work. If feeding for chaining-off is not enough, pull the thread gently.

## When threads break during sewing



- \*Remove the material and re-thread correctly. Place the same material under the presser foot so that machine will sew 3 cm to 5 cm over the previous stitches.

### To sew thick material



\*Place the material underneath the presser foot until it touches the front of upper blade. Then, start sewing.

\*Do not lift the presser foot while sewing.

### To sew fine material

- (1) Adjust the pressure to stop the material from puckering and to facilitate sewing curves.
- (2) The standard bite for the overlock machine is 3.5 mm, but when you sew fine material, select a bite size smaller to avoid edge rolling.
- (3) Set the thread tension slack, but if the thread tension is too slack, the thread may break and skipped stitches will occur.
- (4) When using synthetic thread, do not pass the thread through the thread check spring.
- (5) If the blades are blunt, they will not cut a clean seam, and also cause the cloth to pucker. (Refer to page 26 for changing the blades.)

## Fault-finding

This sewing machine is designed for trouble-free operation. However the following chart indicates faults which may develop in the absence of basic adjustments.

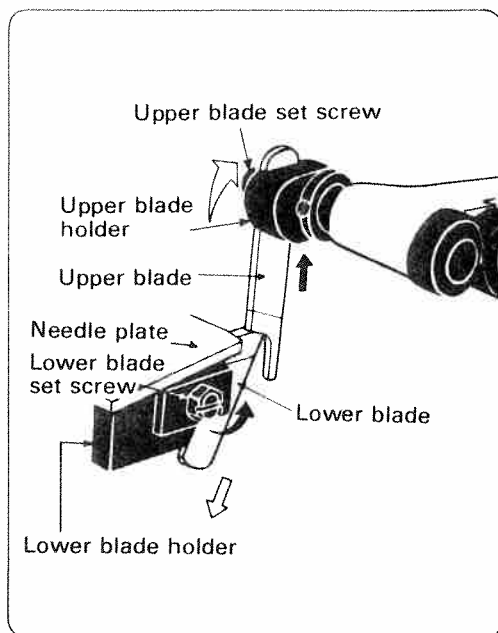
Trouble	Cause	Remedy
1. Won't feed.	Presser foot pressure too weak.	Turn pressure adjusting screw clockwise to increase presser foot pressure.
2. Needles break.	1. Needles bent, or needle tip blunt.	Replace with new needle.
	2. Needles incorrectly fitted.	Fit needles correctly. (See page 6.)
	3. Material pulled forcibly.	Do not press or pull material too hard when sewing.
3. Threads break.	1. Threaded wrong way.	Thread correctly. (See page 9 ~ 13.)
	2. Thread caught up in something.	Check spool pin, thread holders, etc. to see that threads are not caught up.
	3. Thread tension too tight.	See page 18 ~ 19 "Thread tension".
	4. Needles incorrectly fitted.	Fit needles correctly. (See page 6.)
	5. Wrong needle used.	Use sewing machine needle TE X 1 (DB X 1)
4. Stitches skip.	1. Needle bent, or needle tip blunt.	Replace with new needle.
	2. Needle incorrectly fitted.	Fit needle correctly. (See page 6.)
	3. Wrong needle used.	Use sewing machine needle TE X 1 (DB X 1)
	4. Threaded wrong way.	Thread correctly. (See page 9 ~ 13.)
	5. Presser foot pressure too weak.	Turn pressure adjusting screw clockwise to increase presser foot pressure.
5. Stitches not uniform.	Thread tensions not adjusted properly.	See page 18 ~ 19 "Thread tension".
6. Cloth puckered.	1. Thread tension too tight.	Decrease thread tension when sewing light-weight or fine material. (See page 18 ~ 19.)
	2. Threaded wrong way, or threads caught up in something.	Thread correctly. (See page 9 ~ 13.)

## Replacing the Blades

If the blades are blunt, they will cause the material to pucker and uneven stitches.

\* If one strand of thread can be cut off in front of or of the rear of the blade, the blade is sharp enough.

\* When the blades are blunt, replace them with new ones in the manner mentioned below. But be sure to unplug the power cord before doing so.



### Replacing the upper blade

- (1) To remove, loosen the upper blade set screw and pull up the upper blade.
- (2) Insert the new upper blade into the upper blade holder.
- (3) Then turn the pulley by hand until the upper blade is right down. Check that the upper blade is in front of the lower one and adjust the clearance between it and the edge of the lower blade i.e. from 0.5 mm to 1.0 mm.
- (4) Retighten the upper blade securely.

### Replacing the lower blade

- (1) Loosen the lower blade set screw and pull down the lower blade.
- (2) Insert the new lower blade into the lower blade holder.
- (3) Position the lower blade so that its edge is flush with the needle plate.
- (4) Tighten the lower blade set screws.

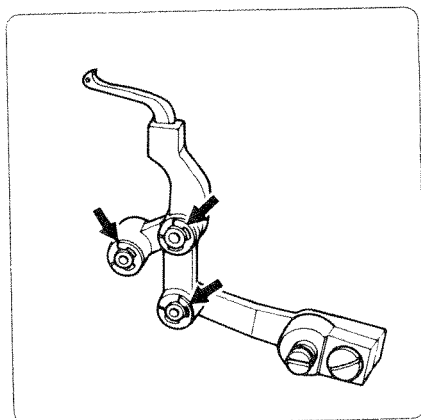
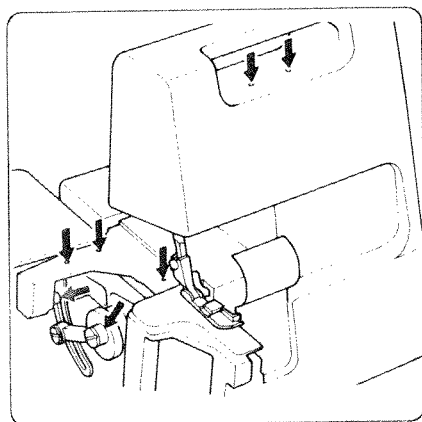
\* It is important to adjust the alignment of the upper and lower blades for sharp cutting.

## Oiling

For smooth and silent operation the moving parts of the machine should be oiled periodically. (See diagram below.)

### REMARKS:

1. Be sure to oil your sewing machine before use.
2. Oil 1 to 2 drops at the oiling points.
3. OIL ONCE OR TWICE A MONTH IF MACHINE IS USED NORMALLY. IF MACHINE IS USED MORE OFTEN, OIL ONCE A WEEK.
4. After oiling, run the machine without thread and the presser foot up. Wipe off an excess oil with a scrap of material to avoid oil stains.



## Machine Specification

Model No.	524
Use	Light to heavy weight materials
Sewing speed, normal	1,500 stitches per minute
Bite	3 mm to 5 mm
Stitch length (pitch)	2 mm to 5 mm
Needle bar stroke	27 mm
Presser foot	Free presser type
Presser foot lift	5 mm
Cutter width	Adjustable (3 mm to 5 mm)
Needle	TE X 1, #11, 14 (DB X 1 usable)
No. of needles and threads	Two needles, four threads
Machine net weight	7.0 kgs.



**Huskylock**

M440  
193541-0-17  
Printed in Japan