Standard Engineering Ltd.
10 Garrard Way, Telford Way South Ind. Estate,
Kettering, Northamptonshire, England, NN16 8TD.
VAT Reg No: GB 729 9213 08
Tel: 01536 517070
www.standardgroup.co.uk

PLEASE READ BEFORE USING THE STITCHER

Model 848 Goodyear Tips

Your stitching machine has been thoroughly tested prior to delivery. It is vitally important that you follow our guidelines as your warranty may be invalidated due to operator error if not.

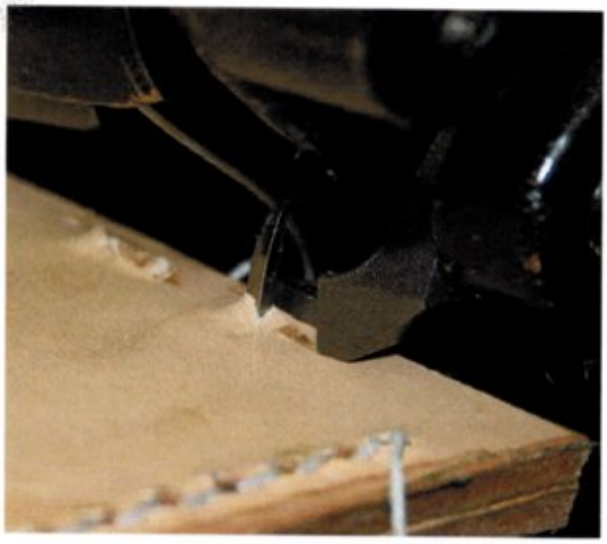
- Thoroughly read your manual before using your machine. In addition, watch the supplied DVD.
- Keep an eye on your thread use and replace before it reaches the end of the cop. It is much easier to tie a small knot in the braid and pull it through your machine, than fully re-thread it!
- Keep clean (**weekly brush with a 2" paint brush**). This will help keep the machine grease free and assist the free running of your stitcher.
- Use a quality general-purpose oil such as 3-in-1 or Duckams Duck oil on the shuttle, needle, awl and needle guide before stitching. **On a weekly basis** also use this oil for the cams and inner workings of the machine.
- Regularly check the condition of the needle and awl (weekly if used often). This will help maintain a quality stitch and help prevent breakages. Replace said items if blunt or damaged.
- Always use 'Geneva' branded thread in your machine. Inferior polyester braided threads are readily available, but will often give you problems.

We recommend Geneva thread (MP1498/A White) through the machine and 6 cord waxed thread (WA11020/A) in the shuttle.
Both of these threads are available from Standard.

For machines fitted with a block table (see below). Before using your stitcher, make sure you have set your grooving tool to your machine. Should you ignore this crucial step, you may damage your machine during the stitching operation, as too much pressure will be placed on the needle and cause it to break!

Please follow the steps below: -

Rest a leather sole against the block table shown.



Manually turn the stitcher wheel away from you until the awl pierces the leather

Identify awl piercing as shown. This mark (highlighted for the purposes of this example) shows where the machine will stitch in relation to the channel yet to be grooved.

Ensure that your grooving tool grooves to this mark. This will prevent the need to "push" the sole into the machine to stitch within the channel, as the Goodyear will automatically be stitching in the right place.

When stitching the sole resist the temptation to push the leather through the mechanism. On the other hand, it is not recommended that the sole isn't held too timidly. Hold the sole firmly but lightly and allow the operation of the stitcher to draw the sole through the mechanism. Keep turning the sole as it is pulled through the machine. Please refer to the included DVD for a demonstration of the correct stitching method.

Should you need to raise the presser foot, for example when stitching rubber, please follow steps shown in diagrams.

To raise the presser foot and hold it at the higher level as per this photograph use the included tommy bar to loosen the nut as shown.

The bar, which has been loosened, needs to be set to adjust the height of the presser foot. Setting the bar lower will raise the gap between the presser foot and the table.

When the presser foot is at the desired height, re-tighten the nut.

To lower the presser foot the bar must be raised by the same method.

INSTRUCTIONS FOR OPERATING THE "STANDARD" GOODYEAR TYPE STITCHING MACHINE

The successful operation of the "Standard" Goodyear Type Stitcher, depends a great deal upon:-

The Machine being kept clean and oiled frequently.

SPEED OF MACHINE

The countershaft should run at 350 to 400 rpm in a clockwise direction, when viewed from the right of the operator.

OILING MACHINE

All oiling places in the machine head should be oiled twice each day with good quality medium bodied lubricating oil, first wiping the machine clean. The Countershaft should also be kept well lubricated.

The sight feed lubricators on the hood of the No 1 Machine should be adjusted to allow oil to drip slowly into the head of the mechanism.

THREADING THE MACHINE

See Diagram, Plate 31

OPERATING THE MACHINE

Turn the handwheel to bring the Take-up to its highest position. Pull forward the lever G1291, this will release the Presser Foot Locking Pawls. The Presser Foot will now be free - push the Presser Foot Lever backwards, still keeping the pawls disengaged. Place the work on the table, welt downwards, and allow the Presser Foot to come to the work. Now release lever G1291, this will cause the pawls to lock the Presser Foot.

Remember:- NEVER bring the Presser Foot down to work when the pawls are engaged, or their life will be shortened considerably.

It may be an advantage to pull the Presser Foot lightly to the work, before making the first stitch.

The needle thread should be held lightly allowing the machine to take a small amount of thread for the first stitch.

If difficulty (breaking thread etc) is found in allowing this small amount of thread to go to the machine, the handwheel should be turned upwards away from the operator until the Take-up is almost in its lowest position, when no further thread will be required for the first stitch. This is a difficulty only experienced by beginners.

The shoe should not be twisted or distorted during stitching, neither should it be pursued or retarded in the direction of the feed of the machine. The best results will be obtained by holding the shoe to the Edge Gauge and just by guiding the work.

A perfectly adjusted machine will produce unsatisfactory work if the operator is careless in the handling of the shoe.

Remember:- The feed of the machine is quite positive - no help is needed in this direction JUST GUIDE THE SHOE.

The beginner will find it advisable to reduce the speed of the machine when stitching round the toes and in the waists.

The machine should be kept running evenly and when speed is reduced it should be reduced evenly.

Do not remove the work until the last stitch has been properly formed.

To do this - Stop the machine with the Take-up at its lowest position, then turn the Handwheel towards the operator to bring the Take-up to its highest position. The thread will then have fallen, and will be locked in the sole.

When an ordinary table is used, the beginner may cut the upper with the awl. This is due to faulty operating. The loose upper in the waists should be held away from the awl by the fingers. After a little practice this is quite simple.

The use of table G667 renders this precaution necessary.

A perfectly free passage of the needle through the needle guide is very necessary and to ensure this the holes in the needle guide through which the needle passes should be lubricated frequently. This will prevent the needle binding in the needle guide and causing damage to the mechanism. If the needle is allowed to run dry, the action of the leather on the needle is liable to cause this binding of the needle.

The thread rollers in the waxpots must be submerged in the wax.

When stitching rubber, wet the surface of the sole, this will help to obtain a uniform length of stitch.

NEEDLES AND AWLS

Awls in every case must be one size heavier than that of the needle.

Needles	54	52	50	47	45	43	41	39
Awls to suit above Needles	52	50	47	45	43	41	39	37

No 54 is the smallest, No 39 is the largest.

THREADS

Blake Thread, being loosely wound, gives free access to the wax, which will quickly cover all the cords in the thread.

Needle	47	45	43	Both
Shuttle Thread	5 Cord	6 Cord	7 Cord	Blake
Thread through M/c	6 Cord	7 Cord	8 Cord	Threads

When using two Blake Threads, the shuttle thread must be 1 cord lighter than that through the machine

Needle	50	47	45	Stitching
Thread through M/c	6 Cord	8 Cord	10 Cord	Thread
Shuttle Thread	4 Cord	5 Cord	6 Cord	Blake Thread

ADJUSTING THE MACHINE

LOOPER

The Looper should be set to place the thread well into the barb of the needle, leaving sufficient space for the thread between the Looper and Thread Hook. See diagram 8, Plate 32.

NEEDLE

The needle should be set to allow the Looper to place the thread well on to the barb.

The needle should be set to the Looper, but a check can be obtained by comparing the position of the needle to the needle guide. See diagram 7, Plate 32.

AWL

Set the Awl to clear the needle point by about 1/6 inch. In no part of the revolution should the needle touch the awl. The awl and needle must be in perfect alignment or broken needles may result.

TO ALIGN AWL TO NEEDLE

See diagram 1, Plate 32.

Slightly loosen screw G1069V. Adjust Feed Slide by means of screw G650, finally locking up G1069V.

Badly cut awls are a common cause of broken needles. The awl should be cut in such a manner which will cause the work to be neither pulled on or pushed off the table. Some operators may find it an advantage to cut the awl to pull on slightly, but this must not be overdone or trouble with the needle and needle guide will occur.

KEEP THE AWL SHARP

See diagram 3, Plate 32

THREAD FEEDING

Adjustment is made by means of eccentric G638. Loosen Screw G639, adjust eccentric G638, finally locking up G639. See diagram 2, Plate 32.

THREAD LOCK

The thread must be locked when the Take-up is nearing its lowest point.

TO TEST LOCK

Turn the machine until the Take-up is about 3/4 inch from its lowest position. If the lock is set correctly, the operator should, only with some difficulty, be able to pull the thread through the machine.

The lock must not be too severe or the thread will be damaged and breaking will occur. See diagram 4, Plate 32.

BOBBIN CASE

Thread as Diagram 3, Plate 32. The thread should run freely and evenly. Tension adjustment is obtained by means of 3 small screws, the centre one being the locking screw.

THREAD LIFTER

The Thread Lifter should be set to pass as near as possible to the needle point. It must clearly separate the two threads on the needle, taking one to form a loop, into which the shuttle enters.

The Thread Lifter should be set just clear of the Shuttle. See Diagram 6, Plate 32. Adjustment can be made by means of eccentric G272.

TENSION ON THREAD THROUGH MACHINE

The tension on the thread through the machine should be greater than that on the shuttle thread, but it must be even and smooth.

All thread rollers must revolve freely, or uneven stitching will occur.

An excess of tension is unnecessary when the Thread Feed and Thread Lock are correctly adjusted.

BREAKING OF THE THREAD MAY BE CAUSED BY ANY OF THE FOLLOWING

Tension on shuttle thread may be excessive

Too much lock on thread

Thread Feed may be incorrectly set (give more thread, See Diagram 2, Plate 32)

The Looper may be set too near the Thread Hook

If the thread repeatedly breaks at about 3/4 inch above the work, the Thread Lifter needs adjustment (See Diagram 6, Plate 32)

Thread Rollers may be stuck

Thread may be off one of the rollers

Too much tension on thread through machine

There may be sharp edges on any part over which the thread runs

When using a light stitching thread a very high setting of the needle may cause breaking or stranding

The machine may be threaded incorrectly

STRANDING OF THE THREAD MAY BE CAUSED BY THE FOLLOWING

Badly set Looper (see that the thread is placed well on the barb of the needle)

Thread Lifter may not be properly separating the two threads

Sharp edges on any of the parts

The missing of stitches is usually caused by incorrect adjustment of the Looper. When stitching, the Looper should have about 1/16 inch clearance at the side of the needle.

If at any time the machine has to be taken down, the relationship of the teeth in the levers, with those of the segments, should be noted.

A small scratch placed on the cam shaft at each side of the centre cams makes the replacement of the cams a simple matter.

The Needle Guide must be correctly timed.

If the machine is revolved when the Needle Guide is out of time, the Thread Hook will probably be broken.

When turning the Machine by hand before the Needle Guide is timed, care must be taken to prevent the teeth of the Needle Guide Holder coming into contact with the Thread Hook.

There is no danger of these parts coming out of time.

The possibility of damage only occurs when the machine is being taken down or being built up again.

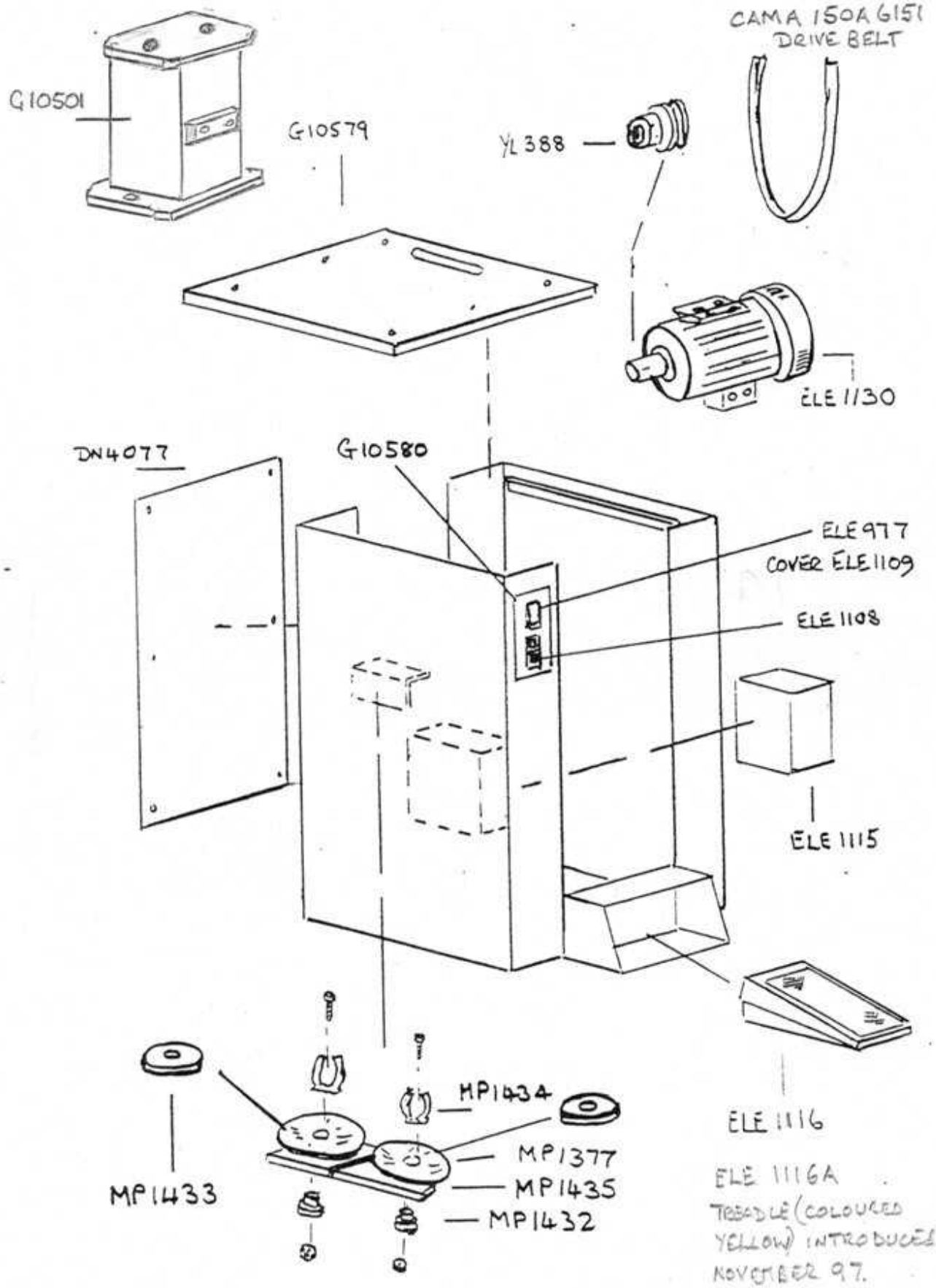
TO TIME NEEDLE GUIDE

See Diagram 5, Plate 32. Turn the machine (watching the Thread Hook and Needle Guide Holder) until the needle is at its lowest point.

Push the Needle Guide to the Needle Segment. Slide the Clap Pinion G549 into mesh as shown in Diagram 5, taking care that there is no side play in Shaft G547, before tightening Clamp Pinion G549.

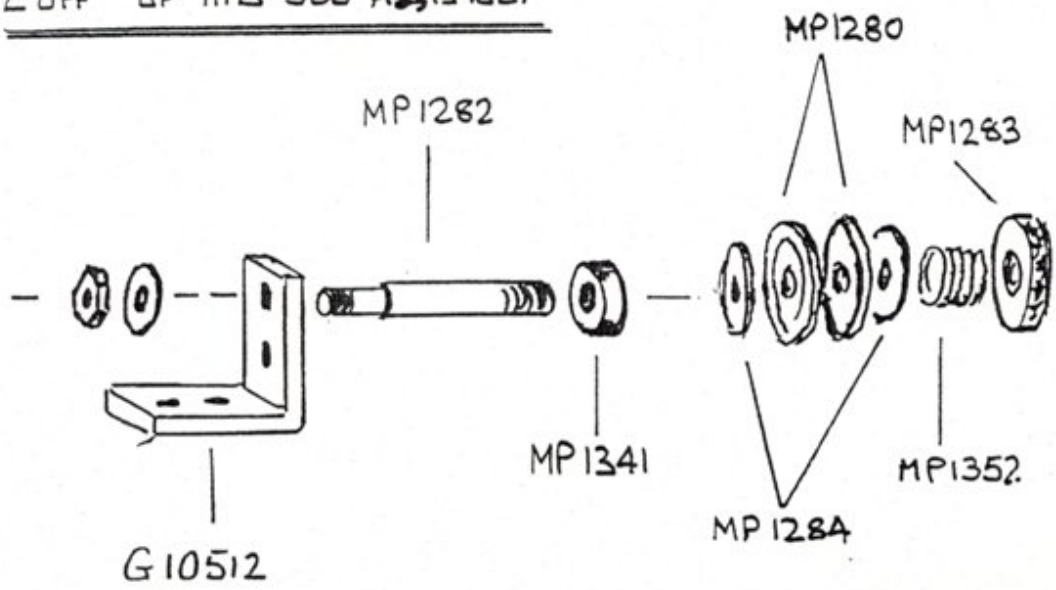
After any adjustment has been made the Machine should on no account be run under power until it has first been turned by hand.

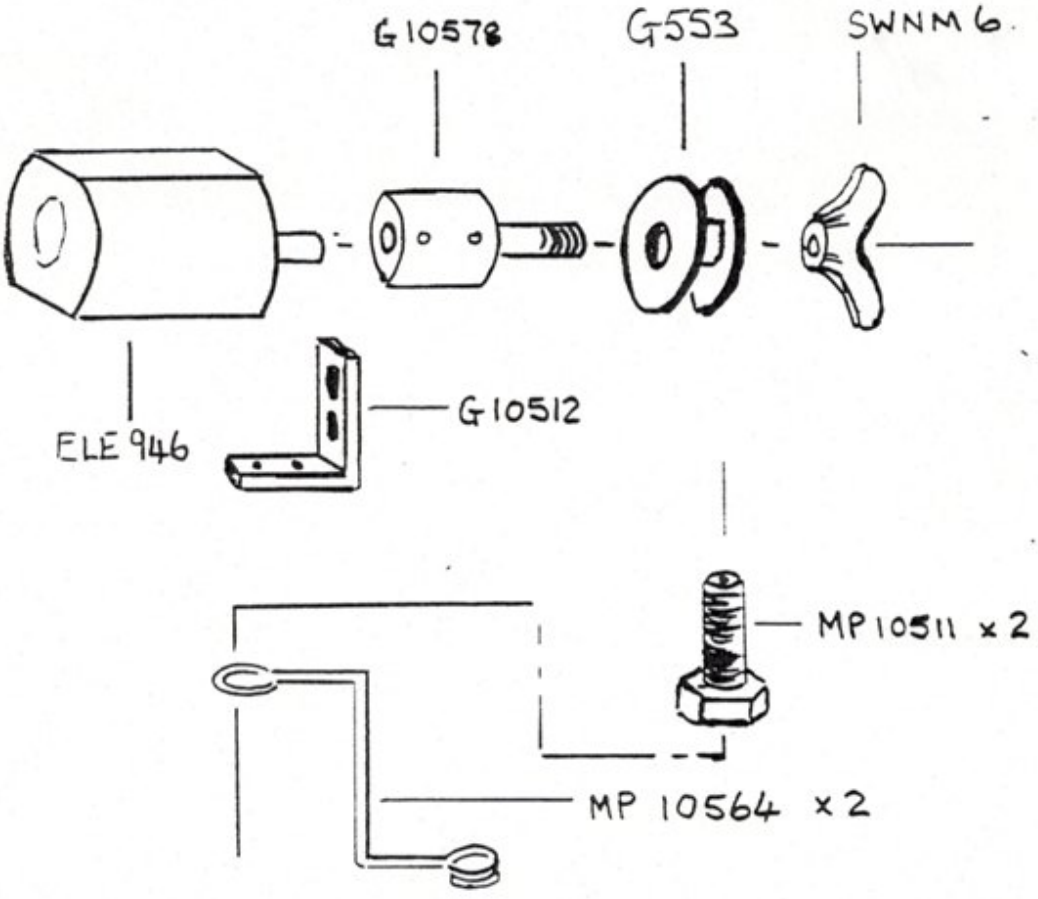
THE NEW STYLE BASE WITH AN INVERTER DRIVE UNIT.



ELE 1116A
TREADLE (COLOURED YELLOW) INTRODUCED NOVEMBER 97.

2 OFF OF THIS SUB ASSEMBLY





2 OFF OF EACH PART PER MACHINE

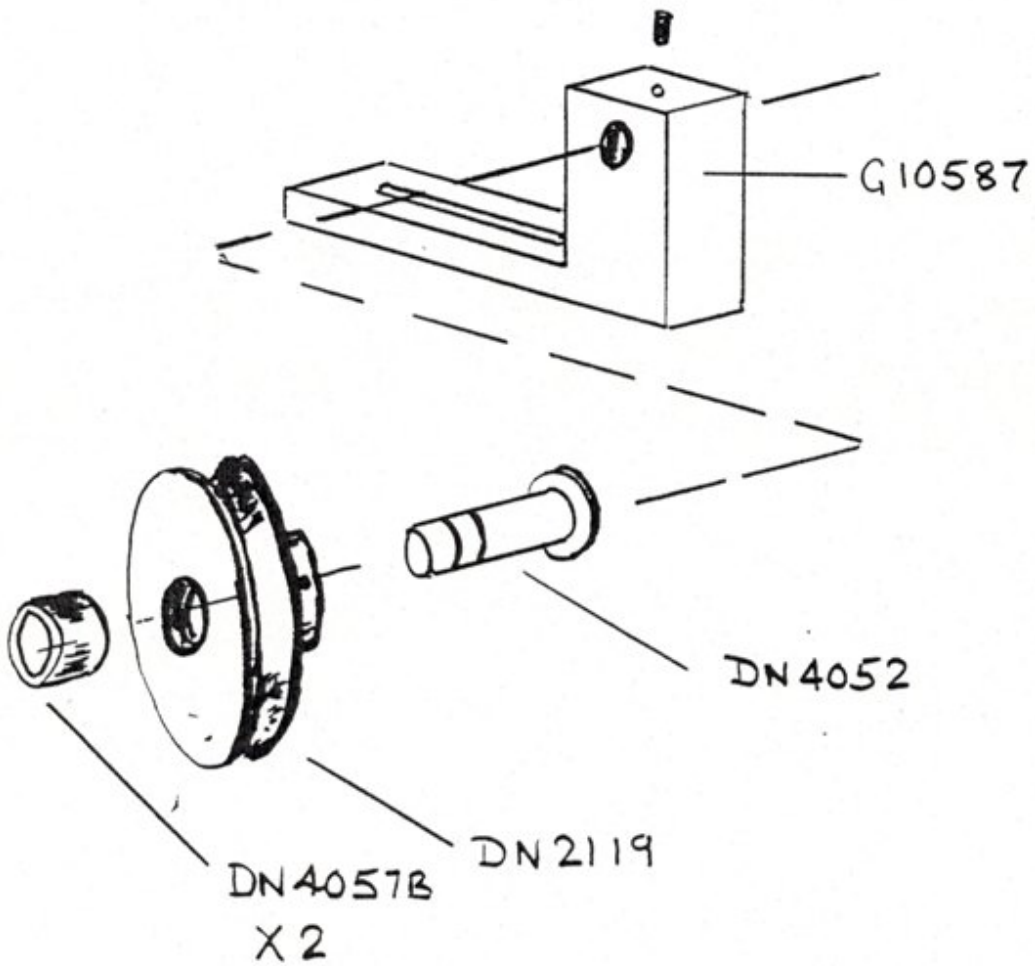

G10587
DN4052
DN2119
DN4057B
X2

PLATE 7
HEAD STOCK AND CAM LEVER FULCRUM SHAFT

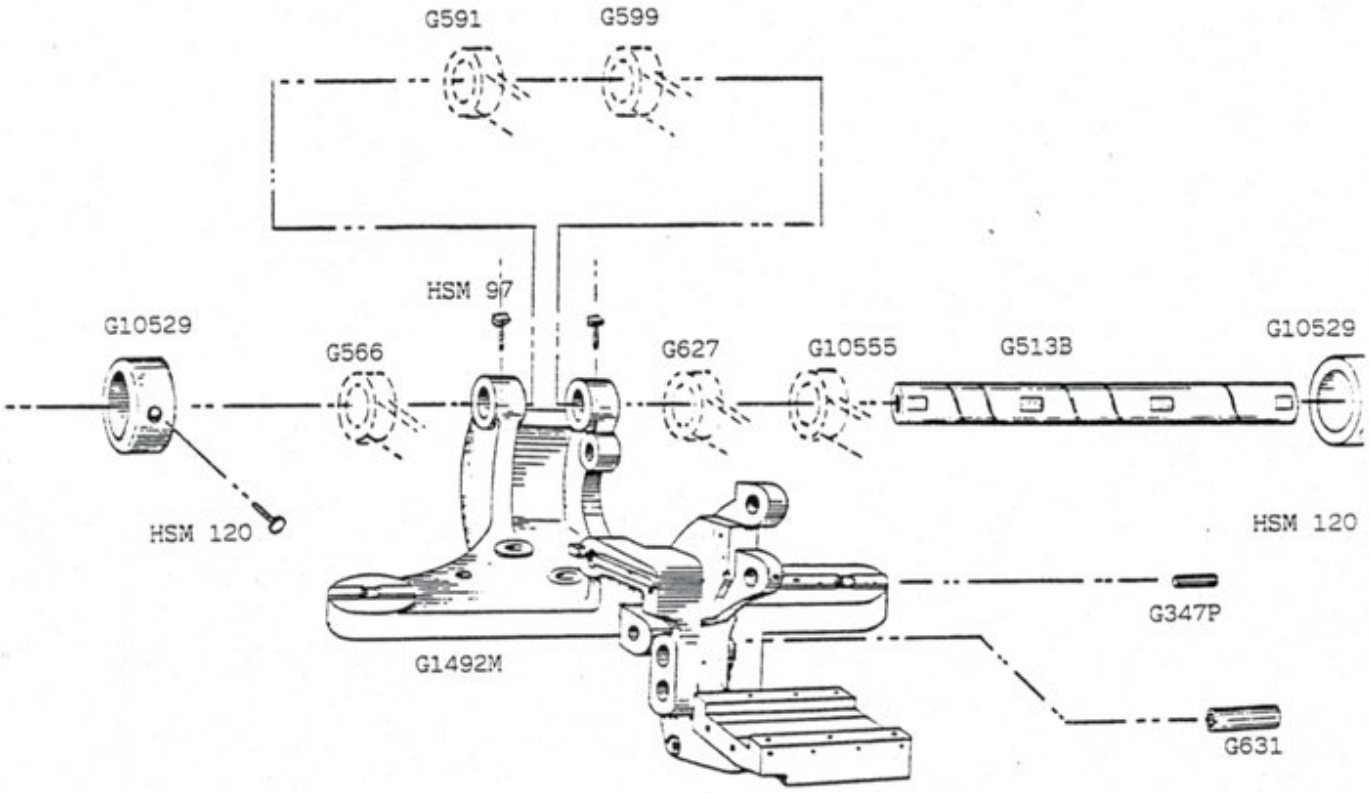


PLATE 8
CAMS AND CAM SHAFT ASSEMBLY

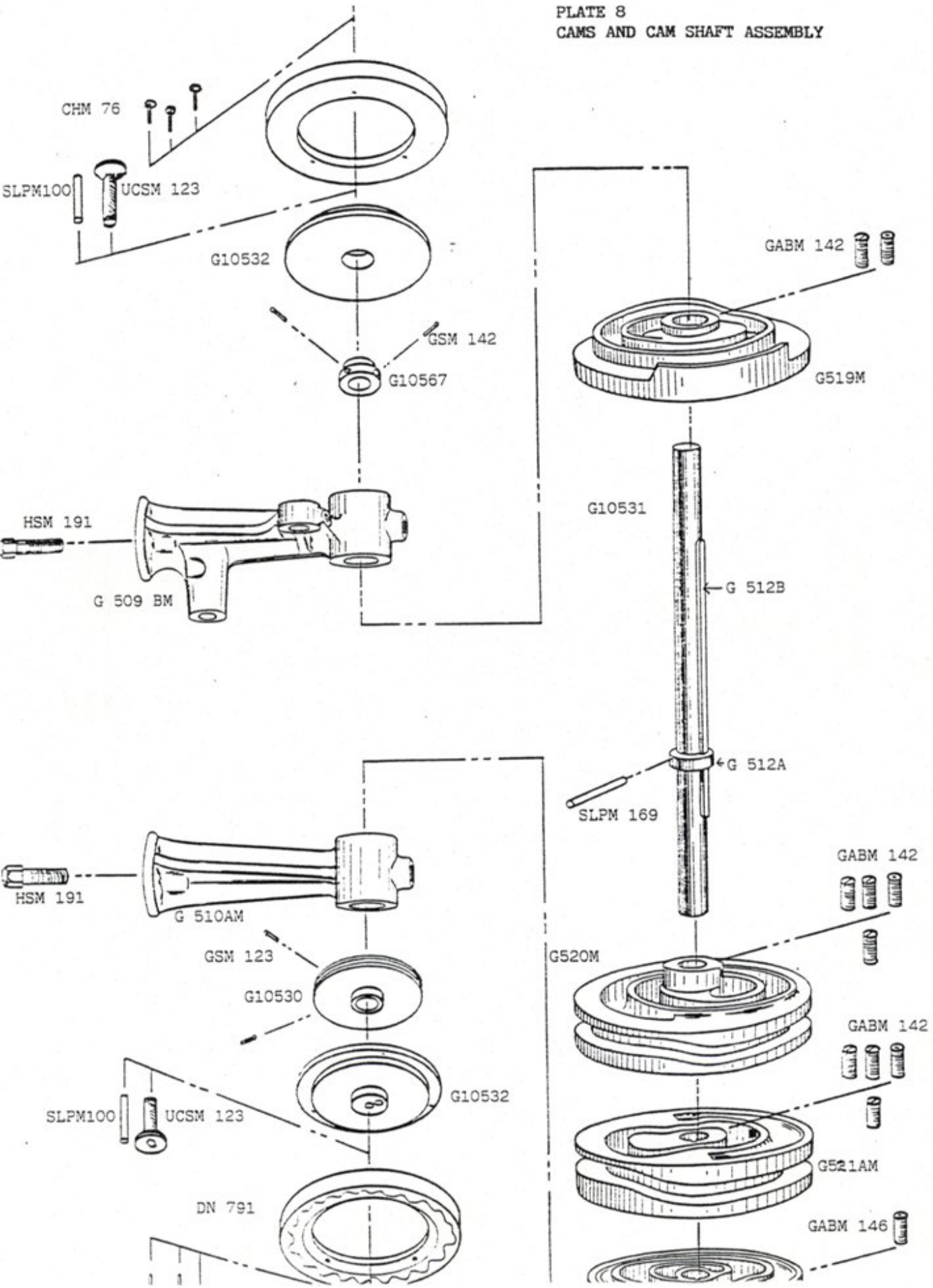


PLATE 9
HEADSTOCK SECTION & THREAD HOOK

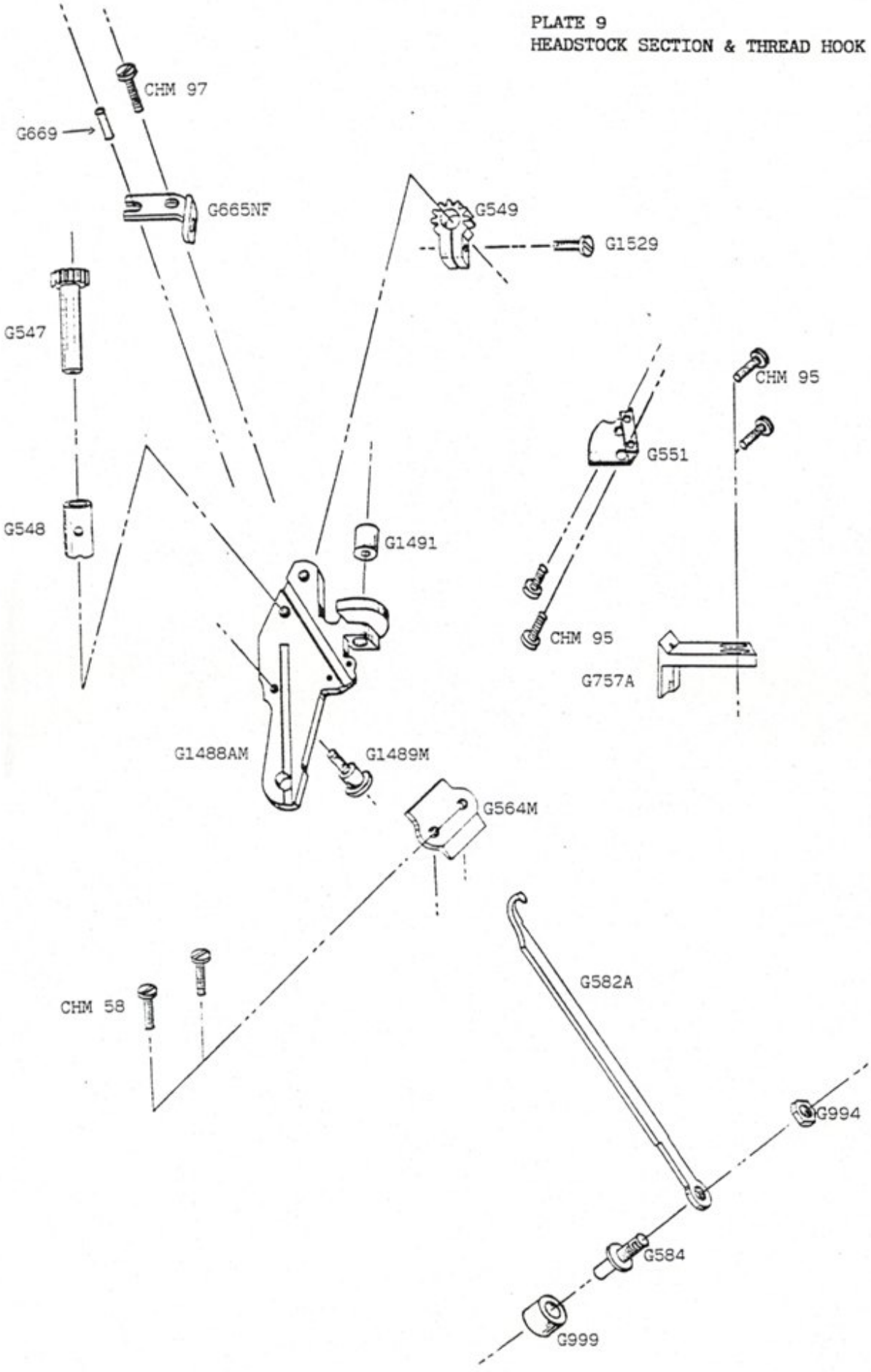


PLATE 10
NEEDLE GUIDE CAM LEVER ASSEMBLY

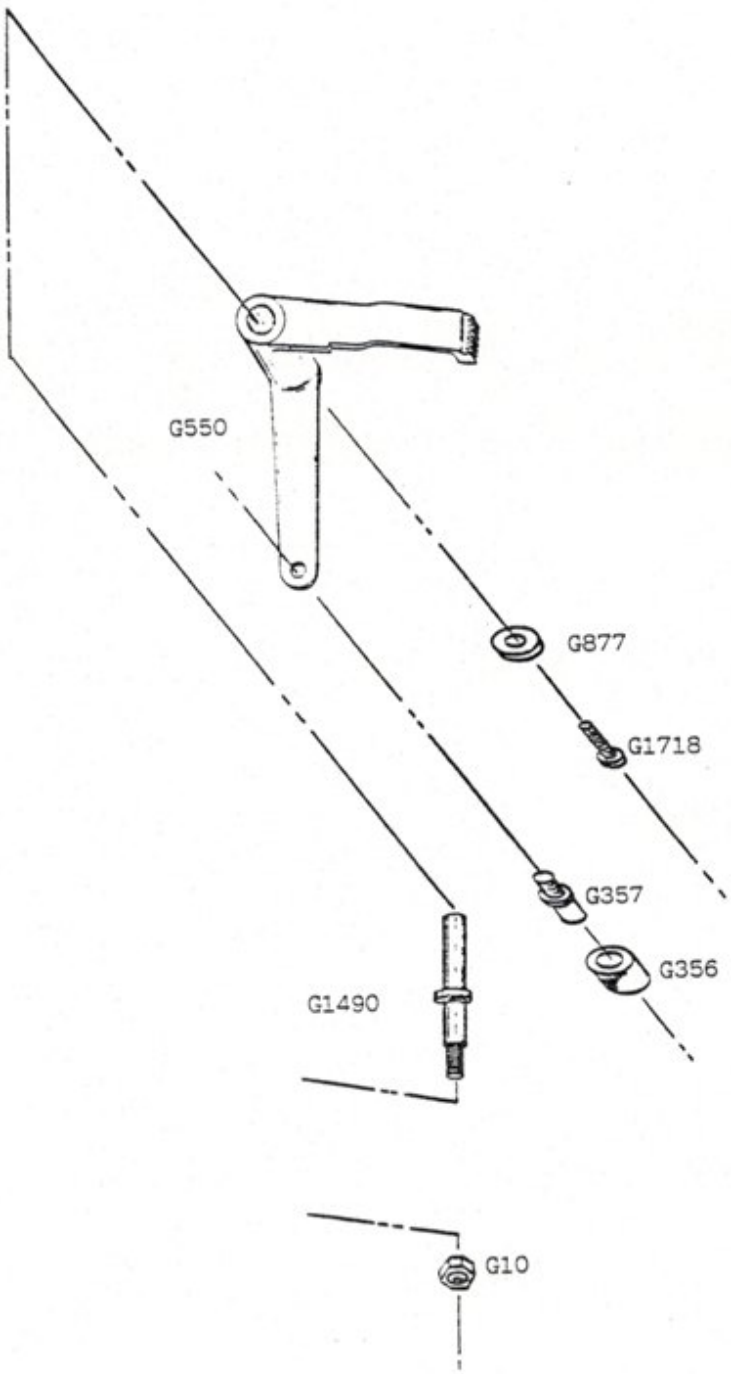


PLATE 11
THREAD LOCK MECHANISM

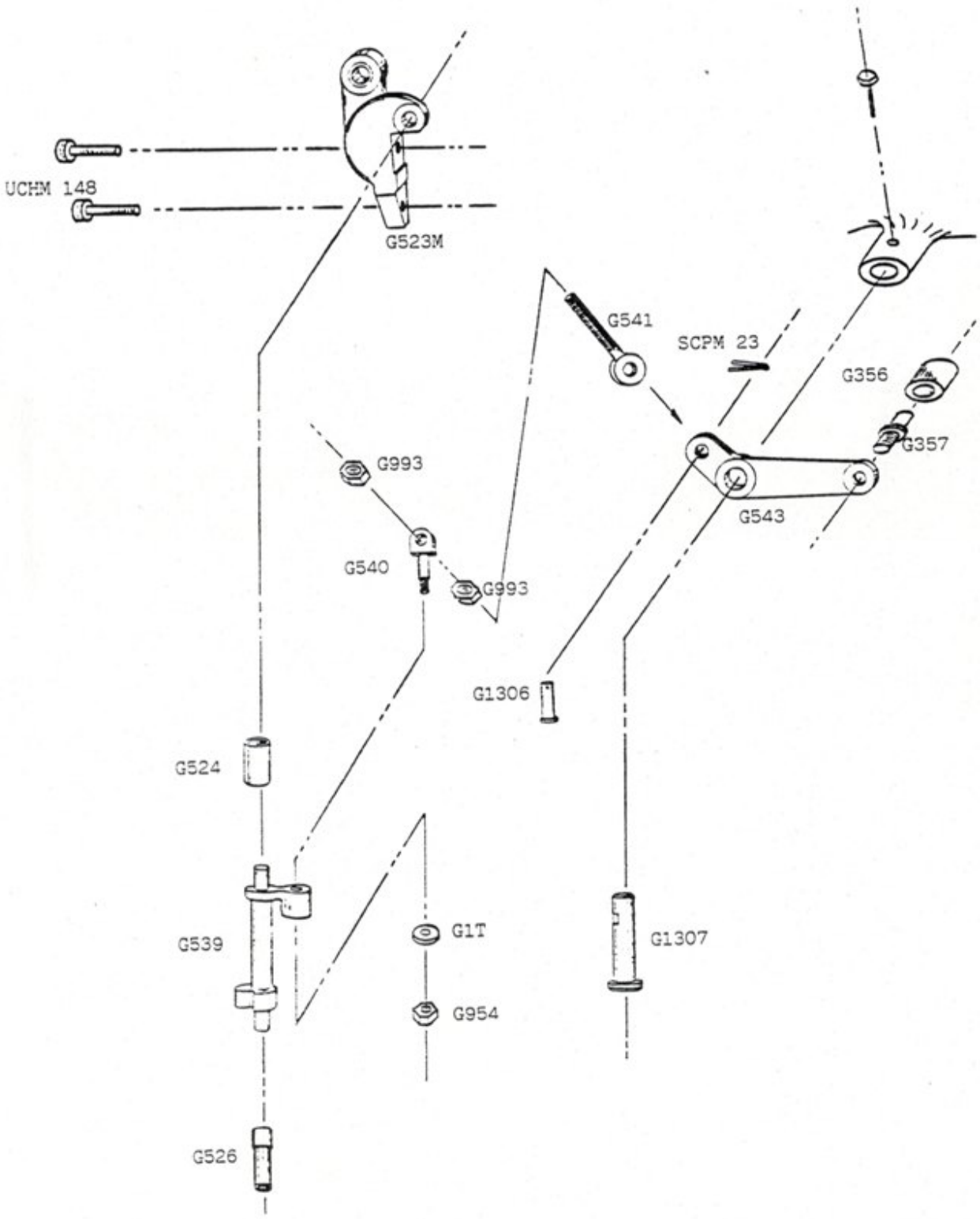


PLATE 12
THREAD TAKE UP

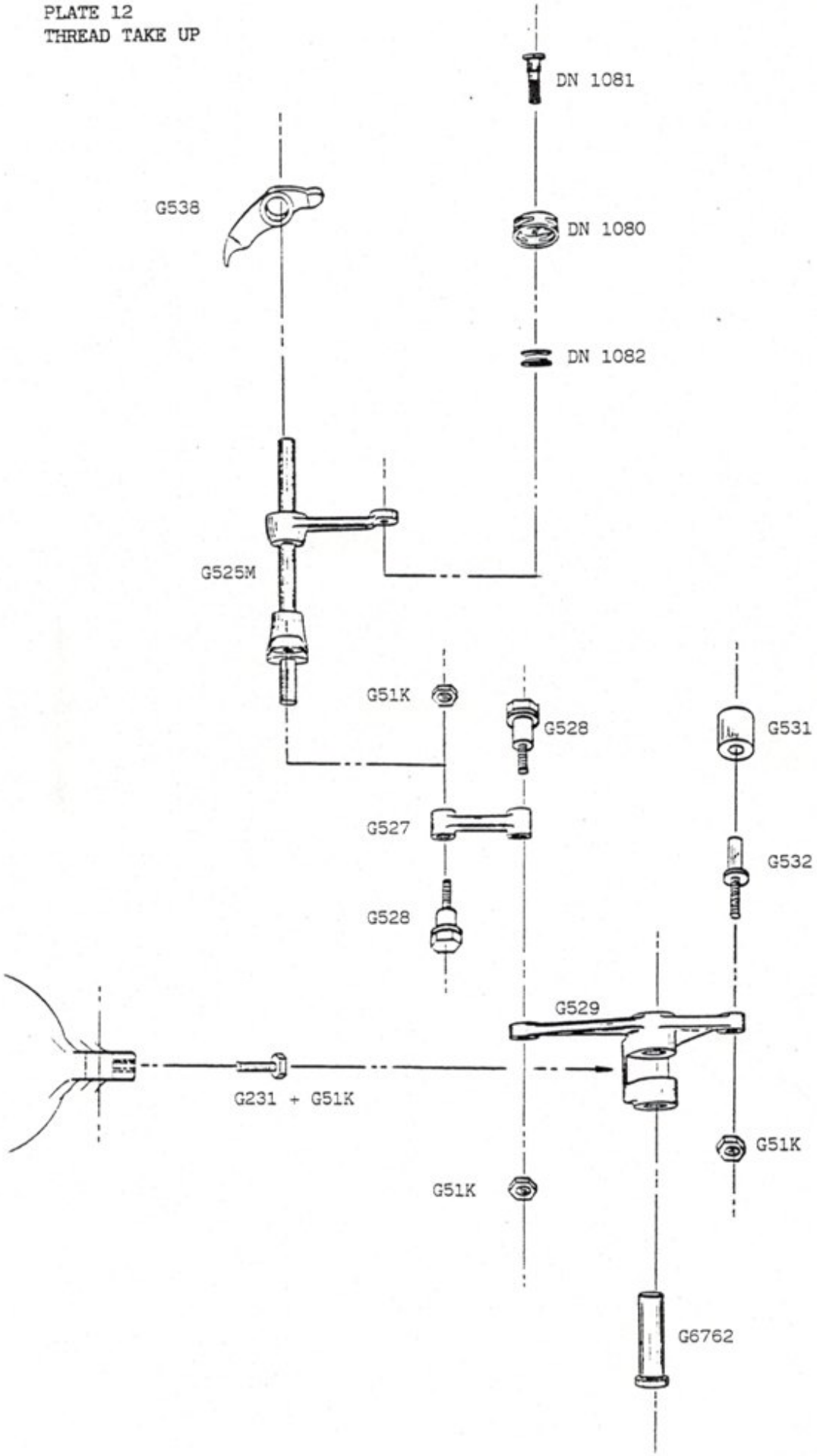
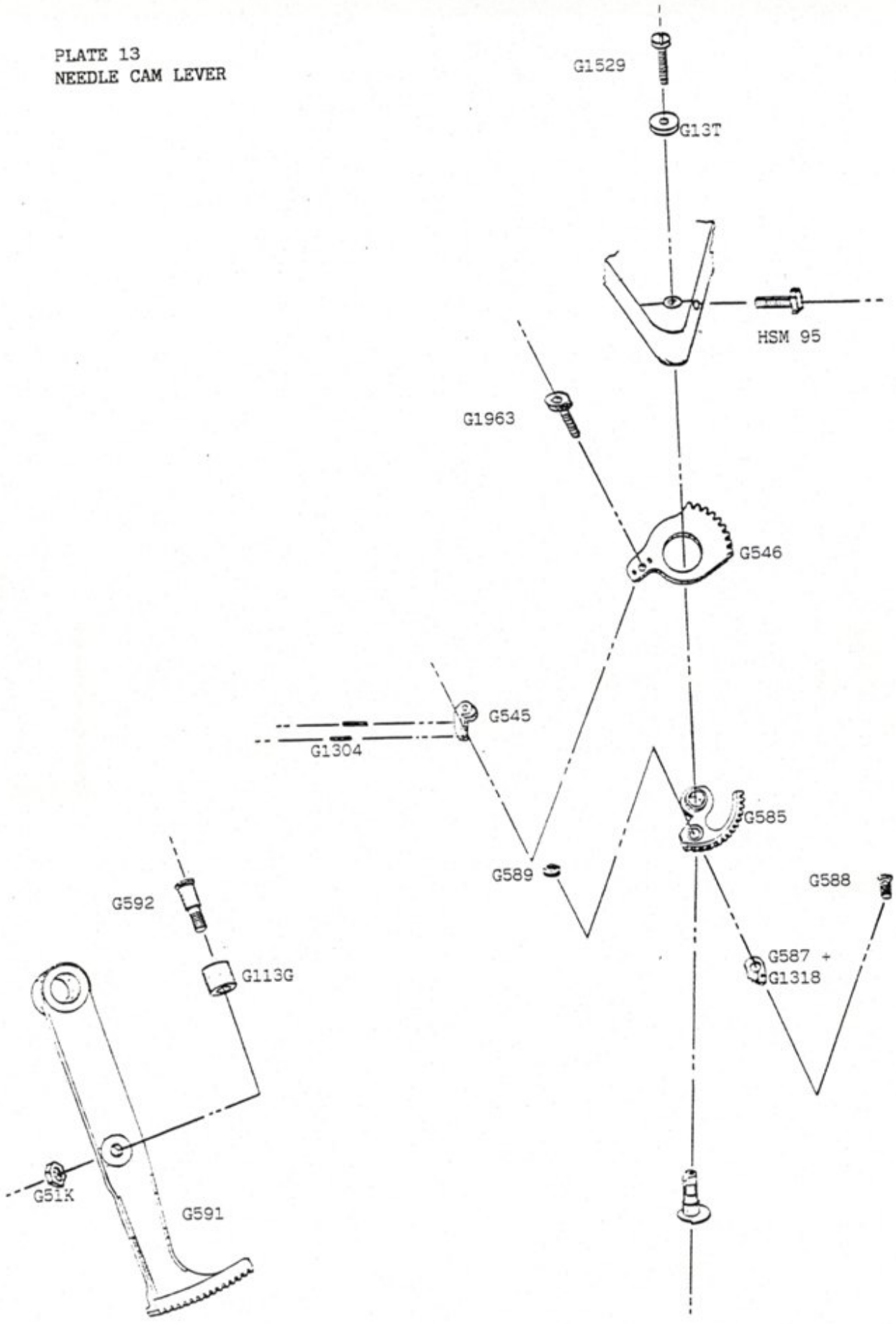


PLATE 13
NEEDLE CAM LEVER



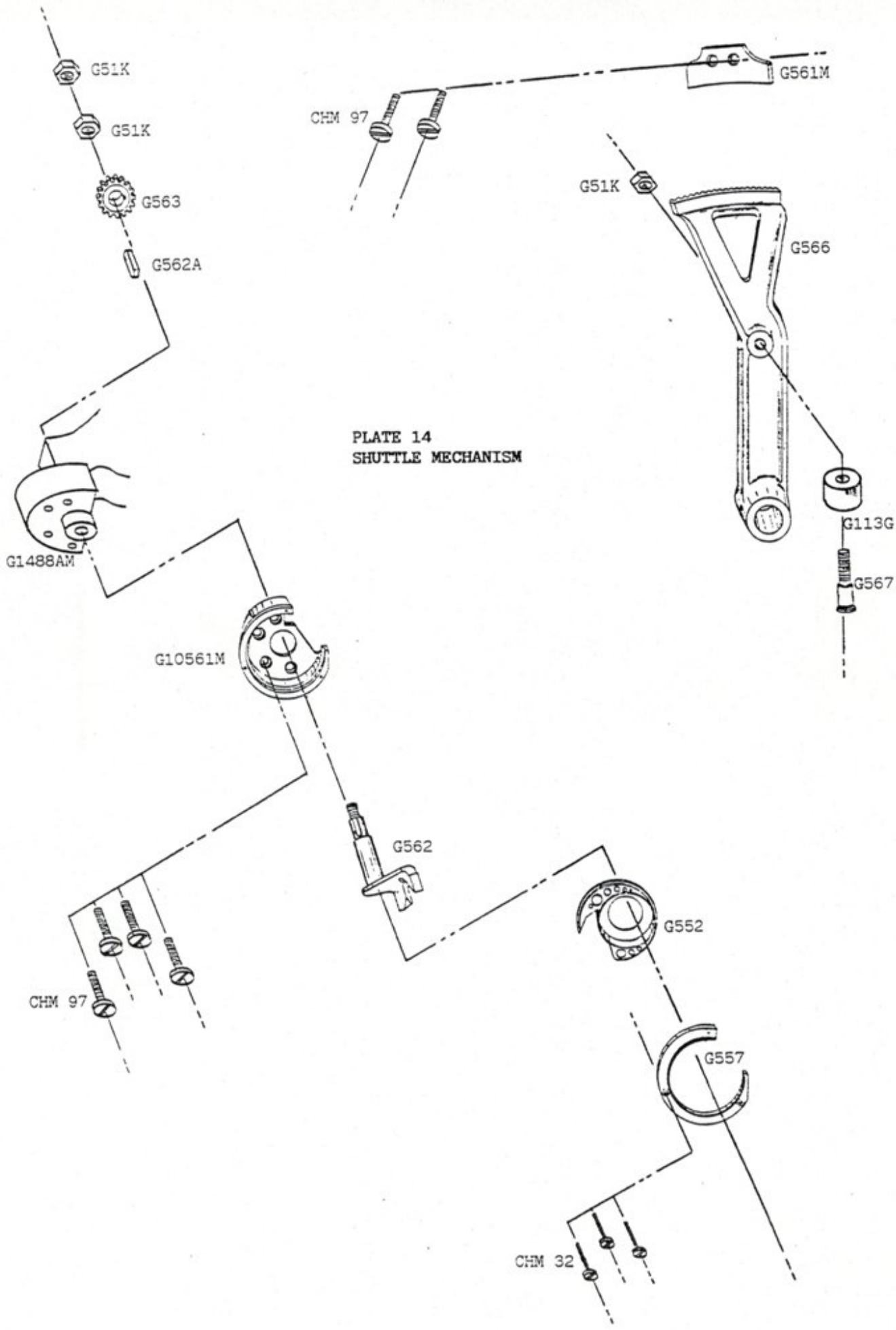
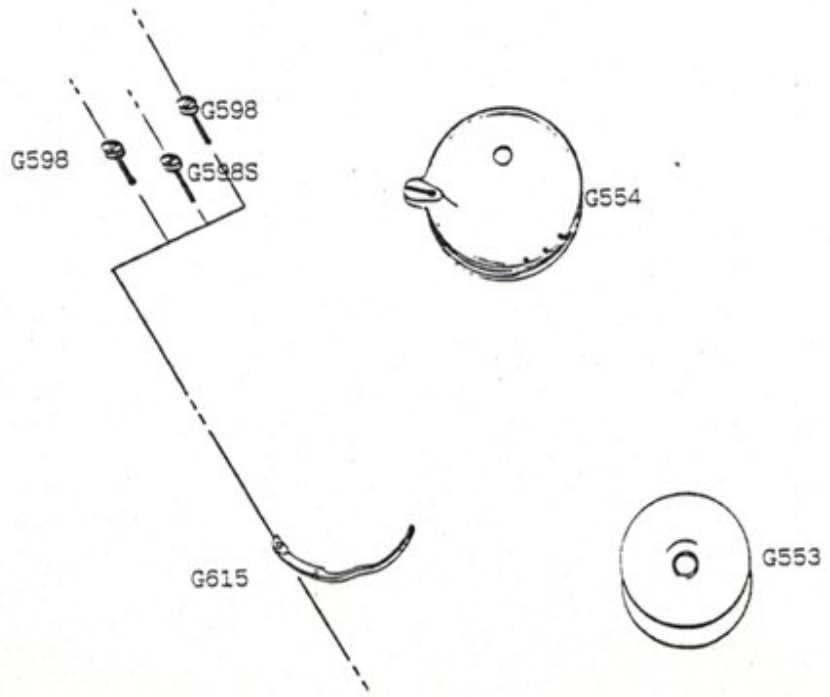


PLATE 14
SHUTTLE MECHANISM

PLATE 15
BOBBIN & GUIDE ARM



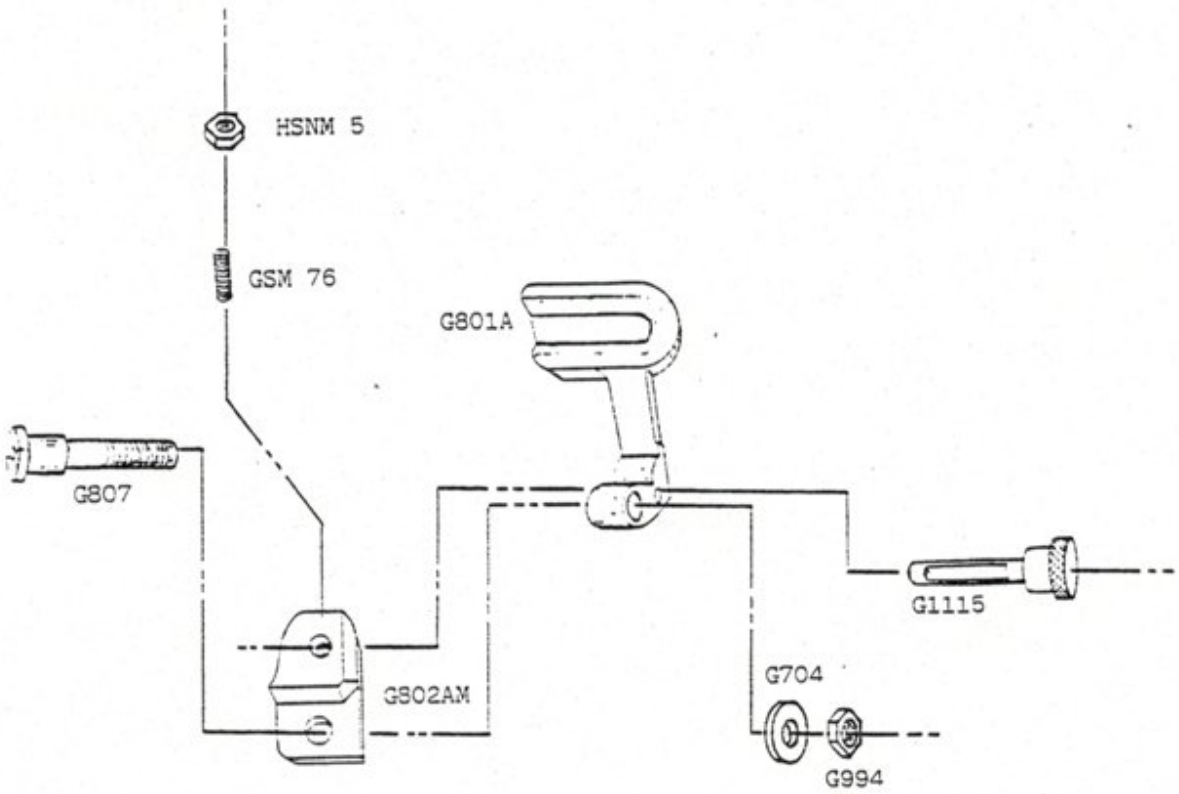


PLATE 16
LCOPER MECHANISM

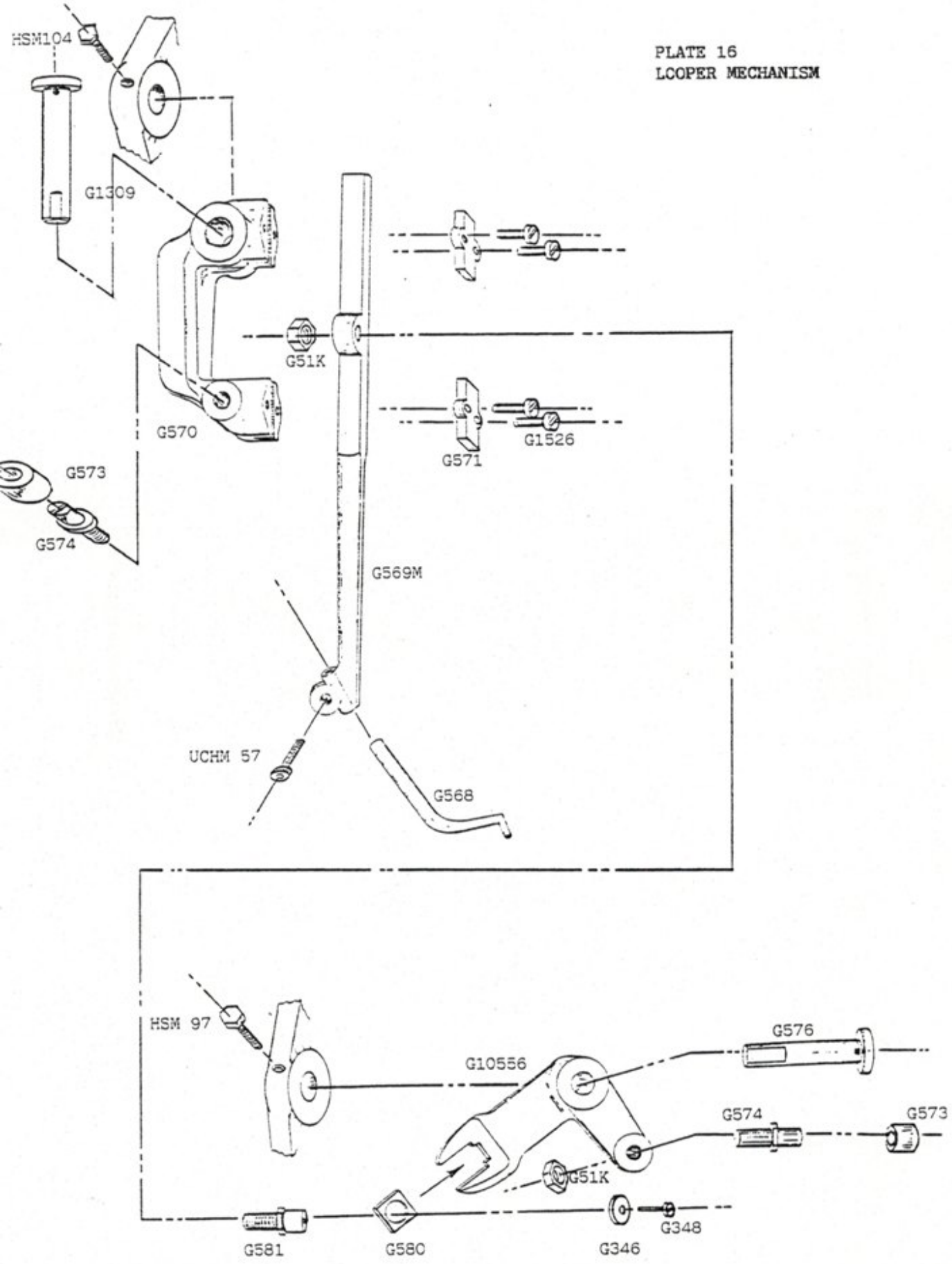


PLATE 17
AWL MECHANISM

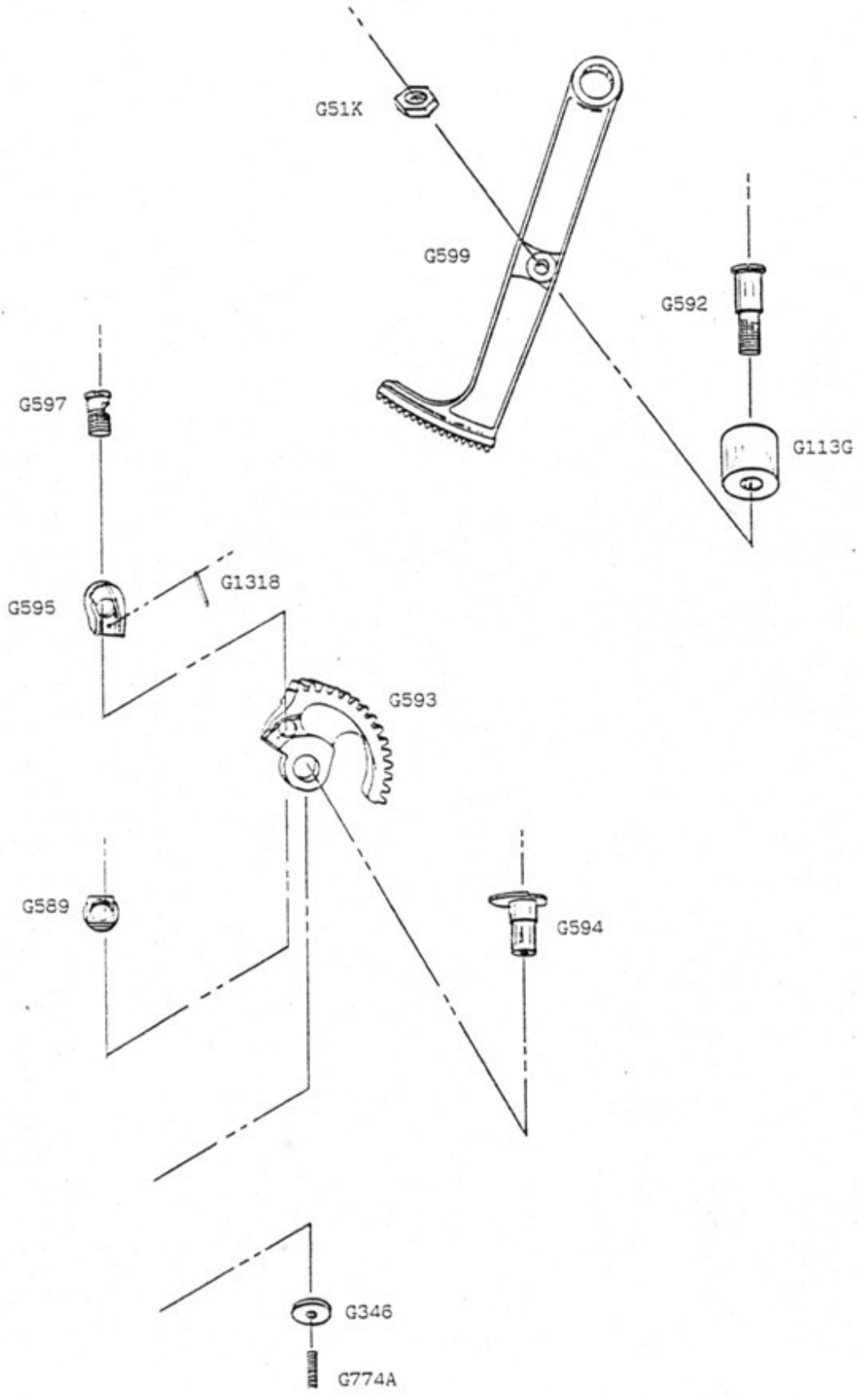


PLATE 18
PRESSER FOOT ASSEMBLY

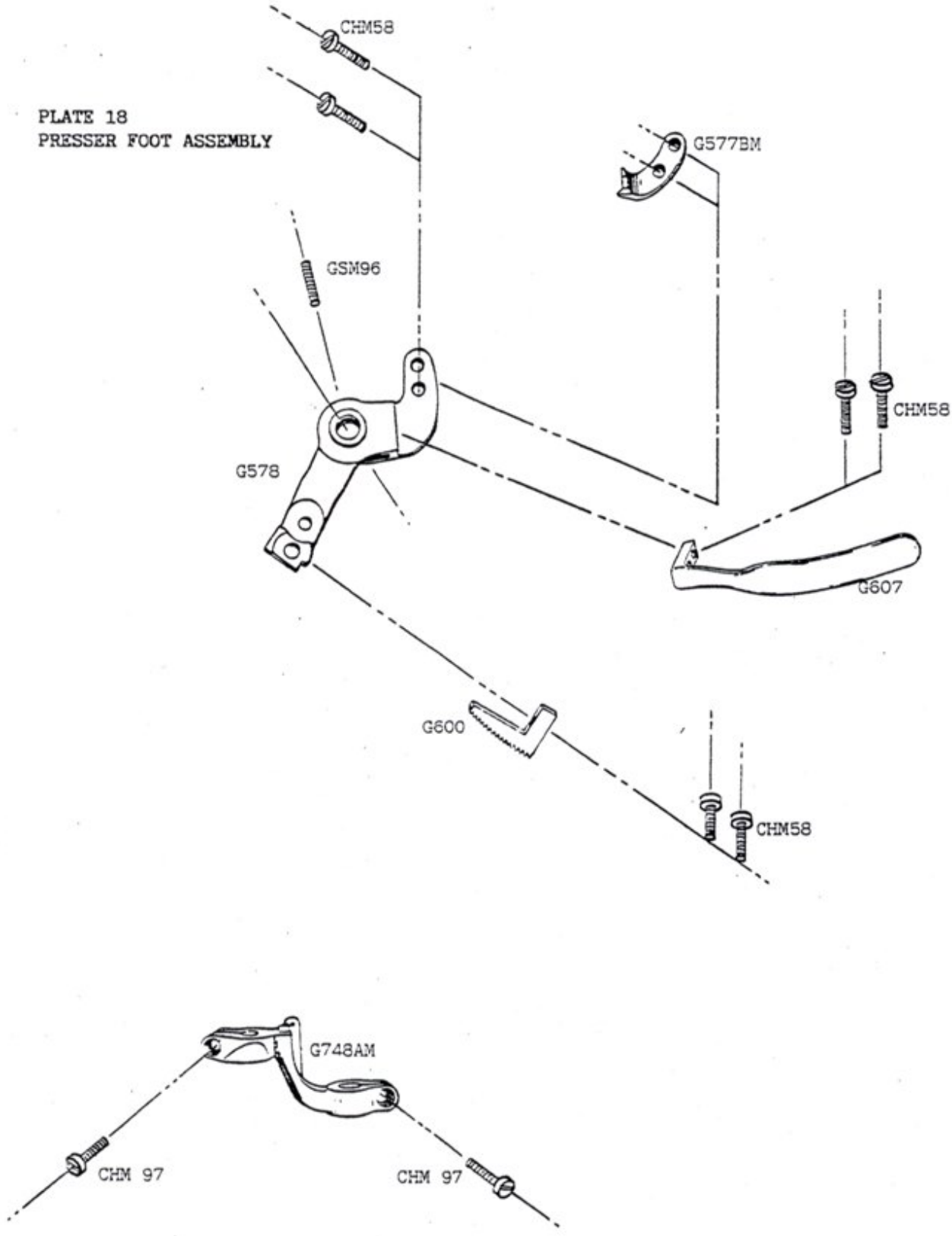


PLATE 19
DOUBLE RELEASE ASSEMBLY

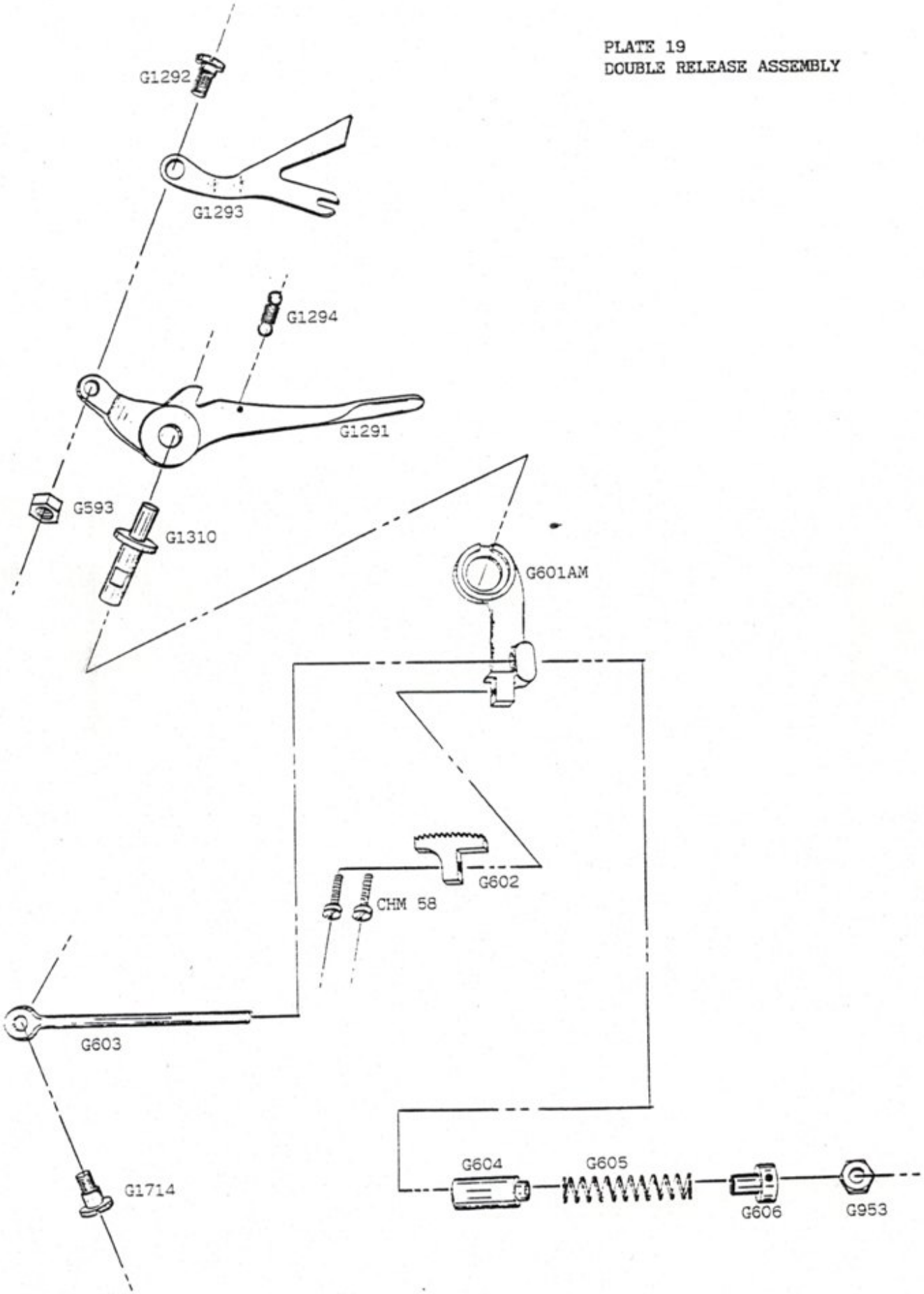


PLATE 20
AUTOMATIC LOCKING

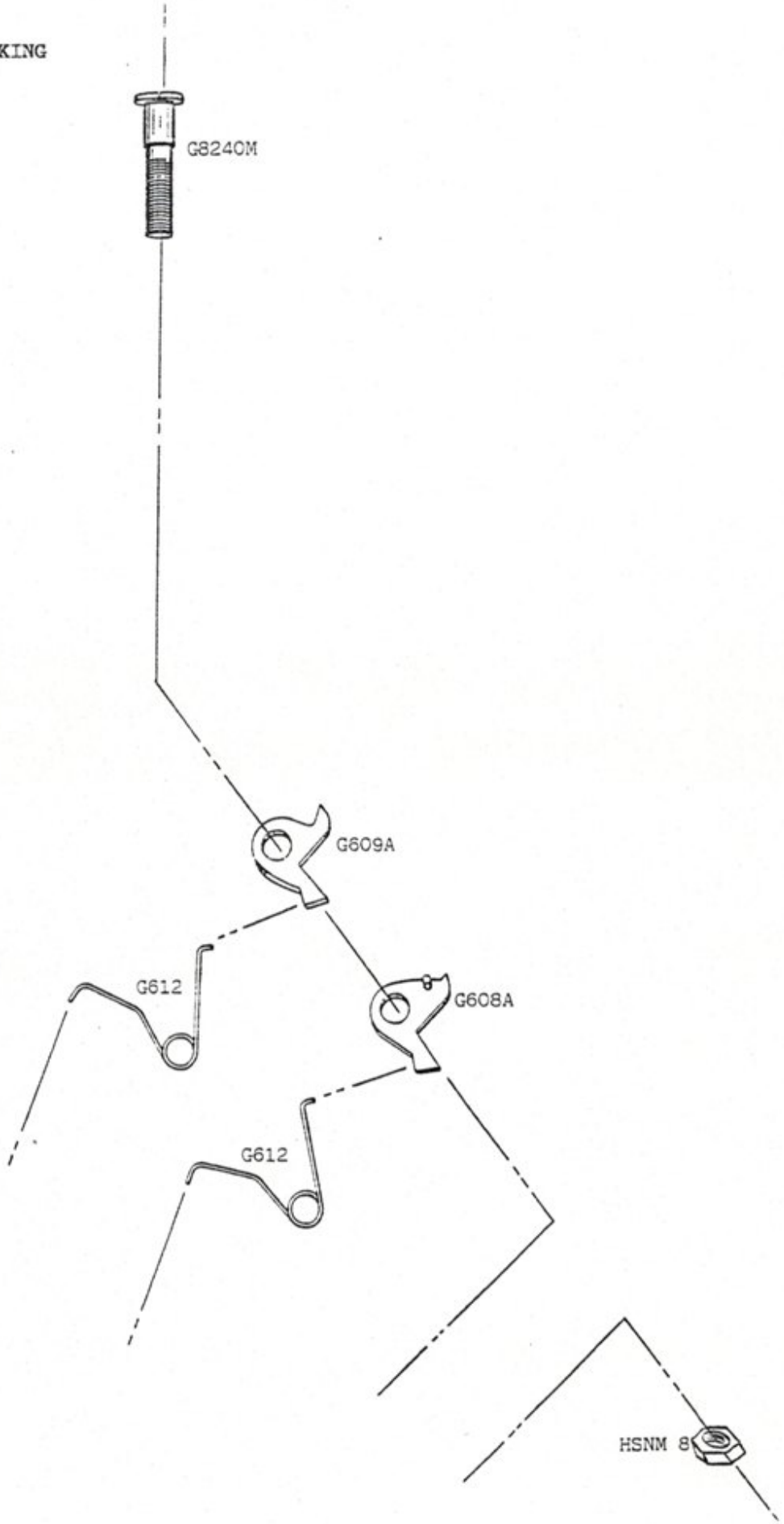


PLATE 21
PRESSURE ACTUATING ASSEMBLY

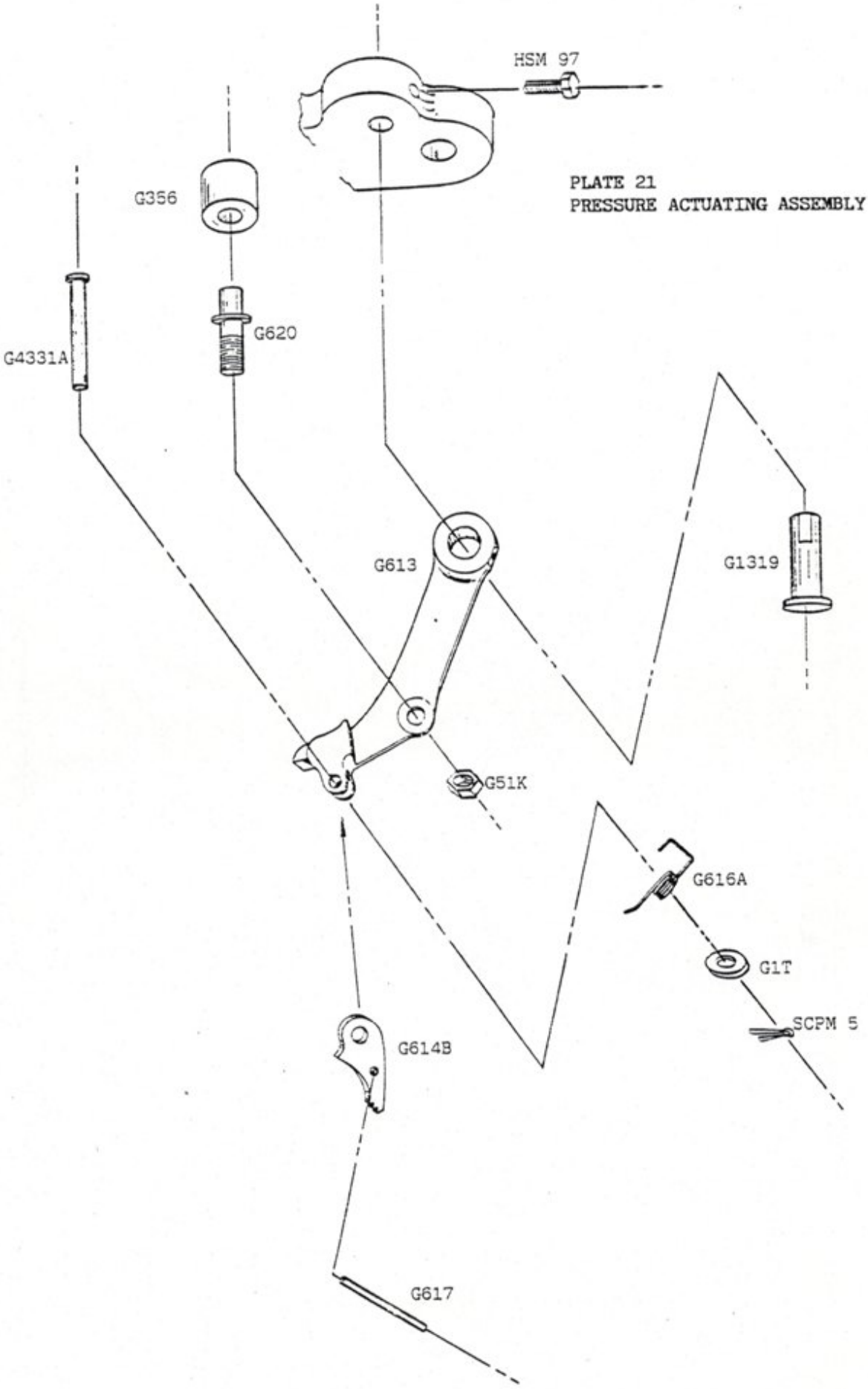
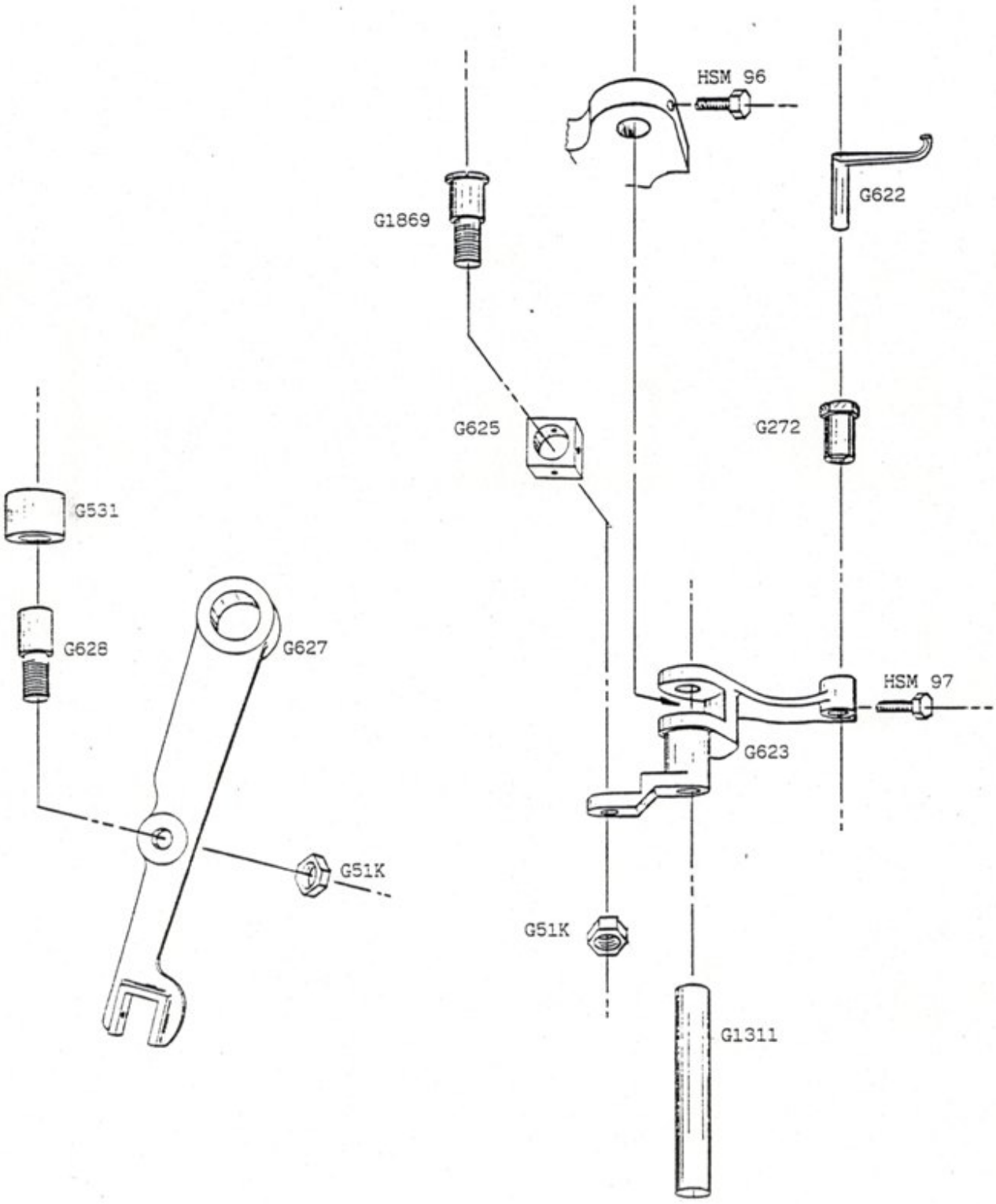


PLATE 22
THREAD LIFTER ASSEMBLY



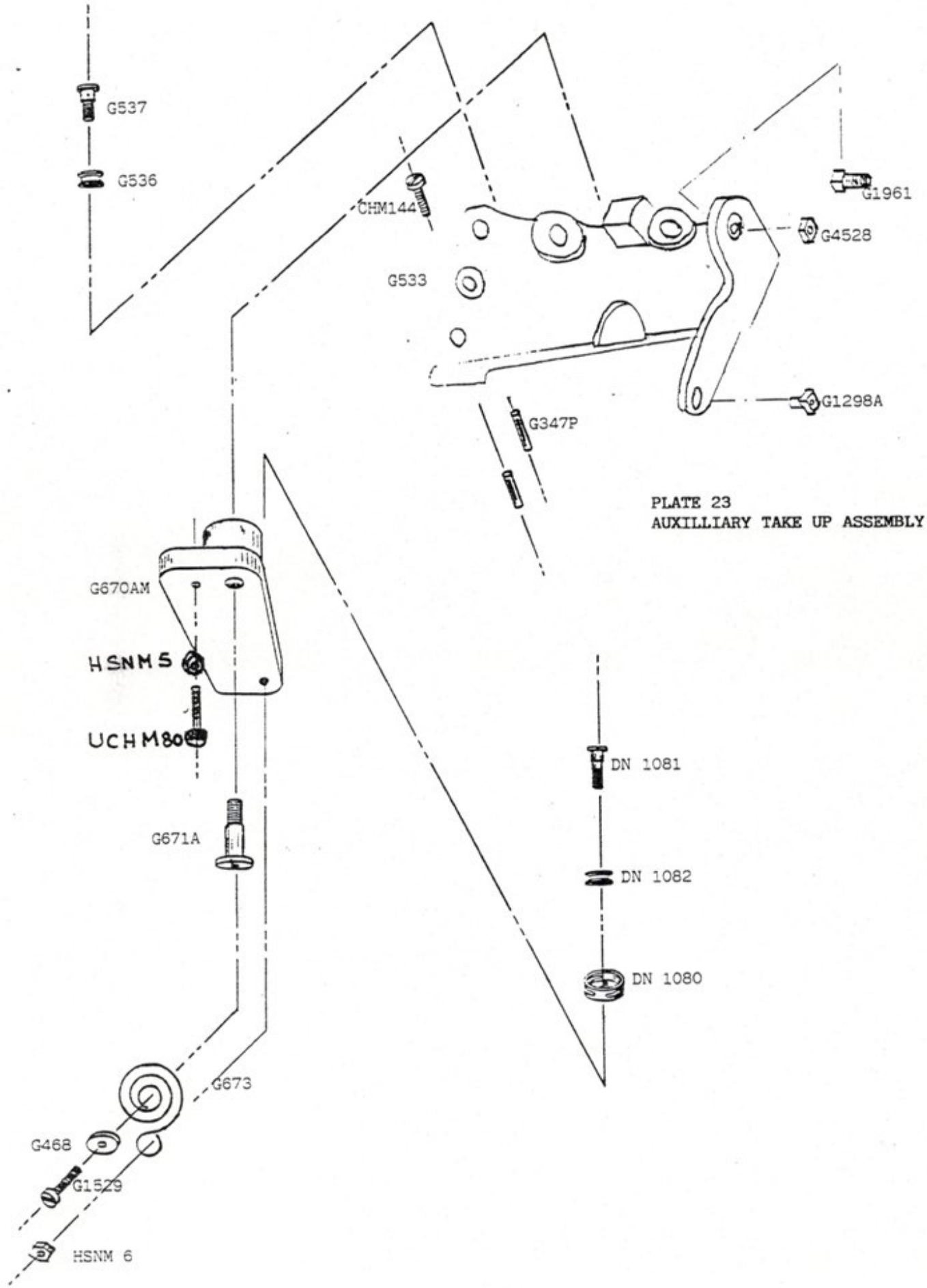


PLATE 23
AUXILLIARY TAKE UP ASSEMBLY

PLATE 24
THREAD FEED MECHANISM

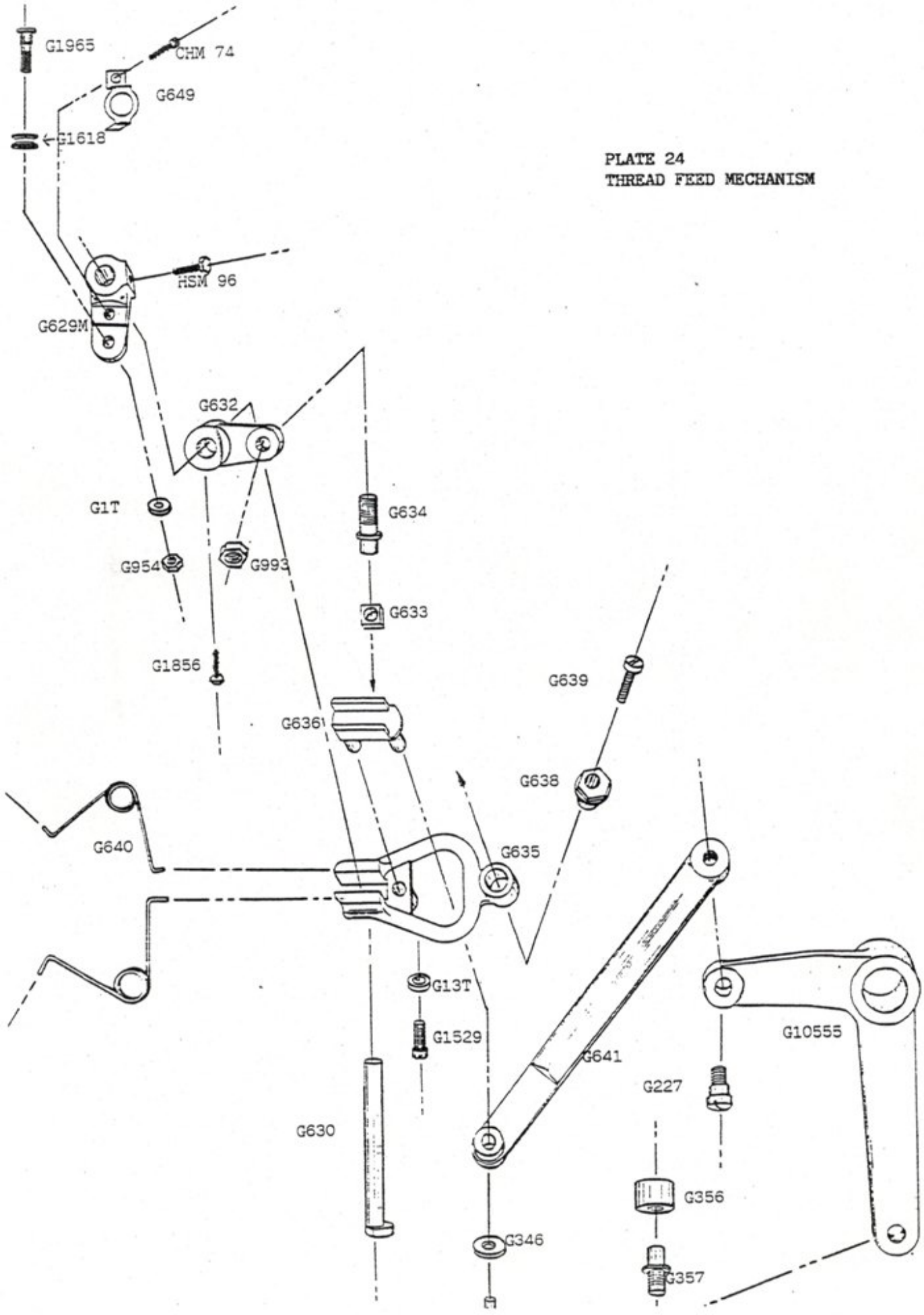


PLATE 25
FEED SLIDE ASSEMBLY

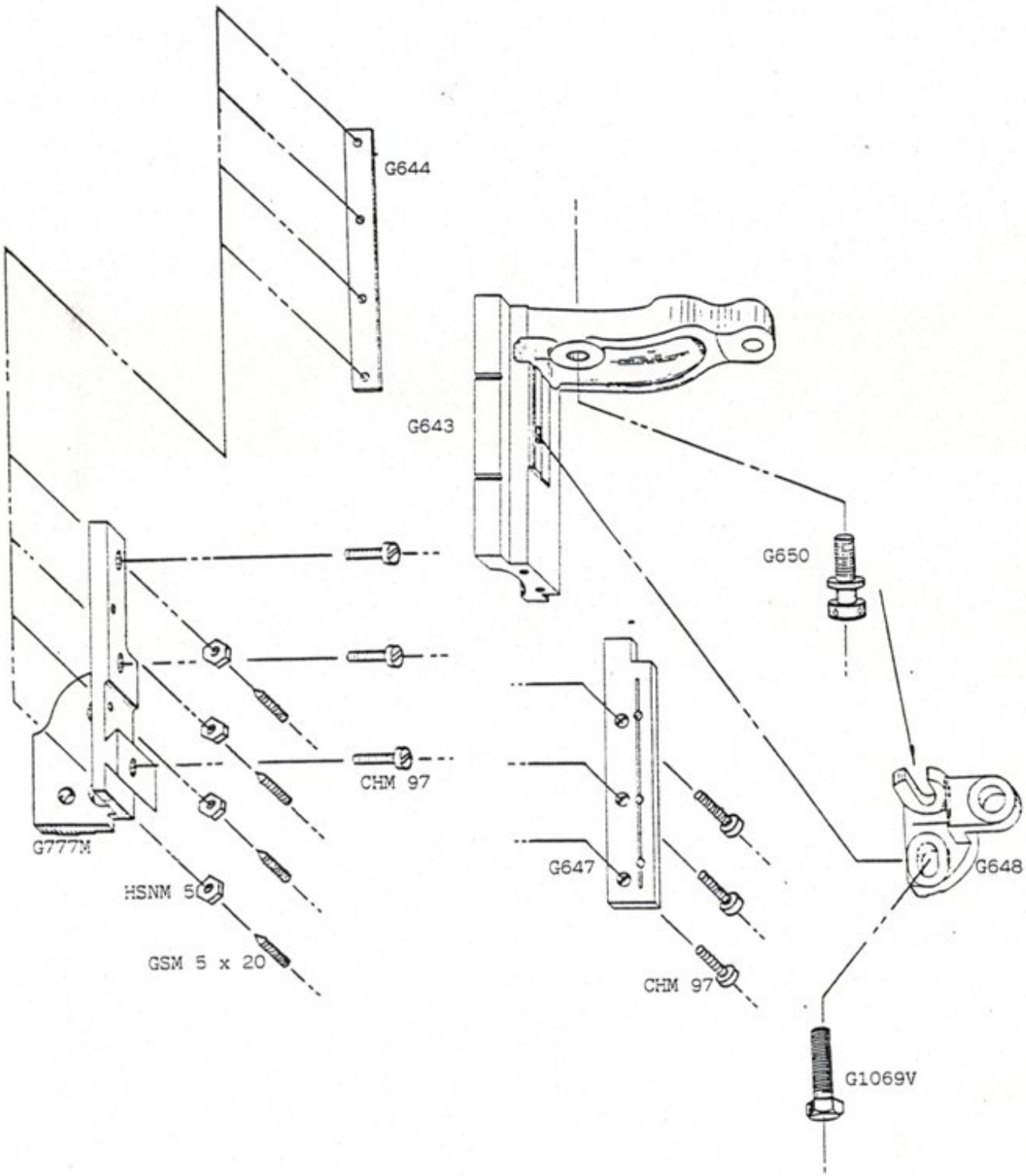


PLATE 26
FEED SLIDE LEVER ASSEMBLY

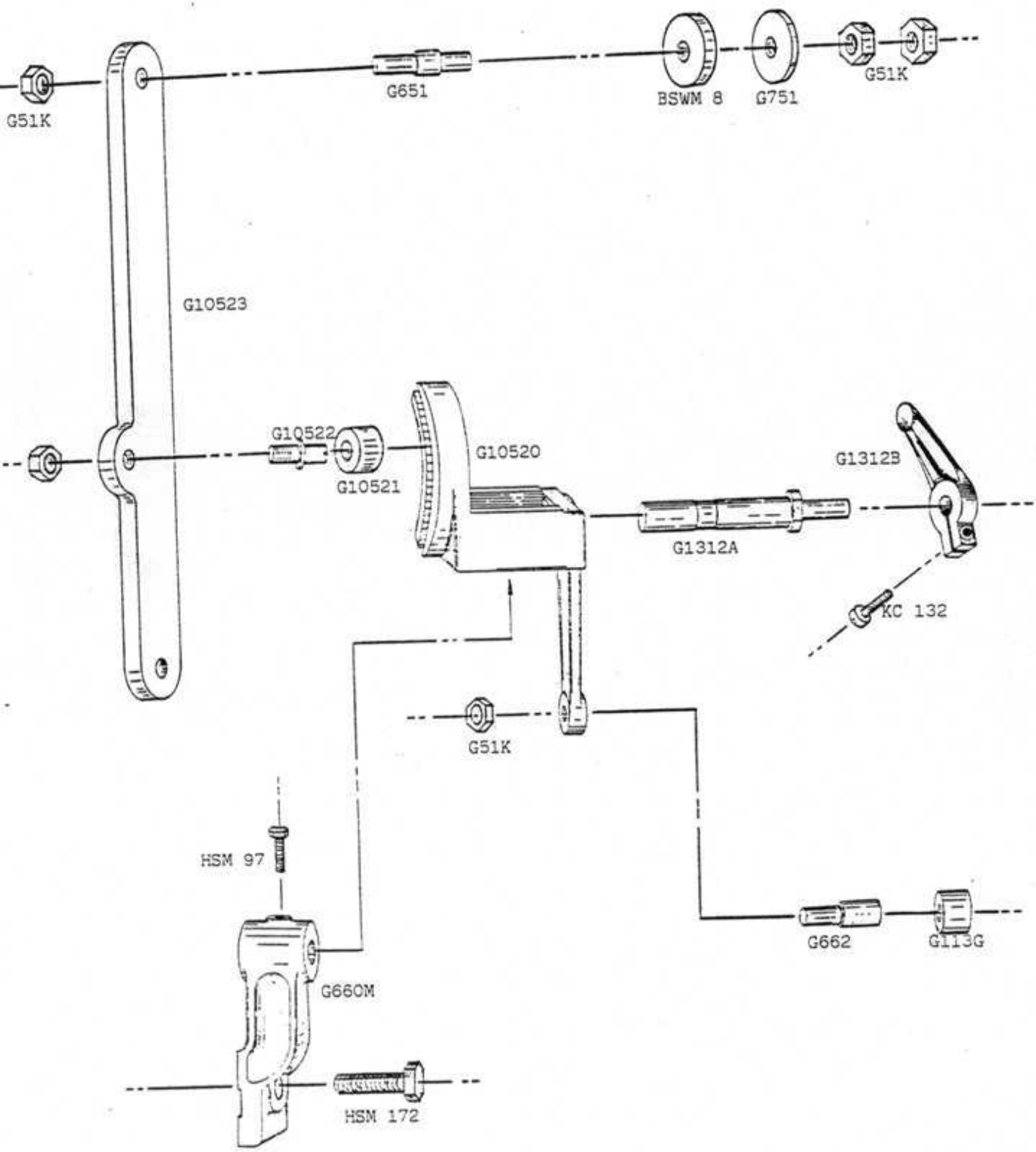
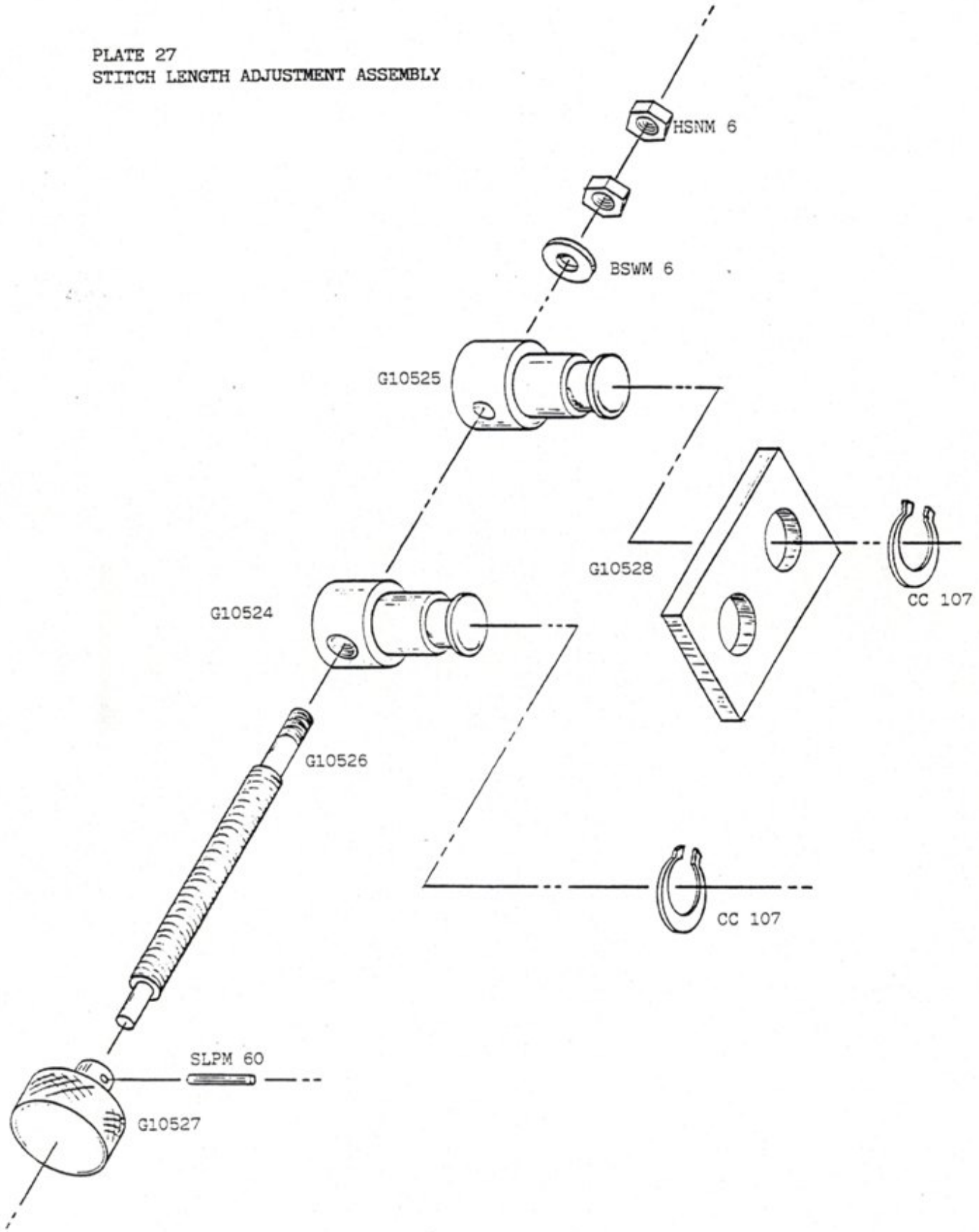


PLATE 27
STITCH LENGTH ADJUSTMENT ASSEMBLY



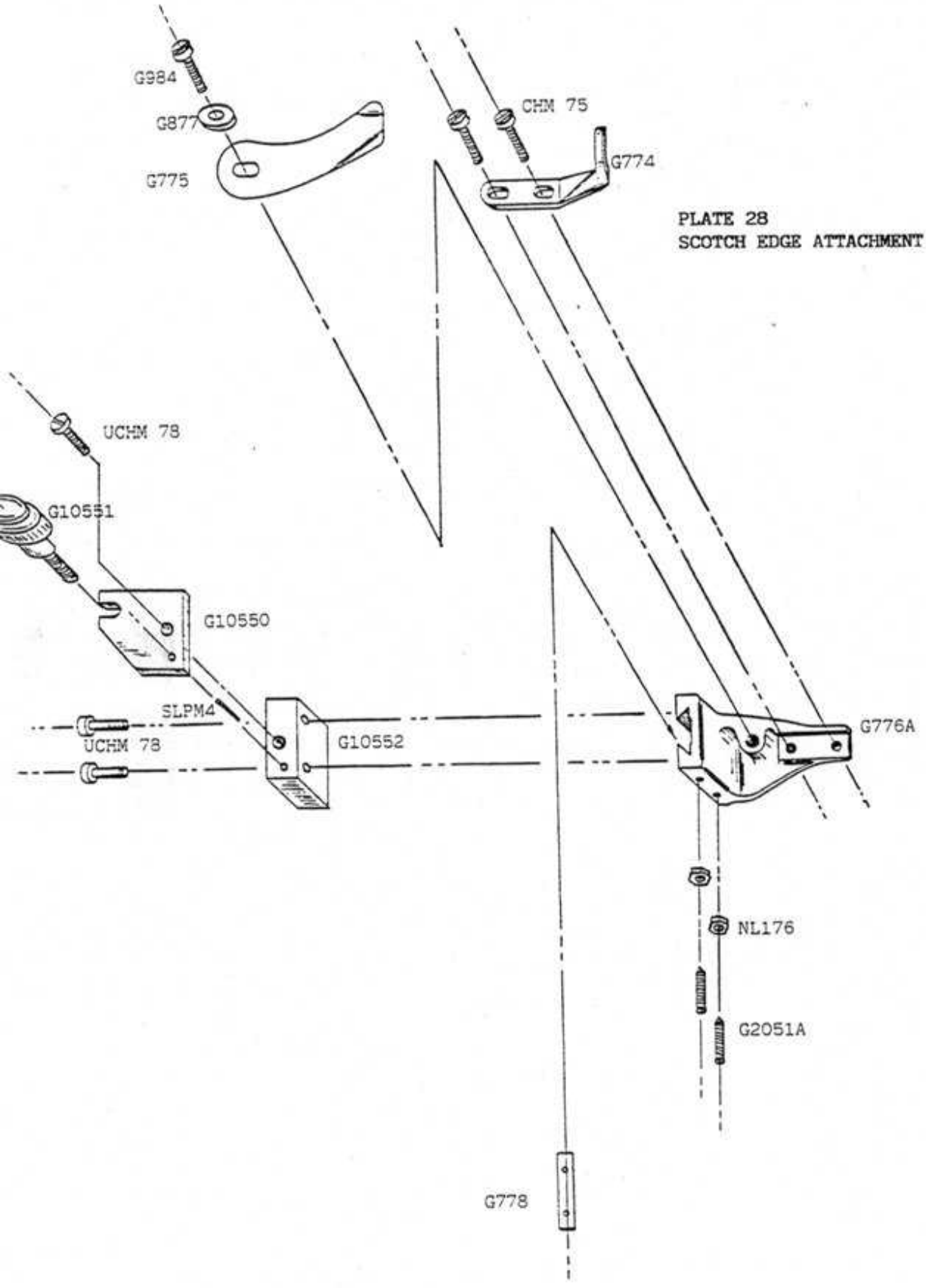
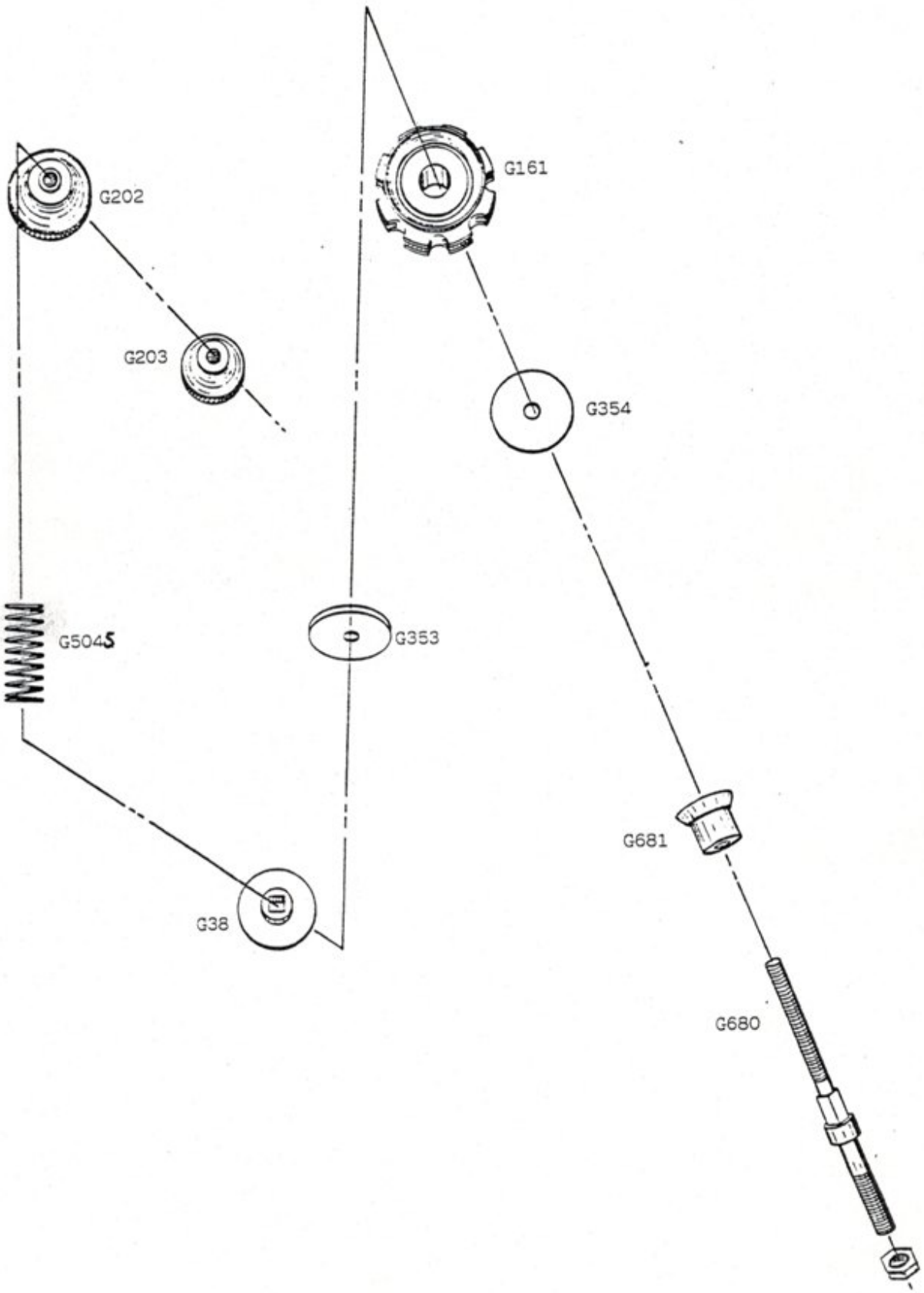


PLATE 28
SCOTCH EDGE ATTACHMENT

PLATE 29
THREAD TENSION



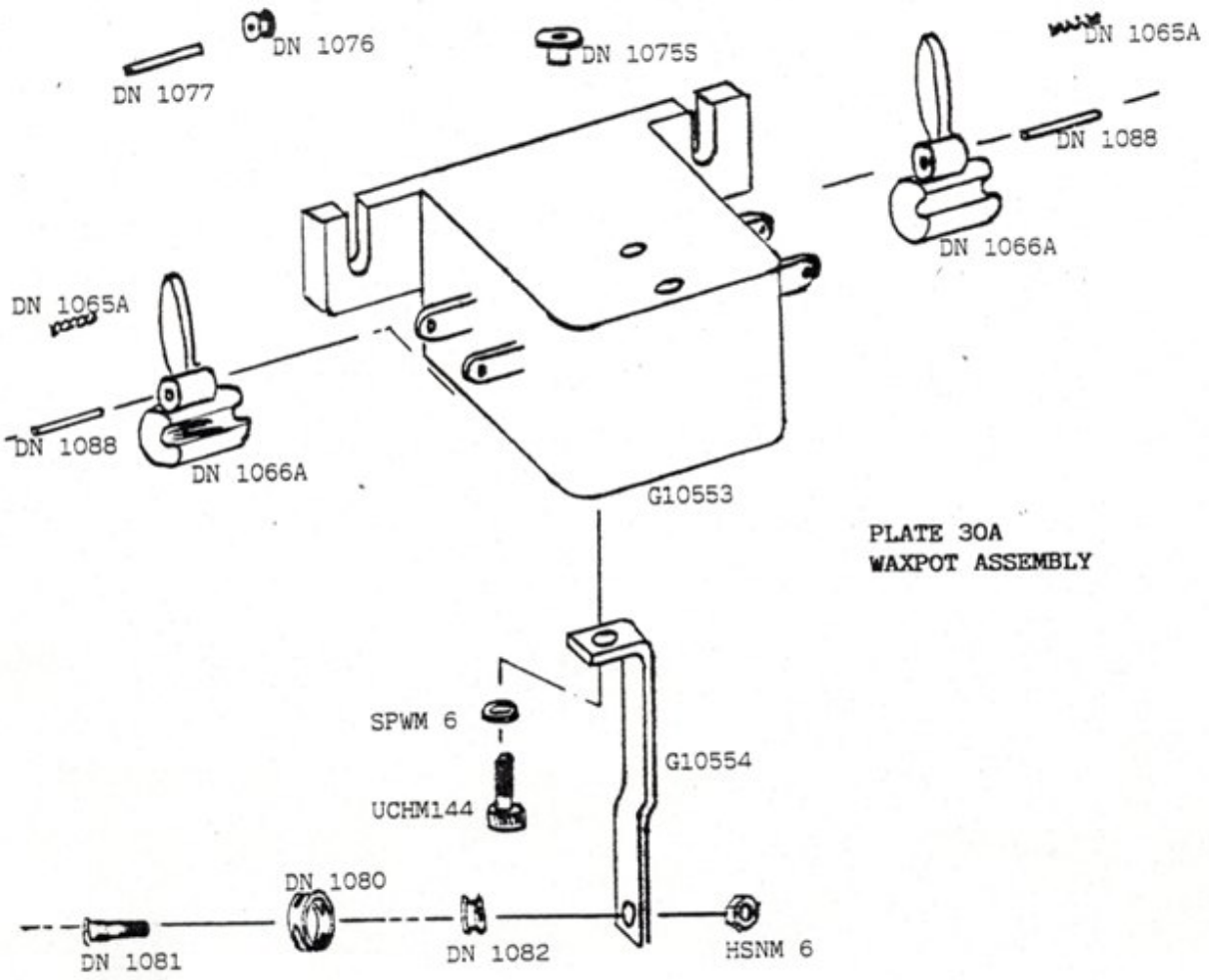


PLATE 30A
WAXPOT ASSEMBLY

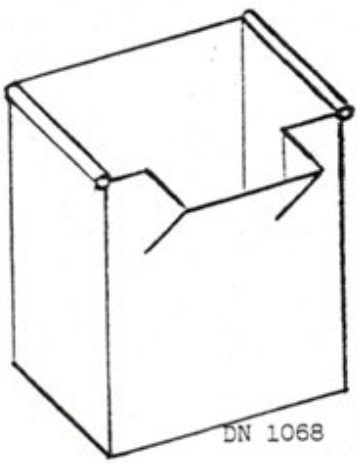


PLATE 31
THREADING DIAGRAM

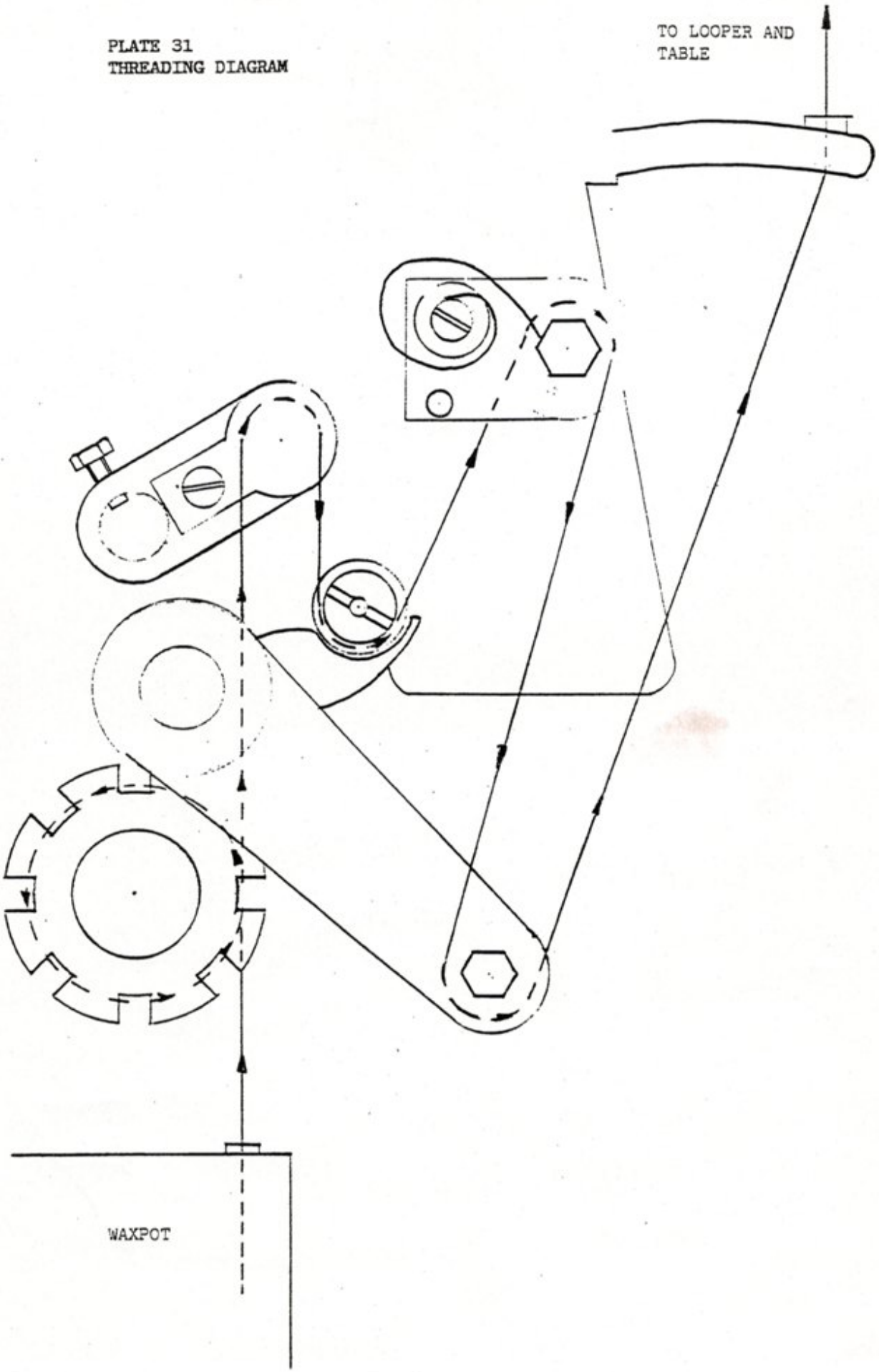
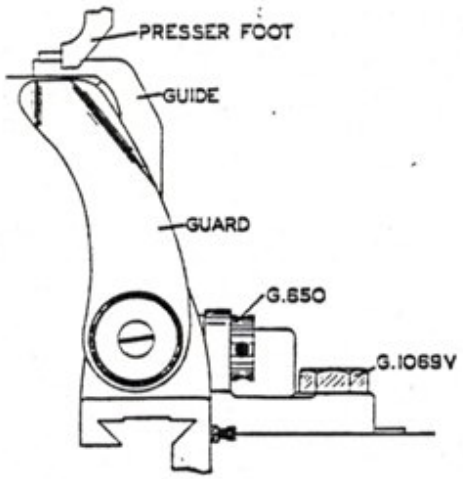


DIAGRAM Nº 1



ADJUSTMENTS FOR LINING UP AWL & NEEDLE

DIAGRAM Nº 2

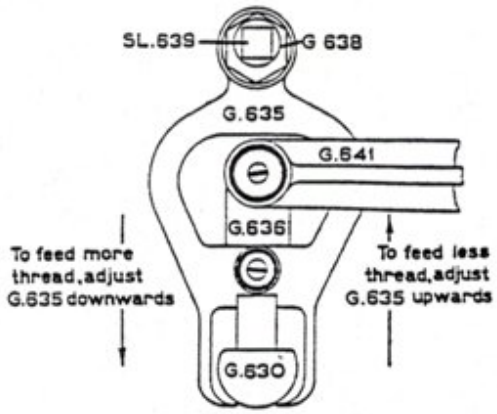
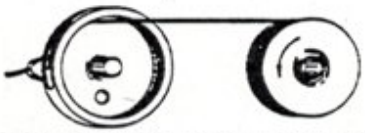


DIAGRAM Nº 3



Place spool in bobbin case to revolve in direction of arrow

Awl cut high at back will tend to push work off table

Awl cut high at front will tend to pull work onto table

DIAGRAM Nº 4

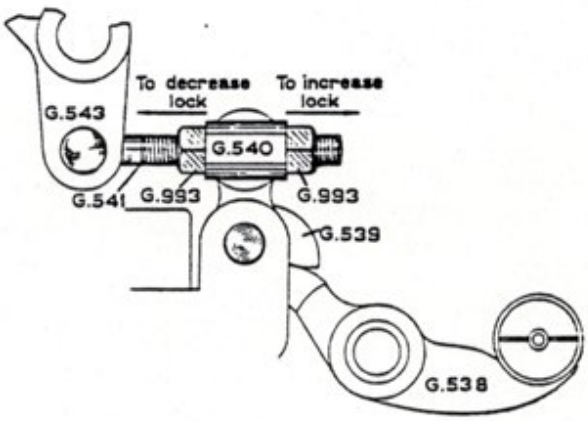
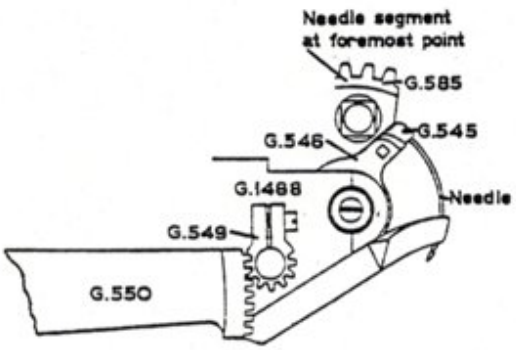
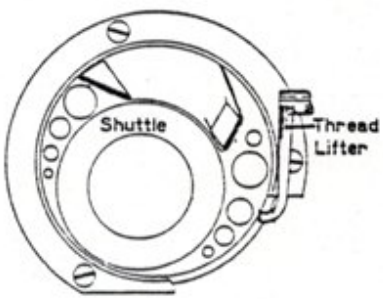


DIAGRAM Nº 5



TIMING OF NEEDLE GUIDE

DIAGRAM Nº 6



Set thread lifter as near as possible to shuttle at this point.

DIAGRAM Nº 7

WHEN AWL IS FEEDING

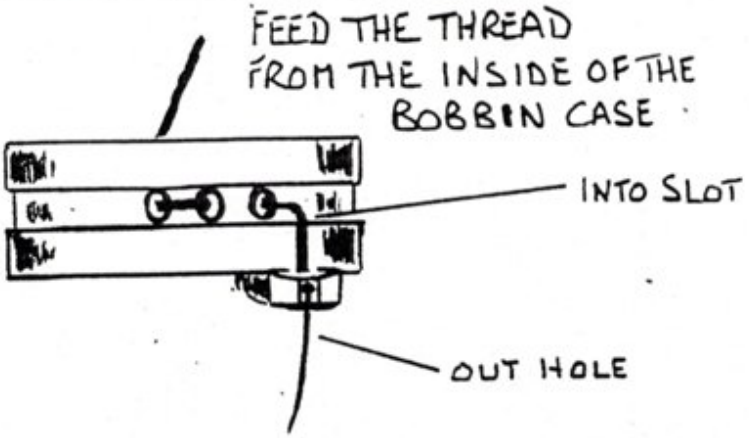
DIAGRAM Nº 8

When needle is at its

THREADING THROUGH THE BOBBIN CASE

NEW STYLE WITH THREE TENSION HOLES

NO SPRING REQUIRED



HEAVY TENSION USE THREE HOLES

LIGHT TENSION USE ONE HOLE.