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› SINGER HD0400S Heavy Duty Overlock Serger Sewing Machine User Manual

## SINGER HD0400S

# SINGER® HD0400S Heavy Duty Overlock Serger Sewing Machine User Manual

Model: HD0400S

## 1. INTRODUCTION

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The SINGER® HD0400S Heavy Duty Overlock Serger Sewing Machine is designed for durable performance and professional finishes. This machine offers speed, strength, and precision for various sewing projects, from finishing seams to creating decorative edges. It features a heavy metal frame, 2/3/4 thread capability, and a high stitching speed of up to 1,300 stitches per minute.



**Figure 1:** The SINGER HD0400S Heavy Duty Overlock Serger Sewing Machine, showcasing its robust design.

This manual provides instructions for setting up, operating, and maintaining your SINGER HD0400S serger to ensure optimal performance and longevity.

## 2. IMPORTANT SAFETY INSTRUCTIONS

Before using the SINGER HD0400S serger, please read all instructions. Keep this manual for future reference.

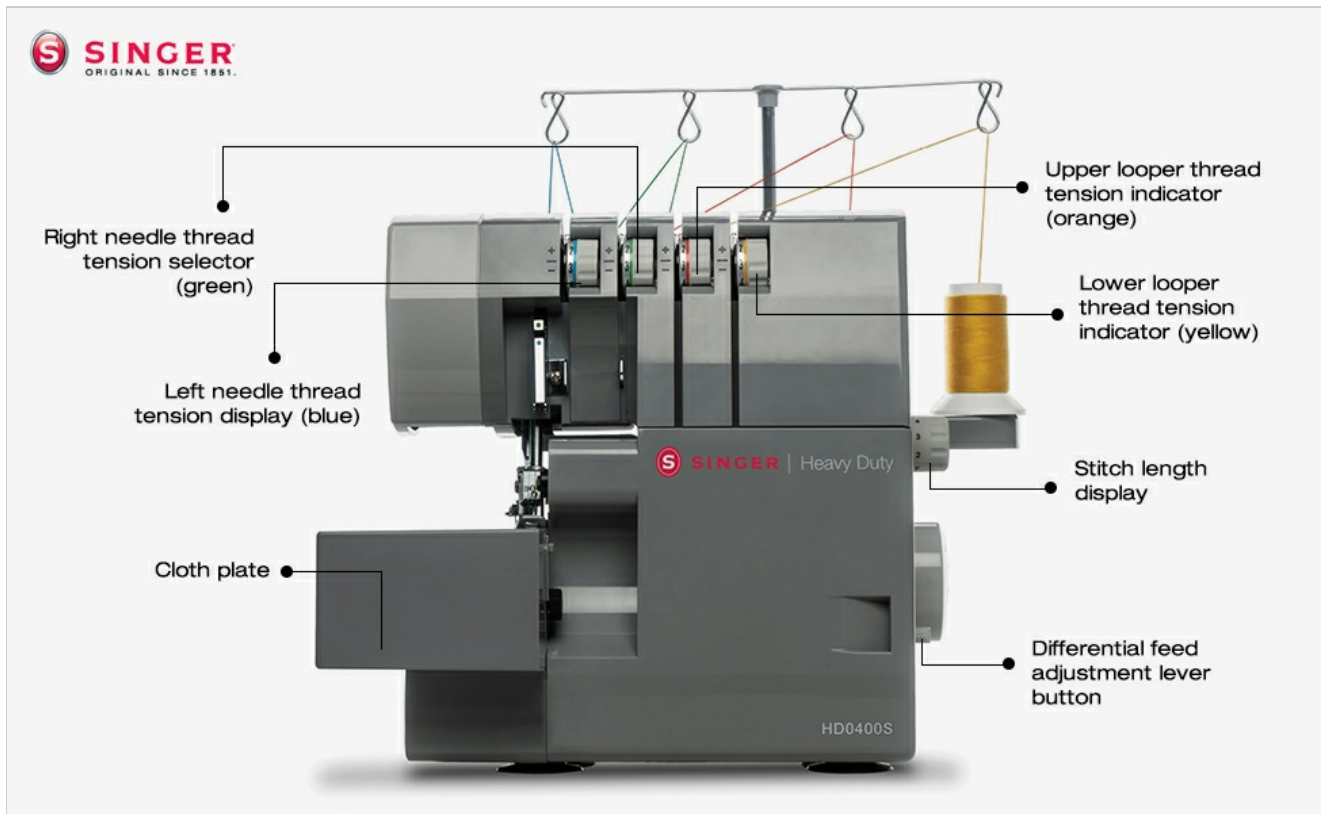
- Always unplug the machine from the electrical outlet immediately after using and before cleaning, removing covers, or making any user servicing adjustments.
- Do not allow children to operate the machine without supervision.
- Use this appliance only for its intended use as described in this manual.
- Never operate the machine if it has a damaged cord or plug, if it is not working properly, or if it has been dropped or damaged.
- Keep fingers away from all moving parts. Special care is required around the serger needles and cutting knife.
- Always use the proper needle plate. The wrong plate can cause the needle to break.

- Do not pull or push fabric while stitching. This may deflect the needle, causing it to break.
- Turn the serger off when making any adjustments in the needle area, such as threading the needle, changing the needle, or changing the presser foot.

### 3. MACHINE COMPONENTS AND INCLUDED ACCESSORIES

#### 3.1 Machine Overview

Familiarize yourself with the main parts of your SINGER HD0400S serger.



**Figure 2:** Overview of the SINGER HD0400S serger with key components labeled, including tension indicators, stitch length display, and differential feed adjustment.

- **Right Needle Thread Tension Selector (Green):** Adjusts tension for the right needle thread.
- **Left Needle Thread Tension Display (Blue):** Displays tension for the left needle thread.
- **Upper Looper Thread Tension Indicator (Orange):** Indicates tension for the upper looper thread.
- **Lower Looper Thread Tension Indicator (Yellow):** Indicates tension for the lower looper thread.
- **Stitch Length Display:** Shows the current stitch length setting.
- **Differential Feed Adjustment Lever/Button:** Controls the differential feed ratio.
- **Cloth Plate:** The working surface where fabric is placed.

#### 3.2 Included Accessories

The following accessories are included with your SINGER HD0400S serger:

- 4 Thread Spool Holders
- All-Purpose Foot
- Lint Brush
- Needles
- Scrap Bag

- Screwdriver
- Spare Lower Knife
- Spreader
- Storage Compartment
- Tweezers

## 4. SETUP

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### 4.1 Unpacking and Placement

1. Carefully remove the serger from its packaging.
2. Place the machine on a stable, flat surface.
3. Ensure there is adequate space around the machine for fabric handling and accessory storage.
4. Connect the power cord to the machine and then to a suitable electrical outlet.

### 4.2 Threading the Machine

The SINGER HD0400S features a color-coded threading system and on-machine diagrams to simplify the threading process.



**Figure 3:** The color-coded threading paths on the SINGER HD0400S serger, designed for ease of use.

1. Raise the presser foot and turn the handwheel towards you to raise the needles to their highest position.
2. Follow the color-coded guides on the machine for each thread (blue for left needle, green for right needle, orange for upper looper, yellow for lower looper).
3. Use the included tweezers to assist with guiding threads through small openings.
4. Ensure all threads are correctly seated in their tension discs and guides.

*Refer to the detailed threading diagrams printed on the machine for precise instructions.*

## **5. OPERATING INSTRUCTIONS**

### **5.1 Basic Operation and Stitch Options**

The HD0400S offers 2, 3, or 4 thread stitch options for various professional finishes.



The Serger Heavy Duty SINGER® HD0400S is a fast, powerful machine designed for durable performance, professional finishes and effortless sewing on all types of fabrics.



The sturdy metal frame provides exceptional durability and keeps the machine stable during high-speed sewing, ensuring smooth, skip-free sewing for consistent, professional-quality results on any fabric.

The Serger Heavy Duty SINGER® HD0400S combines power, speed and versatility for professional results. With a 60% larger cutting knife, 1,300 stitches per minute and 2/3/4 thread options, it handles thick fabrics with ease. Features like differential feeding, six stitch types, color-coded threads and dual LED lights make sewing fast, smooth and precise on all types of fabric.



High-speed sewing at 1,300 stitches per minute ensures fast, professional-quality sewing results.



The movable upper knife cuts the fabric or disengages for special techniques.



2-3-4 thread capacity offers versatile seams, hems and decorative edges.



Figure 4: Key operational features of the SINGER HD0400S, including high-speed stitching, the larger cutting knife, and versatile thread capacity.

- **Stitching Speed:** The machine operates at up to 1,300 stitches per minute, allowing for efficient completion of projects.
- **2/3/4 Thread Capability:** Select the appropriate number of threads for your desired stitch type (e.g., 4-thread overlock for strong seams, 3-thread for general finishing, 2-thread for delicate rolled hems).
- **Stitch Length Adjustment:** Use the stitch length dial to set the desired stitch length for your fabric and project.

## 5.2 Differential Feed Control

The differential feed system controls the movement ratio between the front and back sections of the feed teeth. This feature is crucial for managing various fabric types.



Figure 5: A hand adjusting the differential feed dial, which helps prevent fabric stretching or puckering.

- **Preventing Puckering:** For lightweight or stretchy fabrics, adjust the differential feed to a higher ratio (e.g., above 1.0) to prevent puckering.
- **Preventing Stretching:** For knit fabrics or bias-cut materials, adjust to a lower ratio (e.g., below 1.0) to prevent stretching.
- **Even Stitching:** For most woven fabrics, a 1:1 ratio (1.0) is suitable for even stitching.

### 5.3 Built-in Rolled Hem

The HD400S features a built-in rolled hem plate, allowing for quick conversion to rolled hem stitching without changing the stitch plate.

1. Locate the lever for the rolled hem conversion.
2. Flip the lever to engage the rolled hem setting.
3. Adjust tension settings as recommended for rolled hems (refer to the full user manual for specific tension guidelines).

### 5.4 Free Arm Design

The free arm design facilitates sewing tubular items such as cuffs, sleeves, and small openings.

1. Remove the accessory storage compartment to expose the free arm.
2. Slide the tubular fabric item onto the free arm.
3. Proceed with stitching, ensuring the fabric moves smoothly around the free arm.

## 5.5 Dual LED Lighting

Two integrated LED lights illuminate the work area, reducing shadows and improving visibility, especially when working with dark fabrics or in low-light conditions.



Figure 6: A user operating the SINGER HD0400S, demonstrating the illuminated work area provided by the dual LED lights.

## 6. MAINTENANCE

Regular maintenance ensures the smooth operation and longevity of your serger.

### 6.1 Cleaning

1. **Power Off:** Always turn off and unplug the machine before cleaning.
2. **Remove Lint:** Use the included lint brush to remove lint and thread scraps from the feed dogs, looper area, and under the needle plate.
3. **Scrap Bag:** Regularly empty the scrap bag to prevent accumulation of fabric trimmings.
4. **Exterior Cleaning:** Wipe the exterior surfaces with a soft, dry cloth. Do not use harsh chemicals or abrasive cleaners.

## 6.2 Replacing the Lower Knife

The serger includes a spare lower knife. Replace the knife when it becomes dull to ensure clean fabric cuts.

1. **Safety First:** Ensure the machine is unplugged.
2. **Access Knife:** Open the front cover to access the lower knife.
3. **Remove Old Knife:** Use the screwdriver to loosen the screw holding the lower knife in place and carefully remove it.
4. **Install New Knife:** Insert the spare lower knife, ensuring it is correctly positioned, and tighten the screw securely.
5. **Test:** Close the cover and perform a test stitch on scrap fabric to verify proper cutting.

## 7. TROUBLESHOOTING

This section addresses common issues you might encounter. For more detailed troubleshooting, refer to the complete user manual.

Problem	Possible Cause	Solution
Skipped Stitches	Incorrect needle, bent needle, improper threading, incorrect tension.	Replace needle with correct type/size, re-thread machine carefully, adjust tension settings.
Thread Breakage	High tension, poor quality thread, burrs on thread path, incorrect threading.	Reduce tension, use quality thread, check thread path for obstructions, re-thread.
Fabric Puckering/Stretching	Incorrect differential feed setting.	Adjust differential feed ratio according to fabric type (see Section 5.2).
Machine Not Starting	Power cord not connected, power switch off, safety features engaged.	Check power connections, ensure switch is on, verify all covers are closed.

## 8. SPECIFICATIONS

Feature	Detail
Brand	SINGER
Model Number	HD0400S
Color	Grey
Material	Metal (Heavy Duty Frame)
Product Dimensions (D x W x H)	14"D x 11"W x 11.5"H

Feature	Detail
Power Source	Electric
Stitch Options	2/3/4 Thread
Stitches Per Minute (SPM)	Up to 1300
Cutting Knife	60% Larger than standard models
Differential Feed	Adjustable
Rolled Hem	Built-in Plate
Arm Type	Free Arm
Lighting	Dual LED Lights
Portability	Built-in Carry Handle
GTIN (UPC)	037431887269

## 9. WARRANTY AND SUPPORT

For detailed warranty information, please refer to the official SINGER warranty documentation included with your purchase.

For comprehensive instructions, advanced techniques, and further troubleshooting, please download the complete User Manual (PDF) from the official SINGER website or via the link provided during purchase.

[Download User Manual \(PDF\)](#)

For customer support, visit the official SINGER website or contact their customer service department.