



**3568 - 2/01 ; - 2/11**  
**- 2/05 ; - 2/15**  
**- 2/06 ; - 2/16**

Gauge for setting the zero point plus the needle position. □  
# 95-730 242-75/993

Instruction book

## SICHERHEITS-HINWEISE

- Die Maschine darf nur ihrer Bestimmung gemäß verwendet werden. Beim Umbau in andere Ausführungen sind alle gültigen Schutzbestimmungen zu berücksichtigen.
- Ein Betrieb der Maschine ohne die vom Werk angebrachten Schutzrichtungen ist nicht erlaubt.
- Das Einschalten und Betreiben der Maschine darf nur durch die entsprechend unterwiesene Bedienungsperson erfolgen.
- Beim Wechseln von Nähwerkzeugen (wie z. B. Nadel, Nähfuß, Stichplatte, Stoffschieber und Spule) beim Einfädeln, bei Verlassen des Arbeitsplatzes und bei Wartungsarbeiten, ist die Maschine durch Betätigen des Hauptschalters oder durch Herausziehen des Netzsteckers vom Netz zu trennen. Bei mechanisch betätigten Kupplungsmotoren ist der Stillstand des Motors abzuwarten.
- Bei Wartungs- und Reparaturarbeiten an pneumatischen Einrichtungen ist die Maschine vom pneumatischen Versorgungsnetz zu trennen. Ausnahmen sind nur bei Justierarbeiten und Funktionsprüfungen durch entsprechend unterwiesene Fachkräfte zulässig.
- Arbeiten an der elektrischen Ausrüstung dürfen nur durch Elektrofachkräfte oder entsprechend unterwiesene Personen durchgeführt werden.
- Arbeiten an unter Spannung stehenden Teilen und Einrichtungen sind, abgesehen von zulässigen Abweichungen gemäß DIN 57 105 bzw. VDE 0105, nicht erlaubt.

## NORMES DE SÉCURITÉ

- N'utiliser la machine que pour les travaux auxquels elle est destinée. En cas de transformation en une autre version, respecter toutes les prescriptions de sécurité valables.
- Ne pas utiliser la machine sans les dispositifs de sécurité.
- Seule l'opératrice instruite en conséquence devra mettre la machine en circuit et coudre.
- Avant le changement d'organes de couture tels que l'aiguille, le pied presseur, la plaque à aiguille, la griffe et la canette, avant l'enfilage, avant de quitter la machine et avant les travaux d'entretien, la machine est à mettre hors circuit à l'interrupteur général ou par enlèvement de la fiche secteur.  
Pour les moteurs-transmetteurs mécaniques, attendre l'arrêt du moteur.
- Pour les travaux d'entretien et de réparation au système pneumatique, couper la machine du réseau pneumatique. Seules exceptions admises: réglages et contrôles par du personnel compétent.
- Les travaux aux équipements électriques sont à confier à un électricien ou à du personnel compétent.
- Les travaux aux pièces et dispositifs sous tension ne sont pas admis, sauf les exceptions selon la norme DIN 57 105 ou VDE 0105.

## SAFETY INSTRUCTIONS

- The machine must only be used for the purpose it was designed for. In case of conversion into another version all valid safety instructions have to be considered.
- Do not operate the machine without the safety devices it is equipped with.
- The machine must only be switched on and operated by persons who have been instructed accordingly.
- When exchanging gauge parts (e. g. needle, presser foot, needle plate, feed dog, bobbin), threading the machine or leaving it, and when making maintenance work, the machine must be disconnected either by actuating the master switch or by removing the mains plug.  
In case of mechanically-actuated clutch motors wait for the motor to stand still.
- When carrying out maintenance- or repair work on pneumatic devices the machine must be disconnected from the pneumatic supply source. The only exceptions permitted are adjustments and performance checks made by competent personnel.
- Work on the electrical equipment of the machine must only be carried out by electricians or other persons who have been instructed accordingly.
- Apart from the permissible deviations according to DIN 57105 or VDE 0105, work on live parts and equipment is not permitted.

## NORMAS DE SEGURIDAD

- No utilice la máquina más que para los trabajos para los que esté destinada. Al transformarla en otro tipo, ténganse en cuenta todas las normas de seguridad vigentes.
- No está permitido usar la máquina sin los dispositivos de protección montados en fábrica.
- La máquina sólo deberá ser conectada y manejada por la persona instruida al respecto.
- Al cambiar órganos de costura (aguja, prensatelas, placa de aguja, transportador, canilla, etc.), lo mismo que al enhebrar, al abandonar el puesto de costura y al hacer trabajos de mantenimiento, la máquina deberá desconectarse eléctricamente con el interruptor general o retirando el enchufe de la red.  
En motores de embrague accionados mecánicamente hay que esperar a que se pare el motor.
- Al efectuar trabajos de reparación y mantenimiento, habrá que desconectar la máquina de la red de alimentación neumática. Sólo se admiten excepciones en el caso de ajustes o controles efectuados por personal especializado.
- Los trabajos en el equipo eléctrico deberán ser realizados por electricistas competentes o por personal instruido al caso.
- No está permitido realizar trabajos en piezas y dispositivos que estén bajo tensión, salvo en las excepciones de la norma DIN 57 105 ó VDE 0105.

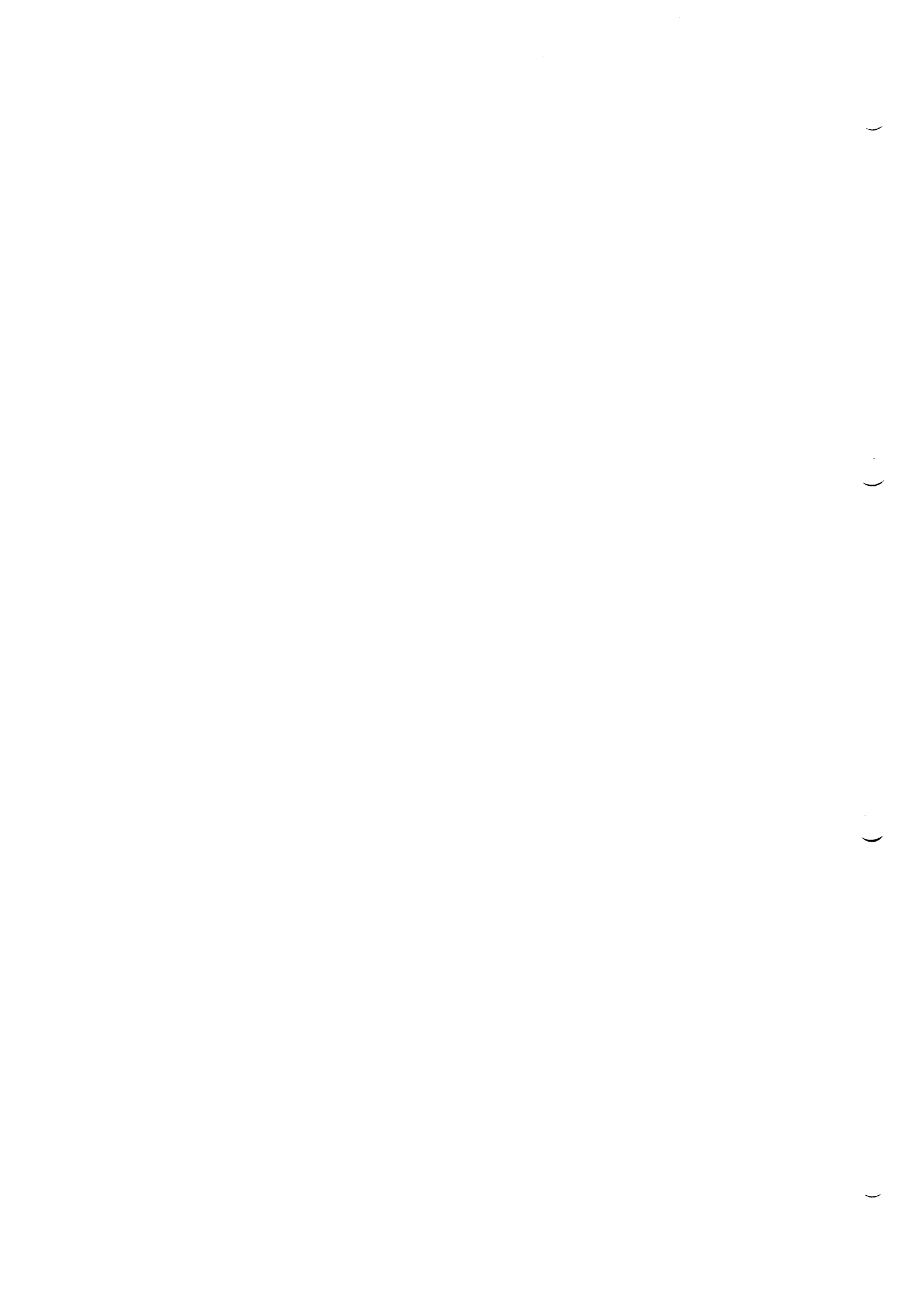
## Contents

For notes on safety see inside front cover  
Functions of switches and keys

1	Switching on the machine
2	Inserting the needle
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4	Regulating the bobbin thread tension
5	Removing the bobbin case
6	Threading the bottom thread
7	Regulating the bottom thread tension
8	Inserting the bobbin case
9	Threading the needle thread
10	Regulating the needle thread tension
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### Additional instructions

1	Loading the workpiece on version with stationary pocket plate
2	Sewing on version with stationary pocket plate

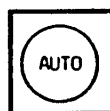


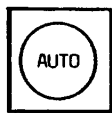
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FUNKTION DER SCHALTER UND TASTEN  
FUNCTIONS OF SWITCHES AND KEYS  
FONCTIONS DES INTERRUPTEURS ET TOUCHES  
FUNCIONES DE LOS INTERRUPTORES Y PULSADORES

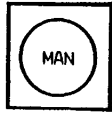
mit Gegenüberstellung alter und neuer Symbole  
with a comparison of old and new symbols  
avec comparaison des anciens et des nouveaux symboles  
con comparación de los símbolos antiguos y nuevos

Beispiel: Alte Ausführung - Neue Ausführung  
Example: Old version - New version  
Exemple: Ancien modèle - Nouvelle version  
Ejemplo: Tipo antiguo - Nuevo tipo

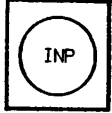




Bedienung Automatik  
Automatic operation  
Commande automatique  
Manejo automático



Bedienung manuell  
Manual operation  
Commande manuelle  
Manejo manual



Betriebsarten  
Modes of operation  
Modes opératoires  
Modalidades operacionales

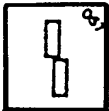
Eingabe (Taste drücken, bevor Haupt- bzw. Teilfunktionen eingegeben werden)  
Input (press before entering primary or partial functions)  
Entrée (appuyer sur cette touche avant d'entrer les fonctions principales ou partielles)  
Entrada (pulsar botón antes de registrar las funciones principales y parciales)



Service (Taste drücken, bevor Servicefunktionen eingegeben werden)  
Service (press before entering service functions)  
Service (appuyer sur cette touche avant d'entrer les fonctions de service)  
Servicio (pulsar botón antes de registrar las funciones de servicio)



- Haupt- und Teilfunktionen aus SERV und INP abfragen
- Übernahme von neuen Eingaben
- Inquiring primary and partial functions from SERV and INP
- Adoption of new inputs
- Questionner les fonctions principales et partielles de SERV et INP
- Reprise de nouvelles entrées
- Toma de las funciones principales y parciales de SERV e INP
- Aceptación de nuevas entradas



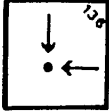
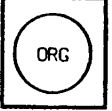
Fehler-Rücksetzung (nach Beheben von Fehlern oder Spulenwechsel)  
Error reset (after removal of errors or after bobbin changes)  
Réarmer (après l'élimination de défauts ou le changement de canette)  
Reposicionado de errores (después de subsanar fallos o de cambiar la canilla)



Nähschablone vorwärts takten  
Click sewing jig forwards  
Avancer le gabarit de couture pas à pas  
Para avance de la plantilla de costura



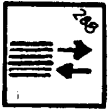
Nähschablone rückwärts takten  
Clock sewing jig backwards  
Reculer le gabarit de couture pas à pas  
Para retroceso de la plantilla de costura



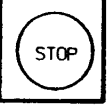
Nähprogramm in Grundstellung  
Basic position of sewing program  
Programme de couture en position de base  
Programa de costura en posición básica



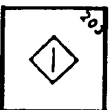
Nadel positionieren in Hochstellung  
Needle up position  
L'aiguille positionne en haut  
Para posicionado superior de la aguja



Stapler vor - zurück (zum Spulenwechsel)  
Stacker forwards - backwards (to change bobbin)  
L'empileur avance - recule (pour le changement de la canette)  
Apilador avanza - retrocede (para cambiar la canilla)



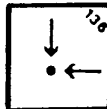
Programm-Stop  
Program stop  
Arrêt de programme  
Parada del programa



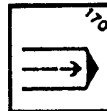
Nähen Start  
Programmfortsetzung nach Stop  
Start sewing  
Program continued after stop  
Lancement couture  
Reprise de programme après interruption  
Comienzo de la costura  
Continuación del programa después de la parada



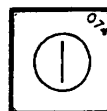
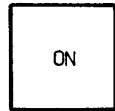
Programmablauf ohne Nähen bei "AUTO"  
 Program without sewing in "AUTO"  
 en "AUTO", déroulement du programme sans couture  
 Desarrollo del programa sin coser con "AUTO"



Umbugger und Schablonentransport in Grundstellung  
 Basic position of edge folder and jig feed  
 Conformeuse et gabarit en position de base  
 Grupo doblador y transporte de la plantilla en posición básica



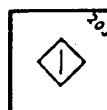
Funktionsablauf in Einzelschritten bei "MAN" ohne Nähvorgang  
 Function flow in single steps in "MAN" without sewing  
 Séquence de fonctionnement pas à pas  
 en commande "MAN", sans opération de couture  
 Funcionamiento en pasos individuales con "MAN" sin proceso de costura



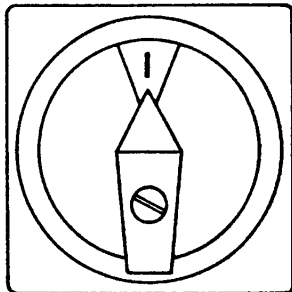
Maschine ein  
 Machine on  
 Machine en fonction  
 Conexión de la máquina



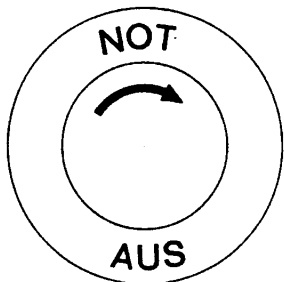
Nähen ein bei "MAN"  
 Sewing on in "MAN"  
 Déclenchement de la couture en service "MAN"  
 Costura con "MAN"



Aufhebung von STOP (Bedienpult Umbugger)  
 STOP cancelled (control panel edge folder)  
 Elimination de "STOP" (console de la conformeuse)  
 Desbloqueo del STOP (pupitre de mandos, grupo doblador)

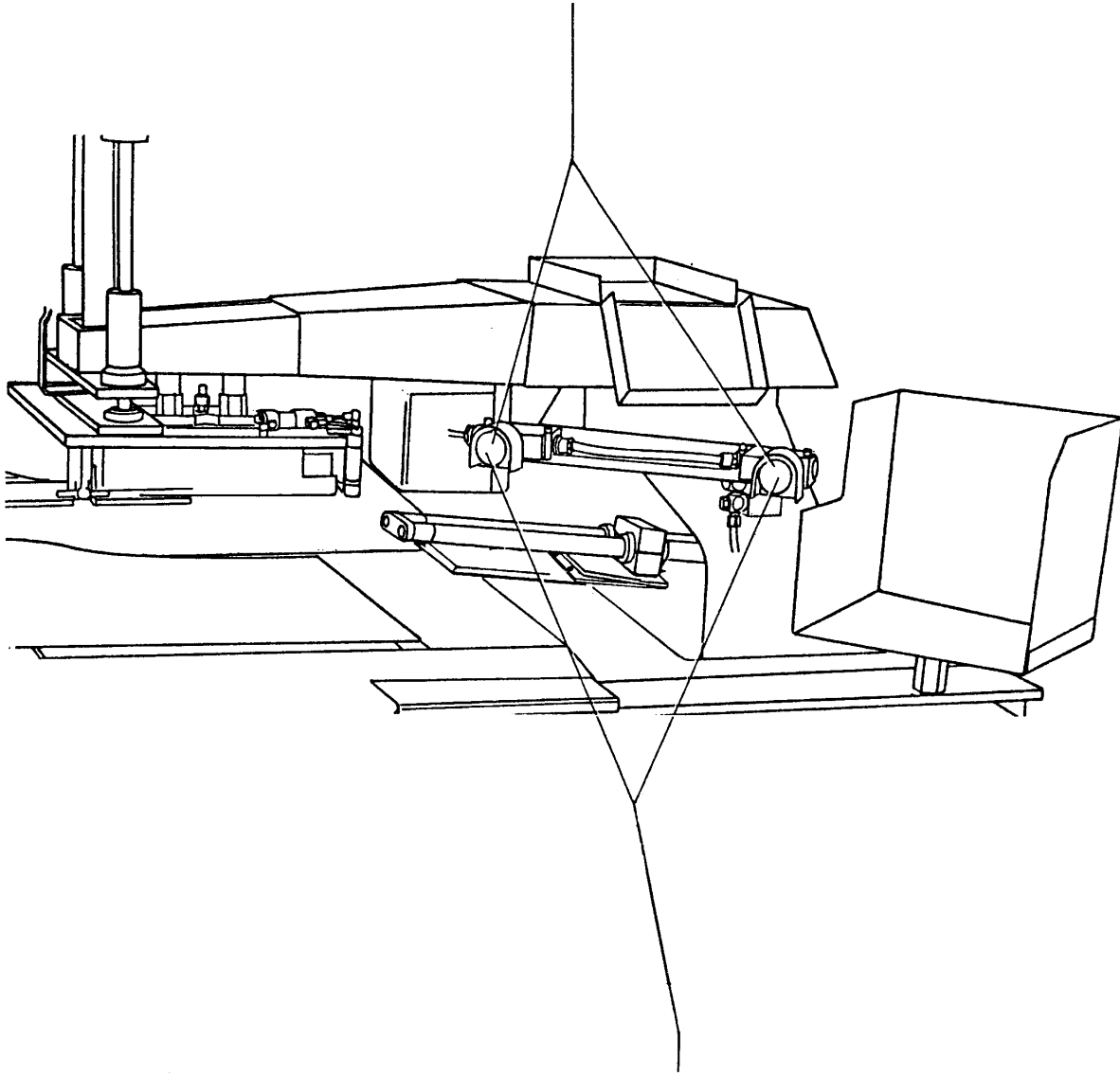


Hauptschalter  
 Master switch  
 Interrupteur général  
 Interruptor general



NOT - AUS  
 EMERGENCY OFF  
 ARRET D'URGENCE  
 PARADA DE EMERGENCIA

Bei "MAN":  
Taschenblech vor (bei Ausführung mit schwenkbarem Taschenblech)  
Umbugger und Tisch ab (bei Ausführung mit starrem Taschenblech)  
In "MAN":  
Pocket plate forwards (on version with movable pocket plate)  
Edge folder and table down (on version with stationary pocket plate)  
Avec commande "MAN":  
Gabarit de poche avance (modèle à gabarit de poche pivotant)  
Conformeuse et table descendant (modèle à gabarit de poche rigide)  
Con "MAN":  
Chapa de bolsillo avanza (en el tipo con chapa de bolsillo giratoria)  
Grupo doblador y mesa descenden (en el tipo con chapa de bolsillo rígida)



Bei "AUTO"  
Programstart  
In "AUTO"  
Program start  
Avec commande "AUTO"  
Démarrage du programme  
Con "AUTO"  
Puesta en marcha del programa



1 Switching on the machine

Open compressed air valve 1 (Figs. 1, 1.1).

Check that gauge 2 (Fig. 2) shows a pressure of 6 bar. Have this pressure set by a mechanic, if it does not.

Set master switch 3 (Fig. 2) at "1" - key "ERROR RESET" lights up.

Press key "ON"

- control carriage in basic position, keys "MAN" and "START" light up.

The machine is ready for manual operation.

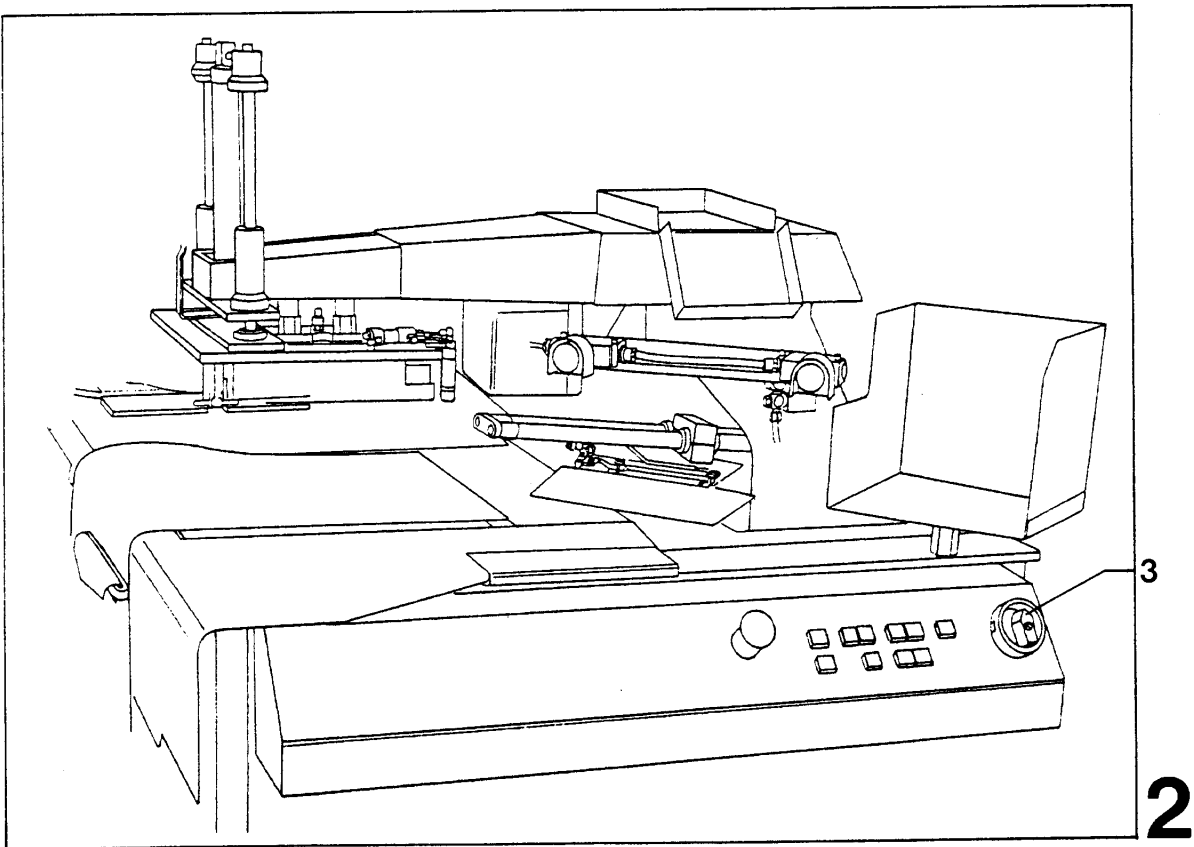
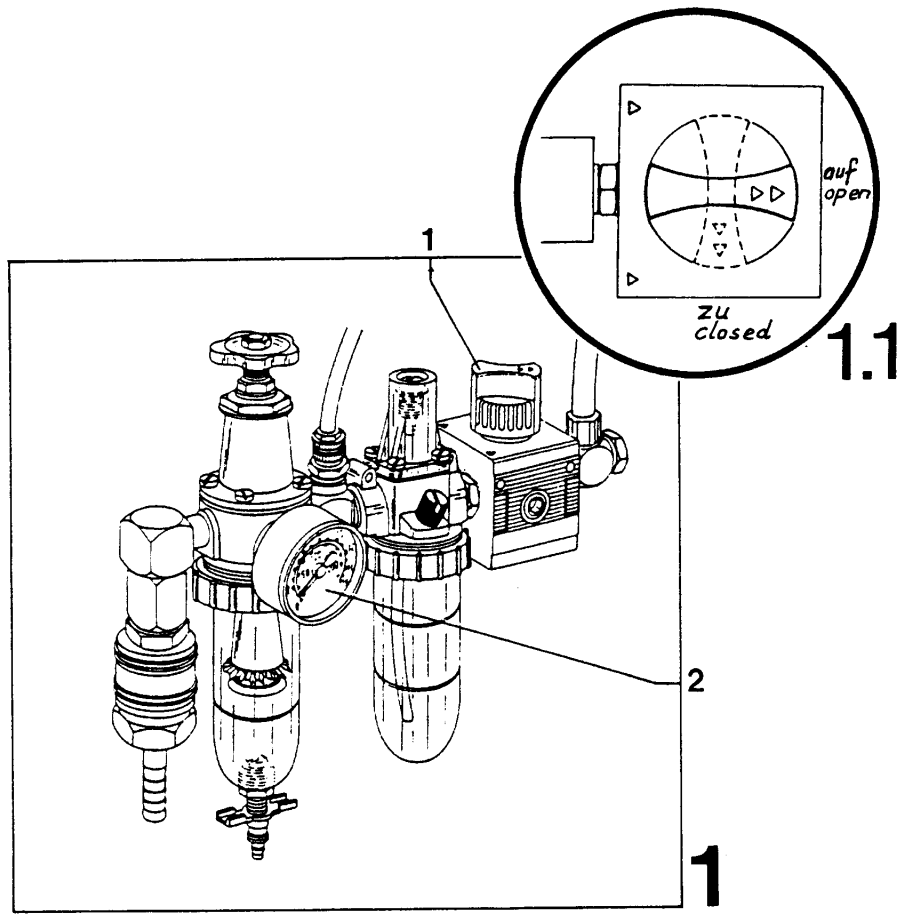
For automatic work cycle press key "AUTO" in addition

-keys "AUTO" and "STOP" light up.

Press key "START"

- key "START" lights up,  
- key "STOP" goes out, the machine is operative.





2 Inserting the needle

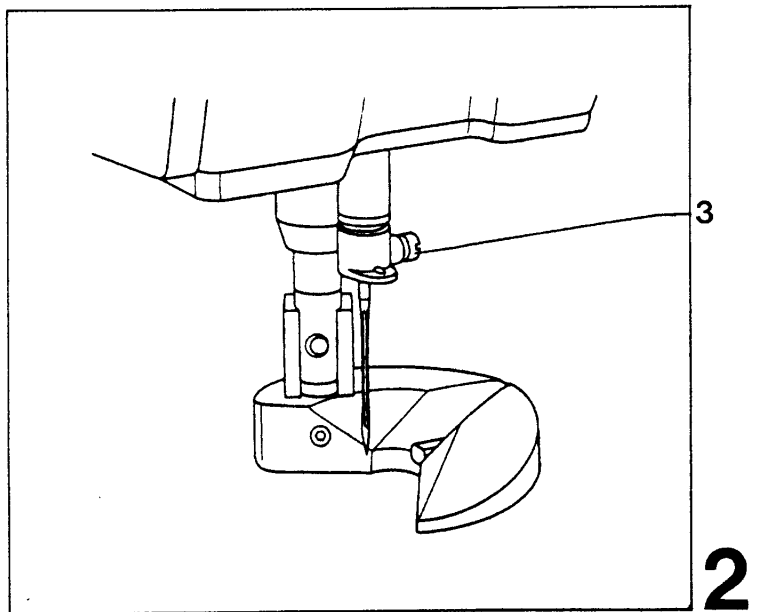
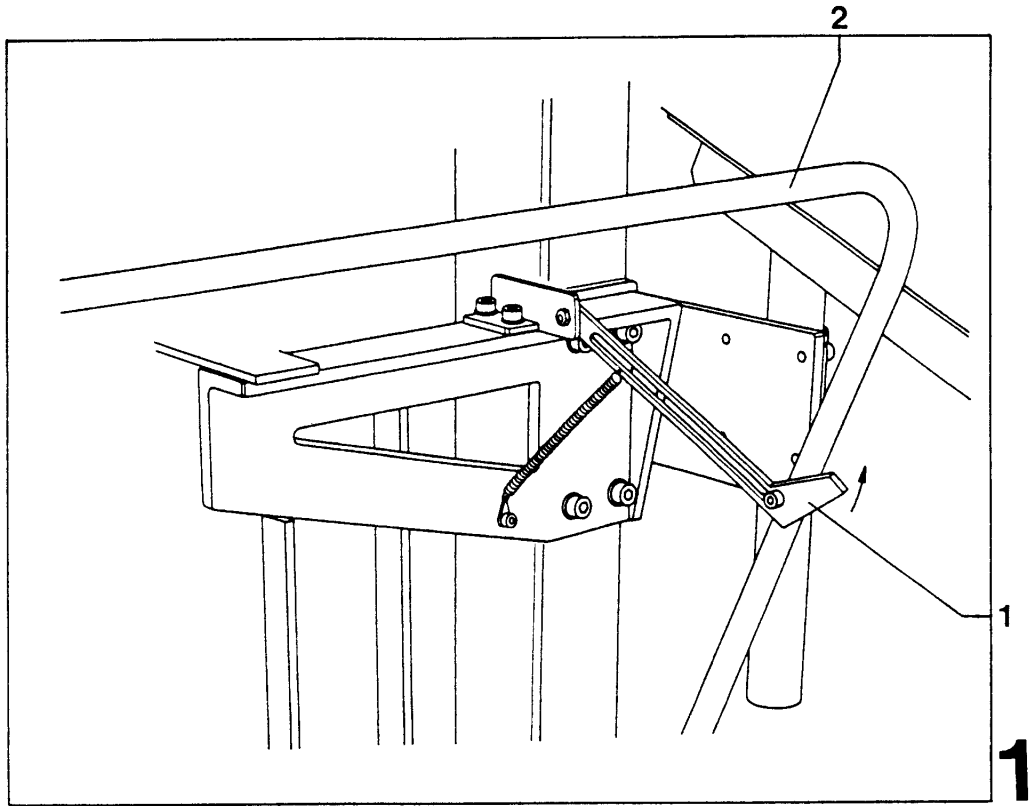
Use system 134 CL suk NM 110-140 needles.

RELEASE RATCHET LEVER 1 (Fig. 1) AND PUSH BAR 2 FULLY TOWARDS THE MACHINE - KEY "STOP" LIGHTS UP, THE MACHINE IS OUT OF OPERATION.

Fully insert the needle in the needle bar and turn until the long groove faces the folding station.

Tighten needle retaining screw 3 (Fig. 2).

RETURN BAR 1 (Fig. 1) TO ORIGINAL POSITION AND PRESS KEY "START"  
- KEY "STOP" GOES OUT, THE MACHINE IS OPERATIVE.



### 3 Winding the bottom thread

Place an empty bobbin on the bobbin winder spindle.

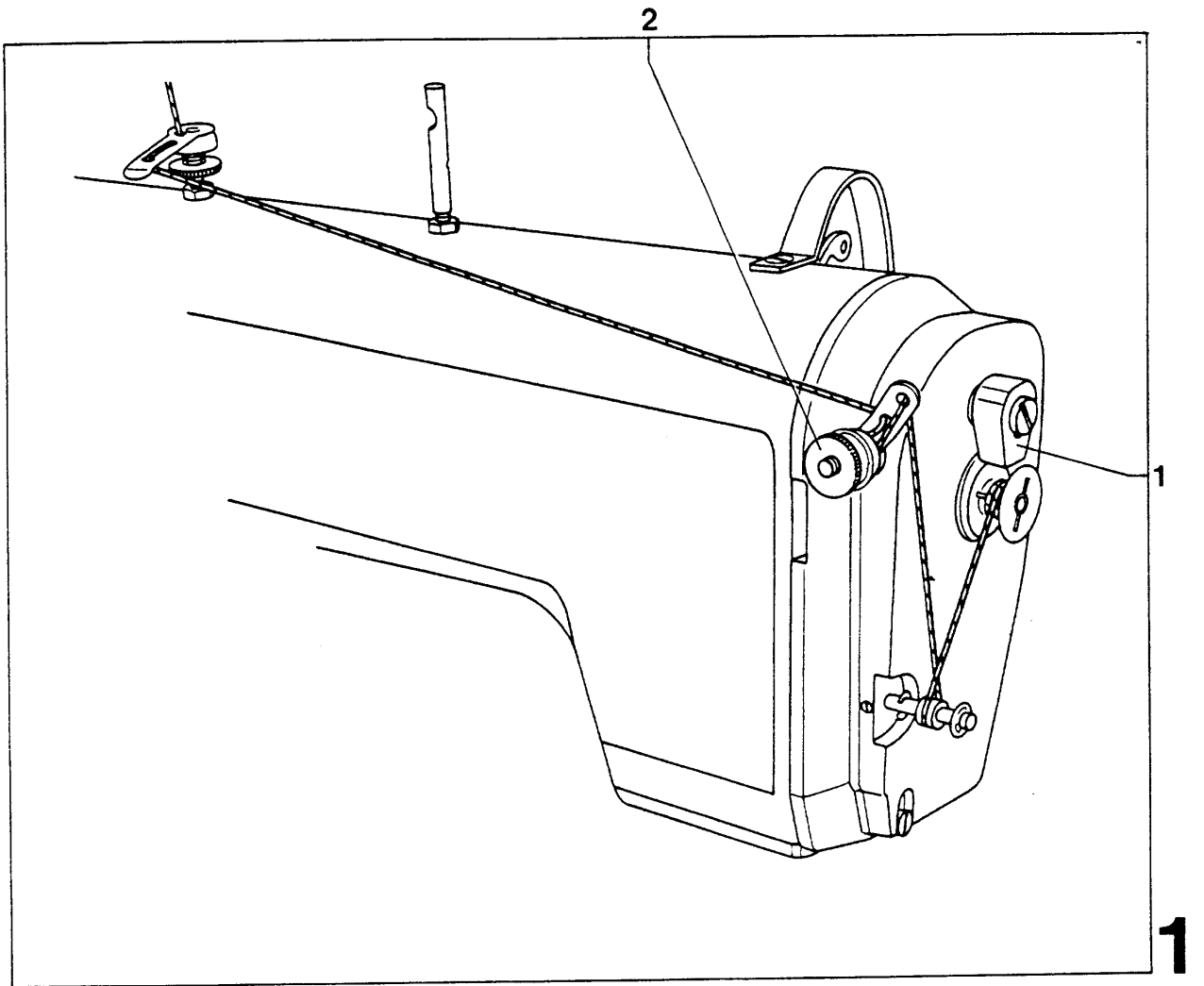
Press down trip 1 (Fig. 1). (If it resists, turn the bobbin lightly).

Wrap the thread (threaded according to Fig. 1) several times around the bobbin in clockwise direction.

During sewing, the bobbin winder runs as long as it takes to fill the bobbin and is then switched off automatically.

### 4 Regulating the bobbin thread tension

By turning milled screw 2 (Fig. 1) in clockwise direction, the tension is decreased, by turning it counter-clockwise it is increased.



5 Removing the bobbin case

RELEASE RATCHET LEVER 1 (Fig. 1) AND PUSH BAR 2 FULLY TOWARDS THE MACHINE

- KEY "STOP" LIGHTS UP, THE MACHINE IS OUT OF OPERATION.

Press keys "ERROR RESET" and "STACKER"  
- stacker flap moves forwards.

Open flap 3 (Fig. 2) and pull bobbin case out of sewing hook.

6 Threading the bottom thread

Insert the full bobbin in the bobbin case so that it turns in the direction indicated by the arrow when thread is wound off (Fig. 3).

Hold the bobbin. Insert the thread in groove 4 and pull through under the tension spring until it emerges again behind delivery eye 5. Then insert the thread in grooves 6 and 7 and pull it through the holes.

7 Regulating the bottom thread tension

By turning screw 8 (Fig. 3) in clockwise direction, the tension is increased, by turning it counter-clockwise it is decreased.

8 Inserting the bobbin case

Open flap 3 (Fig. 2); thus the bobbin cannot fall out.

Insert the bobbin case in the sewing hook and let flap 3 go.

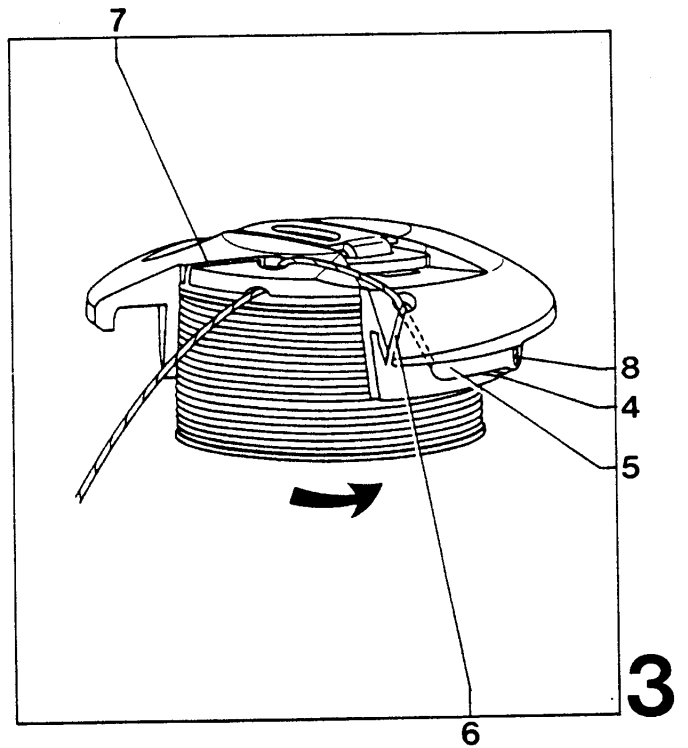
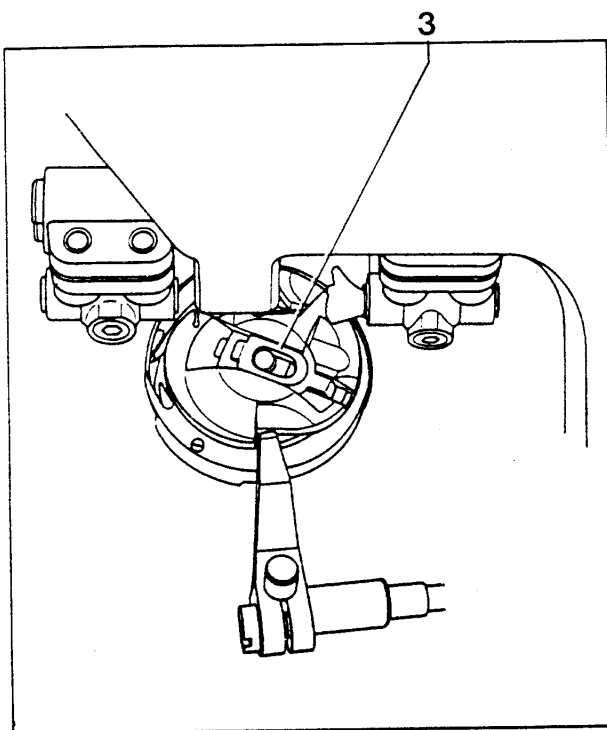
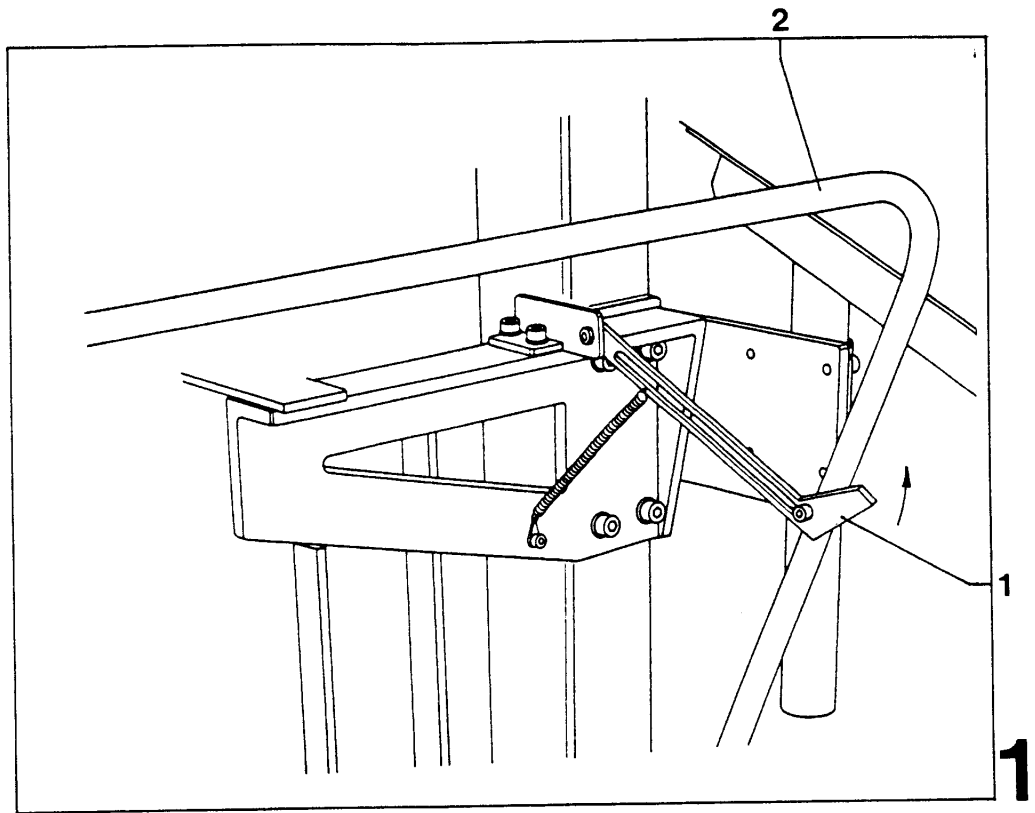
Lightly press in the bobbin case so it engages properly.

Press key "STACKER" - the stacker flap moves back.

RETURN BAR 2 (Fig. 1) TO ORIGINAL POSITION AND PRESS KEY "START"

- KEY "STOP" GOES OUT, THE MACHINE IS OPERATIVE.





9 Threading the needle thread

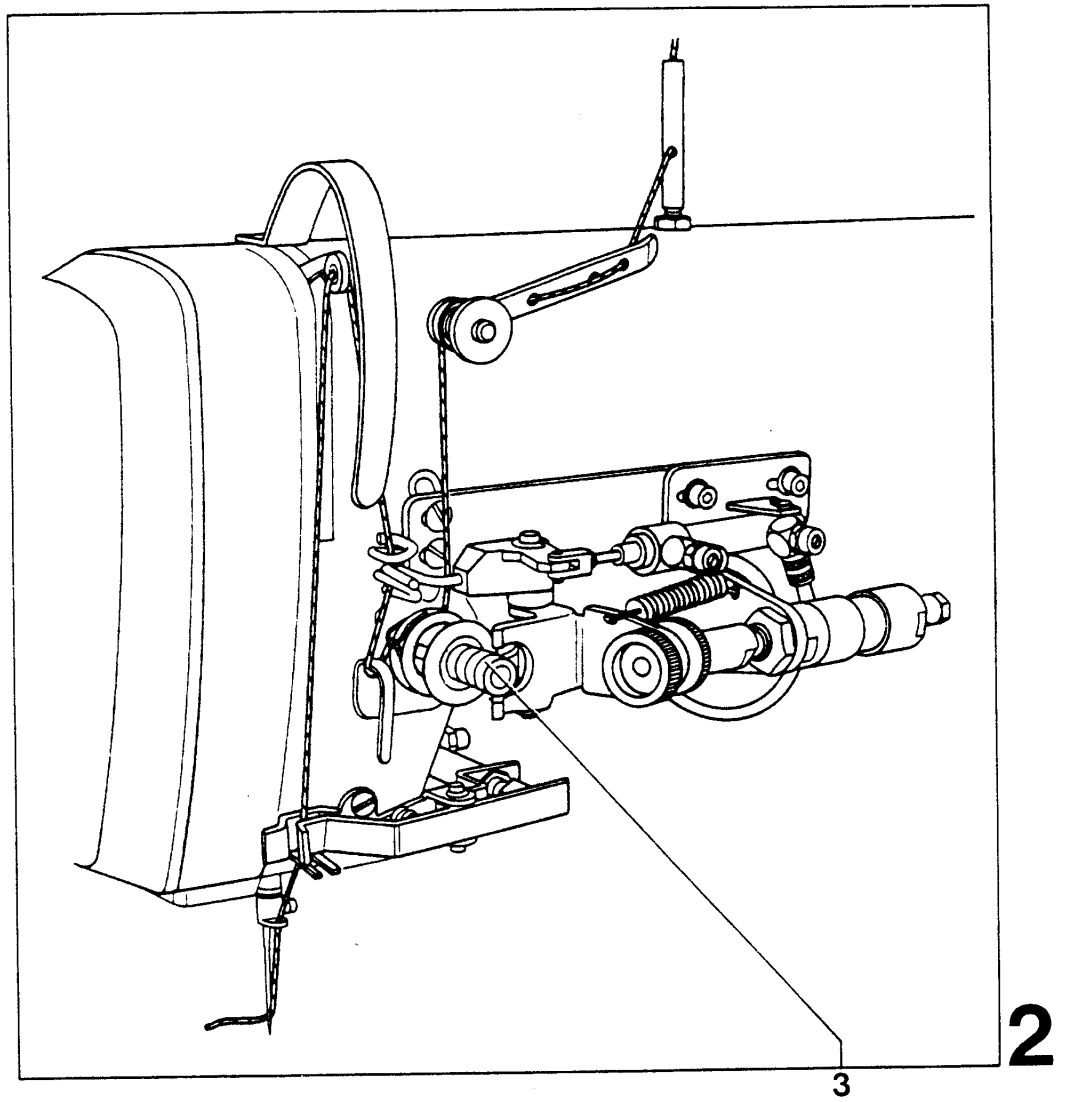
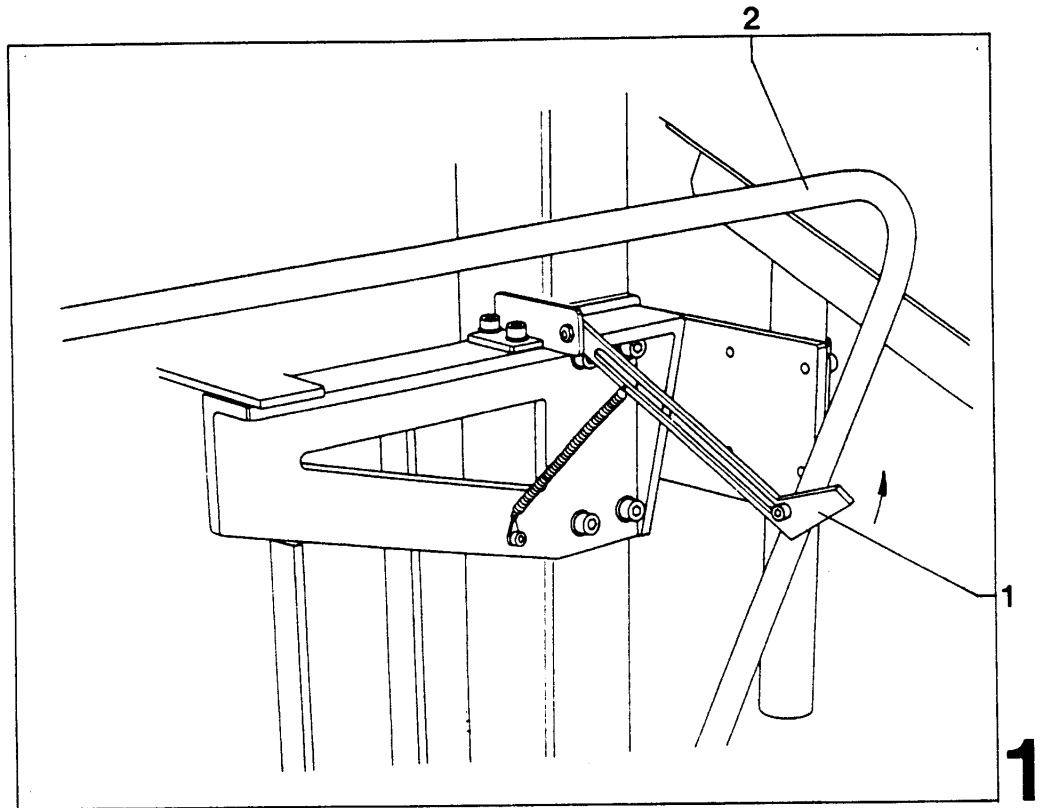
RELEASE RATCHET LEVER 1 (Fig. 1) AND PUSH BAR 2 FULLY TOWARDS THE MACHINE  
- KEY "STOP" LIGHTS UP, THE MACHINE IS OUT OF OPERATION.

Thread the needle according to Fig. 2 and pull approx. 7 cm through the needle eye, so it does not unwind when sewing is started.

RETURN BAR 2 TO ORIGINAL POSITION AND PRESS KEY "START"  
- KEY "STOP" GOES OUT, THE MACHINE IS OPERATIVE.

10 Regulating the needle thread tension

By turning nut 3 (Fig. 2) in clockwise direction, the tension is increased, by turning it counter-clockwise it is decreased.



## 11 Inquiring the primary functions

In basic state of input, all primary functions with their numbers can be displayed by key "ENTER".

Switch on the machine.

Press key "INP" on the control panel (Fig. 1).

By pressing key "ENTER" repeatedly, the primary functions are displayed.

- 1 ... PROGRAMM NUMBER
- 2 ... SOURCE
- 3 ... SEWING SPEED
- 4 ... RESET OF COUNTERS
- 5 ... READ, DELETE, DIR. OF PROGRAMS
- 6 ... MANIPULATION OF TIMES
- 7 ... SWITCH FUNCTIONS

Press one of the operation mode keys to leave the input status.

### 11.1 Inquiring the partial functions

In the respective primary function, all available partial functions and their numbers can be displayed by operating key "ENTER" (see input summary in section 12).

Empty rectangular box for display or input.

7	8	9		AUTO	ENTER	FWD	START
4	5	6		MAN		BACK	STOP
1	2	3		INP		ORG	
0				SERV	ERROR RESET	NEEDLE POS	STACKER

12 Input summary

Basic state

- 1 — Program number
- 2 — Program source
  - 1 — EPROM
  - 2 — Memory
- 3 — Sewing speeds
  - 1 — Max. sewing speed
  - 2 — Reduced sewing speed
- 4 — Setting/resetting counters
  - 1 — Piece counter
  - 2 — Bottom thread stitch counter
  - 3 — Preliminary setting of bottom thread stitch counter
  - 4 — Delay of zigzag on
  - 5 — Delay of zigzag off
- 5 — Reading, deleting, directory of programs
  - 1 — Directory
    - 1 — EPROM
    - 2 — Memory
  - 2 — Delete one program
  - 3 — Delete all programs
  - 4 — Read in one program from EPROM
  - 5 — Read in all programs from EPROM
  - 6 — Read in programs via interface
- 6 — Manipulation of times
  - 1 — Stacker airblast
  - 2 — Fabric feed roller
  - 3 — Positioning pin up
  - 4 — After table up
  - 5 — Edge folder slide
  - 6 — Jig feed forwards
- 7 — Switch functions
  - 1 — Airblast selection
    - 1 — Needle cooling during feed
    - 2 — Needle cooling during stacking
    - 3 — Fabric feed assistance during feed forwards
    - 4 — Fabric feed assistance during stacking
    - 5 — Fabric feed assistance during sewing
  - 2 — Puller
  - 3 — Positioning pin
  - 4 — Thread monitor

13 Program selection

The input of program numbers is only possible with the machine in basic position.

Press key "INP" on the control panel  
- input.

Press key **1**  
- on the display of the control panel appears: NEW PROGRAM NUMBER ...

By pressing keys **0** to **9**, input the required program number.

Press key "ENTER"  
- the program number is adopted and appears in the left top corner of the display.\*

Press one of the two operation mode keys "MAN" or "AUTO"  
- end of input.

When changing programs sewing jig and edge folder may have to be changed, too.

- \* If the selected program number is not available in the current program source, a warning is issued - "NO PROGRAM NUMBER ... (i.e. the input number).

Although the program is adopted when key "ENTER" is pressed again, it cannot be sewn before the selected program has been included in the current program source.

14 Program source

| Input of the program source is only possible  
| with the machine in basic position.

Press key "INP"  
- input.

Press key 2  
- on the display of the control panel  
appears:  
1 - EPROM/2 - MEMORY.

If the current program number is available  
in the selected program source, the new  
program source is adopted and the program  
can be processed.\*

- \* If the current program number is not available in the selected program source (EPROM or MEMORY), a warning is issued "NO PROGRAM NUMBER ... (i.e. the input number).

Although the program source is adopted when key "ENTER" is pressed again, sewing cannot start before the correct program number has been selected.



## 15 Sewing speeds

Both top and reduced sewing speeds can be displayed and affected.

The sewing speed can be input in steps from 1 to 15, the 15 standing for top speed (= 100%).

Between 100% and 40% the sewing speed is changed by 5% with each step, from 40% the change per step is 10%.

The respective percentage appears in the display.

### 15.1 Top speed

Press keys "INP", [3] and [1].

The lower line of the display shows the current speed level (e.g. MAX SPEED 15).

By pressing keys [0] to [9], the required speed level is input and indicated in percentage.

By pressing key "ENTER", the value is adopted.

### 15.2 Reduced sewing speed

Press keys "INP", [3] and [2].

The current speed level (e.g. RED SPEED 15) is indicated in the lower line of the display.

By pressing keys [0] to [9], the required speed level is input and indicated in percentage.

By pressing key "ENTER", the value is adopted.

## 16 Setting, resetting the counters

### 16.1 Piece counter

The piece counter continuously counts the pockets sewn on.

For resetting at "0", press keys "INP", [4], [1] and [0] in the sequence indicated.

Afterwards press one of the operation mode keys.

### 16.2 Bottom thread stitch counter

The bottom thread stitch counter counts the number of sewn stitches in units of 100 stitches.

The number of stitch units which can be sewn with a full bobbin must be ascertained individually.

For 100 stitches each, the stitch counter advances by one unit until the preset value is achieved. The started seam is finished and the program remains in position "jig feed at rear". "CHANGE BOBBIN" appears on the display.

Change the bobbin according to sections 5 - 9 and press keys "ERROR RESET" and "START" - the program is continued.

In case of premature bobbin change (i.e. before the set value is reached) the bottom thread stitch counter must be reset by pressing keys "INP", [4], [2] and [0].

### 16.3 Pre-setting of bottom thread stitch counter

Preset the ascertained value by pressing keys "INP", [4] and [3].

Afterwards input the setting value by pressing keys [0] to [9] and adopt by pressing key "ENTER".

#### 16.4 Zigzag delay on

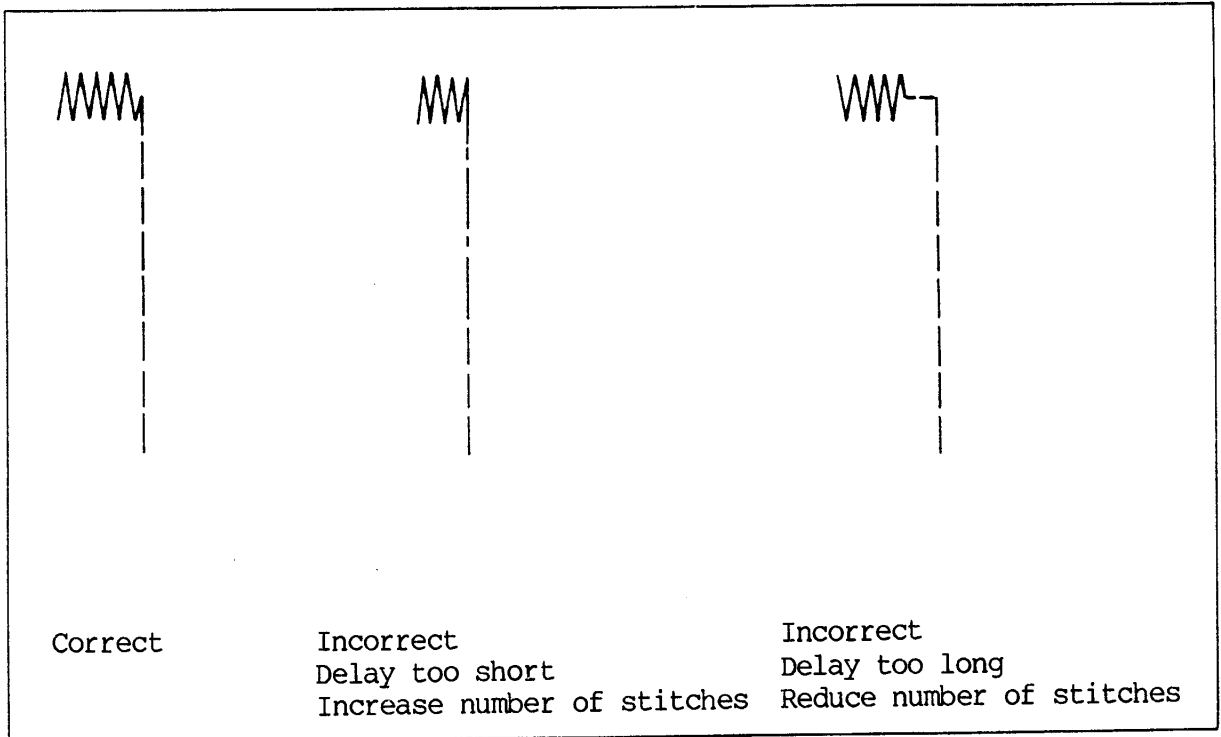
The command for "zigzag on" is programmed 7 stitches before start of backtack. Due to the propagation delay of valve and cylinder, the command must be issued with a delay, depending on the speed.

When changing the sewing speed, the number of stitches between command "zigzag on" and start of backtack (Fig. 1) must be changed.

Press key "INP" and twice key **4**.

The current delay value is indicated in stitches.

Input a new value by pressing keys **0** to **9** and adopt by pressing key "ENTER".



## 16.5 Zigzag delay off

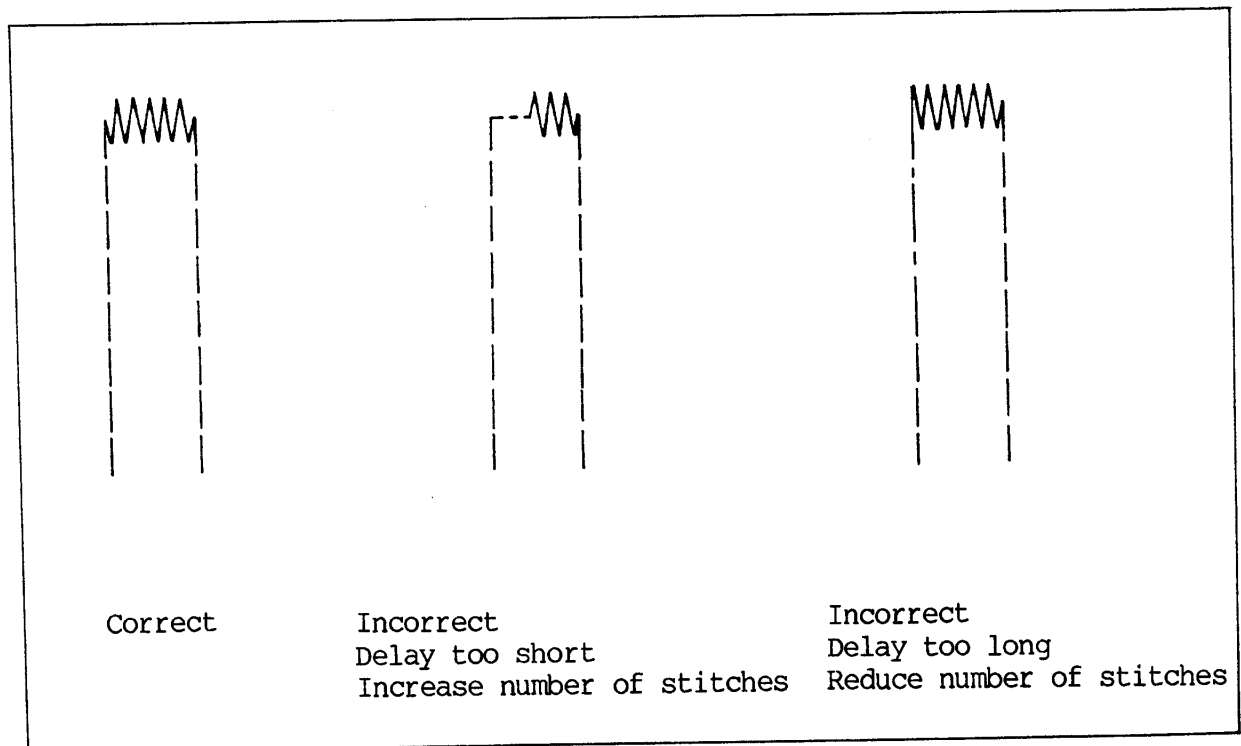
The command for "zigzag off" is programmed 7 stitches before end of backtack. Due to the propagation delay of valve and cylinder, the command must be issued with a delay, depending on the speed.

When changing the sewing speed, the number of stitches between command "zigzag off" and end of backtack (Fig. 2) must be changed.

Press keys "INP", [4] and [5].

The current delay value is indicated in stitches.

Input a new value by pressing keys [0] to [9] and adopt by pressing key "ENTER".



17 Reading, deleting, directory of programs

After pressing keys "INP" and [5], it is possible to scroll through the possible partial functions by means of key "ENTER".

In doing so, the function number of each partial function is indicated too.

1 ... Directory of programs

After pressing key [1], it is possible to display the programs in the EPROM by operating key [1] again or those in the memory by pressing key [2].

If one line is not sufficient for the display of all available program numbers, the display can be continued by pressing key "ENTER".

After the last program number END appears.

2 ... deleting individual programs

The deletion of programs is only possible in basic position of the machine.

Press key [2] and input the program number to be deleted.

Press key "ENTER" - the deleting action is triggered and confirmed afterwards.

3 ... deleting all programs

First press key [3], then "ENTER"  
- all programs are deleted and the deleting action is confirmed.

4 ... Reading in a program from EPROM in memory

After pressing key [4], input the program number to be read in and press key "ENTER"  
- the input is started.

If the program to be read in cannot be found in the EPROM, or if the same program number is already available in the memory, or if the storage location is not sufficient, there is a corresponding error message.

## 18 Manipulation of times

### 18.1 Stacker airblast

The airblast timing must be adjusted so as to ensure that the part to be stacked is blown reliably over the stacker buck.

Press keys "INP", [6] and [1] for shorter or longer airblast timing.

"TIMING FOR AIR BLAST STACKER" and the adjusted value in seconds appear in the lower line of the display.

Input a new value by operating keys [0] to [9] and adopt by pressing key "ENTER".

### 18.2 Timing of fabric feed roller

The stacked workpiece must be positioned in the middle of the stacker buck (Fig. 1).

Press keys "INP", [6] and [2] for longer or shorter timing of the feed roller.

"TIMING FOR STACKER ROLLER" and the adjusted value in seconds appear in the lower line of the display.

Input a new value by operating keys [0] to [9] and adopt by pressing key "ENTER".

### 18.3 Positioning pin up (For setting see service manual)

### 18.4 Table up (For setting see service manual)

### 18.5 Edge folder slide (For setting see service manual)

### 18.6 Jig feed (For setting see service manual)

5 ... Reading in all programs from an EPROM  
in the memory

Press "ENTER" after having operated key [5]  
first

- the programs are read in; the reading in  
function is confirmed at the end.

6 ... Reading in programs in memory via  
interface

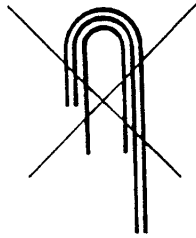
After operating key [6], the machine is ready  
for transfer.

The transfer is started at the personal com-  
puter.

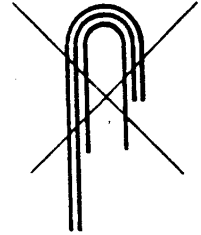
At the end, the reading in function is  
confirmed or an error message issued.



CORRECT



INCORRECT  
Increase timing



INCORRECT  
Increase timing



## 19 Switch functions

### 19.1 Airblast selection

#### Needle cooling during feed forwards

To avoid the starting thread from being pushed under the presser foot while the workpiece is fed to the sewing station.

Press keys "INP", [7], [1] and again key [1].

The airblast is switched on by key [1], and switched off by key [0].

#### Needle cooling during stacking

(If required)

#### Airblast "fabric feed assistance" (Work aid)

When processing large workpieces, it is possible to work with the "fabric feed assistance" airblast during the functions "jig feed forwards" and "stacking", and "sewing" in order to avoid the material from jamming.

#### Airblast during "feed forwards"

Press keys "INP", [7], [1] and [3].

The airblast is switched off by key 0, and switched on by key [1].

#### Airblast during "stacking"

Press keys "INP", [7], [1] and [4].

The airblast is switched off by key [0], and switched on by key [1].

#### Airblast during "sewing"

Press keys "INP", [7], [1] and [5].

The airblast is switched off by key [0], and switched on by key [1].

19.2 Puller  
(Work aid)

Press keys "INP", [7] and [2].

The puller is switched off by key [0], and switched on by key [1].

19.3 Positioning pin

On machine versions with positioning pin, the folding action can be triggered with or without positioning pin, as required.

Press keys "INP", [7] and [3].

The positioning pins are switched off by key [0], and switched on by key [1].

19.4 Thread monitor

Press keys "INP", [7] and [4].

The thread monitor is switched off by key [0], and switched on by key [1]. (Mainly for inspection purposes.)

Inquiring service functions

(Only for mechanics, detailed instructions in service manual)

In the basic state of service, all service functions with their function numbers can be indicated by pressing key "ENTER".

Switch on the machine.

Press key "SERV" on the control panel.

By pressing key "ENTER" repeatedly, the service functions are displayed.

- 1 ... Setting/resetting exits
- 2 ... Step motor for X-coordinate
- 3 ... Step motor for Y-coordinate
- 4 ... Sewing motor
- 5 ... Thread trimming sequence
- 6 ... Display of entries

21 Loading the workpiece on version with  
movable pocket plate  
(For versions with stationary pocket plate  
see additional instruction book)

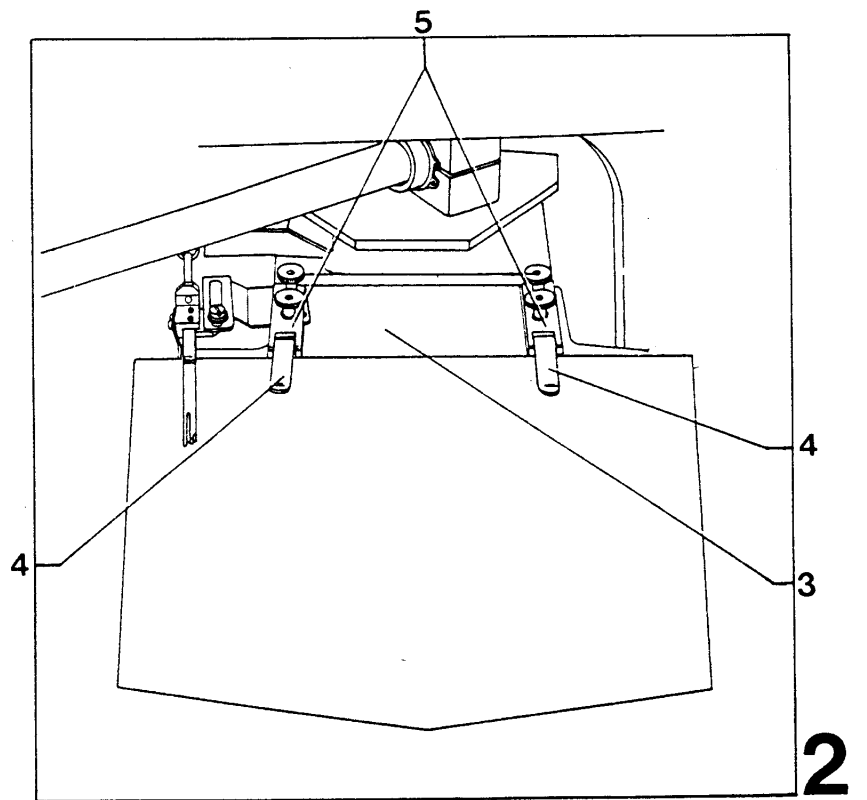
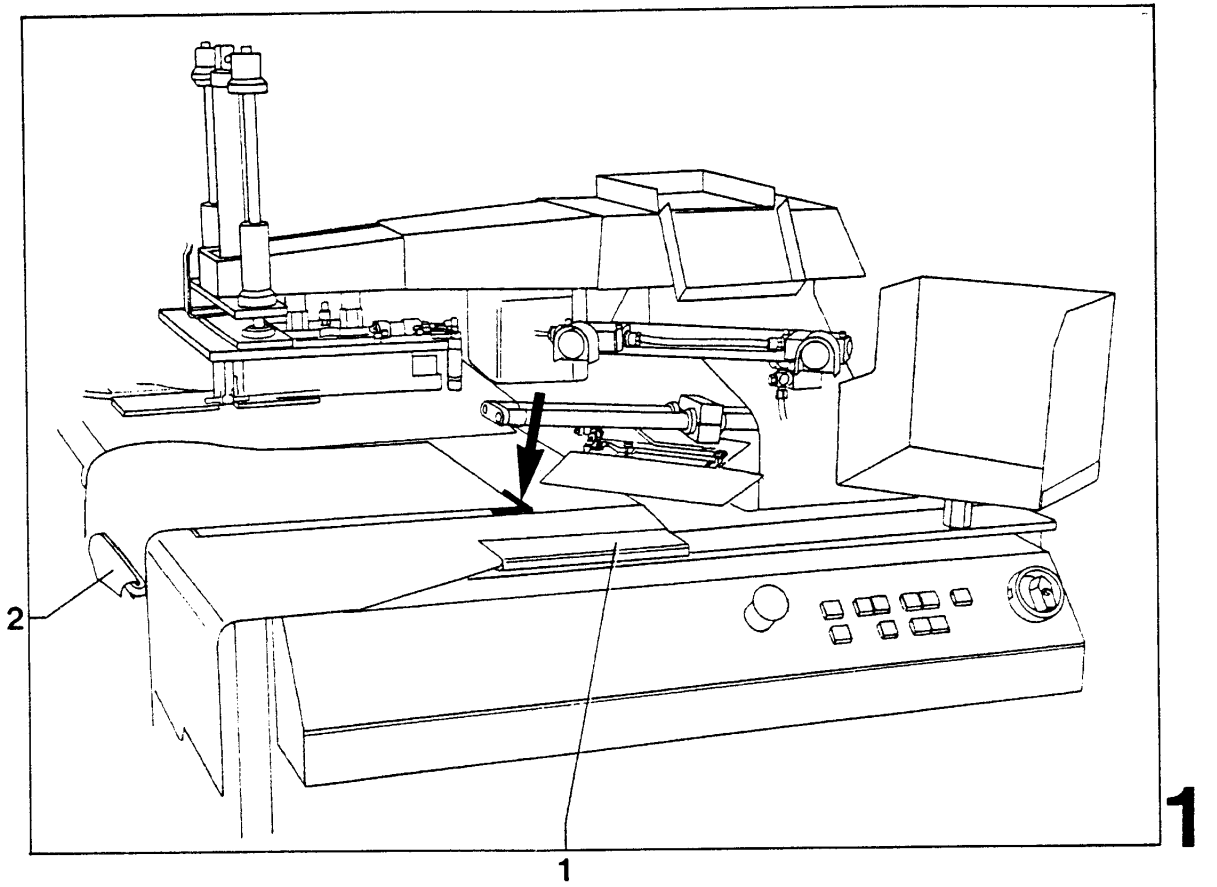
With colored adhesive tape, mark the position of the cutting on the work table (see arrow in Fig. 1).

Press key 1 (Fig. 1) and keep pressed  
- clamping strip 2 opens.

Insert cutting in folding station and level out according to marking.

Let key 1 go afterwards  
- the cutting is held by clamping strip 2.

Place the cutting on pocket plate 3 (Fig. 2), push underneath leaf springs 4 up to stops 5 and position in the middle of the pocket plate.



22 Sewing on version with movable pocket plate  
(For versions with stationary pocket plate  
see additional instruction book)

22.1 Manual operation (key "MAN" lights up)

After the workpiece is loaded and aligned,  
press buttons 1 simultaneously (Fig. 1)  
- pocket plate forwards and down.

Clock through the program sequence by  
pressing key "STEP" repeatedly.

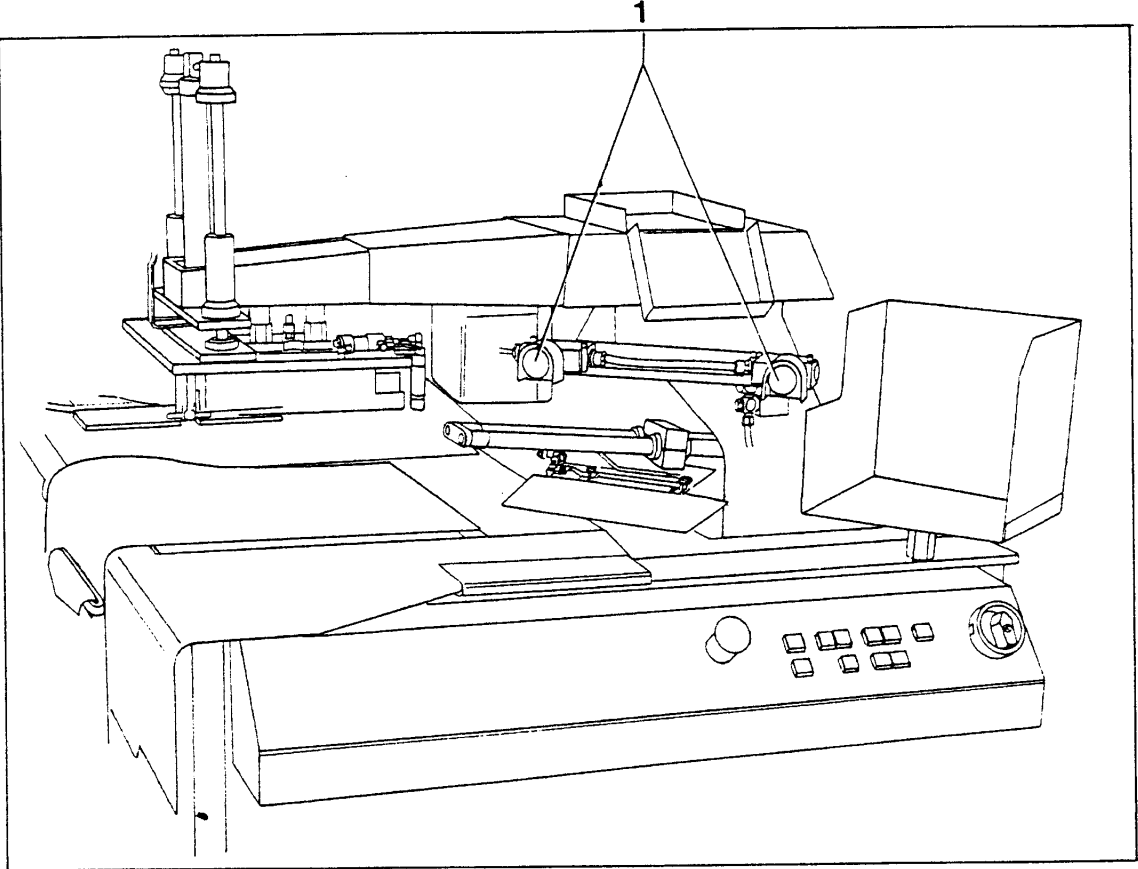
- Edge folder and table down
- Edge folder slide on and off
- Edge folder and table up
- Sewing jig moves to folding station,  
stacker in function
- Sewing jig lowered
- Pocket plate backwards
- Sewing jig moves to sewing station

Press key "SEW" - sewing on.

22.2 Automatic work sequence

Press keys "AUTO" and "START"  
- the machine switches over to automatic  
work sequence.

After the workpiece is loaded and aligned,  
press buttons 1 simultaneously (Fig. 1)  
- the entire work sequence runs off  
automatically.



## 23 Malfunctions

When the thread breaks, THREAD ERROR appears on the display of the control panel, the machine automatically clocks back 12 stitches back and stops.

Thread the needle thread according to section 9.

Press keys "FWD" or "BACK" until the sewing jig has reached the position to continue sewing.

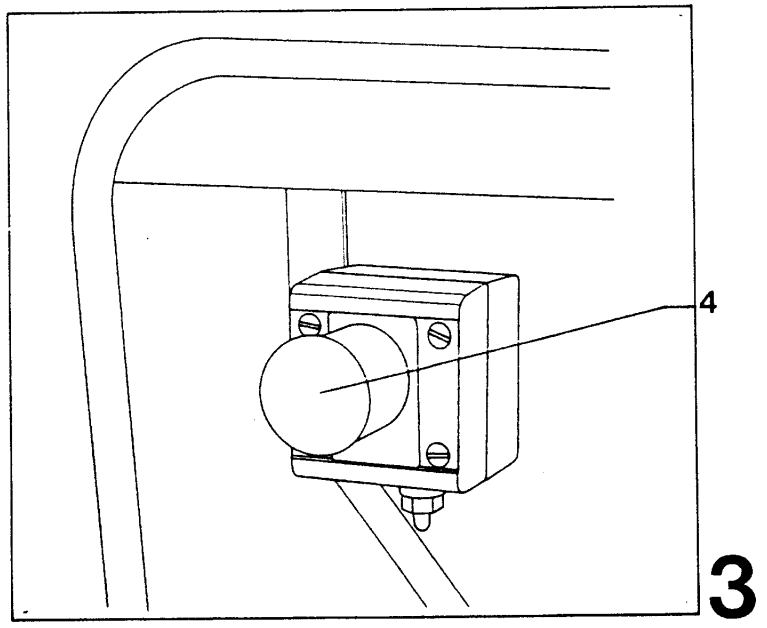
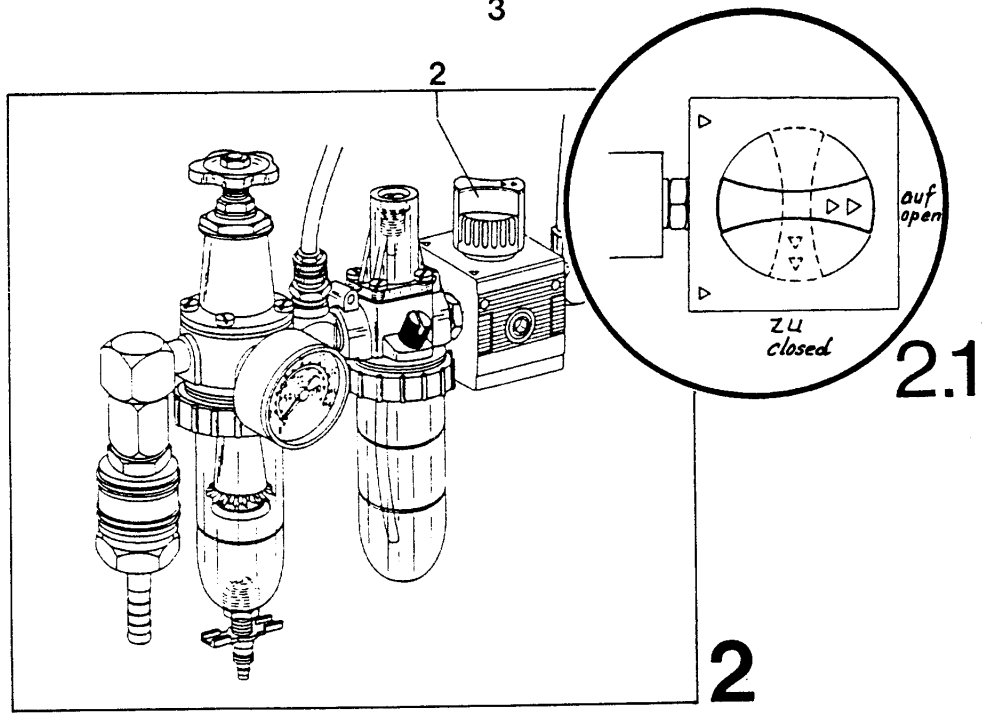
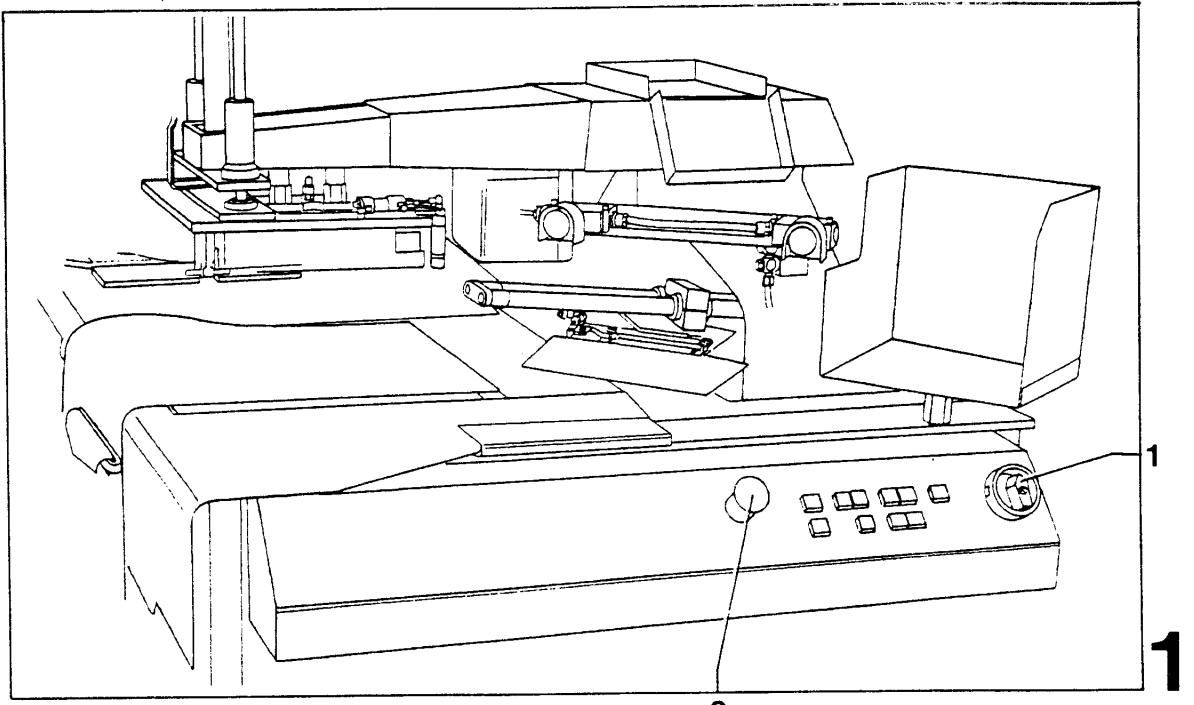
Press key "START"  
- the sewing operation is continued until end of program.

## 24 Switching off the machine

Set master switch 1 (Fig. 1) at "0" and close compressed air valve 2 (Fig. 2), (see Fig. 2.1).

If the machine is to be switched off immediately, press either key 3 (Fig. 1) or key 4 (Fig. 3) - EMERGENCY OFF.





## 25 Care and maintenance

### 25.1 Air filter/lubricator

When using the machine continuously, check the air filter/lubricator daily.

The oil level must not drop below the mark on oil reservoir 1 (see arrow in Fig. 1). (Have oil topped up by a mechanic, if necessary).

The water level must not exceed the mark on container 2 (see arrow). Open drain screw 3 by two or three turns and let the water drain off.

Afterwards tighten drain screw 3 firmly.

### 25.2 Oiling the sewing unit

When using the machine continuously, check both oil levels in oil sight glass 4 on the sewing unit (Fig. 2) daily. They must not drop below marks 5 and 6 respectively.

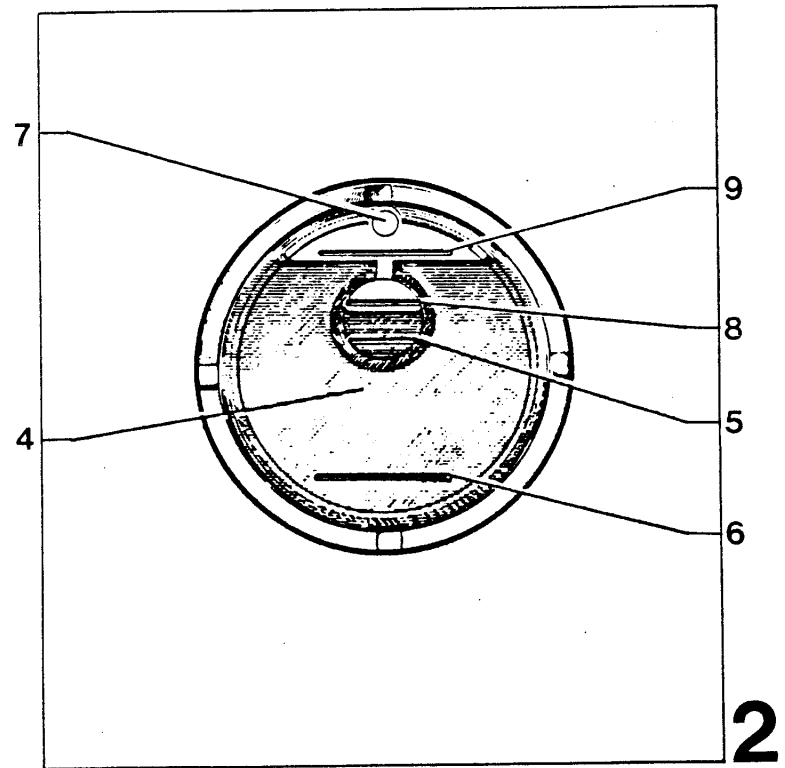
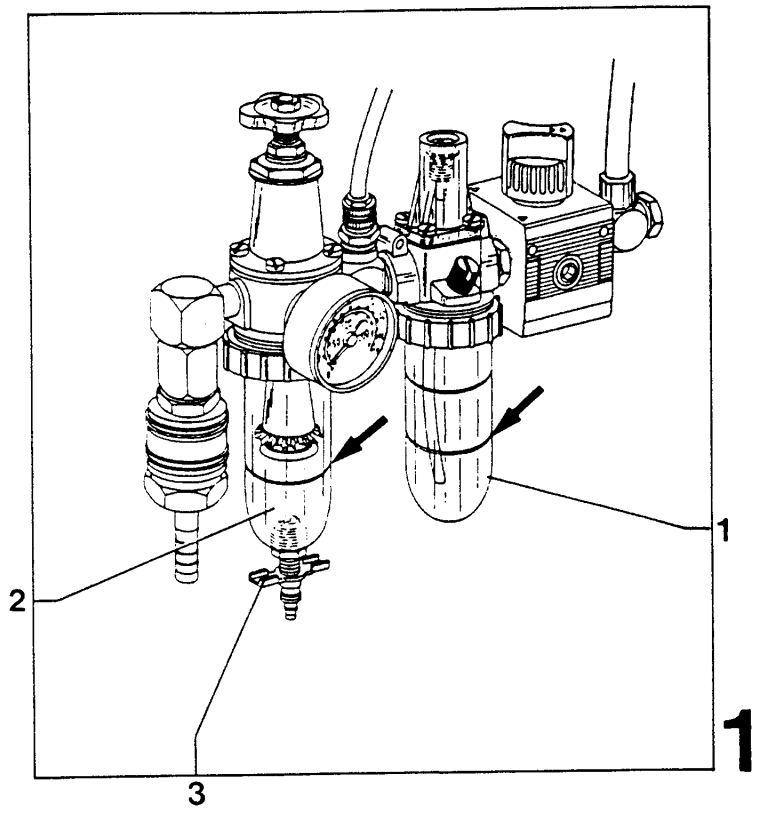
If required, top up oil through hole 7 until both oil levels have reached marks 8 and 9.

We recommend Pfaff sewing machine oil, part No. 280-1-120 144 or an oil with a mean viscosity of  $22.0 \text{ mm}^2/\text{s}$  at  $40^\circ\text{C}$  and a density of  $0.865 \text{ g/cm}^3$ .

### 25.3 Cleaning the machine

Clean the entire machine regularly.

The sewing hook area however must be cleaned several times a day.





**Additional instructions**

1 Loading the workpiece on version with stationary pocket plate

Cuttings on which the location of the pockets is marked are aligned according to positioning lights.

In case of unmarked cuttings, mark the position of the cuttings on the work table.

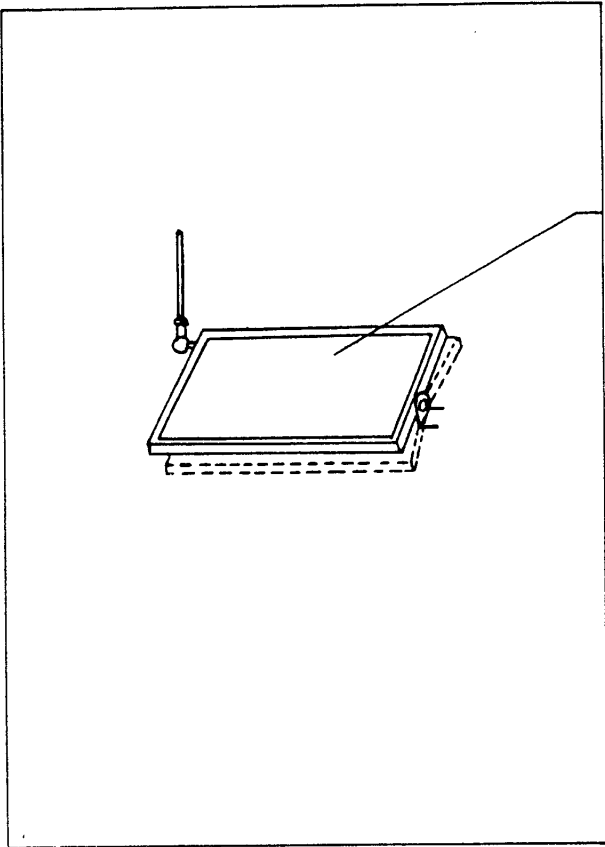
Press pedal 1 (Fig. 1) backwards (and keep pressed), - clamp strip 2 (Fig. 2) opens.

Insert and align cutting in edge folder.

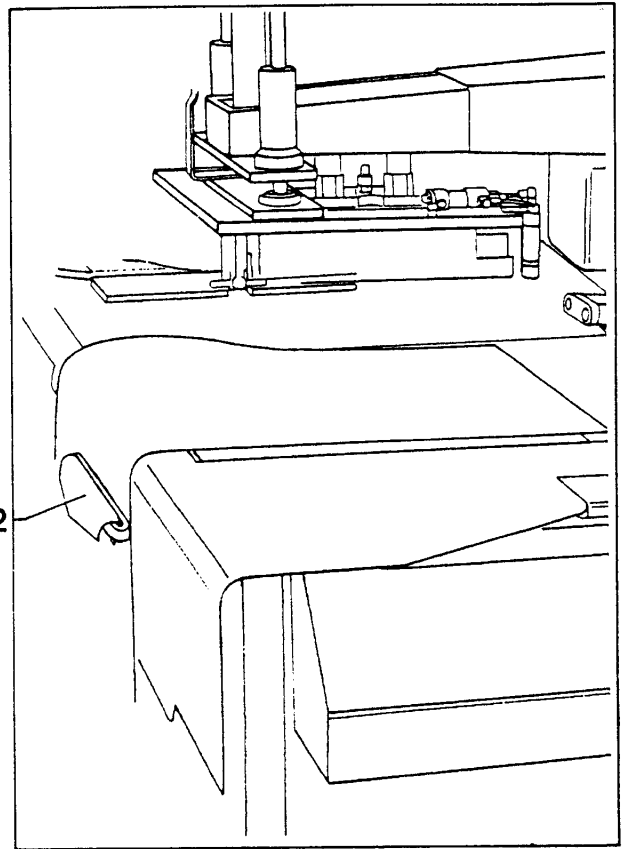
Release pedal 1 afterwards  
- the cutting is held by the clamp strip.

Press pedal 1 (Fig. 1) forwards - the pocket plate moves forwards.

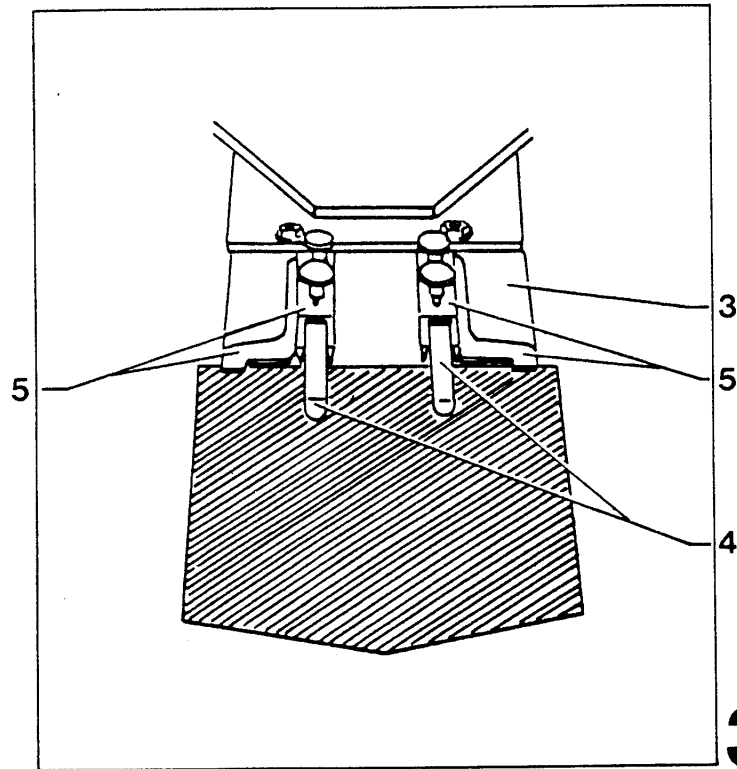
Place the cutting on pocket plate 3 (Fig. 3), push underneath leaf springs 4 against stops 5 and position in the middle of the pocket plate.



**1**



**2**



**3**

## 2 Sewing on version with stationary pocket plate

### 2.1 Manual operation (key "MAN" lights up)

When the workpiece is loaded and aligned, press buttons 1 simultaneously (Fig. 1)

- pocket plate forwards and down

Clock through the program by repeatedly pressing key "STEP".

- Edge folder slide on and off
- Edge folder and table up
- Sewing jig moves to folding station, stacker in function
- Sewing jig lowers
- Pocket plate backwards
- Sewing jig moves to sewing station

Press key "SEW" - sewing on.

### 2.2 Automatic work sequence

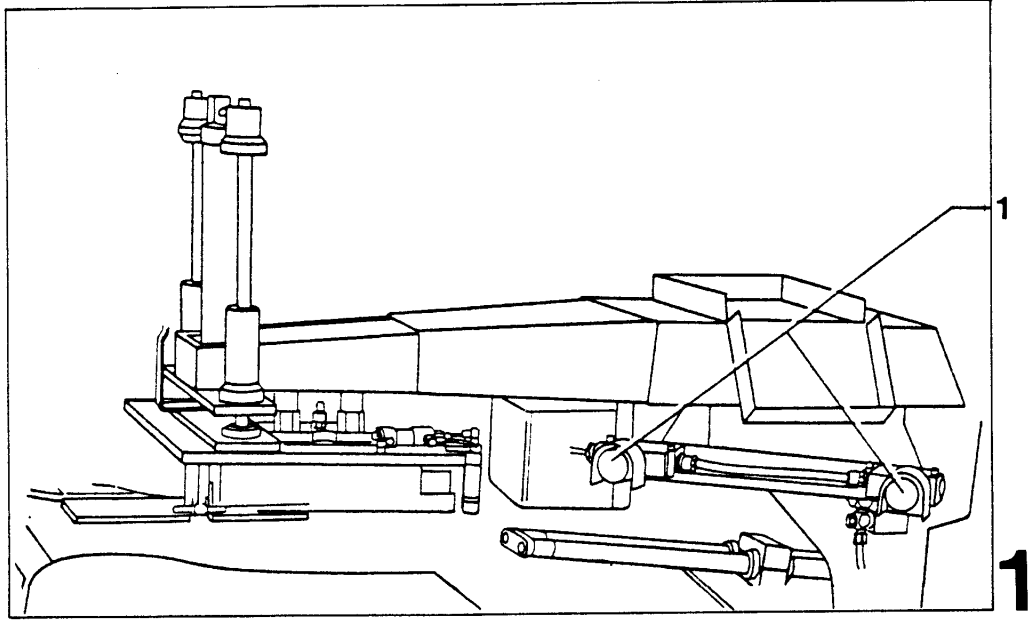
Press keys "AUTO" and "START"

- the machine switches over to automatic work sequence.

When the workpiece is loaded and aligned, press buttons 1 simultaneously (Fig. 1)

- the entire work sequence runs off automatically.





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