

GLOBAL

**LP 1971 LH (AUT)
series**

**Single needle postbed shoe machines with
large hook**

**Instruction manual &
Instruction for service manual**

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Foreword

This instruction manual is intended to help the user to become familiar with the machine and take advantage of its application possibilities in accordance with the recommendations.

The instruction manual contains important information on how to operate the machine securely, properly and economically. Observation of the instructions eliminates danger, reduces costs for repair and down-times, and increases the reliability and life of the machine.

The instruction manual is intended to complement existing national accident prevention and environment protection regulations.

The instruction manual must always be available at the machine/sewing unit.

The instruction manual must be read and applied by any person that is authorized to work on the machine/sewing unit. This means:

- Operation, including equipping, troubleshooting during the work cycle, removing of fabric waste
- Service (maintenance, inspection, repair and/or)
- Transport.

The user also has to assure that only authorized personnel work on the machine.

The user is obliged to check the machine at least once per shift for apparent damages and to immediately report any changes (including the performance in service), which impair the safety.

The user company must ensure that the machine is only operated in perfect working order.

Never remove or disable any safety devices.

If safety devices need to be removed for equipping, repairing or maintaining, the safety devices must be remounted directly after completion of the maintenance and repair work.

Unauthorized modification of the machine rules out liability of the manufacturer for damage resulting from this.

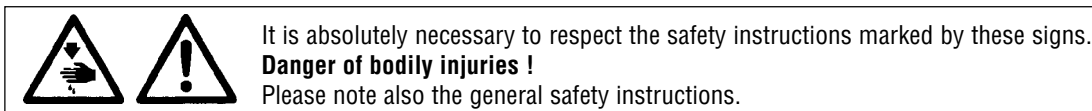
Observe all safety and danger recommendations on the machine/unit! The yellow-and-black striped surfaces designate permanent danger areas, eg danger of squashing, cutting, shearing or collision.

Besides the recommendations in this instruction manual also observe the general safety and accident prevention regulations!

General safety instructions

The non-observance of the following safety instructions can cause bodily injuries or damages to the machine.

1. The machine must only be commissioned of the instruction book and operated by persons with appropriate training.
2. Before putting into service also read the safety rules and instructions of the motor supplier.
3. The machine must be used only for the purpose intended. Use of the machine without the safety devices is not permitted. Observe all the relevant safety regulations.
4. When gauge parts are exchanged (e.g. needle, presser foot, needle plate, feed dog and bobbin) when tread-ing, when the workplace is left, and during service work, the machine must be disconnected from the mains by switching off the master switch or disconnecting the mains plug.
5. Daily servicing work must be carried out only by appropriately trained persons.
6. Repairs, conversion and special maintenance work must only be carried out by technicians or persons with appropriate training.
7. For service or repair work on pneumatic systems the machine must be disconnected from the compressed air supply system. Exceptions to this are only adjustments and functions checks made by appropriately trained technicians.
8. Work on the electrical equipment must be carried out only by electricians or appropriately trained persons.
9. Work on parts and systems under electric current is not permitted, except as specified in regulations DIN VDE 0105.
10. Conversion or changes to the machine must be authorized by us and made only in adherence to all safety regulations.
11. For repairs, only replacement parts approved by us must be used.
12. Commissioning of the sewing head is prohibited until such time as the entire sewing unit is found to comply with EC directives.



IMPORTANT WARNING!

To the feeding network cord, it is necessary to connect the respective network plug which has been approved in the country of utilizing the machine. This operation should be performed by a worker acquainted with the electric safety rules being in force in the given country. The supplier is not responsible for any damages caused by defective plug or owing to incorrect assembly of the plug.

In spite of all safety measures made on the machines, inappropriate actions of the operator may lead to dangerous situations. In industrial sewing machines, attention should be paid to the following still remaining possible sources of injury:

1. Moving sewing needle
 - risk of injury when sewing with raised pressure foot or top roller, because the finger guard is then positioned too high.
2. Moving thread take-up lever
 - risk of injury when inadvertently or intentionally inserting the finger(s) between the thread take-up lever and its guard.
3. Moving pressure member
 - risk of injury when holding sewn work in immediate vicinity of the pressure member and beginning to insert under the pressure member a considerably thicker sewn work portion,
 - risk of injury when sinking the pressure member.
4. When switched off, the clutch motor slows down by inertia but would be reactivated by an accidental tread-ing down of the motor treadle. To avoid such risk, it is advised to hold the handwheel by hand and slightly to depress the motor treadle.

Part A - Instruction manual

1. Proper use of the machine

The machine can be used in the shoemaking industry for sewing of light medium and heavy shoe uppers. It is suitable for sewing natural and man made leathers, shoemaking textiles and even plastic parts of sports shoes.

The machine is also used in the fancy goods industry for sewing bags, handbags, rucksacks and cases from the usual fancy goods materials.

The machine sews with a double needle stitch. It is standardly equipped with needles of the 134 LR system which are suitable for sewing leather. When sewing textile materials it is necessary to install the needle of the 134 system. The machine enables the sewing of both technical and decorative seams which have almost the constant length of the stitch at a different sewing speed. Only a dry material, which cannot be thicker than 8 mm when depressed by top roller, can be sewn by these machines, generally. The material cannot contain any hard subjects, to the contrary case it is possible to work only with applied eye-protective shield. Such a shield is not available to delivery at this time. Generally threads up to size 1000 dtex x 1 x 3 (Labelled number 10) have been used namely synthetic, cotton or core threads. Whoever should like to use other special threads, that one should consider the resulting risks and make appropriate safety measures.

The total thickness is determined by sewing with a thicker needle of very strong material. In cases like this it is also necessary substantially reduce the speed of sewing below the value shown in paragraph 5.

These special machines may be installed and operated only in dry and kept up expenses. We, as industrial sewing machines manufacturers, agree with the fact that our products are operated, at the least, so far learned operators who can carry out all usual operating functions and suppose their possible risks as perceptible.

Machine noisiness

Machine noisiness has been measured in accordance with the standards ISO 3746, ISO 11204 at maximum speed.

L_{aeq} = equivalent machine noise of the self-standing machine on the working place, converted to % machine employment (dB) - stated in the table

Type of the machine	Noisiness dB	% machine employment
4180i-5XX-100	82	20
4180i-5XX-200	79	20
4180i-5XX-300	73	20
4180i-5XX-400	70	20

2. Description of the machine

It is single needle machine. It sews with a double threaded lock-stitch. It has a lower circular feed, needle feed and a top roller which is driven. There are two possibilities for feeding. At the first step it feeds a lower circular feed, needle and top roller. Secondly it feeds only the circular feed and the top roller (the needle is above the throat plate). Feeding can be in both directions. The stitch length can be adjusted with an adjusting dial. The feeding mechanism can be adjusted to two systems after removing the rear cover:

1. Stitch length up to 5 mm at max. sewing speed up to 3000 rpm (stitch length 3 mm at max. sewing speed up to 3500 rpm).
2. Stitch length up to 7 mm at max. sewing speed up to 2000 rpm.



Caution!

Maximum allowed speed must not be exceeded for the given system of sewing. Otherwise it can cause damage to the feeding mechanism.

The machine is fitted with a large-size vertical hook protected by an safety clutch.

The machine uses a wick lubrication system with central oil supply. The hook is lubricated from an independent oil source.

The simplest sub-class is standardly equipped with a knee operated lever. Specially for the Czech republic and if required with treadle. Reverse stitching is with a manually operated lever.

Higher sub-classes have always mechanical control like the simplest sub-class, and furthermore there is a possibility of levelling the needle, thread trimmer, electromagnetic top roller lift and electromagnetic reverse stitching (according to your order).

Each sub-class can be delivered in four sewing categories. Sewing category is determined by the number of the thread label and the corresponding number of the needle. The machine is adjusted in the factory so that it corresponds to the ordered sewing category. Changes of adjustment can be carried out only by a skilled and trained mechanic. A stand with wedge is in the simplest sub-class equipped with a lever clutch motor and if required with a stop motor which enables the levelling of the needle.

In higher sub-classes, the stop motor is either situated on the machine table top or as a minimotor integrated on the machine head. The type of mechanical top roller lift depending on the stand has one or two treadles.

3. Machine sub-classes and sewing categories

3.1 Sub-class

Table 1

Type of the machine	Top roller lift				Reverse stitching		Thread trimmer
	Via knee lever	Treadle	Via electro-mag. + knee lever	Via electro-mag. + treadle	Via hand lever	Via electro-mag. + hand lever	
4180i-511-XXX	●				●		
4180i-521-XXX*		●			●		
4180i-547-XXX			●			●	●
4180i-557-XXX*				●		●	●

*for only Czech republic

3.2 Sewing categories

This code indication includes the equipment assembled on the machine head, both necessary equipment and optional equipment. The standard configuration of the equipment has been preset, according to the under mentioned table, in the factory which includes only necessary equipment. If the buyer demands a different configuration then the factory allocates a new code indication.

Table 2

Standard configuration - the numbers in brackets stand for ordering Nos. when ordering separately the Equipment in question (needles - delivered in 10 pcs pack).

Type	Needle size	Top roller	Wheel feeder	Throat plate insert	Throat plate
Class-sub-class -sewing category	0.01mm	Diameter mm	Pitch of teeth mm	Width of hole mm	-
4180i-5XX-100	80	35	0.4	1.2	(M 037)
	(S548 134013)	(M 173)	(M 060)	(M 101)	
4180i-5XX-200	100	35	0.4	1.5	
	(S548 134001)	(M 173)	(M 060)	(M 102)	
4180i-5XX-300	130	35	0.6	2.0	
	(S548 000311)	(M 173)	(M 059)	(M 103)	
4180i-5XX-400	160	35	1.2	2.4	
	(S548 000320)	(M 173)	(M 058)	(M 104)	

4. Survey of equipment

This survey does not include the equipment assembled on the stand.

4.1 Equipment (at least one of each from the following group of equipment is assembled)

4.1.1 Needles

- M 020 - needle 134 LR size 80
- M 023 - needle 134 LR size 100
- M 021 - needle 134 LR size 130
- M 022 - needle 134 LR size 160

4.1.2 Wheel feeders

- M 060 - wheel feeder with pitch of teeth 0.4 mm
- M 059 - wheel feeder with pitch of teeth 0.6 mm
- M 058 - wheel feeder with pitch of teeth 1.2 mm

4.1.3 Top roller holders

- M 156 - holder for the top roller ø 25 mm
- M 157 - holder for the top roller ø 35 mm
- M 295 - holder for the top roller ø 45 mm

4.1.4 Top rollers

- M 172 - top roller ø 25 mm
- M 173 - top roller ø 35 mm
- M 174 - rubberized top roller ø 25 mm
- M 175 - rubberized top roller ø 35 mm
- M 310 - smooth top roller ø 25 mm
- M 311 - smooth top roller ø 35 mm
- M 296 - top roller ø 45 mm - width 2.0 mm
- M 297 - top roller ø 45 mm - width 3.8 mm

4.1.5 Throat plate

- M 037 - throat plate

4.1.6 Throat plate inserts

- M 101 - insert for throat plate (for needle 60-80)
- M 102 - insert for throat plate (for needle 80-110)
- M 103 - insert for throat plate (for needle 110-140)
- M 104 - insert for throat plate (for needle 160-180)

4.1.7 Connecting cables of the head to the drive

- M 163 - connecting cable to the drive EFKA DC 1600/DA82GA; EFKA VD 552/6F82FA and EFKA VD 554/6F82FA
- M 055 - connecting cable without any specified drive (with free cable end)





Note: For the machine provided with a minimotor, the cable is component part of the drive thereof.

4.2 Optional equipment

- M 010 - built-in lighting (including transformer 230/12V)
- M 069 - rounded throat plate with 4 pcs inserts - available for sewing categories -100, -200, -300 for narrow 3D parts
- M 018 - sewn work guide
- M 149 - sewn work guide
- M 291 - upper unwinding equipment
- M 293 - lower unwinding equipment
- M 313 - set of parts for attaching French border (to be ordered together with the equipment M291, M 293 and M 314 or M 315)
- M 314 - throat plate for attaching border - width 2.0 mm
- M 315 - throat plate for attaching border - width 2.5 mm
- M 242 - setting gauge
- 4180 511001V - high mortality spare parts kit in plastic box for sub-class without thread trimmer
- 4180 547001V - high mortality spare parts kit in plastic box for sub-class with thread trimmer
- S794 222012 - halogen lighting (12 V, 20 W - contains transformer)

5. Technical data

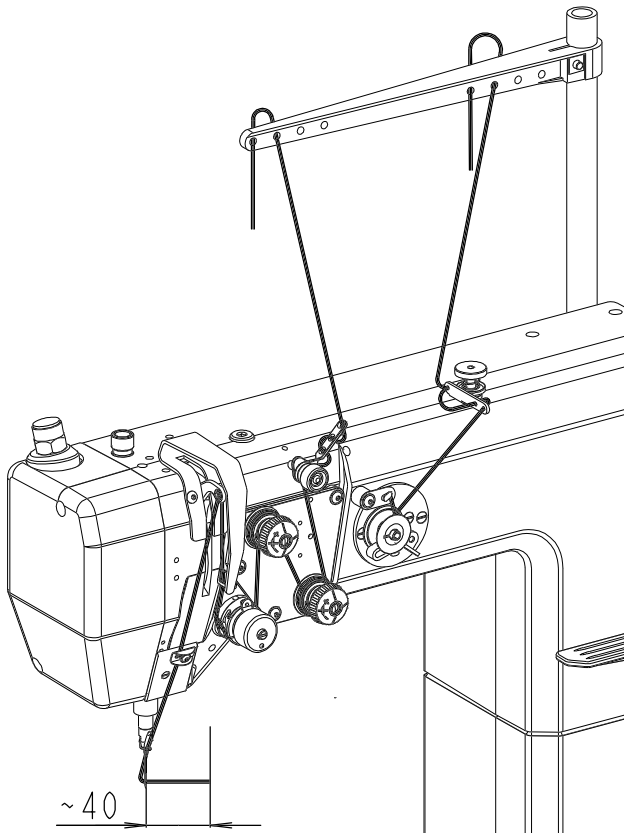
Table 3

Sewing category	Material sewn		Stitch length		Labelled number of polyester thread		Number of needle		Sewing speed		Hook
	Standard										
	Thickness of one layer	Number of layers	Standard	Maximum	Standard	Range	Standard	Range	Standard	Maximum	
	mm	-	mm	mm	-	-	0,01mm	0,01mm	SPM	SPM	
-100 -light	0,8	2	1,7	3	70	80,70, 60	80	60-80	2500	3000	R 820 * 
-200 -medium	1	2	2,5	5	40	50,40, 30	100	80-110	2500	2500	R 820 * 
-300 - me- dium heavy	1,5	1-2	3,5	5 7	20	25,20	130	110-140	1600	2000	R 820 ** 
- 400 - heavy	2	1-2 or 2-3	5	7	10	10 (20)	160	160-180	1200	1600	R 820 ** 

* The splice with the so-called spur is being mounted as a standard with the sewing categories 100 and 200 and is designed for sewing thin materials. For sewing thicker materials with a maximum stitch length it is possible to use a splice without spur.

** Splice without spur is mounted as a standard with the sewing categories 300, 400.

Stitch type	Double thread lock-stitch
Top roller stroke	6 mm - via hand lever 12.5 mm via knee lever, treadle, electromagnet
Hook	R 820 - vertical large
Needle	System 134 LR System 134 KCLR System 134
Driving unit	Lever clutch 4 poles change motor min. 0.4 kW, lever clutch 2 poles change motor min. 0.4 kW Stopmotor min. 0.4 kW
Weight of the head	max. 52 kg (58 kg head with minimotor)
Weight of the stand	max. 61 kg (38 kg for head with minimotor)
Height of post bed	173 mm
Opening space of machine head	270 x 298 mm
Dimension of bed plate	178 x 518 mm
Length of trimmed thread ends	10...19 mm
Input machine with clutch motor	Max. 700 W
Input machine with stop motor	Max. 800 W (600 W with minimotor)
Equivalent acoustic presser level of the sole machine at work place by 20% use of the machine during a shift under standard sewing conditions	82 dB/A
Layout dimensions of the machine (including the stand)	1060 x 550 mm
Height of the machine (including the stand)	1680 mm



6. Operation of the machine

6.1 Threading a thread



Caution! Risk of injury!

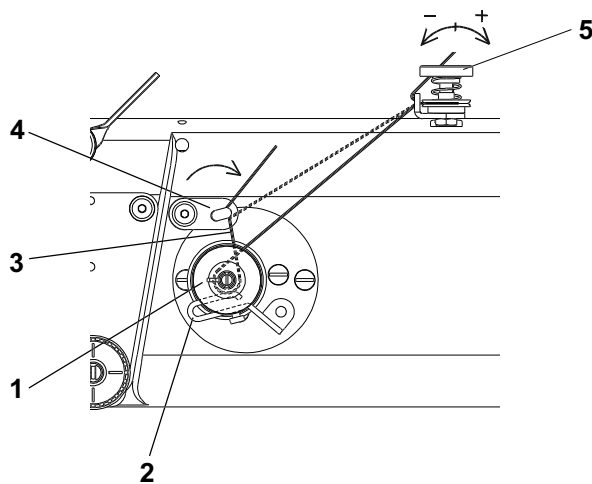
Before threading a thread, turn the main switch off and wait until the machine stops!

Thread the threads as it is shown in picture.



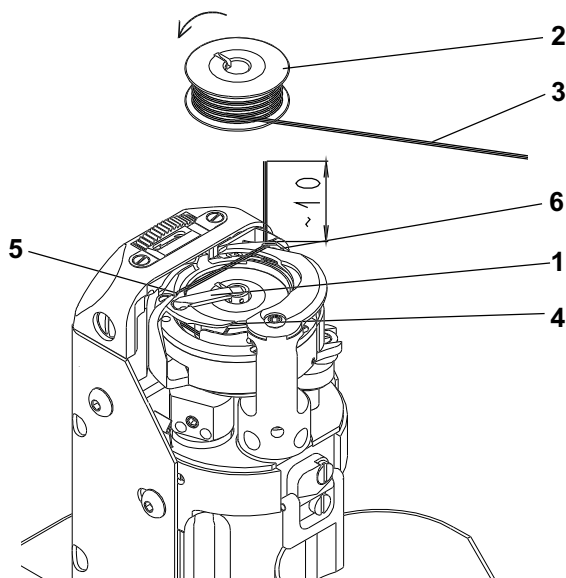
Caution!

Not following the correct method of threading a thread may cause serious damage to the function of the machine.



6.2 Bobbin thread winding

- Insert the bobbin (1).
- Spool counter-clockwise manually onto the bobbin, minimum six threads of the lower thread (3).
- Insert the thread ends into the equipment (4) and cut off the ends.
- Press the lever (2) until it reaches its limit.
- Switch on the machine.
- The winder will automatically switch off after winding.
- Take off the hook bobbin and cut off the end in the equipment (4).
- The nut (5) is instrumental to thread tension control for winding. Turning clockwise sense the thread tension is increased and the single threads are more firmly fixed on the bobbin.
- The tension cannot be so extensive as far as slipping of the winder friction drive has occurred.



6.3 Inserting the bobbin and threading the lower thread

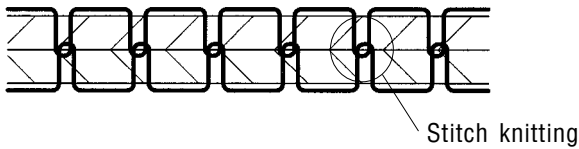


Caution! Risk of injury!

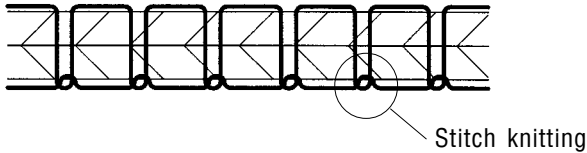
Turn the main switch off and wait until the motor stops!

- Tilt the shutter (1) up.
- Insert the bobbin (2) with thread end (3) in the direction as shown in the picture.
- Thread the thread through the notch (4) and the space (5) and place under the spring (6).
- Cut off the thread end as shown.

Fitting seam



Decorative seam



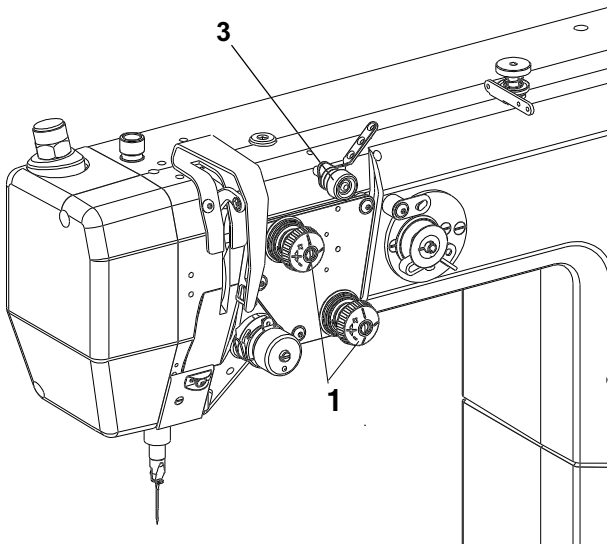
6.4 Regulating the thread tension

The thread tension must conform to the thickness of the sewn threads, thickness and hardness of sewn material (thin and soft material will fold with high tension) and the kind of seam. An ordinary fitting seam should be formed with stitches knitted in the middle of the sewn material.

A decorative seam is mostly used with rough threads (10, 20) on thin material and it has tied up threads on the reverse side of the material for achieving a decorative appearance.

Thread tension adjustment is by standard sewing (par. 5, table 3) conditions in accordance with table No. 4.

If achieving of a decorative seam with stitch knitting on the underside is wished, it is necessary to decrease the upper thread tension, it is carried out by turning of nuts (1), in the counter-clockwise sense.



Thread tension

Table 4

Sewing category	Kind of seam	Identified value upper thread tension	Maximum tension of lower thread
		N	N
1	-	3	1
2	-	4.5	1.5
3	Fitting	8	2
	Decorative	5	
4	Fitting	12	2
	Decorative	10	



If the maximum lower thread tension exceeds the values given in table No. 4, it may cause problems in the beginning of sewing after the previous thread trim.

Measurement of tension is done by dynamometer.

Warning:

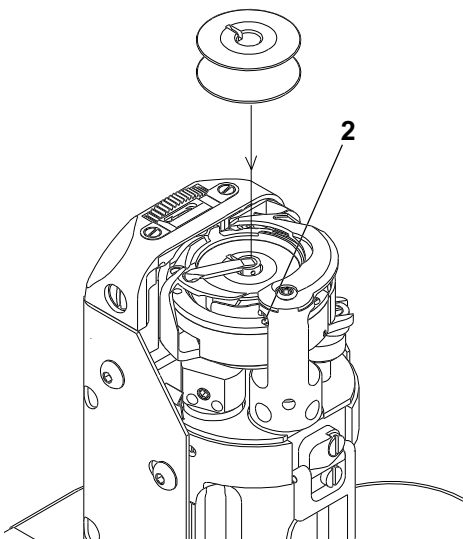
The upper thread tensioner has been loosened automatically after every trimming and top roller lifting. In these cases the thread tension cannot be measured.

Regulating the thread tension



Caution! Risk of injury!

Before regulating the lower thread tension, turn the main switch off and wait until the motor stops.

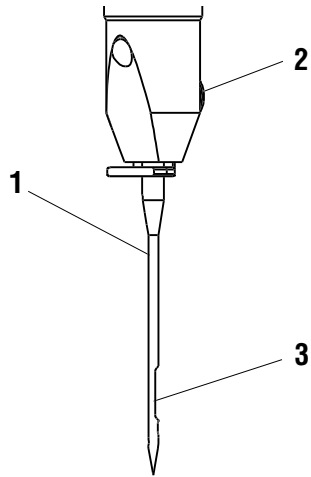


The upper thread tension is adjusted with nuts (1). Its clockwise turning increases the tension.

The tension of the auxiliary tensioner (3) should be as low as possible but it should be on a level so that the upper thread would not pull out of the tensioner when the work is being removed.

The lower thread tension is adjusted with a screw (2). Its clockwise turning increases the tension.

Tension correlation rate defines the depth of the seam tied through. The result of raising the upper tension will be the decreasing depth of tie through. The opposite will apply with the lower thread.



6.5 Needle replacement



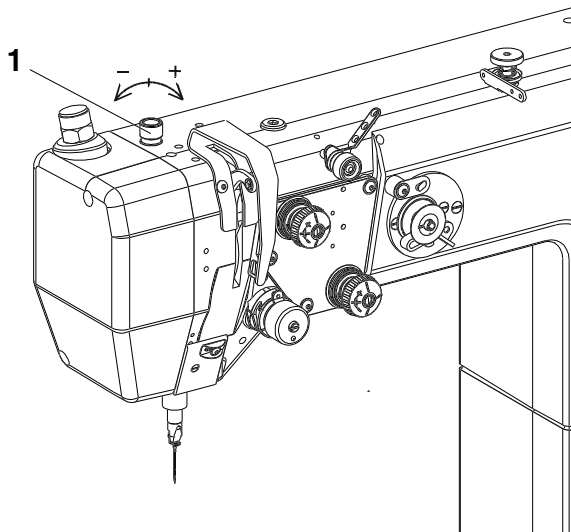
Caution! Risk of injury!

Before removing and inserting the needle turn the main switch off and wait until the motor stops!

- Turn with the hand wheel as far as the top needle (1) position has been reached.
- Loosen the screw (2) and take the needle out.
- When inserting a new needle, care is to be taken that groove (3) above the needle's eye was in the same direction as the hook.
- Tighten the screw (2).



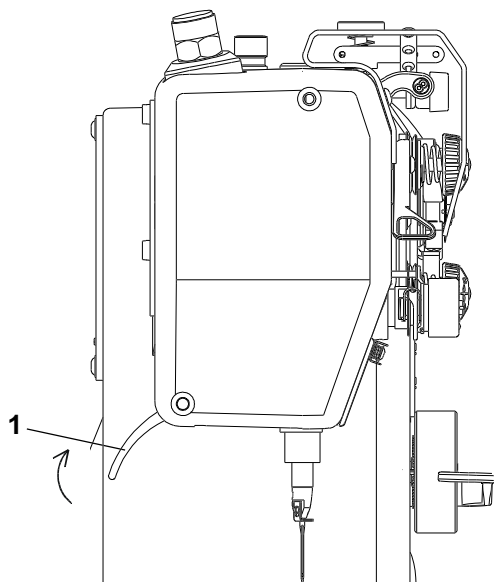
The inserted needle must respond to the sewing category according to paragraph No. 5, table 3. Otherwise it will cause damage to sewing, or eventually the machine could be broken.



6.6 Regulation of pressing the top roller

The pressing of the top roller should be as low as possible but on a level so that the top roller would not fly over when needle comes off the material and that the feeding power got over the thread pull by stitch tightening.

By turning of the screw (1) clockwise pressing of the top roller has been increased, by counter-clockwise turning pressing of the top roller has been decreased.

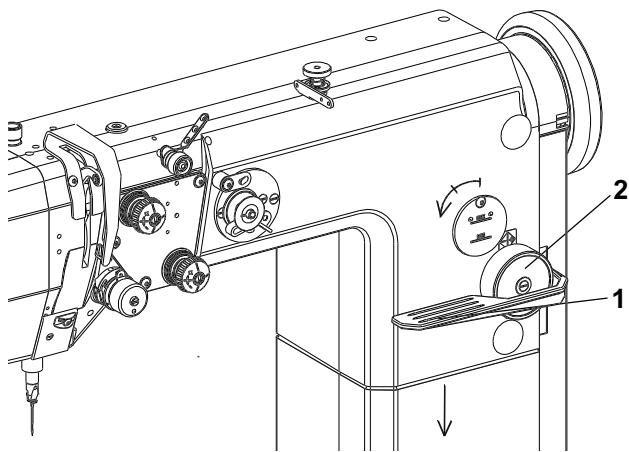


6.7 Lifting the top roller up

Mechanical lifting of the top roller is enabled by means of the hand lever (1), which contemporarily, after it has been lifted in the arrow direction, is locking the top roller in its top position and turning (adjustment) of the machine is possible. The top roller can be lifted via knee lever or left treadle - depending on the machine sub-class. Automatical lifting by means of electromagnet is described in the paragraph No. 7.



When lifting top roller via knee lever or the treadle or electromagnet, the needle must be in the upper position and the machine has to come to a full stop.



6.8 Reverse stitching

The change of direction of sewn work can be mechanically controlled via a reverse stitching lever (1) by its depression in the arrow direction (down). The sub-class defines whether the machine has electromagnetic reverse stitching – see paragraph No. 7.

6.9 Stitch length adjustment

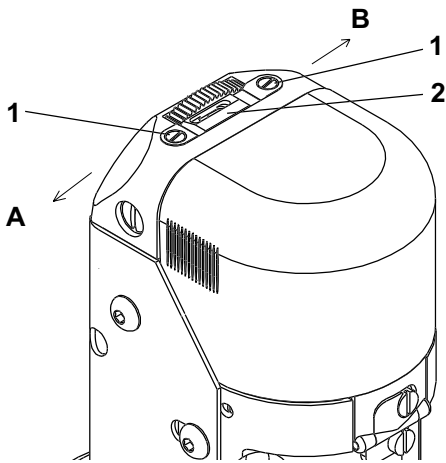
Stitch length adjustment is by dial (2) by its turning. Turning clockwise stitch length is decreased, turning counter-clockwise stitch length is increased.



If it comes to a substantial change of length of stitch it is necessary to adjust of the throat plate insert in accordance with the following paragraph, by the machines with the thread trimmer.

6.10 Thread trimmer and adjustment of the throat plate insert

The throat plate is fitted with a slidable throat plate insert. It is necessary to adopt the position of the insert to the stitch length in sub-classes of the machine with a thread trimmer in the way that for short stitches the insert will be shifted in the direction "A" up to stop; for medium length it will be shifted towards the centre; for long stitches (e.g. decorating) it will be shifted in the direction "B" up to stop. All the stitch lengths will be shifted towards "B" by the machines without the thread trimmer.



Caution! Risk of injury!

Before adjustment turn the main switch off and wait until the motor stops!

- Loosen the screws (1).
- Shift the insert (2) in the direction of the arrows into the required position.
- Tighten the screws (1).



Wrong set of insert can cause cluster knot at the lower side of the work, malfunction of the thread trimmer, wrong beginning of the seam after the previous trim.

6.11 Safety clutch

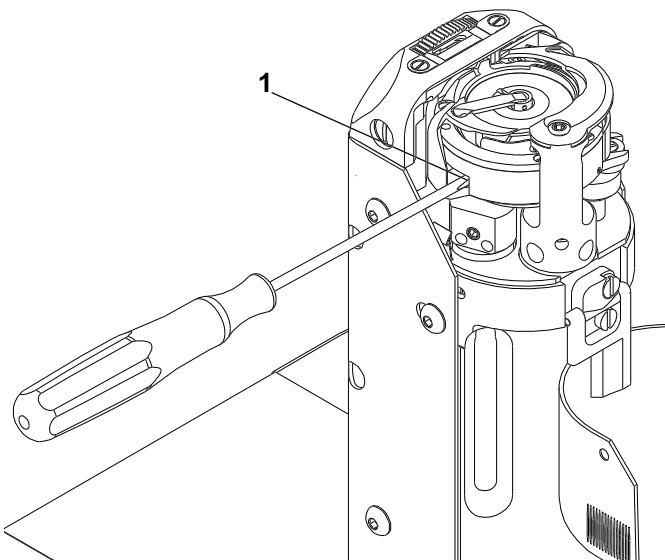
The machine is provided with a safety clutch which disengages the driving unit, when the hook is blocked. Reconnection must be done in the following way:



Caution! Risk of injury!

Before assembly turn the main switch off and wait until the motor stops!

- Turn the manually operated wheel as far as you can reach the suitable point for inserting a screwdriver into the space(1).
- Continue turning the manually operated wheel in direction of the arrow located on it, until you feel the drop in of the safety clutch.



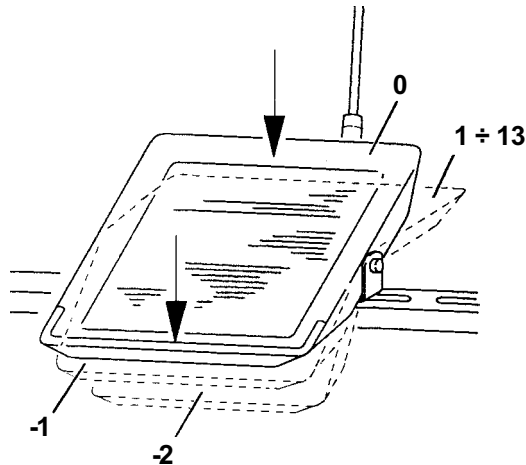
7. Electronic control of the machine

(it is valid for sub-classes equipped with stop motor)

7.1 Control of sewing by means of control elements

7.1.1 Via treadle (treadle positions and function possibilities)

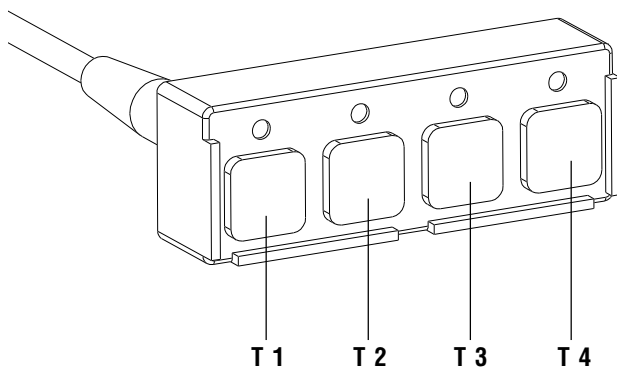
The position of the treadle is read by the reader, which can recognise 16 levels. Its meaning is shown on the table.



Treadle position	Treadle	Meaning
-2	Foot full backwards	Command for thread trimming (seam finishing)
-1	Foot slightly	Command lifting the top roller up
0	Neutral position	Note
1	Slightly forwards	Command releasing top roller
2	Continually forwards	Sewing at minimum speed (1. gear)
3	Continually forwards	Sewing at second speed level
:	:	:
13	Fully forwards	Sewing at maximum speed (12. gear)

Note: It is possible to pre-adjust the needle position (up/down) and foot position (up/down) by stopping in seam (introducing the treadle in neutral position). Foot position (up/down) after seam finishing (pressing the treadle by foot fully backwards).

7.1.2 Via pushbutton panel



There are four built-in pushbuttons in the panel with fixed adjustable functions:

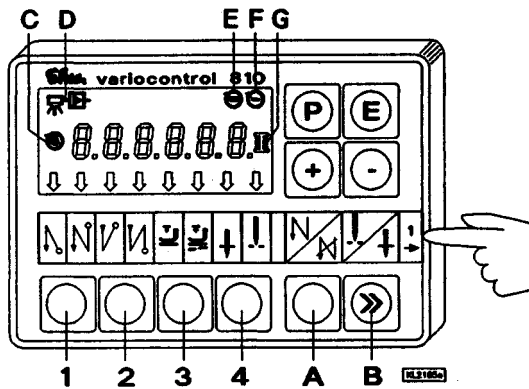
- T1 - bar operation (by pressing this pushbutton during sewing the sewn work is feed back)
- T2 - needle up/down (each press of the pushbutton changes the needle position)
- T3 - temporary cancelling (recalling) bar (in case) the bar is pre programmed at the start and end of the seam, by pressing the pushbutton down will uniformly switch off; if it is not chosen it will switch on by pressing the pushbutton
- T4 - revolutions limitation (valid for motor Efka DA82GA)
 - reduction of pressure of the presser foot for Mini-stop EFKA DA320 (see The instructions for assembling with Mini-stop, par. 5.2.4)

7.1.3 Via control panel Efka V 810/V 820

These functions are standardly assigned to the pushbuttons A, B:

- A - cancelling (recalling) the bar (the same function as T3 of the pushbutton panel)
- B - needle up/down (the same function as T2 of the pushbutton panel)

Note: function of the A, B pushbuttons can be changed by different adjustment of parameters 293, 294 (see the parameters list of driving unit Efka DA82GA).



Note: The last section of end bar must have at least 3 stitches. Foot position adjustment by stopping at the seam (by neutral position of treadle) and after finishing seam (by neutral position of treadle):

Setting is by means of pushbutton 3, arrow indication above the corresponding symbol.

Needle position adjustment by stopping at the seam:

Setting is by means of pushbutton 4.

7.2.1.2 Setting by means of parameters

Drive memory contains the parameters which enables sewing system tuning. These parameters have exact meaning and they are divided into 3 levels. Further parameters which are available only for operation will be quoted. Each parameter has its (sequence) number and value.

General procedure by changing parameters of operation level:

- switch the main switch on or finish the seam by pressing the treadle fully backwards down
- press pushbutton P on the panel V 810
- it will be displayed on the display F 000 (000 it is the number of parameter)
- by several times pressing + (or -) set the requested number of parameter
- push pushbutton E down and it will be shown the value of parameter on the display
- you can change the value by means of pushbutton + or -
- by pushing pushbutton E down you will change the sequence to the following number of parameter
- by pushing pushbutton P down you will leave the mode of changing parameters

Note: 1. For permanent memory storing of changed parameter, it is necessary to press treadle forwards down after changing of parameters.

2. Mode of changing parameters is possible only after finishing of the seam.

Number of stitches in bars:

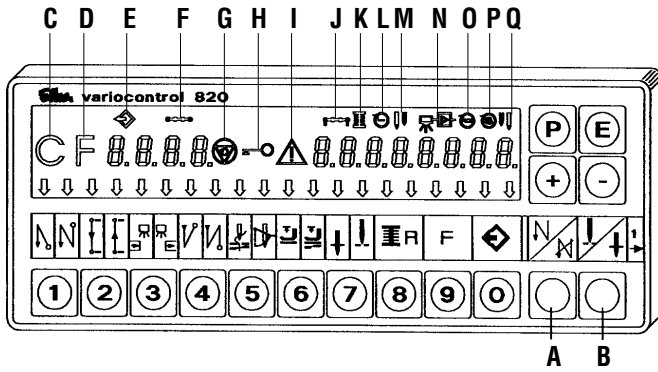
Number of stitches is stored in parameter's number.

No. of parameter	Value range of parameter	Description of parameters
000(080)	0-254	Number of stitches of start (fancy) bar forwards
001(081)	0-254	Number of stitches of start (fancy)bar backwards
002(082)	0-254	Number of stitches of end (fancy) bar backwards
003(083)	0-254	Number of stitches of end (fancy)bar forwards

Sewing according to sewing program:

Drive with panel V810 automatically enables sewing of 1 seam with setting number of stitches. It is necessary to set in corresponding number of stitches, and initialisation of sewing program.

No. of parameter	Value range of parameter	Description of parameters
007	0-254	Number of stitches
015	ON/OFF	ON/OFF sewing under sewing program



Symbol P Automatic revolutions ON
 Symbol Q Left needle disconnected

The arrows on the display indicate switching the functions which are displayed by symbols above the pushbuttons on.

7.2.2.1 Adjustment by means of buttons with fixed setting function

Note: It is important to finish the seam in order to reach effective button pressing (press the treadle fully backwards down).

Setting start bar:

Drive enables sewing start bar automatically. It is necessary to choose the type (single, double, off) and number of stitches which will be sewn forwards and backwards.

The arrow above its symbol shows the type of bar (chosen by gradually pressing pushbutton 1). It will be displayed following after pressing pushbutton 1.

Arv (SAv) XXX - number of stitches of start (fancy) bar forwards or

Arr (SAR) XXX - number of stitches of start (fancy) bar backwards for about 3 sec.

At this time you can change the number of stitches by gradually pressing the pushbutton + or -.

Setting end bar:

The same applies to the start bar (setting by the means of pushbutton 4).

Erv (SEv) XXX - end (fancy) bar number of stitches forwards

Err (SEr) XXX - end (fancy) bar number of stitches backwards

Note: The last section of end bar must have at least 3 stitches.

Foot position adjustment by stopping at the seam (by neutral position of treadle) and after finishing seam (by neutral position of treadle):

Setting is by means of pushbutton 6, arrow indication above the corresponding symbol.

Needle position adjustment by stopping at the seam:

Setting is by means of pushbutton 7.

Trimming switched ON/OFF:

To be set using pushbutton 5.

Sewing programme ON:

To be switched on using pushbutton 0.

Switching ON/OFF the function of the pushbutton F:

The pushbutton F on panel can have assigned one of the following functions: Sst - softstart

SrS - fancy bar

Frd - reverse angle after trimming

7.2.2.2 Setting by means of parameters

Drive memory contains the parameters which enables sewing system tuning. These parameters have exact meaning and they are divided into 3 levels. Further parameters which are available only for operation will be quoted. Each parameter has its (sequence) number and value.

General procedure by changing parameters of operation level:
 - switch the main switch on or finish the seam by pressing the treadle fully backwards down

- press pushbutton P on the panel V 820

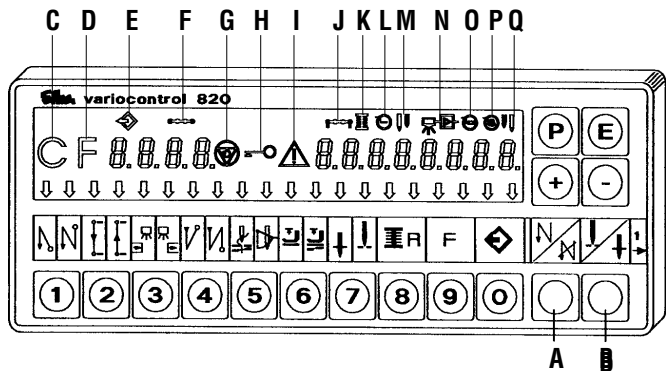
- on the display there is no data shown

- by depressing the pushbutton E several times, set the required parameter (without having displayed the parameter number)

- you can change the value using pushbuttons + or -

- by depressing the pushbutton E you will pass in the given sequence to the following parameter

- by depressing the pushbutton P down you will leave the mode of changing parameters



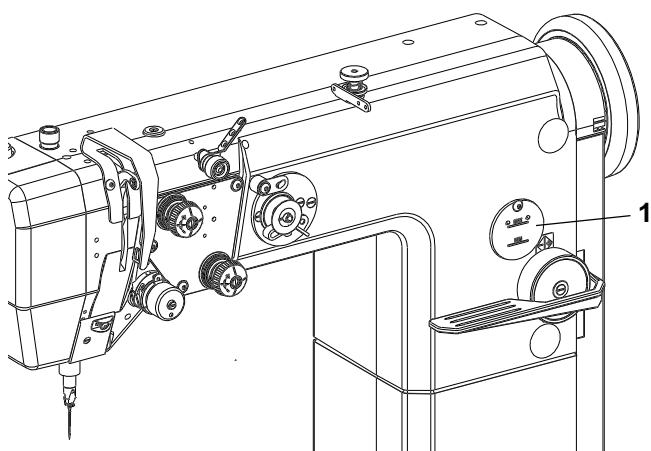
- Note:*
1. For permanent memory storing of changed parameter, it is necessary to press treadle forwards down after changing of parameters.
 2. Mode of changing parameters is possible only after finishing of the seam.

Number of stitches in bars:

Number of stitches is stored in parameter's number.

No. of parameter	Value range of parameter	Description of parameters
000(080)	0-254	Number of stitches of start (fancy) bar forwards
001(081)	0-254	Number of stitches of start (fancy) bar backwards
002(082)	0-254	Number of stitches of end (fancy) bar backwards
003(083)	0-254	Number of stitches of end (fancy) bar forwards

The drive with the panel V 820 enables sewing automatically up to 40 seams distributed up into eight programmes with the given stitch numbers and sewing direction (forwards/rearwards). For more detailed information see the original driving instructions.



8. Maintenance

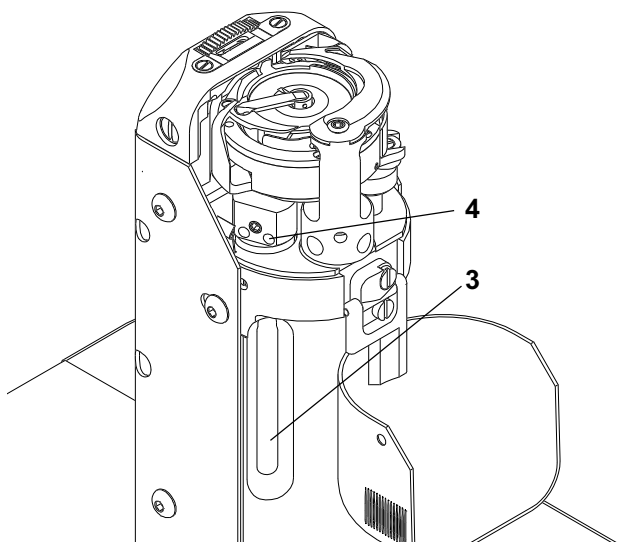
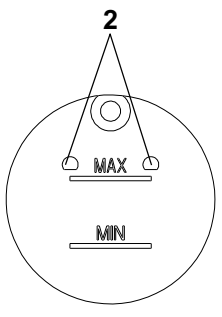


Caution! Risk of injury!

Maintenance work can only be carried out when the machine is off and the motor stops.

Maintenance work which must be carried out and the intervals between them and set out in the following table.

Maintenance work	Interval
Removing throat plate and its cleaning. Cleaning of circular feed dog, hook and space around feeding wheel of material and thread residues. To clean it, use brush. It is prohibited to use compressed air for cleaning without protective guards preventing injury of persons with flying impurities. Hook lubrication - (one drop of oil).	1 day
Checking the oil level in the hook lubrication oil tank.	1 week
Checking the oil level in the oil tank of the central distribution.	1 month



For the lubrication of this machine Esso SP-NK 10, DA 10 or an equivalent quality lubricating oil is recommended (viscosity at 40° C: 10 mm²/s; flash point: 150°C).

The oil tank (1) of the central distribution is to be filled the hole (2) up to the mark max.

The oil tank (3) of the hook lubrication is to be filled the hole (4) up to the upper edge.

Operating instructions for eventual trouble shooting

Meaning of abbreviations: NP - Instruction manual
SK - Instructions for service

Note: When the machine is driven by a stop motor, it is indispensable to check up, before starting its repair, the setting of its parameters according to NP, part B, par. 5.

Trouble	Cause	Method of troubleshooting
1. Upper thread breaking.	1.1 Incorrect threading of the upper thread.	Thread the upper thread according to NP, par. 6.1.
	1.2 Excessive thread tension.	Set the tension according to NP, par. 6.4.
	1.3 Needle incorrectly inserted or damaged.	Replace needle according to NP, par. 6.5.
	1.4 Needle thickness does not suit to that of thread or sewn material.	Use a thicker needle.
	1.5 Hook point sticks the thread.	Set distance between hook and needle according to SK, par. 3.1.3 and 3.1.5.
	1.6 Needle thread excessively elastic.	Increase the hook timing and set the needle bar height according to SK, par. 3.2.3.
	1.7 Low quality thread.	Replace thread.
	1.8 Needle thickness unsuitable for the hole in the throat plate insert.	Replace insert.
	1.9 Damaged throat plate insert.	Replace insert.
	1.10 Incorrect setting of opening bobbin case lifter (little opening).	Set according to SK, par. 3.1.6.
2. Lower thread breaking.	2.1 Incorrect threading.	Thread according to NP, par. 6.3.
	2.2 Damaged bobbin.	Replace bobbin.
3. Skipped stitches at the seam beginning after previous thread trimming.	3.1 Short thread end in needle after trimming (thread too tensioned in the moment of trimming).	Thread upper thread according to NP, par. 6.1. Reduce tension of pretension unit according to NP, par. 6.4. Accelerate slightly OFF position of main tensioner according to SK, par. 4.8; NP, part B, par. 5.2.2, 5.3.2; Mini-stop, par. 5.2.5 - parameter 192.
	3.2 Excessive thread tension.	Set thread tension according to NP, par. 6.4.
	3.3 Upper thread not squeezed, at the first needle piercing, between sewn material and rear edge of piercing hole.	Reduce height of wheel feeder according to SK, par. 3.5.3.2.1. Put nearer top roller to needle and shift it rearwards according to SK, par. 3.6.6.2. Set position of sliding throat plate insert according to NP, par. 6.10; SK, par. 3.3.3.
	3.4 Upper thread incorrectly caught by movable trimming knife. Lumps of thread remaining in hook space.	Set correctly hook opening according to SK, par. 3.1.6 and adjust setting of trimming cam according to SK, par. 4.3.

	3.5 Needle too thick with regard to thickness of thread and sewn material.	Use thinner needle.
4. Stitch skipping.	4.1 Needle incorrectly inserted.	Insert needle according to NP, par. 6.5.
	4.2 Too big distance between needle and hook point.	Set according to SK, par. 3.1.3 and 3.1.5.
	4.3 Incorrectly set needle hook timing or needle height.	Set according to SK, par. 3.1.4 and 3.2.3.
	4.4 Excessively elastic material or excessively elastic thread.	Increase timing as needed and set the needle bar height according to SK, par. 3.2.3.
	4.5 Damaged hook point.	Replace hook.
5. Incorrect stitch locking. Threads are locked on top side of sewn material.	5.1 Lower thread tension.	Set according to NP, par. 6.4.
	5.2 Incorrect threading and tension setting of upper thread.	Thread according to NP, par. 6.1 set according to NP, par. 6.4.
6. Incorrect stitch locking. Threads are locked on bottom side of sewn material and increasing of tension is of upper thread no help.	6.1 Upper thread out of tensioning dishes.	Thread correctly according to NP par. 6.1.
	6.2 Opening bobbin case lifter incorrectly set (it opens too little).	Set according to SK, par. 3.1.6.
	6.3 Wheel feeder too low - difficult passage of thread between sewn material and throat plate.	Set wheel feeder height according to SK, par. 3.5.3.2.1.
	6.4 Upper thread insufficiently tensioned when passing through hook.	Shift thread limiter to the top according to SK, par. 3.4.5 or by more than the value quoted there.
7. Stitches insufficiently tightened and with irregular positioning. Thread unravelled.	7.1 Low tension of upper and lower threads.	Set tension according to NP, par. 6.4.
	7.2 Upper thread insufficiently tensioned when passing through hook.	Shift thread limiter to the top according to SK, par. 3.4.5 or more than the value quoted there.
	7.3 Thin needle with regard to thread thickness.	Use a thicker needle.
8. Sewn material wavy in seam.	8.1 Thread tension too high for sewn material.	Reduce tension of both threads.
9. Machine does not feed or is feeding slowly or in reverse sense.	9.1 Overrun safety clutch against hook overload.	Engage correctly clutch according to NP, par. 6.11.
10. Difficult and irregular machine feed.	10.1 Wheel feeder too low (especially when sewing soft and thick materials).	Raise feeder more from throat plate according to SK, par. 3.5.3.2.1.
	10.2 Feeder teeth unsuitable (too fine) for sewn material.	Use feeder with 0.6 mm teeth pitch. Replace according to SK, par. 3.5.3.2.2.
	10.3 Wheel feeder driving chain too tensioned - blocked feeding.	Set chain tension according to SK, par. 3.5.3.2.1.
11. Hook blocked.	11.1 Incorrect lower thread threading when replacing hook bobbin - lower thread caught by hook point.	Thread lower thread according to NP, par. 6.3.

	11.2 Upper thread out of tensioning dishes and 2x caught by hook point.	Thread upper thread according to NP, par. 6.1.
	11.3 Insufficient gap between needle and piercing hole from hook side.	Set side position of the throat plate post according to SK par. 3.3.4.
12. No upper thread trimming.	12.1 Incorrectly threaded thread.	Thread the thread according to NP, par. 6.1.
	12.2 Upper thread excessively braked when moving upwards due to thin needle, thick elastic material, low feeder position, low thread tension.	Insert thicker needle according to NP, par. 6.5. Lift wheel feeder according to SK, par. 3.5.3.2.1.
	12.3 Tensioner electromagnet cuts soon main tensioner during trimming.	Delay position of cutting the main tensioner according to SK, par. 4.8 and according NP, part B, par. 5.2.2, 5.3.2; Mini-stop, par. 5.2.5 - parameter 192.
	12.4 Fixed trimming knife does not fit with all its width against movable knife.	Set knives according to SK, par. 4.6.
	12.5 Movable knife does not run over movable knife edge.	Set knife according to SK, par. 4.5.
	12.6 During trimming cycle, safety clutch against hook overload gets disengaged.	Increase clutch disengaging moment according SK, par. 3.9.2.
13. No lower thread trimming.	13.1 Incorrect movable knife path setting.	Set knife according to SK, par. 4.5.
	13.2 Incorrect cam setting.	Set cam according to SK, par. 4.3.
	13.3 Incorrect trimming knife height setting.	Set height according to SK, par. 4.5.
14. Second and third stitches incorrectly locked at the beginning of sewing after previous trimming.	14.1 Incorrect setting of lower hook thread retaining spring.	Set spring according to SK, par. 4.7.

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Part B - The instructions for assembling with standard drives

1. Safety instructions

	Caution ! Assembly of the machine must only be carried out by appropriately trained technician. Any operations to be performed on the electric installation of the sewing machine are to be done only by a competent electrician.
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2. The way of machine supply

The contents of supply will be determined in agreement between the supplier and buyer. There are following possibilities:

2.1 Complete head with accessories

In this case the supply contains:

- Complete head.
- Chosen spare parts in the bag under the presser element (see parts indicated * in catalogue of spare parts).
- Standard accessories (it contains tools-see module in catalogue of spare parts).
- Special accessories (it contains some components of a stand and upper belt cover-see module in catalogue of spare parts).

The supply like this is not complete. Buyer will provide missing components himself or he can put in an extra order to get them according to the following paragraphs.

2.2 Stand

Delivery contains components of a stand, however, without components of a stand included in special accessories supplied with machine head (see par.2.1) and without any electrical components.

If it hasn't been agreed otherwise, the stand is supplied in separate pieces. If the assembled stand is asked, special accessories are used from head supply.

Stand (ordered number S400 010000) contains following items:

MG55 000501	Stand frame
MG53 002501	Big treadle
MG53 007511	Set of parts for a stand
S615 000320	Table top

Equipment for foot lifting by treadle:

S522 000450	Small treadle
S980 060028	Foot lifting rod

2.3 Motor

The supply contains its own motor, switch - circuit breaker, all cabling (except of the plug) and material for connection. It can contain a control panel according to the type of motor. If it hasn't been agreed otherwise, it is supplied in separate pieces. A machine without trimming is equipped with clutch lever motor. However if positioning is asked or electromagnetic foot lifting or electromagnetic reverse stitching (bartacking) the machine without trimming must be equipped with stopmotor.

Motors are chosen according to the following table:

Machine subclass	Ordered number	Name	Diameter of pulley	Machine rev. max./min 50 Hz/60 Hz	Approx. specification
X11 X21	S359 600030 63	FIR 1148	63	2500/3000	asynchronous clutch motor; switch-circuit breaker with cabling; connection material
	S359 600030 50	3 x 400/230 V, 2800 RPM, 50 Hz	50	2000/2400	
	S359 600030 42		42	1600/2000	
	S359 600031 75	FIR 1147F	75	1500/1800	asynchronous clutch motor; switch-circuit breaker with cabling; connection material
	S359 600031 63	3 x 400/230 V, 1400 RPM, 50 Hz	63	1200/1500	
	S359 600031 42		42	800/1000	
X12 X22 X4X X5X	S359 600045 810	Stopmotor EFKA DC 1600/DA82GA 1 x 230 V, 50/60 Hz	58	adjustable	DC motor (AC servo) control panel V810; mains switch with cabling; connection material
	S359 600045 820		58	adjustable	DC motor (AC servo) control panel V820; mains switch with cabling; connection material
	S359 600052 63	Stopmotor EFKA *	63	2500/3000	asynchronous stopmotor with friction clutch and brake; switch-circuit breaker; connection material
	S359 600052 50	VD 552/6F82FA	50	2000/2400	
	S359 600052 42	3 x 400/230 V, 2800 RPM, 50/60 Hz	42	1600/2000	
	S359 600056 75	Stopmotor EFKA *	75	1500/1800	asynchronous stopmotor with friction clutch and brake; switch-circuit breaker; connection material
	S359 600056 63	VD 554/6F82FA	63	1200/1500	
	S359 600056 42	3 x 400/230 V, 1400 RPM, 50/60 Hz	42	800/1000	

* Control panel S359 600038/V810 or S359 600050/V820 it is possible to order for setting the stop motor, however, it is not included in supply of the stopmotor and it has to be ordered separately.



Above mentioned stop motors were tested in the machine and they meet functional requirements. Other types of stop motors can have but need not have suitable parameters. Producer does not recommend using the other stopmotor without testing.

2.4 Motor pulley

By stopmotor EFKA DC 1600/DA82GA is revolutions are set continuously by electronics.

The diameter of the motor pulley in mm must be by asynchronous motors according to the following quotation:

$$\text{Diameter of pulley} = 71 \times \frac{\text{sewing speed (st/min)}}{\text{motor revolutions (rev./min)}}$$

The smallest diameter of pulley is 42 mm considering used V-belt. Belt cover on the motor limits the biggest diameter of pulley to 127 mm.

The pulley for the maximum or other sewing speed will be supplied on express wish of the customer.

Motor pulley diameter

Sewing speed of machines: standard ¹⁾

Mains voltage frequency: 50 Hz

Model	Sewing speed (SPM)	Ordered number/motor pulley diameter ²⁾						
		EFKA DC 1600/ DA82GA 3312 4000 RPM	EFKA VD 552/ 6F82FA 2800 RPM	FIR 1148/552/3 2800 RPM	EFKA VD 554/ 6F82FA 1400 RPM	FIR 1147F/554/3 1400 RPM		
4180-1XX-100	2500	S359 600045 810/ř 58 S359 600045 820/ř 58	S359 600052 63/ř 63	S359 600030 63/ř 63	-	-		
	-200 2500							
	-300 1600						S359 600056 75/ř 75	S359 600031 75/ř 75
4180-5XX-100	2500	S359 600045 810/ř 58 S359 600045 820/ř 58	S359 600052 63/ř 63	S359 600030 63/ř 63	-	-		
	-200 2500							
	-300 1600						S359 600056 75/ř 75	S359 600031 75/ř 75
	-400 1200						-	-

¹⁾ When the customer will not order anything else, he will get a pulley for standard sewing speed. Owing to a limited assortment of pulleys, the effective sewing speed may slightly differ from that declared and quoted in the column.

²⁾ The table gives effective pulley diameter which is by 4 to 5 mm lower than the outer diameter.

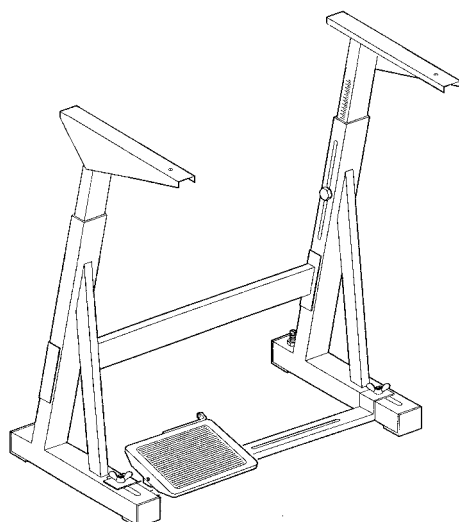
Note.: The effective diameter of the hand wheel pulley is 71 mm.

Sewing speed of machines: standard ¹⁾
Mains voltage frequency: 60 Hz

Model	Sewing speed (SPM)	Ordered number/motor pulley diameter ²⁾				
		EFKA DC 1600/ DA82GA 3312 4000 RPM	EFKA VD 552/ 6F82FA 3360 RPM	FIR 1148/552/3 3360 RPM	EFKA VD 554/ 6F82FA 1680 RPM	FIR 1147F/554/3 1680 RPM
4180-1XX-100	2500	S359 600045 810/ř 58	S359 600052 50/ř 50	S359 600030 50/ř 50	-	-
-200	2500	S359 600045 820/ř 58	-	-	S359 600056 63/ř 63	S359 600031 63/ř 63
-300	1600	-	-	-	-	-
4180-5XX-100	2500	S359 600045 810/ř 58	S359 600052 50/ř 50	S359 600030 50/ř 50	-	-
-200	2500	S359 600045 810/ř 58	S359 600052 50/ř 50	S359 600030 50/ř 50	-	-
-300	1600	S359 600045 820/ř 58	-	-	S359 600056 63/ř 63	S359 600031 63/ř 63
-400	1200	-	-	-	S359 600056 42/ř 42	S359 600031 42/ř 42

When the customer requires another ¹⁾ sewing speed than standard, he may additionally order another pulley according to the following table:

Motor	Sewing speed 50 Hz	Sewing speed 60 Hz	Diameter of pulley (mm)	Ordered number
FIR 1148/552/3 EFKA VD552	1660	1990	42	S980 045548
	1850	2220	47	S980 045377
	1970	2370	50	S980 045491
	2130	2560	54	S980 045361
	2290	2740	58	S980 045472
	2480	2980	63	S980 045378
	2640	3170	67	S980 045476
	2760	3310	70	S980 045370
	2960		75	S980 045384
	3150		80	S980 045479
	3350		85	S980 045480
FIR 1147F/554/3 EFKA VD554	830	990	42	S980 045548
	930	1110	47	S980 045377
	990	1180	50	S980 045491
	1060	1280	54	S980 045361
	1140	1370	58	S980 045472
	1240	1490	63	S980 045378
	1320	1590	67	S980 045476
	1380	1660	70	S980 045370
	1480	1770	75	S980 045384
	1580	1890	80	S980 045479
	1680	2010	85	S980 045480
	1770	2130	90	S980 045481
	1970	2370	100	S980 045483
	2090	2510	106	S980 045484
	2210	2650	112	S980 045485
2500	3010	127	S980 045337	



3. Table top

In case buyer will provide his own table top its drawing is shown in supplement.

4. Machine assembly

It is described machine assembly with stand here which is supplied in separate pieces. Otherwise use these instructions adequate.

4.1 Stand frame assembly

A frame is assembled according to the picture.

4.2 Assembly of components on the bottom of table top

- Put down antiskid (rubber) bands on the stand frame.
- Turn the table top up side down and put it down on prepared bands.
- By means of screws screw the drawer (1) down.
- Nail down the rubber stop (2).
- By means of screws fasten transformer for lighting (3) if available.
- By means of screws fastened transformer for trimming (4) if available.
- By means of screws fasten switch – circuit breaker (5).
- Screw the motor holder down (6) (possibly motor). Lever clutch motor is assembled into the holes (A). Stopmotor into holes (B).
- By means of clips (7) install transmission line of heavy current conductors. Connection is different from the type of motor, supply voltage and number of conductors of electric supply. In case of quad (four wire) supply 3 x 400 V, transformer for lighting must be supplied with separate supply cable 1 x 230 V.



Caution!

The voltage in the mains must be in conformity with the voltage indicated on the drive plate.

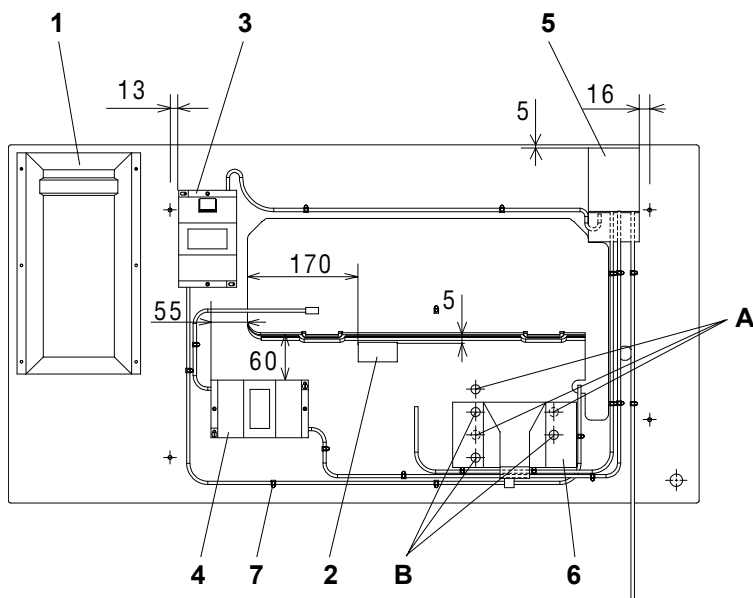


Caution!

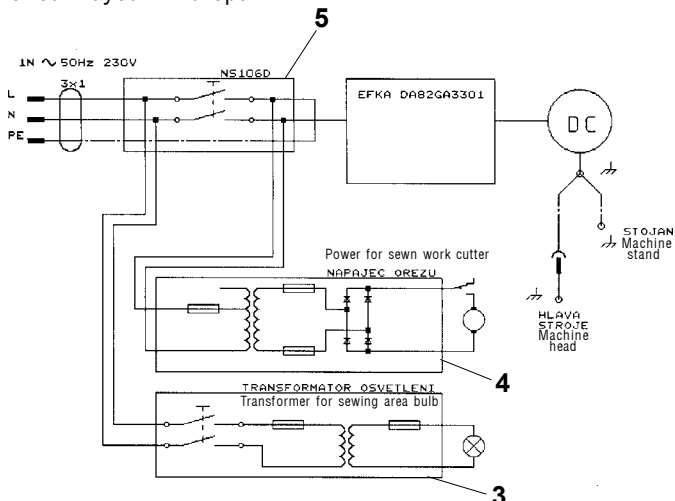
The transformer of the bulb for the sewing area is not switched off by the main switch (EN 60204-3-1). Before proceeding to any repair operation in the transformer box (such as a fuse exchange) the plug categorically must be taken out of the socket. Such operations may be carried out only by persons with adequate electrotechnical skill.

Choose the suitable variant according to the pictures:

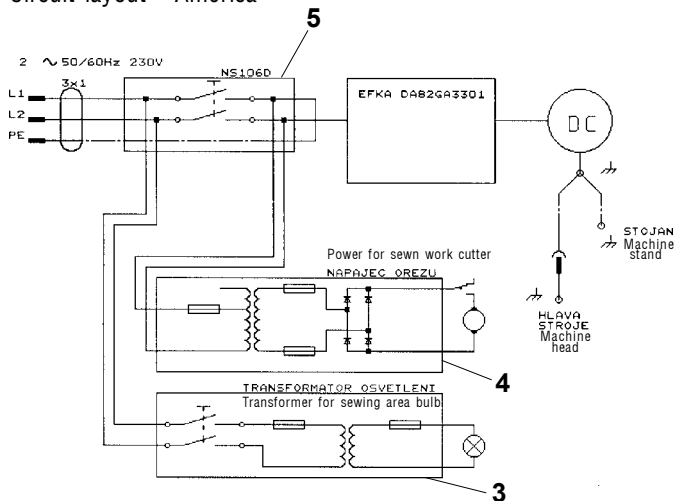
4.2.1 Power supply 1 x 230 V - DC motor



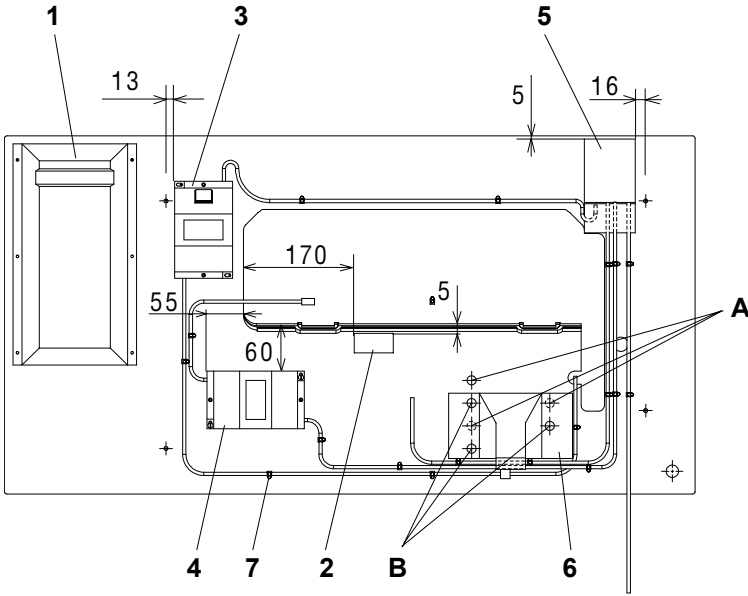
Circuit layout - Europe



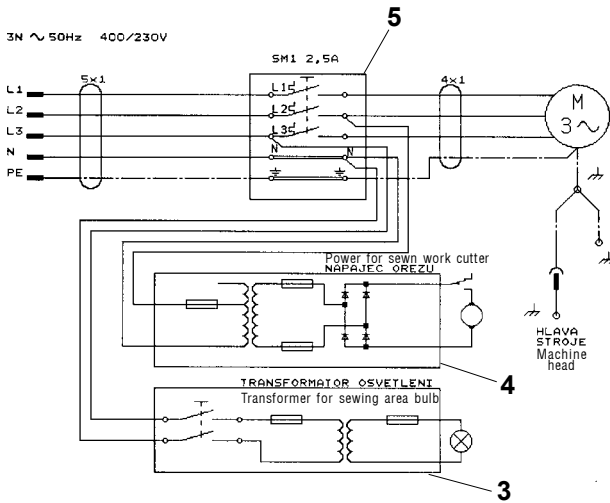
Circuit layout - America



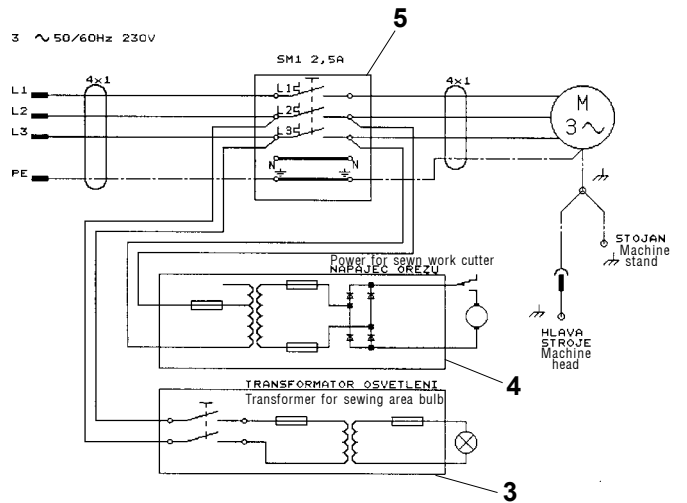
4.2.2 Power supply 3 x 400 V - five wire power distribution, power supply 3 x 230 V - four wire or five wire power distribution



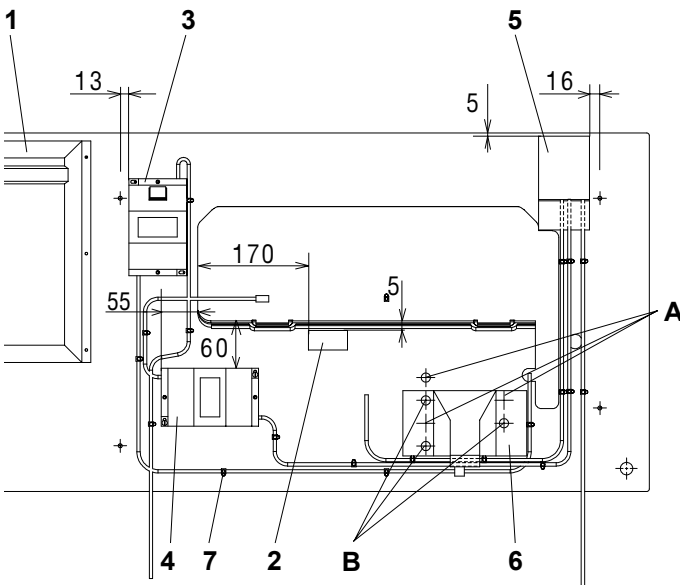
Circuit layout - Europe



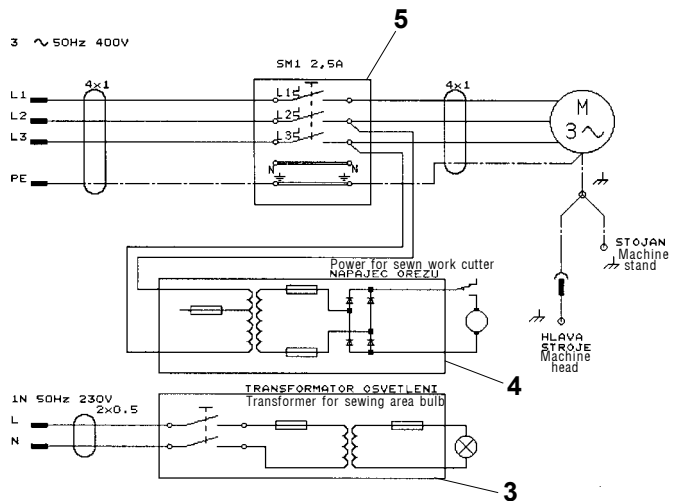
Circuit layout - America

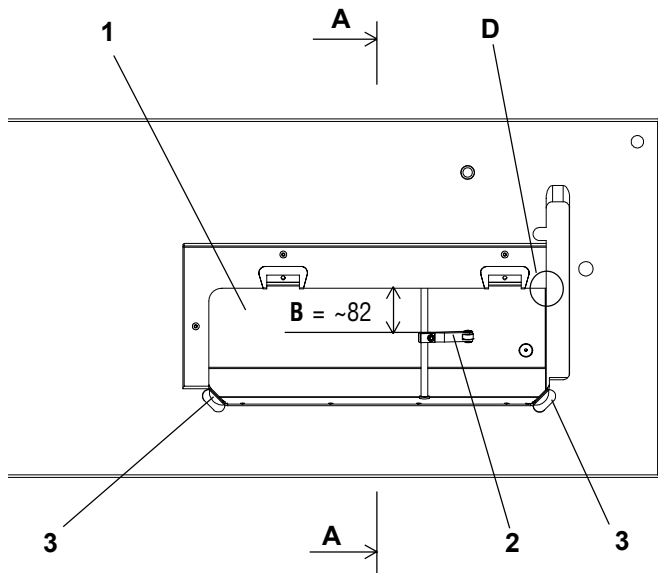


4.2.3 Power supply 3 x 400 V - four wire power distribution plus 1 x 230 V - two wire cable

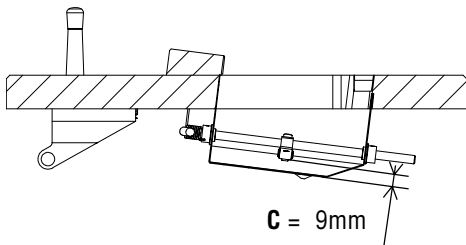


Circuit layout

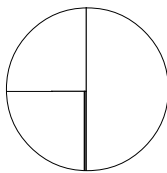




A - A

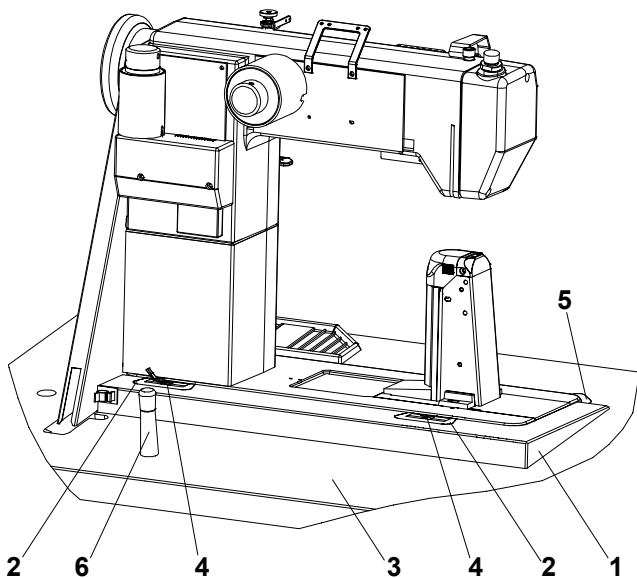


D



4.3 Assembly of a table top on a stand frame, assembly of oil tank

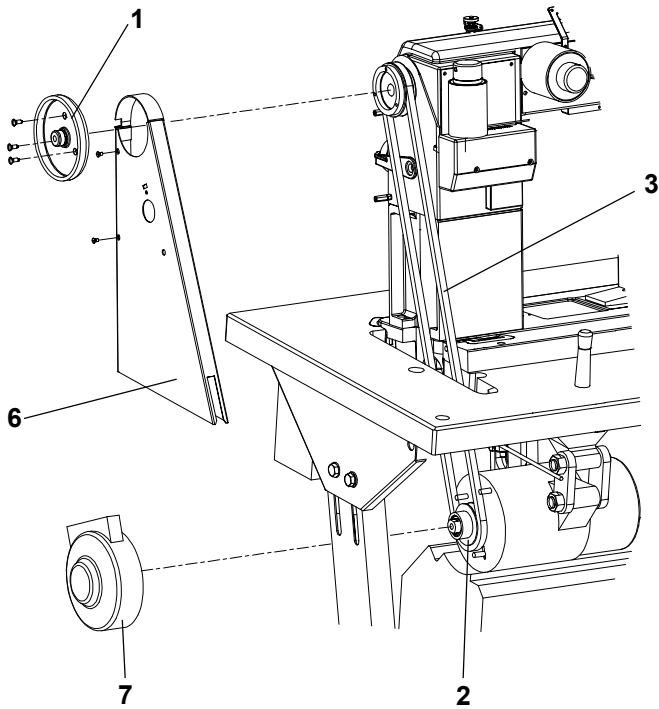
- Turn the table top around and screw it down to the frame by means of screw ř 8 x 35 mm.
- When applying a frame different from that recommended by the producer, be sure to adapt its position so as to ensure the stability of the machine head in its tilted state.
- Oil tank (1) with assembled lever (2) insert through the bottom part into the cut hole in the table top and put down as shown in detail (D) in that way, that the edge of the tank would fit in with the edge of the cut hole in the table top. Set the height of the tank according to the section A-A. Tank may not protrude out of upper surface of a table top. Nail down the tank with nails ř 2 x 40 mm.
- Adjust the lever (2) to the dimensions "B" and "C".
- Insert rubber inlays (3) into the groove in a table top.



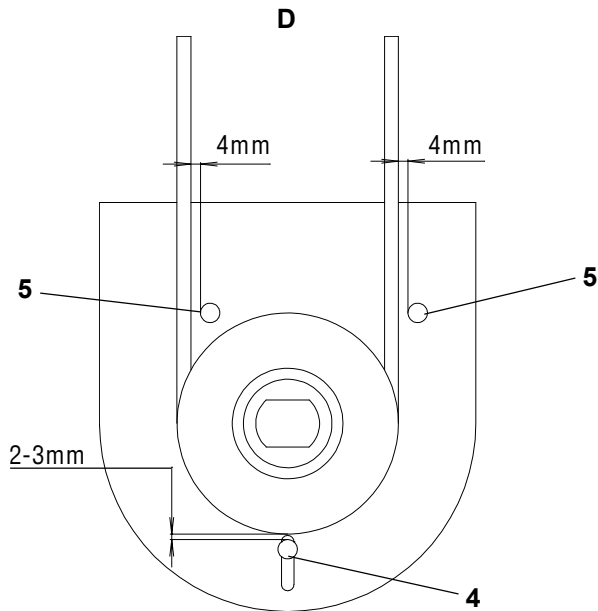
4.4 Assembly of machine head onto a stand

- Stick down rubber inlays (2) with glue into the groove in a wedge (1) and put the wedge down on the table top (3).
- Disassemble transported tank (cover) from the machine head and assemble hangers (4) on the head.
- Put the head down into the rubber inlays (2) and (5).
- Define space along circumference of basic machine plate. 2 mm forwards, 1 mm backwards (head will later move forward because of its own weight), along sides 1,5 mm up to 2 mm.
- Conforming with holes in a wedge (1) and in hangers (4) drill holes through the table top ř 3,5 in length approx. 30 mm in the table top.
- Screw the wedge down to the table top with screws ř5 x 30 mm.
- Screw the hangers down to the table top with screws ř5 x 40 mm. Tighten the screws so that oscillating of the head on rubber inlays would not be reduced.
- Insert supporting pin (6).

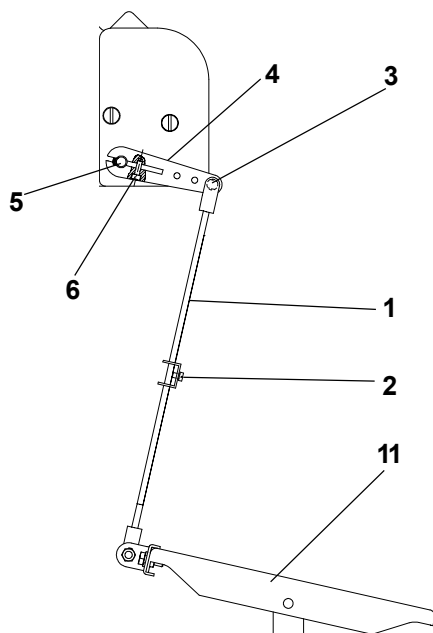
4.5 Assembly of motor pulley, belt, belt covers, hand wheel



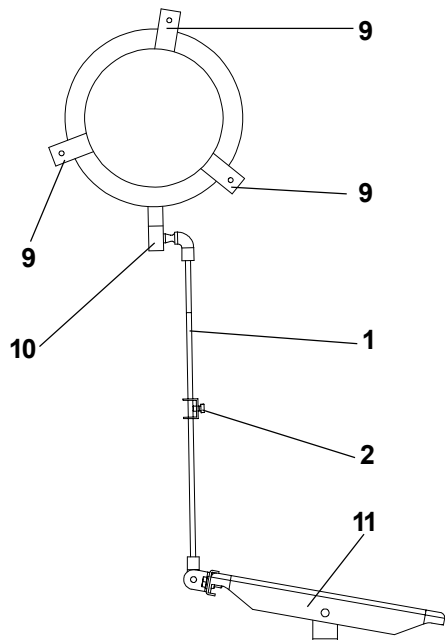
- Disassemble hand wheel (1).
- Assemble motor pulley (2).
- Insert V-belt (3) and tighten it by leaning out of the motor. V-belt is tightened correctly when the opposite sides of belt are approaching to each other in distance of about 20 mm with power 10 having an effect in the middle of both sides. Stop motor should be leveled so that the bottom surface of its control panel would be horizontal.
- Adjust the stop (4) by bigger pulleys against falling the belt out of the pulley so that the distance from the belt will be 2-3 mm. Adjust pins by smaller pulleys (5) according to the detail (D).
- Assemble the bottom cover belt (7) on to the motor.
- Assemble upper cover belt (6) and hand wheel (1) by clutch lever motor.
- Assemble upper cover belt (6), hand wheel (1) and position reader by stop motor but only after electrical connection of the head to the stopmotor (see par. 4.7).



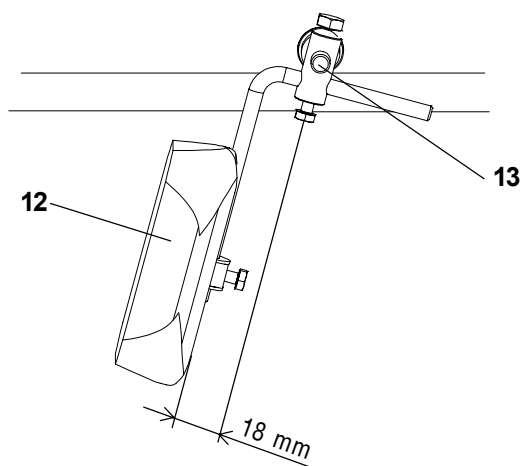
4.6 Assembly of treadle rod, setting rod and of position reader, knee lever



- Insert treadle rod (1) on pins.
- Adjust approx. length of rod by means of screw (2). If the ends of rod are too long, shorten them.
- Install the pin into the hole (3) by stopmotor EFKA. Adjust the lever (4) so that it would be approx. square angle at a rod (1) - take off the ring (5), loosen the screw (6), take of the lever (4) and assemble it into desirable position.



- Loosen the screws (9) by clutch lever motor and turn the motor with lever in such a way that the lever (10) would be in direction of the rod axis (1).
- Adjust angular turning of treadle (11). The position of treadle is correctly adjusted if there is a square angle at the shin-bone of the operator to the treadle.



- Fasten knee lever (12) onto the shaft (13) and adjust it in a position that it is shown in the picture (slightly leant out).

4.7 Electrical connection of machine head to the stopmotor

4.7.1 Connecting cable

Together with the machine head there is supplied a connecting cable for the following drives:

EFKA DC 1600/DA82GA 3311 and higher

EFKA VD 552/6F82FA 2315 and higher

EFKA VD 554/6F82FA

When there is no drive specified, a cable without any connecting power plug is supplied (mind the caution 2.3).

For the information sake, there are given the respective circuit layout.

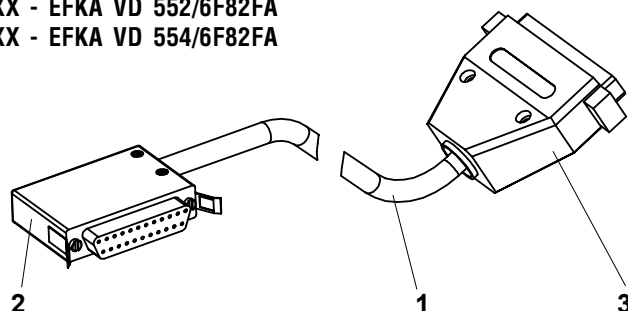
The colours are indicated with numbers in brackets (6 – green, 7 – blue, 8 – pink, 9 – black, 10 – white, 11 – violet, 12 – yellow, 13 – red, 14 – grey, 15 – brown). Included insulating covers PVC (5) are put on the bunches and they are put together with remaining part of cable insulation by means of contracted tube (4) (it is heated up with fire of lighter).

Power connecting cable is marked off with dotted line in circuit layout.

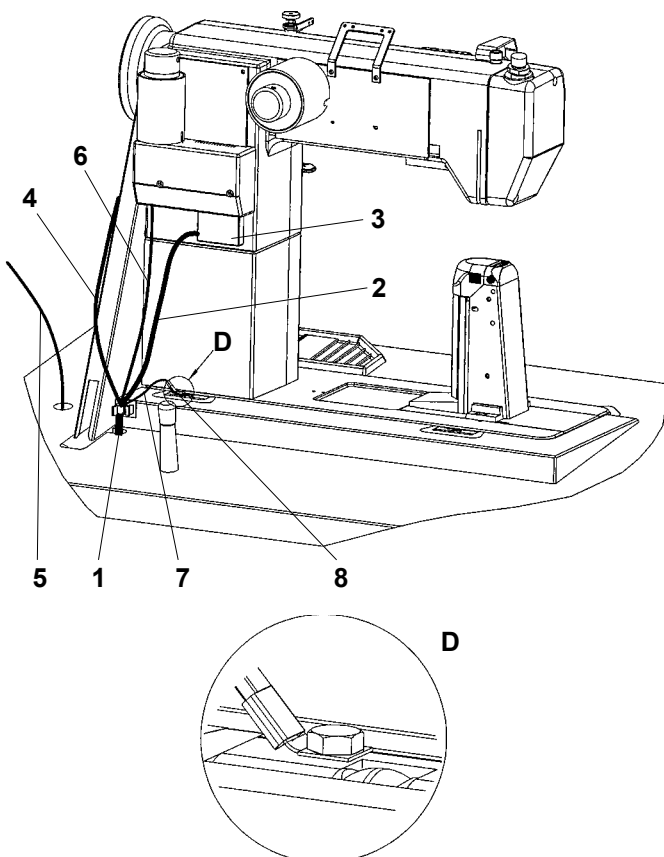
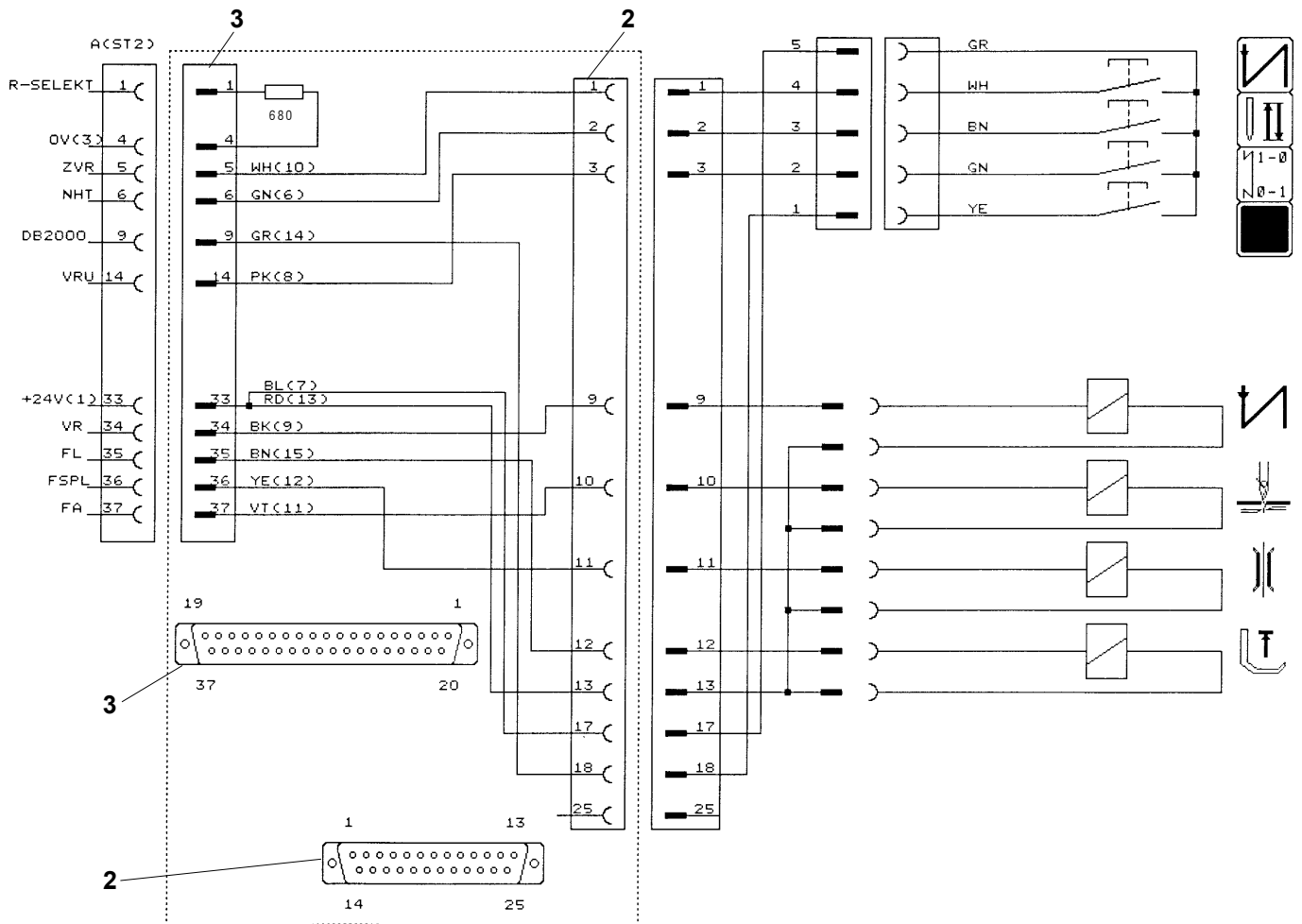
Stopmotor S359 600045 XXX - EFKA DC 1600/DA82GA

Stopmotor S359 600052 XX - EFKA VD 552/6F82FA

Stopmotor S359 600056 XX - EFKA VD 554/6F82FA

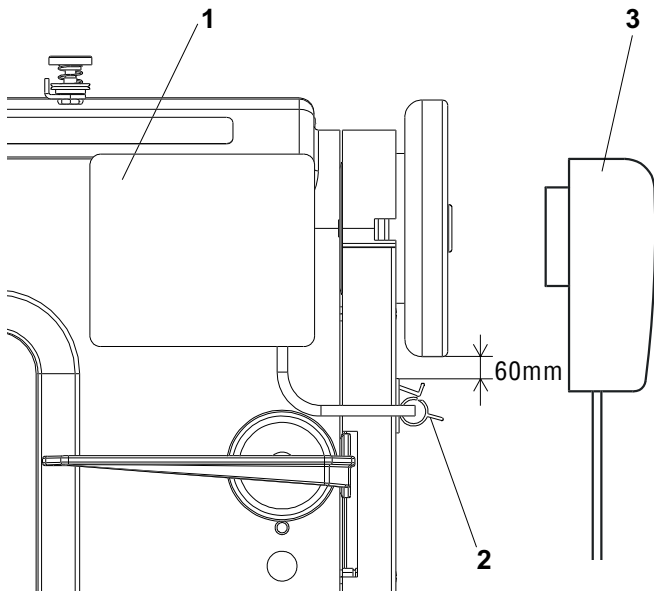


Circuit layout



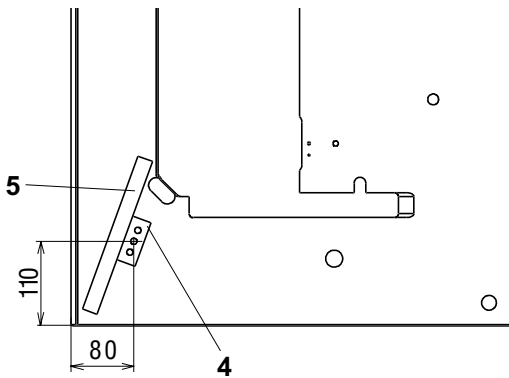
4.7.2 The actual electrical connection

- Stick the clip (1) on wedge (defeat the contact surface!).
- Install the power supply cable (2) so that connector (3) is in the direction of a head. The other connector (connectors) is (are) connected into terminal box rack of the stop motor according to the pictographs that are situated on it.
- Install the cable of control panel (4) and connect it to the terminal box of stop the motor according to the pictographs.
- Pass the cable of position reader through (5) and connect it to the terminal box of the stopmotor according to the pictographs.
- Install lighting if available and connect its cable (6) to the cable of transformer.
- Install the earthing cable (7) one end to the hanger (8) and second end to the holder of stopmotor.

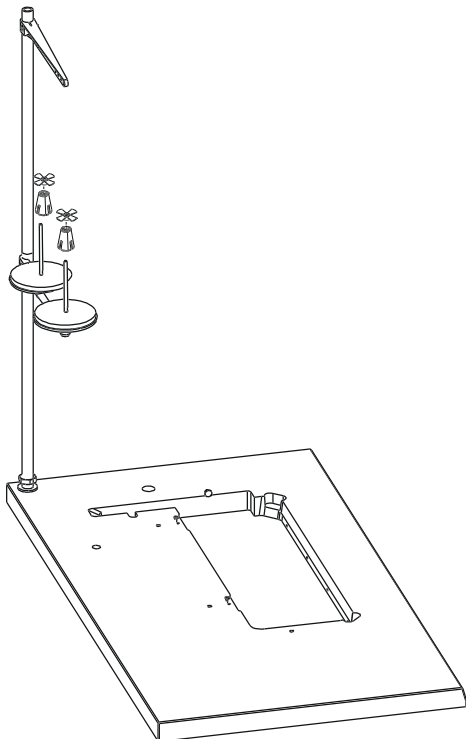


4.7.3 Fastening upper cover belt, position reader, control panel of stopmotor and thread stand

- Screw the stop to the belt guard.
- Assemble upper cover belt and hand wheel according to par.4.5.
- Set the position reader (3) on the handwheel pin so as to match the stop groove of the position reader with the stop (thus immobilizing the position reader).
- Fix the position reader by retightening the two hexagonal screws.
- Fix the control panel of stopmotor:
- Stick the panel V 810 (1) by stopmotor EFKA on the machine head (if any). Defat the contact surface properly. Stick the clip (2) on the cover belt.



- With the Efka stopmotor, mount the holder (4) on the panel V820 (5) (if any) using screw and screw on the holder with the panel to the stand table.



- Assemble the thread stand so that its arms would be parallel to the longer edge of a table top.

5. Basic setting of stopmotor and position reader

5.1 Generally

The procedure of setting parameters of the stopmotor S359 600045 XXX - EFKA DC 1600/DA82GA on the level of the operator is described in the first part of the Instruction manual - par. 7.2.1.2 (V810); par. 7.2.2.2 (V820).

A correct function of the sewing machine with drive is attained when changing some parameters of the drive, which are inaccessible for the attendance of the machine. Hereinafter there is a description of the possible procedures of changing all parameters.

Procedure of changing parameters of the drive Efka S359 600045 810 - DC 1600/DA82GA; S359 600052 XX - VD 552/6F82FA and S359 600056 XX - VD 554/6F82FA (panel V 810)

- depress the pushbutton **P** on panel and switch on thereafter the main switch
- on the display there will appear **C 0000**, the 1st digit flashes
- using pushbutton **+** - set the 1st digit on the value **3**
- depress the pushbutton **>>**, the 2nd digit flashes
- in the same way set the remaining digits in the way to get displayed on the display **C 3112** (the number of the code for the possibility of changing all parameters of the drive)
- depress the pushbutton **E**, on the display will appear **F 200** (parameter number **200**)
- using pushbuttons **>>**, **+**, **-** set the required parameter number and depress the button **E**
- using pushbuttons **+**, **-** set the required parameter value
- depress the pushbutton **E** (a parameter number following in the sequence will appear) or **P** (the same parameter number will appear)
- carry out the termination of changes in depressing the pushbutton **P** (return to the respective sewing mode)

You will find a detailed information in the original directions for use of the drive.

Note: To get the change of parameters permanently stored, it is necessary, after having changed the parameter, to depress the pedal in forward direction.

Procedure of changing parameters of the drive Efka S359 600045 820 - DC 1600/DA82GA; S359 600052 XX - VD 552/6F82FA and S359 600056 XX - VD 554/6F82FA (panel V 820)

- depress the pushbutton **P** on panel and switch on thereafter the main switch
- on the display there will appear **C 0000**, the 1st digit flashes
- using pushbutton **0 ÷ 9** set **C 3112** on the display (code number for possible changing of all drive parameters)
- depress the pushbutton **E**, on the display will appear **F 200** (parameter number **200**)
- using pushbutton **0 ÷ 9**, set the required parameter number and depress the pushbutton **E**
- using pushbutton **+**, **-**, set the required parameter value
- depress the pushbutton **E** (there will appear further parameter number in the given sequence) or **P** (return to the given sewing mode)
- the termination of changes is to be done in depressing the pushbutton **P** (return to the sewing mode)

A detailed information is in the original directions for use of the drive.

Note.: To get the change of parameters permanently stored, it is necessary, after having changed the parameter, to depress the pedal in forward direction.

5.2 Stopmotor setting S359 600045 XXX - EFKA DC 1600/DA 82 GA 3312

5.2.1 Setting position reader

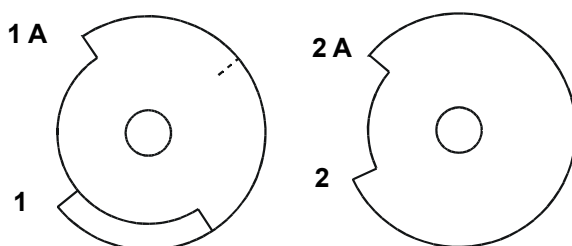
- set parameter **170**, **Sr1** is shown on the display (reference position)
- depress pushbutton **>>**, **PoS 0** appears on the display and changing symbol of rotation
- turn the hand wheel until symbol of rotation disappears
- turn the hand wheel to angular value **105°** of hand wheel (thread tip is approx. in the level of throat plate)
- depress pushbutton **E**, changeover to parameter **171**
- set parameter **171**, **Sr2** is shown on the display (all positions)
- depress pushbutton **>>**
- **1 XXX** is shown on the display (value of first position of needle)
- turn the hand wheel until value **XXX** begins changing
- turn the hand wheel to the angular value of first position (**135°** on the hand wheel respective **30** on the panel)
- depress pushbutton **E**
- **2 XXX** is shown on the display (value of upper position of take-up lever)
- turn the hand wheel until value **XXX** begins changing
- turn the hand wheel to the angular value of upper position (**65°** on the hand wheel respective **450** on the panel)
- depress pushbutton **P 2x** (return to the sewing mode)
- step shortly treadle down forwards (entry to the memory)

5.2.2 Changes of setting parameters of stopmotor setting considering original producer setting

Parameter No	Parameter value	
111	-	Max. revolutions (according to a type of machine)
116	180	Trimming revolutions
170	-	Reference position
171	30	First position of needle
192	340	Delay angle of tensioner switch on
202	120	Delay of start run after switch off the signal foot
225	3	Type of the machine

5.3 Setting stopmotor S359 600052 XX-EFKA VD 552/6F82FA and S359 600056 XX-EFKA VD 554/6F82FA

5.3.1 Setting position reader



Positions are set by means of discs with cut outs directly in position reader.

Setting bottom position:

- Disassemble the cover of position reader
- Disconnect head power supply cable from drive
- Switch on the power supply switch
- Step treadle shortly down forwards (machine stops in first position of needle)
- Switch off the power supply switch
- Turn the beginning of cut out **1** of coinciding discs so that machine would stop at the value **135°** of the hand wheel
- Carry out check by repeating procedure

Setting upper position of thread lever:

- Step treadle down backwards (machine stops in upper position of needle)
- Switch off the power supply switch
- Turn the beginning of cut out **2** of separate disc so that machine would stop at the value **65°** of the hand wheel
- Carry out check by repeating procedure

5.3.2 Changes in parameters of stopmotor setting considering original producer setting

Parameter No	Parameter value	
111		Max. revolutions (according to a type of machine)
116	180	Trimming revolutions
136	ON	Stitch by thread trimmer (back)
192	86	Delay angle of tensioner switch on
202	120	Delay of start run after switch off the signal foot

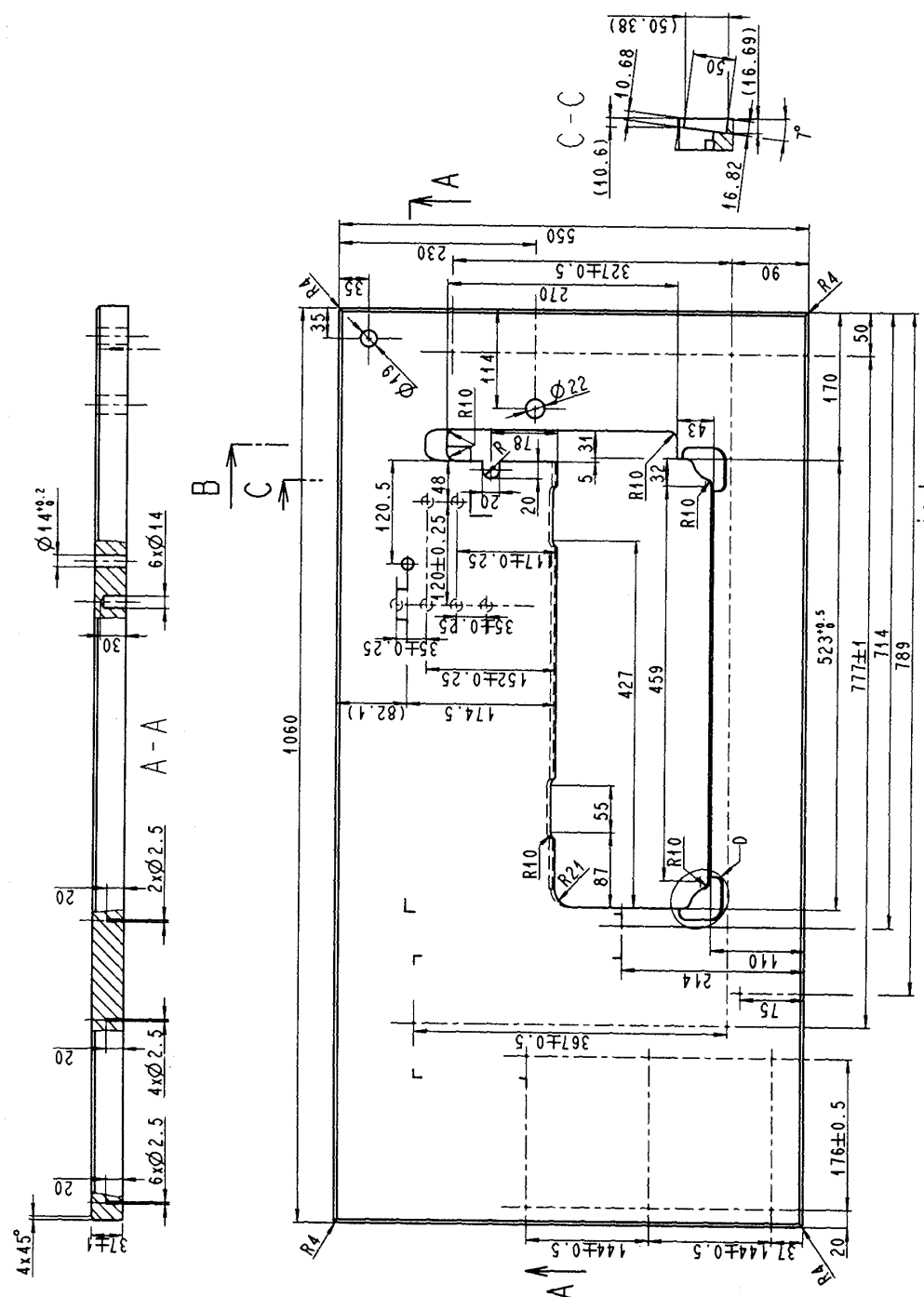
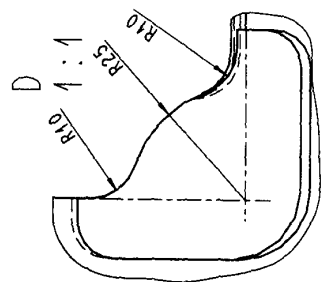
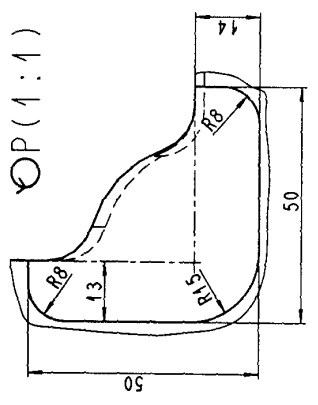
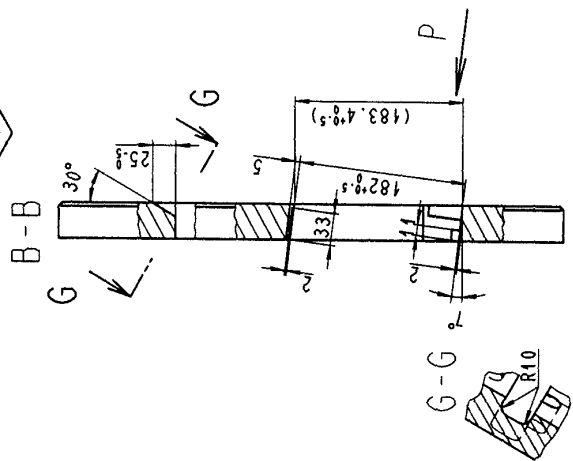
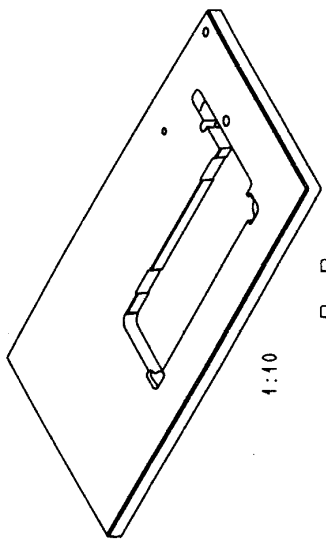
6. Examination of sewing



Caution! Risk of injury!

Before threading a thread switch the main switch off and wait until the motor stops.

- Check the sense of turning the hand wheel – according to the arrow situated on it.
- Thread a thread.
- Choose sewing material.
- Switch the desirable function on the control panel of stopmotor. Examination should be carried out with selection of fancy bar.
- First sew slowly then speed up the sewing.
- If the stitch does not meet requirements, follow the first part of instructions manual or service book.



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1. General safety instructions

The non-observance of the following safety instructions can cause bodily injuries or damages to the machine.

1. The machine must only be commissioned in full knowledge of the instruction book and operated by persons with appropriate training.
2. Before putting into service also read the safety rules and instructions of the motor supplier.
3. The machine must be used only for the purpose intended. Use of the machine without the safety devices is not permitted. Observe all the relevant safety regulations.
4. When gauge parts are exchanged (e.g. needle, top roller, needle plate, feed dog and bobbin) when treading, when the workplace is left, and during service work, the machine must be disconnected from the mains by switching off the master switch or disconnecting the mains plug.
5. Daily servicing work must be carried out only by appropriately trained persons.
6. Repairs, conversion and special maintenance work must only be carried out by technicians or persons with appropriate training.
7. For service or repair work on pneumatic systems the machine must be disconnected from the compressed air supply system. Exceptions to this are only adjustments and function checks made by appropriately trained technicians.
8. Work on the electrical equipment must be carried out only by electricians or appropriately trained persons.
9. Work on parts and systems under electric current is not permitted, except as specified in regulations DIN VDE 0105.
10. Conversions or changes to the machine must be authorized by us and made only in adherence to all safety regulations.
11. For repairs, only replacement parts approved by us must be used.
12. Commissioning of the sewing head is prohibited until such time as the entire sewing unit is found to comply with EC directives.



It is absolutely necessary to respect the safety instructions marked by these signs.
Danger of bodily injuries !
Please note also the general safety instructions.

IMPORTANT WARNING

In spite of all safety measures made on the machines, inappropriate actions of the operator may lead to dangerous situations. In industrial sewing machines, attention should be paid to the following still remaining possible sources of injury:

1. Moving sewing needle
 - risk of injury when sewing with raised pressure foot or top roller, because the finger guard is then positioned too high,
 - risk of injury when inadvertently threading down of the motor treadle.
2. Moving thread take-up lever
 - risk of injury when inadvertently or intentionally inserting the finger(s) between the thread take-up lever and its guard.
3. Moving pressure member
 - risk of injury when holding sewn work in immediate vicinity of the pressure member and beginning to insert under the pressure member a considerably thicker sewn work portion,
 - risk of injury when sinking the pressure member.
4. When switched off, the clutch motor slows down by inertia but would be reactivated by an accidental treading down of the motor treadle. To avoid such risk, it is advised to hold the handwheel by hand and slightly to depress the motor treadle.

2. Introduction

This service book contains instruction for regulating the mechanisms of the sewing machine head.

The instructions for use and for putting the machine into operation and for the control of the stopmotor are not included in this service book, but they are supplied as separate publications.

This service book is universal for all subclasses of the machine - it contains setting procedures for all elements which may be placed on the machine of the given class. When the supplied subclass of this machine does not include some element, then it is possible to leave out the respective parts of the instructions. The optional equipments of the machine and the respective configurations of the subclasses of the machine are given in the operating instructions.

This sewing machine disposes of a large extent of its use. The machine should be set with respect to the parameters of the sewn material, the sewing thread etc. The setting for the individual categories is given in the chapter 11.2.

For setting the machine, simple setting aids are used which are included in the accessory of the machine. Besides these aids, universal measuring devices are used, such as slide calliper, feeler gauges and dynamometer for measuring the thread tension.

3. Head of the sewing machine

3.1 Hook and the hook post

3.1.1 Description

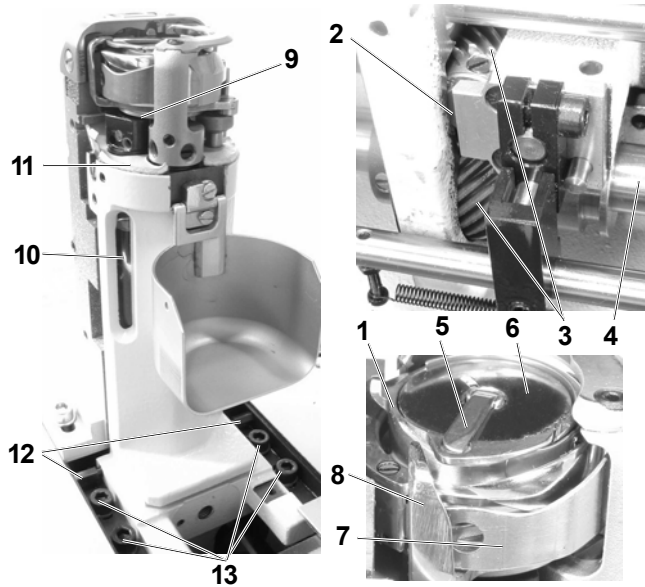
The hook (1) is mounted on the shaft (2) and is driven by the gear (3) from the shaft (4).

The shaft of the hook (2) is slidably mounted on the top, in post and, on the bottom, in a needle bearing.

The hook is provided with a lever (5) which is tilted when removing the bobbin (6). The protecting sheet (7) protects against the collision of the needle with the hook point. The bobbin case opener (8) is driven by the eccentric (9) on the shaft (2).

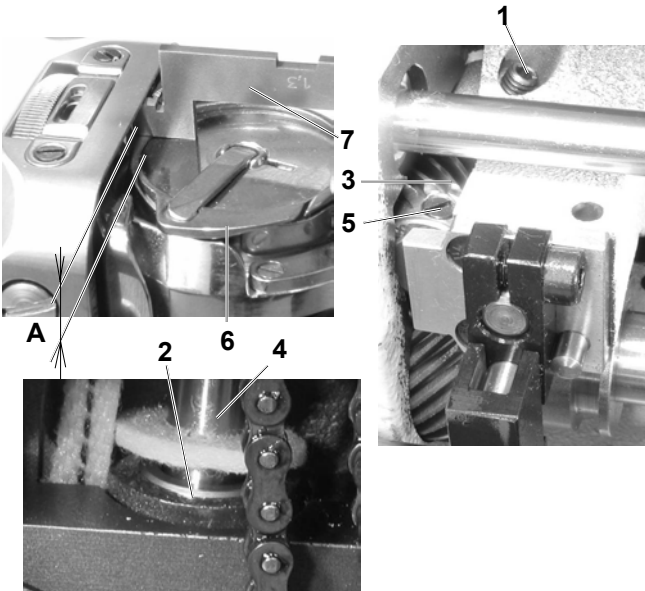
The oil tank (10) contains oil supply for the hook lubrication. Superfluous oil is taken by the felt piece (11) used to lubricate sliding mounting hook shafts. The wick connected to the felt piece (11) lubricates the gearing (3).

The screws (12) serve for taking up the clearance of the gear. The screws (13) fasten the post to the bedplate.



3.1.2 Height setting of the hook

The designated distance „A“ should be 5.3 mm.



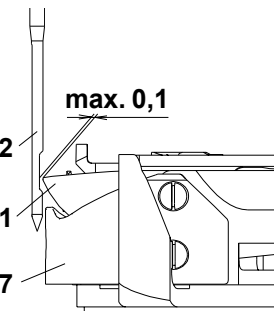
Caution! Danger of injury!

Switch off the main switch ! Before starting the setting operation, wait until the motor stops!

- Loosen both screws (1).
- By axial shifting of the bushing (2) set the axial clearance of the wheel (3) to the least value still ensuring easy rotation of the shaft (4) with the fixed wheel (3).
- Tighten both screws (1).
- Loosen both screws (5).
- Shift axially the shaft (4) with the hook (6) so as to obtain the required distance „A“. For setting up use the setting gauge (7) as per the respective figure.
- Carefully retighten the screws (5) after the adjustment. Caution! One of these screws must bear on the flat of the shaft (4).

3.1.3 Setting the distance of the hook from the needle

The hook point (1) is set up to the maximum distance of 0.1 mm from the bottom of the needle recess (2). For the sewing categories 1 and 2, the needle size 100 is set, for the sewing categories 3 and 4, it is the needle size 160.



Caution! Danger of injury!

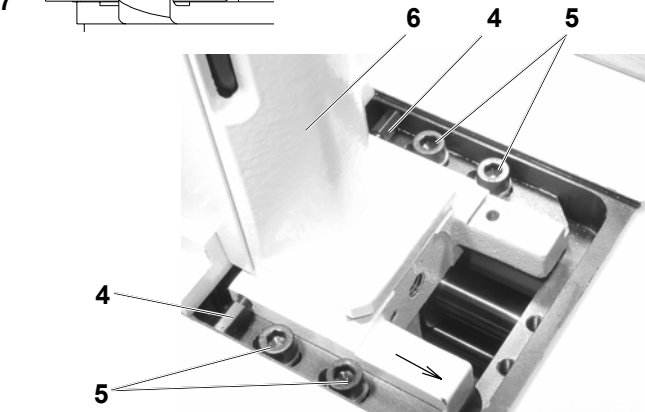
Switch off the main switch ! Before starting the setting operation, wait until the motor stops!

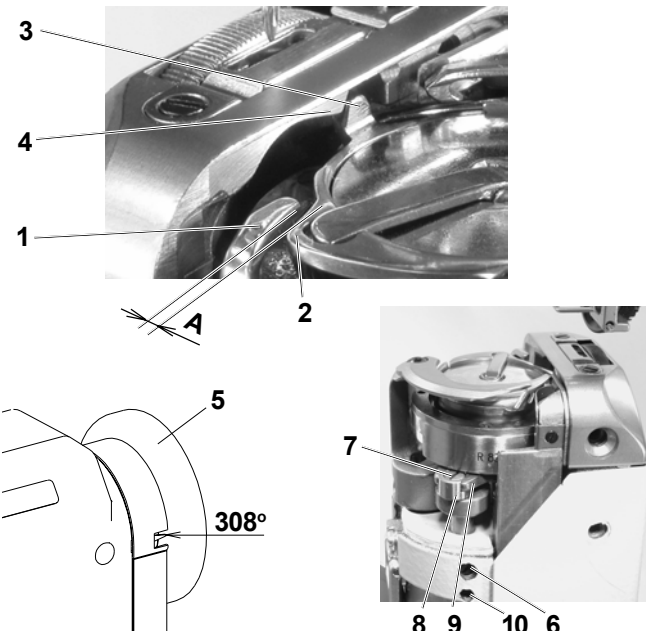
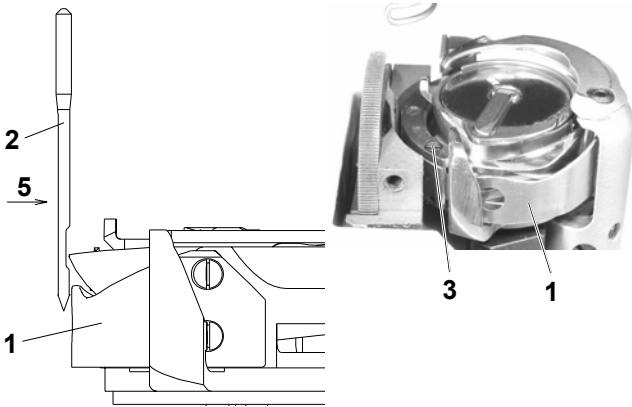
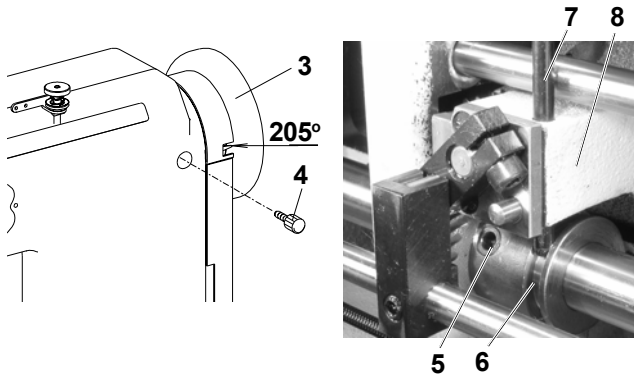
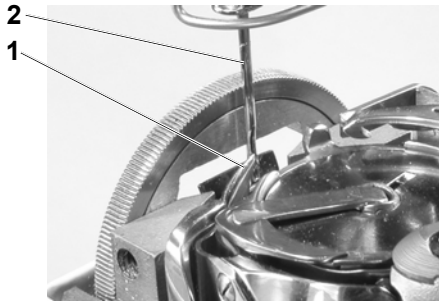
- Loosen only one screw (4).
- Loosen the screws (5) and tighten them only slightly.
- Shift the hook post (6) at the determined distance between the needle and the hook point.
- Tighten carefully the screw (4) (be sure not to damage the threads!)
- Tighten duly the screws (5).
- Check up the setting using a narrow strip of thin paper and proceed to the eventual correction of setting.



Caution!

When changing substantially the sewing category, the protecting sheet of the hook (7) should be set up.





3.1.4 Angular setting of the hook (timing)

The hook is to be angularly set in such a way that the hook point (1) is opposite the needle at the moment, when the needle shifts by 2.5 mm from its bottom dead center. This corresponds to the 205° on the scale of the handwheel (3).



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the throat plate.
- Turn the handwheel (3) to the 205° and fix it with the screw (4) which is component part of the accessory of the machine (tighten it carefully).
- Loosen the screws (5).
- Turn the hook into the required position.
- Pass the locating pin (7) contained in the machine accessories through the hole in the hook post bed (8) and insert it into the groove of the gear wheel (6). In this way, the wheel is axially set.
- Tighten to the maximum the screws (5) and take the locating pin (7) out.

3.1.5 Protection of the needle and of the hook point

The protecting sheet (1) is to be set up in such a way that the clearance between the protecting sheet and the needle (2) is the least possible.



Caution ! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the throat plate and the movable trimming knife.
- Unscrew the screw (3).
- Put the screwdriver into the hole of the screw (3) and, using the regulating screw, set up the required clearance between the needle (2) and the protecting sheet (1). When turning to the right, the protecting sheet shifts out from the groove and inversely.
- Check up the protecting effect in pushing against the needle in the sense of the arrow (5). The hook point must not catch the needle. If so, set up the protecting effect, correct eventually the setting of the distance of the hook point from the needle according to the paragraph 3.1.3.
- Screw in the screw (3).

3.1.6 Setting of the bobbin case opener

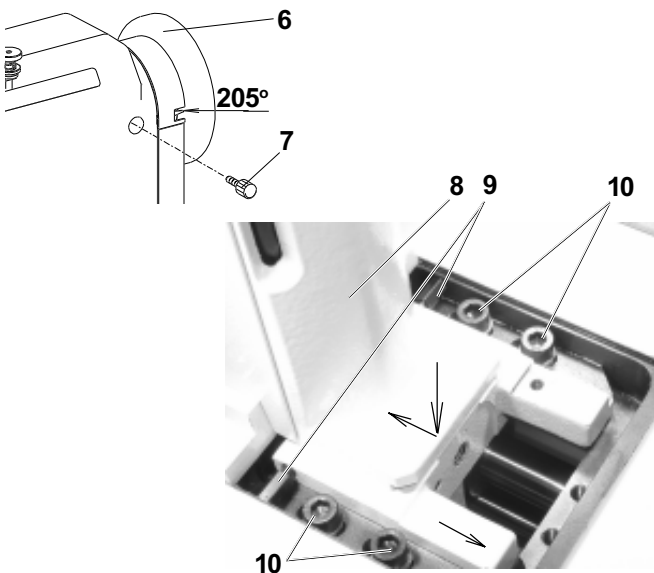
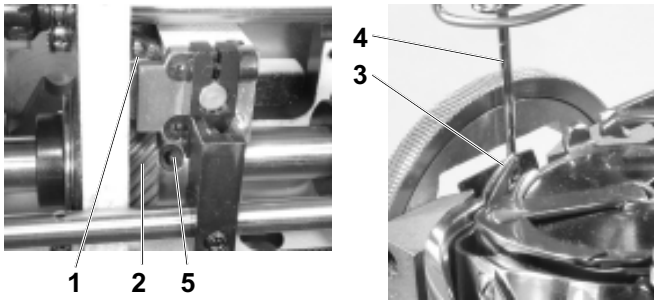
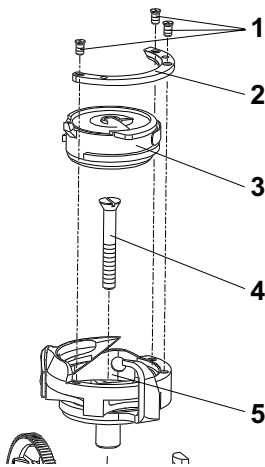
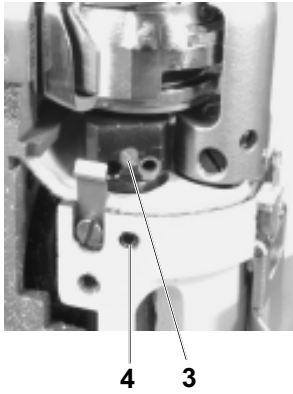
The bobbin case opener (1) is to be set in such a way that, at the moment when the opener is in its dead centre, there would be a clearance „A“ between the opener (1) and the projection (2), whereas the finger (3) bears on the projection (4), „A“ = 0.7 mm for the sewing category 1 and 2, „A“ = 0.3 mm for the sewing category 3 and 4.



Caution ! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- On the handwheel (5), set the angle of 308° (the hook is in its dead centre).
- Loosen the screw (6).
- Turn the eccentric (7) in such a way that the required clearance between the elements (1) and (2) is attained.
- By turning the screw (10), set the height of the eccentric (7) in such a way that it is in its highest position in retaining the minimum clearance between the slide (8) and the fork (9).
- Tighten duly the screw (6).



3.1.7 Setting the regulation of the hook lubrication

Oil is wiped from the lubrication wick by the surface of the hook eccentric and is then supplied by centrifugal force into the hook path (7). The intensity of oil supply is regulated by turning the screw (3).



Caution! Danger of injury!

Switch off the main switch ! Before starting the setting operation, wait until the motor stops!

- To reduce the oil supply, turn the screw (3) to the right.
- To increase the oil supply, turn the screw (3) to the left.
- After the adjustment, loosen the screw (4) and set the height of the oil tank so as to ensure reliable contact between the surface of the eccentric and the lubrication wick.



Caution!

The quantity of the fed oil has been set up in the manufacturing factory. This setting is to be done only in emergency events. A bad setting of the quantity of the fed oil or of the height of the lubricating tube may cause a rapid wear or a seizure of the hook.

3.1.8 Replacement of the hook



Caution! Danger of injury!

Switch off the main switch ! Before starting the setting operation, wait until the motor stops!

- Remove the throat plate and the trimming knife together with its holder.
- Unscrew the screws (1) and remove the splice (2).
- After having suitably turned a bit the hook, remove the bobbin case (3).
- Unscrew thoroughly the screw (4).
- Remove the body of the hook (5) upwards.
- When mounting, the procedure is inverse.

3.1.9 Setting the gear

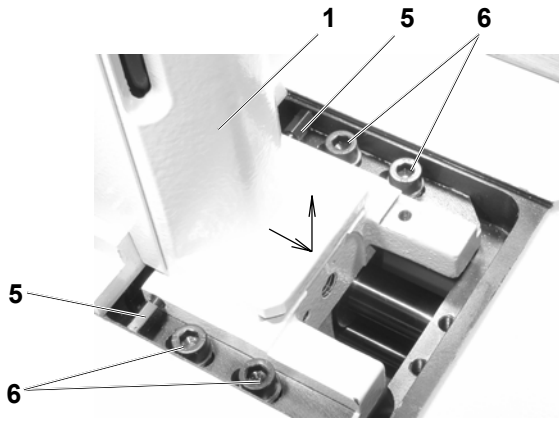
The mutual angular orientation of the gear wheel (1) relative to the gear wheel (2) should ensure the accessibility of the screw (5) at the moment when the hook point comes to lie opposite the needle (4). The wheel (2) is to be set with its gear rim symmetrically to the centre of the gear wheel (1). The clearance between the gear wheels is to be the least possible.



Caution ! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

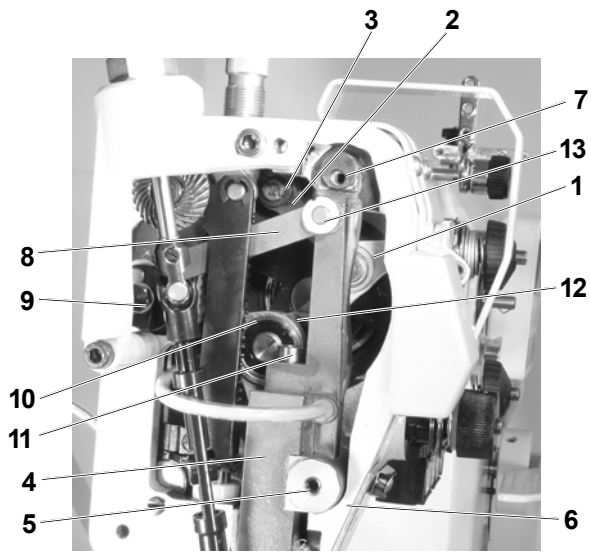
- Set the angle of 205° on the handwheel (6) and lock it with the screw (7).
- On the removed post of the hook (8), according to the paragraph 3.1.10, the hook point (3) is to be turned a bit according to the illustration.
- Turn the gear wheel (2) into the suitable position and insert the post of the hook into the machine according to the respective arrows. Check up, whether the screw (5) is accessible and, if not, repeat the procedure.
- Set the the distance of the hook from the needle according to the paragraph 3.1.3.
- Set the precise angular displacement of the hook according to the paragraph 3.1.4.
- Loosen the screw (10) and tighten them slightly.
- Set the clearance in the gear in turning the screws (9). Check up, whether the gear has a clearance during the whole revolution of the hook. Turn the handwheel step by step by 15° and, with each step, grasp the hook and try, if there is an angular dead travel. Tighten carefully the screws (9).
- Tighten duly the screws (10) and try anew the clearance of the gear.



3.1.10 Dismantling of the hook post

Caution ! Danger of injury!
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen only one screw (5).
- Unscrew the screws (6).
- Shift the post(1) in the sense of the arrows and remove it out from the machine.
- When mounting it, proceed inversely.



3.2 Needle and thread mechanism

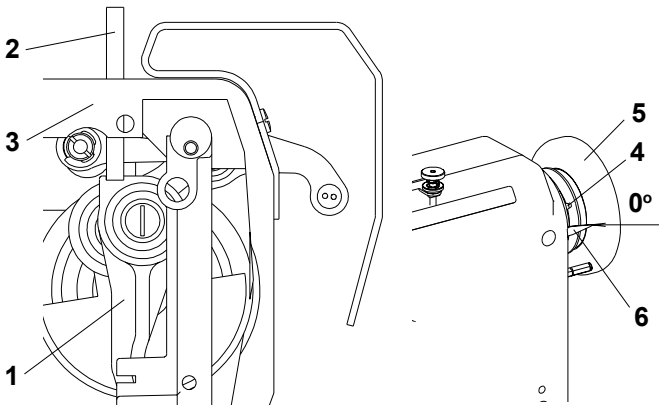
3.2.1 Description

The take-up lever (1) is mounted in ball bearings, both at the spot of its suspending on the connecting rod (2) and in the mounting on the loop (12). The take-up lever is of aluminum and is provided with a stuck-in eye for two threads. The connecting rod (2) is mounted on the eccentric pin (3), by means of which the thread mechanism is adjusted according to the category of stitching. The needle rod holder (4) is mounted through the pivot (5) in a rotating way in the arm (6). In its top part, the holder is guided by the guide pin (7). The movement for the needle feed is given to it by the connecting rod (8) driven by the feeding shaft (9). The connecting rod (8) is mounted by pin (13) with needle bar holder (4). The connecting rod (10) of the needle bar (11) on the loop (12) is mounted in a ball bearing and it is slidingly mounted on the needle bar carrier. The mechanism is lubricated by means of a central-wick lubricating system.

3.2.2 To check the handwheel angular adjustment

The handwheel (5) must be situated in its precise position relative to the needle and thread mechanism. This position is given by a pin (2), which locks the connecting rod of the needle rod (1) through a hole in the arm (3). In this position, the indicator (6) of the handwheel must show „0“. The position is fixed by the handwheel screw (4) contacting a small flat surface provided on the upper shaft. The correct adjustment of the angular position has been carried out at the producer's.

Caution ! Danger of injury!
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

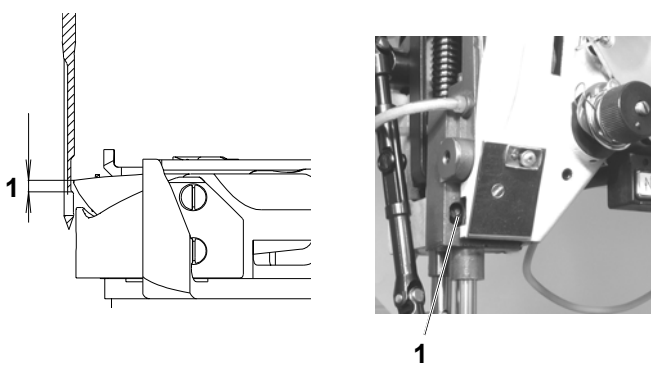


3.2.3 Height setting of the needle bar

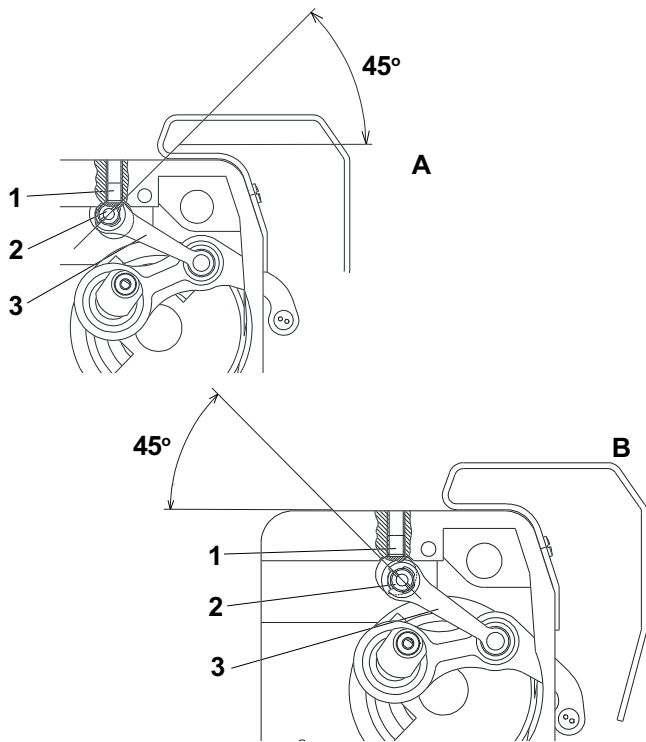
At the moment, when the hook point passes around the needle, the upper edge of the needle eye must be about 1 mm below the hook point. In an opposite case, it is necessary to set the height of the needle bar as follows:

Caution ! Danger of injury!
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the front guard.
- Loosen the screw (1) of the needle bar carrier
- Set the correct height of the needle bar and tighten anew the screw (1).



Caution !
An incorrect setting of the needle bar height may cause the striking of the hook point against the needle.



3.2.4 Angular setting the pin of the thread mechanism

The hinged pin (2) of the connecting rod (3) can be set in two positions:

- for stitching category 100, 200, 300 - the groove of the pin (2) is in position (turned) as shown in Fig. "A"
- for stitching category 400 - the groove of the pin (2) is in position (turned) as shown in Fig. "B".

Set the connecting rod pin as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the front guard.
- Loosen the screw (1) /imbus/ of the connecting rod (3) pin (2).
- Set the pin into the corresponding position and tighten anew the screw.
- The correct position is given by the flat on the pin (2), on which the screw (1) is tightened.
- After having tightened the screw (1) check the axial clearance of the connecting rod (3).

3.2.5 Side setting of the needle bar holder

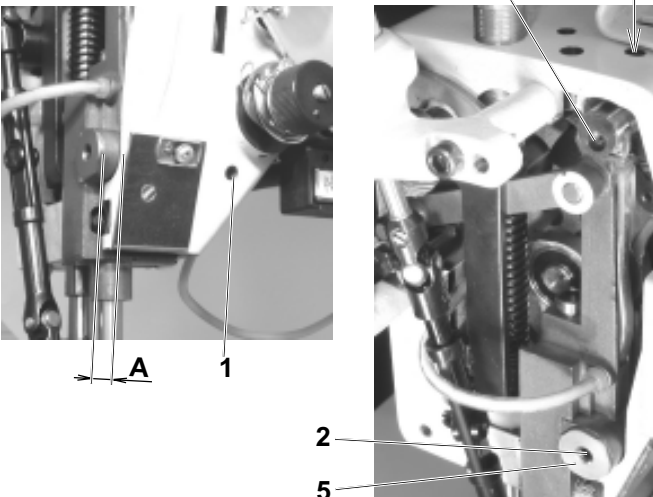
The correct position of this holder is in such case, when the needle bar is lined up with the presser-foot bar. The needle bar holder can be set as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screw (1) of the pin (2).
- Loosen the screw (3) of the guide pin (4).
- In shifting the pin (2) set the needle bar holder on the measure „A“ = 8 mm (distance between the front face of the arm and the front face of the safety bolt (5) of the needle bar holder) /at the same time the pin (4) shifts/.
- The guide pin (4) is to be set in such a way that the needle bar holder moves easily.
- Tighten the screws (1 and 3).



3.2.6 Setting the needle (the needle bar holder) in the direction of sewing

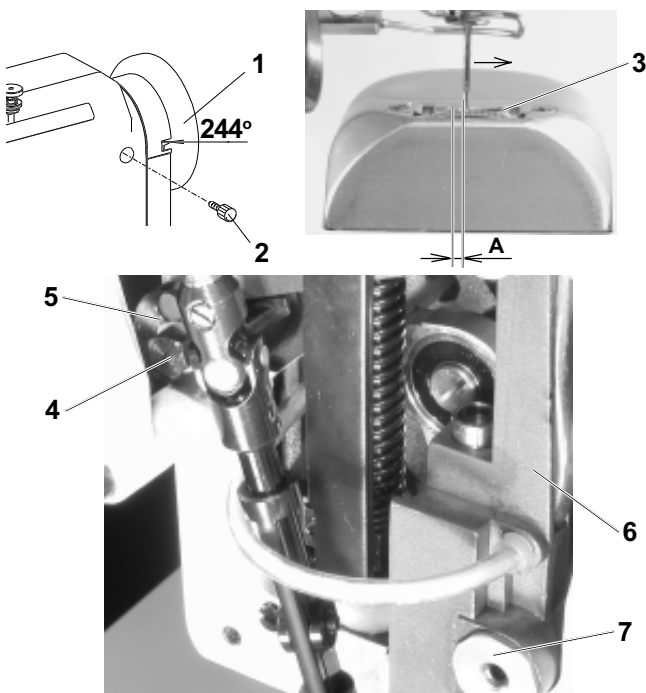
When shifting out the needle from the throat plate insert, at the moment, when the needle eye is at the level of the top surface of the throat plate insert, the distance between the needle and the wall of the throat plate insert must be „A“ = 0.2 mm.



Caution ! Danger of injury!

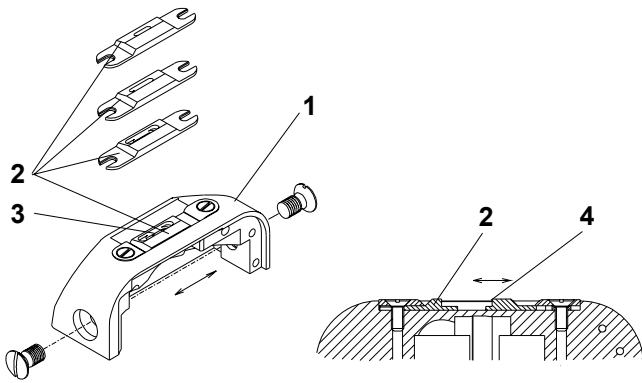
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Shift the insert (3) up to the stop in the sense of the arrow.
- Set the maximum allowed stitch length.
- Set the handwheel (1) to the angle of 244° and lock it with the screw (2).
- Loosen the screw (4) of the lever (5).
- By turning the needle bar holder (6) on the pin (7) set the required distance „A“ = 0,2 mm.
- Tighten up the screw (4) and check up the setting.



Caution!

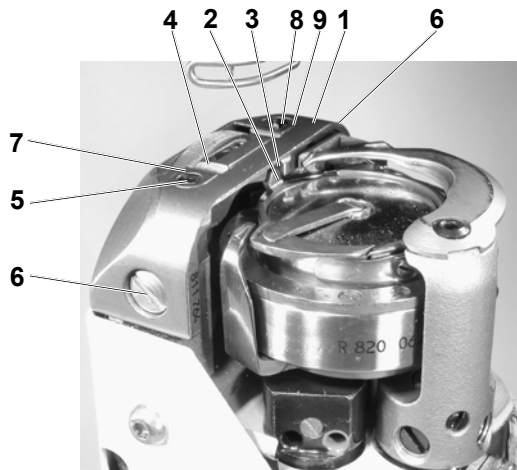
A faulty setting may cause bending or breaking of needles against the throat plate insert.



3.3 Throat plate and its post

3.3.1 Description

The throat plate (1) is universal for all categories of sewing. In the throat plate there is mounted an exchangeable insert (2). The machine is supplied with several types of inserts differing in the width of their needle aperture (3), see tab. in the par.11.2. For ensuring a good function of the thread trimming device, the insert can be set in various positions in the sense of arrows in such a way that the rear edge of the hole in the throat plate (4) prevents unthreading the thread from the sewn material when forming the first stitches at the beginning of the seam.



3.3.2 Mounting and removing the throat plate and its insert

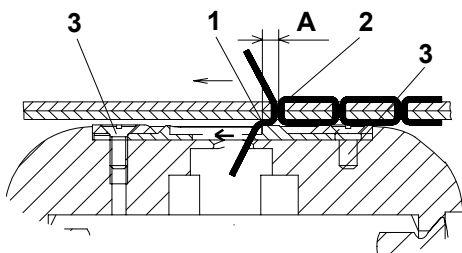
When mounting the throat plate (1), the finger (2) must engage into the recess (3). To remove the throat plate insert (4), screw out the screw (5), take out the washer (7), loosen the screw (8) and remove the insert (4) by oblique upward movement.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Turn the finger (2) in the sense towards the throat plate (1).
- Mount the throat plate (1).
- Screw in the screws (6).
- Slide in the insert under the washer (9) in the oblique rearward sense (4).
- Mount the insert (7) and screw in the screw (5).
- Tighten the screw (8).
- When removing the insert, proceed in an inverse sequence.



3.3.3 Setting the throat plate and its insert

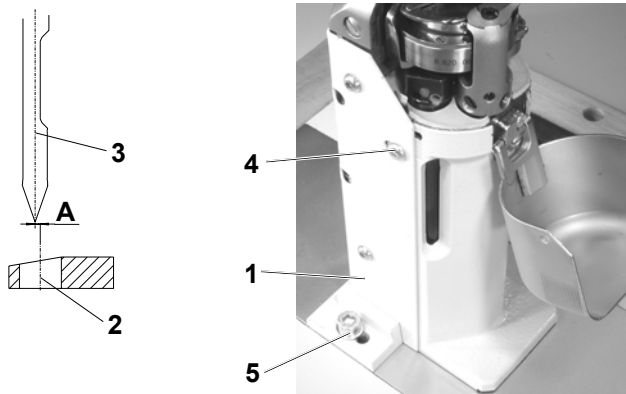
The insert of the throat plate should be set in the machines with the trimming device in such a way that the edge (1) is at the distance „A“ = 1 to 2 mm before the spot of interlacing of the threads (2). For the stitches up to the length of 2/3 of the maximum length, the insert is to be set in its extreme front position in the sense of the arrow. For long stitches, it should be in its extreme rear position, against the sense of the arrow. With the machines without the trimming device, the insert is in its extreme rear position.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screws (3).
- By applying a heavy pressure of the screwdriver, shift the insert in its required position.
- Tighten the screws (3).



3.3.4 Side setting of the throat plate post

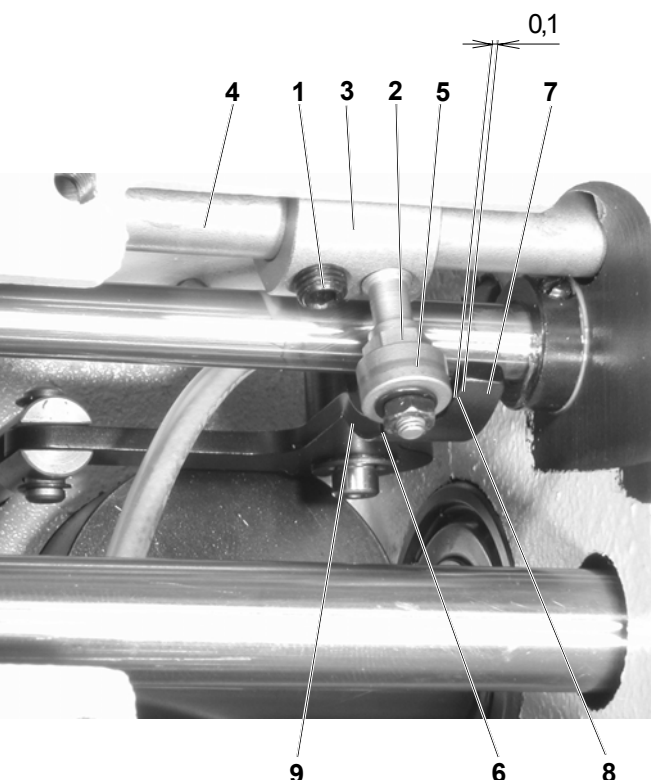
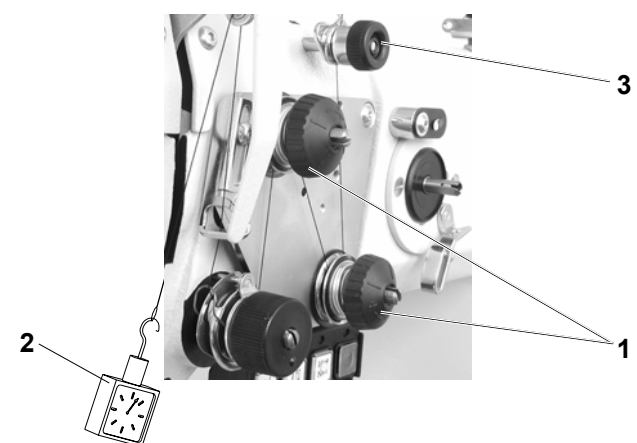
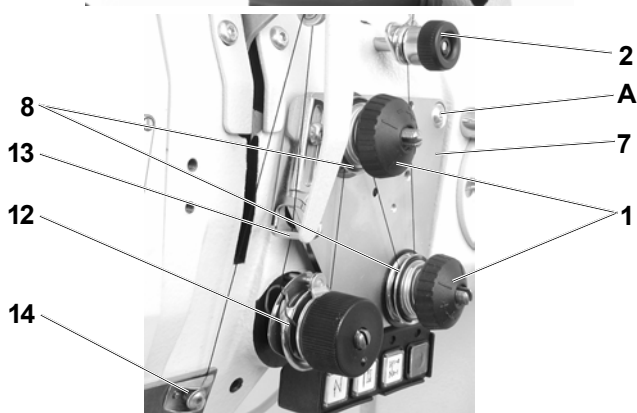
The post of the throat plate (1) is to be side set in such a way that the axis of the hole in the insert of the throat plate (2) is at the distance „A“ = 0.1 mm to the right from the axis of the needle (3).



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screws (4 and 5) (from the rear side of the post as well).
- Shift the post (1) in the sense required for attaining the distance „A“ = 0.1 mm.
- Tighten the screws (4 and 5) and check up for the correct setting.



3.4 Thread tensioners and limiter

3.4.1 Description

The main tensioners (1) serves for creating the tension of the thread when tightening the stitch. The auxiliary tensioner (2) reduces the risk of pulling out of the thread after the thread trimming when removing the sewn material, when the thread is passed through this material and when the main tensioner is relieved. The main tensioner is relieved by the mechanism controlled by the shaft of the presser bar lifting (3) holding the lever (4) with a pulley. The motion is then transmitted by the lever (5) and the tie rod (6) on the thread tensioner plate (7) whose displacement (motion) relieves the thread tensioner springs (8). In machines provided with a thread trimming device, the main tensioners (1) are relieved as well upon the switching on of the electromagnet (10) whose electromagnetic field will attract the thread tensioner plate (7). The mechanism of the adapting spring (12) maintains the upper thread in its tensioned state when passing through the hook and when entering the needle into the sewn material. The thread limiter (13) limits the length of the thread fed by the take-up lever when moving from the upper to the bottom dead centre to get a controlled passing of the thread through the hook. The auxiliary guide (14) maintains the upper thread in front of the needle in a tensioned condition and helps against pulling the thread from the needle after thread trimming.

3.4.2 Setting the tension of the main and auxiliary tensioners

The tension of the main thread tensioners is regulated by means of the nuts (1). The force of tensioning the thread is measured by the dynamometer (2) as it is shown on the illustration. The size of this force differs according to the size of the category, and its orientation value is indicated in the par. 11.2. The tension of the auxiliary tensioner is regulated using the nut (3). It should be the least possible, but sufficient for unthreading the thread from the sewn material when removing the sewn material from the pressing element without leaving the tensioner.

3.4.3 Setting the tensioning mechanisms of the main tensioners

In the rest position of the tensioners, when pushing the plate of the tensioners on the spot "A" 3.4.1, this plate must have the so-called dead travel of about 0,5 mm. At this lifting, the tension discs of the tensioners must not be relieved. This can be attained by a suitable shaping of the relieving disc of the tensioners - this has been set up in the manufacturing factory. In the maximum opened position of the tensioners, the plate of the tensioners, when pushing it at the spot "A" 3.4.1, must still have the minimum lifting. This can be attained when axially shifting the lever (3) with the roller (5) on the shaft (4). The disengagement of the main tensioners must be coordinated with the top roller lift. To achieve this, turn the lever (3) with the roller (5) on the shaft (4). The movement of the roller (5) on the slanting surface (6) of the lever (7) disengages the tensioners. In this way, also a lag of the upper thread tension disengagement after the top roller lift can be obtained.

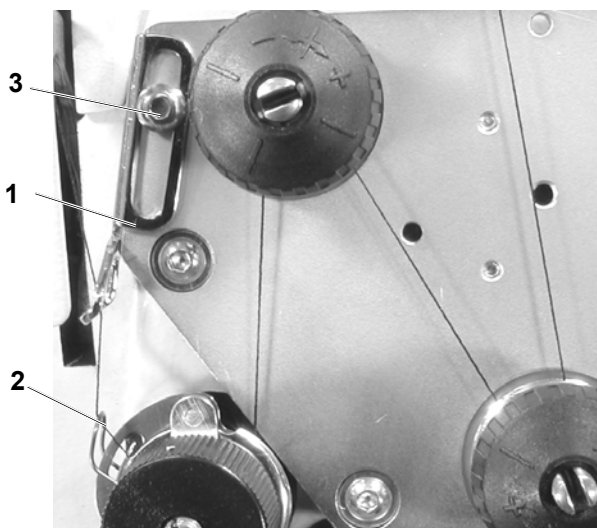
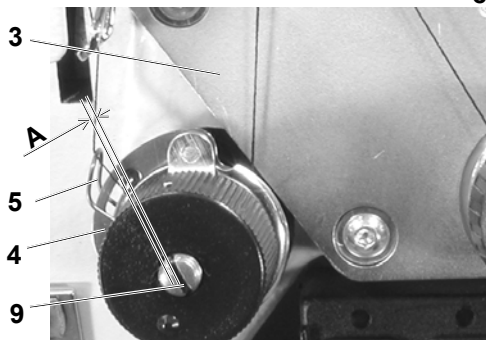
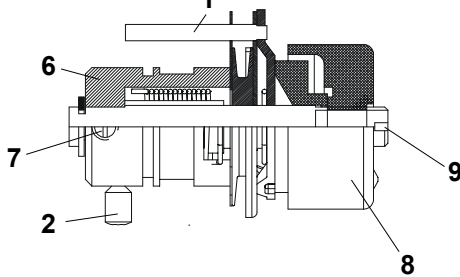
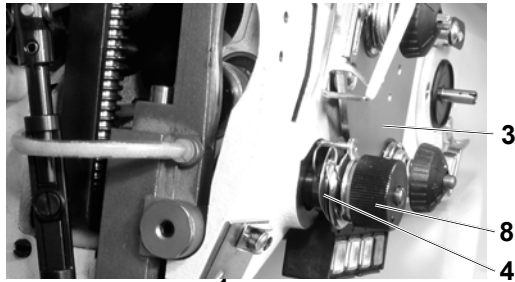


Caution ! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the rear cover with the top roller lift magnet.
- Loosen the screws (1) and (2) of the lever (3).

- In the rest state of the machine (with not relieved tensioner discs) set the lever (3) in turning it slightly on the shaft (4) to a position in which the roller (5) of the lever (3) is in contact with the slanting surface (6) of the lever (7) and is about 0.1 mm distant from the flat surface (8) of the lever.
- At the maximum lift of the top roller, the roller (5) moves on the flat surface (9) of the lever (7); in this condition, there must be a minimal play at the tensioner plate lift (when pushing qat the spot "A" (3.4.1), the plate must still have a minimum lifting - between the roller (5) and the surface (9) there is a minimum clearance). Retighten the screws (1) and (2), check the play, and correct it in case of need.



3.4.4 Setting the adapting spring

The mechanism of the adapting spring is in the machine arm set by the pin (1) and fixed by the screw (2). The axial adjustment shall ensure that the surfaces of the parts (3) and (4) are aligned (the threaded thread must in no place break on edges). The initial position of the adapting spring (5) shall ensure that "B" = 1 to 1.5 mm (see the Figure).



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screw (2) and take the mechanism out of the machine arm.
- Turning the body (6) relative to the pin (1), set the required initial position of the adapting spring /the screw (7) has been set at the producer's so as to permit the turning movement of the body (6) the screw must not be fully tightened/.
- During the installation of the mechanism into the machine arm take care of the axial adjustment of the mechanism.
- Retighten the screw (2) and check the adjustment.
- Loosen the nut (8) of the mechanism, insert a screwdriver into the notch of the screw (9) and set the required value of the adapting spring. By turning the screw clockwise you increase the spring force, and vice versa.
- Retighten the nut (8) and check the function of the adapting spring.

3.4.5 Setting the thread limiter

The thread limiter is to be set in such a way that, when sewing and passing the thread through the most distant point of the hook, the spring (2) shifts by about 1/4 to 1/2 length of its total length. This means that the thicker will be the sewn material and the longer will be the stitch length, the more will be the limiter shifted in the sense of the arrow and inversely. Under standard sewing conditions, the thread limiter is set in its tested positions depending on the sewing category in accordance with the chapter 11.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Tighten the screw (3).
- Set the thread limiter (1) so as to ensure a minimum motion of the adapting spring (2) when the thread passes around the bottom of the hook.
- Tighten the screw (3).

3.5 Feeding mechanism of the needle feed and of the lower feed wheel

3.5.1 Description

The feeding mechanism is formed by the leverage (1) which is driven from the main shaft through the eccentric with connection rod (2). The feeding motion is transmitted by the shaft (3) on the clutch of the bottom feed (7).

The engaging and the disengaging function of the clutch (7) is controlled from the lower shaft (8) through the eccentric with the connecting rod (9) and through the wedge coupling (10).

The feeding movement is transmitted by the shaft (11) through the chain transmission (12) onto the wheel feeder (13).

The stitch length is set by the knob (14) through the leverage (15) to the feeding mechanism (1).

3.5.2 Stitch length mechanism

3.5.2.1 Setting the upper eccentric

The eccentric (1) must be set in its angular position in such a way that the horizontal component of the needle motion is in a phase delay from the vertical component of this movement. This refers to the angle of 90° on the handwheel (2), when the setting stick (3) is engaged into the eccentric (1) and leans from above against the feeding shaft (4).

Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Set the angle 90° on the handwheel (2) and fix it with the screw (5) which is component part of the accessory of the machine (tighten it with care).
- Loosen the gripping joints of the levers (6) and (7).
- Turn the feeding shaft (4) in such a way, so that the recesses (flats) point towards the bedplate (owing to the unambi-guous setting of the eccentric by means of the setting bar).
- Insert the setting bar (3) into the hole in the eccentric (1) and prop it from above against the feeding shaft (4).
- Shift axially the eccentric (1) on the shaft into its extreme positions and place it in the middle.
- Tighten the screws of the eccentric (1) to the maximum (one screw first and, after having turned slightly the hand-wheel, the second screw as well).
- Turn the feeding shaft (4) back into the position for setting the leverage in such a way, so that the levers (10) of the mechanism pass in the spots of the recesses.
- Tighten the gripping joints of the levers (6) and (7).
- Test the sufficient clearance in the recesses of the feeding shaft (4) and, using the levers (10) with the maximum stitch length forward and rearward – push against the reverse stitching lever.
- Correct eventually the position of the feeding shaft.

3.5.2.2 Setting the prop

In this machine with a wheel feed, the prop (1) is mounted in the pits (A and C) as per the drawing.

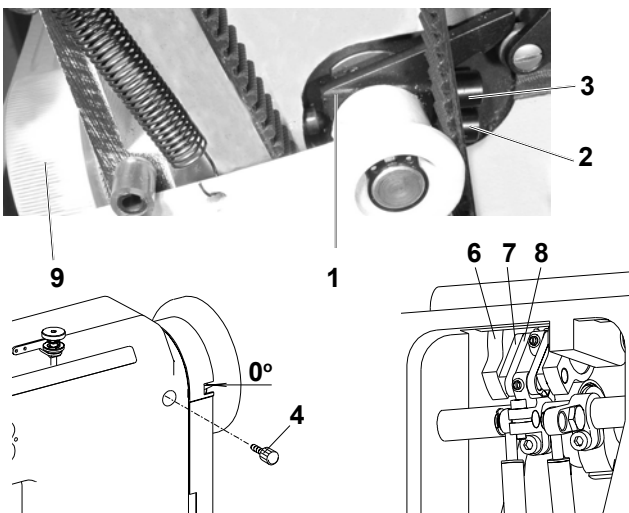
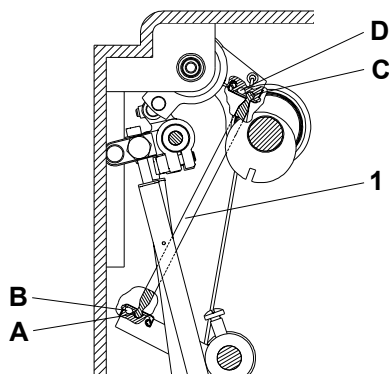
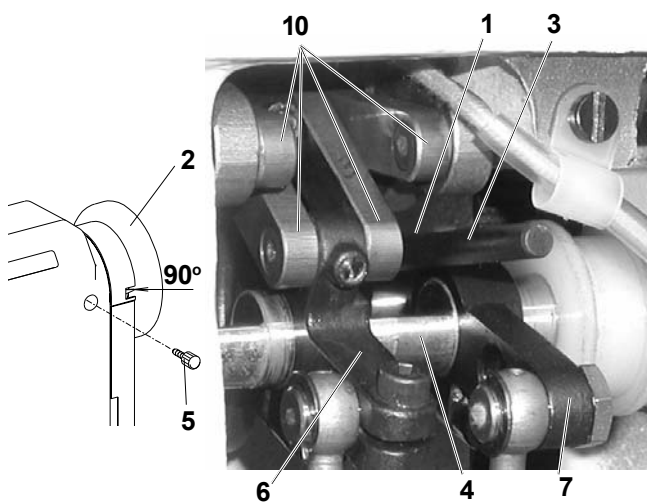
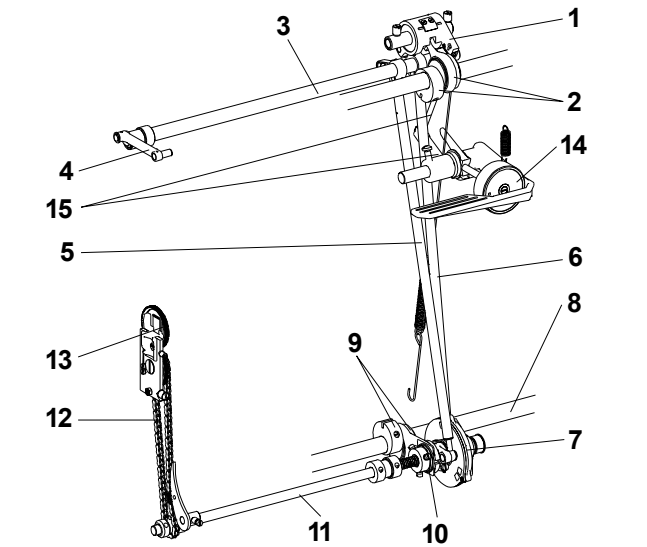
3.5.2.3a Forward and rearward stitch length distribution (rough)

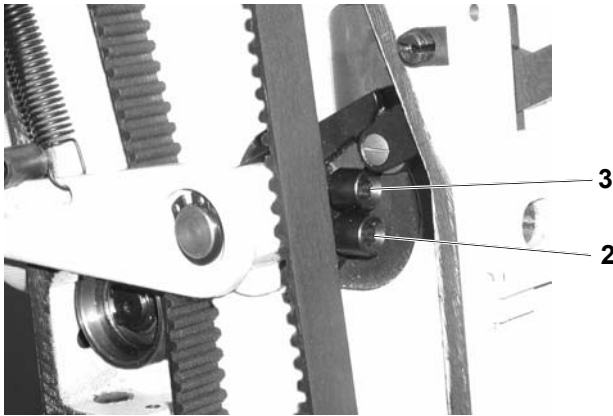
The cam (1) is to be set at the respective angle in such a way that the stirrup (6) is oriented in such a position, so that the connecting rods (7 and 8) are in a line with a thoroughly screwed in knob (9) and with turning the handwheel at 0°. This setting can be done only after having set the top eccentric according to the paragraph 3.5.2.1.

Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Set the zero stitch /screw in the knob (9) to the bottom of the cam (1)/.
- Set the angle 0° on the handwheel and lock it with the screw (4).
- Turn the screw (3) in the respective sense in such a way that the connecting rods (7 and 8) are in a line and tighten the screw (2).





3.5.2.3b Forward and rearward stitch length distribution (fine)

When setting the maximum length of the stitch, the forward and the rearward stitch length must be equal with the maximum error of $\pm 5\%$. This setting can be done only after having set the needle bar holder in the direction of sewing (par. 3.2.6) and the wheel feed (par. 3.5.3.1.2).



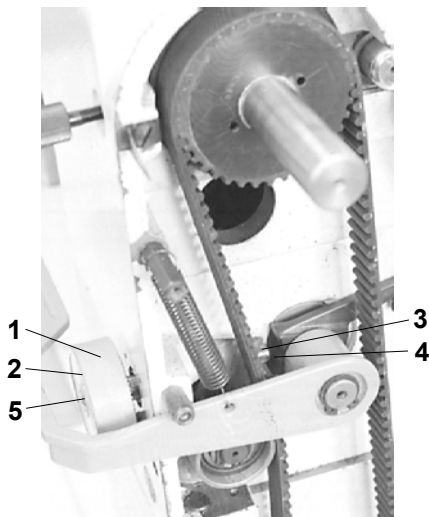
Caution! Danger of injury!

switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Set the maximum stitch length .
- Place a suitable material under the presser foot and mark therein the forward and the rearward stitch length.
- With an unequal length of the stitch, proceed to the correction of setting by turning the screws (2 and 3). When tightening the screw (3), the forward length of the stitch is shortened and inversely. When tightening the screw (2), the forward stitch length is lengthened.
- Each time first loosen one screw and then retighten the other one.

3.5.2.4 Setting the control knob (including the stitch length limitation)

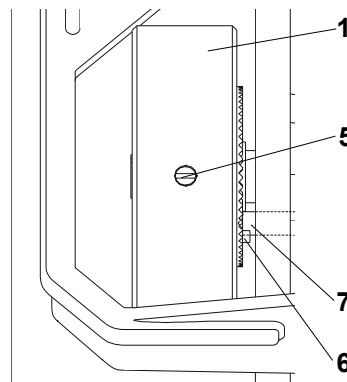
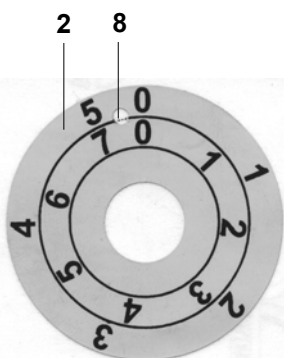
The control knob (1) is to be set up in such a way that, when turning it in counterclockwise sense up to the stop, the maximum stitch length valid for the given sewing category is attained (cat. 1: 3 mm, cat. 2: 5 mm, cat. 3 and 4: 7 mm). The scale of the control knob is to be oriented in such a position, so that the scale end corresponds to the maximum stitch length, excepting the first sewing category, where the stitch length of the indicator is 3 mm.

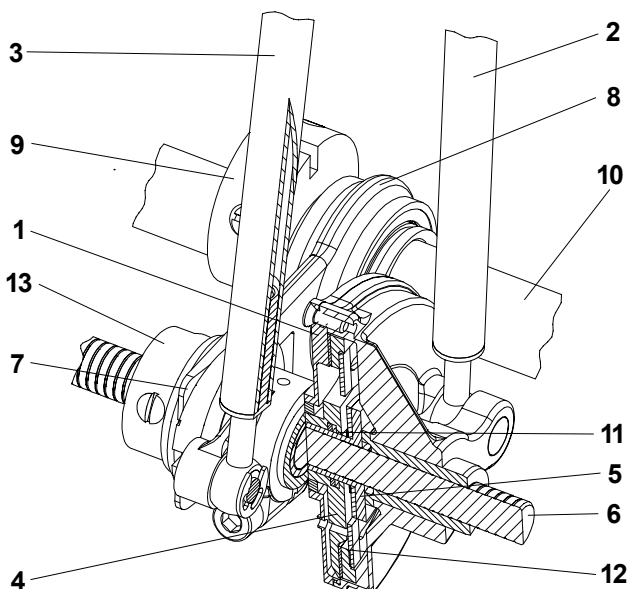


Caution! Danger of injury

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Screw in the screw of the control knob in such a way, that the spherical surface of the screw (3) bears on the seat of the cam (4).
- Loosen the screw (5) and turn the control knob in the clockwise direction, until the pin (6) of the knob (1) bears on the pin (7). Tighten firmly the screws (5).
- Turn the knob in the counterclockwise direction up to the stop, when the pin (6) of the knob (1) bears on the pin (7).
- In a sewing test check up the length of the stitch, if this corresponds to the maximum stitch length valid for the given sewing category.
- If the stitch is longer, loosen then the screws (5) and turn the knob in the clockwise direction and inversely. Tighten firmly the screws (5).
- Insert a screwdriver into the hole (8) of the scale (2) and adjust the scale in such a way that the maximum length on the scale is against the marking of the stitch length on the machine arm.
- For the sewing category 1, set the control knob (1) on the stitch length of 3 mm and check it by a sewing test.
- Loosen the screws (5) and turn the control knob (1) in the counterclockwise direction, until the pin (6) of the knob (1) bears on the pin (7). Tighten firmly the screws (5).
- Put a screwdriver into the hole (8) of the scale (2) and adjust the scale in such a way that the value of the stitch length on the scale against the marking on the arm is 3 mm.





3.5.3 Lower feed wheel

3.5.3.1 Feeding clutches

3.5.3.1.1 Description


The feeding clutch is formed by the clutch cover (1) driven from the connecting bar (2), by the clutch star (4) driven from the connecting rod (3) and by the carrier plate (5) firmly connected with the shaft (6). Of the clutch give the connecting rods (2 and 3) an opposite direction swinging movement. The clutch is coupled by means of the wedge (7) on the connecting rod (8) through the eccentric (9) which is placed on the lower shaft (10).

In the position, when the wedge is disengaged, the star (4) is shifted out from the frictioning engagement with the lining of the carrier plate (5) by means of the spring washer (11). The plate (5) lining is then pushed by means of a flat profiled spring (12) against the cover of the clutch (1).

In the position, when the wedge is disengaged, the star (4) is pushed against the plate (5) lining and, at the same time, the friction connection with the cover of the clutch (1) is disconnected. Within a short instant, when engaging and disengaging with the carrier plate (5), there are in a friction engagement both the cover (1) and also the star (4), namely in the dead centre of the connecting rods (2 and 3). The setting of the change-over of clutches is done by tightening or by loosening the nut (13).

3.5.3.1.2 Setting the lever of the second step of feeding (angle, position)

The lever of the second step (1) must be set in such a way that, in the bottom dead centre of the needle, the axis of the spider part (2) lies in the screw axis (3). The pin screw (4) can be mounted into the position (4.1 - corresponds to the maximum stitch length of 5 mm) or into the position (4.2 - corresponds to the stitch length of 7 mm). The position of the pin screw is given by the sewing category (see par. 11.2).



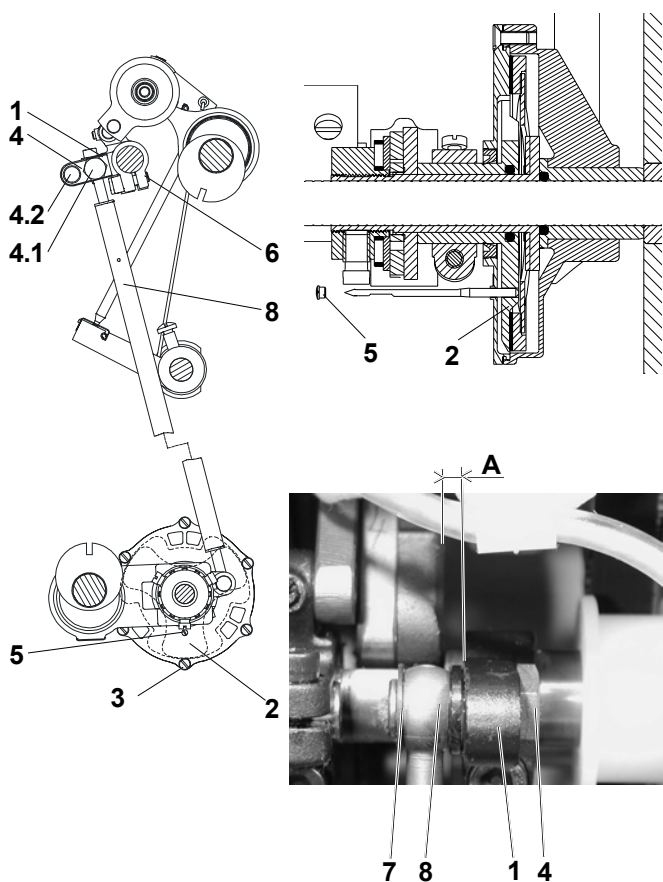
Caution! Danger of injury!
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

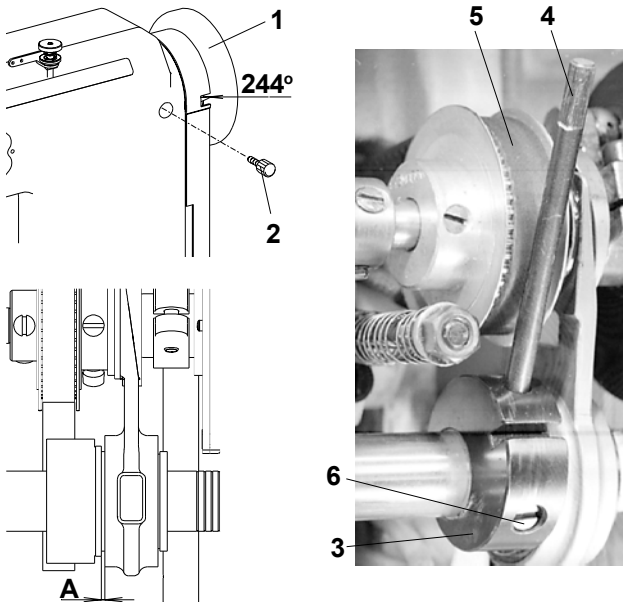
Lever (1) displacement.

- Loosen the screw (6).
- Set the maximum stitch length.
- Set the angle 180° on the handwheel.
- Unscrew the screw (5) and put the needle shank in its hole.
- Turn the lever (1) until the needle drops into the clutch disk (2).
- Side set the lever (1) to the measure „A“ = 0.5 to 1 mm.
- Tighten the screw (6).
- Screw in the screw (5) and seal it with the Loctite cement.

Change of the position of the pin screw (4).

- Remove the retaining ring (7).
- Unscrew the screw (4) and screw it into the new position and tighten it duly. Mount the connecting rod (8) and the retaining ring (7).





3.5.3.1.3 Setting of the lower eccentric

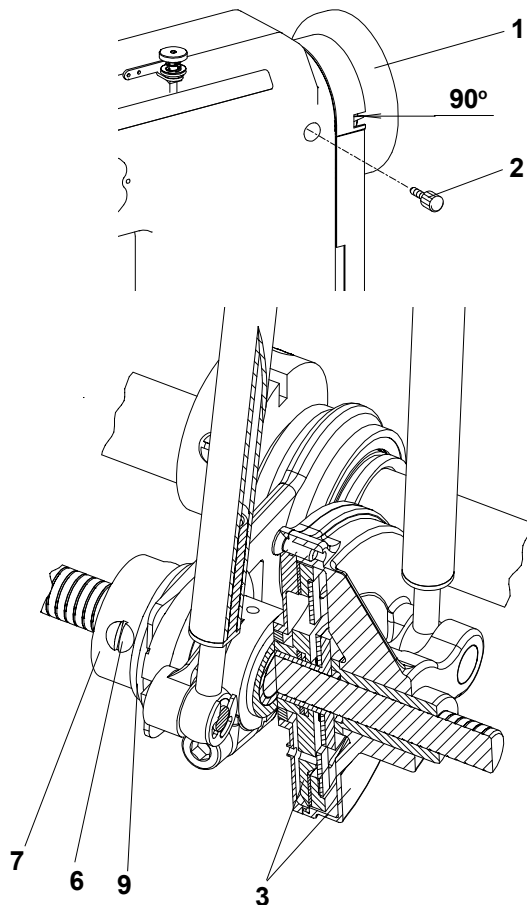
The rotation of the eccentric (3) must be delayed in phase by 1/4 revolution against the rotation of the eccentric of the stitch length. This corresponds to the angle of 244° on the handwheel (1), when the setting pin (4) is put into the eccentric (3) which is in contact with the indented belt (5).



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Set 244° on the handwheel (1) and lock it with the screw (2), which is included in the accessory of the machine (tighten it carefully).
- Put the setting stick (4) into the hole in the eccentric (3) and prop it from below against the indented belt (5).
- Set eccentric (3) axially.
- Tighten it the utmost the screws of the eccentric (6).
- By means of the handwheel, turn the eccentric (3) into the marked position and check in this position the clearance „A“ = 0.05, proceed eventually to its correction by a new side setting of the eccentric.



3.5.3.1.4 Setting the engagement and disengagement of the clutches

The nut (7) is to be side set in such a way that the shifting of the clutches is done at the moment when the clutch disks (3) do not move, which means, when they are at the dead center of their oscillating movement. This corresponds to the angle 90° on the handwheel.



Caution! Danger of injury!

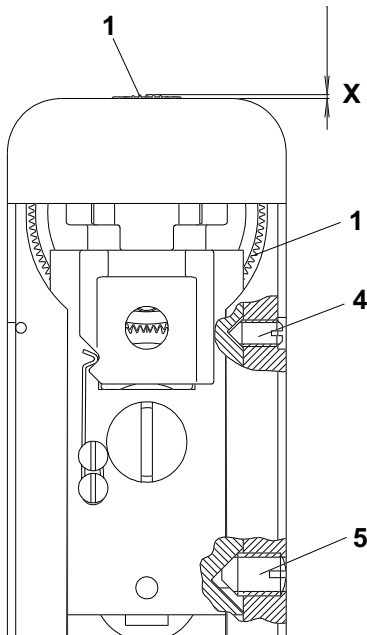
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screws of the indented pulley of feeding and shift it to the left.
- Set the maximum stitch length.
- Set the angle 90° on the handwheel (1) and lock it with the screw (2). which is included in the accessory of the machine (tighten it carefully).
- Loosen three screws (6) in the nut (7) and unscrew it by 2 mm to the left.
- Tighten slowly the nut (7), until it strikes against the axial bearing (9). (At this moment, the tightening moment increases in jumps) and tighten the screws (6).
- Set the the handwheel on 85° and push the backtacking lever, the feeder is to turn against the movement of the needle. Set then the handwheel on 95°, the feeder is to be turned in the sense of the needle movement. If not being so, correct the side setting of the nut (7). When the clutches shift too soon, turn a bit the nut (7) to the right and inversely.
- Tighten the screws (6).
- Return the indented pulley in its original place according to the paragraph 3.6.2.

3.5.4.2 Wheel feeder and its post

3.5.4.2.1 Height setting of the feeder and tensioning of the chain

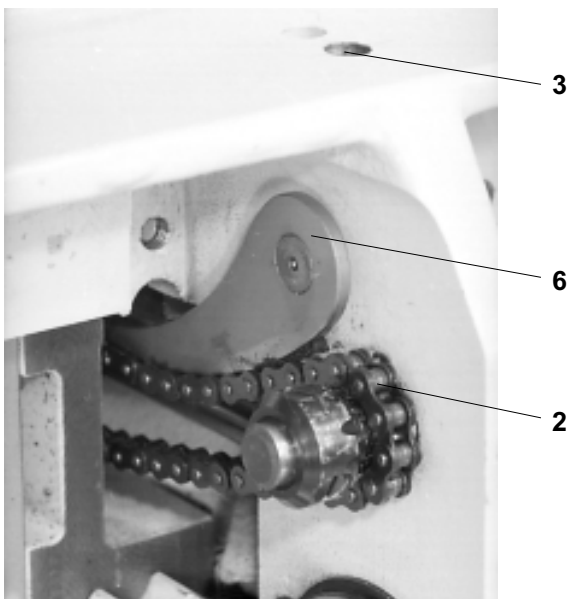
The wheel feeder (1) is to be set in such a way that the points of its teeth overtop the insert of the throat plate by „X“ = 0.3 to 0.7 mm. When sewing soft and thick materials, it is necessary to increase the value „X“, until a good quality of feeding is attained, but only to the measure of not deteriorating the beginning of sewing after the carried out thread trimming. Set the height of the feed dog using a setting gauge. With every correction of the teeth height, the tension of the chain (2) is to be corrected.

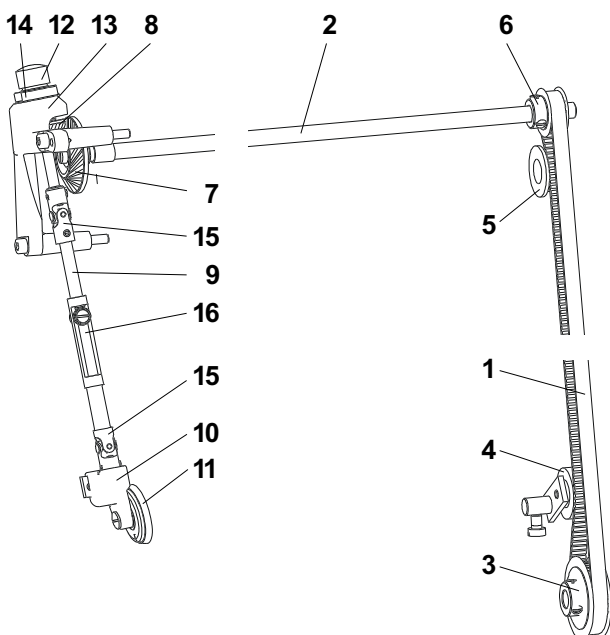
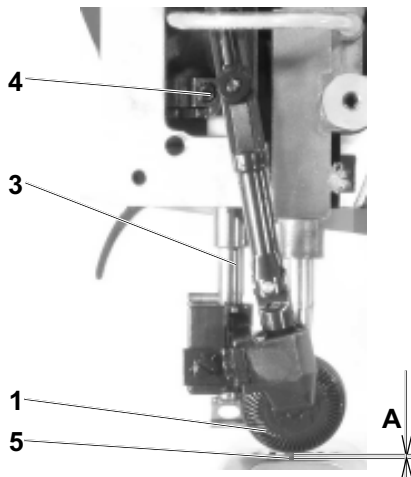
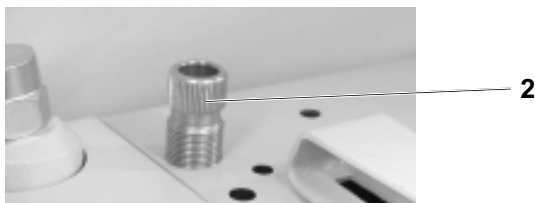
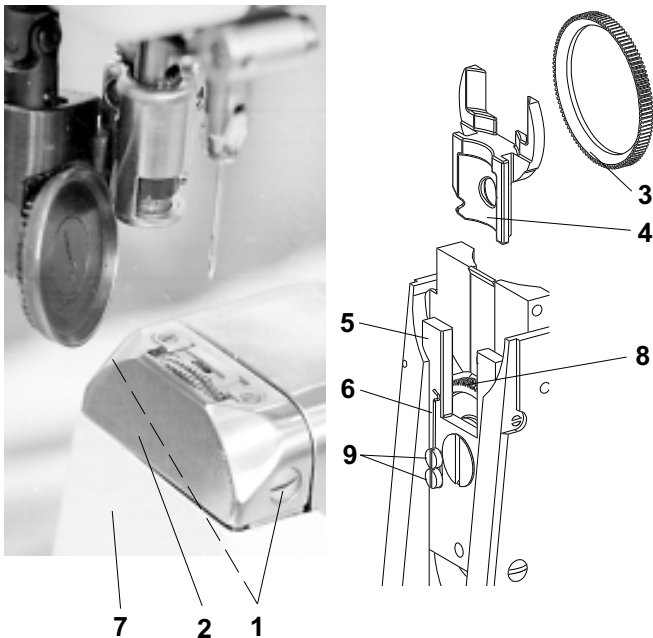


Caution! Dangers of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screw (3).
- Loosen the screw (4).
- Loosen or tighten the screw (5) and push simultaneously with finger the feeder (1) downwards, until the required height of the teeth „X“ of the wheel feeder is attained.
- Tighten then still the screw (5) by 45° (1/8 revolution).
- Tension the tensioner (6) up to the stop. Be careful in side shifting it to the centre of the chain. Tighten the screw (3).
- Loosen the screw (5) by 45° (1/8 revolution), into its original position. In this way, the optimal clearance of the chain transmission is attained.
- Tighten the screw (4).
- Correct the set height of the top roller according to the par. 3.5.4.





3.5.3.2 Replacement of the feeder

For the replacement of the wheel feeder (change of the wheel feeder according to the machine setting - see par. 11.2 - setting of the machine - feeder - pitch of the teeth).



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Unscrew the screws (1) and remove the throat plate (2).
- Unscrew the guard (7).
- In pulling upwards (securing by a spring), pull out the feeder (3) with the guide (4).
- Replace the feeder (3).
- Insert the feeder with the guide into the groove of the holder (5).
- Mount the throat plate (2) and tighten up the screws (1).
- Check up, if the spring (6) pushes the guide (4) with the feeder (3) against the wheel (8).
- In the opposite case, loosen the screws (9), tense up the spring (6) in such a way, so that the guide (4) with the feeder (3) is pushed against the wheel (8) and tighten the screws (9).
- Mount the guard (7) and tighten the screws.

3.5.4 Setting the top roller (pressing force, height)

When lowering the top roller (1), set the clearance „A“ between the feeder (5) and the top roller to the maximum of 0.2 mm. Set the pressing force of the top roller (1) so as to avoid the slippage of the sewn material when feeding it.

Method of setting the height of the top roller:

- Lower by hand the presser bar (3) with the top roller (1) above the wheel feeder (5).
- Loosen the screw (4) and set the required value „A“ (0.2 mm).
- Tighten the screw (4).

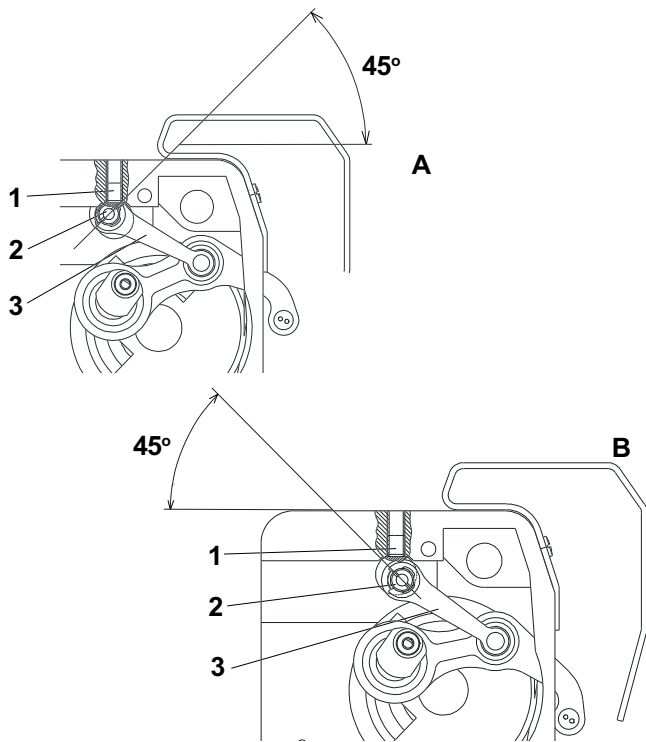
Setting the force of the top roller (1).

- In screwing in the screw (2), the force of the top roller is increased and inversely.

3.6 Feeding mechanism of the top roller

3.6.1 Description

The starting movement for the drive of the top roller feeder is the bottom feeding shaft. From this shaft, the movement is transmitted by the indented belt (1) onto the top feeding shaft (2). A component part of the transmission by indented belt is the pulley (3), the tensioning roller (4), the roller (5) and the pulley (6). Starting from the shaft (2), the movement is further transmitted through the wheels (7 and 8) onto the articulated shaft (9). From this articulated shaft, the movement is transmitted by a cone transmission, situated in the holder (10), onto the feeder wheel (11). The shaft of the wheel (8) is mounted in the screw (12) on bearings. The articulated shaft (9) contains two joints (15) and a telescopic part (16). Both these elements secure the lifting and the tilting of the top roller.



3.2.4 Angular setting the pin of the thread mechanism

The hinged pin (2) of the connecting rod (3) can be set in two positions:

- for stitching category 100, 200, 300 - the groove of the pin (2) is in position (turned) as shown in Fig. "A"
- for stitching category 400 - the groove of the pin (2) is in position (turned) as shown in Fig. "B".

Set the connecting rod pin as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the front guard.
- Loosen the screw (1) /imbus/ of the connecting rod (3) pin (2).
- Set the pin into the corresponding position and tighten anew the screw.
- The correct position is given by the flat on the pin (2), on which the screw (1) is tightened.
- After having tightened the screw (1) check the axial clearance of the connecting rod (3).

3.2.5 Side setting of the needle bar holder

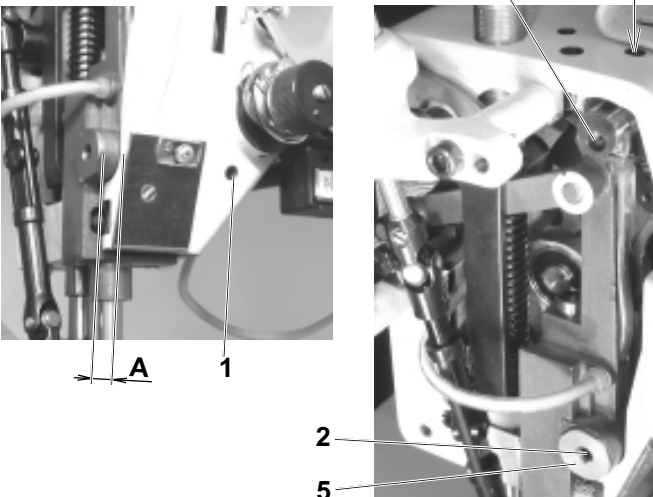
The correct position of this holder is in such case, when the needle bar is lined up with the presser-foot bar. The needle bar holder can be set as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screw (1) of the pin (2).
- Loosen the screw (3) of the guide pin (4).
- In shifting the pin (2) set the needle bar holder on the measure „A“ = 8 mm (distance between the front face of the arm and the front face of the safety bolt (5) of the needle bar holder) /at the same time the pin (4) shifts/.
- The guide pin (4) is to be set in such a way that the needle bar holder moves easily.
- Tighten the screws (1 and 3).



3.2.6 Setting the needle (the needle bar holder) in the direction of sewing

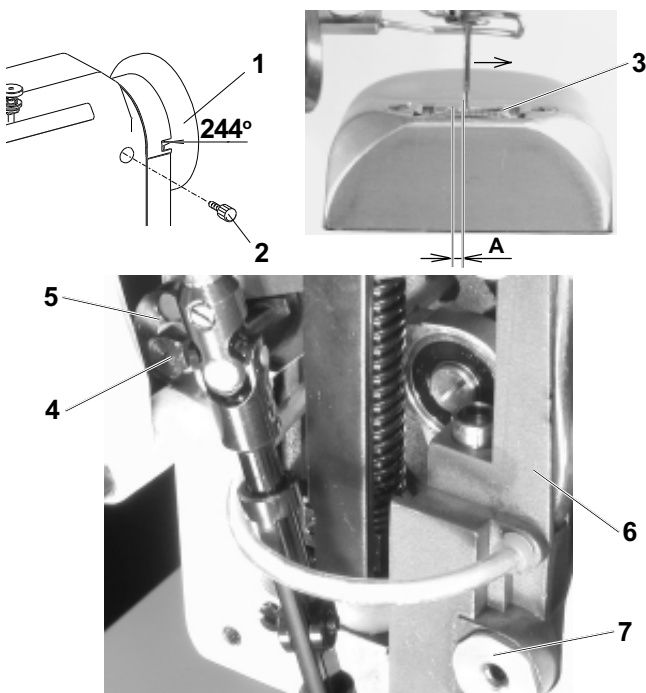
When shifting out the needle from the throat plate insert, at the moment, when the needle eye is at the level of the top surface of the throat plate insert, the distance between the needle and the wall of the throat plate insert must be „A“ = 0.2 mm.



Caution ! Danger of injury!

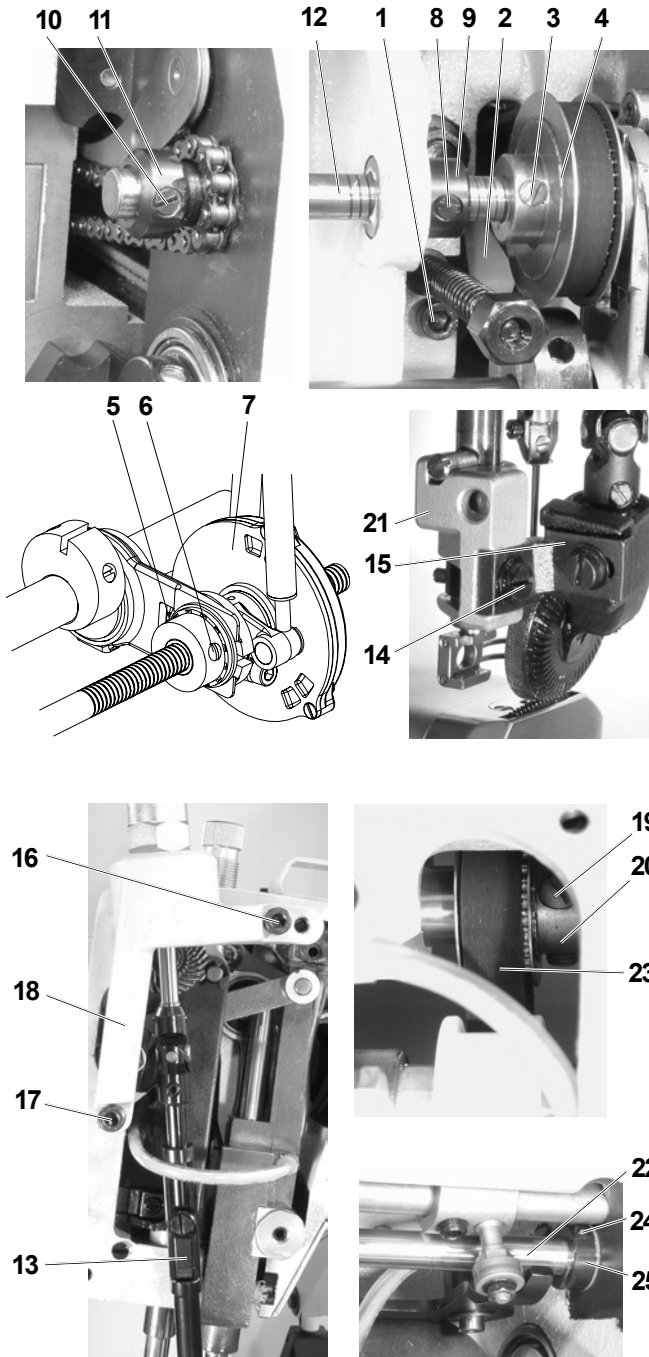
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Shift the insert (3) up to the stop in the sense of the arrow.
- Set the maximum allowed stitch length.
- Set the handwheel (1) to the angle of 244° and lock it with the screw (2).
- Loosen the screw (4) of the lever (5).
- By turning the needle bar holder (6) on the pin (7) set the required distance „A“ = 0,2 mm.
- Tighten up the screw (4) and check up the setting.



Caution!

A faulty setting may cause bending or breaking of needles against the throat plate insert.



3.6.5 Replacement the indented belt

Before replacing the indented belt, the bottom feeding shaft is to be removed. The procedure is as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screw (1) of the tensioning roller (2) and loosen it.
- Loosen the screws (3) of the pulley (4) and shift it to the left in such a way that the screws (5 and 6) of the feeding clutch (7) are accessible.
- Loosen the screws (5 and 6).
- Loosen the screws (8) of the axial ring (9).
- Loosen the screws (10) of the chain wheel (11).
- Push the shaft (12) to the left in such a way that it is out of the pulley (4).
- Remove the pulley (4).
- Remove the front guard.
- Loosen and unscrew the screw (14) of the holder of the wheel (15) and remove it from the holder (21).
- Loosen the screws (16 and 17) of the holder (18).
- Remove the holder (18) together with the holder (15) and articulated shaft (13) from the machine.
- Loosen the screws (19) of the pulley (20).
- Loosen the screw (24) of the ring (25).
- Hold the pulley (20) and pull out the feeding shaft (22) from the arm in such a way that it is possible to remove the indented belt (23) from the arm of the machine.
- Replace the belt with a new one and proceed to the assembly (inverted procedure of dismantling).
- Proceed to the setting operation according to the par. 3.6.2, 3.6.3 and 3.6.4.

3.6.6 Top roller

3.6.6.1 Selection of the top roller diameter

The machine can be supplied with two types of top roller, namely with the diameter of 25 mm and with the diameter of 35 mm. The suitability of the diameter used depends on the type of sewing and on the concrete technological operation. There are in general valid the following principles for the selection of the wheel diameter:

- ř 25 mm - for sewing small radii
- ř 35 mm - for sewing straight sections or big radii
- for sewing with great passages to thicker materials

3.6.6.2 Forward, rearward and side setting

The top roller must be in a defined position in relation to the needle:

- a) view (see Fig. 1) - the value „X“ depends on the diameter of use top roller (ř 25 - 6.5 mm; ř 35 - 10.5 mm), it is measured from the the needle bar up to the roller edge when turning the handwheel to the 180° of the scale against the indicator
- b) view (see Fig. 2) - the wheel edge must fit with the edge of the needle operture at the spot of the needle punch.

These values are to be set as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screw (1).
- By shifting the holder (2) with the top roller (3) in the groove of the holder (4) set the required value „X“ and tighten the screw(1).
- Loosen the screw (5)
- By shifting the holder (2) in the holder (6) set the bottom edge of the roller to the edge of the needle operture.
- Tighten the screw (5).

3.6.6.3 Setting the gear clearance

and in the mounting of the top roller

In the cone gear of the drive of the top roller foot, the minimum clearance must be set. A too small clearance will increase the friction resistance of the gear, the excessive clearance will influence the inaccuracy of feeding. The top roller itself is mounted on balls. With this type of mounting, it is also necessary to set the minimal possible radial clearance.

The given clearances are set as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

Clearance in the wheel mounting

- Loosen three screws (5) /only slightly/.
- Using the screw (4) set the minimum clearance in the top roller mounting (2) /it must easily rotate without any rubbing and with a minimum clearance/.
- Tighten the screws (5), check the set up clearance, eventually, repeat the setting procedure.

Clearance in the conic gear

- Loosen the screw (1), in shifting the wheel, resp. the holder (3) in the holder groove (6), set the minimum clearance, the pinion (7) must be pushed up to the holder bottom (6).
- Tighten the screw (1), check the set up clearance.

Fig. 1

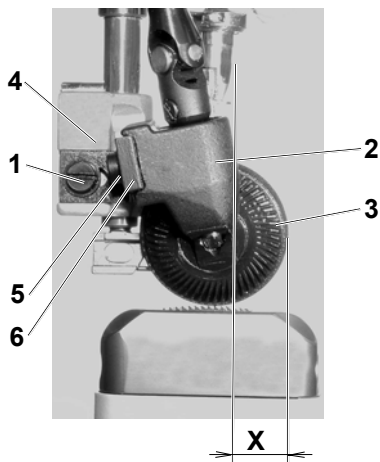
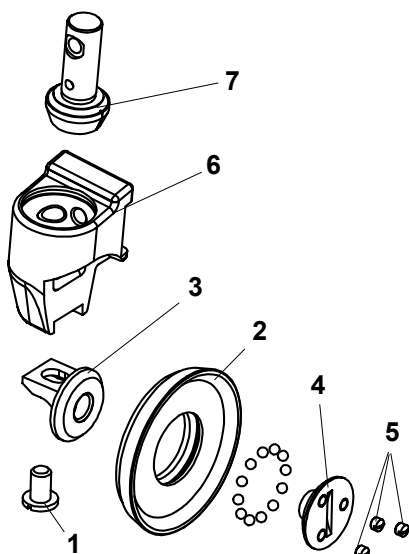
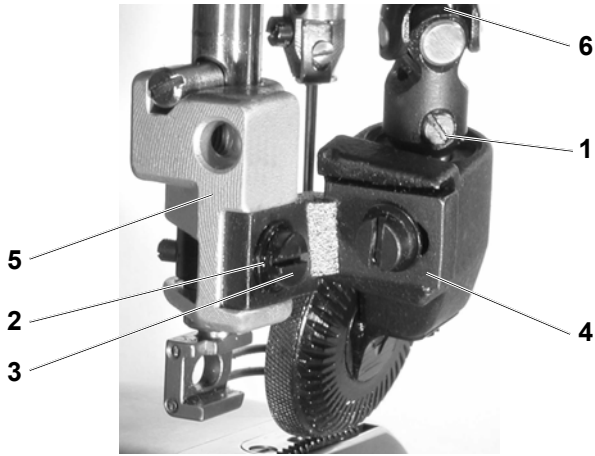


Fig. 2





3.6.6.4 Replacement of the top roller

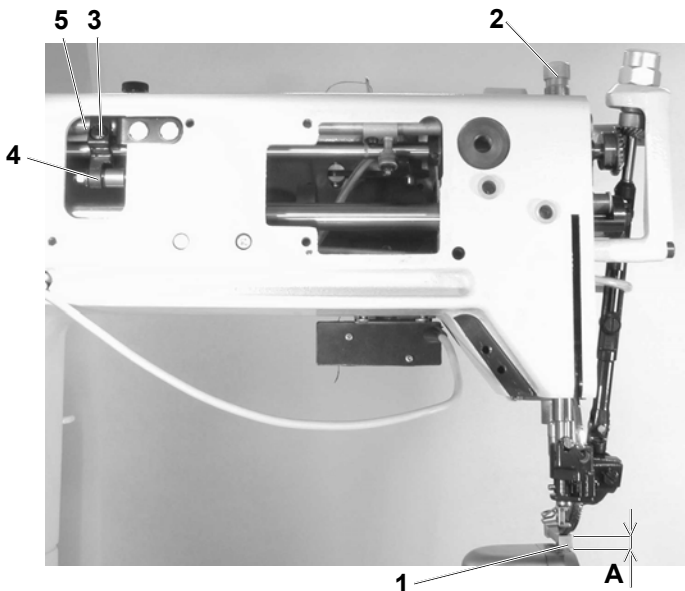
When replacing the top roller, proceed as follows:



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Unscrew the screw (1).
- Unscrew the screw (3) with the washer (2).
- Remove the driven top roller with the holder (4) from the holder (5) and from the articulated shaft (6).
- Mount another top roller in inverted procedure to dismantling.
- Set the top roller according to the par. 3.6.6.2.



3.7 Setting the presser foot lift

The maximum lift of the presser foot when lifting the foot with knee lever or with electromagnet is to be „A“ = 12.5 mm.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Place a cube (1) having the height of „A“ = 12.5 ± 0.7 mm under the presser foot.
- Screw in thoroughly downwards the screw (2).
- Tighten slightly the screw (3) in such a way that the lever (4) turns on the shaft (5) with a certain friction moment.
- Push with the screwdriver on the lever (4), until it attains the wall inside the arm of the sewing machine.
- Return the lever (4) back by about 1 mm and tighten the screw (3). With the maximum top roller lifting, the lever will not strike into the machine arm.
- Check the axial clearance of the shaft (5) which should be the least possible.
- Using the screw (4) set the normal pressure force of the presser foot.

3.8 Bobbin winder

3.8.1 Description

The winder (bobbin winder) winds a reserve of the hook thread. It is driven by a spring-mounted friction gear, which stops after having filled the bobbin.

An ideal winding is attained with a sufficient pretension of the thread obtained on the thread guide (4) and with 1 mm under the diameter of the bobbin. The shaft is mounted in a swinging way and the friction gear is put into engagement by means of a pickup lever (1) and a cam. The winder is fixed on the machine arm by two screws (3). The thread is passed through according to the illustration, the thread is cut off after having stopped the winding operation using the cutting device (5).



3.8.2 Setting the bobbin winder stop

The moment of interrupting the winding is determined by the mutual position of the pickup lever (1) and the cam (5) on a common shaft.

The cam is locked in its functional position by the screw (6). The mutual position is to be set on a not incorporated winder in such a way that in the moment, when the pickup lever leaves the space of the bobbin, the pressing function of the cam on the winder's shaft is interrupted and it moves in the sense of the arrow. A fine setting is to be done on an incorporated condition in the machine. Using the screw (2), the position of the friction part of the pickup lever (1) is adapted. In opening the lever, the stopping function is accelerated. Its inverse function delays it. A test is to be done after having inserted the bobbin, when passing the thread through the device and when winding at the running of the machine.



3.8.3 Setting the friction gear

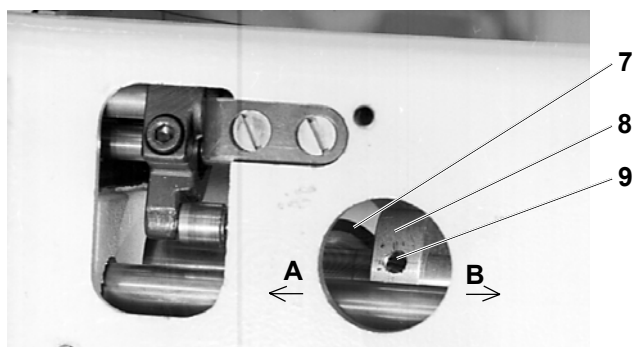
The friction gear is formed frontally by the disk (8) on the main top shaft of the machine and by the disk (7) with a rubber ring on the shaft of the winder.

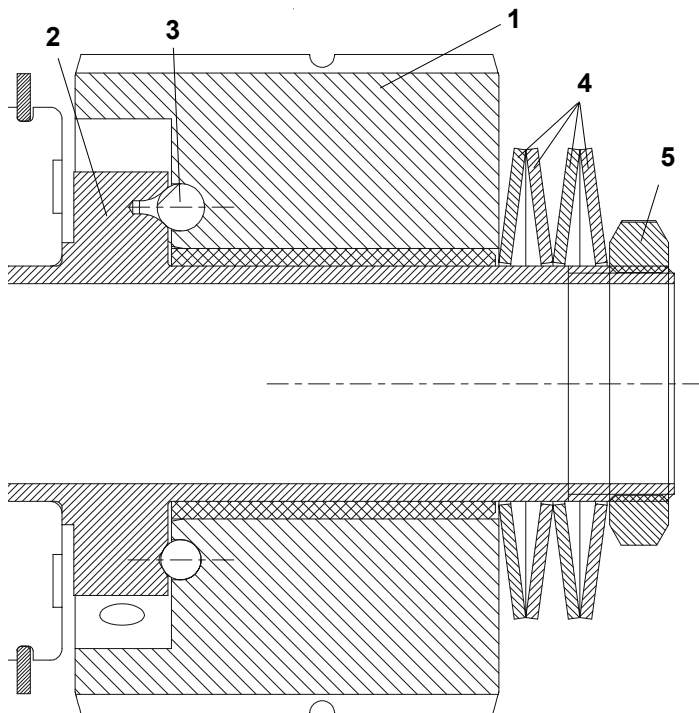


Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Proceed to the setting operation with a removed rear guard.
- The winder is in its stopped position.
- Loosen two screws (9) in the disk (8) through the hole in the arm.
- By shifting axially the disk in the sense A, B, set the disks of the winder (7) at the distance of 0.5 mm from the rubber ring.
- Tighten the screws (9) in the disk (8).
- Put the winder in its working position and proceed to a winding test.
- Mount the rear guard.





3.9 Safety clutch

3.9.1 Description

The machine is provided with a safety clutch which enables the turning through of the lower belt wheel (1) on the hub of the lower shaft (2), when the hook is blocked. This blocking occurs due to the penetration of thread into the hook path. With current running, this clutch should not disengage during the normal running. The mutual coupling of the belt wheel (1) and the hub (2) is effected by means of the bills (3) which are firmly connected with the belt wheel (1). The bills fit in the conic holes of the hub (2) and are pushed therein by means of the springs (4).

Putting the clutch in its working position, eventual checking its correct position are to be done in blocking the hook using a screwdriver and in turning a bit the handwheel.

3.9.2 Setting the disengaging moment



Caution! Danger of injury!

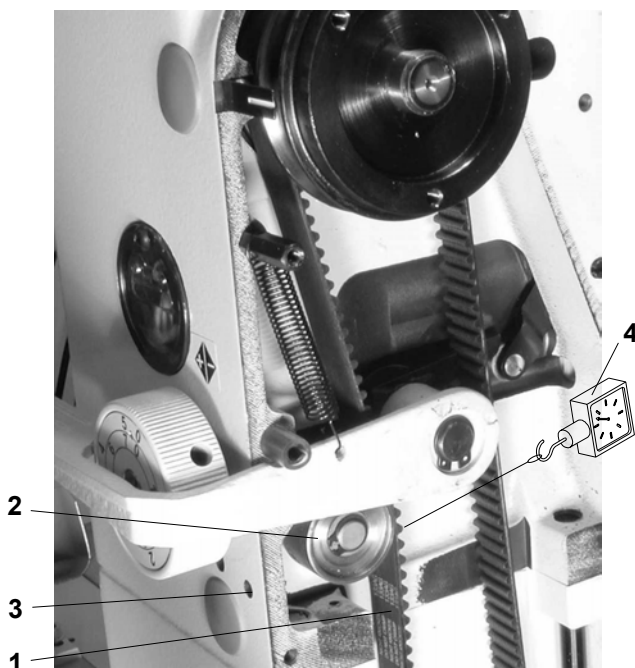
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

The correct value of the tensioning moment (8 Nm) has been set up by the manufacturer. when this value is lower, in a current running, the clutch may disengage. In an opposite case (the moment is higher), the clutch will not disengage. In both cases it is necessary to proceed to a correction of the moment. In turning the nut (5) to the right, the moment will increase and on the contrary. The value of the tensioning moment is very sensible to the turning of the nut (5). When setting it, it is necessary to proceed very carefully, set it up only in emergency cases! Check the moment using a torque-limiting wrench.



Caution!

The clutch guarantees only one mutual position of the hub of the lower shaft (2) and that of the belt wheel (1). No checking according to the gauge marks is needed. Putting the clutch out of operation by excessive tightening of the nut (5) can cause, when blocking the hook, the destruction of the gear within the drive of the hook.



3.10 Indented belt transmission

3.10.1 Setting the tensioning roller of the indented belt

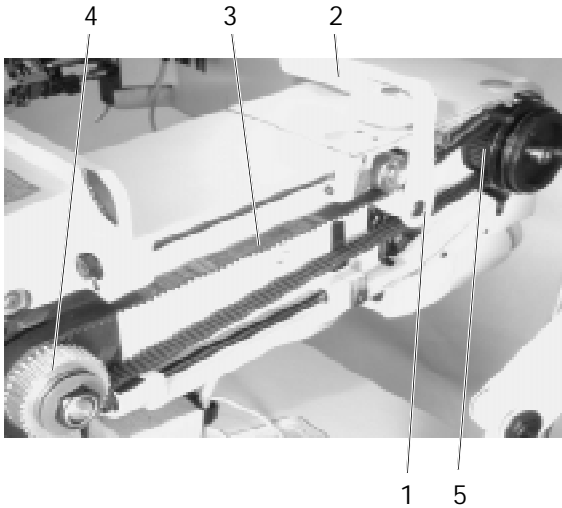
The optimum tension of the indented belt (1) is attained in setting the tensioning roller (2) in such position, when the roller applies the pressure of $F = 20 \text{ N}$ against the belt. The roller must be side set in such a way that the edge of the indented belt does not overlap over the edge of the roller.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the handwheel and the belt guard, remove the V-belt.
- Unlock the fastening of the loop, on which the roller (2) is mounted in such a way that the loop turns freely.
- Lift the roller (2) upwards and, thereafter, using the dynamometer (4), pull horizontally the roller in applying the force of 20 N. In this position, tighten the fastening screw (3).
- Check the side shifting of the roller.



3.10.2 Replacing the indented belt

To observe: in machines with Mini-stop first remove the driving toothed belt as instructed in par. 3.12.

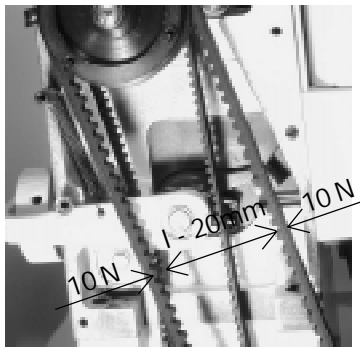
When replacing the indented belt, the mutual position of the pulleys (4 and 5) should be maintained.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Remove the handwheel, the belt guard and the V-belt.
- Remove the retaining ring (1) and remove the backtacking lever (2).
- Mark with a pencil the instantaneous position of the indented pulleys against the machine head in any position.
- Remove the indented belt (3) from the bottom indented pulley (4) first, and then remove the whole belt.
- Apply a new indented belt on the top indented pulley (5) first.
- Turn both indented pulleys in the formerly marked positions and apply the indented belt on the indented pulley (4).
- Tension the belt and mount the dismantled components in the inverse order.



3.11 V-belt, motor - head

3.11.1 Tensioning



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

The belt is correctly tensioned, when the opposite sides of the belt approach one to another by up to 20 mm in applying the force of 10 N. The belt is tensioned in turning respectively the motor in its holder.

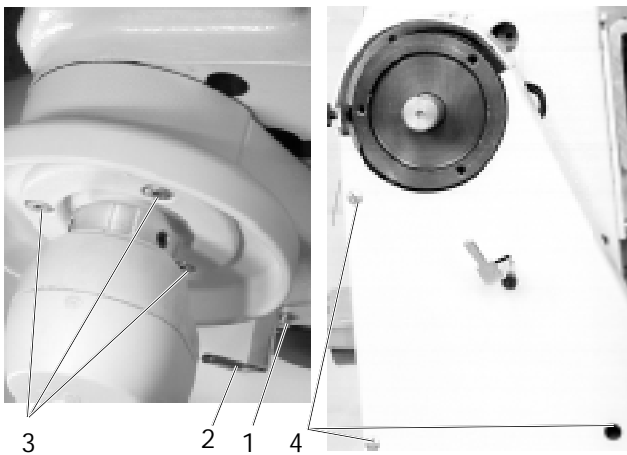
3.11.2 Replacing the V-Belt



Caution! Danger of injury!

Switch off the main switch! before starting the setting operation, wait until the motor stops!

- Loosen the screw (1) of the positioner arrest (2) and tilt the arrest.
- Unscrew the screws (3) of the handwheel.
- Unscrew the screws (4) of the belt guard and tilt the guard.
- Remove the belt guard of the motor and tilt the protections against falling out the belt from the motor pulley.
- Replace the belt.
- Tension the belt (see par. 3.11.1).



3.12 Driving toothed belt

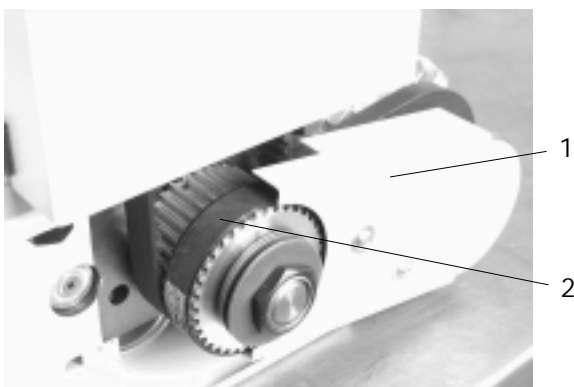
3.12.1 To exchange the driving toothed belt

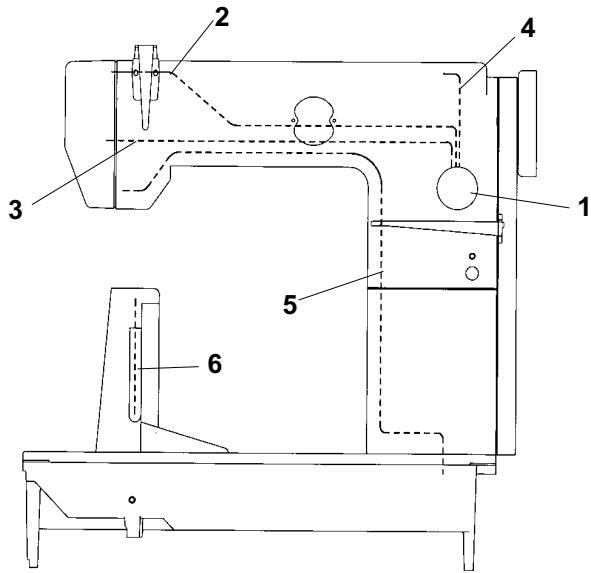


Caution! Danger of injury!

Switch off the main switch! before starting the setting operation, wait until the motor stops!

- Remove the machine head from the stand (uncouple the motor cables, the machine head cable and screw off the wood screw and the screw from the hinges).
- Remove the belt guard (1).
- Replace the belt (2).



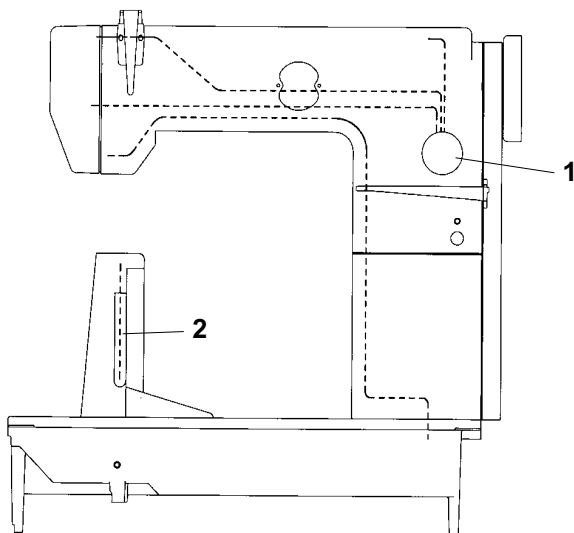


3.13 Lubrication

3.13.1 Description

From the lubricating tank (1) there issue three suction wicks. The wick (2) lubricates the pin of the thread mechanism, the wick (3) lubricates the needle mechanism and the wick (4) lubricates the stitch length mechanism. The superfluous oil from the needle and thread mechanisms is sucked off by the wick (5) and lubricates the shifting wedge of the feeding clutch.

The hook has its own oil reservoir (6). The superfluous oil from the hook lubrication lubricates the driving gear of the hook.

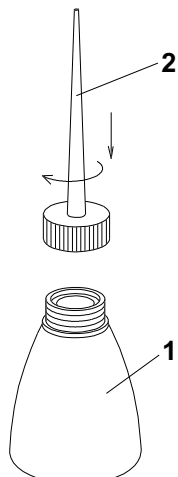
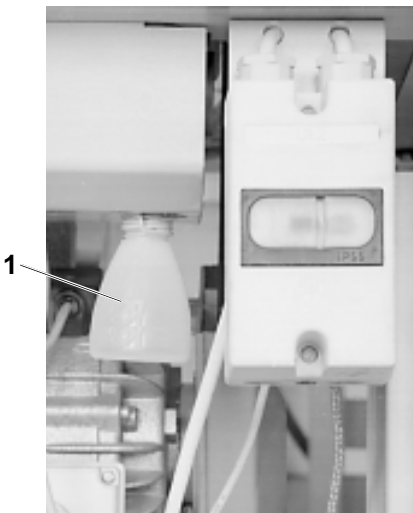


3.13.2 Refilling oil

For lubricating the machine oil Esso SP-NK 10, DA 10 is used or other oil with the same quality. When putting the machine into operation, each mechanism of the machine is to be lubricated with several drops of oil. Oil is only refilled thereafter into the oil reservoirs using an oil can into the holes in the oil level indicators.

The oil tank (1) of the central distribution is to be filled up to the mark max.

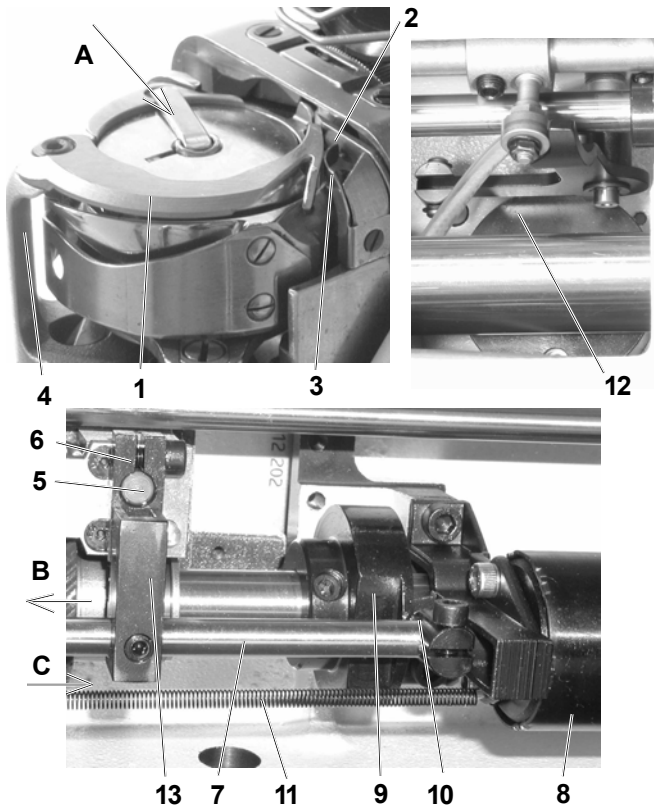
The oil tank (2) of the hook lubrication is to be filled up to the upper edge.



3.13.3 Multiple oil use

Oil which runs into the oil cup is collected in the collector (1) and may be reused for refilling the oil reservoirs in the machine - see par. 3.13.2.

The oil collector (1) with the collected oil is unscrewed and the top part of the oil can (2) which is added in the machine packing is screwed in. Oil is then refilled into the reservoirs on the machine head and everything is put into the original condition.



4. Thread trimming

4.1 Description of the trimming mechanism

During the trimming cycle, the moving trimming knife (1), in an opportune moment, hooks up the sewing threads and pulls them in the sense of the arrow (A) against the fixed knife (2) until the threads are trimmed. The spring (3) holds the hook thread after being trimmed off. The moving trimming knife (1) is fastened on the holder (4) and the holder is fastened on the shaft (5). This shaft is turned by means of the lever (6) under the effect of the fork (13) fastened on the shaft (7), which is shifted by the electromagnet (8) from its starting position in the sense of the arrow (B). When moving back in the sense of the arrow (C), the shaft (7) is shifted by the cam (9) through the pickup roller (10) into the starting position. The spring (11) maintains the mechanism in its starting position. The electromagnet (12), in an opportune moment, loosens the main tensioner. At the end of the trimming cycle, both electromagnets (8 and 12) are switched off.

4.2 Setting the pickup roller

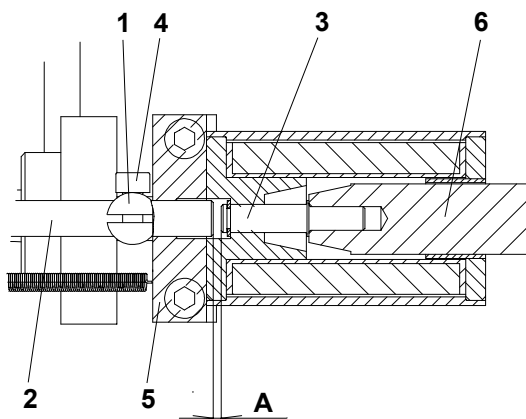
The holder of the pickup roller (1) is to be fixed in such a way that it is positioned, in its starting position, between the shaft (2) and the shaft (3), the respective gap „A“ = 0.2 to 0.4 mm.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- With the loosened screw (4), put the holder of the pickup roller (1) up to the stop against the bracket (5) and, at the same time, the shaft (2) up to the stop against the shaft (3).
- With the holder (1) held on the stop, shift the shaft (2) in such a way that there appears the gap „A“ = 0.2 to 0.4 mm, and tighten the screw (4).
- Check the gap „A“ in shifting the armature (6).



4.3 Setting the cam

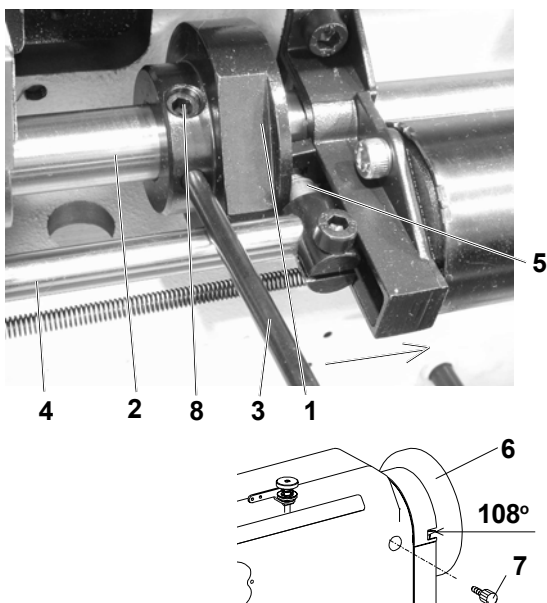
The position of the cam (1) against the shaft (2) is to be such, so that when the adjusting pin is in contact with the shaft (4), the protractor scale of the handwheel (6) shows just the angle of 108°. If the pickup roller (5) is in its starting position of rest, the clearance between the roller (5) and the cam (1) should be as small as possible but sufficient to prevent the cam from getting into accidental contact with the roller.

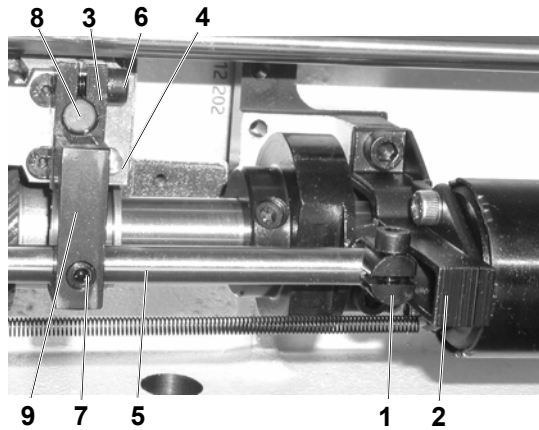


Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Set the angle of 108° on the handwheel (6) and lock it with the screw (7) which is included in the accessory of the machine (tighten with care).
- Shift the pickup roller (5) in the sense of the arrow up to the stop.
- Insert the adjusting pin (3), which is included in the accessory, into the cam and turn the cam, until the pin (3) gets the contact with the shaft (4).
- Insert a gauge having the thickness of 0.1 mm between the cam (1) and the pickup roller (2) and shift the cam against the gauge up to the stop. Tighten then the screw (8).
- Loosen the blocking of the handwheel, turn a bit the cam and tighten the second fastening screw of the cam too.





4.4 Setting the fork

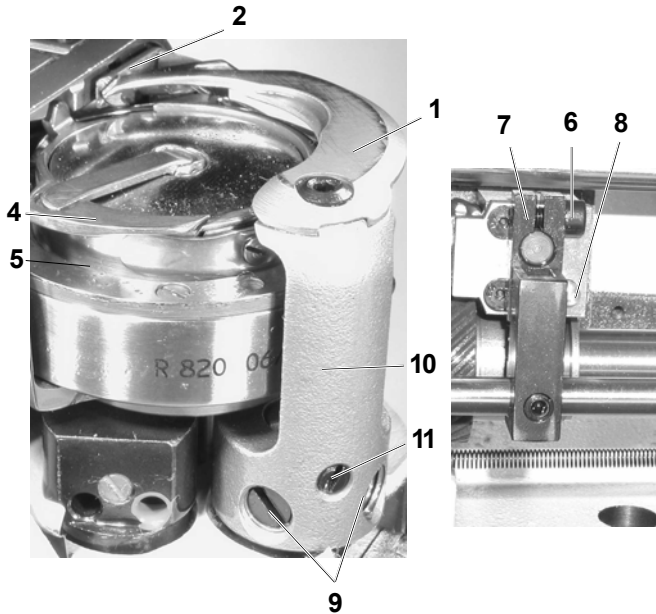
In the starting rest position of the trimming mechanism, when the holder (1) is in contact with the console (2), the lever (3) must be in contact with the stop (4).



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Shift the shaft (5), until the holder (1) strikes the bracket (2).
- Loosen the screw (6) and (7).
- Shift the lever (3) to the stop (4) /mind the axial clearance of the eccentric shaft (8)/ and tighten the screw (6).
- Slip on the fork (9) on the pin of the lever (3) and retighten the screw (7).



4.5 Setting the moving knife

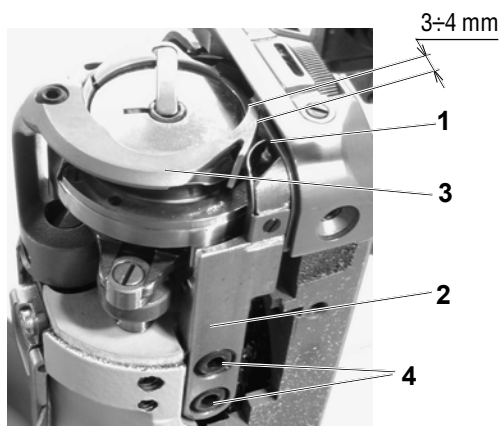
The movable trimming knife (1) is to be, in its starting rest position, in alignment of its end with the edge of the fixed trimming knife (2). It is to be set in height in such a way, so that its bottom surface (3) passes above the surface (4) of the middle part (5) of the hook with the clearance of about 0,3 mm.



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- Loosen the screws (6) of the lever (7).
- Turn the movable trimming knife (1) in alignment with the fixed knife.
- Tighten the screw (6) /the lever (7) must be leaning against the stop (8) and the axial clearance of the trimmer shaft must be maintained/.
- Loosen the screws (9) of the knife holder (10).
- In turning the screw (11), set the height of the movable trimming knife (1). Tighten the screws (9).



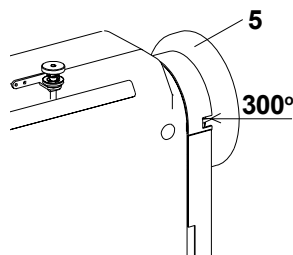
4.6 Setting the fixed knife

The fixed trimming knife (1) is to be spring loaded through swinging out of the knife holder (2) in such a way, so that it fits on the movable trimming knife at the distance of about 3 - 4 mm from the end of the movable knife. In its height position, the fixed knife is to be set with its upper surface above the movable trimming knife (3) by about 0,1 mm. The knives need not to trim untensioned threads.

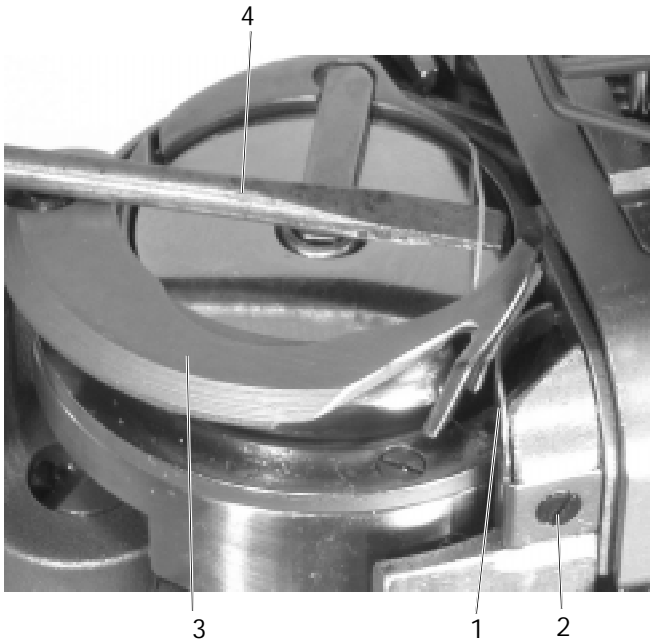


Caution! Danger of injury!

Switch off the main switch. Before starting the setting operation, wait until the motor stops!



- With loosened screws (4), proceed to the height setting of the knife.
- Tighten slightly the bottom screw (4).
- Set the angle of about 300° on the handwheel (5).
- Shift by hand the moving knife (3) into the marked position.
- In swinging out the knife holder (2) set by way of trial the spring loading of the fixed trimming knife (1).
- Tighten both screws (4).
- Check the bearing spot of the moving trimming knife (3) on the fixed trimming knife (1) and give it a correction, if needed.



4.7 Setting the retaining spring of the hook thread

The retaining spring (1) holds the hook thread after having performed the trimming. It is to be set in such a way that the force necessary for pulling out the thread from the retaining spring (1) is approximately equal to the force necessary for pulling out the thread from the hook.



Caution! Danger of injury!

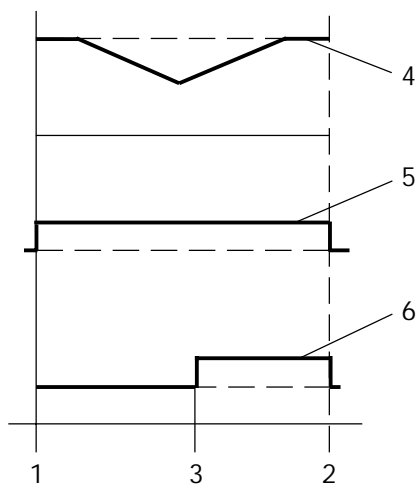
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- In an emergency case, shape the retaining spring (1) in such a way that it fits close with all its surface (without wedge) onto the moving trimming knife (3) and so that, with the slightly tightened screw (2), onto the moving trimming knife without any pressure.
- Tighten the screw (2), until the necessary force for pulling the thread from the retaining spring is attained. The pulling force is tested using a screwdriver (4) according to the illustration.



Caution!

The setting of the retaining spring (1) depends on the setting of the hook thread tension and differs then according to the respective sewing category.



4.8 Setting the switching of electromagnets

The electromagnets of the trimming device and loosening of the tensioner must work in accordance with the diagram. This is ensured by setting the stopmotor (see the instructions for use of the stopmotor).

- 1- 1. position of the needle (135° on the handwheel);
- 2- 2. position of the needle (64° on the handwheel)
- 3- position of stopping the tensioner (10° ÷ 25° on the handwheel)
- 4- movement of the pickup roller of the trimmer cam
- 5- current of the trimming device electromagnet
- 6- current of the tensioner loosening electromagnet

5. Lifting the top roller by electromagnet

5.1 Description

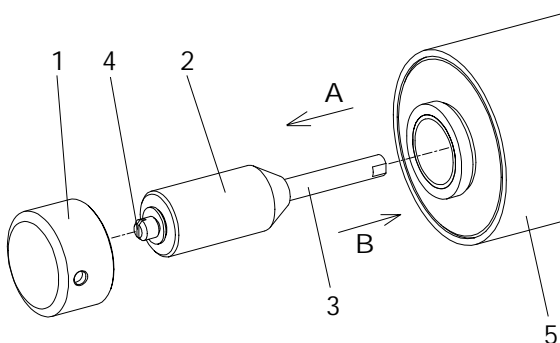
The core of the electromagnet, respectively its pin must be set in such a way that the presser foot lifting is enabled.

5.2 Setting the electromagnet pin



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!



- Unscrew the cap of the core (1) of the electromagnet.
- Shift the core (2) with the pin (3) and unscrew the locking screw (4).
- Unscrew the pin (3) in the core (2) in the "A" direction up to the stop.
- Push the core (2) into the magnet (5) in the "B" direction up to the stop.
- In this position, set the maximum top roller lifting in the "B" direction.
- Screw on and tighten the arresting screw (4).
- Screw on the cap (1).

5.3 Setting the electromagnet current

- The time response of the current of electromag. has 2 phases:
- initial switching on (0,2 ÷ 0,5 s) - the maximum force
 - maintaining (when keying)



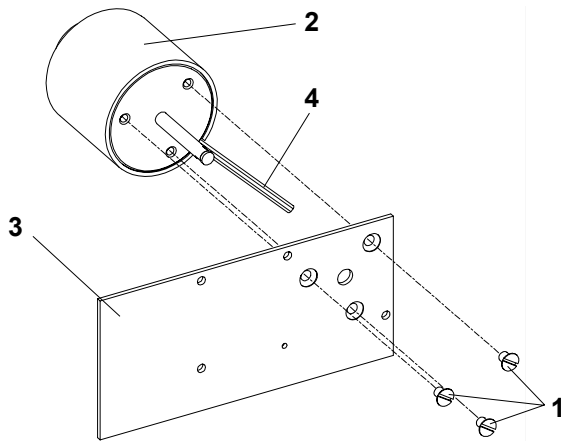
It is necessary to set max. 40 % of keying (see instructions for use of the stopmotor). With a higher value thereof and with a long period of the presser foot in its lifted position there is a danger of electromagnet overheating.

5.4 Assembly of the top roller lifting electromagnet



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!



- Remove the rear guard (3).
- Using the screws (1), fasten the electromagnet (2) on the rear guard (3) with the given orientation of the outlet cable (4).
- Mount the rear guard (3).
- Connect the outlet cable (see par.7).
- Set the pin of the electromagnet (see par. 5.2).
- Set the current of the electromagnet (see par.5.3).

6. Backtacking using electromagnet

6.1 Description

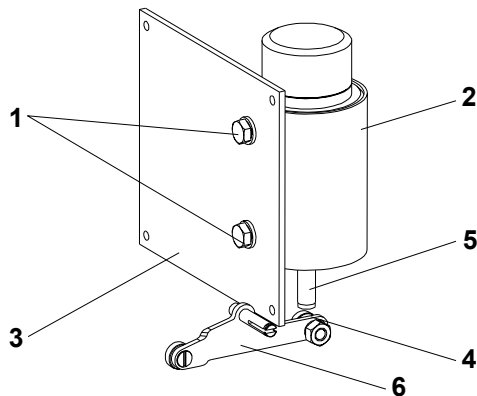
The position of the electromagnet with regard to the backtacking lever must be set in such a way that it enables the maximum stitch length when sewing in forward and in rearward sense. If this position is not correct, the length of the stitch will be shortened in one or the other feed direction.

6.2 Electromagnet height setting



Caution! Danger of injury!

Switch off the main switch! Before starting the setting operation, wait until the motor stops!



- Set the position of the electromagnet (2) in the upper position of the grooves of the guard (3).
- Proceed to the mounting of the guard (3) with the magnet on the machine head.
- Set the maximum stitch length and push the reverse stitching lever into its bottom position (as with the reverse stitching operation).
- In this position, the bar (5) must be in contact with the roller (4) of the lever (6). Otherwise shift the electric magnet (2) in the grooves of the guard (3).

6.3 Setting the position of push-buttons



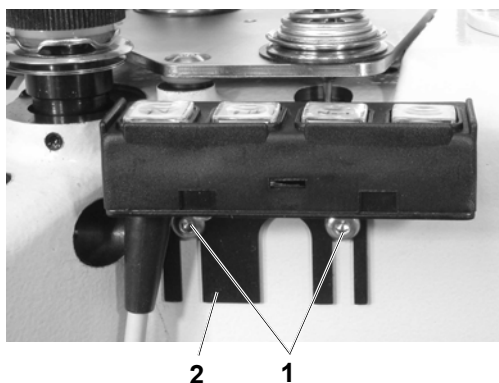
Caution! Danger of injury!

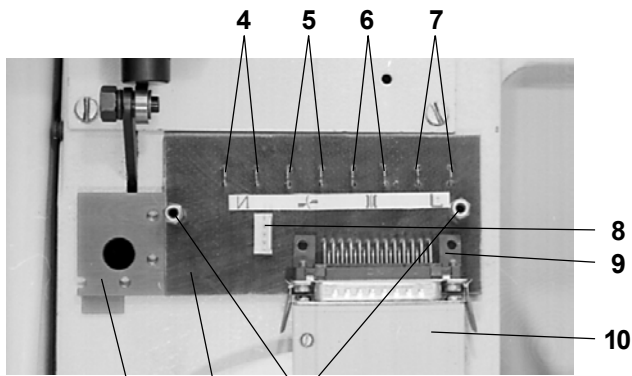
Switch off the main switch! Before starting the setting operation, wait until the motor stops!

- By loosening the screws (1), it is possible to set the position of the holder of the push-buttons (2) in the sense of sewing.

6.4 Change of the function of push-buttons

The Function of the push-buttons can be changed in accordance with the possibilities given by the stopmotor (see instruction for use of stopmotor).



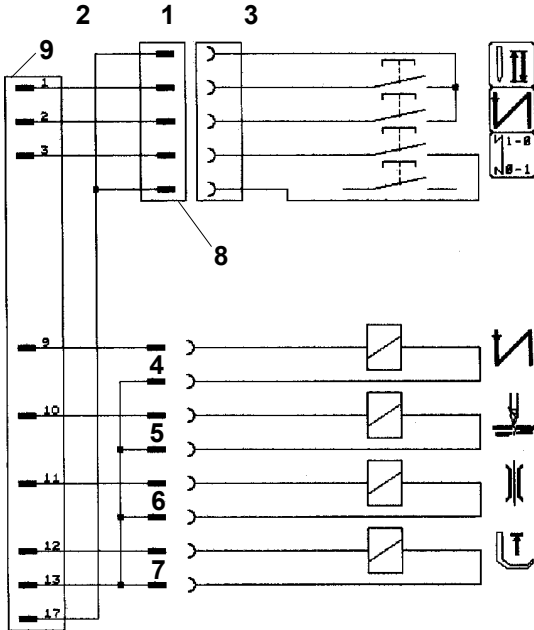


7. Connecting the electric elements on the machine head

The connection of the electric elements (electromagnets, backtacking, presser foot lifting, thread trimming, loosening of the tensioner and push-buttons) is made by means of a switchboard (1) fixed with its supporting plate (2) on the rear side of the head by means of two distance screws (3) (In the Fig., these electric elements are disconnected).

Connecting spots :

- 4 - backtacking electromagnet
- 5 - trimming electromagnet
- 6 - tensioner loosening electromagnet
- 7 - presser foot lifting electromagnet
- 8 - connector of push-button connecting
- 9 - connector of coupling the head with the stopmotor
- 10 - connecting cable of the head and stopmotor



Wiring diagram of connecting the electric elements of the machine head.

8. Drive, control panel, position sensor

The detailed information concerning the drive, the control panel and the setting of the position sensor is given in the manual of the drive and of the control panel.

9. Maintenance



Caution! Danger of injury!

The maintenance operations should be performed only with the machine switched off and with the motor stopped!

In the following table there are given the operations which should be performed and the respective time intervals between the individual operations.

Operation	Time interval
Removal of the throat plate and its cleaning out. Cleaning out of the wheel feeder, hook and their surrounding space. Removal of the residues of material and threads from the top roller.	1 day
Checking of the oil level in the oil tank of the hook.	1 week
Checking of the oil level in the central oil tank.	1 month
Checking the hook wear. Checking the function of the safety clutch against the hook overload.	6 months
Checking the V-belt and the indented belts.	1 year

10. Setting the machine according to the sewing category

10.1 Introduction

This sewing machine enables sewing operations within a large extent from the light up to the heavy-duty sewing. The parameters of the respective sewing operation must be in accordance with the given machine setting which includes also the replacement of some components, such as the needle, the throat plate insert, the top roller. For this reason, the setting of the machine is divided into 4 categories:














- 1 ... light sewing
- 2 ... medium sewing
- 3 ... medium heavy-duty sewing
- 4 ... heavy-duty sewing

In the factory, where this machine has been manufactured, the machine has been set with respect to the standard parameters of the required sewing category which is designed by the number included in the commercial designation of the machine. If the user desires changing the given setting to another sewing category, this operation should be performed by a specialized mechanician.

The standard parameters of sewing are described in the following paragraph. The actual parameters of sewing inside the given sewing category may be different, which means that the machine operative must adapt respectively the setting of the machine, e.g. the tension of the upper thread.

10.2 Table of setting the machine according to the sewing category

Commercial designation of the machine 4180i - 5XX - X

Sewing category	Standard sewing parameters				Standard machine setting ¹⁾										
	Thickness of one material layer 2)	Number of material layers	Stitch length	Label number of thread PES	Needle size 7)	Sewing speed	Position of feeding lever pin	Width of needle plate insert	Feeder - pitch of teeth hole 8)	Presser top roller diameter	Presser top roller position	Thread tension ⁴⁾		Splice of hook	
												needle thread	hook thread 6)		
															
	m m		m m		0.01 mm	SPM		m m	m m	m m	m m	N	N		
-100	0.8	2	1.7	70	80	2500	1	1.2	0.4	35	10.5	3	1	● 9)	●
-200	1	2	2.2 2.5	40	100	2500	1	1.5	0.4	35	10.5	4,5	1.5	● 9)	●
-300	1.5	1-2	3.5	20	130	1600	1	2	0.6	35	10.5	5-8	2		●
-400	2	1-2 or 2-3	5	10 (20) 5)	160	1600	2 3)	2.4	1.2	35	10.5	10-12	2-2.5		●

Setting as per chapter

Instructions for service			3.5.3.1.2	3.3.2	3.5.3.2.2	3.6.6.1	3.6.6.2				
Instructions manual	6.5							6.4	6.4		
Instructions for assembling		2.4 4.5									

- 1) The standard setting of the machine for the categories 3 and 4 concerns a decorative stitching, when it is difficult to match a good stitch interlocking with a faultless function of the thread trimming device. Otherwise, when sewing material of considerable overall thickness, it will be necessary to increase the overtopping of the teeth above the needle plate and to increase also the needle thread tension.
- 2) The thickness of a layer is measured using an engineer slide calliper with the pressure of jaws of about 10 N.
- 3) If the user will agree with the maximum stitch length of 5 mm, the pin of the feeding lever can be left in the position 1.
- 4) The values of tension are only orientative ones and it is necessary to adapt especially the tension of the hook thread according to the stiffness of the material. An excessive tension of the threads when sewing soft materials causes material wrinkling.
- 5) When performing decorative sewing, it is possible to use the hook thread having the label No 20 - the interval between the two replacements of the hook bobbin will be double.
- 6) When changing markedly the sewing category together with changing the tension of the hook thread, it is necessary to modify the tension of the retaining spring of the trimming device according to the paragraph 4.7.
- 7) When changing markedly the sewing category together with a marked change of the needle number, it is necessary to correct the setting of the distance of the hook from the needle, according to the paragraph 3.1.3.
- 8) There are in use various types of feeders with the purpose of avoiding imprinting the teeth in the lining leather. Otherwise, it is possible to use any feeder.
- 9) The splice with the so-called spur may be used with the sewing categories 100 and 200 and is designed for sewing thin materials.
In the production factory, the gib without spur is mounted as standard.
When using the gib with the so-called spur, we recommend carrying out the setting of the pin of the thread mechanism (par. 3.2.4) for the sewing category 400.