

INSTRUCTION MANUAL

GLOBAL
& **STROBEL**
SHOELINE

MODEL 444 - 2

GLOBAL & STROBEL SHOELINE

MODEL 444 - 2

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To continue, tap on screen.

HOME SCREEN

Main Screen



Press to open main screen

Operator Mode



Edit work options

Check I/O



Press to check input and output

Info



General information about the machine

Setting 1



Press to create / edit a program

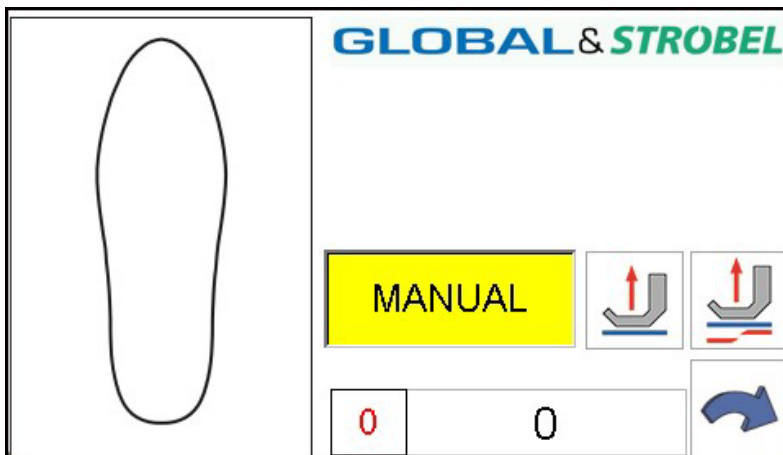
Setting 2



Press to enter technical level

MAIN SCREEN

Fig.2 **Manual operation**



by pressing left pedal gathering will be activated as pre-programmed

Press and enter required gathering value (%). **value -1** releases front cup to turn freely

To switch from manual to automatic sewing mode:

Press button, confirm yes on the pop up screen and will appear.

Fig.3 4 section pre-programmed automatic operation

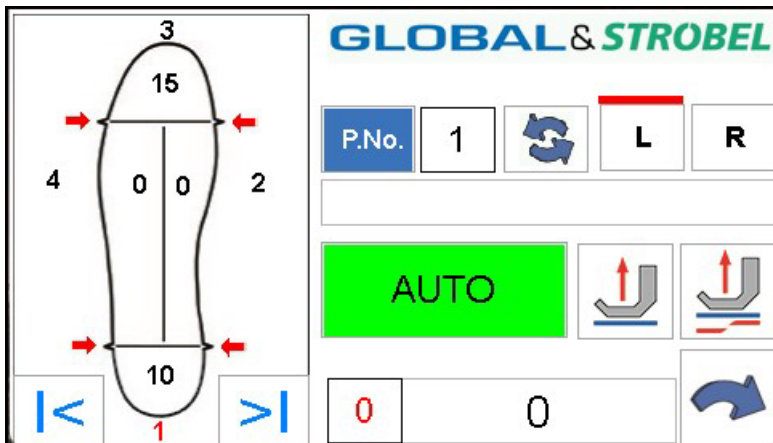


Fig.4 6 section pre-programmed automatic operation

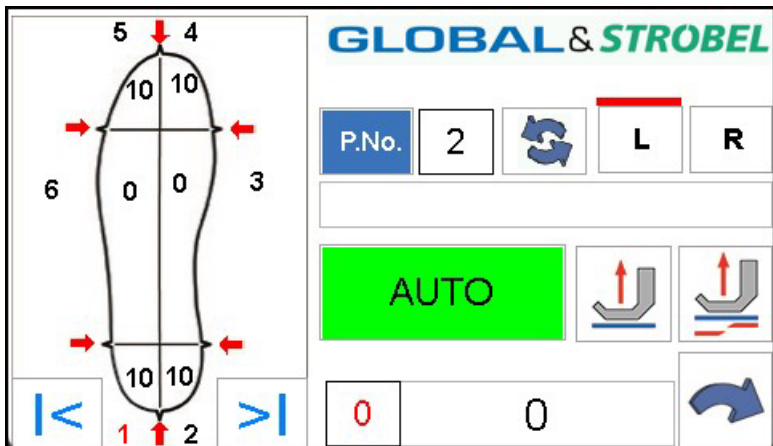
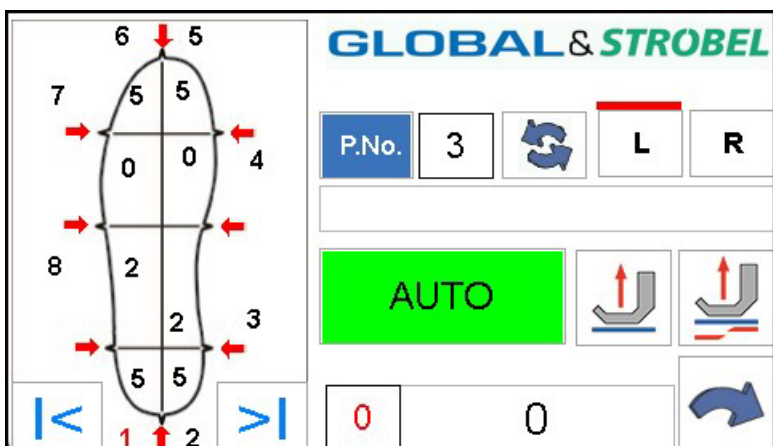


Fig.5 8 section pre-programmed automatic operation





when this button is enabled feed cup will open at every stop during sewing



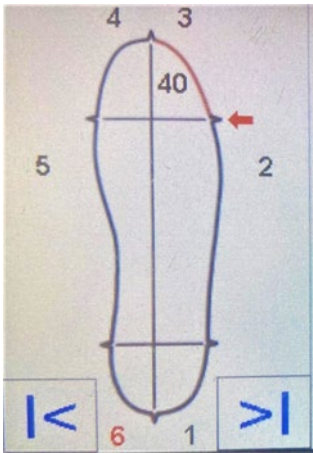
when this button is enabled feed cup will open after thread trimming, or on a machine without thread trimmer, when cycle is finished and pedal is heeled back.



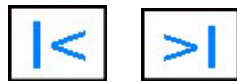
shows actual sewing program



Turn on cycle sewing mode: Select sewing cycle, in pairs or button **L** for only left shoes or button **R** for only right shoes.



select the starting point for left and right shoe separately by touching the number of the section as wanted, number will light up in **red**



by using these buttons program switches from section to section. By pushing on the required section, values for gathering can be given / changed. Figures shown within these sections are the gathering values in %, which are programmed for that section.

Value -1 means that front cup runs freely

During sewing there is also the possibility to increase the gathering manually up to 75% by using the left pedal

All of above described functions also can be programmed at SETTING 1.



by using these buttons or the knee switch , switch from section to section.



Shows present section sewing



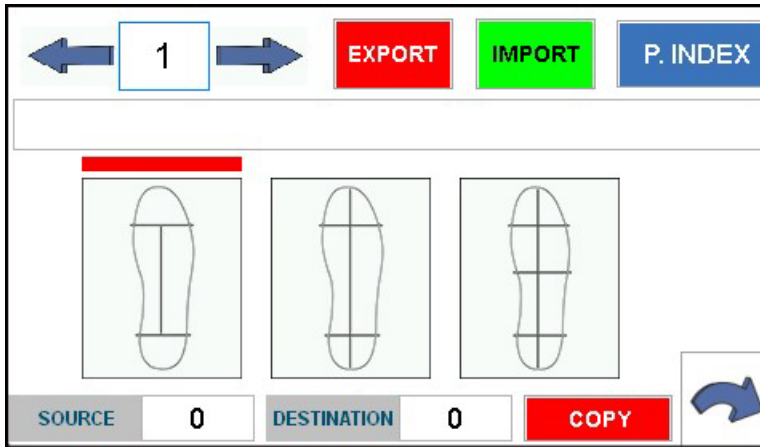
push button for change, delete, edit or create a new program



Back to Main screen

EDIT / CREATE PROGRAM

Fig.6

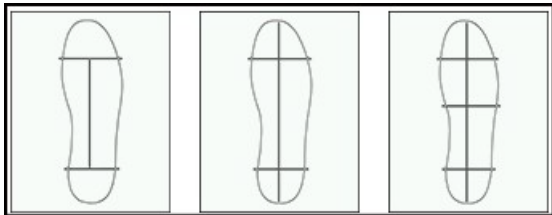


Select Program Number


Scroll to desired program number with left and right arrows or type program number on screen.

After choosing program number, sewing style can be selected visually from the screen.

sewing style: 4, 6 or 8 sections



Model No. or name can be written in the blank section

Parameters are automatically saved when  button is pressed



all programs created on one machine can be exported or imported to other machines by using a USB stick.

Put a USB stick in the machine select export and all programs will be loaded on the USB.

Put the USB stick in the other machine(s) and push import to load the programs in the machine

P. INDEX

Program index: shows a list of all programs to select or delete existing programs.

| | | | | | | | |
|----|----|--------|---|----|----|-------|---|
| 1 | OK | 1 | X | 11 | OK | X | |
| 2 | OK | 2 | X | 12 | OK | HIPPY | X |
| 3 | OK | TEST | X | 13 | OK | X | |
| 4 | OK | JOHN | X | 14 | OK | X | |
| 5 | OK | STEVE | X | 15 | OK | X | |
| 6 | OK | ROY | X | 16 | OK | X | |
| 7 | OK | | X | 17 | OK | X | |
| 8 | OK | RAINER | X | 18 | OK | X | |
| 9 | OK | | X | 19 | OK | X | |
| 10 | OK | | X | 20 | OK | JOHN | X |

Navigation arrows: right arrow and left arrow.

Copy existing program if required.

| | | | | |
|--------|---|-------------|---|------|
| SOURCE | 0 | DESTINATION | 0 | COPY |
|--------|---|-------------|---|------|

first enter the number of the program to be copied at source, then choose destination and push copy button.



Back to Main screen

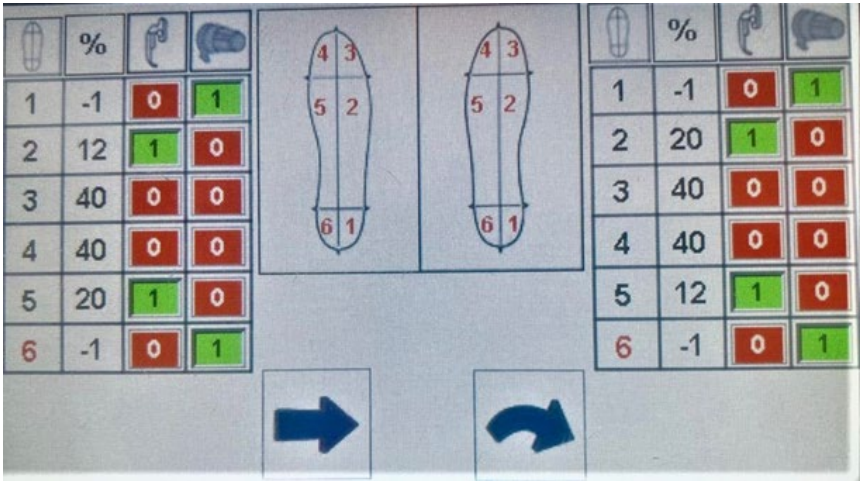


Setting 1

Press to create / edit program

SETTING 1/PAGE 1

Fig.7 programming



shows programmed values for gathering. When creating a program for the right shoe, the program for the left shoe will be created automatically.

In this screen you can program for each section the percentage of gathering by entering the required value in %. Push on required fields to enter values

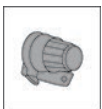
Also for each section, options such as gathering device and second tension can be selected which will be activated automatically during sewing. push on required fields to enable / disable functions.



activates gathering device in selected section

0: disabled

1: enabled



activates second tension in selected section

0: disabled

1: enabled



input of gathering percentage value for each section

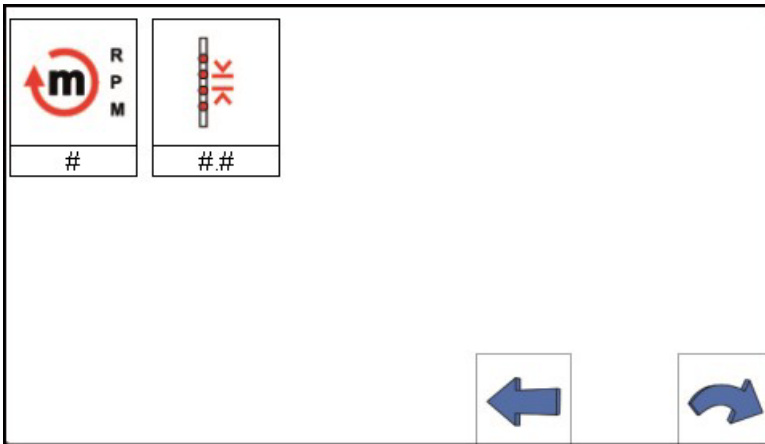


To Next page

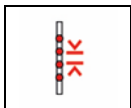


Back to Main screen

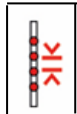
Fig.8



setting maximum speed RPM



Stitch Density.



1. Set required stitch length here
2. Set stitch dial on hand wheel at same value.
3. Set gathering value on zero.
4. Stitch two layers of at least 25 cm. firm material and check whether transport is equal.



In this case increase stitch length on hand wheel



In this case decrease stitch length on handwheel



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Back to Main screen

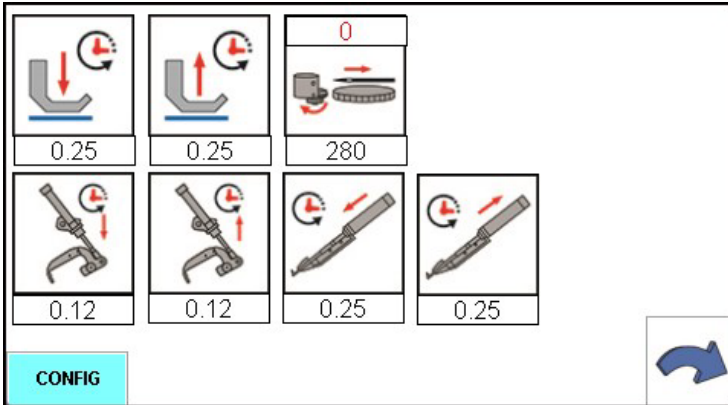


Setting 2

Press to enter technical level.

SETTING 2/ PAGE 1

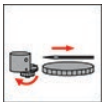
Fig.9



time delay of motor running after feed cup is closed



time delay of feed cup opening after motor stop running



This value is to synchronise the feed motion of the front cup to machine transport. Turn the handwheel of the machine manually, when cup of the machine starts transporting, the value shown must be entered.



time of feed cup opening when gathering device comes in



time of feed cup opening when gathering device returns to home position



time delay of thread trimmer when comes in



time delay of thread trimmer returning



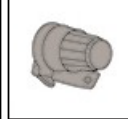
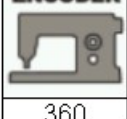




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CONFIG

CONFIGURATION PAGE

Fig.10

| | | | | | |
|---|---|---|--|--|---|
| IN | | | SAVING MACHINE | | OUT |
| 0.00 | 4.16 | Set Max | MOTOR RPM | ACTUAL RPM | 0.00 |
| | 2.75 | Set Start | 1800 | 0 | |
| | 1.16 | Set Neutral | PEDAL RPM | RPM LIMIT | |
| | 0.61 | Set -1 | 1500 | 1700 | |
| | 0.02 | Set -2 | START | HO HSING MOTOR | |
|  |  |  | ENCODER  360 |  34.54 |  |

HO HSING MOTOR motor characteristics adjustments

| | |
|------|-------------|
| 4.16 | Set Max |
| 2.75 | Set Start |
| 1.16 | Set Neutral |
| 0.61 | Set -1 |
| 0.02 | Set -2 |

1.16 Set Neutral entering value when pedal in neutral position

When pedal is in neutral position, voltage value which is shown here

| |
|------|
| OUT |
| 0.00 |

 must be entered in this section

| | |
|------|-------------|
| 1.16 | Set Neutral |
|------|-------------|

2.75 Set Start entering value when motor starts running

push the sewing pedal slowly and actual sewing speed will be shown here

| |
|------------|
| ACTUAL RPM |
| 0 |

 as soon as the motor starts running (not more than 300 RPM) the voltage value shown here

| |
|------|
| OUT |
| 0.00 |

 should be entered in this section (set start)

| | |
|------|-----------|
| 2.75 | Set Start |
|------|-----------|

4.16 Set Max

entering value for maximum speed

maximum speed which is set here

| |
|-----------|
| RPM LIMIT |
| 1700 |

, to set the voltage value here (set max)

| |
|---------|
| 4.16 |
| Set Max |

push the pedal full down and actual speed will be shown here

| |
|------------|
| ACTUAL RPM |
| 0 |

 when maximum speed is reached

| |
|------|
| OUT |
| 0.00 |

the voltage value which is shown here

| |
|---------|
| 4.16 |
| Set Max |

 must be entered here at set max.

0.61 Set-1

entering value when pedal is in half heelback position

When pedal is half heeled back, the value shown here

| |
|------|
| OUT |
| 0.00 |

, must be set in SET-1

| |
|-------|
| 0.61 |
| Set-1 |

0.02 Set-2

entering value when pedal is in full heelback position

When pedal is fully heeled back, the value shown here

| |
|------|
| OUT |
| 0.00 |

, must be set in SET-2

| |
|-------|
| 0.02 |
| Set-2 |

after entering all the values push

| |
|------|
| STOP |
|------|

 button and

| |
|-------|
| START |
|-------|

 will light up.



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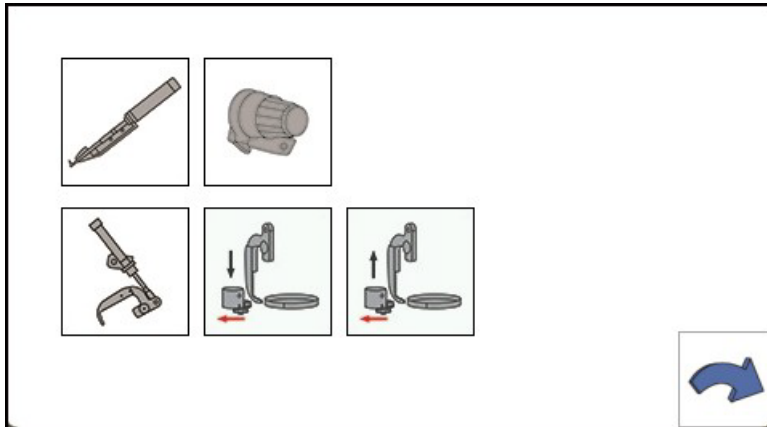


Operator Mode

Edit work options

only the options which are configured at set up of the machine, will be shown in operator mode page.

Fig. 11



enable/ disable threadtrimmer



enable/ disable second tension



enable/ disable gathering device



enable/ disable front cup opening when gathering device comes in.
(only when gathering device is enabled)



enable/ disable front cup opening when gathering device returns to home position.
(only when gathering device is enabled)



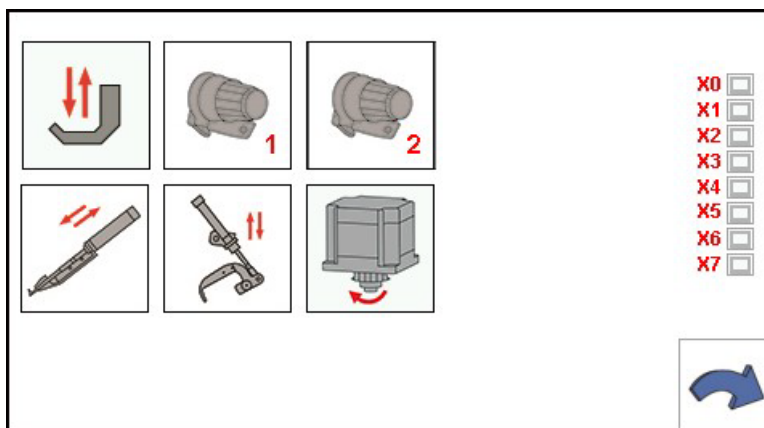
Back to Main screen



Check I/O

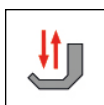
Press to check input and outputs

Fig 12



OUTPUTS

only the options which are configured at set up of the machine will be shown in this page.



cup feed opening



first tension (only in combination with thread trimmer)



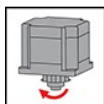
second tension



thread trimmer



gathering device



stepmotor

INPUTS



- X0= ENCODER
- X1= EMPTY
- X3= EMPTY
- X4= ENCODER
- X5= NEEDLE POSITION
- X6= EMPTY
- X7= KNEE SWITCH




Info

General information about the machine

Fig. 13

| | |
|------------------------------|--------|
| AIR PRESSURE | 5 |
| VOLTAGE | 220 |
| POWER | 0.60 |
| NEEDLE | DPx5 |
| SOFTWARE VERSION (PLC / HMI) | XXXXXX |
| SERIAL | XXXXXX |

0 



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Remarks / Notes

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