Programming the Strobel 441- 2

The Strobel 441-2 has a stepper motor driven differential wheel feed. The ratio of differential feed between upper an lower wheel is set by level (not by percentage). Level 0 means no differential feed and level 9 means 50% differential feed. If the percentage of differential feed is determined the corresponding level can be found in below table.

Differential level	**Differential percentage**
Level 0	0 - 2 %
Level 1	3 - 8 %
Level 2	9 - 13 %
Level 3	14 - 19 %
Level 4	20 - 24 %
Level 5	25 - 30 %
Level 6	31 - 35 %
Level 7	36 - 41 %
Level 8	42 - 46 %
Level 9	47 - 50 %

Programming a pair of shoes always starts by programming one of the shoes and then the other shoe is created automatically. Totally 100 shoes can be programmed (50 right and 50 left shoes). The right shoe always has an even number and the left shoe always has an odd number.

Right shoe	**Left shoe**
00R	01L
02R	03L
04R	05L

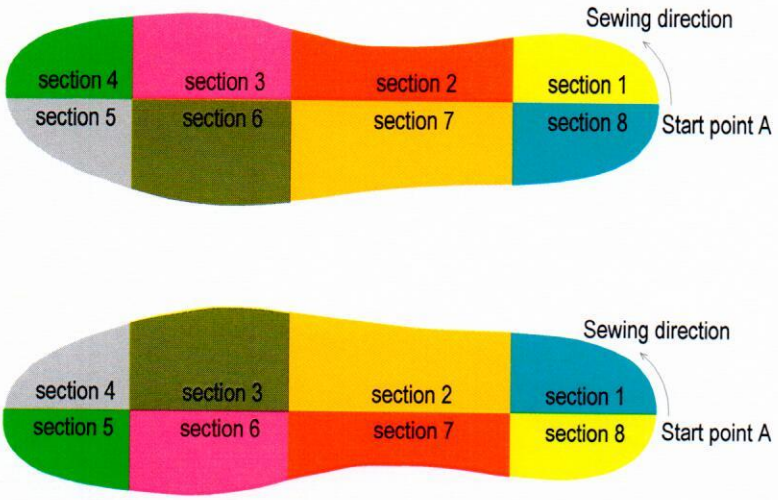
up to

98R	99L

Important !

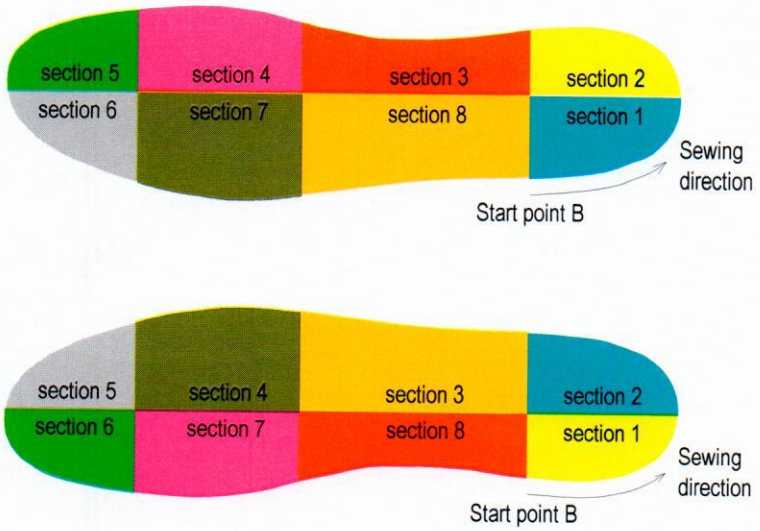
To program a pair of shoes only one shoe needs to be programmed and the control box will automatically create the program for the other shoe. The starting point of sewing determines how the other shoe is created and it is crucial to set the parameter F-714 to the correct value before programming the shoe. After programming the shoe everybody must sew the shoe from the same point ! Changing the parameter F-714 afterwards will not change the original program !

Explanation of parameter F-714 = 0 (sewing start point A):



Parameter F-714 = 0 Right side 00R →	Left side 01L
section 1	section 8
section 2	section 7
section 3	section 6
section 4	section 5
section 5	section 4
section 6	section 3
section 7	section 2
section 8	section 1

Explanation of parameter F-714 = 1 (sewing start point B):

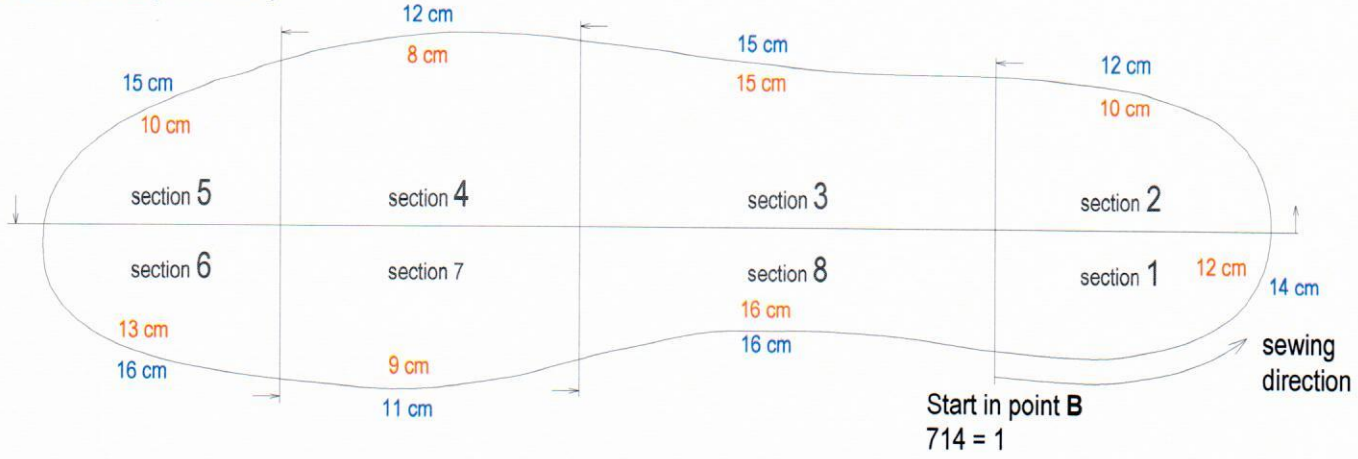


Parameter F-714 = 1 Right side 00R →	Left side 01L
section 1	section 2
section 2	section 1
section 3	section 8
section 4	section 7
section 5	section 6
section 6	section 5
section 7	section 4
section 8	section 3

As can be seen above the sequence of the left shoe is different with parameter F-714 set to 0 or 1.

Programming example with parameter F-714 = 1 (start sewing at point B):

Pattern 03L (left shoe)



Pattern 02R (automatically generated) with F-714 = 1 (start sewing at point B)

blue color is length of the section of the upper
red color is length of the section of the insole

Pattern 03L:

Section 1: 14 - 12 / 14 x 100% = 14% → set level 3

Section 2: 12 - 10 / 12 x 100% = 16% → set level 3

Section 3: 15 - 15 / 15 x 100% = 0% → set level 0

Section 4: 12 - 8 / 12 x 100% = 33% → set level 6

Section 5: 15 - 10 / 15 x 100% = 33% → set level 6

Section 6: 16 - 13 / 16 x 100% = 19% → set level 3

Section 7: 11 - 9 / 11 x 100% = 18% → set level 3

Section 8: 16 - 16 / 16 x 100% = 0% → set level 0

Automatic created pattern 02R with F-714 = 1:

Section 1: 12 - 10 / 12 x 100% = 16% → level 3

Section 2: 14 - 12 / 14 x 100% = 14% → level 3

Section 3: 16 - 16 / 16 x 100% = 0% → level 0

Section 4: 11 - 9 / 11 x 100% = 18% → level 3

Section 5: 16 - 13 / 16 x 100% = 19% → level 3

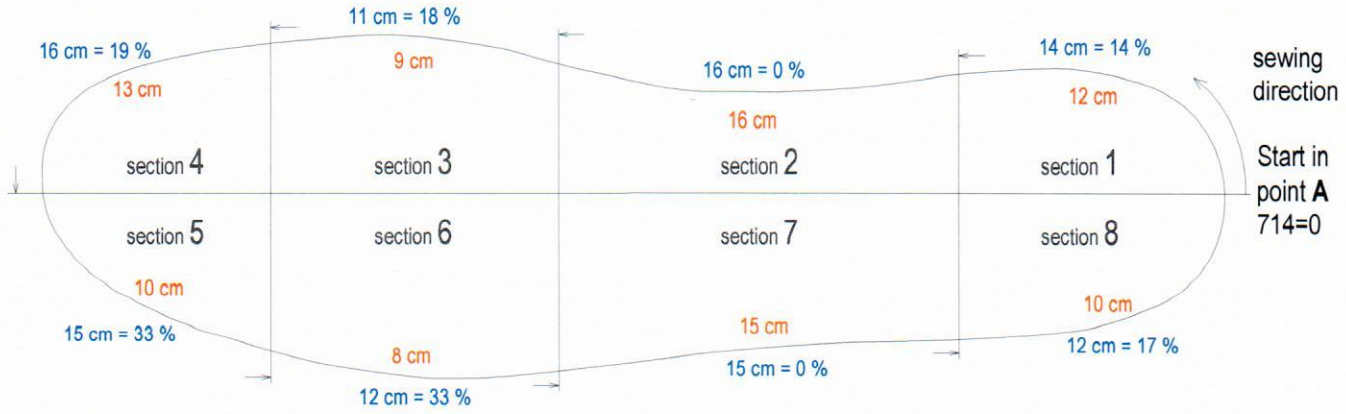
Section 6: 15 - 10 / 15 x 100% = 33% → level 6

Section 7: 12 - 8 / 12 x 100% = 33 % → level 6

Section 8: 15 - 15 / 15 x 100% = 0% → level 0

Programming example with parameter F-714 = 0 (start sewing at point A):

Pattern 00R (right shoe)



Pattern 01L is automatically created with F-714 = 0 (start sewing at point A)

blue color is length of the section of the upper
red color is length of the section of the insole

Pattern 00R:

Section 1: 14 - 12 / 14 x 100% = 14% → set level 3

Section 2: 16 - 16 / 16 x 100% = 0% → set level 0

Section 3: 11 - 9 / 11 x 100% = 18% → set level 3

Section 4: 16 - 13 / 16 x 100% = 19% → set level 3

Section 5: 15 - 10 / 15 x 100% = 33% → set level 6

Section 6: 12 – 8 / 12 x 100% = 33% → set level 6

Section 7: 15 – 15 / 15 x 100% = 0% → set level 0

Section 8: 12 – 10 / 10 x 100% = 17% → set level 3

Automatic created pattern 01L with F-714 = 0:

Section 1: 12 - 10 / 12 x 100% = 17% → level 3

Section 2: 15 - 15 / 15 x 100% = 0% → level 0

Section 3: 12 - 8 / 12 x 100% = 33% → level 6

Section 4: 15 - 10 / 15 x 100% = 33% → level 6

Section 5: 16 - 13 / 16 x 100% = 19% → level 3

Section 6: 11 - 9 / 11 x 100% = 18% → level 3

Section 7: 16 - 16 / 16 x 100% = 0 % → level 0

Section 8: 14 - 12 / 14 x 100% = 14% → level 3