

For the professional user

Mechanic's Instructions

Für den professionellen Anwender

Mechanikeranleitung

Class: 441-1 **Ausf. 1**
Klasse: 441-2 **Ausf. 1**

Dated:
Stand:

The sign of quality



You find the Strobel trademark on every Strobel machine leaving our works. And with good reason. This symbol is a guarantee of the high quality of our products. Quality which creates trust – trust in our technology, our service and, not least of all, in our good name.

Im Zeichen der Qualität

Sie finden die Strobel-Schutzmarke auf jeder Strobel-Maschine, die unser Werk verlässt. Und das aus gutem Grund. Denn dieses Zeichen garantiert Ihnen die hohe Qualität unserer Produkte. Qualität, die Vertrauen schafft – in unsere Technik, unseren Service und nicht zuletzt in unseren guten Namen.

Strobel clients know that they can expect a particularly high standard of performance from our company and our machines. Now you have settled for one of our products. For us this is a source of encouragement and of obligation to Justify your trust.

If you wish to profit from the performance and efficiency of your Strobel machine as long as possible, exact handling and thorough care is necessary. For this reason we kindly request that you read the operating instructions closely. It provides all the information you need for trouble free operation.

And if you do happen to need a spare part the enclosed spare parts list gives a complete overview. It is clearly classified according to components so that you can find the required part quickly and easily. In order to avoid errors we request you to quote machine class, machine number and part number completely on your spare part order.

We wish you lots of success in your work with your new Strobel machine.

Mechanic's instructions STROBEL Class 441-1 and 441-2

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Connecting the sewing machine:

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Strobel - Switchable functions

(DC1200-AB611A) Kl. 441-1
(DC1500-AB425S) Kl. 441-2

Strobel - Parameter list

(DC1200-AB611A) Kl. 441-1
(DC1500-AB425S) Kl. 441-2

Subject to change without prior notice

1 General notes on safety

Every person in charge of setting up, operating, servicing and repairing the machine must first read and understand the operating instructions and particularly the safety instructions before starting up the machine.

Failure to comply with the following safety instructions can lead to bodily injury or damage to the machine.

1. The machine must only be operated by persons familiar with the relevant operating instructions and who have been instructed accordingly.
2. Before commissioning also read the notes on safety and the operating instructions of the sewing drive manufacturer.
3. Only use the machine in the intended manner and never without the provided guards. Always observe the pertinent safety regulations.
4. Switch off the main switch or pull the power plug for threading, changing the reels, exchanging sewing tools such as needle, looper, needle plate, transport devices, possibly cutter and cutting block, for cleaning and when leaving the workplace as well as for maintenance.
5. General maintenance tasks may be carried out only by properly trained persons in accordance with the operating instructions.
6. Repair work, retrofitting and maintenance may be carried out only by technicians or specially trained personnel.
7. When servicing or repairing pneumatic equipment, the machine must be disconnected from the pneumatic supply. Exceptions are only allowed for adjustment work and tests of functionality performed by specially trained technicians.
8. Only specially qualified technicians may work on the electrical equipment.
9. It is forbidden to work on electrically live components! Exemptions are covered by the EN50110 (DIN VDE0105) regulations.
10. Any retrofitting or alterations to the machine may only be performed under strict compliance with all pertinent safety regulations.
11. Only use our approved spare parts when servicing and/or repairing the machine.
12. It is forbidden to operate the sewing head until it is determined that the entire sewing unit complies with EU provisions.
13. It is essential that you observe and follow these instructions as well as the generally valid safety regulations.

14. Warning instructions given in the operating instructions that pertain to especially dangerous parts of the machine must be indicated at these positions using a safety symbol.



Warning instructions given in the operating instructions that pertain to special injury hazards for operating personnel or technicians must be indicated at these positions using a safety symbol.



2 General notes

2.1 Operating instructions

Every person in charge of setting up, operating, servicing and repairing the machine must first read and understand the operating instructions and particularly the safety instructions before starting up the machine.

2.2 Class designations, machine number and initial basis for descriptions

The operating side of the machine is the initial basis for left/right descriptions. The class type, machine and model number (after the dash) is attached in the back of the housing.

2.3 Applications of the machine use as intended

Class 441-1

Single-thread overcast machine with gathering device for attaching soles to shoes made of heavy textile material and leather up to a total thickness of 7 mm.

Class 441-2

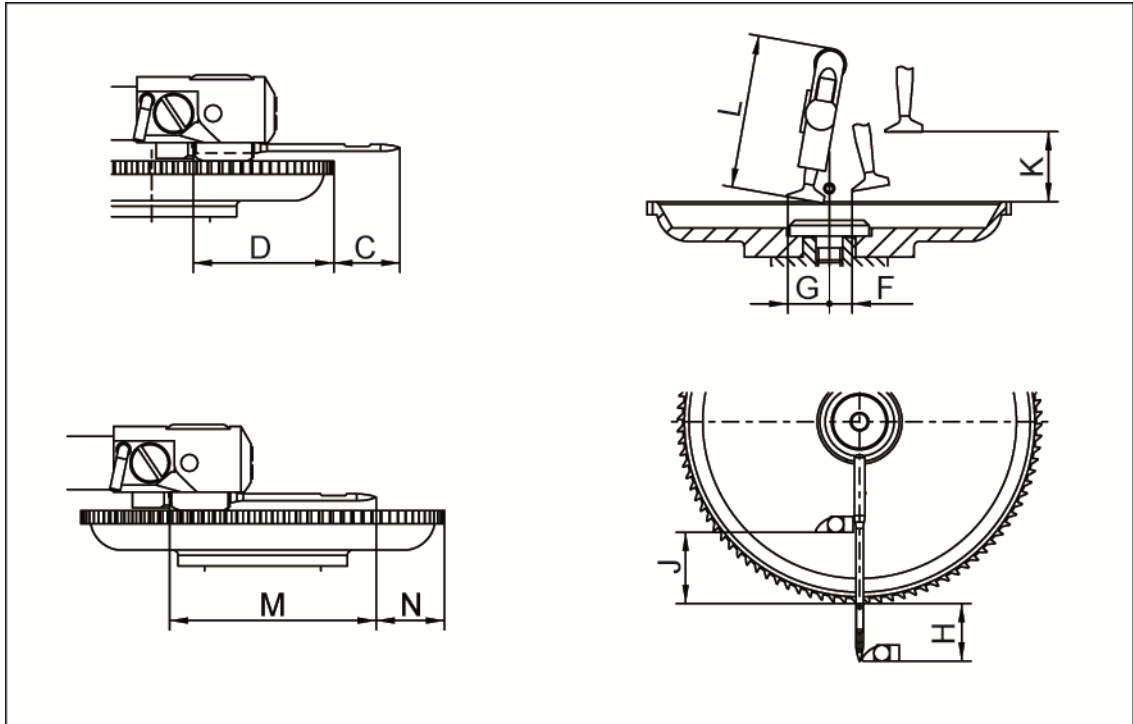
Single-thread overcast machine for attaching soles to shoes made of heavy textile material and leather up to a total thickness of 7 mm, with differential drive.

2.4 Technical data

Recommended nominal stitch number	1800 min ⁻¹
Belt pulley diameter/machine	dw 80
V-belt profile	10 x 6 mm
Stitch length	3 – 8 mm (depends on sewing material)
Stitch type	single-thread overcast stitch
Stitch type	501
Needle system	GROZ-BECKERT 134
Needle thickness	140
Thread	polyester, continuously twined
Thread thickness	40
Transport type	rear plate transport
Pneumatic connection	6 bar
Air consumption, average	depends on equipment
Equipment footprint	0.6 x 1.06 m
Operating noise:	
Averaged measuring surface sound pressure level	
at stitch number n 1800 min ⁻¹	Cl. 441-1 LpAm 71 dB
	Cl. 441-2 LpAm 76.1 dB
	Noise levels in acc. with DIN 45635-48-1 KL3

2.5 Abridged version of adjustment manual

Setting value		
Class	Dimension	
Needle type		134
Needle size		120 - 140
Stitch length	A	3 - 8
Loop stroke	B	5,5
Needle point front measured from plate edge	C	24
Needle bar eccentric stroke	E	32,4
Looper deflection to right from centre needle - looper point	F	4,9
Looper deflection to left	G	10,2
Looper position front measured from plate edge	H	11,7
Looper position rear	J	6,2
Looper transition	K	10,5
Looper height incl. shaft	L	37
Rear end position / Position without needle	M	about 48.1
Rear end position / Position with needle	N	about 9.4



Einstellwerte_09

The lifting value between the feed cups is 12-14 mm.

3 Disassembly of the machine

3.1 Disassembly of the front main shaft (Fig. 1 to Fig. 5)

Before beginning with disassembling the main shaft, it is recommended to record all parts on the shaft using a ruler in a straight line. If necessary, starting at the front edge of the stand, measure the distances of the front and rear bearing bracket using a calliper and write them down (dimension a + b).

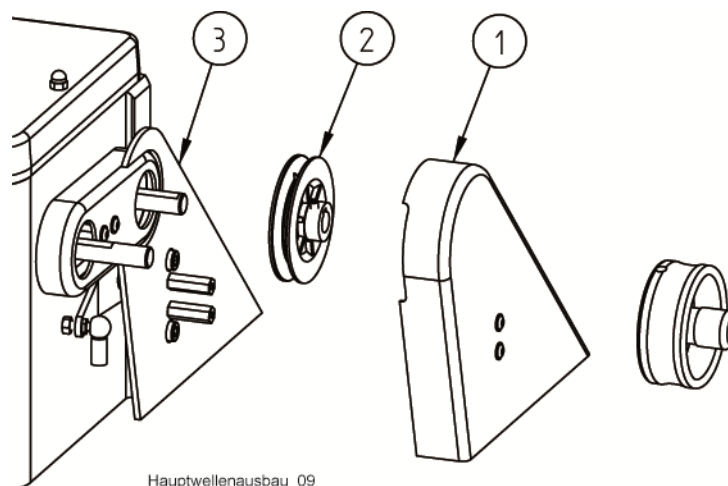
This will save a lot of time during the assembly for calibration. (Fig. 4)

First of all, remove the right handwheel and then disassemble the belt guards in the following sequence.

Cl. 441-1

The belt guard (1), the V-belt pulley (2) and the belt guard back wall (3). (Fig. 1)

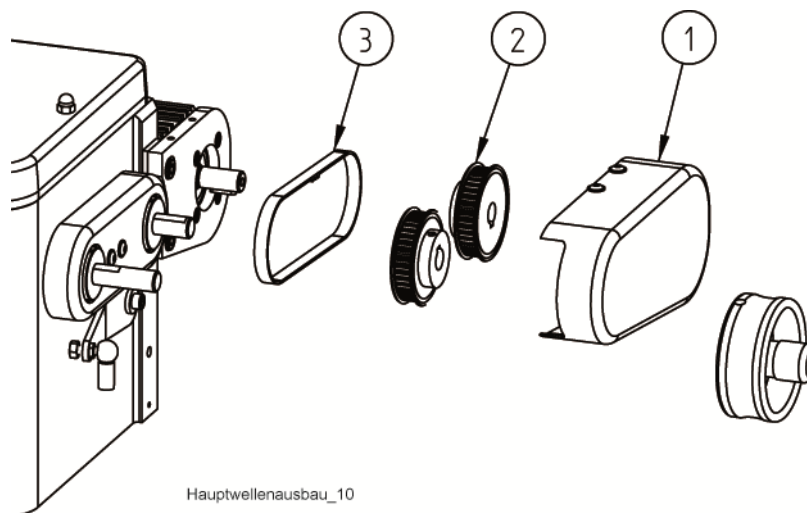
Fig. 1



Cl. 441-2

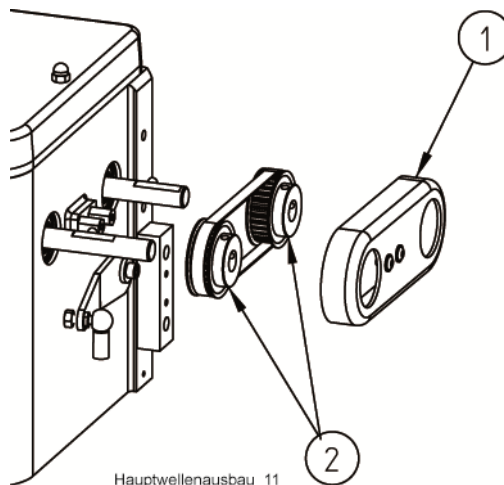
The belt guard (1), the toothed belt pulleys (2) and the toothed belt (3). (Fig. 2)

Fig. 2



Afterwards the belt guard (1). Now make a note of how the two toothed belt pulleys (2) are mounted on the front and rear shaft. Now the toothed belt pulleys (2) can be taken off with the toothed belt. (Fig. 3)

Fig. 3



The left handwheel with the stitch variable eccentric bolt does not need to be removed. **Make sure** that the threaded pins (2) located on both sides of the variable eccentric (A) (1) are removed. (Fig. 4 and Fig. 5)

CAUTION! If not already done, mark the slideway (3) and variable eccentric (A) (1) for correct installation position. (Fig. 5)

Only then should the screws of the parts located on the shaft be loosened and the shaft be pressed out to the left with an extracting tool.

Note here though that the shaft should be pressed to the left by about only 20-30 mm and the glue adhering to the shaft is removed; only then can the shaft be pushed out all the way. Be careful that the ball bearings do not slip.

Any glue residues still on the shaft can be removed easily using a cleanser (e.g. chloroethene).

Fig. 4

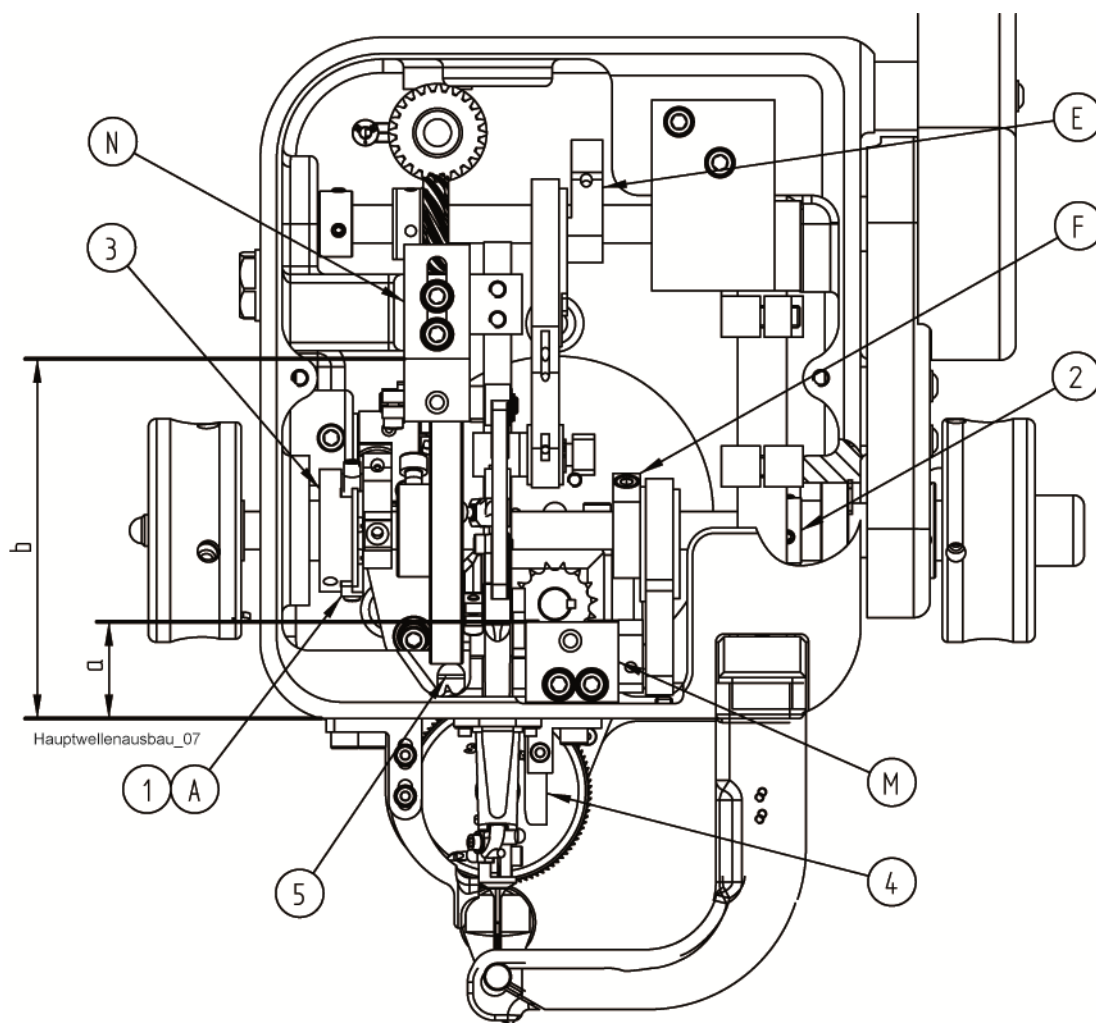
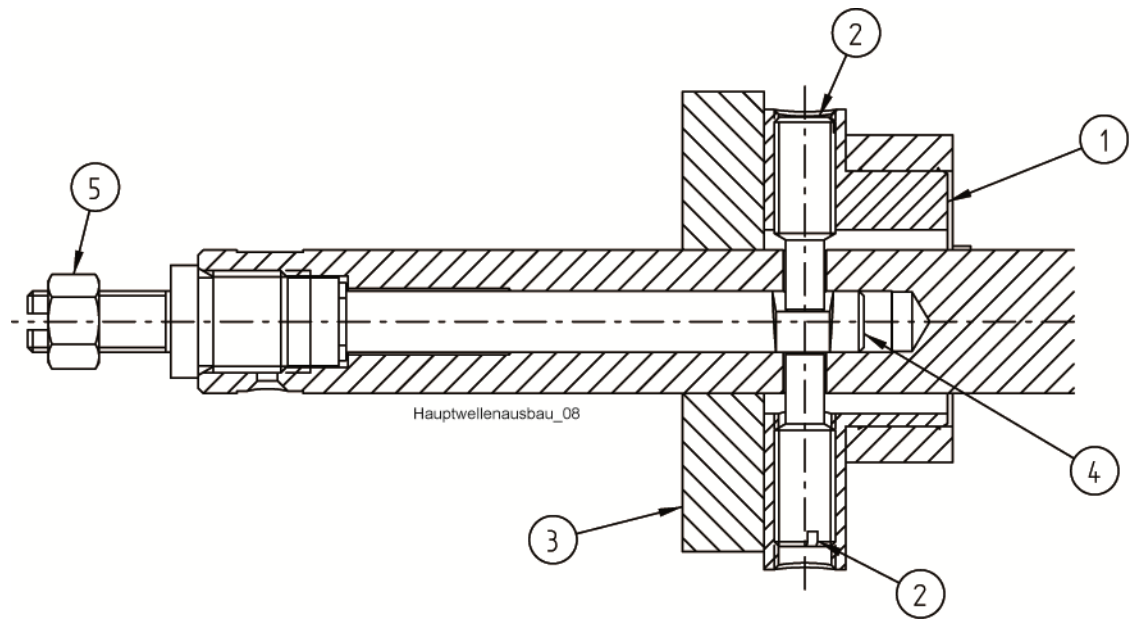


Fig. 5



4 Assembly of the machine

4.1 Assembly of the shaft (Fig. 4, Fig. 6 and Fig. 7)

Once all parts have been threaded in the correct sequence onto the shaft, which has been cleaned of grease first, a drop of Loctite can be put each on the shaft which still protrudes out to the left by about 30 mm, as well as on the right part of the degreased shaft inside the machine stand, at the ball-bearing seat. (Loctite, capillary 290)

CAUTION! To make a fault-free connection possible, the surfaces to be joined must be completely grease-free. The shaft is then pushed all the way into the stand, turned slightly so that the Loctite is drawn in evenly all-around by the ball-bearing ring, the stitch variable eccentric (A) (1) is fixated (see point "4.2 Assembly of the stitch variable eccentric"), the shaft is pushed all the way to left and the adjusting ring (2) on the right shaft side is sealed close so that the axial gap of the shaft is removed. (Fig. 4)

After the adhesive has cured for about one hour (Loctite, capillary 290) the machine can be assembled further and calibrated. During the repair assembly, the left handwheel does not need to be taken off the shaft; however the control knob (1) (Fig. 7) and the pins (3) and springs (2) do have to be removed (Fig. 6).

4.2 Assembly of the stitch variable eccentric (Fig. 4, Fig. 5, Fig. 6, Fig. 7)

Mount the left handwheel on the installed shaft so that the tip of the first screw fits, in the direction of rotation, into the depression of the left radial bore of the shaft and stands upwards during that.

Turn the slideway (3) so that the variable eccentric (1) can be pushed down in the position described above. (Fig. 5)

Turn the first screw (2) so far into variable eccentric so that the adjustment bolt (4) can be turned through in the shaft. First, loosen the counter nut. Turn the handwheel with shaft by 180°. Turn the second screw (2) all the way into variable eccentric; the adjustment bolt (4) should be able to rotate free of backlash. Screw slideway (3) onto the shaft. (Fig. 5)

Slide the shaft all the way to the left on the ball bearings, push adjusting ring (2) on the right shaft side all the way on the ball bearings and tighten. The shaft is fixated now. (Fig. 4)

Allow stitch variable eccentric (1) to level off and tighten. Slide two greased springs (2) and two greased pins (3) into the bore of the handwheel (Fig. 6).

Fig. 6

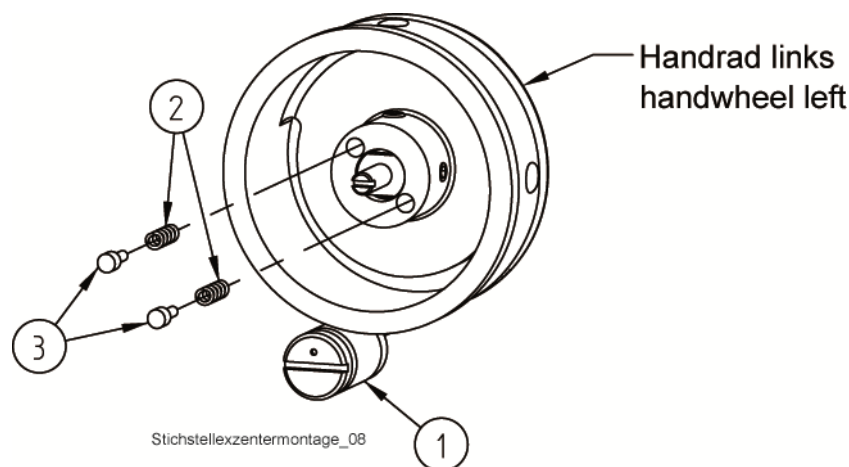
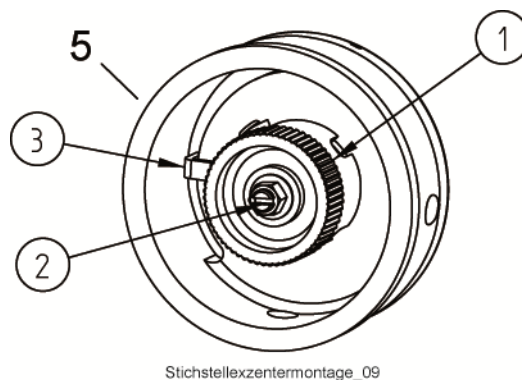


Fig. 7



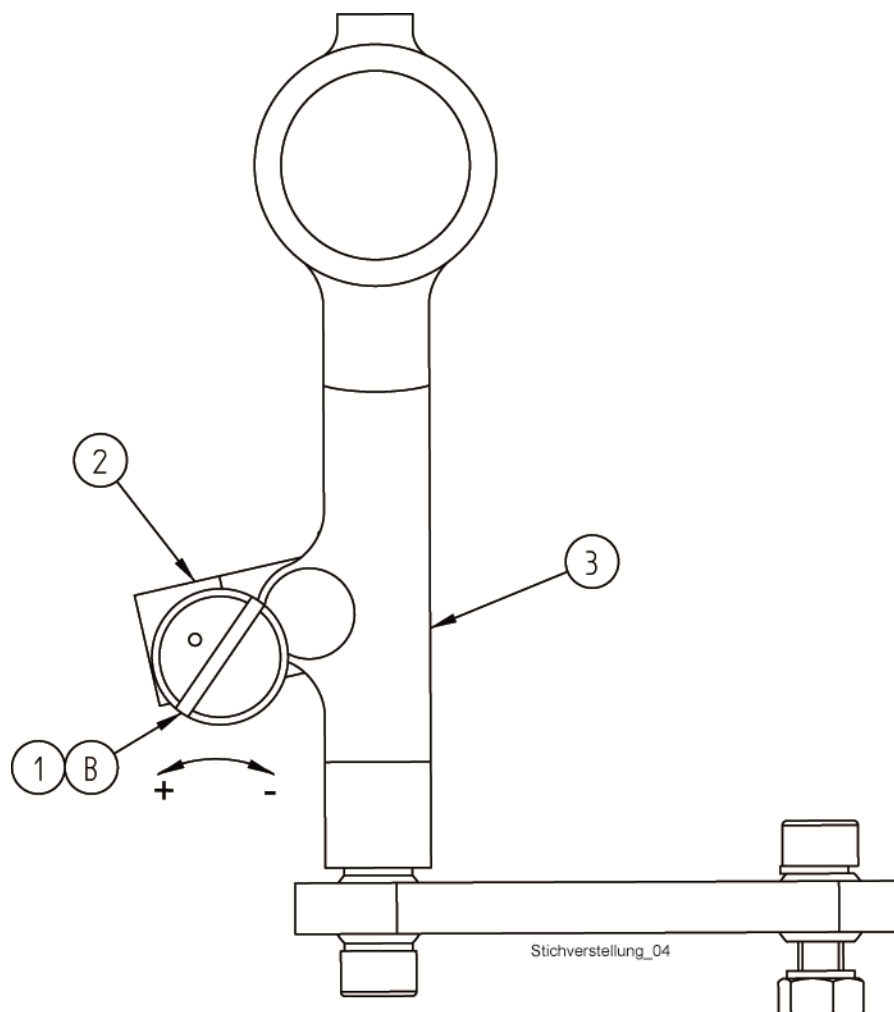
Screw the control knob (1) onto the shaft or the adjustment bolt (2) until the control knob contacts the handwheel. Hold the control knob tight and screw out the adjustment bolt until the pointer (3) on the control knob of the handwheel (marking 5), (large stitch), contacts and can be slightly seen between handwheel and stand. (Fig. 7)

The control knob needs to be free from the large to the small stitch.

If the setting has been done properly, the variable eccentric (1) is standing at the large stitch at the top dead centre and the pointer of the control nut is at the marking 5 on the handwheel. To complete, the counter nut (5) is screwed on. (Fig. 5)

4.3 Setting the ecc. pin for stitch adjustment **(Fig. 4 and Fig. 8)**

In combination with the stitch variable eccentric (A) (1) (Fig. 4), the ecc. pin (B) (1) needs to be set to the determined position for the stitch length specified for each class (see "2.5 Abridged version of adjustment manual"). Please be sure that the rocker (2) and the connecting rod (3) are not stretched out. The marking (punch mark) made on the ecc. pin (1) (Fig. 6) has to be mounted upwards in any case. This has the effect that the punch mark is swivelled to the right (-) for a smaller stitch and to the left (+) for a larger stitch - arrow direction. (Fig. 8)

Fig. 8

4.4 Setting of the needle and transport movement

If the largest stitch length is set (see "2.5 Abridged version of adjustment manual"), the transport movement is ended when the needle point is located about 1.5 mm within the plate edge before the piercing.

Transport beginning is when the needle has left the material and is located about 1 mm behind the plate edge.

The setting is done at the needle bar eccentric (E) (Fig. 4); observe the front-most needle position thereby (see "2.5 Abridged version of adjustment manual").

During the setting of the needle bar, make sure that the surface on the needle bar for needle clamping is precisely at a right angle to the feed cup.

4.5 The looper movement

The looper movement is determined by the stroke of the looper eccentric (F) (Fig. 4) or (1) (Fig. 9), by the crank distance and by the bore distance of the clamping lever (2) (Fig. 9). The looper movement has to equal temporally the needle bar movement.

The curve form of the control curve (3) (Fig. 9) produces the lateral looper deflection, corresponding to the needle movement.

Make sure that the looper carriage (4) (Fig. 9) or the looper shaft is mounted exactly centrally to the needle bar (5) (Fig. 9).

It is recommended for setting the parts described below to mount them on the shaft so that they adhere, but can still be turned by hand and then tightening them after the final setting.

4.5.1 Setting the looper movement

Find the top dead centre of the needle bar eccentric and mark it (corresponds to position "1"). (E) (Fig. 4)

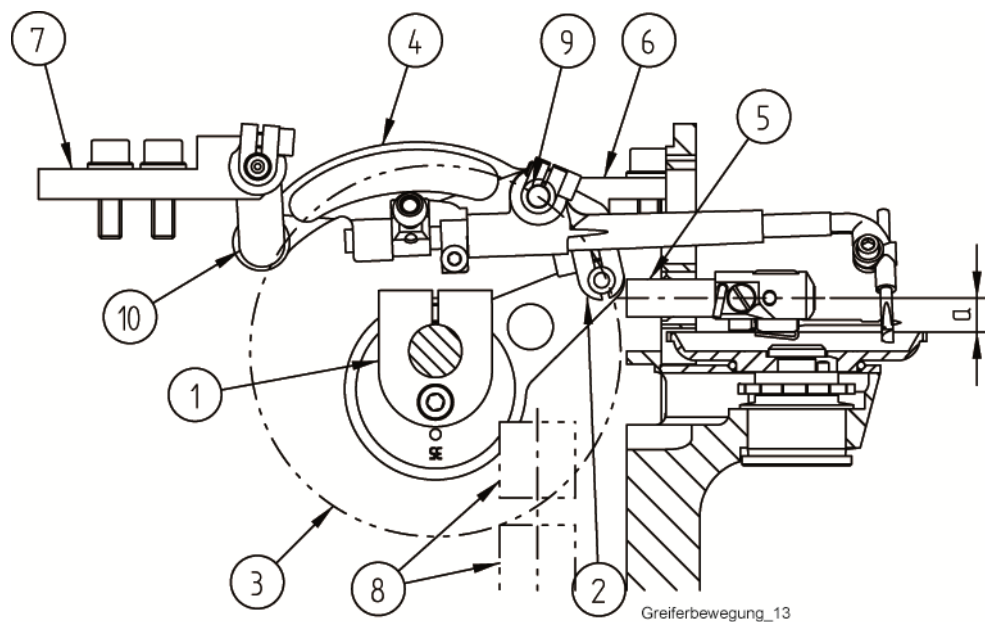
The top dead centre of the needle bar eccentric equals the bottom dead centre offset by 180° of the looper eccentric (1) (Fig. 9) (see point "4.5.2 Setting the looper eccentric").

Turn the control curve (3) in this position until the leftwards movement of the looper reaches the reversal point after taking up the loop.
(Fig. 9)

Make sure that the control curve (3) is fixated so that there is a backlash of about 1 mm between curve and adjusting ring on the looper carriage (4) (Fig. 9). The looper deflection is influenced by a lateral shifting of the control curve (3).

If the distance is enlarged, this results in a smaller looper deflection to the right.
The total path of the looper changes insignificantly.

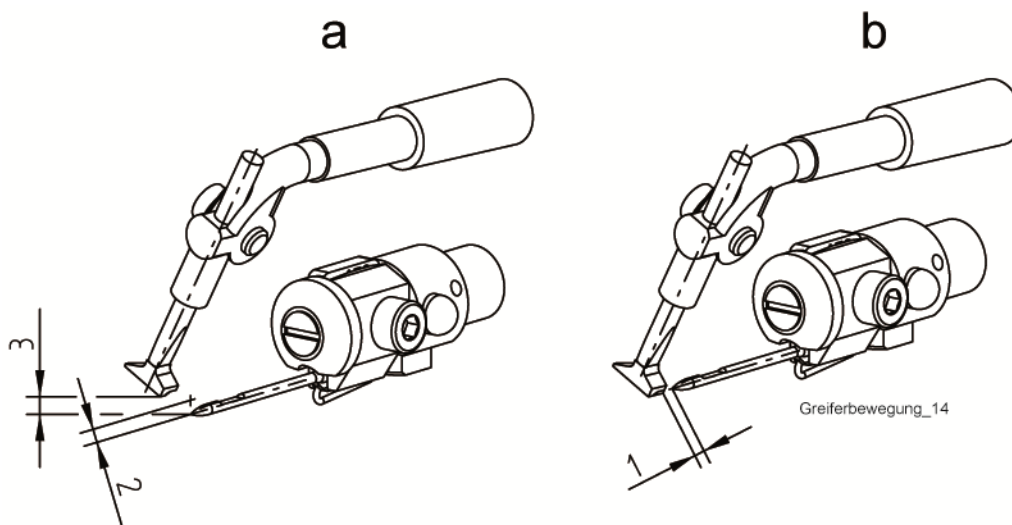
Fig. 9



4.5.2 Setting the looper eccentric

Set the looper eccentric (1) (at position "1") so that its surface is horizontal (Fig. 9). During a later partial rotation of about 100° at the handwheel (position "2"), the back-most needle position is reached. The looper is positioned then about 2 mm left of and about 3 mm over the needle, differently depending on the loop stroke (Fig. 10a). During forwards movement of the needle, the needle point arrives then at the right looper edge, whereby the needle point stands about 1 mm over the looper and then moves over the looper at an unvarying distance (Fig. 10b). The needle point is located at the rear dead centre of the looper, lateral and longitudinal movement, depending on the loop stroke, about 1 - 3 mm within the feed cup.

Fig. 10



4.5.3 Setting the front crank

Set the front crank (9) vertically at position "1".

The looper height movement is influenced by the front crank (9). (Fig. 9)

In the front position, the looper comes higher and should pass very closely (0.1 - 0.15 mm) over the needle for a good loop pick-up. The various needle thicknesses need to be taken into account for that. In the rear looper position, the looper stands under the needle, the needle about 1 mm over the looper bevel (Fig. 10b).

4.5.4 Setting the front looper position to the feed cup

At a rotation of about 45° in the opposite direction of rotation to position "1", the looper has reached its front-most position; set dimension (H) according to point "2.5 Abridged version of adjustment manual".

Make sure that the looper height (L) is correct (see "2.5 Abridged version of adjustment manual"), including the shaft.

4.5.5 Setting the loop stroke

The loop stroke (B) needed for the respective class (see "2.5 Abridged version of adjustment manual") is set by turning the control curve and the looper eccentric. Measured from the front dead centre of the needle to the contact of the looper point over the needle centre.

- | | | |
|----------------------|---|--|
| Increase loop stroke | - | Turn curve and looper eccentric contrary to the machine's direction of rotation. |
| Reduce loop stroke | - | Turn curve and looper eccentric in machine's direction of rotation. |

The looper picks up the thread loop from here and places it in as straight a lined as possible over the sewing material to the back.

4.5.6 Setting the rear bearing bracket

Shifting the rear bearing bracket (N) (Fig. 4) or (7) (Fig. 9) changes the looper transfer in the end positions. During pushing back, the looper goes closer to the needle in the front and vertical looper position (without significant change of height in rear position - ratio about 10:1); during pushing forward, the looper distance to the needle becomes greater.

4.6 Height adjustment of the feed cup

In case the socket (4) is removed, pull it in far enough so that the dimension of 8.8 ± 0.1 (a) of (Fig. 14) results in mounted condition feed cup (5).

4.7 Assembly of the front cup

Cl. 441-1 (Fig. 14)

During the assembly of the front cup on the machine, make sure that it is mounted in horizontal position and by 0.1 mm lower in relation to the feed cup. If there is a needle guard, the base of the needle channel has to be 0.1 mm lower in turn than the top edge of the front cup.

Cl. 441-2 (Fig. 11)

After the lid has been removed (1) (2x screws [2]), 2 threaded pins (4), which have been inserted at 90°, can be loosened via the borehole in the flange (3) and then the gearwheel (5) can be pulled out including the shaft (6).

Afterwards the retaining ring (7) can be taken from the bearing pin of the small front cup and the front cup can be exchanged.

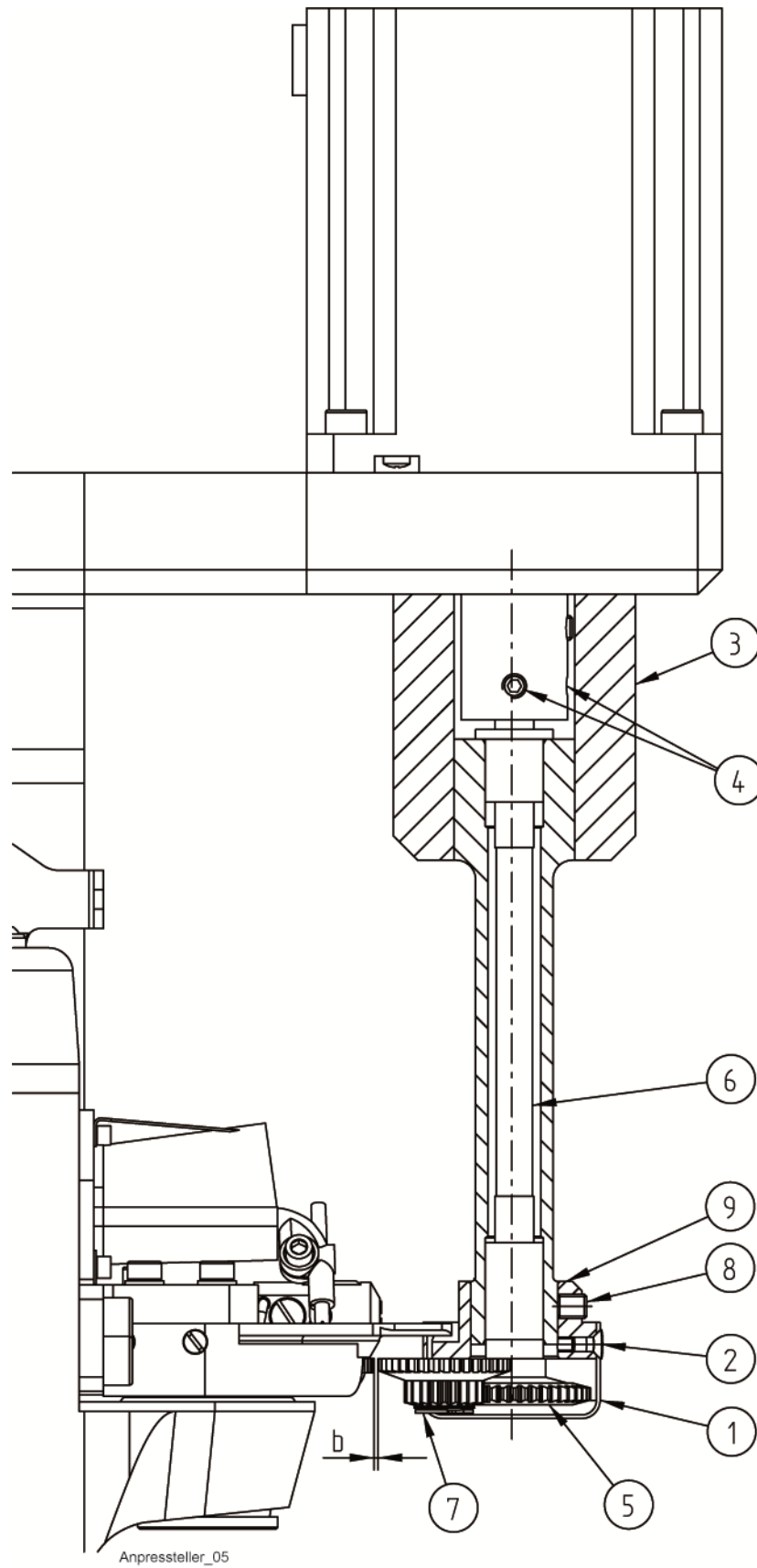
The assembly is done in reverse order.

To prevent damage to the feed cup teeth during a possible idling of the machine, feed cup and front cup should be moved together only so far that there still is a gap of 0.2 - 0.3 (b) mm between them. (Fig. 11)

The gap can be adjusted with threaded pin (4) and secured with threaded pin (5). (Fig. 12)

Make sure that the front cup is mounted 0.1 mm lower in relation to the feed cup. This can be adjusted by loosening the 2 threaded pins (8) from the needle guard (9). (Fig. 11)

Fig. 11



4.8 Tread lifting in the needle bar head

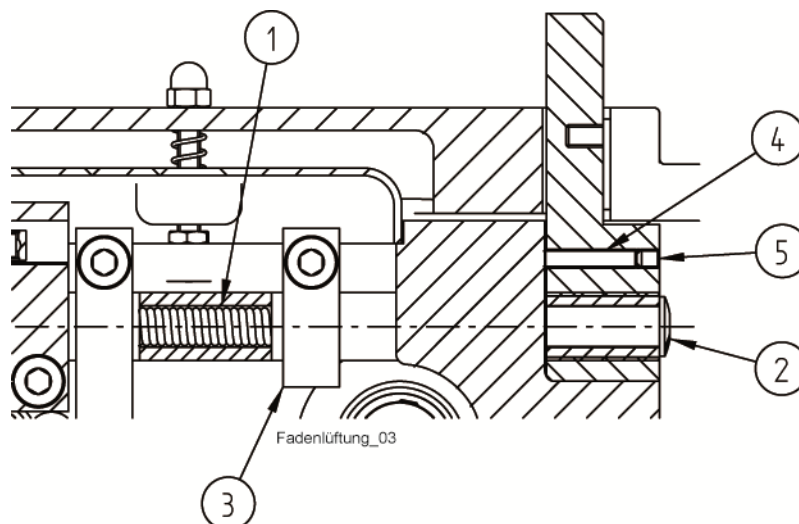
The lifter bar (4) for the tread lifting in the needle bar head has to be set so that the thread can be lifted when the looper stands vertically over the needle as the needle retracts and the loop pick-up is done up to the moment when the looper has reached the needle centre with the left looper point as the needle advances. (Fig. 4)

The thread breaking at the needle bar is 0.35 - 0.4 N.

4.9 Spring tension at the plate bearing arm

The tension of the spring (1) needs to be adjusted to the material to be processed; for shoes it can be up to 200 N for example. The spring tension can be set using the setting screw (2). (Fig. 12)

Fig. 12



4.9.1 Plate arm lifting

The plate arm lifting is about 12 - 14 mm and can be adjusted using the lever (3). (Fig. 12)

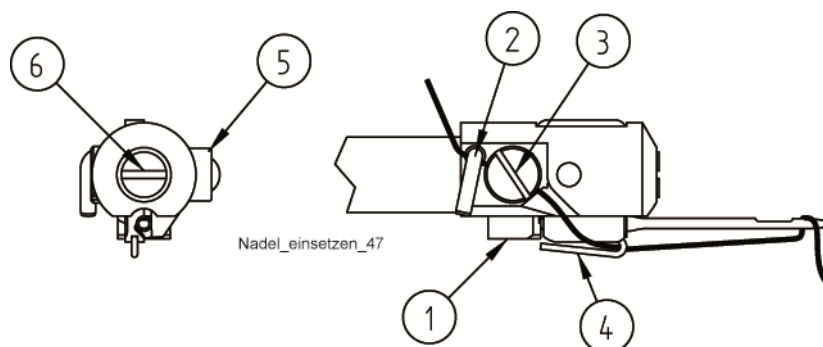
4.10 Needle setting

The setting dimension for the needle bar can be found in the table in point "2.5 Abridged version of adjustment manual".

4.10.1 Height adjustment of the needle (Fig. 13)

Using this special construction, the height of the needle can be adjusted. This device proves to be quite useful when using different needle thicknesses. The height of the needle can be adjusted by turning the eccentric (6), which features a groove, that is located on the front side of the needle bar head. Make sure that the needle of any thickness passes over the feed cup with a gap of about 0.1 mm in the area between the point and the eye of the needle. After loosening the screw (5) of the needle setting plate (4) and then adjusting the height of the needle, the screw (5) has to be tightened again.

Fig. 13



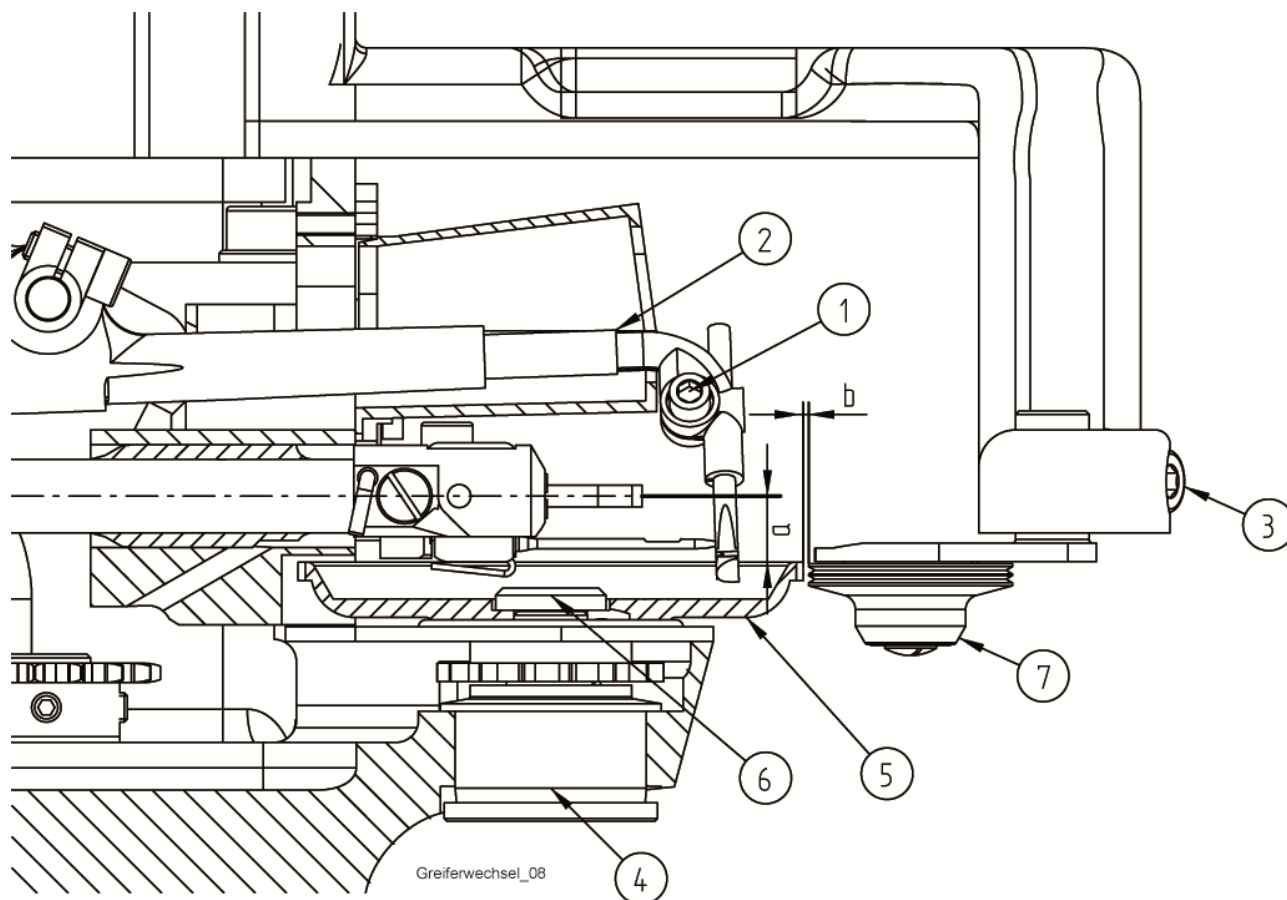
4.11 Replacing the looper

After loosening the clamping screw (1) (Fig. 14) at the head of the looper shaft (2), the looper can be removed.

When inserting a new looper, make sure that it contacts the needle or feed cup neither when it is in the front nor when it is in the rear position (see also installation dimension (L), point "2.5 Abridged version of adjustment manual").

The wide looper back should be set up as parallel as possible to the needle.

Fig. 14



4.12 Thread trimmer (optional)

The optional thread trimmer is controlled by an electro-pneumatic control when the right pedal is pressed back.

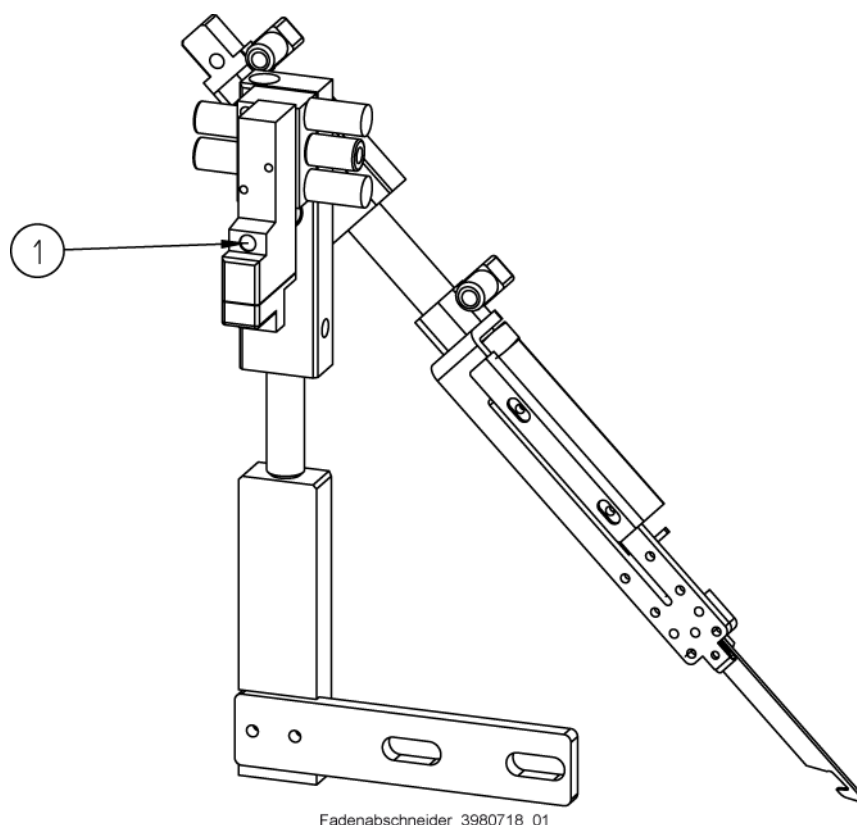
4.12.1 Calibration

Before mounting the thread trimmer, the 2 threaded pins (10) (Fig. 22) in the stand need to be removed. Then the thread trimmer is mounted on the stand with the 2 supplied screws. It is aligned so that the thread puller, when it is extended, **DOES NOT** collide with the feed cup, looper and needle and picks up the thread between needle and looper.

CAUTION: The needle position needs to be adjusted for the thread trimmer before the thread trimmer is put into operation.

The thread trimmer can be checked by triggering the button (1) on the backside of the valve, which is mounted on the thread trimmer, using a pointed object (e.g. ballpoint pen). (Fig. 15)

Fig. 15



4.13 Positions

With the control AB611 or AB425

Function	Parameter
Setting the reference position	F-170

This function sets the reference position.

Function	Parameter
Setting positions 1 and 2	F-171

This function sets the two positions.

The control has two positions. The positions are set exclusively by programming the control.

A position is determined by a position input and output value. The values correspond to the number of increments (steps), counted from an entered reference position. A rotation is divided into 360 steps (increments) thereby, i.e. 1 step = 1 degree.

C A U T I O N !

In order to ensure a safe or proper sequence there should be at least 50 steps (increments) between two positions.

Furthermore there should be 25 steps between position input value and output value of the same position (very important for internal functions of the control).

For the precise programming of the individual positions refer to point "4.14 Setting the positions".

The setting of the positions can be easily checked using the F-172 function. Refer to point "4.15 Display of the needle positions"

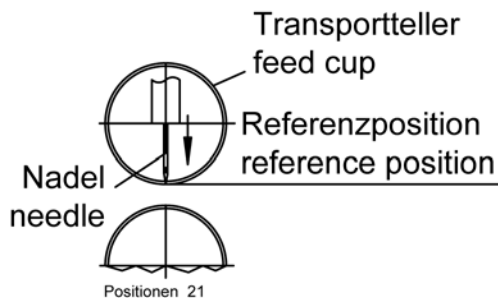
Machine with or without gathering device:

The machine requires two needle positions and, depending on sewing drive, possibly also a reference position.

Reference position (Fig. 16):

The reference position needs to be set so that the point of the needle concludes with the outer plate edge in the direction of the piercing.

Fig. 16



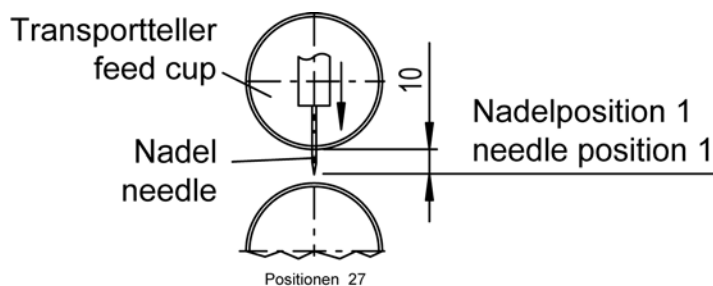
Refer to the enclosed sewing drive instructions for the programming of the positions on the motor.

Needle position (when stop inside the stitch with pedal position "0" (Fig. 17)):

The needle position needs to be set so that the distance between the outer plate edge in the direction of the piercing and the point of the needle is about 10 mm.

The needle position is position 1 at the sewing drive.

Fig. 17

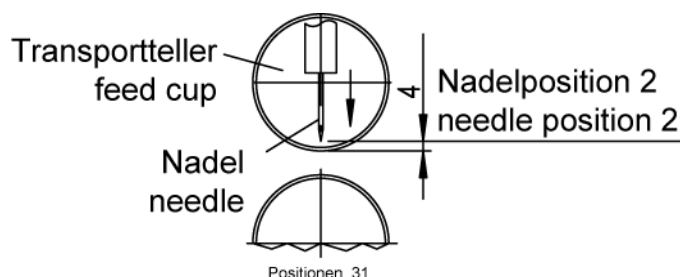


Needle position (when stop outside the stitch with pedal position "-2" (Fig. 18)):

The needle position needs to be set so that the distance between the point of the needle in the direction of the piercing and outer plate edge is about 4 mm.

The needle position is position 2 at the sewing drive.

Fig. 18



Afterwards, check its function by manually actuating the thread trimmer.

4.14 Setting the positions

Refer also to point "4.13 Positions"

4.14.1 Setting the reference position

After entering the code number "1907" and the button "E" for the technician level:

- Select parameter F-170. Display shows:.1.7.0.
- Press the "E" button. Sr 1_
- Press the ">>" button. P0 □

Turn the handwheel in the machine's direction of rotation until the rotating icon in the display disappears and then set the handwheel or needle to the reference position of the sewing machine (Fig. 16).

- Press the "E" button. .1.7.1.
 - Exit the programming level by pressing the button "P"
- or

continue with point: "4.14.2 Setting the position 1 and 2" with step 2.

4.14.2 Setting the position 1 and 2

After entering the code number "1907" and the button "E" for the technician level:

- Select parameter F-171. Display shows: 1.7.1.
- Press the "E" button. Sr2_
- Press the ">>" button. P1E
Keep turning the handwheel in the machine's direction of rotation until the display of "P1E" changes into the display of the position value and then set the handwheel or needle to the position 1 of the sewing machine (Fig. 17). Remember or record the position value.
- Press the "E" button. P2E
Keep turning the handwheel in the machine's direction of rotation until the display of "P2E" changes into the display of the position value and then set the handwheel or needle to the position 2 of the sewing machine (Fig. 18). Remember or record the position value.
- Press the "E" button. P1A
Keep turning the handwheel in the machine's direction of rotation until the display of "P1A" changes into the display of the position value and then turn the handwheel until the position value "P1E + 25" is displayed.
- Press the "E" button. Display shows: P2A
Keep turning the handwheel in the machine's direction of rotation until the display of "P2A" changes into the display of the position value and then turn the handwheel until the position value "P2E + 25" is displayed.
- Press the "P" button. 1.7.1.
- Press the "P" button.

At least one cycle needs to be sewn so that the setting is saved before the machine is switched off.

4.15 Display of the needle positions

Refer also to point "4.13 Positions"

Function	Parameter
Display of the Positions 1 and 2 (down / up)	F-172

The setting of the positions can be easily checked using this function.

After entering the code number "1907" and the button "E" for the technician level:

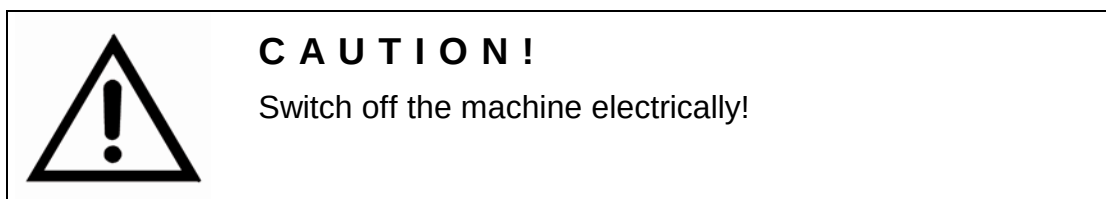
- Select parameter F-172. Display shows: .1.7.2.
- Press the "E" button. Sr 3
Turn the handwheel according to the motor's direction of rotation.
- Display at the control:
 - Segment 5 is switched on. ⇒ Position 1E
 - Segment 5 is switched off. ⇒ Position 1A
 - Segment 6 is switched on. ⇒ Position 2E
 - Segment 6 is switched off. ⇒ Position 2A
- Press the "P" button. .1.7.2.
- Press the "P" button.

4.16 Sewing drive

Refer also to point "4.13 Positions"

The motor has its own operating instructions included which has information on programming and circuit diagrams.

4.17 Working with the control AB425



4.17.1 Setting the stitch length

Function with V850 operating control	Parameter
Stitch length setting	F-711

In order for the machine to run synchronously, the stitch length needs to be determined first. To do so, you take a Texon strip for example and feed the strip between both plates, with the machine switched off, by turning the handwheel until the needle has pierced 11 times. Afterwards you measure the distance of the 11 piercings and enters this via the parameter "F-711".

Input example: Measuring result: 40.21
 Input: 04021

4.17.2 Working with operating control (V850) (Fig. 19)

Activation of control panels by code.

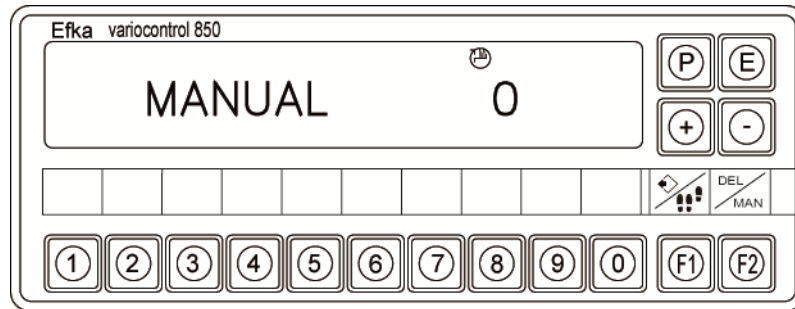
For activation you need a two part code, available from your Strobel agent.

Procedure of activation:

- Press and hold button "P" and switch on the machine by "S1"
- Open the supplier level by code "3112" and confirm with "E"
- Select parameter "F-798" and confirm with "E", for code-A
- Enter the 5-digit code-A and confirm with "E"
- Select parameter "F-799" and confirm with "E", for code-B
- Enter the 5-digit code-B
- Save data by pressing "P" two times

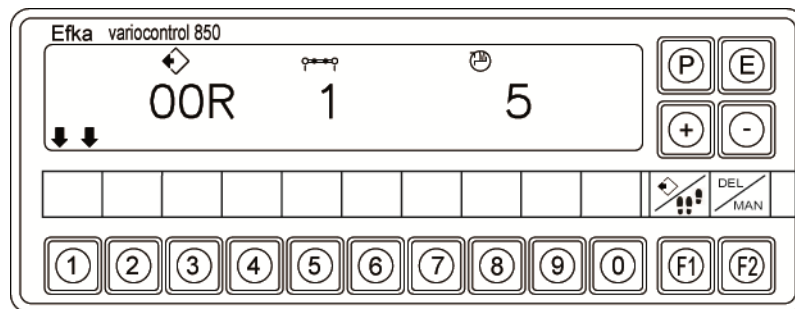
Fig. 19

Example:



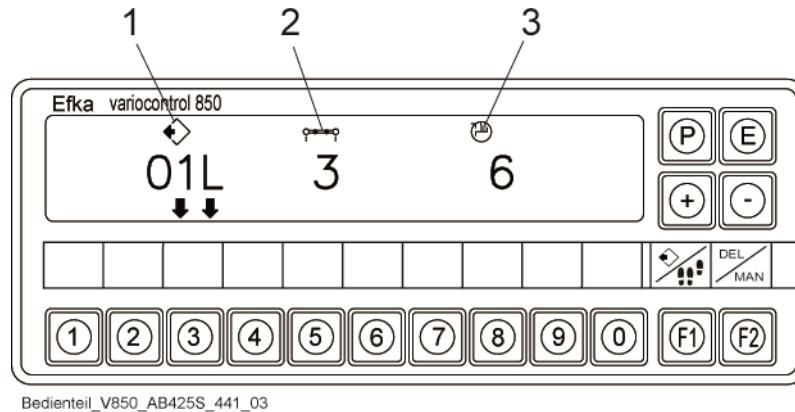
Bedienteil_V850_AB425S_441_01

Example:



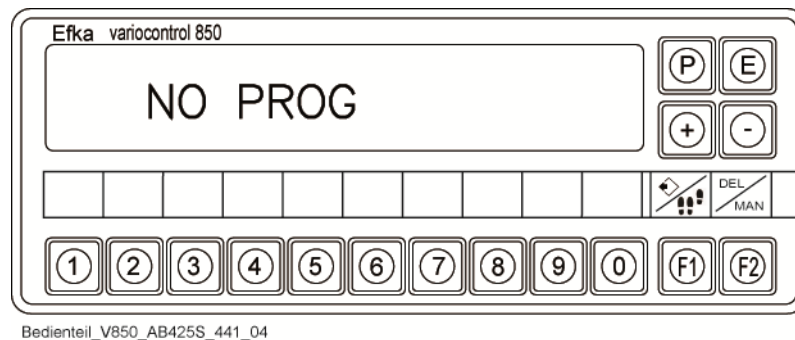
Bedienteil_V850_AB425S_441_02

1. Display "Standard"

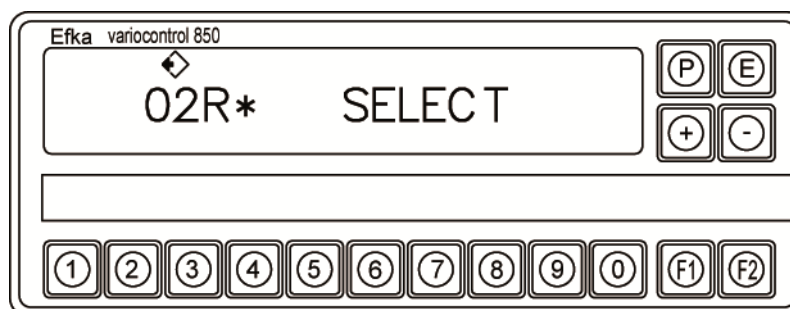


- 1** Program number
- 2** Sector
- 3** Reduction differential transport

- Additional display of the current sector by arrow symbols
- The letter behind the program number (L/R) indicates whether it is a left or right shoe.
- If no program is saved at the current program number, then this will be indicated by "No Prog".



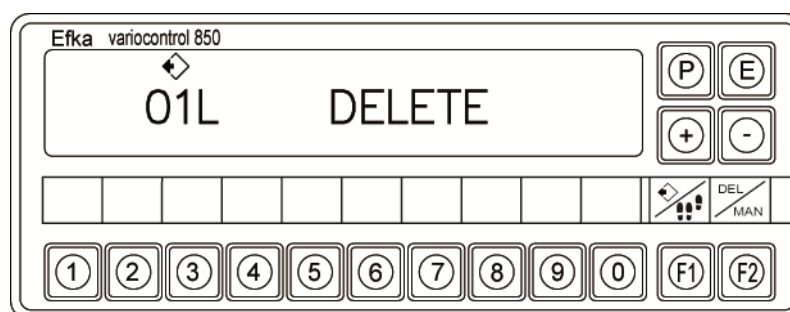
2. Display "Program selection"



Bedienteil_V850_AB425S_441_05

- Press the "F1" button in the "Standard" display.
- Enter the program number using the keypad or "+/—" buttons.
- Confirm the entry with the "E" button.
- Corresponding program is loaded.
- Return to the standard display
- If no corresponding program is saved, this is indicated by the "*" icon.
- Use the "P" button to switch into the "Standard" display without selecting a program.

3. Display "Delete program"



Bedienteil_V850_AB425S_441_06

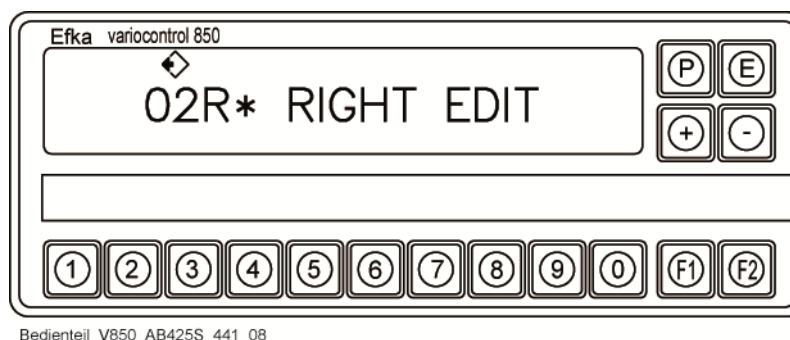
- Press the "F2" button in the "Standard" display.
- Enter the program number using the keypad or "+/—" buttons.
- Confirm the entry with the "E" button.
- If no corresponding program is saved, this is indicated by the "*" icon.
- Otherwise a confirmation is expected once more to delete the program definitely.



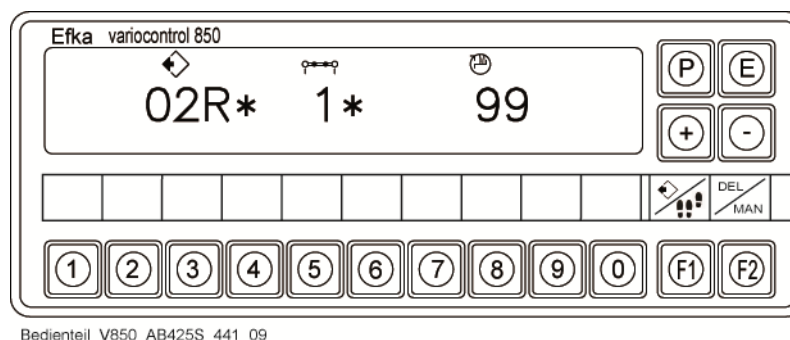
- Confirm the deletion process with the "E" button.
- The two programs that belong together are always deleted (e.g. 00R+01L, 02R+03L...)
- Return to the standard display ("No Prog")
- Use the "P" button to switch into the "Standard" display without deleting a program.

4. Display "Programming mode"

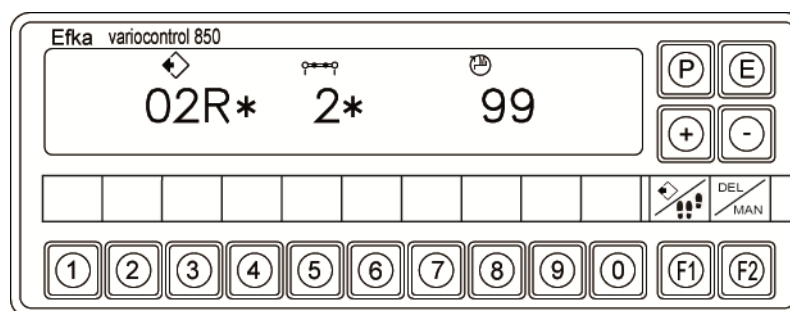
- Add new program



- Press the "P" button in the "Standard" display invoke the programming mode.
- Enter the program number using the keypad or "+/-" buttons.
- Confirm with the "E" button or exit with the "P" button.



- It starts with the value of the differential transport of sector 1.
- The value "99" indicates that no differential transport has been set for the current sector.
- Reduction differential transport begins to flash.
- The "*" icon behind the values of the program and sector numbers indicate that this program number or this sector has not yet been occupied (if the "*" icon cannot be seen in this display, then this program number or the sector is already occupied).
- The corresponding value for differential transport can be set using the "+/-" buttons.



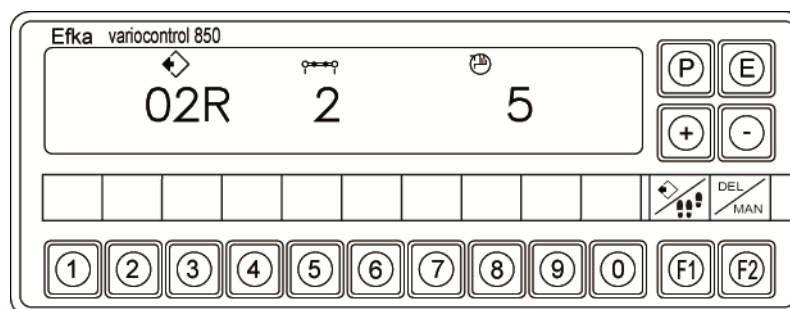
Bedienteil_V850_AB425S_441_10

- The sector is increased with the "E" button or the knee switch and the next value for the differential transport can be entered.
- Once the desired sectors are programmed, the program is saved by pressing the "P" button.
- During saving, the second associated program is created automatically (e.g. 00R+01L, 02R+03L, 04R+05L...)
- Return to the standard display

● Process existing program

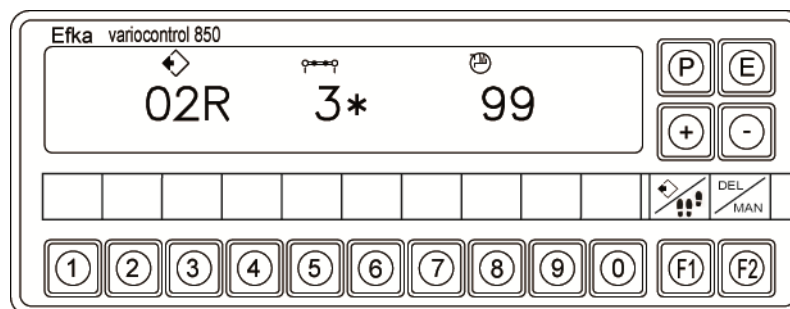
➤ Add sector to the end

- Activate programming mode.
- Select and confirm program number.
- Press the "F1" button to display last sector.



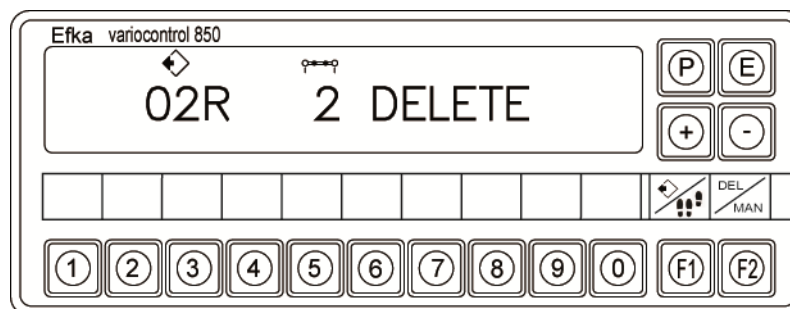
Bedienteil_V850_AB425S_441_11

- Add a new sector with the "E" button or knee switch.



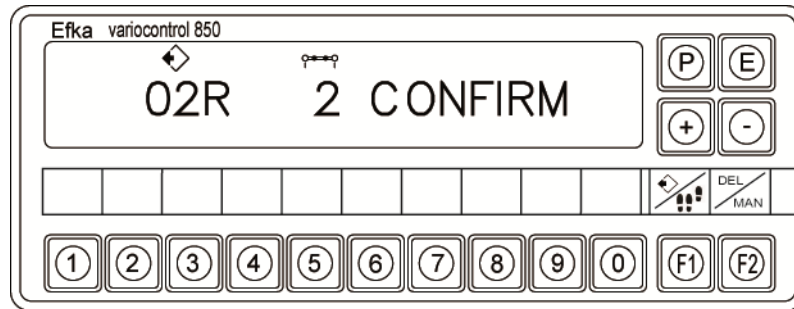
Bedienteil_V850_AB425S_441_12

- Set the differential transport and save with "P" button.
 - During saving, the second associated program is adapted automatically (e.g. 00R+01L, 02R+03L, 04R+05L...)
 - Return to the display "Standard".
- Delete last sector
- Activate programming mode.
 - Select and confirm program number.
 - Press the "F1" button to display last sector.
 - Press the "F2" button to delete the last sector ("Delete" is displayed).



Bedienteil_V850_AB425S_441_13

- Press the "E" button to confirm the entry.
- The "P" button cancels the deletion process.
- If cancelling, return to display "Programming mode".



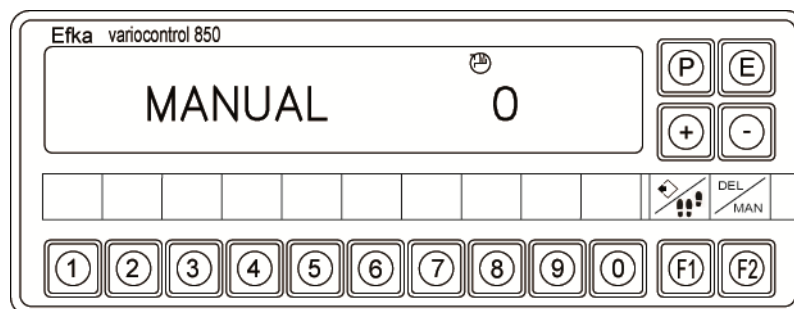
Bedienteil_V850_AB425S_441_14

- To make sure, the deletion needs to be confirmed by pressing the "E" button again.
- Save and return to the display "Standard" by pressing the "P" button.
- The deletion process is also transferred to the second associated program (e.g. 00R+01L, 02R+03L, 04R+05L...)

➤ Process sector

- Activate programming mode.
- Select and confirm program number.
- If the program number is invalid, "No Prog" is displayed.
- Page through to the corresponding sector with the "E" button or knee switch.
- Set the value of the differential transport.
- Save with the "P" button
- The processing process is automatically transferred to the second associated program (e.g. 00R+01L, 02R+03L, 04R+05L...)
- Return to the display "Standard".

5. Display "Manual mode"



Bedienteil_V850_AB425S_441_01

- The switching of the display into manual mode is done by a parameter.

4.18 Servicing the machine

The individual oiling points of the machine are supplied fully automatically; the machine needs no maintenance in this regard.

An oil change should be done about twice a year, depending on the amount of dust and hours of operation. It is recommended to use 0.5 litres of oil for that; an oil with the viscosity of 46 cSt.

(Recommended oil: Shell Voltol 46)

Also clean the plastic lever and the boreholes.

4.19 General notes

Further details such as sewing instructions and the like can be found in the operating instructions, on the homepage.

5 Notes on repair and adjustments

5.1 Feed cup assembly

In addition to the transport and front cups attached to the normal version, optional transport and front cups are offered according to the various materials to be processed and requirements with suitable gearing and edge heights; they can be freely combined with each other.

5.2 Replacing the feed cup

If the feed cup in the machine should be exchanged with other geared feed cups, then proceed first as follows:

1. Remove material guide (1) - 2x screw (2). (Fig. 20)
2. Pull out needle (1), cylinder head screw (2), needle clamping plate (3), pressure spring (4) and needle setting plate (5). (Fig. 21)
3. Screw out the flat-head screws (6) of the feed cup attachment; take feed cup off upwards. (Fig. 14)
4. The assembly of the exchanged feed cup is done in reverse order.

Fig. 20

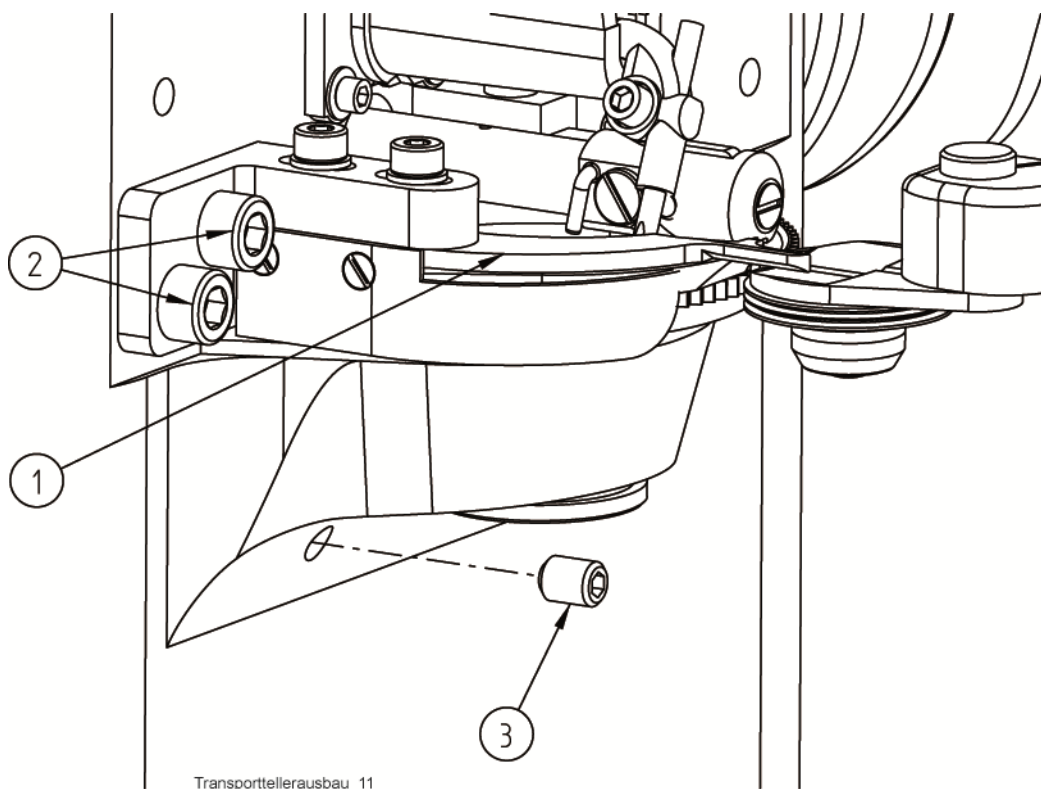
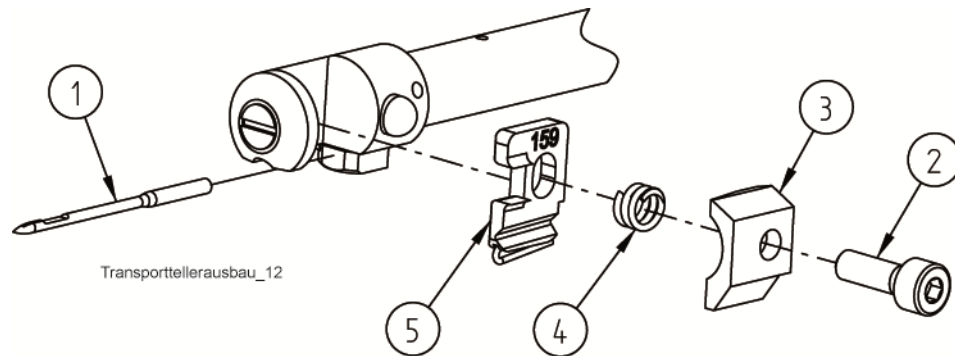


Fig. 21

5.2.1.1 Chain tension

The chain for the feed cup drive can be tensioned from above by loosening the threaded pin (3) (Fig. 20) the chain tensioner (5) (Fig. 4).

5.3 Setting and installation instruction for the Strobel gathering device

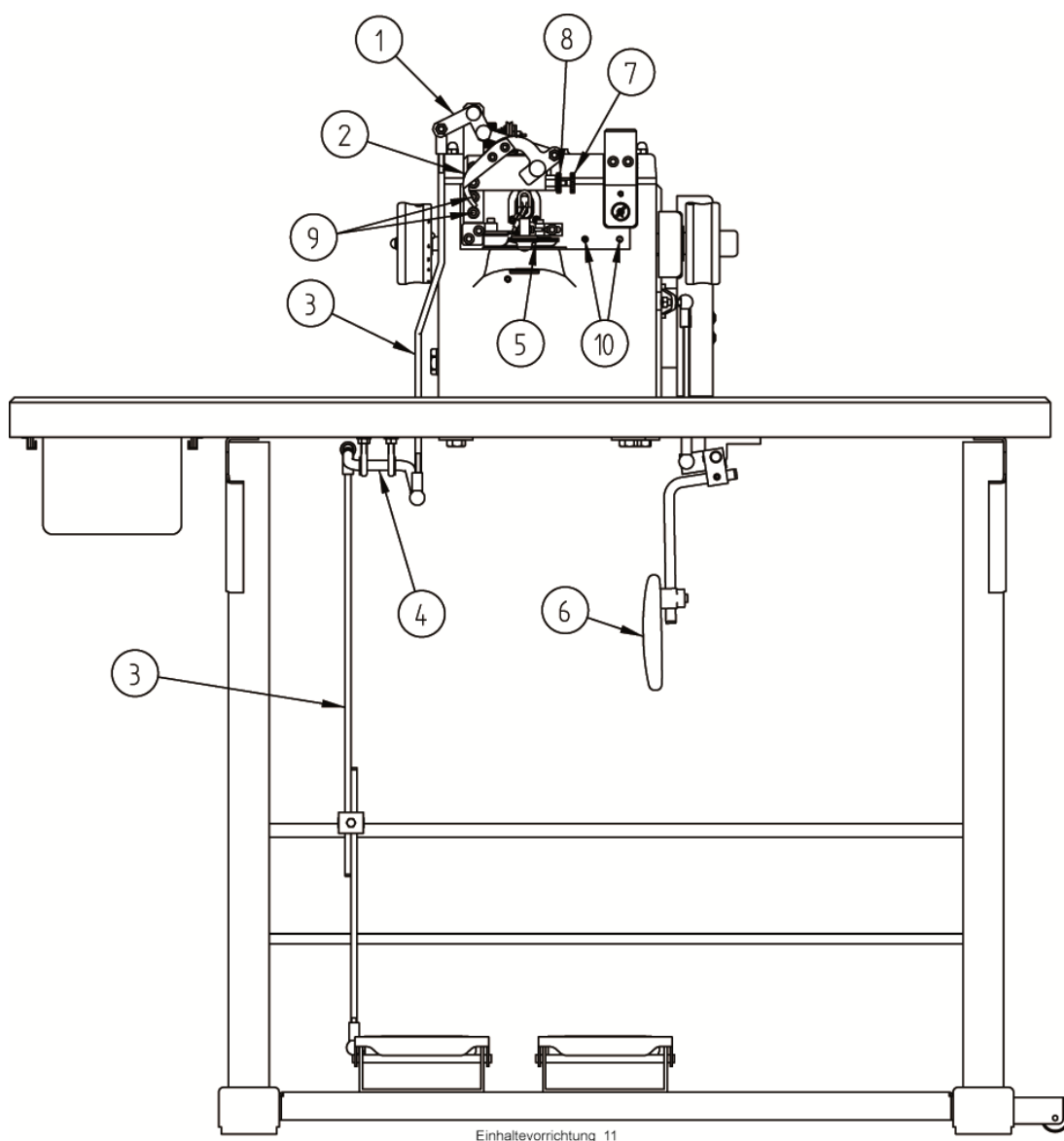
(See also operating instructions point "4.1.1.1 Processing with gathering device")

The gathering device EV (1) (Fig. 22) is attached to the machine housing with two screws (9). There are two threads made in the housing for that.

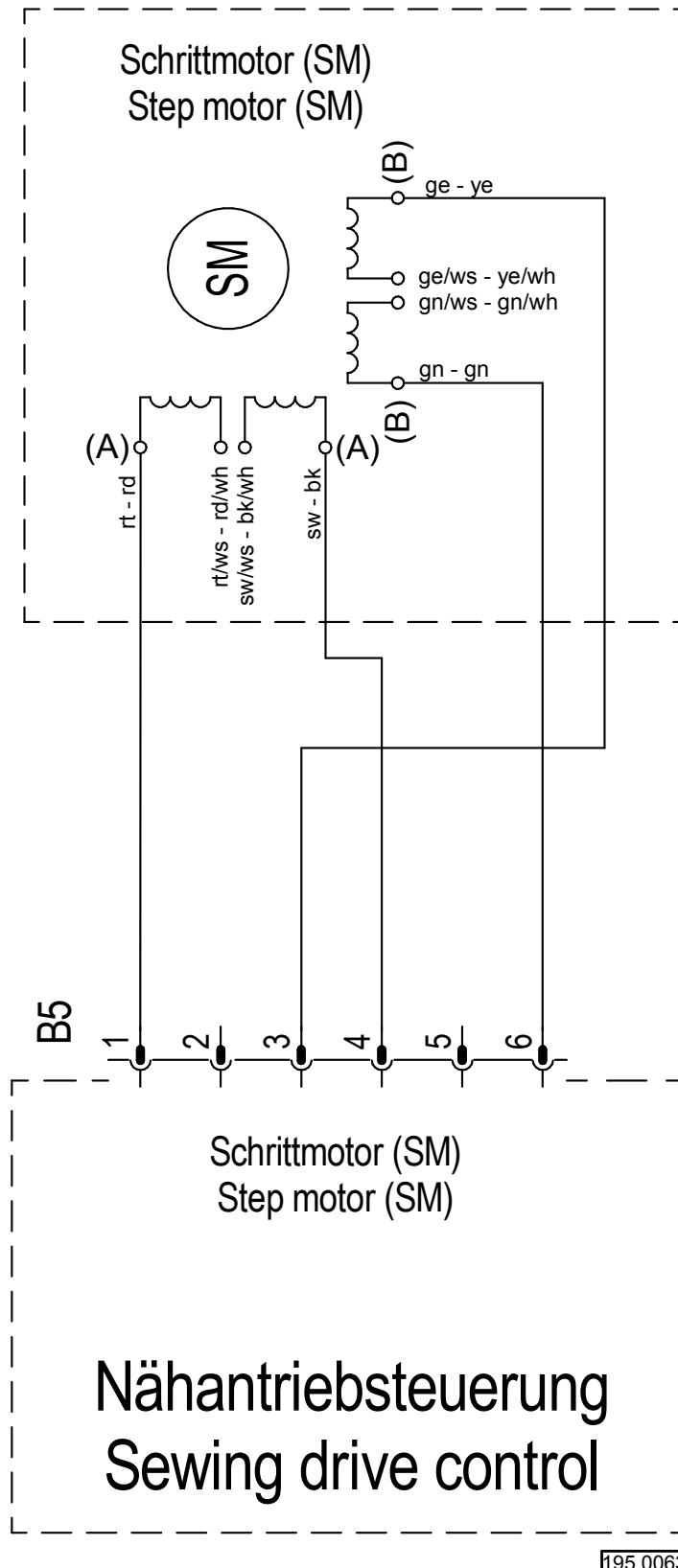
When mounting the EV, make sure that after swivelling down the guide (2) between the feed cups it comes to a stop about 1 mm under the plate edge and about 5 – 6 mm to the right of the needle.

For a subsequent mounting of the EV, a $\varnothing 24$ borehole needs to be made in the tabletop for the rods (3) (see tabletop drawing in the operating instructions).

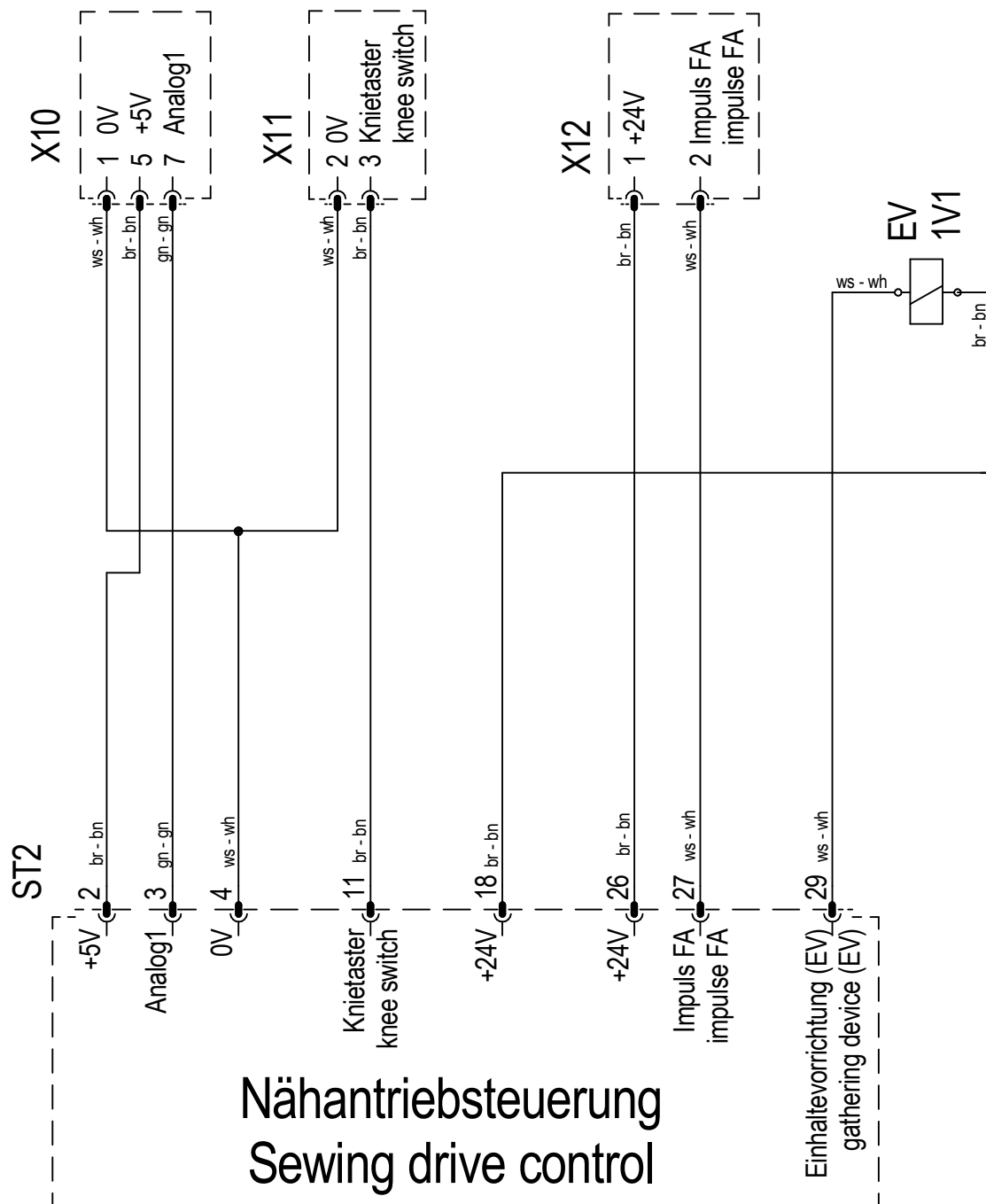
Fig. 22



Elekrischer Schaltplan AB425S Kl. 441-2 ab Ausf. 1
Electrical wiring diagram AB425S Cl. 441-2 as of version 1



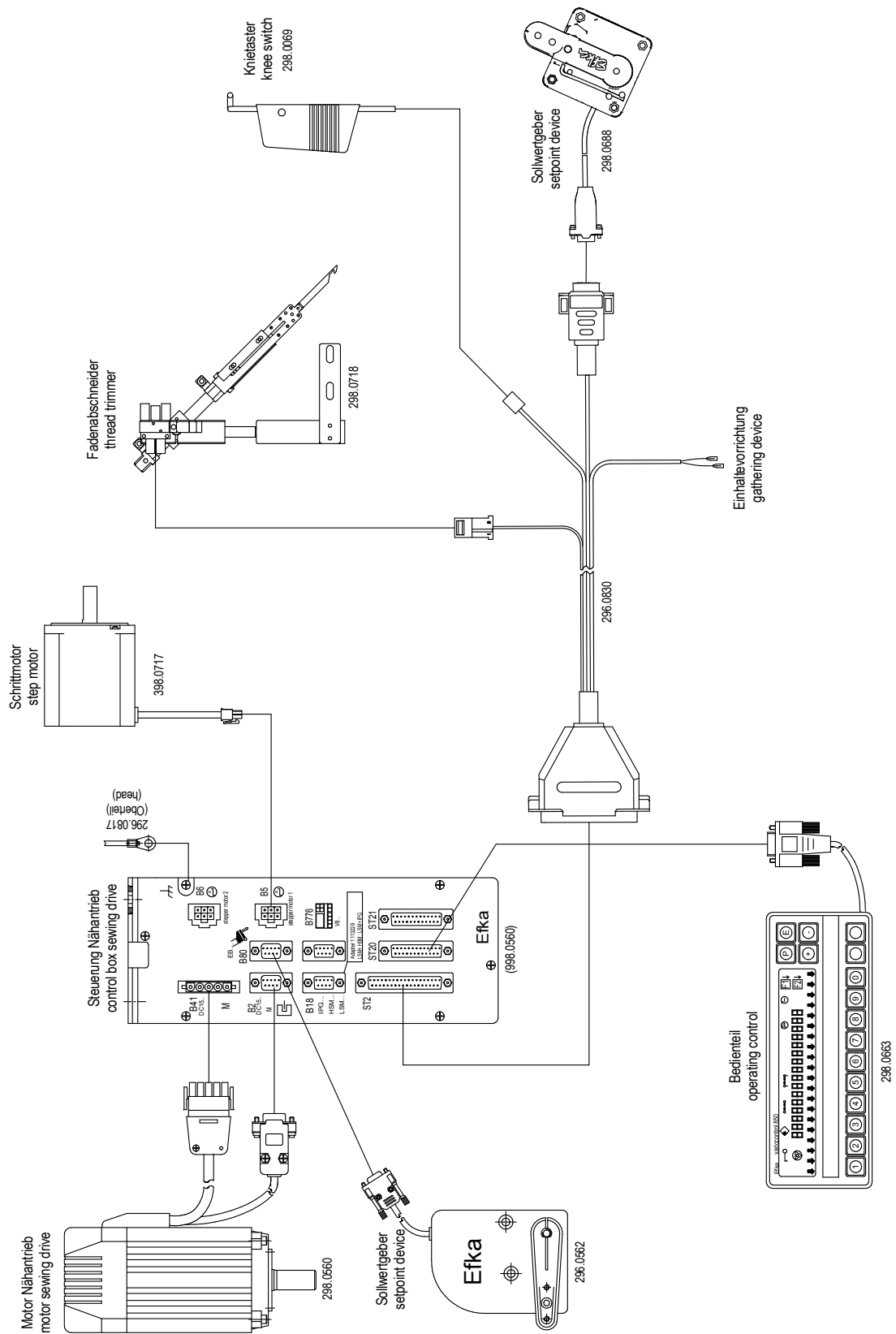
Elekrischer Schaltplan AB425S Kl. 441-2 ab Ausf. 1
Electrical wiring diagram AB425S Cl. 441-2 as of version 1



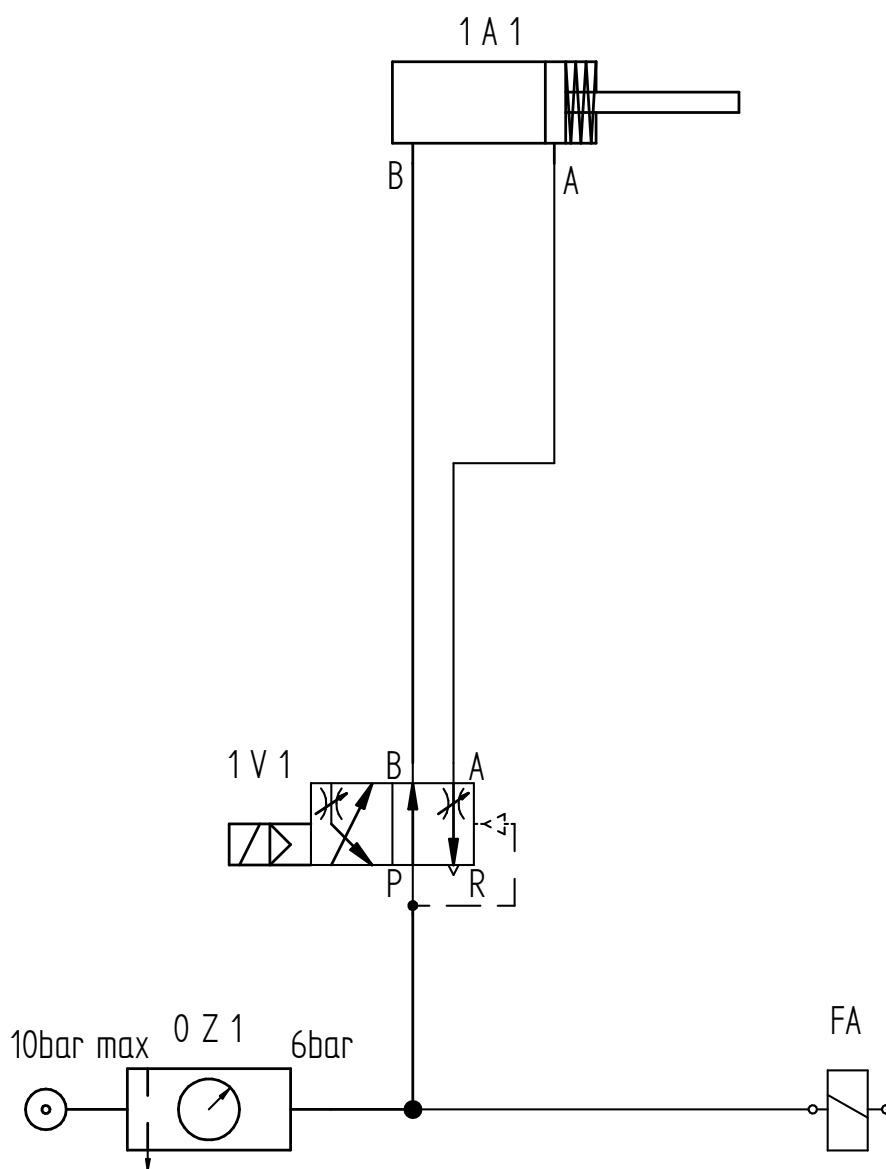
195.0064

1V1	Magnetventil "Lüftung" (LÜ)	solenoid valve "lifting" (LÜ)
EV	Einhaltvorrichtung	gathering device
ST2	Stecker Steuerkasten (Nähantrieb)	plug control box (sewing drive)
X10	9-poliger Stecker "Sollwertgeber"	9-pin plug "setpoint device"
X11	RJ12 Buchse "Knietaster"	RJ12 bush "knee switch"
X12	2-poliger Stecker "Fadenabschneider"	2-pin plug "thread trimmer"

Montageplan AB425S Kl. 441-2 ab Ausf. 1 Assembly plan AB425S cl. 441-2 as of version 1



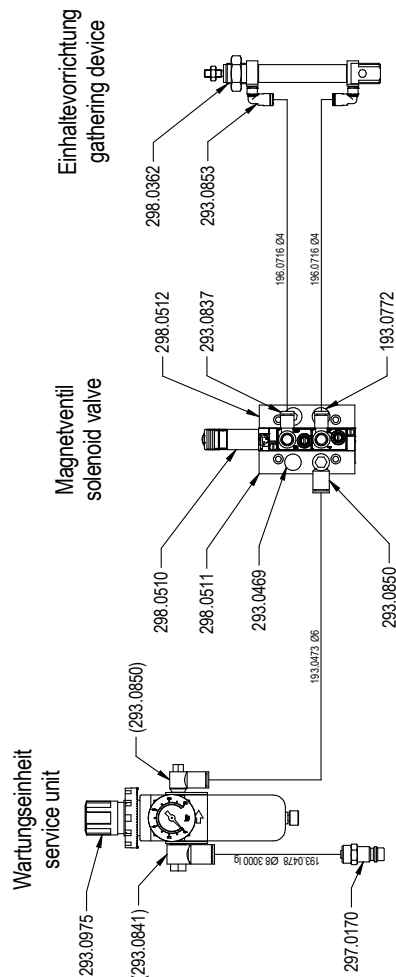
Pneumatischer Schaltplan Kl. 441-2 ab Ausf. 1 Pneumatic circuit diagram cl. 441-2 as of version 1



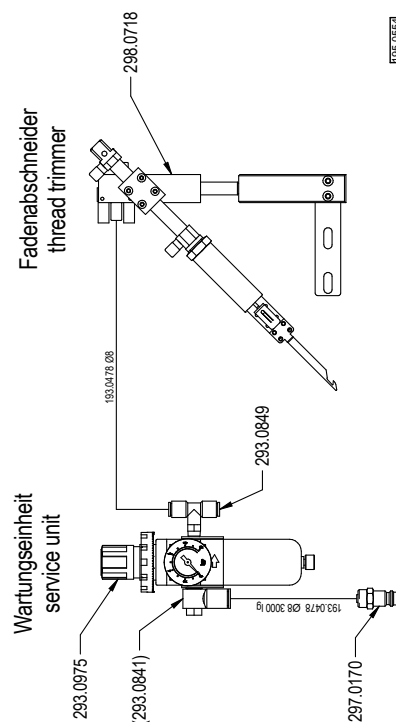
195.0553

0 Z 1	Wartungseinheit	service unit
1 V 1	4/2-Magnetventil "Einhaltevorrichtung" (P-EV)	4/2-solenoid-way valve "gathering device" (P-EV)
1 A 1	Zylinder "Einhaltevorrichtung" (P-EV)	cylinder "gathering device" (P-EV)
FA	Fadenabschneider	thread trimmer

Pneumatischer Bauschaltplan Kl. 441-2 ab Ausf. 1
Pneumatic construction circuit diagram cl. 441-2 as of version



Einhaltevorrichtung / Gathering device (EV)		
178.0009	2	Spannplattenschraube Ø5x30
193.0896	1	Tragschiene
293.0469	1	Schalldämpfer R 1/8
293.0772	2	Verschlußschraube R 1/8
293.0837	2	L-Einschraubanschluß R 1/8-4
293.0850	1	L-Einschraubanschluß R 1/8-6
293.0853	2	L-Einschraubanschluß M5-4
293.0975	1	Wartungseinheit
297.0170	1	Schnellverschlußkupplung Ø8
298.0362	1	Miniatür-Zylinder
298.0510	1	4/2-Wege Magnetventil
298.0511	1	Eingangsmodul G1/8 rechts
298.0512	1	Eingangsmodul G1/8 links
298.0517	1	Input modul G1/8 left
298.0518	1	Input modul G1/8 right
298.0519	1	4/2 solenoid-way valve
298.0520	1	Input module G1/8 left
298.0521	1	Input modul G1/8 right
298.0522	1	4/2 solenoid-way valve
298.0523	1	Input module G1/8 left
298.0524	1	Input modul G1/8 right
298.0525	1	4/2 solenoid-way valve
298.0526	1	Input module G1/8 left
298.0527	1	Input modul G1/8 right
298.0528	1	4/2 solenoid-way valve
298.0529	1	Input module G1/8 left
298.0530	1	Input modul G1/8 right
298.0531	1	4/2 solenoid-way valve
298.0532	1	Input module G1/8 left
298.0533	1	Input modul G1/8 right
298.0534	1	4/2 solenoid-way valve
298.0535	1	Input module G1/8 left
298.0536	1	Input modul G1/8 right
298.0537	1	4/2 solenoid-way valve
298.0538	1	Input module G1/8 left
298.0539	1	Input modul G1/8 right
298.0540	1	4/2 solenoid-way valve
298.0541	1	Input module G1/8 left
298.0542	1	Input modul G1/8 right
298.0543	1	4/2 solenoid-way valve
298.0544	1	Input module G1/8 left
298.0545	1	Input modul G1/8 right
298.0546	1	4/2 solenoid-way valve
298.0547	1	Input module G1/8 left
298.0548	1	Input modul G1/8 right
298.0549	1	4/2 solenoid-way valve
298.0550	1	Input module G1/8 left
298.0551	1	Input modul G1/8 right
298.0552	1	4/2 solenoid-way valve
298.0553	1	Input module G1/8 left
298.0554	1	Input modul G1/8 right
298.0555	1	4/2 solenoid-way valve
298.0556	1	Input module G1/8 left
298.0557	1	Input modul G1/8 right
298.0558	1	4/2 solenoid-way valve
298.0559	1	Input module G1/8 left
298.0560	1	Input modul G1/8 right
298.0561	1	4/2 solenoid-way valve
298.0562	1	Input module G1/8 left
298.0563	1	Input modul G1/8 right
298.0564	1	4/2 solenoid-way valve
298.0565	1	Input module G1/8 left
298.0566	1	Input modul G1/8 right
298.0567	1	4/2 solenoid-way valve
298.0568	1	Input module G1/8 left
298.0569	1	Input modul G1/8 right
298.0570	1	4/2 solenoid-way valve
298.0571	1	Input module G1/8 left
298.0572	1	Input modul G1/8 right
298.0573	1	4/2 solenoid-way valve
298.0574	1	Input module G1/8 left
298.0575	1	Input modul G1/8 right
298.0576	1	4/2 solenoid-way valve
298.0577	1	Input module G1/8 left
298.0578	1	Input modul G1/8 right
298.0579	1	4/2 solenoid-way valve
298.0580	1	Input module G1/8 left
298.0581	1	Input modul G1/8 right
298.0582	1	4/2 solenoid-way valve
298.0583	1	Input module G1/8 left
298.0584	1	Input modul G1/8 right
298.0585	1	4/2 solenoid-way valve
298.0586	1	Input module G1/8 left
298.0587	1	Input modul G1/8 right
298.0588	1	4/2 solenoid-way valve
298.0589	1	Input module G1/8 left
298.0590	1	Input modul G1/8 right
298.0591	1	4/2 solenoid-way valve
298.0592	1	Input module G1/8 left
298.0593	1	Input modul G1/8 right
298.0594	1	4/2 solenoid-way valve
298.0595	1	Input module G1/8 left
298.0596	1	Input modul G1/8 right
298.0597	1	4/2 solenoid-way valve
298.0598	1	Input module G1/8 left
298.0599	1	Input modul G1/8 right
298.0600	1	4/2 solenoid-way valve



Fadenabschneider / Thread trimmer (FA)	
1	T-Einschraubanschluß R1/8x6
1	Wartungseinheit
1	Schnellverschlusskupplung Ø8
1	Fadenabschneider
1	T-threaded connection service unit
1	coupling Ø8
1	thread trimmer

Strobel-Switchable Functions - DC1200-AB611A

		Machine class			
		Setting range		Preset at mode 56	441-1
Explanation: 0 = Off 1 = On					
F-290	Mode	00 56		56	56
"Control"	Button "E" Seg1 Softstart ON/OFF	0 1		0	0
	Button "E" Seg2 Not assigned	0 1		0	0
	Button "+" Seg3 Thread trimmer ON/OFF	0 1		0	0
	Button "+" Seg4 Output M3 ON/OFF	0 1		0	0
	Button ">>" Seg5 Basic position "needle position 1"	0 1		0	1
	Button ">>" Seg6 Basic position "needle position 2"	0 1		1	0
	Button "-" Seg7 Automatic lifting in the seam	0 1		0	0
	Button "-" Seg8 Automatic lifting at the seam end	0 1		1	1
Stand: 12.04.2018 - PT_AB611A_441-1_180412					

Strobel-Parameter list - DC1200-AB611A

		Machine class			
		Setting range	Unit	Preset at mode 56	441-1
F-467	Motor selection	1 10		3	3
F-290	Mode	00 56		56	5
F-365	Machine classes selction	0 2		0	0
F-001	Stitch number beginning backtack "simple"	000 254		003	000
F-002	Stitch number end backtack "simple"	000 254		003	000
F-003	Stitch number end backtack "double"	000 254		001	000
F-010	end backtack stitches OFF/SIMPLE/DOUBLE	0 2		0	0
F-013	Thread trimmer OFF/ON	0 1		0	0
F-014	Output 3 OFF/ON	0 1		0	1
F-019	Lifting with pedal position "-1"	0 4		3	3
F-026	Characteristic of the pedal EB401	0 4		4	4
F-100	Stitch number softstart	000 254		002	002
F-110	Positioning speed n1	070 390	min-1	200	200
F-111	Maximum speed n2- (setting range)	n2_ 9900	min-1	2200	1800
F-112	Beginning backtack speed n4	200 9900	min-1	0600	1200
F-113	End backtack speed n4	200 9900	min-1	0600	0600
F-115	Softstart speed n6	0070 1500	min-1	0500	0500
F-121	Lower limit of the n-max setting range	0200 n2-	min-1	0200	0200
F-134	Softstart OFF/ON	0 1		0	0

Strobel-Parameter list - DC1200-AB611A

		Machine class			
		Setting range	Unit	Preset at mode 56	441-1
F-135	Festoon stitch backtack OFF/ON	0 1		1	0
F-153	Holding force during machine standstill	00 50		05	05
F-155	Control signal trimming device OFF/ON	0 4		1	1
F-156	Switch-off delay, Control signal trimming device	0000 2550	ms	0200	0000
F-161	Direction of rotation of the motor	0 1		0	0
F-180	Number of turn-back steps	000 359	Grad	040	175
F-181	Switch delay for turn back	000 990	ms	200	010
F-182	Turn backOFF/ON	0 1		0	0
F-201	Switch delay of the lifting at pedal position "-1"	0020 2550	ms	1000	0080
F-202	Starting delay after the lifting signal switches off	000 500	ms	300	050
F-203	Full drive time of the lifting	000 600	ms	500	500
F-204	Holding force (continuous duty) of the lifting	F-254 1	%	040	040
F-207	Braking effect when changing the set-point ≤ 4 steps (indicated valus only with transmission ratio 1:1)	00 55		15	15
F-208	Braking effect when changing the set-point ≥ 5 steps (indicated valus only with transmission ratio 1:1)	00 55		20	20
F-210	Stop time for switching the backtack signal (festoon stitch backtack)	000 500	ms	140	140
F-219	Positioning force when stopping the drive	00 55		04	04
F-220	Accelerating power of the drive (indicated valus only with transmission ratio 1:1)	00 55		20	20

Strobel-Parameter list - DC1200-AB611A

		Machine class			
		Setting range	Unit	Preset at mode 56	441-1
F-234	Restarting after activated run inhibition	0 1		1	0
F-236	Lifting mode	0 2		2	0
F-240	Selecting the input function In.1	00 47		00	00
F-241 - F-246	Selecting the input function In.2 bis In.7	00 47		00	00
F-254	Upper limit continuous duty for lifting (F-204)	001 100	%	100	100
F-269	Positioning offset	000 100	Ink	015	010
F-270	Selection of the position sensors	0 6		0	6
F-272	Transmission motor shaft to machine shaft	0150 9999		1000	1000
F-280	Delay time Thread trimmer (M1)	0000 5000	ms	0100	0000
F-281	On-time Thread trimmer (M1)	0000 5000	ms	0180	0100
F-284	Delay time Output M3	0000 5000	ms	0000	0200
F-285	On-time Output M3	0000 5000	ms	0300	0100
F-288	Delay time till lifting On	0000 5000	ms	0200	0380

Stand: 12.04.2018 - PT_AB611A_441-1_180412

Strobel-Umschaltbare Funktionen - DC1500-AB425S

Explanation: 0 = Off 1 = On		Machine class				
		Setting range		Preset at mode 56	441-2	441-2 mit Fadenabschneider
F-290	Mode	00 56		56	56	56
"Control"	Button "E" Seg1 Softstart ON/OFF	0 1		0	0	0
	Button "E" Seg2 Not assigned	0 1		0	0	0
	Button "+" Seg3 Thread trimmer ON/OFF	0 1		0	0	0
	Button "+" Seg4 Output M3 ON/OFF	0 1		0	0	0
	Button ">>" Seg5 Basic position "needle position 1"	0 1		0	1	1
	Button ">>" Seg6 Basic position "needle position 2"	0 1		1	0	0
	Button "-" Seg7 Automatic lifting in the seam	0 1		0	0	0
	Button "-" Seg8 Automatic lifting at the seam end	0 1		1	1	1

Stand: 12.04.2018 - PT_AB425S_441-2_180412

Strobel-Parameter list - DC1200-AB425S

		Machine class				
		Setting range	Unit	Preset at mode 56	441-2	441-2 with Thread trimmer
F-467	Motor selection	1 10		3	1	1
F-290	Mode	00 56		56	5	5
F-365	Machine classes selction	0 2		0	1	1
F-001	Stitch number beginning backtack "simple"	000 254		003	000	000
F-002	Stitch number end backtack "simple"	000 254		003	000	000
F-003	Stitch number end backtack "double"	000 254		001	000	000
F-010	end backtack stitches OFF/SIMPLE/DOUBLE	0 2		0	0	0
F-013	Thread trimmer OFF/ON	0 1		0	0	1
F-014	Output 3 OFF/ON	0 1		0	1	1
F-019	Lifting with pedal position "-1"	0 4		3	3	3
F-026	Characteristic of the pedal EB401	0 4		4	4	4
F-100	Stitch number softstart	000 254		002	002	002
F-110	Positioning speed n1	070 390	min-1	200	200	200
F-111	Maximum speed n2- (setting range)	n2_ 9900	min-1	2200	1800	1800
F-112	Beginning backtack speed n4	200 9900	min-1	0600	1200	1200
F-113	End backtack speed n4	200 9900	min-1	0600	0600	0600
F-115	Softstart speed n6	0070 1500	min-1	0500	0500	0500
F-121	Lower limit of the n-max setting range	0200 n2-	min-1	0200	0200	0200
F-134	Softstart OFF/ON	0 1		0	0	0

Strobel-Parameter list - DC1200-AB425S

		Machine class				
		Setting range	Unit	Preset at mode 56	441-2	441-2 with Thread trimmer
F-135	Festoon stitch backtack OFF/ON	0 1		1	0	0
F-153	Holding force during machine standstill	00 50		05	05	05
F-155	Control signal trimming device OFF/ON	0 4		1	1	1
F-156	Switch-off delay, Control signal trimming device	0000 2550	ms	0200	0000	0000
F-161	Direction of rotation of the motor	0 1		0	0	0
F-180	Number of turn-back steps	000 359	Grad	040	040	040
F-181	Switch delay for turn back	000 990	ms	200	200	200
F-182	Turn backOFF/ON	0 1		0	0	0
F-201	Switch delay of the lifting at pedal position "-1"	0020 2550	ms	1000	1000	1000
F-202	Starting delay after the lifting signal switches off	000 500	ms	300	300	300
F-203	Full drive time of the lifting	000 600	ms	500	500	500
F-204	Holding force (continuous duty) of the lifting	F-254 1	%	040	040	040
F-207	Braking effect when changing the set-point ≤ 4 steps (indicated valus only with transmission ratio 1:1)	00 55		15	15	15
F-208	Braking effect when changing the set-point ≥ 5 steps (indicated valus only with transmission ratio 1:1)	00 55		20	20	20
F-210	Stop time for switching the backtack signal (festoon stitch backtack)	000 500	ms	140	140	140
F-219	Positioning force when stopping the drive	00 55		04	04	04
F-220	Accelerating power of the drive (indicated valus only with transmission ratio 1:1)	00 55		20	35	35

Strobel-Parameter list - DC1200-AB425S

		Machine class				
		Setting range	Unit	Preset at mode 56	441-2	441-2 with Thread trimmer
F-234	Restarting after activated run inhibition	0 1		1	0	1
F-236	Lifting mode	0 2		2	2	2
F-240	Selecting the input function In.1	00 47		00	00	00
F-241 - F-246	Selecting the input function In.2 bis In.7	00 47		00	00	00
F-254	Upper limit continuous duty for lifting (F-204)	001 100	%	100	100	100
F-269	Positioning offset	000 100	Ink	015	015	015
F-270	Selection of the position sensors	0 6		0	0	0
F-272	Transmission motor shaft to machine shaft	0150 9999		1000	1000	1000
F-280	Delay time Thread trimmer (M1)	0000 5000	ms	0100	0000	1000
F-281	On-time Thread trimmer (M1)	0000 5000	ms	0180	0180	0180
F-284	Delay time Output M3	0000 5000	ms	0000	0200	0200
F-285	On-time Output M3	0000 5000	ms	0300	0300	0300
F-288	Delay time till lifting On	0000 5000	ms	0200	0200	0200

Stand: 12.04.2018 - PT_AB425S_441-2_180412

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Noch Fragen?

Dann rufen Sie uns an, schreiben Sie uns oder kommen Sie einfach bei uns vorbei. Sie können jederzeit weitere Informationen über unsere Produkte anfordern oder die Strobel-Nähmaschinen in unserem Ausstellungsraum live erleben. Wir freuen uns auf Sie!

Any further questions?

Then phone, write or simply come and see us. You can have further information about our products at any time, or experience the Strobel machines live in our show room. We're looking forward to meeting you!

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