Mechanic's Instructions

Mechanikeranleitung

Class:	**443-1**	**Ausf. 1**
Klasse:	**443-2**	**Ausf. 1**

Dated:
Stand:

STROBEL
S p e z i a l m a s c h i n e n   G m b H

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.

STROBEL
Spezialmaschinen GmbH

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Mechanic's instructions
STROBEL Class 443-1 and 443-2

Contents

Subject to change without prior notice

1 General notes on safety

Manuals and additional information can be found on the STROBEL website at:

http://www.strobel.biz

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 physical injuries 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 bobbin, exchanging sewing tools such as needle, hook, stitch plate, transport devices, trimming knive 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 description, serial number and initial basis for description

For side-referenced descriptions, the operating side of the machine is the starting base.

The class descriptions (type), the serial and model number (after the hyphen) can be found on the rating plate on the back of the machine.

2.3 Range of application and intended use

Class 443-1

Single Thread Overseaming 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 443-2

Single Thread Overseaming Machine for attaching soles to shoes made of heavy textile material and leather up to a total thickness of 7 mm, with differential drive.

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
2.4   Technical data

2.4.1   Class 443-1

	Empfohlene Nennstichzahl / Recommended rated speed	1800 min-1
	Stichlänge / stitch length	3,0 - 7,0 mm Auslieferzustand / delivery condition 4,5 mm
	Nadelsystem / needle system Nadelstärke / needle size	GROZ-BECKERT 134 140/22 LR
	Nadelhöhenverstellung / Adjustable needle height	
	Fadenabschneider pneumatisch / thread trimmer pneumatic	Optional
	Fadenspannung / thread tension Faden / thread	Auslieferzustand / delivery condition 150 cN Polyester, endlos gezwirnt 40/ polyester continuous filament 40
	Freiraum / free space	60 mm
	Einhaltevorrichtung manuell / Gathering device manually	

Technischer Auslieferzustand / delivery condition:	
Riemenscheibendurchmesser Maschine/ machine pulley diameter	dw 80 mm
Keilriemen-Profil / V-belt profile	10 x 6 mm
Stichart / stitch type	Einfaden-Überwendlichstich Typ 501 / single-thread overcast stitch type 501
Anschluss pneumatisch / pneumatic connection	6 bar
Luftverbrauch, Mittelwert / avarage air consumption	abhängig von der Ausstattung / depending on the equipement
Stellfläche / Foot print	0,5 m x 1,1 m
Arbeitsgeräusch / operating noise at 1800 min-1 nach DIN 45635-48-1 KL3	LpAm 71 dB(A)

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2.4.2   Class 443-2

	Empfohlene Nennstichzahl / Recommended rated speed	1800 min-1
	Stichlänge / stitch length	3,0 - 7,0 mm Auslieferzustand / delivery condition 4,5 mm
	Programmierbar / programable	
	Differential-Tellertransport / differential cup feed	REDUZIERBAR bis / REDUCIBLE until 50%
	Nadelsystem / needle system Nadelstärke / needle size	GROZ-BECKERT 134 140/22 LR
	Nadelhöhenverstellung / Adjustable needle height	
	Fadenabschneider pneumatisch / thread trimmer pneumatic	optional
	Fadenspannung / thread tension Faden / thread	Auslieferzustand / delivery condition 150 cN Polyester, endlos gezwirnt 40/ polyester continuous filament 40
	Freiraum / free space	60 mm
	Einhaltevorrichtung pneumatisch / Gathering device pneumatic	optional

| Technischer Auslieferzustand / delivery condition:	
Motor-Leistung min. / min. motor power	550 W
Zahnriemenscheibe Maschine / toothed belt pulley/machine	Z = 38
Zahnriemenprofil / toothed belt profile	HTD 5M-9
Stichart / stitch type	Einfaden-Überwendlichstich Typ 501 / single-thread overcast stitch type 501
Anschluss pneumatisch / pneumatic connection	6 bar
Luftverbrauch, Mittelwert / avarage air consumption	abhängig von der Ausstattung / depending on the equipement
Stellfläche / Foot print	0,5 m x 1,1 m
Arbeitsgeräusch / operating noise at 1800 min-1 nach DIN 45635-48-1 KL3	LpAm 76,1 dB(A)

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2.5   <u>Abridged version of adjustment manual</u>

Setting value		
Class 443-1, -2	**Dimension**	
Needle type		134
Needle size		120 - 140
Stitch length	**A**	3 - 7
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 48.5
Rear end position / Position with needle	**N**	about 9.4

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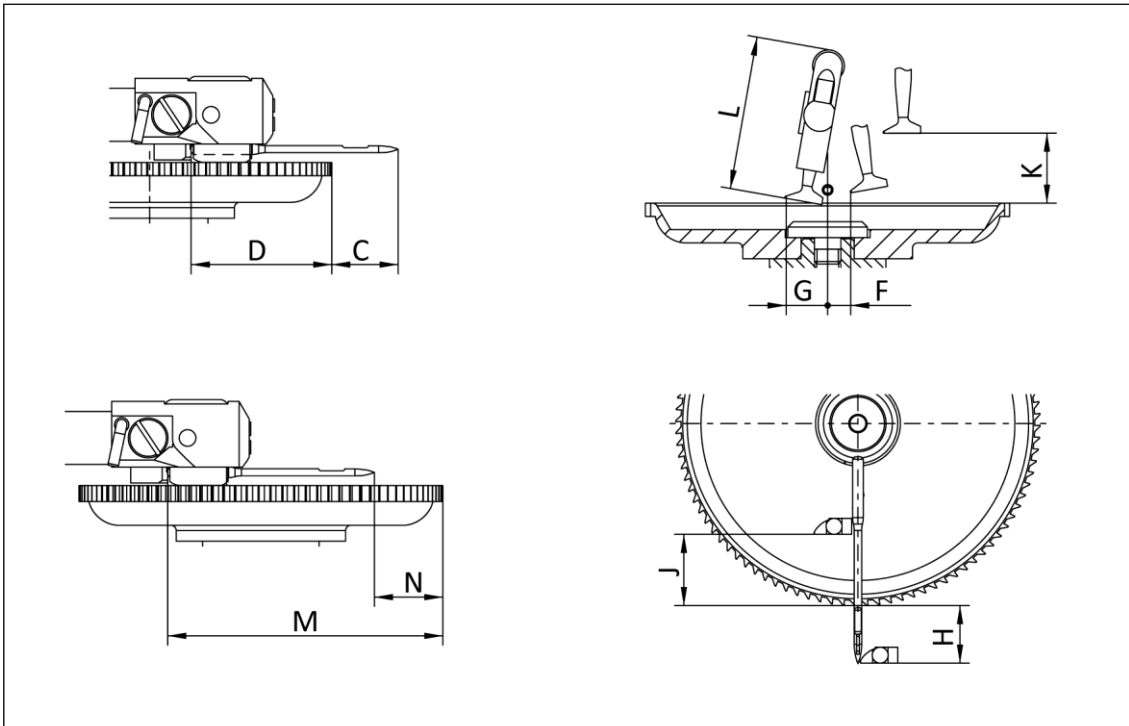
Einstellwerte_10

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). (Fig. 4)

This will save a lot of time during the assembly for calibration.

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

Cl. 443-1

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

Fig. 1

Hauptwellenausbau_09

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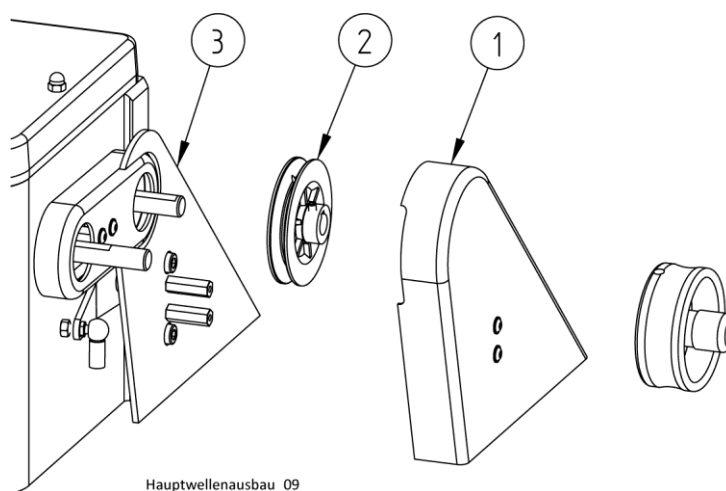
Cl. 443-2

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

Fig. 2

Hauptwellenausbau_10
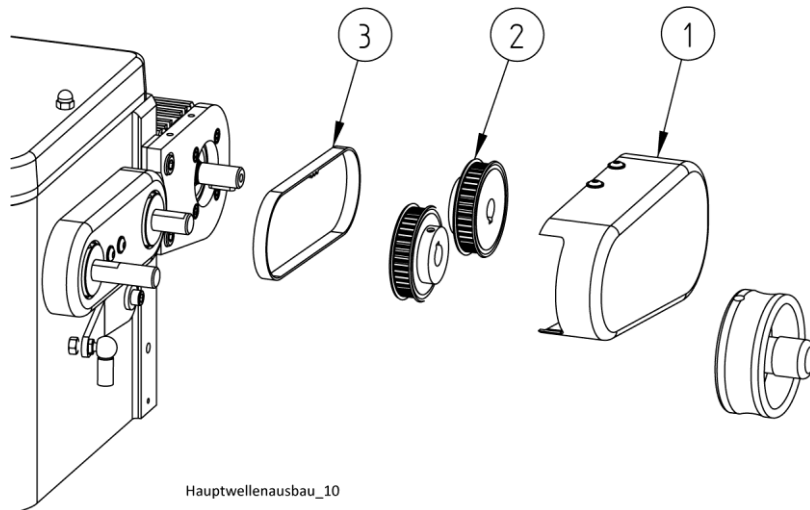
Afterwards the belt guard (1). Now make a note of how the two toothed belt pulleys (2) are mounted on the front and rear shaft. Now the toothed belt pulleys (2) can be taken off with the toothed belt. (Fig. 3)

Fig. 3

Hauptwellenausbau_11
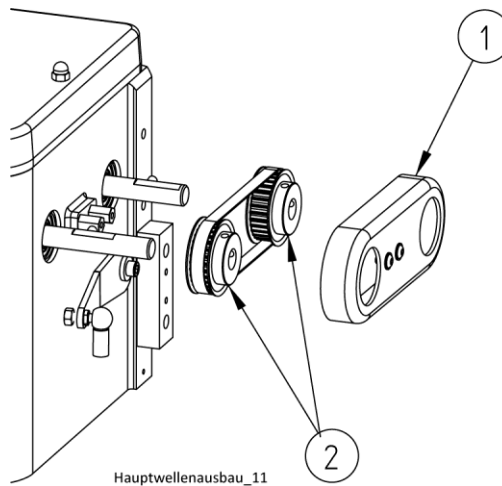
The left handwheel with the stitch variable eccentric bolt does not need to be removed. **Make sure** that the threaded pins (2) located on both sides of the variable eccentric (A) (1) are removed.
(Fig. 4 and Fig. 5)

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

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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.

Fig. 4

Hauptwellenausbau_14

Fig. 5

Hauptwellenausbau_08

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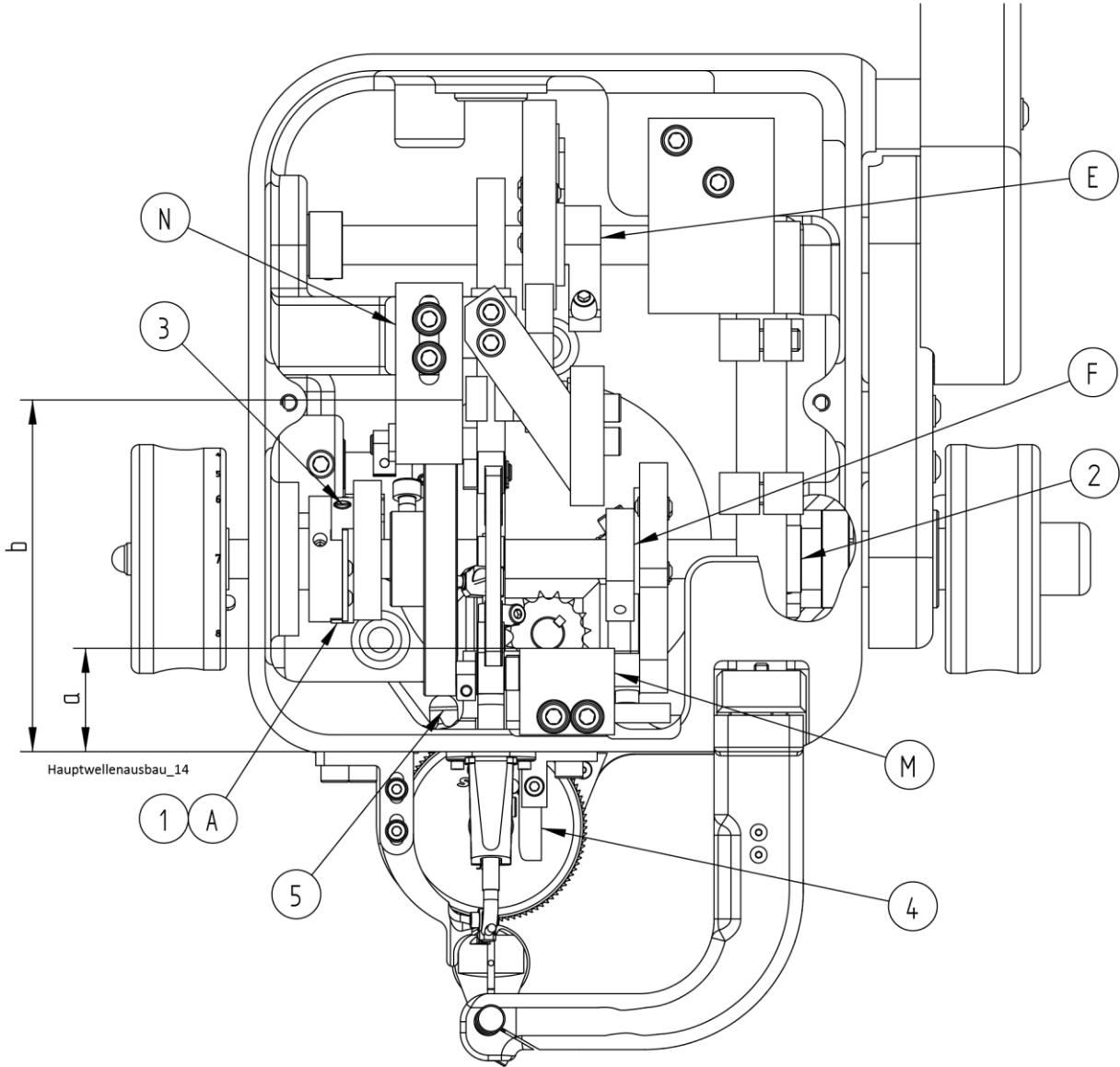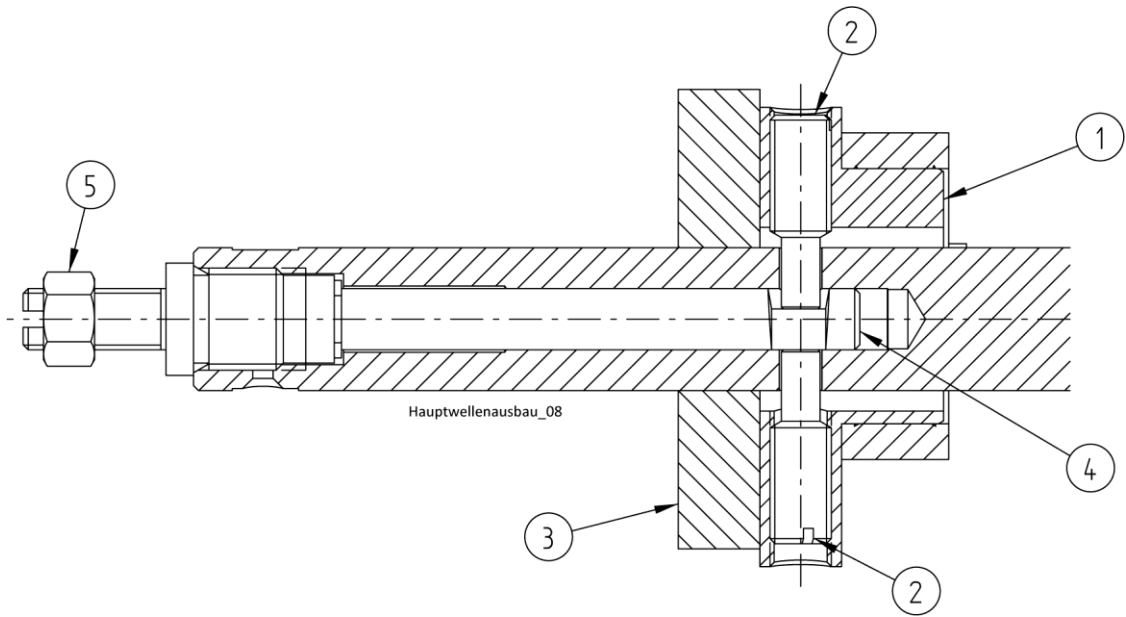
4 Assembly of the machine

4.1 Assembly of the shaft (Fig. 4, Fig. 7 and Fig. 8)

After all the parts have been threaded onto the shaft in the correct order, the shaft can be pushed all the way into the stand. Fix the stitch eccentric (A) (1) (see point "4.2 Assembly of the stitch variable eccentric (Fig. 4 to Fig. 8)"), push the shaft to the left as far as it will go and seal the adjusting ring (2) on the right-hand side of the shaft so that the axial air in the shaft is eliminated. (Fig. 4)

4.2 Assembly of the stitch variable eccentric (Fig. 4 to Fig. 8)

Mount the left handwheel (1) on the installed shaft (2) so that the tip of the first screw (3) fits, in the direction of rotation, into the depression of the left radial bore of the shaft and stands upwards during that. (Fig. 6)

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. 7).

Fig. 6

Hauptwellenausbau_15

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Fig. 7

Handrad links
handwheel left

Stichstellexzentermontage_08

Fig. 8

Stichstellexzentermontage_09
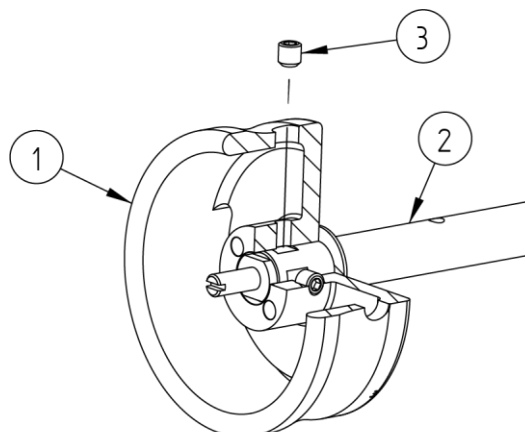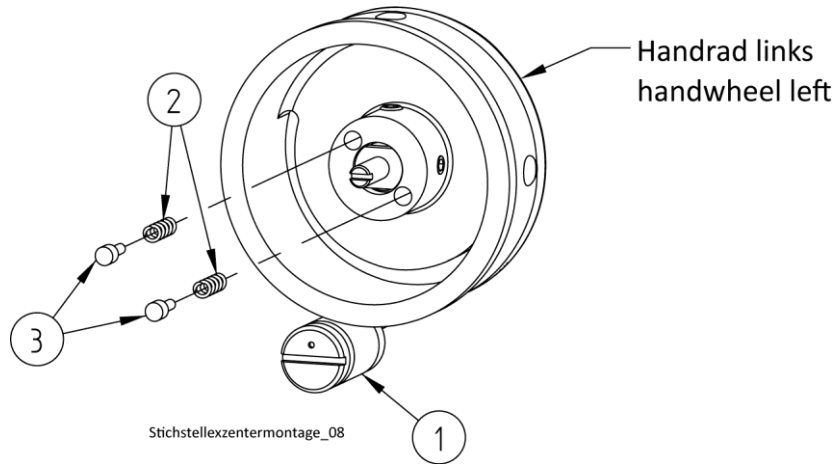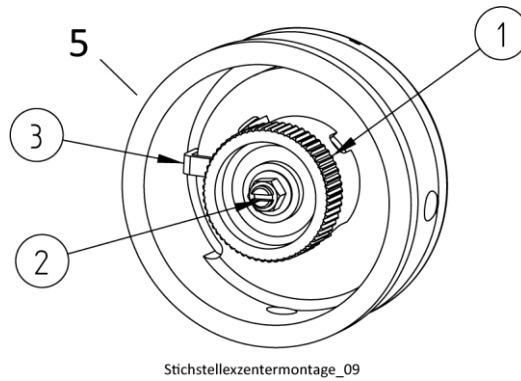
Screw the control knob (1) onto the shaft or the adjustment bolt (2) until the control knob contacts the handwheel. Hold the control knob tight and screw out the adjustment bolt until the pointer (3) on the control knob of the handwheel (marking 5), (large stitch), contacts and can be slightly seen between handwheel and stand. (Fig. 8)

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)

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4.3 Setting the ecc. pin for stitch adjustment (Fig. 4 and Fig. 9)

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. 7) 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. 9)

Fig. 9

Stichverstellung_06
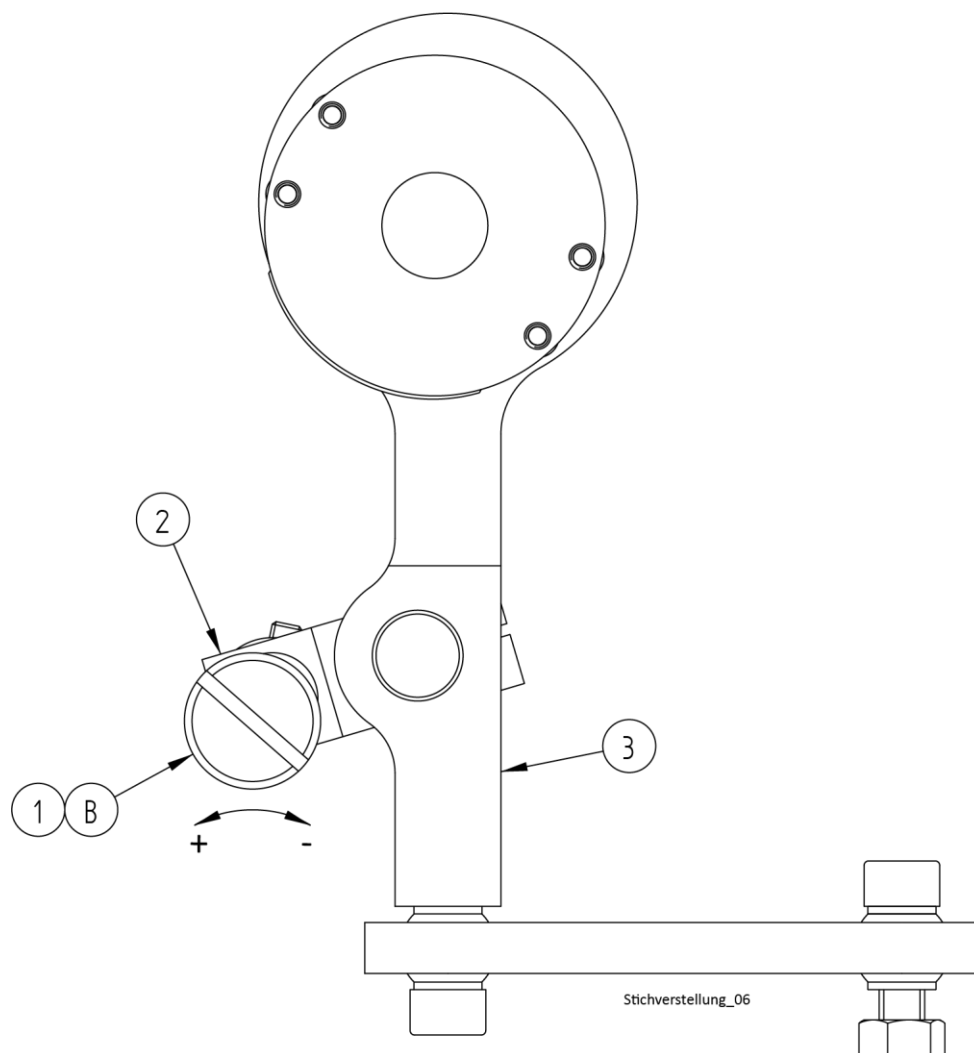
4.4   <u>Setting of the needle and transport movement</u>

If the largest stitch length is set (see "1 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. 10), by the crank distance and by the bore distance of the clamping lever (2) (Fig. 10). The looper movement has to equal temporally the needle bar movement.

The curve form of the control curve (3) (Fig. 10) produces the lateral looper deflection, corresponding to the needle movement.

Make sure that the looper carriage (4) (Fig. 10) or the looper shaft is mounted exactly centrally to the needle bar (5) (Fig. 10).

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. 10) (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. 10)

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. 10). 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.

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Fig. 10

Greiferbewegung_13
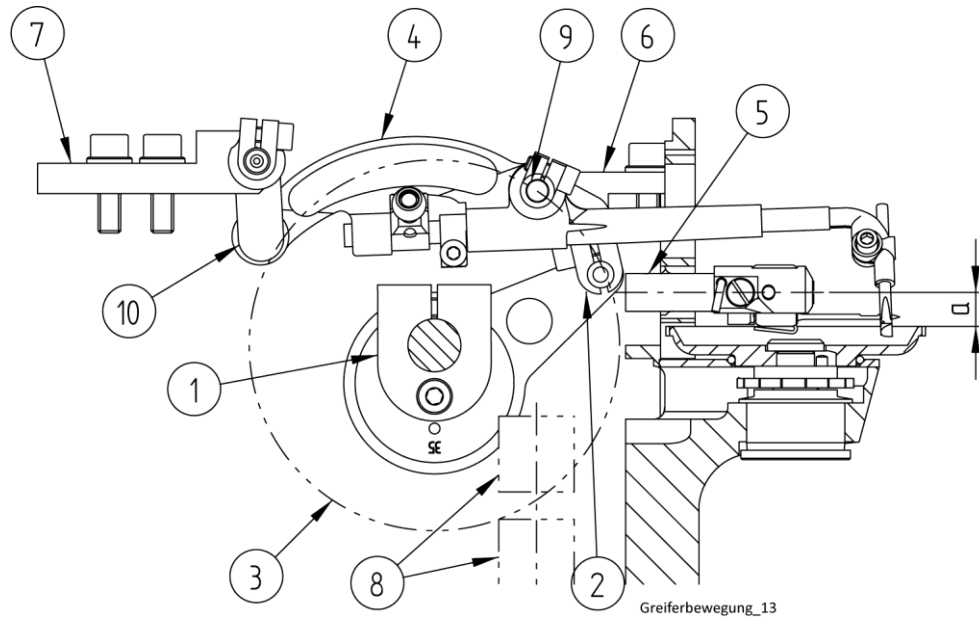
4.5.2   Setting the looper eccentric

Set the looper eccentric (1) (at position "1") so that its surface is horizontal (Fig. 10). During a later partial rotation of about 100° at the handwheel (position "2"), the backmost 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. 11a). 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. 11b). 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. 11

a   b

Greiferbewegung_14

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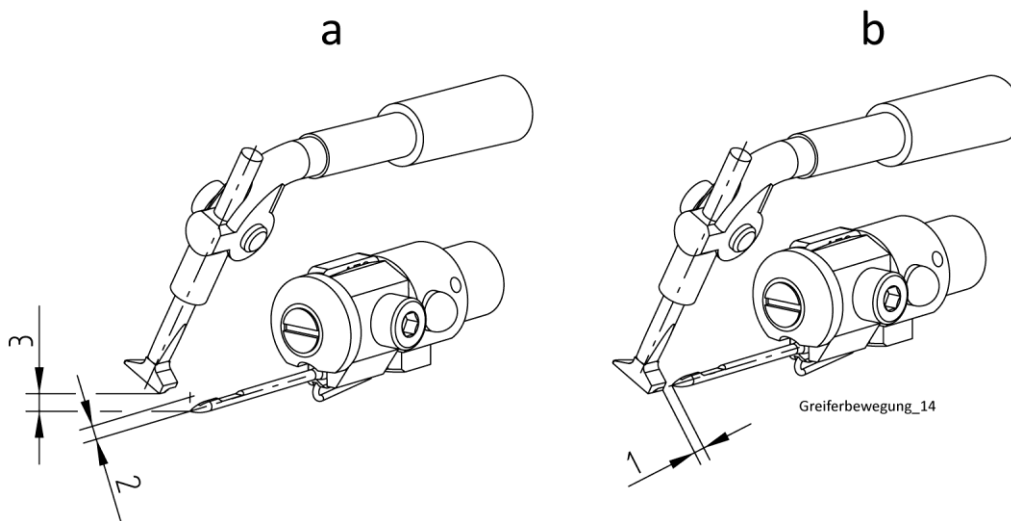
4.5.3   Setting the front crank

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

The looper height movement is influenced by the front crank (9). (Fig. 10)

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. 11b).

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. 10) 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.

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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. 15) results in mounted condition feed cup (5).

4.7 Assembly of the front cup

Cl. 443-1 (Fig. 15)

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. 443-2 (Fig. 12)

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. 12)

The gap can be adjusted with threaded pin (4) and secured with threaded pin (5). (Fig. 13)

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. 12)

Fig. 12

Anpressteller_05
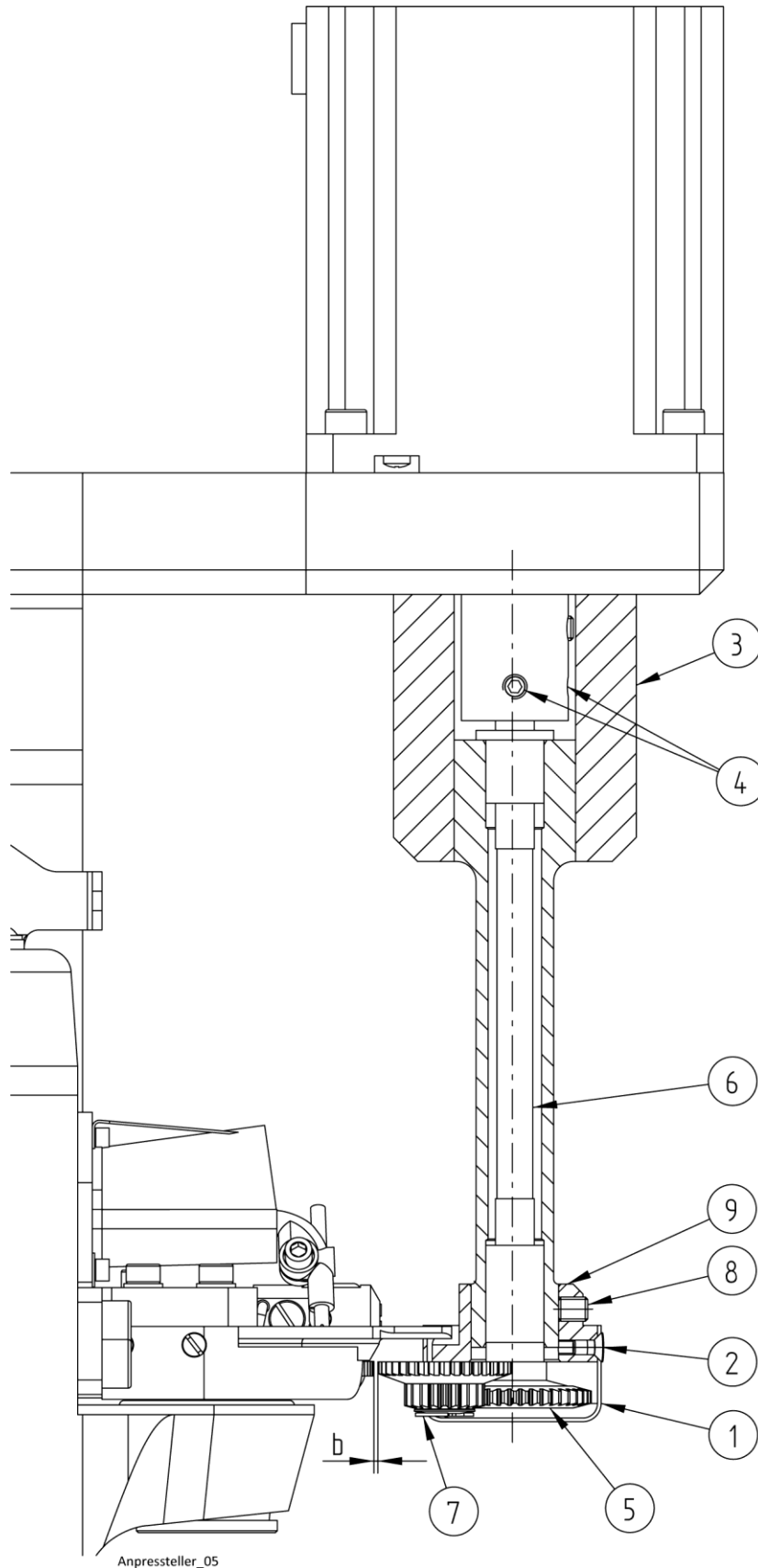
4.8 Tread lifting in the needle bar head

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. 13)

Fig. 13

Fadenlüftung_03
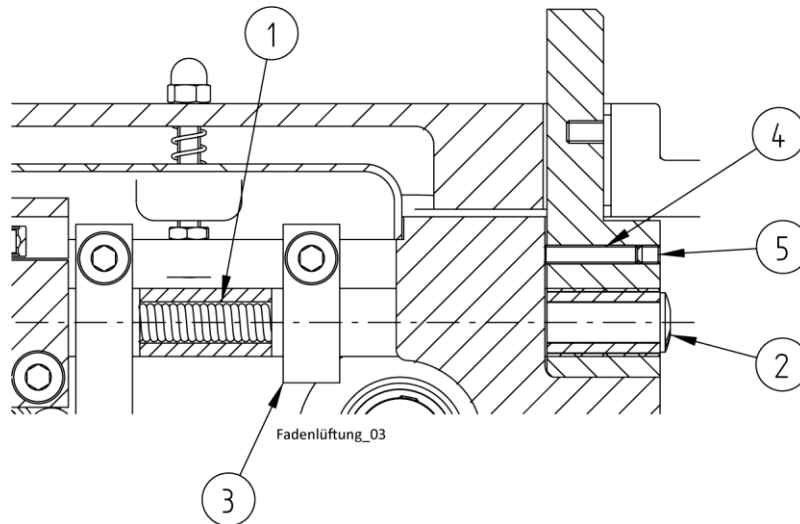
4.9.1 Plate arm lifting

The plate arm lifting is about 12 - 14 mm and can be adjusted using the lever (3). (Fig. 13)

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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. 14)

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. 14

Nadel_einsetzen_47

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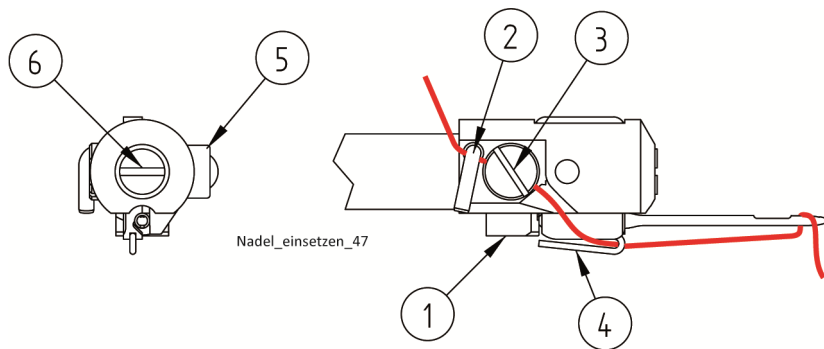
4.11 <u>Replacing the looper</u>

After loosening the clamping screw (1) (Fig. 15) 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. 15

Greiferwechsel_08

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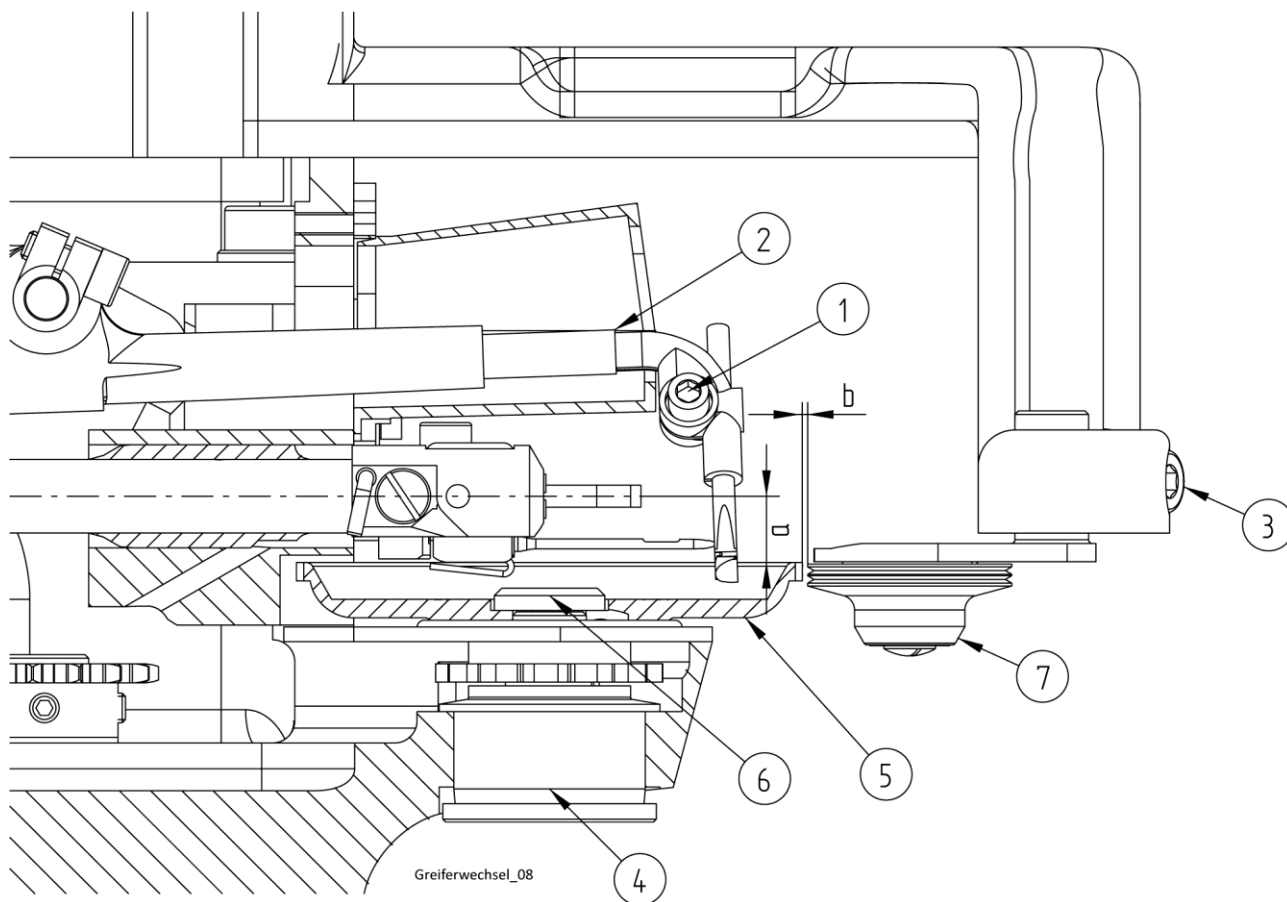
4.12   Thread trimmer (optional)

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. 28) 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.

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

More Details see point „4.14.3 Adjustment of the needle position for the use of our thread trimmer".

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. 16)

Fig. 16

Fadenabschneider_3980718_01

STROBEL
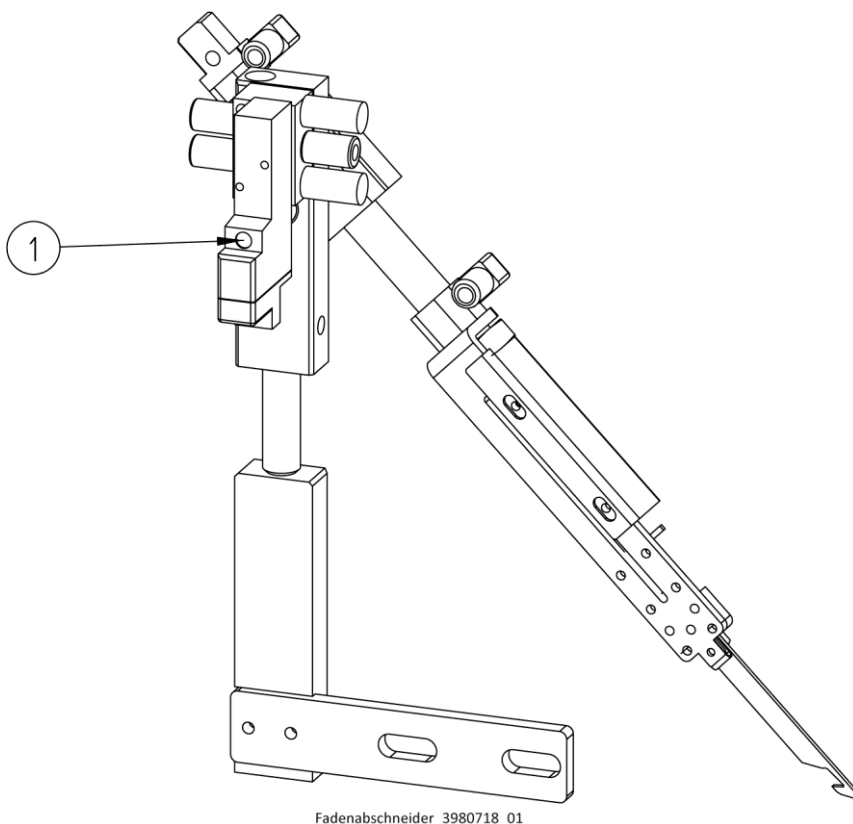
4.13   Positions

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. 17):

> 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. 17
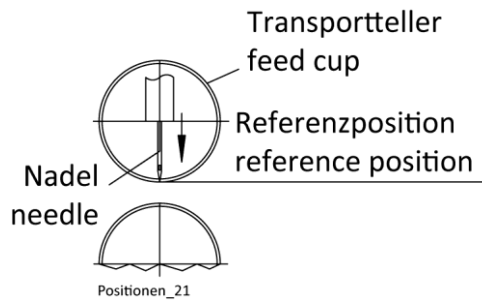
Refer to the enclosed sewing drive instructions for the programming of the positions on the motor.

Needle position (when stop inside the stitch with pedal position "0" (Fig. 18)):

> 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. 18
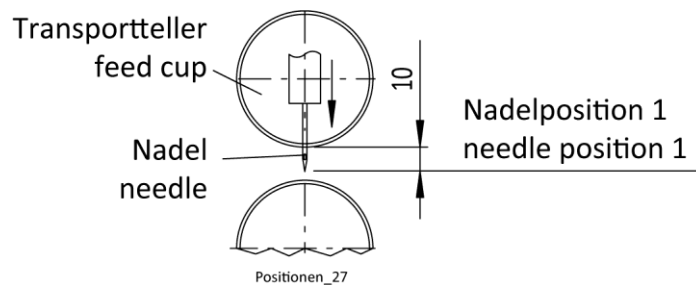
Needle position (when stop outside the stitch with pedal position "-2" (Fig. 19)):

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. 19
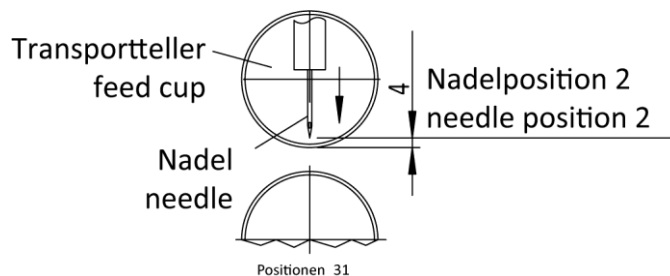
Afterwards, check its function by manually actuating the thread trimmer.

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. 17).

- 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 "5913" 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. 18). 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. 19). 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.

Needle positions		
Parameter		Value
F-451	P1E	036
F-452	P1A	061
F-453	P2E	342
F-454	P2A	009

Starting point for stepper motor	
Parameter	Value
F-749	220

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4.14.3 <u>Adjustment of the needle position for the use of our thread trimmer</u>

When the thread trimmer is mounted, the needle position parameters and parameter F-749 must be changed.

Needle positions		
Parameter		Value
F-451	P1E	036
F-452	P1A	061
F-453	P2E	273
F-454	P2A	298

After entering the code number "5913" for the supplier level:

- Select parameter F-451 and confirm with the "E" key

- Set the value according to table (Needle positions) and confirm with the key "E"

- Go to the next parameter and set the value as described in the chart (Needle positions) and continue this procedure   up to Parameter F-454.

- Save the data by pressing the "P" key twice and exit the supplier level.

Starting point for the stepper motor F-749	
Operation without thread cutter	Value 220 (Factory setting)
Operation with thread trimmer	Value 289

Starting point for the stepper motor F-749

- Select parameter F-749 and confirm with the "E" key

- Change the value to the value "289" and confirm with the "E" key

- Press the "P" key

Procedure to save the change

- Select parameter F-401

- change value to "1"

- Save the data by pressing the "P" key twice and exit the supplier level.

- Switch the control box off and on again so that the change is saved.

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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.

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4.17 Working with the control AB425

⚠	**A T T E N T I O N !** Switch off the machine electrically!

Bevor sewing!
Care must be taken when the machine is switched on via the main switch, that a reference run without material is done to synchronize the stepper motor.
Note: The transport plate should make at least one full turn.

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".

Fig. 20

Rechenbeispiel / Specimen calculation

Messergebniss = 65,50mm / 10 = 6,550mm Stichlänge
Eingabe der Stichlänge in Parameter 711 = 06550

Measurement = 65,50mm / 10 = 6,550mm Stitchlenght
Enter the value in the Parameter 711 = 06550
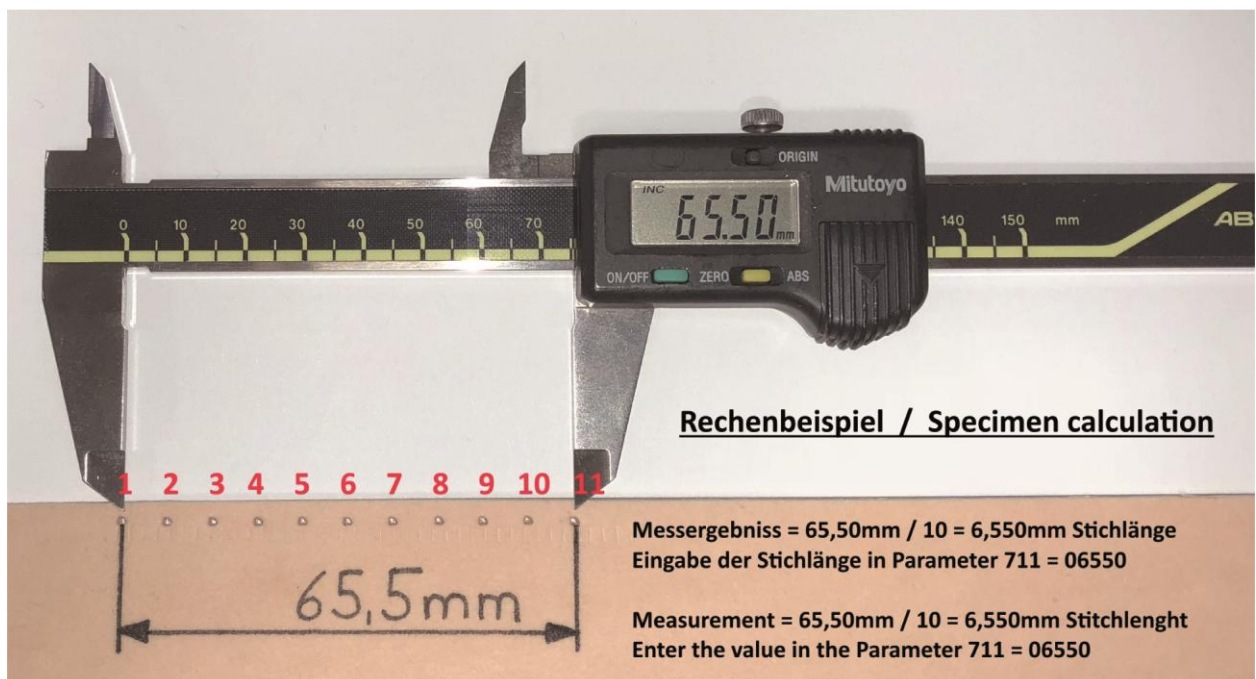
Stichlängeneinstellung_21

4.17.2 Working with operating control (V850) (Fig. 21)

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. 21

Example:
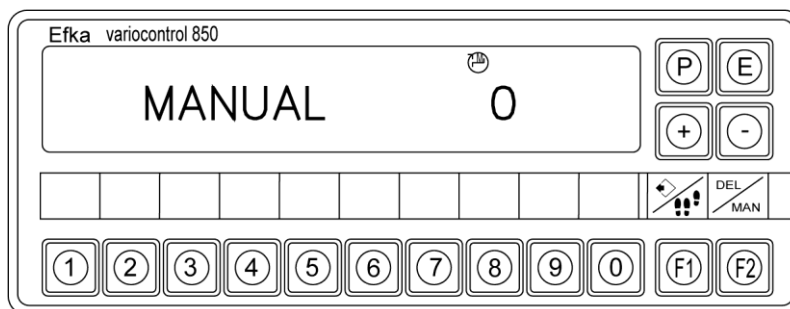
Bedienteil_V850_AB425S_441_01

Example:
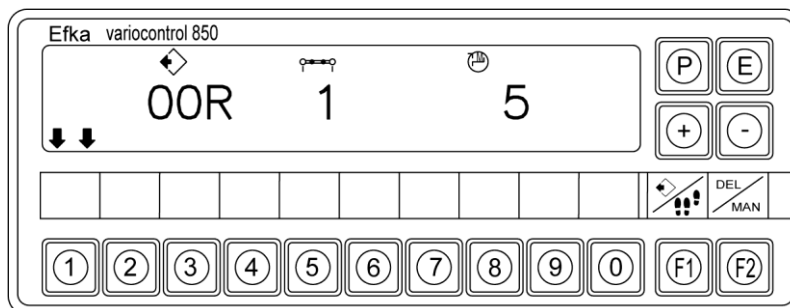
Bedienteil_V850_AB425S_441_02

1. Display "Standard"
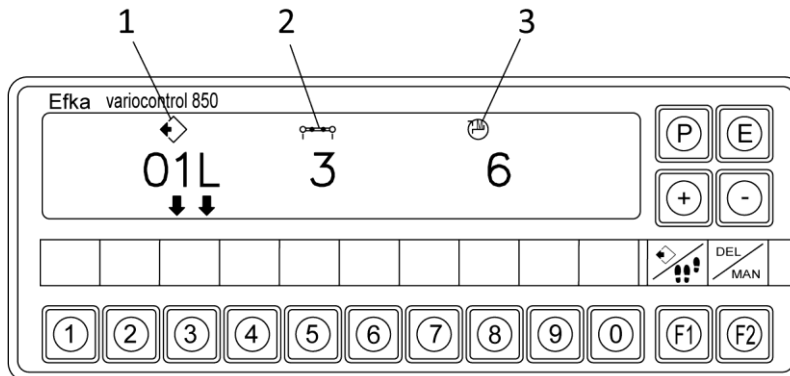
Bedienteil_V850_AB425S_441_03

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".
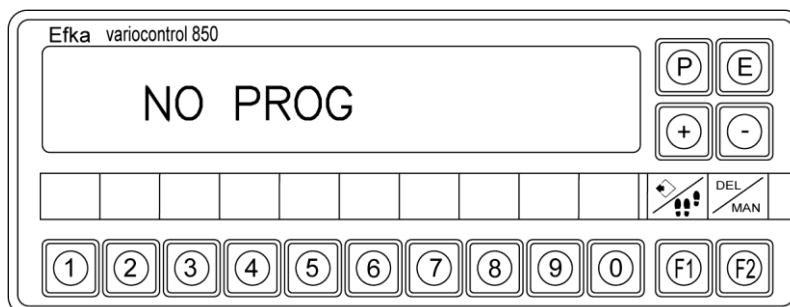
Bedienteil_V850_AB425S_441_04

2. Display "Program selection"
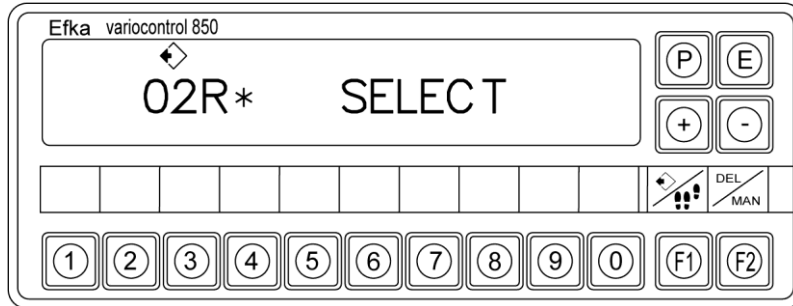
Bedienteil_V850_AB425S_441_05

- 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"
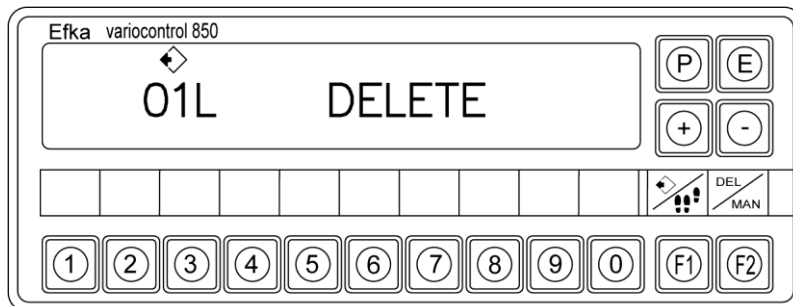
Bedienteil_V850_AB425S_441_06

- 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.

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Efka variocontrol 850

01L   DEL CONFIRM

Bedienteil_V850_AB425S_441_07

- 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**

Efka variocontrol 850

02R* RIGHT EDIT
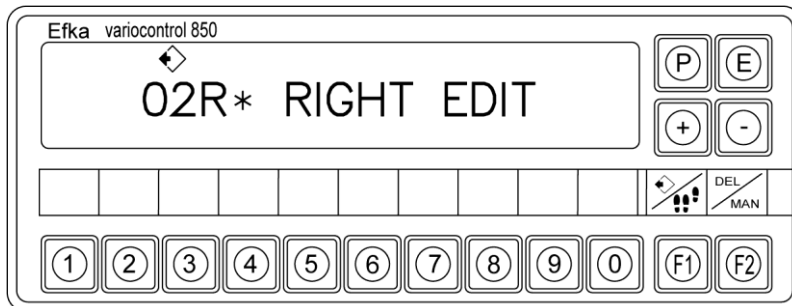
Bedienteil_V850_AB425S_441_08

- 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.

Efka variocontrol 850

02R* 1*   99

Bedienteil_V850_AB425S_441_09

37
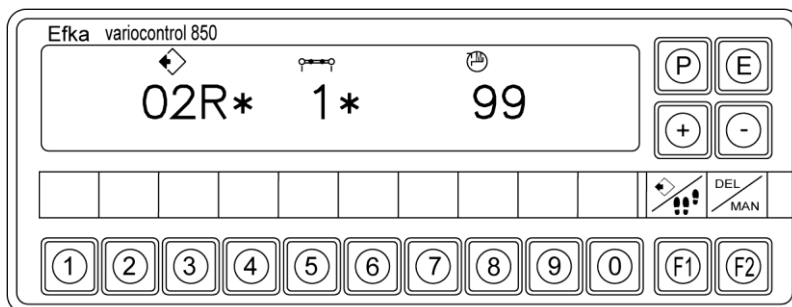
- It starts with the value of the differential transport of sector 1.

- 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.

Efka   variocontrol 850

02R*   2*   99
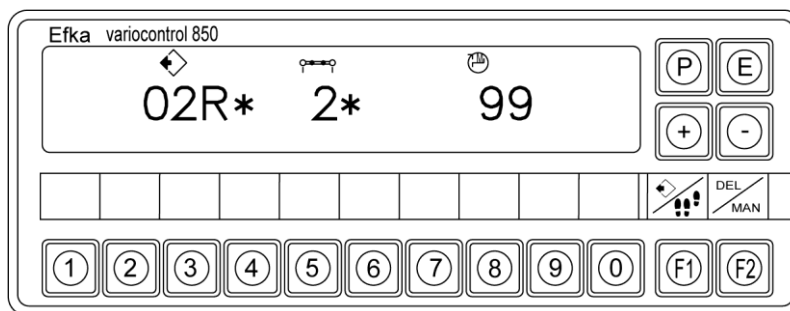
Bedienteil_V850_AB425S_441_10

- 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.

Efka   variocontrol 850

02R   2   5

Bedienteil_V850_AB425S_441_11

STROBEL
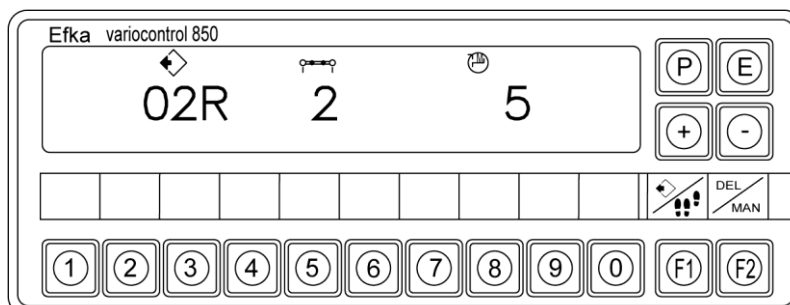
- Add a new sector with the "E" button or knee switch.
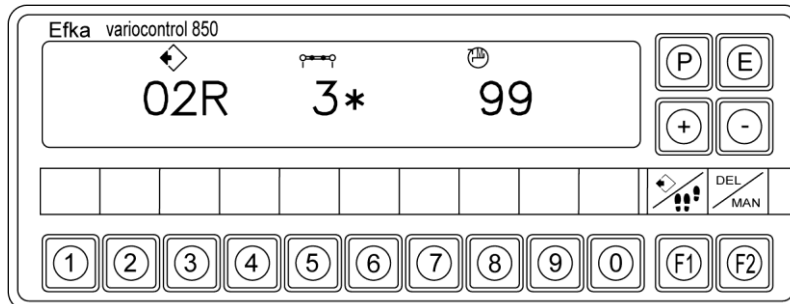
```
Efka   variocontrol 850
          ◇           ⊶          ⌚
       02R      3*         99           [P] [E]
                                         [+] [-]
  ┌──┬──┬──┬──┬──┬──┬──┬──┬──┬──┐  ◇   DEL
  │  │  │  │  │  │  │  │  │  │  │  ⫶⫶⫶  MAN
  ①  ②  ③  ④  ⑤  ⑥  ⑦  ⑧  ⑨  ⓪   F1  F2
```
Bedienteil_V850_AB425S_441_12

- 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).
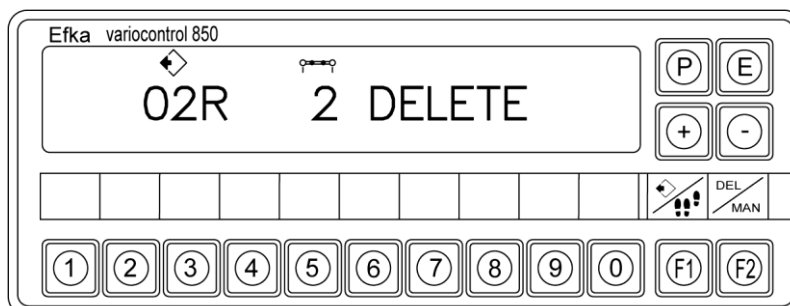
```
Efka   variocontrol 850
          ◇           ⊶
       02R      2 DELETE              [P] [E]
                                         [+] [-]
  ┌──┬──┬──┬──┬──┬──┬──┬──┬──┬──┐  ◇   DEL
  │  │  │  │  │  │  │  │  │  │  │  ⫶⫶⫶  MAN
  ①  ②  ③  ④  ⑤  ⑥  ⑦  ⑧  ⑨  ⓪   F1  F2
```
Bedienteil_V850_AB425S_441_13

- Press the "E" button to confirm the entry.

- The "P" button cancels the deletion process.

- If cancelling, return to display "Programming mode".
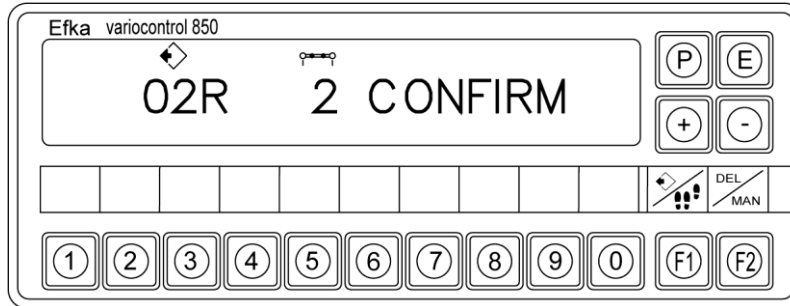
Bedienteil_V850_AB425S_441_14

- 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"
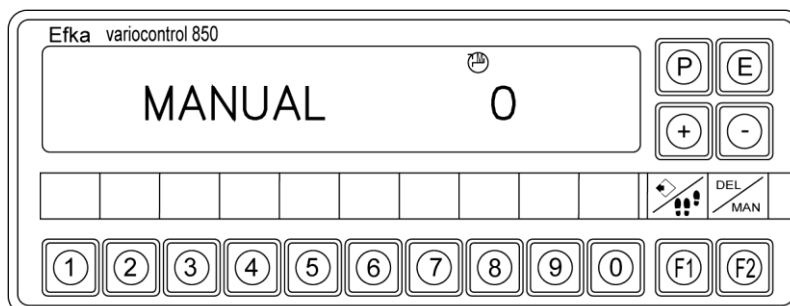
Bedienteil_V850_AB425S_441_01

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

MA_443-1-2_A1_210421_en.doc

4.17.3   Parameter und Functions F-714 (Class 443-2)

Parameter 714 defines the 1st sector for the start of sewing. Two options are available.

The mirroring is done automatically in the right order for the right or left shoe.

The examples are based on an insole with 8 sectors.

The starting point for sewing is always at sector 1

Fig. 22

Parameter 714 = 0

Startpunkt_F-714-0_01
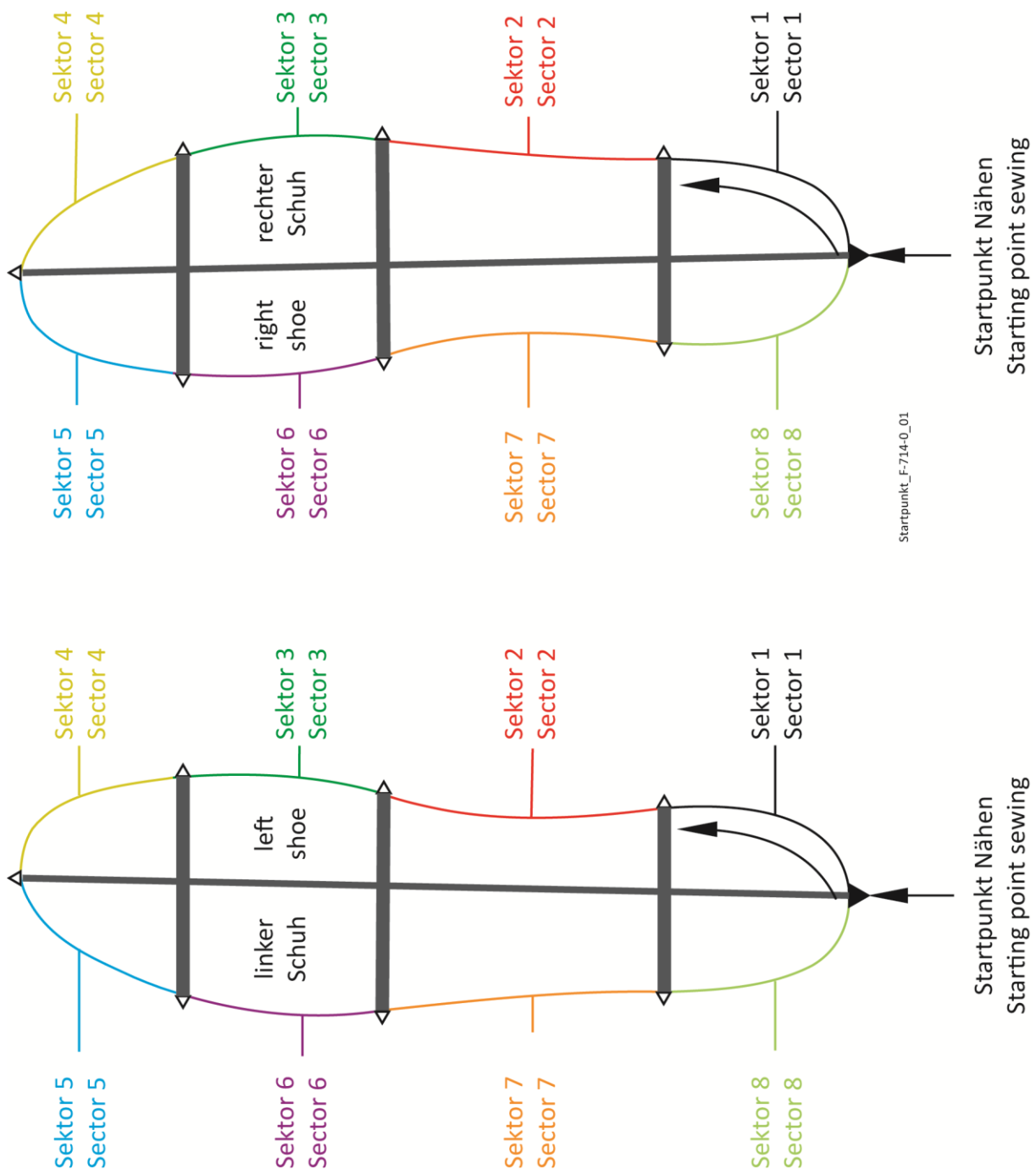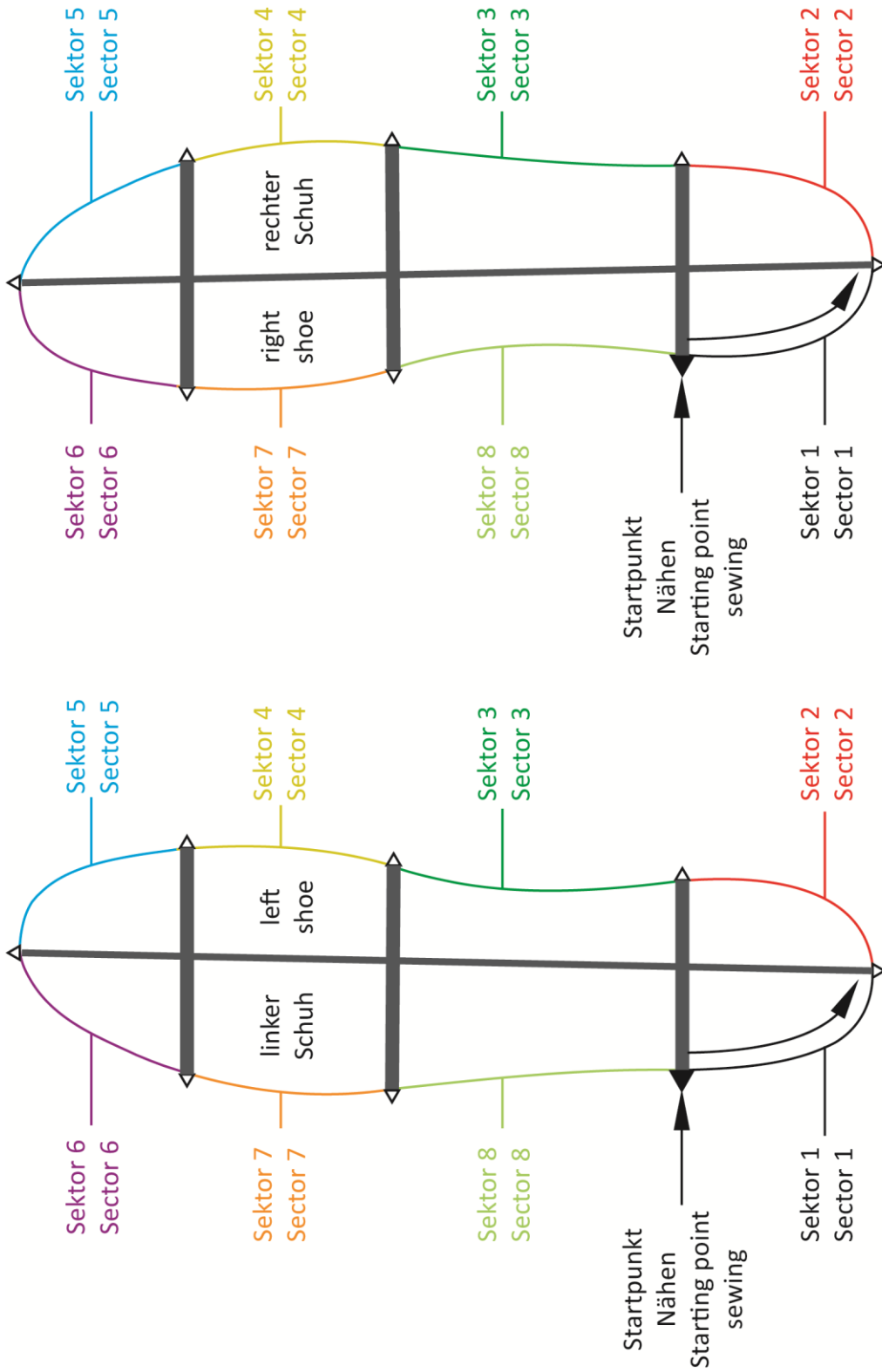
Parameter 714 = 1

Startpunkt_F-714-1_01

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4.17.4 Parameter and Functions F-715 (Class 443-2)

Function	Parameter
Selection of processing via parameter F-715	F-715

With the Parameter F-715 you can decide if you want to use a sewing program for pairwise shoe processing or single shoe processing.

F-715 = 0   In this mode, e.g. the sewing program 02 for a right shoe and the sewing program 03 for a left shoe is repeated in continuous sequence.

F-715 = 1   In this mode, e.g. the sewing program 02 for a right shoe is repeated until you manually switch to the next sewing program 03 for a left shoe.

4.17.5 Parameter and Functions F-760 (Class 443-2)

Function	Parameter
Setting synchronized differential feed	F-760

With this parameter, the synchronisation of the differential transport can be finely adjusted if the material pairings have different friction values.

The factory setting is set to value "6".

In the factory setting "6" our off-sewing material is transported synchronously between feed- and front cup.

If the materials have different values of friction, we have the option of fine adjustment of the differential feed to ensure always synchronized operation.

Value 0 – 5   =   More transport by the front cup

Value 6   =   factory setting

Value 7 – 10   =   Less transport by the front cup

After entering the code number "3112" for the supplier level:

- Select parameter F-760
- Press the "E" key
- Enter the value or correct the value up or down
- Press the "P" key

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Procedure to save the change

- Select parameter F-401

- change value to "1"

- Save the data by pressing the "P" key twice and exit the supplier level.

- Switch the control box off and on again so that the change is saved.

4.17.6 Copy sewing programs to another machines (Class 443-2)

Here is a description, how to copy the sewing programs from a control box to a USB stick and then transfer them to another control box.

Procedure with control panel V850

- **Copy the sewing program from the controller**

    - Insert the USB stick into the control box
    - Press the "P" key and switch the control box on at the same time
    - Enter code 3112 and confirm with key "E"
    - Select parameter F-514 and confirm with "E"
    - Press the "F2" key
    - Press the "E" key twice
    - Then the file with the sewing programs is copied to the USB stick
    - Press the "P" key and switch off the controller
    - Now you can remove the USB stick from the control box

The file name, which is copied to the USB stick, is titled by the controller "0300DATA.pay". This file can be renamed up to 8 characters, but the extension always must be ".pay".

Example:

0300DATA.pay   =>>   shoe-1.pay

- **Copy the sewing program to a control box**

    - Insert the USB stick into the control box
    - Press the "P" key and switch the control box on at the same time
    - Enter code 3112 and confirm with key "E"
    - Select parameter F-515 and confirm with "E"
    - Press the "F2" key
    - Select the sewing program (for example, shoe -1.pay) using the +/- buttons on the control panel
    - Press the "E" key twice
    - File with the sewing program is up-loaded in the control box
    - Press the "P" key and switch off the controller
    - Now you can remove the USB stick from the control box

4.17.7 Brief instruction (Class 443-2)

Display Symbol:	Programnumber	Sector	Reduction of Differentialfeed

Function Key`s	Assignment of Key`s	
P	**Key has double function** - Generation of a program / changing of a program. Please see below - Change values during program sequence with the **+ / -** key and press the **P** key and hold until the display shows (Save Array).	
E	Confirm / Next Step	
+ / -	Input Area or Next Step	
F1	**Key has double function!** **Select a program** or **Hold down the button and the pair / single appears. After selection confirm with P key** **Select a Program** **0 means:** automatic change from **R to L** (pairwise processing) **1 means:** it will repeat **#R** until manually switched to **# L (single processing)**	
F2 DEL M	**Key has double function!** Deleting a program (see below) **Hold down the button for 3 seconds and switch to the manual control of the differential transport, which is controlled via the left foot pedal.** **By pressing the F2 key again you return to the program / sector where you have left the automatic mode.**	
1 - 0	**Function keys for direct selection of a sector and during programming, the value for reducing the differential transport can be entered directly.**	

Create a Program:	Press **P**, then **+ / -** button until free program space with **(*)** appears. Press **E**, **1 *** appears **(means sector 1)** and **99** flashes **(means differential value)** **For sector 1,** the differential value can now be entered via the direct buttons **1 - 0** or vai **+ / -** Press button **E** or the knee switch, then program the next sector. At the end of the program, press **P**. The display will show **(Save Array)**. Program is now saved. **! Automatically the program is mirrored for right / left shoe**
Delete a Program:	Select program number, then press **F2** and the display will show **(Delete)** **Press E and the display shows (DEL Confirm). Press E again and the program # R and # L will be deleted.** **The display will show (Save Array).** **! The program place # R and # L remains free until it is filled again. No program moves to free space.**

The parameters F-711, F-714, F-715, F-760 are described in the mechanics manual

4.18 Servicing the machine

Check the cam (1) and the sliding block (2) every 3 months and relubricate if necessary. (Fig. 23)

Recommended and enclosed lubricant: Molykote G-RAPID plus

Fig. 23

Wartung_01
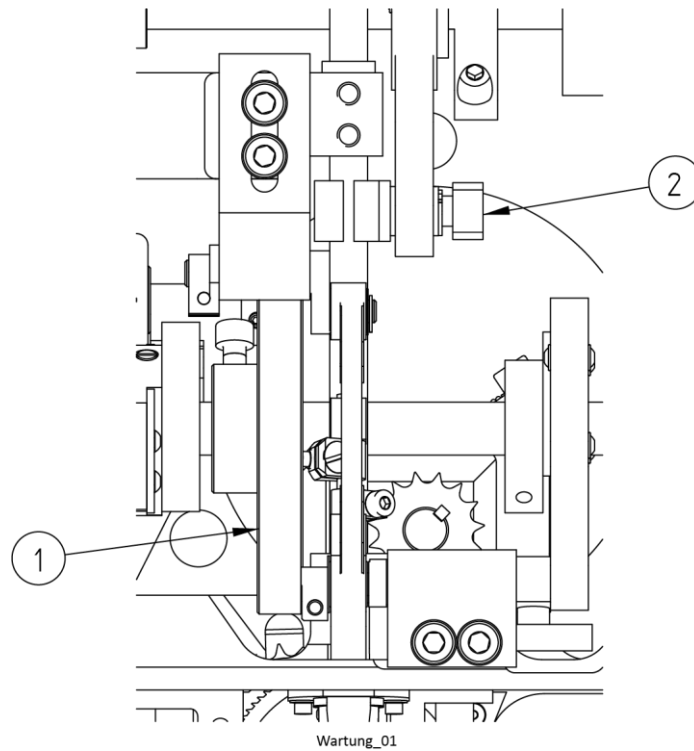
Check the chain play of the chain (1) every 3 months and retighten if necessary. (Fig. 24)

Fig. 24

Kettenrad mit Nabe
chain wheel

Kettenspanner
chain tensioner

1 mm

Transportteller
feed cup

Kettenspanung_01
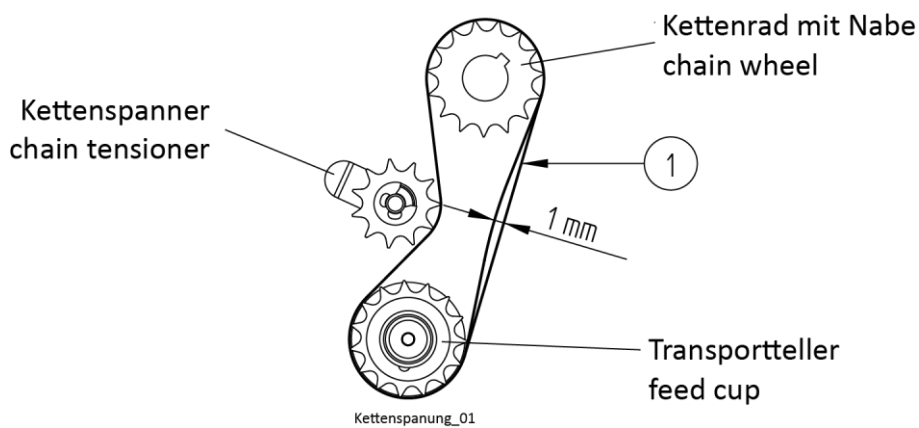
4.19 General notes

Further details such a 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:

- Remove material guide (1) - 2x screw (2). (Fig. 25)

- Pull out needle (1), cylinder head screw (2), needle clamping plate (3), pressure spring (4) and needle setting plate (5). (Fig. 26)

- Screw out the flat-head screws (3) of the feed cup attachment; take feed cup (4) off upwards. (Fig. 27)

- The assembly of the exchanged feed cup is done in reverse order.

Fig. 25

Transporttellerausbau_17

Fig. 26

Transporttellerausbau_12
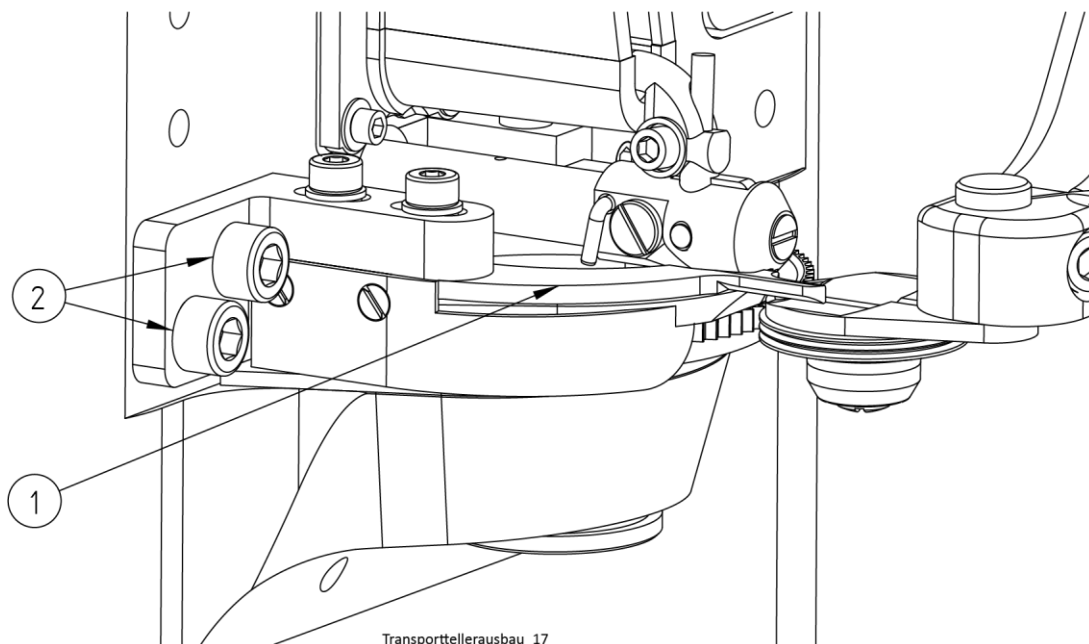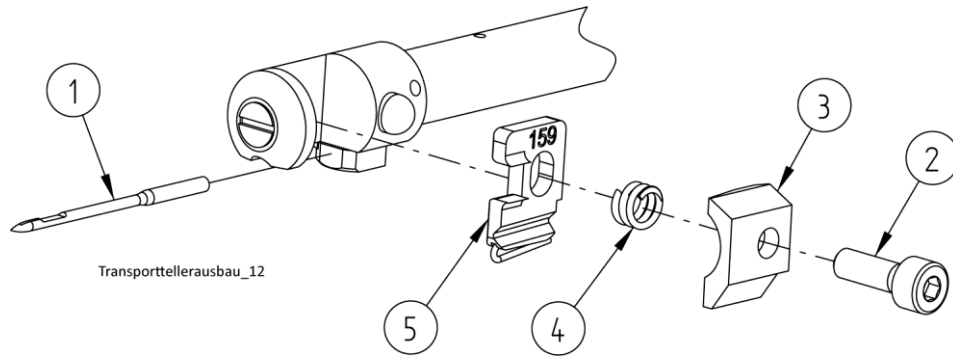
5.2.1   <u>Chain tension</u>

The chain for the feed cup drive can be tensioned from above by loosening the threaded pin (1) the chain tensioner (2) (Fig. 27).

Fig. 27

Kettenspanung_02
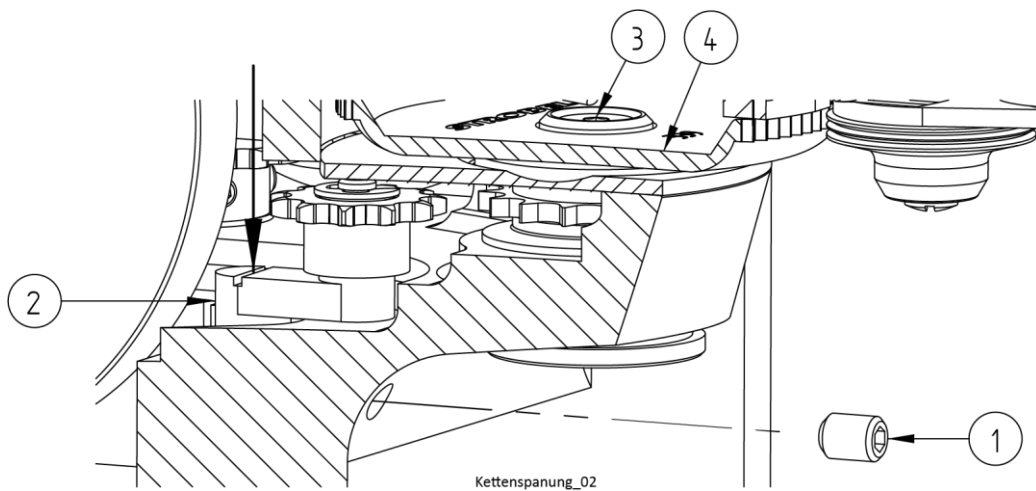
5.3 Setting and installation instruction for the Strobel gathering device

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

The gathering device EV (1) (Fig. 28) 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. 28

Einhaltevorrichtung_15
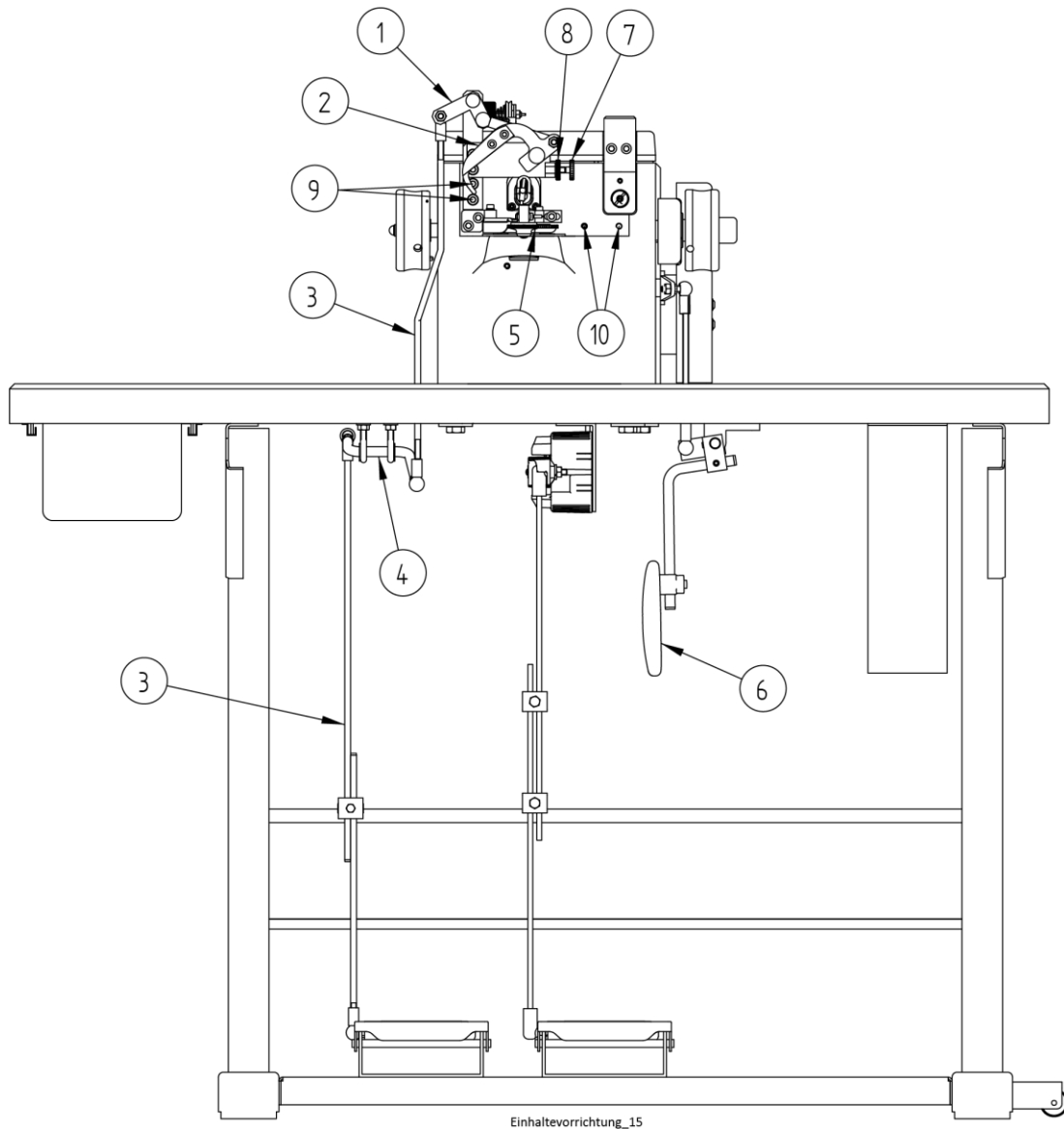
6 Circuit diagrams

6.1 Electrical wiring diagram AB425S Cl. 443-2 – Step motor

Schrittmotor (SM)
Step motor (SM)

(B) ge - ye
ge/ws - ye/wh
gn/ws - gn/wh
(B) gn - gn

SM

(A) rt - rd
rt/ws - rd/wh
sw/ws - bk/wh
sw - bk
(A)

B5
1 2 3 4 5 6

Schrittmotor (SM)
Step motor (SM)

Nähantriebsteuerung
Sewing drive control
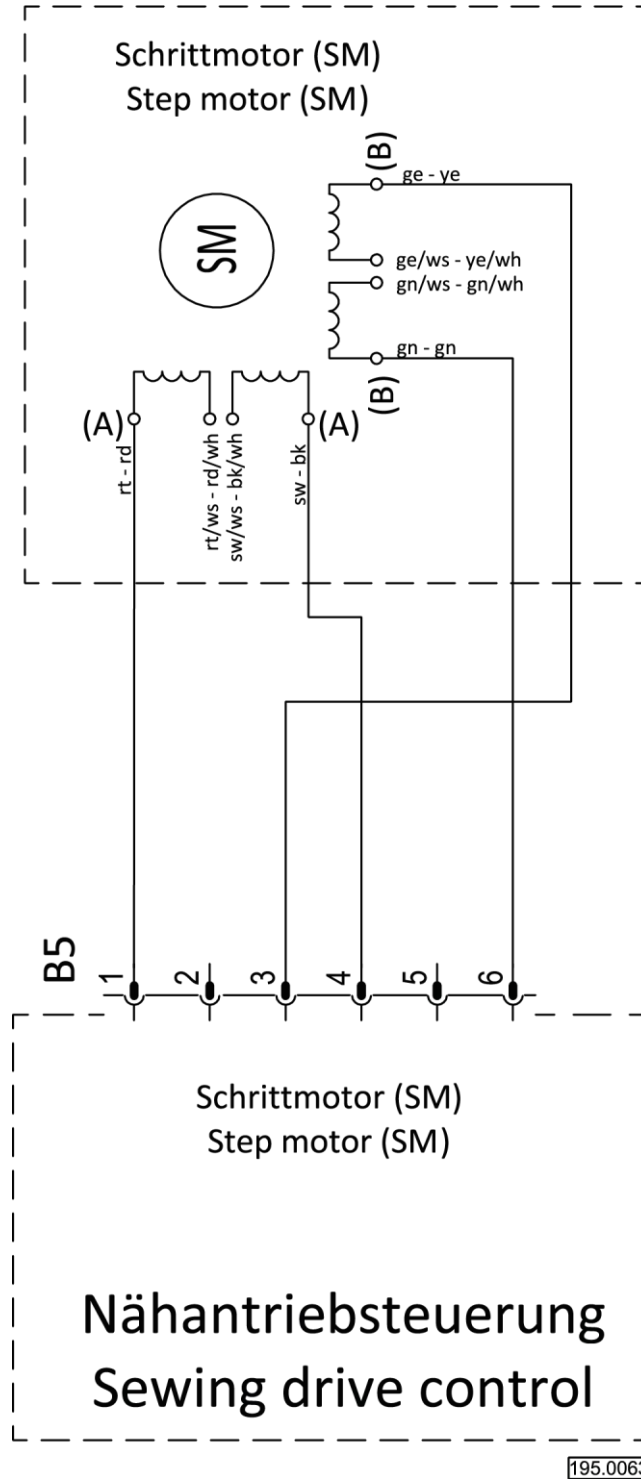
195.0063

6.2 Electrical wiring diagram AB425S Cl. 443-2
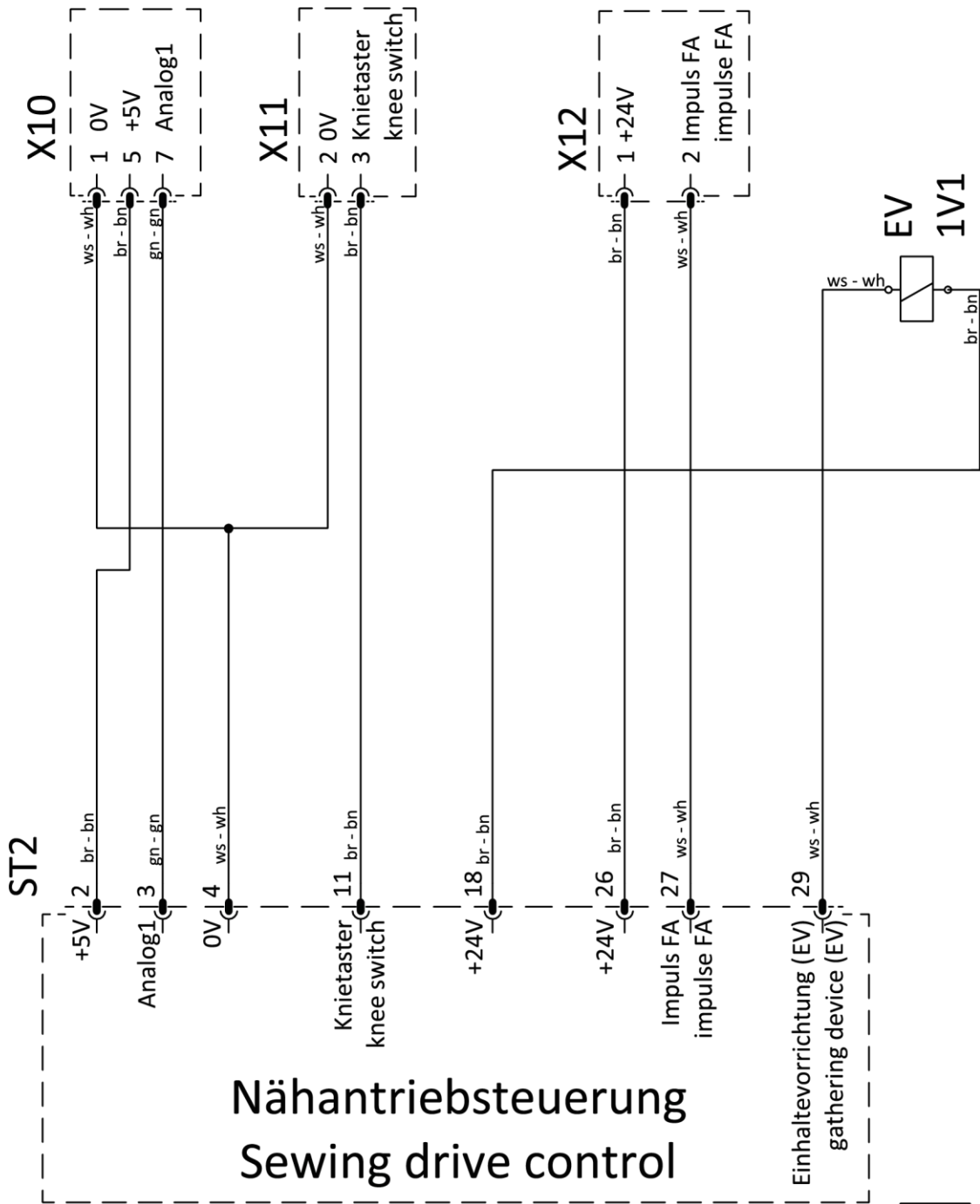
195.0064

1V1	Magnetventil "Lüftung" (LÜ)	solenoid valve "lifting" (LÜ)
EV	Einhaltevorrichtung	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"

6.3　Assembly plan AB425S Cl. 443-2

Knietaster
knee switch
298.0069

Sollwertgeber
setpoint device
298.0688

Fadenabschneider
thread trimmer
298.0718

Einhaltevorrichtung
gathering device

296.0830

Schrittmotor
step motor
398.0717

296.0817
(Oberteil)
(head)

Steuerung Nähantrieb
control box sewing drive

Efka
(998.0560)

B6
B5
B80
B76
ST21
ST20
ST2
B41
B2
B18

Bedienteil
operating control
298.0663

Motor Nähantrieb
motor sewing drive
298.0560

Sollwertgeber
setpoint device

Efka
296.0562

195.0065

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6.4   Pneumatic circuit diagram Cl. 443-2
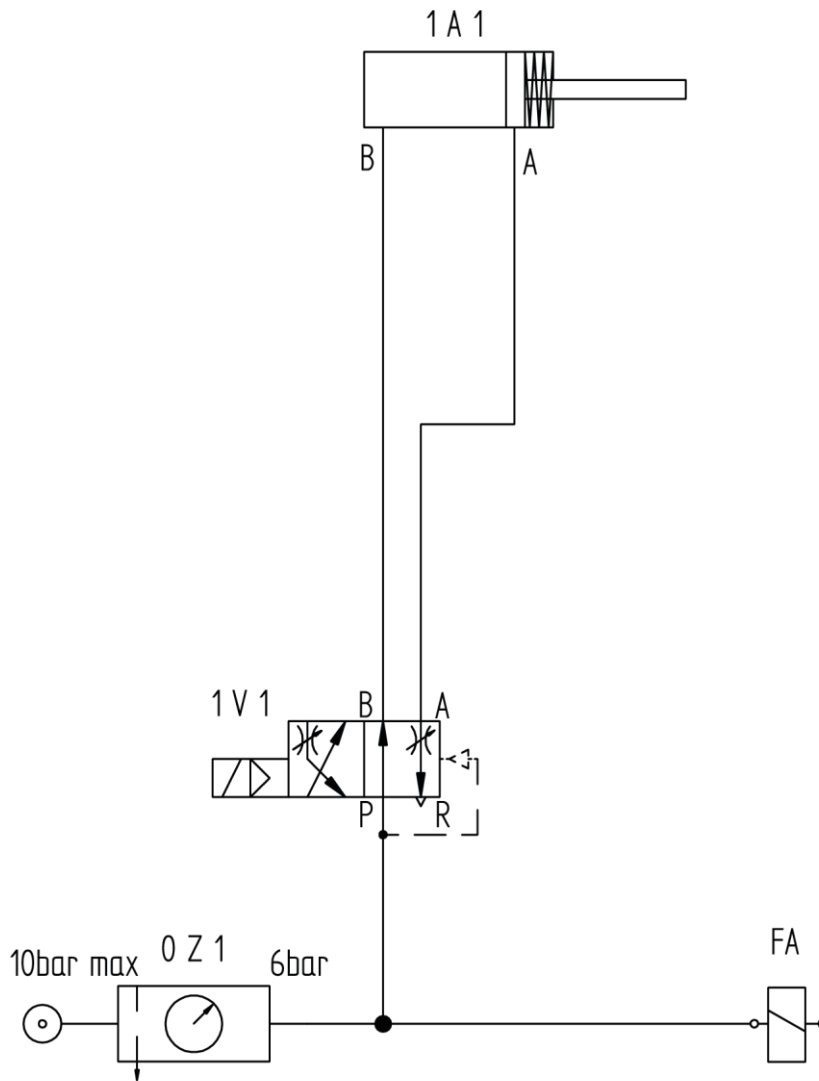
0 Z 1	Wartungseinheit	service unit
1 V 1	4/2-Magnetventil "Einhaltevorrichtung" (P-EV)	4/2-solenoid-way valve "gathering device" (P-EV)
1 A 1	Zylinder "Einhaltevorrichtung" (P-EV)	cylinder "gathering device" (P-EV)
FA	Fadenabschneider	thread trimmer

6.5 Pneumatic construction circuit diagram Cl. 443-2
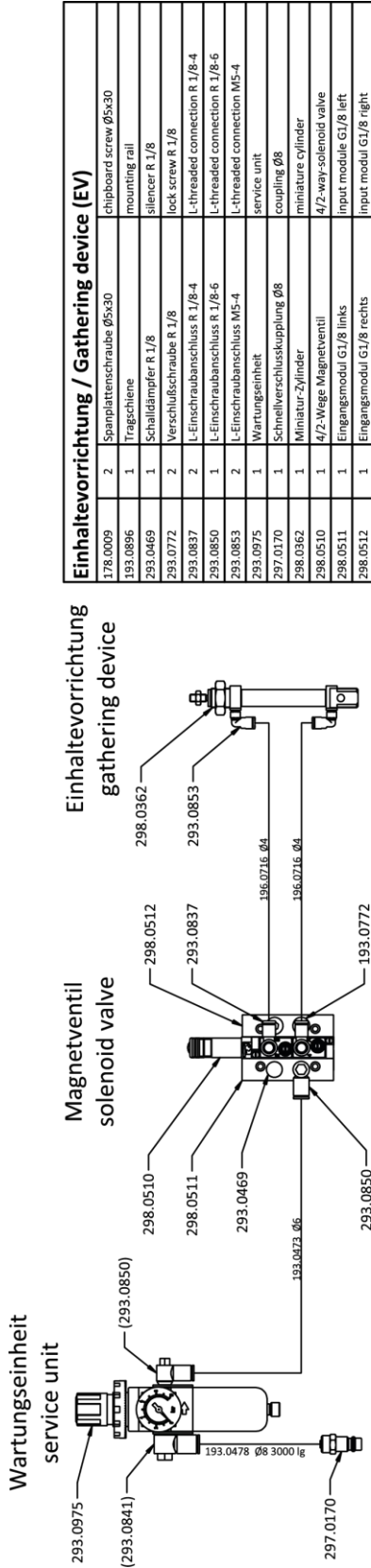
Einhaltevorrichtung / Gathering device (EV)			
178.0009	2	Spanplattenschraube Ø5x30	chipboard screw Ø5x30
193.0896	1	Tragschiene	mounting rail
293.0469	1	Schalldämpfer R 1/8	silencer R 1/8
293.0772	2	Verschlußschraube R 1/8	lock screw R 1/8
293.0837	2	L-Einschraubanschluss R 1/8-4	L-threaded connection R 1/8-4
293.0850	1	L-Einschraubanschluss R 1/8-6	L-threaded connection R 1/8-6
293.0853	2	L-Einschraubanschluss M5-4	L-threaded connection M5-4
293.0975	1	Wartungseinheit	service unit
297.0170	1	Schnellverschlusskupplung Ø8	coupling Ø8
298.0362	1	Miniatur-Zylinder	miniature cylinder
298.0510	1	4/2-Wege Magnetventil	4/2-way-solenoid valve
298.0511	1	Eingangsmodul G1/8 links	input module G1/8 left
298.0512	1	Eingangsmodul G1/8 rechts	input modul G1/8 right
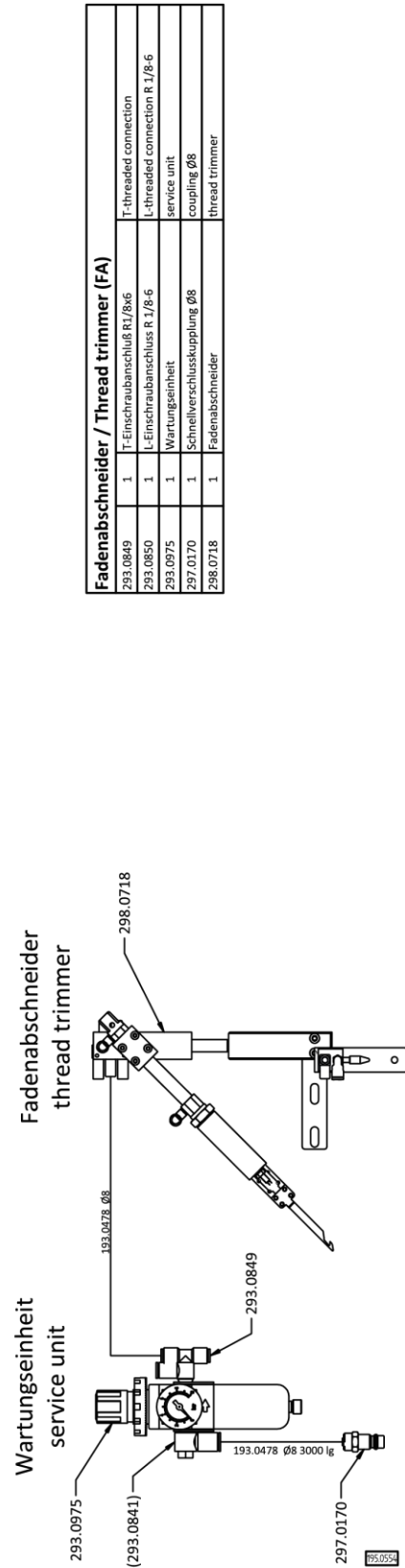
Fadenabschneider / Thread trimmer (FA)			
293.0849	1	T-Einschraubanschluß R1/8x6	T-threaded connection
293.0850	1	L-Einschraubanschluss R 1/8-6	L-threaded connection R 1/8-6
293.0975	1	Wartungseinheit	service unit
297.0170	1	Schnellverschlusskupplung Ø8	coupling Ø8
298.0718	1	Fadenabschneider	thread trimmer

Einhaltevorrichtung
gathering device

Magnetventil
solenoid valve

298.0362
293.0853
196.0716 Ø4
196.0716 Ø4
298.0512
293.0837
193.0772
298.0510
298.0511
293.0469
293.0850
193.0473 Ø6

Wartungseinheit
service unit

293.0975
(293.0841)
(293.0850)
193.0478 Ø8 3000 lg
297.0170

Fadenabschneider
thread trimmer

298.0718
193.0478 Ø8
293.0849

Wartungseinheit
service unit

293.0975
(293.0841)
193.0478 Ø8 3000 lg
297.0170
195.0554

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7   <u>Switchable Functions</u>

7.1   <u>DC1200-AB611A Cl. 443-1</u>

			Machine class		
	Explanation: 0 = Off 1 = On	Settimg range	Preset at mode 56	443-1	443-1F
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: 11.01.2021 - PT_AB611A_443-1_210111					

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7.2   DC1500-AB425S Cl. 443-2

		Settimg range	Preset at mode 56	443-2	443-2F
	Explanation: 0 = Off 1 = On		**Machine class**		
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	1	1	1
	Button ">>" Seg6 Basic position "Needle position 2"	0 1	0	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: 11.01.2021 - PT_AB425S_443-2_210111

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8 Parameter list

8.1 DC1200-AB611A Cl. 443-1

		Setting range	Unit	Machine class		
				Preset at mode 56	443-1	443-1F
F-467	Motor selection	1 10		3	3	3
F-290	Mode	00 56		56	5	5
F-365	Machine classes selction	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-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
F-153	Holding force during machine standstill	00 50		05	05	05

		Machine class				
		Setting range	Unit	Preset at mode 56	443-1	443-1F
F-161	Direction of rotation of the motor	0 1		0	0	0
F-180	Number of turn-back steps	000 359	Degree	040	175	175
F-181	Switch delay for turn back	000 990	ms	200	010	010
F-182	Turn back OFF/ON	0 1		0	0	0
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-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	20	20
F-234	Restarting after activated run inhibition	0 1		1	0	1
F-240	Selecting the input function In.1	00 47		00	00	00
F-270	Selection o9f the position sensors	0 6		0	6	6
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	0000
F-281	On-time Thread trimmer (M1)	0000 5000	ms	0180	0100	0100

		Setting range	Unit	**Machine class**		
				Preset at mode 56	443-1	443-1F
F-284	Delay time Output M3	0000 5000	ms	0000	0200	0200
F-285	On-time Output M3	0000 5000	ms	0300	0100	0100
F-288	Delay time till lifting On	0000 5000	ms	0200	0380	0380
Stand: 11.01.2021 - PT_AB611A_443-1_210111						

8.2 DC1500-AB425S Cl. 443-2

		Setting range	Unit	Machine class		
				Preset at mode 56	443-2	443-2F
F-467	Motor selection	1 10		3	1	3
F-290	Mode	00 56		56	5	5
F-365	Machine classes selction	0 2		0	1	0
F-013	Thread trimmer OFF/ON	0 1		0	1	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-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
F-153	Holding force during machine standstill	00 50		05	05	05

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		Setting range	Unit	Machine class		
				Preset at mode 56	443-2	443-2F
F-161	Direction of rotation of the motor	0 1		0	0	0
F-180	Number of turn-back steps	000 359	Degree	040	040	040
F-181	Switch delay for turn back	000 990	ms	200	200	200
F-182	Turn back OFF/ON	0 1		0	0	0
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-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
F-234	Restarting after activated run inhibition	0 1		1	0	1
F-240	Selecting the input function In.1	00 47		00	00	00
F-270	Selection o9f 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

			Machine class			
		Setting range	Unit	Preset at mode 56	443-2	443-2F
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: 11.01.2021 - PT_AB425S_443-2_210111						

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STROBEL

Spezialmaschinen GmbH

Postfach 1242
82168 Puchheim

Boschstraße 16
82178 Puchheim
DEUTSCHLAND

www.strobel.biz
Telefon: +49 89 80096-0
Telefax: +49 89 80096-190