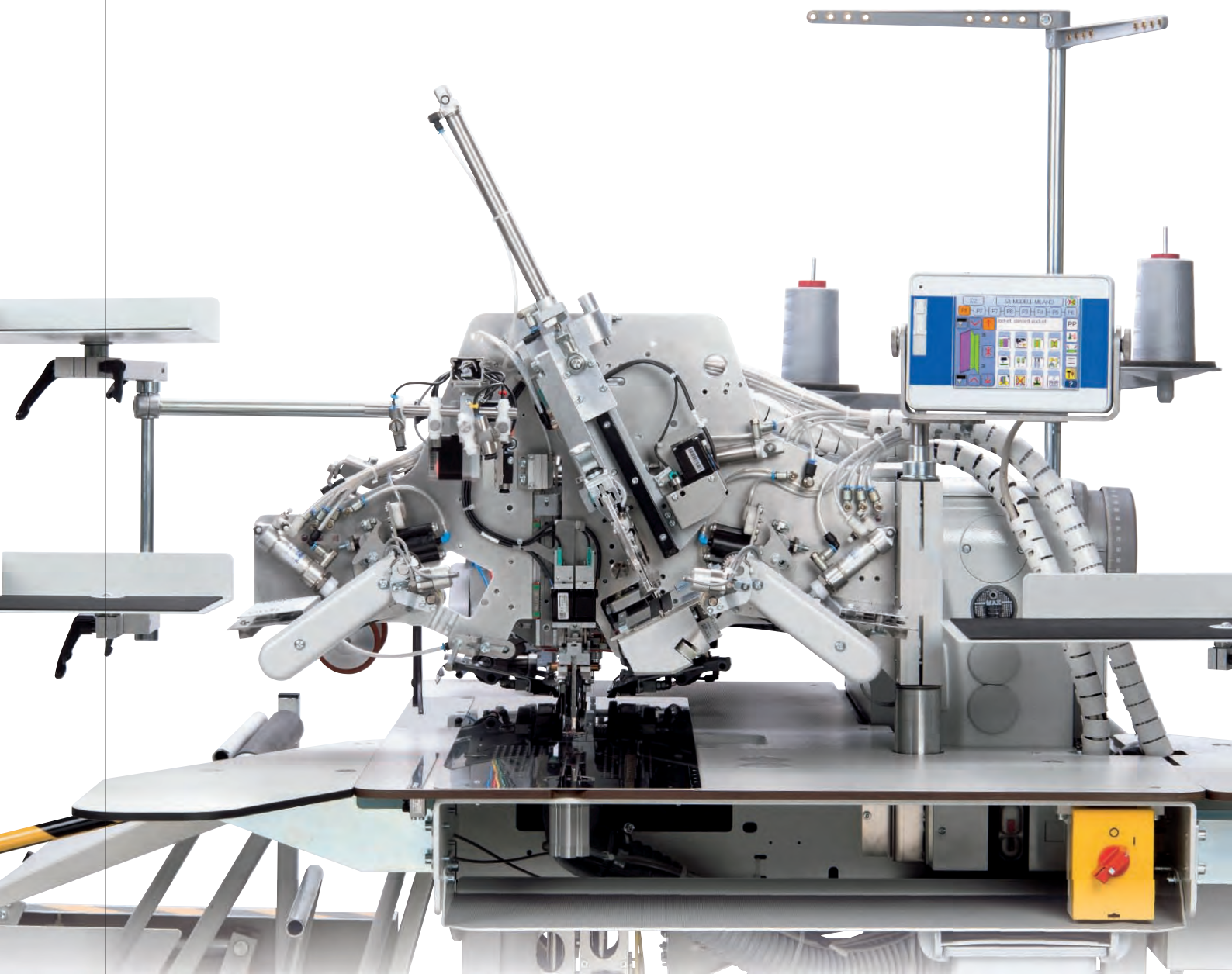
DÜRKOPP ADLER

755 B/756 B, F Operating Instructions



IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE

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1 About these instructions

These instructions have been prepared with utmost care. They contain information and notes intended to ensure long-term and reliable operation.

Should you notice any discrepancies or if you have improvement requests, then we would be glad to receive your feedback through **Customer Service** (📖 *p. 331*).

Consider these instructions as part of the product and keep it easily accessible.

1.1 For whom are these instructions intended?

These instructions are intended for:

- Operators:
  This group is familiar with the machine and has access to the instructions. Specifically, chapter **Operation** (📖 *p. 17*) is important for the operators.
- Specialists:
  This group has the appropriate technical training for performing maintenance or repairing malfunctions. Specifically, the chapter **Setup** (📖 *p. 305*) is important for specialists.

Service Instructions are supplied separately.

With regard to minimum qualification and other requirements to be met by personnel, please also follow the chapter **Safety** (📖 *p. 9*).

1.2 Representation conventions – symbols and characters

Various information in these instructions is represented or highlighted by the following characters in order to facilitate easy and quick understanding:



Proper setting

Specifies proper setting.



Disturbances

Specifies the disturbances that can occur from an incorrect adjustment.



Cover

Specifies which covers must be disassembled in order to access the components to be set.



Steps to be performed when operating the machine (sewing and equipping)



Steps to be performed for service, maintenance, and installation



Steps to be performed via the software control panel

The individual steps are numbered:

1. First step
2. Second step
3. … The steps must always be followed in the specified order.

- Lists are marked by bullet points.



Result of performing an operation

Change to the machine or on the display/control panel.



Important

Special attention must be paid to this point when performing a step.



Information

Additional information, e.g. on alternative operating options.



Order

Specifies the work to be performed before or after an adjustment.

References

🕮 Reference to another section in these instructions.

Safety Important warnings for the user of the machine are specifically marked. Since safety is of particular importance, hazard symbols, levels of danger and their signal words are described separately in the chapter **Safety** (🕮 *p. 9*).

Location information If no other clear location information is used in a figure, indications of **right** or **left** are always from the user's point of view.

1.3 Other documents

The machine includes components from other manufacturers. Each manufacturer has performed a hazard assessment for these purchased parts and confirmed their design compliance with applicable European and national regulations. The proper use of the built-in components is described in the corresponding manufacturer's instructions.

1.4 Liability

All information and notes in these instructions have been compiled in accordance with the latest technology and the applicable standards and regulations.

Dürkopp Adler cannot be held liable for any damage resulting from:

- Breakage and transport damages
- Failure to observe these instructions
- Improper use
- Unauthorized modifications to the machine
- Use of untrained personnel
- Use of unapproved parts

Transport

Dürkopp Adler cannot be held liable for breakage and transport damages. Inspect the delivery immediately upon receiving it. Report any damage to the last transport manager. This also applies if the packaging is not damaged.

Leave machines, equipment and packaging material in the condition in which they were found when the damage was discovered. This will ensure any claims against the transport company.

Report all other complaints to Dürkopp Adler immediately after receiving the product.

2 Safety

This chapter contains basic information for your safety. Read the instructions carefully before setting up or operating the machine. Failure to do so can result in serious injury and property damage.



2.1 Basic safety instructions

The machine may only be used as described in these instructions.

These instructions must be available at the machine's location at all times.

Work on live components and equipment is prohibited. Exceptions are defined in the DIN VDE 0105.

For the following work, switch off the machine at the main switch or disconnect the power plug:

- Replacing the needle or other sewing tools
- Leaving the workstation
- Performing maintenance work and repairs
- Threading

Missing or faulty parts could impair safety and damage the machine. Only use original parts from the manufacturer.

Transport

Use a lifting carriage or stacker to transport the machine. Raise the machine max. 20 mm and secure it to prevent it from slipping off.

Setup

The connecting cable must have a power plug approved in the relevant country. The power plug may only be assembled to the power cable by qualified specialists.

Obligations of the operator

Follow the country-specific safety and accident prevention regulations and the legal regulations concerning industrial safety and the protection of the environment.

All the warnings and safety signs on the machine must always be in legible condition. Do not remove!
Missing or damaged warnings and safety signs must be replaced immediately.

Requirements to be met by the personnel

Only qualified specialists may be used for:

- Setting up the machine
- Performing maintenance work and repairs
- Performing work on electrical equipment

Only authorized persons may work on the machine and must first have understood these instructions.

Operation

Check the machine during operating for any externally visible damage. Stop working if you notice any changes to the machine. Report any changes to your supervisor. Do not use a damaged machine any further.

Safety equipment

Safety equipment should not be disassembled or deactivated. If it is essential to disassemble or deactivate safety equipment for a repair operation, it must be assembled and put back into operation immediately afterward.

2.2 Signal words and symbols used in warnings

Warnings in the text are distinguished by color bars. The color scheme is based on the severity of the danger. Signal words indicate the severity of the danger.

Signal words

Signal words and the hazard they describe:

Signal word	Meaning
DANGER	(with hazard symbol) If ignored, fatal or serious injury will result
WARNING	(with hazard symbol) If ignored, fatal or serious injury can result
CAUTION	(with hazard symbol) If ignored, moderate or minor injury can result
CAUTION	(with hazard symbol) If ignored, environmental damage can result
NOTICE	(without hazard symbol) If ignored, property damage can result

Symbols

The following symbols indicate the type of danger to personnel:

Symbol	Type of danger
	General
	Electric shock

Symbol	Type of danger
	Puncture
	Crushing
	Environmental damage

Examples Examples of the layout of warnings in the text:

DANGER



Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that will result in serious injury or even death if ignored.

WARNING



Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in serious or even fatal injury if ignored.

CAUTION



Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in moderate or minor injury if the warning is ignored.

CAUTION



Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in environmental damage if ignored.

NOTICE

Type and source of danger!

Consequences of non-compliance.

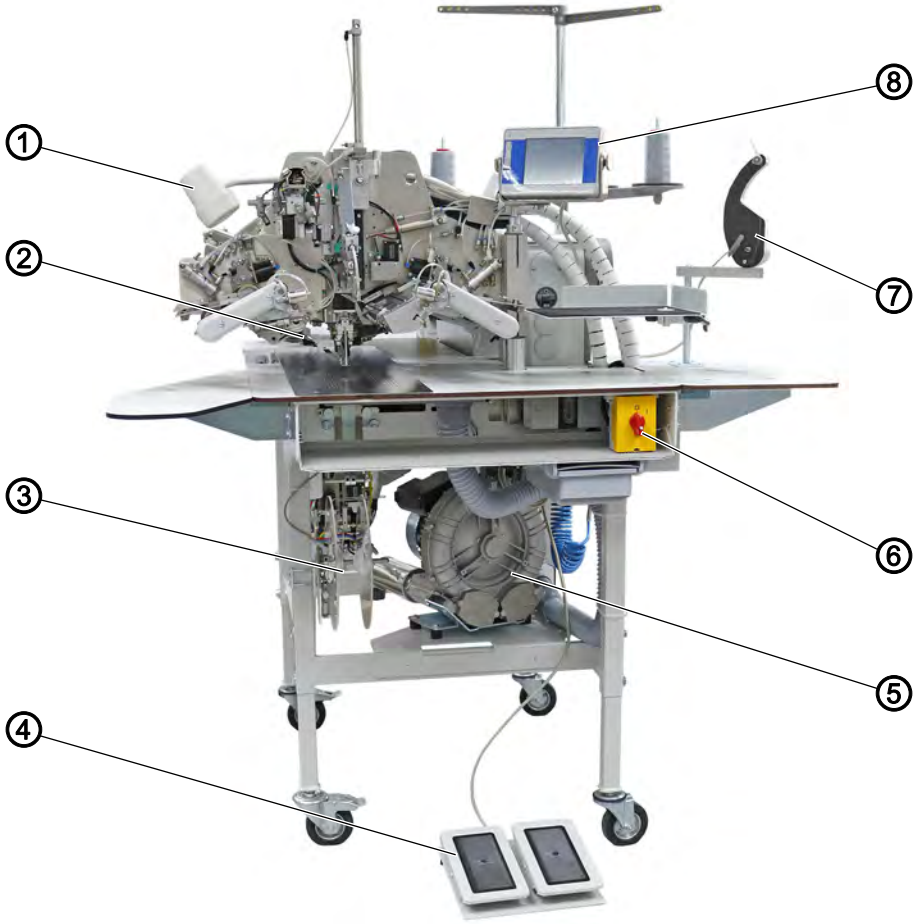
Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in property damage if ignored.

3 Machine description

3.1 Components of the machine

Fig. 1: Components of the machine, class 756 F



(1) - Sewing light
(2) - Turning device
(3) - Tape unwinder
(4) - Pedals
(5) - Vacuum system
(6) - Main switch
(7) - Winder
(8) - Control panel

3.2 Proper use

The machine may only be used with sewing material that satisfies the requirements of the specific application at hand.

The needle thicknesses permissible for the machine are listed in the **Technical data** (📖 *p. 351*) chapter.

The machine is intended only for use with dry sewing material. The sewing material must not contain any hard objects.

The seam must be completed with a thread that satisfies the requirements of the specific application at hand.

The machine is intended for industrial use.

The machine may only be set up and operated in dry conditions on well-maintained premises. If the machine is operated on premises that are not dry and well-maintained, then further measures may be required which must be compatible with DIN EN 60204-31.

Only authorized persons may work on the machine.

Dürkopp Adler cannot be held liable for damages resulting from improper use.

WARNING



Risk of injury from live, moving and cutting parts as well as from sharp parts!

Improper use can result in electric shock, crushing, cutting and punctures.

Follow all instructions provided.

NOTICE

Non-observance will lead to property damage!

Improper use can result in material damage at the machine.

Follow all instructions provided.

3.3 Declaration of Conformity

The machine complies with European regulations ensuring health, safety, and environmental protection as specified in the declaration of conformity or in the declaration of incorporation.

CE

4 Operation

The operating sequence consists of several different steps. Fault-free operation is necessary in order to achieve a good sewing result.

4.1 Preparing the machine for operation

WARNING



Risk of injury from moving, cutting and sharp parts!

Crushing, cutting and punctures are possible.

If possible, make preparations only when the machine is switched off.

Complete the following steps in preparation of sewing before starting to work:

- Inserting or changing the needle
- Threading the needle thread
- Threading or winding the hook thread
- Adjusting the thread tension

4.2 Switching on the machine

Fig. 2: Switching on the machine





To switch on the machine:

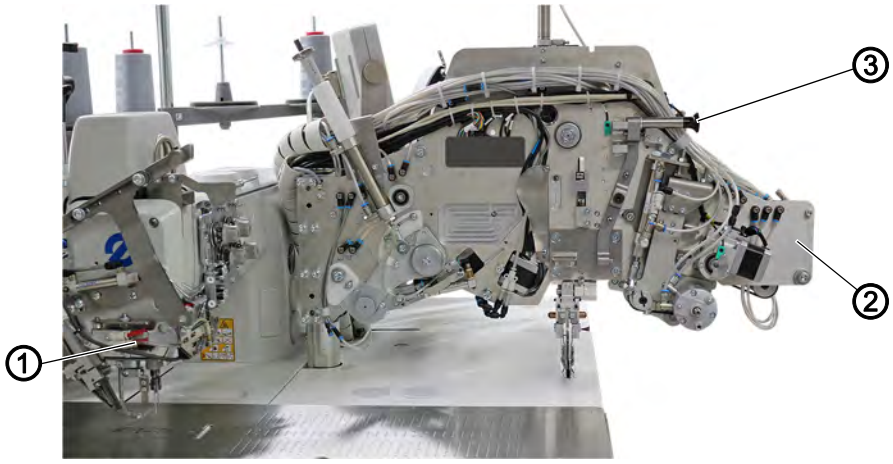
1. Turn the main switch from position **0** to position **I**.

↳ The machine starts up.
The control panel starts up.

4.3 Swiveling the folder station out

The entire folder station including folder can be swiveled out of the way to the right in order to gain access for work in the sewing area (threading the needle thread, changing the needle, etc.). The light barriers are swiveled out of the way to the left.

Fig. 3: Swiveling the folder station out



(1) - Light barriers
(2) - Folder station
(3) - Handle

To swivel the folder station to the side:

1. Press the handle (3) down to loosen the locking mechanism.
2. Swivel the entire folder station (2) including folder to the right.
3. Swivel the light barriers (1) out to the left.

Information

If the machine is switched on, the display of the control panel will show a safety message: `Info 9002`   .

↳ The sewing area is freely accessible.

4.4 Swiveling the folder station in

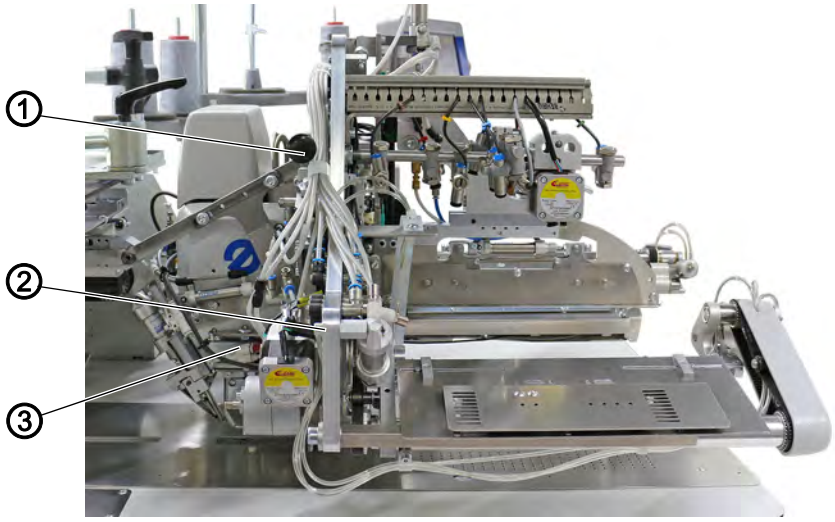
NOTICE

Property damage may occur!

If the folder station is not fully swiveled in, the machine can be damaged when sewing starts.

Lock the folder station in place inside the locking mechanism.

Fig. 4: Swiveling the folder station in



(1) - Locking mechanism
(2) - Folder station
(3) - Light barriers

To swivel the folder station in:

1. Swivel down the light barriers (3).
2. Swivel down the folder station (2).
3. Lock the folder station (2) in place inside the locking mechanism (1).

4.5 Changing needles

CAUTION



Risk of injury from sharp parts!

Punctures or cutting possible.

Only change needles with the main switch turned off.

When changing the needles, NEVER reach into the area of the middle knife.

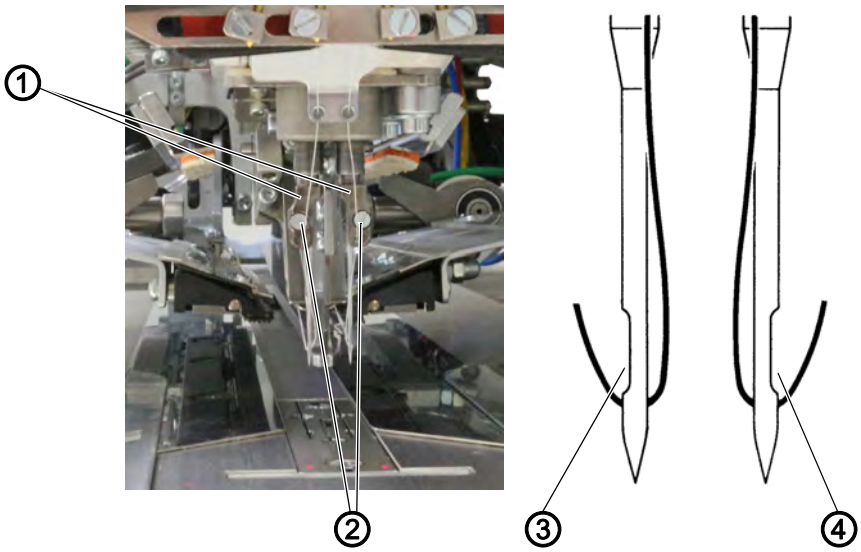
NOTICE

Property damage may occur!

When switching to needles with a different needle strength the needle can be damaged by the hook.

Readjust the needle guard at the hook.

Fig. 5: Changing needles



(1) - Needle holder
(2) - Screws
(3) - Needle groove left needle
(4) - Needle groove right needle

To change the needles:

1. Swivel the folder station out (📖 *p. 18*).

↳ The needles are freely accessible.

2. Loosen the screws (2) and remove the needles from the needle holders (1).
3. Insert new needles into the holes of the needle holders (1) until they reach the stop (use only the correct needles 📖 *p. 351*).

Important

The groove of the left needle (3), as viewed from the operator side of the machine, must point to the left, while the groove of the right needle (4) must point to the right (see diagram).

4. Tighten the screws (2).

4.6 Threading the needle thread

CAUTION

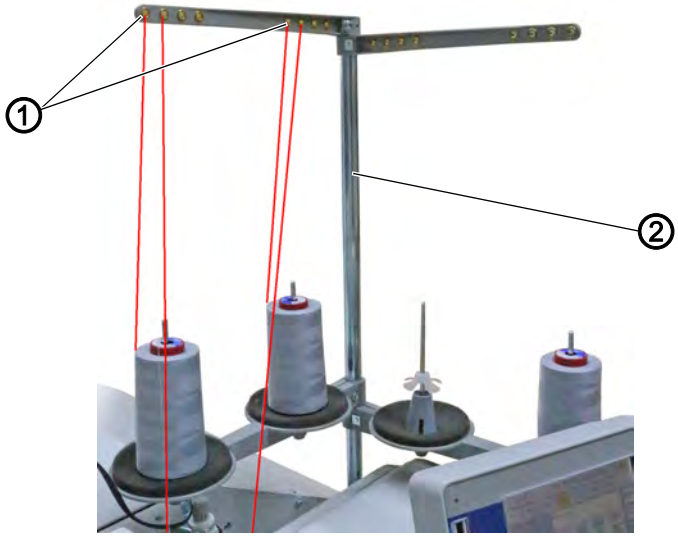


Risk of injury from sharp parts!

Puncture possible.

Only thread the needles with the machine switched off.

Fig. 6: Threading the needle thread (1)



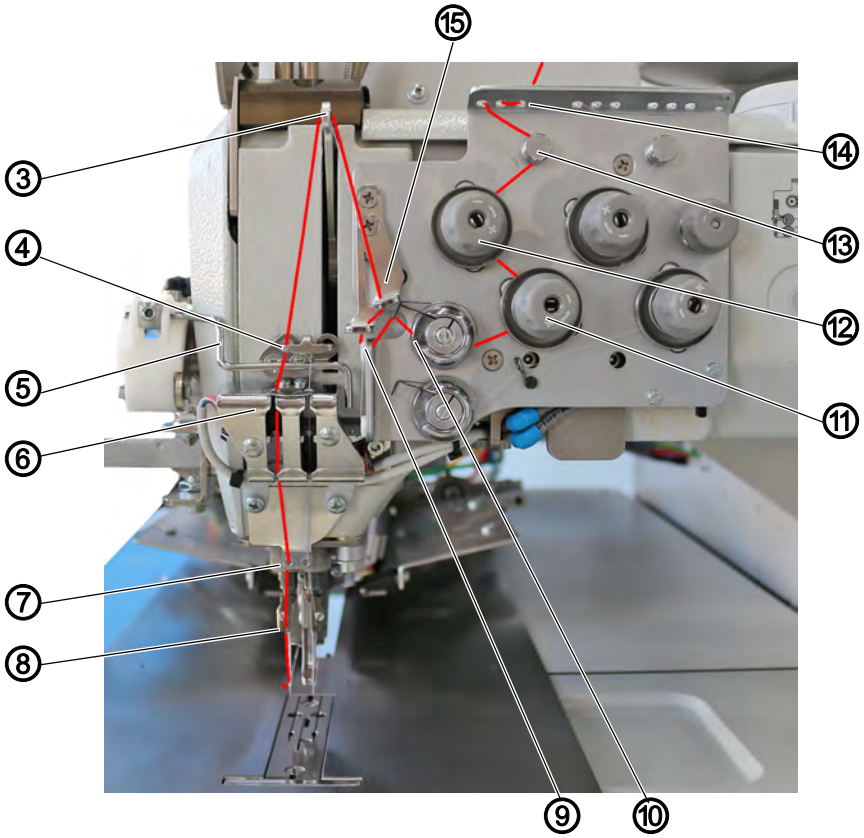
(1) - Holes *(2) - Reel stand holder*

Left needle thread

To thread the left needle thread:

1. Swivel the folder station out (📖 *p. 18*).
2. Swivel the light barriers out to the left.
3. Fit the thread reel onto the left side of the reel stand holder (2).
4. Feed the needle thread from the thread reel through the holes (1) of the reel stand holder (2).

Fig. 7: Threading the needle thread (2)



(3) - Thread lever
(4) - Guide
(5) - Thread advancing device
(6) - Needle thread monitor
(7) - Guide
(8) - Guide
(9) - Hole
(10) - Thread tensioning spring
(11) - Thread tension
(12) - Additional thread tension
(13) - Guide
(14) - Holes
(15) - Thread regulator



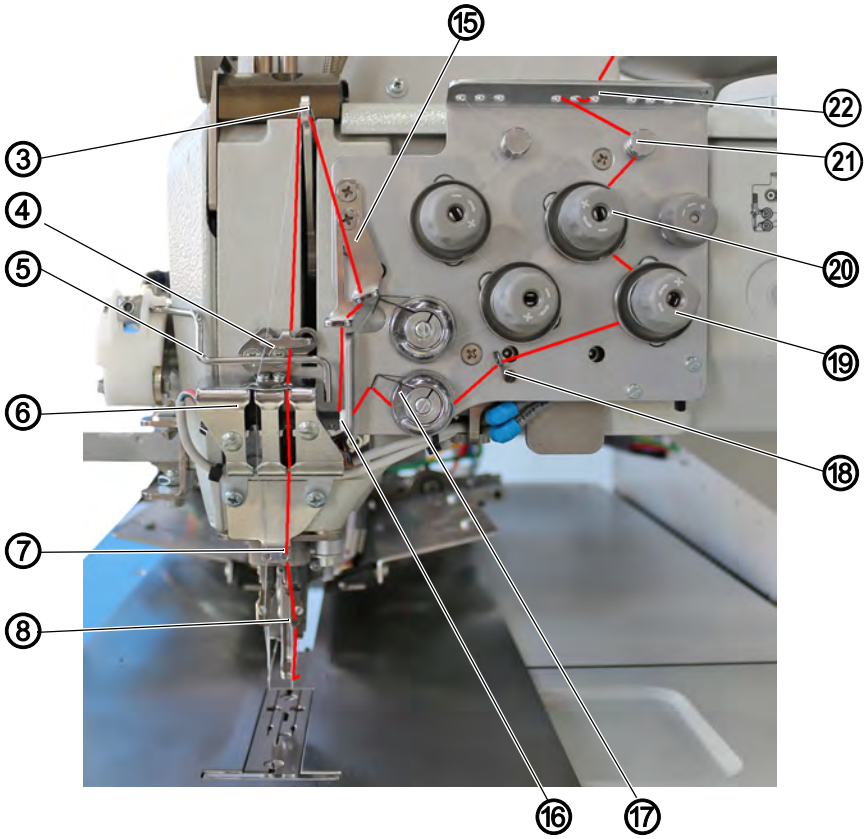
5. Insert the needle thread in a wavelike manner through the left holes (14) in the mounting plate, as shown above.
6. Feed the needle thread through the guide (13).
7. Guide the needle thread counterclockwise around the additional thread tension (12).
8. Guide the needle thread clockwise around the thread tension (11).
9. Feed the needle thread around the thread tensioning spring (10).
10. Insert the needle thread through the hole (9) in the mounting plate.
11. Feed the needle thread through the holes of the thread regulator (15).
12. Insert the needle thread through the upper hole in the thread lever (3).
13. Feed the needle thread through the guide (4).
14. Feed the needle thread in front of the thread advancing device (5).
15. Feed the needle thread through the needle thread monitor (6).
16. Feed the needle thread through the guide (7).
17. Feed the needle thread through the guide (8).
18. Feed the needle thread into the left needle.

Right needle thread

To thread the right needle thread:

1. Swivel the folder station to the side (📖 *p. 18*).
2. Swivel the light barrier out to the left.
3. Fit the thread reel onto the right side of the reel stand holder (2).
4. Feed the needle thread through the guide (1).

Fig. 8: Threading the needle thread (3)



(3) - Thread lever
(4) - Guide
(5) - Thread advancing device
(6) - Needle thread monitor
(7) - Guide
(8) - Guide
(15) - Thread regulator
(16) - Hole
(17) - Thread tensioning spring
(18) - Guide
(19) - Thread tension
(20) - Additional thread tension
(21) - Guide
(22) - Holes

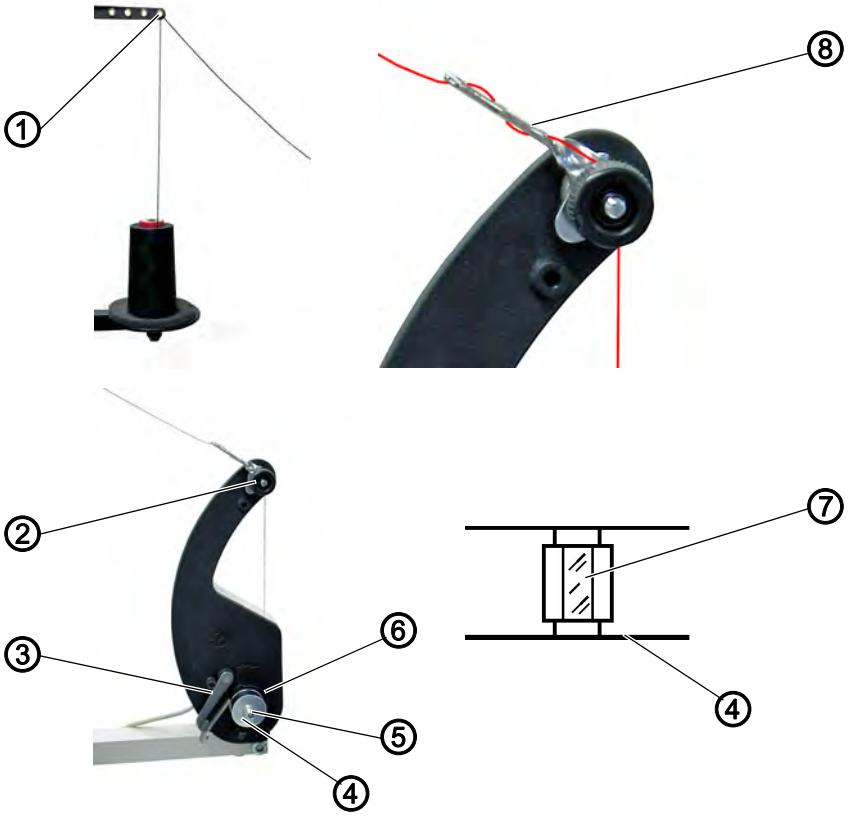
5. Insert the needle thread in a wavelike manner through the right holes (22) in the mounting plate, as shown above.
6. Feed the needle thread through the guide (21).
7. Guide the needle thread counterclockwise around the additional thread tension (20).
8. Guide the needle thread clockwise around the thread tension (19).
9. Feed the needle thread through the guide (18).
10. Feed the needle thread around the thread tensioning spring (17).
11. Feed the needle thread through the hole (16).

12. Feed the needle thread through the holes of the thread regulator (15).
13. Insert the needle thread through the lower hole in the thread lever (3).
14. Feed the needle thread through the guide (4).
15. Feed the needle thread in front of the thread advancing device (5).
16. Feed the needle thread through the needle thread monitor (6).
17. Feed the needle thread through the guide (7).
18. Feed the needle thread through the guide (8).
19. Feed the needle thread into the right needle.

4.7 Winding the hook thread

The separate winder makes it possible to wind the hook threads separately from the sewing process.

Fig. 9: Winding the hook thread



(1) - Hole
(2) - Hook thread tension
(3) - Winder lever
(4) - Bobbin
(5) - Bobbin hub
(6) - Thread-pulling knife
(7) - Reflecting surface
(8) - Guide

To wind the hook thread:

1. Remove any thread residues from the bobbin hub (5) prior to winding.
2. Fit the empty bobbin (4) onto the bobbin hub (5).
3. Insert the hook thread through the hole (1) of the real stand.
4. Insert the hook thread in a wavelike manner through the guide (8).
5. Guide the hook thread clockwise around the hook thread tension (2).
6. Wind some of the hook thread clockwise into the front and rear reserve groove of the bobbin (4).
7. Cut off the thread protruding at the thread-pulling knife (6).
8. Press the winder lever (3) into the bobbin (4).

↳ The winder starts up.

Information

With the thread supply in the reserve grooves it is ensured that the pocket opening can be safely finished after the remaining thread monitor has produced the message *Error 3220*  (bobbin empty).

Important

Keep the reflecting surface (7) of the bobbin clean.

Information

The winder stops automatically when the configured bobbin filling volume has been reached. For the setting of the bobbin filling volume, see the 🕮 *Service Instructions.*

4.8 Changing the bobbins

Fig. 10: Changing the bobbins (1)

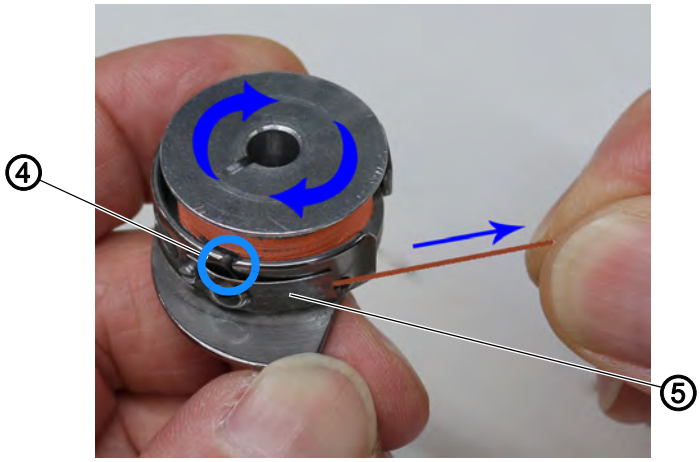


(1) - Bobbin case upper section
(2) - Bobbin case retainer
(3) - Thread-pulling knife

To change the bobbins:

1. Switch off the machine.
2. Swivel the folder station to the side (📖 *p. 18*).
3. Raise the fabric sliding plate and swivel it to the left (📖 *p. 32*).
4. Lift the bobbin case upper section (1).
   The bobbin case retainer (2) will be lifted as well.
5. Remove the bobbin case upper section (1) together with the empty bobbin.
6. Remove the empty bobbin from the bobbin case upper section (1).

Fig. 11: Changing the bobbins (2)



(4) - Slot
(5) - Thread tensioning spring

7. Insert the full bobbin into the bobbin case upper section (1).

8. Pull the hook thread through the slot (4) under the thread tensioning spring (5).

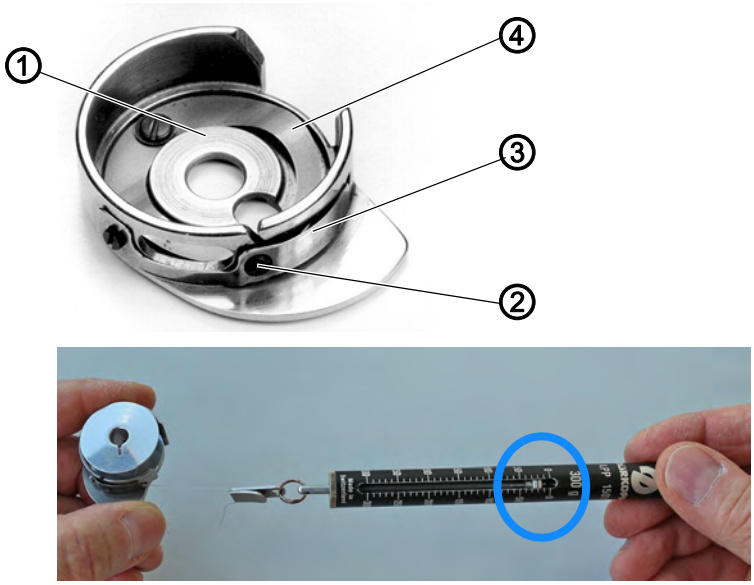
↳ The bobbin must rotate in the direction of the arrow when pulling out the thread (against the pulling direction).

9. Insert the bobbin case upper section (1) with the full bobbin into the bobbin case bottom section.
10. Close the bobbin case retainer (2).
11. Pull the hook thread behind the thread-pulling knife (3) and tear it off.
12. Replace the fabric sliding plate.
13. Switch on the machine.
14. Start a new sewing process.

4.9 Thread tension

Adjusting the hook thread tension and the bobbin brake power

Fig. 12: Adjusting the hook thread tension and the bobbin brake power (1)



(1) - Flat
(2) - Adjusting wheel
(3) - Leaf spring
(4) - Braking spring

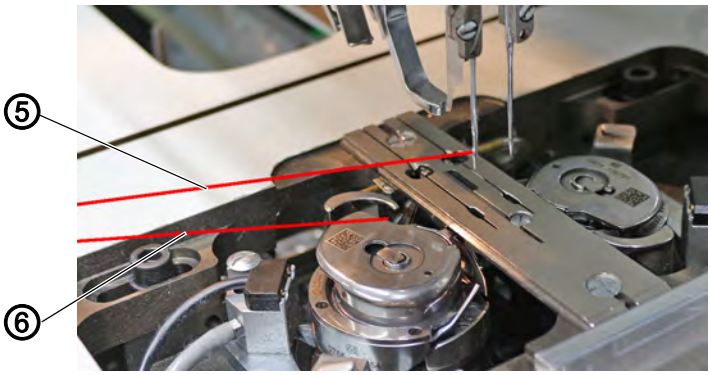
You use the leaf spring (3) to adjust the hook thread tension.
The braking spring (4) is used to slow down the bobbin.

To adjust the hook thread tension and the brake power of the bobbin:

1. Switch off the machine.
2. Disconnect the compressed air supply (📖 *p. 31*).

3. Use the adjusting wheel (2) to set the initial hook thread tension of the leaf spring (3) to approx 20 gr.
   - **Increase the hook thread tension:** Turn the adjusting wheel (2) clockwise
   - **Reduce the hook thread tension:** Turn the adjusting wheel (2) counterclockwise
4. Insert the bobbin case upper section with the braking spring (4) and with the full bobbin into the bobbin case bottom section.
5. Close the bobbin case retainer.

Fig. 13: Adjusting the hook thread tension and the bobbin brake power (2)

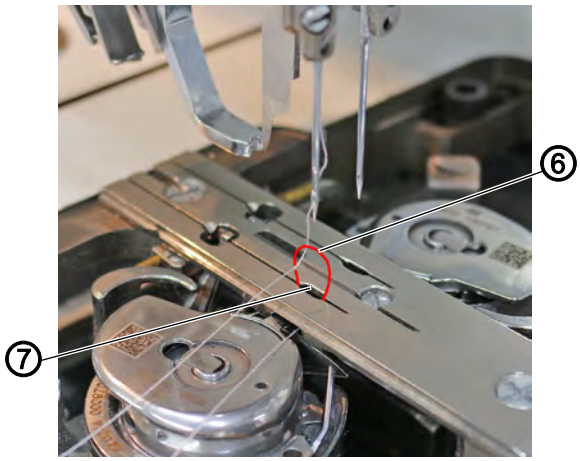


(5) - Needle thread *(6) - Hook thread*



6. Turn the handwheel while keeping needle thread (5) and hook thread (6) under tension.
7. Shortly before the hook tip reaches the needle after the hook thread was picked up, tighten the needle thread (5) a little more.

Fig. 14: Adjusting the hook thread tension and the bobbin brake power (3)

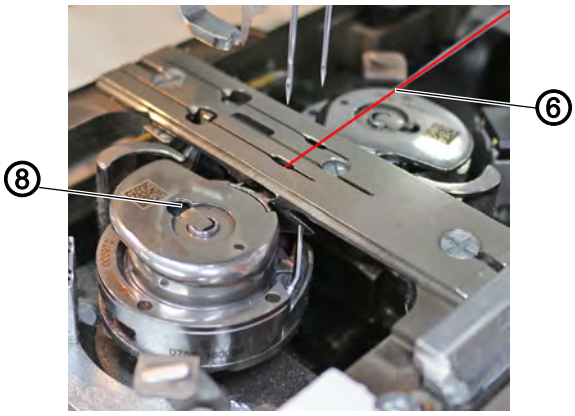


(6) - Hook thread *(7) - Needle hole*



↳ The hook thread (6) has now been pulled up through the needle hole (7).

Fig. 15: Adjusting the hook thread tension and the bobbin brake power (4)



(6) - Hook thread
(8) - Inspection glass

8. Swiftly pull on the hook thread (6) and stop abruptly while checking the inspection window (8) to see if the bobbin keeps running.

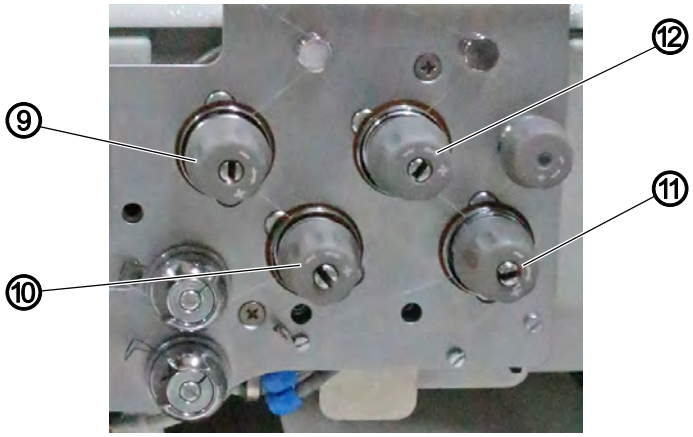
If the bobbin keeps running:

9. Adjust the braking spring (4) just enough to prevent an after-run of the bobbin (this is important as the braking spring will increase the hook thread tension more than necessary if its pretension is excessive).

↳ Pull-off must be uniform and easy once the bobbin has been inserted and the hook thread (6) has been threaded through the needle hole.

Adjusting the needle thread tension

Fig. 16: Adjusting the needle thread tension



(9) - Additional thread tension - left needle thread
(10) - Thread tension - left needle thread
(11) - Thread tension - right needle thread
(12) - Additional thread tension - right needle thread

To adjust the needle thread tension:

1. Set the needle thread tension so that an even stitch pattern is achieved.

2. Adjust the main tension of the needle threads using thread tension (11) (right needle thread) and thread tension (10) (left needle thread).
   - **Increase the needle thread tension:** Turn clockwise
   - **Reduce the needle thread tension:** Turn counterclockwise

Information

The additional thread tensions (9) and (12) are used to ensure seam securement at seam beginning and seam end.
The additional thread tension is activated in addition to the main tension at seam beginning and seam end.
Setting at the control panel OP7000 under `Program parameters > Sewing head parameters > Additional thread tension` (📖 *p. 147*).

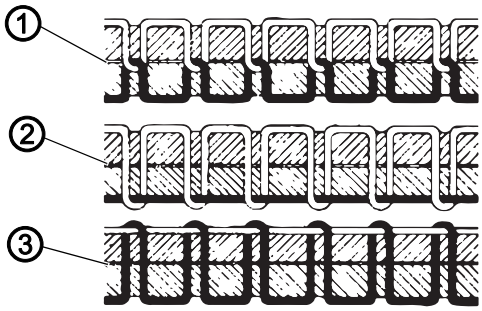
Important

Together with the hook thread tension, the needle thread tension influences the final seam pattern.
Always adjust needle thread tension and hook thread tension together.

Proper setting

If the tension of needle thread and hook thread is identical, the thread interlace lies in the middle of the sewing material.
Adjust the needle thread tension so that the desired seam pattern is achieved with the lowest possible tension.

Fig. 17: Thread tension



(1) - Identical needle thread and hook thread tension
(2) - Hook thread tension higher than needle thread tension
(3) - Needle thread tension higher than hook thread tension

4.10 Disconnecting the compressed air supply

Fig. 18: Disconnecting the compressed air supply



(1) - Handle

To disconnect the compressed air supply:

1. Pull the handle (1) on the compressed air maintenance unit to the left.

4.11 Sliding back the hood and removing the fabric sliding plate

To provide for easier access to the transport clamps, the hood can be moved out of the way.

CAUTION



Risk of injury from moving parts!

Crushing possible.

Switch off the machine. Do not slide the hood back and remove the fabric sliding plate back UNLESS the machine is switched off.

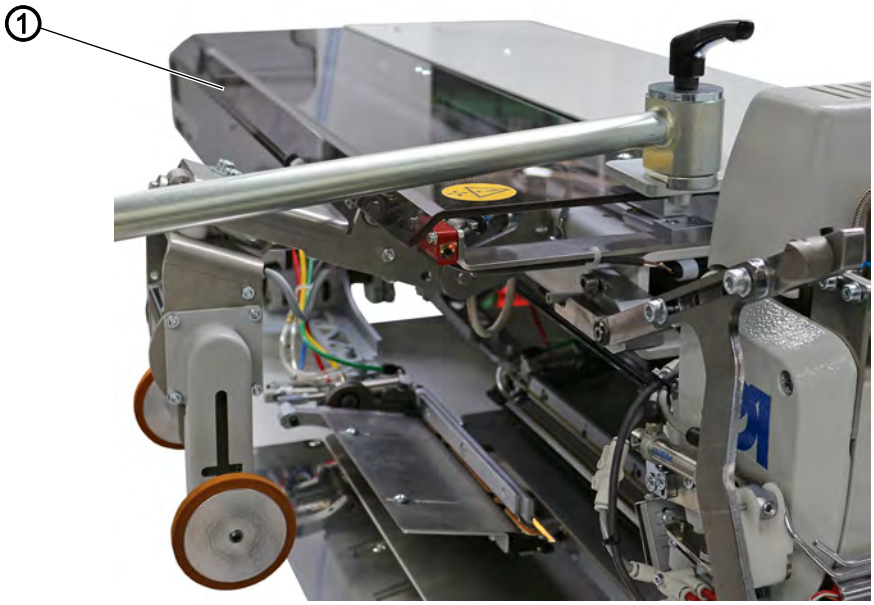
NOTICE

Property damage may occur!

Risk of breakage.
If the shim kit has been fitted, the shims may become damaged when the fabric sliding plate is removed.

Ensure that the shims have been moved out of the throat plate area and out of the guides.

Fig. 19: Sliding back the hood and removing the fabric sliding plate (1)



(1) - Hood

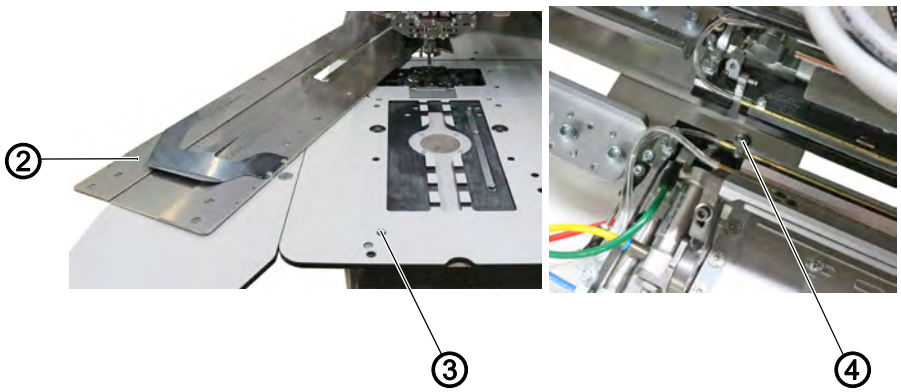
To slide back the hood:

1. Switch off the machine.
2. Slide the hood (1) to the back.

↳ You can now access the transport clamps.

3. Slide the hood (1) back to the front until it locks audibly into place.

Fig. 20: Sliding back the hood and removing the fabric sliding plate (2)



(2) - Fabric sliding plate
(3) - Pin
(4) - Pin

To disassemble the fabric sliding plate:

For machines with shims

1. Move the shims out of the throat plate area.
   - Press back the pedal for more than 1 second **OR**
   - Press the **Shim** button on the start screen (only possible if active in the software, 📖 *p. 187*)

↳ The transport clamp along with the shims moves out of the throat plate area.

2. Lift the fabric sliding plate (2) off the pin (3) and swing it out to the left.
3. Lift the fabric sliding plate (2) at the pin (4).

4.12 Swiveling up the machine head

The machine head can be swiveled up for maintenance work.
This requires that the transport carriage be in its rear position.

WARNING

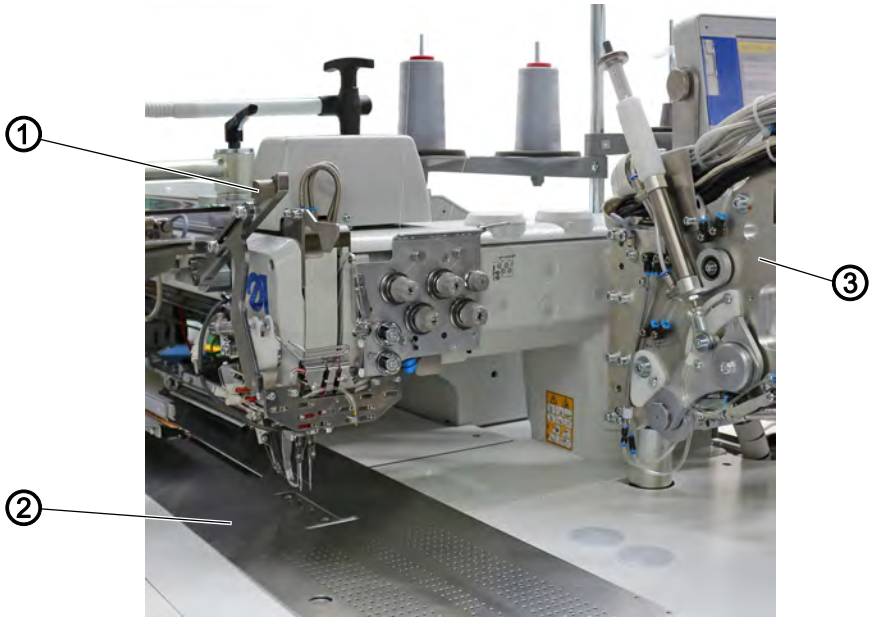


Risk of injury from moving parts!

Crushing possible.

Switch off the machine.
Swivel up the machine head using the utmost caution

Fig. 21: Swiveling up the machine head (1)

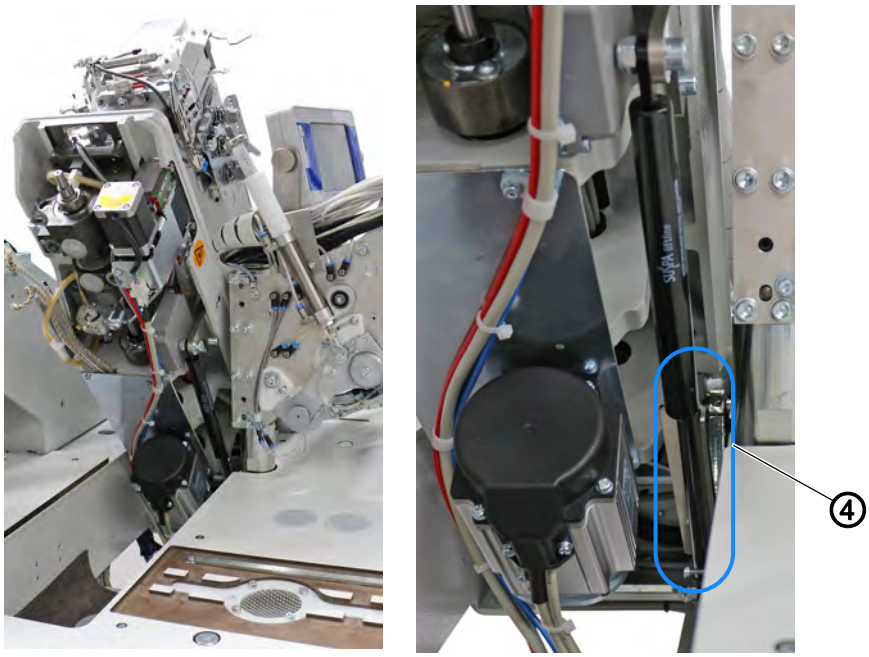


(1) - Lever
(2) - Fabric sliding plate
(3) - Folder station

To swivel up the machine head:

1. Swing the folder station (3) out (📖 *p. 18*).
2. Disassemble the fabric sliding plate (2).
3. Swivel the lever (1) up.

Fig. 22: Swiveling up the machine head (2)



(4) - Latch

4. Lift and carefully swivel up the machine head.
   The latch (4) locks into place as well.

4.13 Swiveling down the machine head

WARNING



Risk of injury from moving parts!

Crushing possible.

Switch off the machine.
Swivel up the machine head using the utmost caution

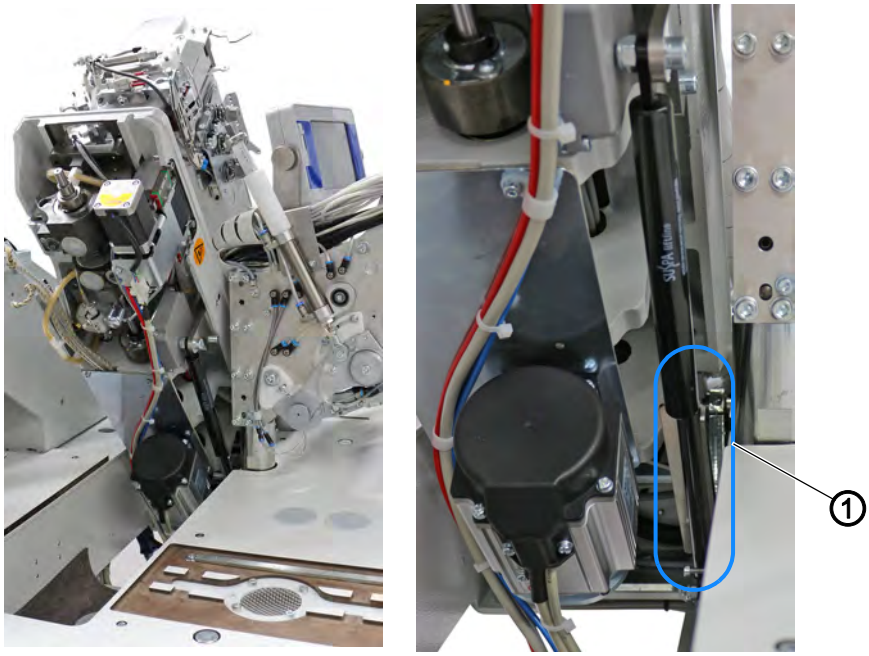
NOTICE

Property damage may occur!

Damage to the machine head.

Hold on to the machine head until it is completely at rest when lowered.

Fig. 23: Swiveling down the machine head (1)

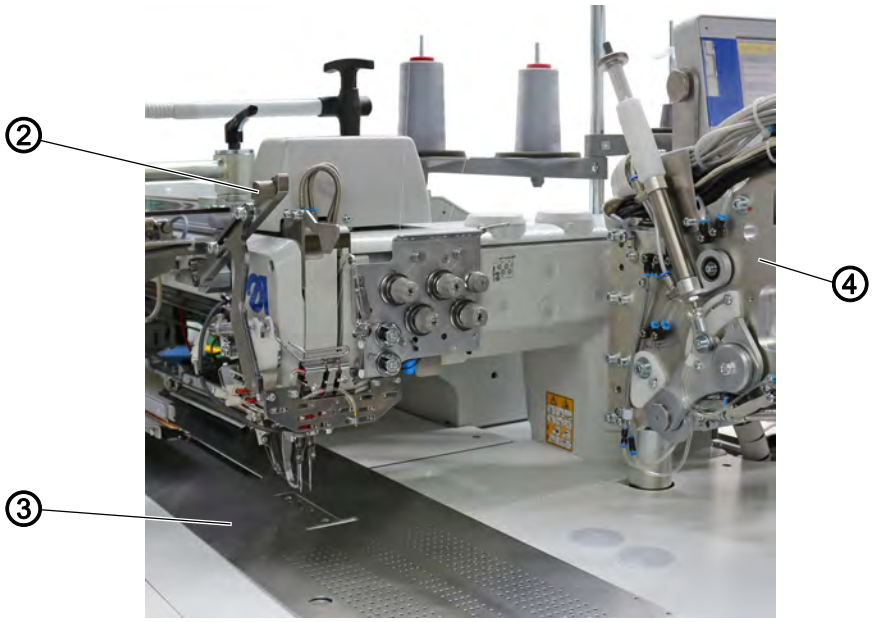


(1) - Latch

To swivel down the machine head:

1. Hold the machine head in place.
2. Release the latch (1).
3. Swivel down the machine head carefully.

Fig. 24: Swiveling down the machine head (2)



(2) - Lever
(3) - Fabric sliding plate
(4) - Folder station

4. Insert the fabric sliding plate (3).
5. Swivel the lever (2) down.
6. Swivel down the folder station (4).

4.14 Remaining thread monitor

The remaining thread monitor together with the infrared reflected light barriers (1) and (2) monitors the left and the right bobbin.

Fig. 25: Remaining thread monitor



(1) - Light barrier 1
(2) - Light barrier 2
(3) - Reflecting surface

To operate the remaining thread monitor:

- When the bobbin is empty, the light beam transmitted by the light barrier (1) or (2) is reflected by the exposed reflecting surface (3) of the bobbin hub.
- If the remaining thread monitor is switched on, the control panel displays the message: `Error 3220` 

.
- The pocket opening is safely finished with the remaining thread in the reserve groove of the bobbin hub. The transport carriage stops at its rear end position. It cannot be started again until the bobbin has been changed.

Cleaning the remaining thread monitor

CAUTION



Risk of injury from sharp and moving parts!

Puncture or crushing possible.

Do not clean the lenses of the light barriers unless the machine is switched off.

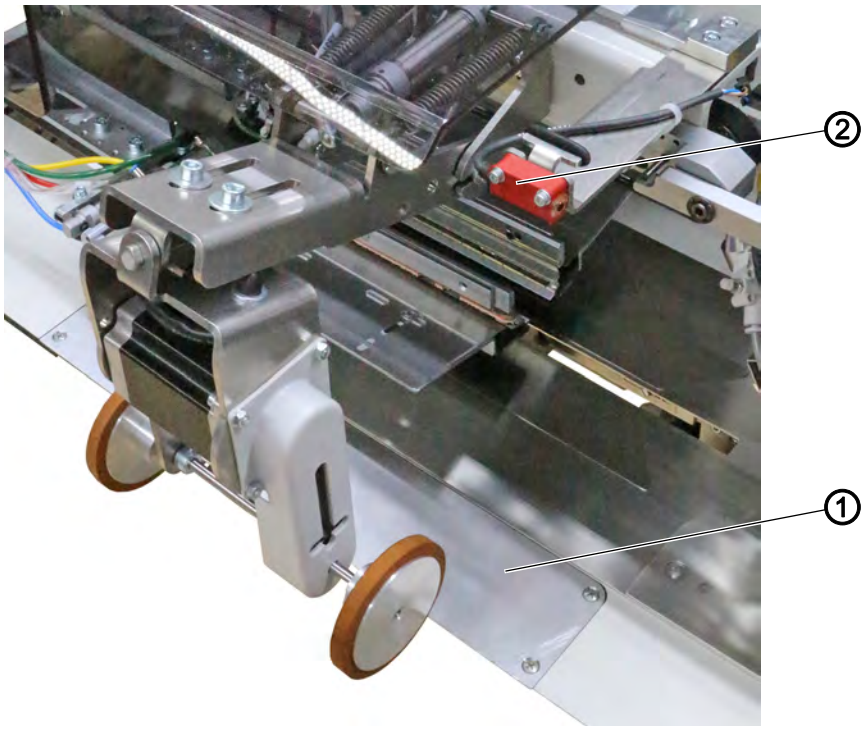


To clean the remaining thread monitor:

1. Switch off the machine.
2. Clean the lenses of the light barriers with a soft cloth every time you change the bobbin.
3. Wind the bobbin.
4. Switch on the machine.
5. Start a new sewing process.

4.15 Stacker control

Fig. 26: Stacker control



(1) - Reflecting sheet *(2) - Reflected light barrier*

The reflected light barrier (2) monitors how the sewn pieces are stacked and blown out. The transport carriage is not returned until the workpiece has been moved out correctly.

Important

For a secure function of the stacking control clean the lens of the reflected light barrier with a soft cloth once a day.

Workpiece is not conveyed out correctly

If the workpiece is not moved out correctly, the light beam between the reflected light barrier (2) and the reflecting sheet (1) remains interrupted. Renewed starting is not possible.

CAUTION



Risk of injury from moving parts!

Crushing possible.

Do not reach into the movement area of the transport carriage when removing the workpiece.

Do not clean the lenses of the light barriers unless the machine is switched off.

To correct faulty stacking or blowing out:

1. Remove workpiece from the light beam.

↳ You can start a new sewing process.

4.16 Setting up double pipe/single pipe

4.16.1 Changing the folder tools

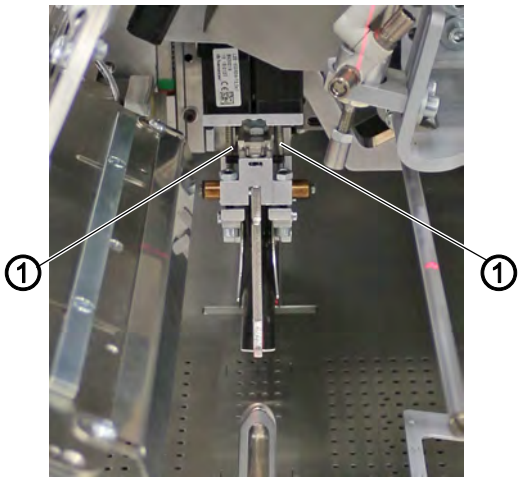
NOTICE

Property damage may occur!

Acting in a careless manner when changing the folder tools may damage the folder tools and render them useless.

Always proceed with utmost caution when changing the folder tools.

Fig. 27: Changing the folder tools (1)

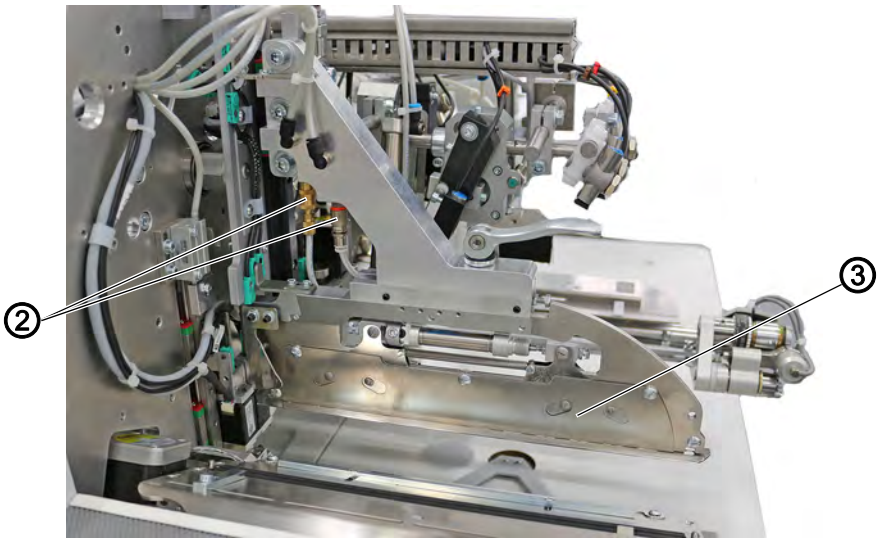


(1) - Spindles

To change the folder tools:

1. Press `Folder change position` on the start screen.
2. The spindles (1) move up.
3. Switch off the machine.

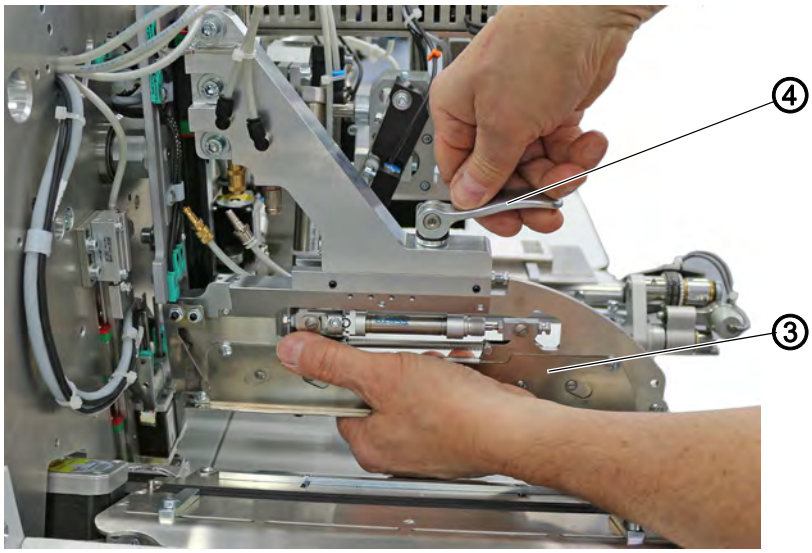
Fig. 28: Changing the folder tools (2)



(2) - Hoses *(3) - Pick-up folder*

4. Disconnect the hoses (2) of the pneumatic system from the pick-up folder (3)

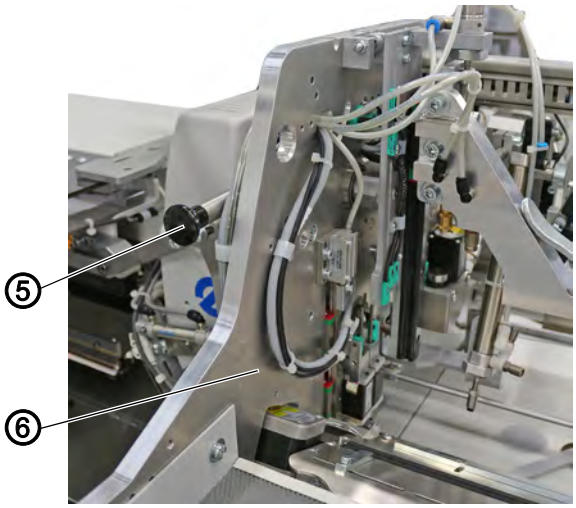
Fig. 29: Changing the folder tools (3)



(3) - Pick-up folder *(4) - Lever*

5. Flip the lever (4) while holding the pick-up folder (3) in place.
6. Pull the pick-up folder (3) out towards the front.

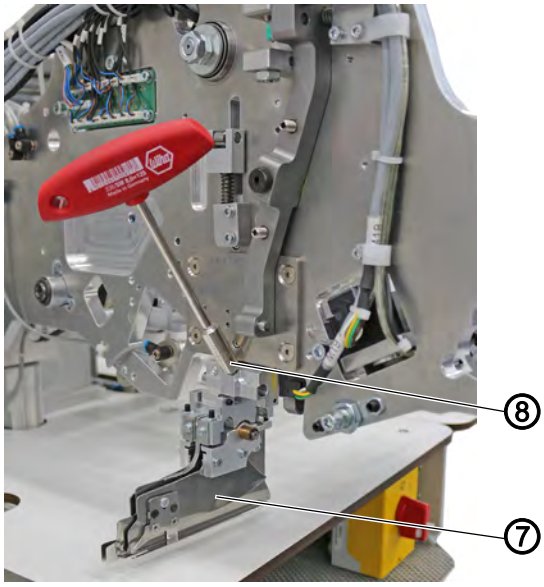
Fig. 30: Changing the folder tools (4)



(5) - Handle *(6) - Method plate*

7. Unlock the method plate (6) at the handle (5) and swivel it to the side

Fig. 31: Changing the folder tools (5)



(7) - Folder *(8) - Screw*

8. Loosen the screw (8) on the folder (7).
9. Pull the folder (7) down and out towards the side.
10. Position the new folder and pull it down while pushing it in.
11. Re-tighten the screw (8).
12. Carefully swivel back the method plate (6) and lock it into place.
13. Carefully insert the pick-up folder as far as it will go, hold in it place, and flip the lever (4).
14. Connect the hoses (2) of the pneumatic system again.

15. Switch on the machine.

↳ The spindles (1) move back down automatically.

16. Set the software to the correct setting.

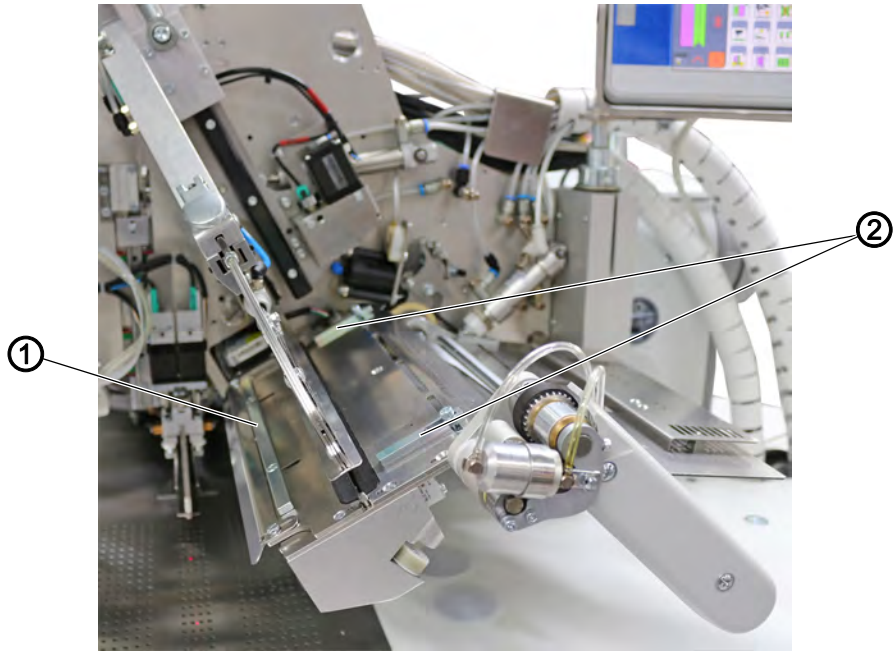
You switch and set the transport clamps from double pipe to single pipe and vice versa at the OP7000 control panel. *Program parameters > Process of transport clamp > Quick clamp adjustment* (📖 *p. 167*).

Important

If the display shows error message 9014 - warning of collisions, the software setting for the folder tools is incorrect/not sensible. Check and, if necessary, correct the setting.

4.16.2 Setting up double pipe

Fig. 32: Setting up double pipe



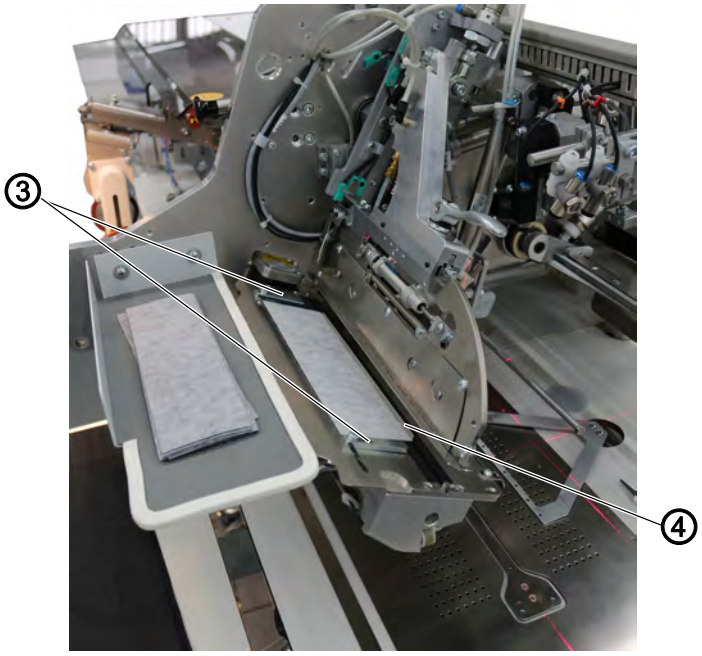
(1) - lateral stop *(2) - Stops*

To set up double pipe:

1. You switch and set the transport clamps from single pipe to double pipe (also requires a change of the folder tools!) at the OP7000 control panel. *Program parameters > Process of transport clamp > Transport clamp quick adjustment* (📖 *p. 167*).
2. Position the piping strip at the front or rear stop (2).
3. Position the piping strip at the lateral stop (1).
4. Start sewing.

4.16.3 Setting up single pipe

Fig. 33: Setting up single pipe



(3) - Stops *(4) - Center stop*

To set up single pipe:

1. You switch and set the transport clamps from double pipe to single pipe (also requires a change of the folder tools!) at the OP7000 control panel. `Program parameters > Process of transport clamp > Transport clamp quick adjustment` (📖 *p. 167*).
2. Position the piping strip at the front or rear stop (3).
3. Position the piping strip at the center stop (4).
4. Start sewing.

4.17 Corner knife station

4.17.1 Swiveling the corner knife station in and out

CAUTION



Risk of injury from sharp parts!

Cutting possible.

Swivel out the corner knife station only when the machine is switched off.

NOTICE

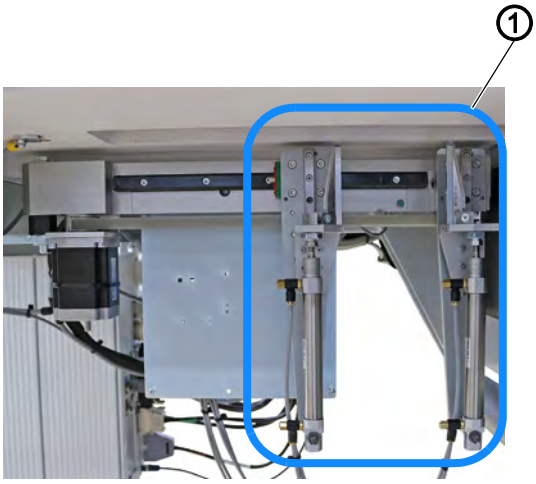
Property damage may occur!

Unless swiveled in all the way, the corner knife station can damage the machine.

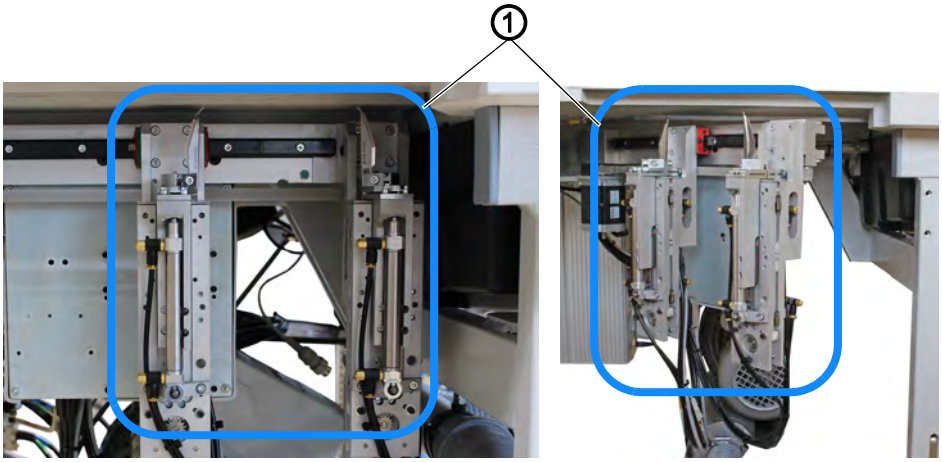
When swiveled in, the corner knife station engages audibly.

Fig. 34: Swiveling the corner knife station in and out (1)

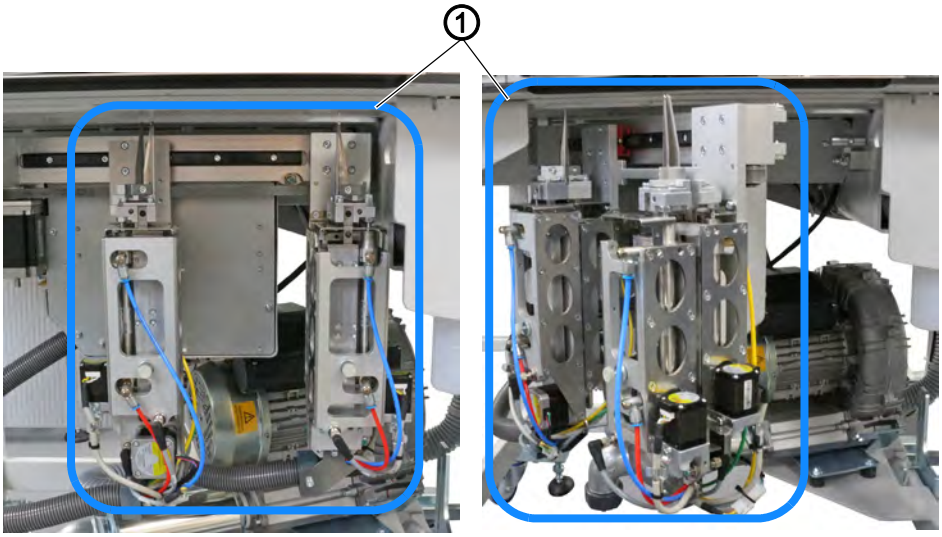
automatic corner knife station (straight pocket)



automatic corner knife station (slanted pocket)

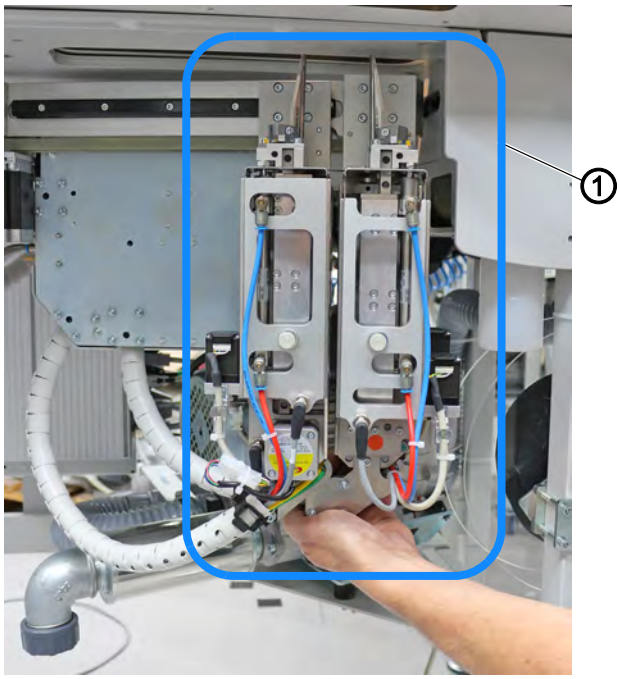


multi-functional corner knife station



(1) - Corner knife station

Fig. 35: Swiveling the corner knife station in and out (2)



(1) - Corner knife station

To swivel the corner knife station out and back in:

1. Switch off the machine.
2. Slide the transport clamps to the rearmost position.
3. Grasp the corner knife station (1) at the bottom and swivel it out to the left.

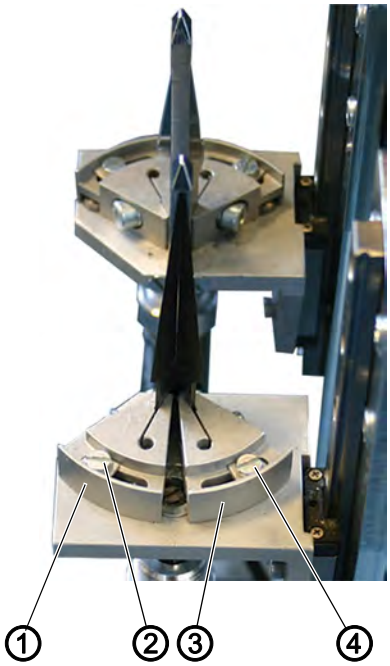
↳ The knives are accessible for setup and service work.

4. Swivel the corner knife station (1) back and re-engage it.

4.17.2 Adjust corner knife (automatic corner knife station)

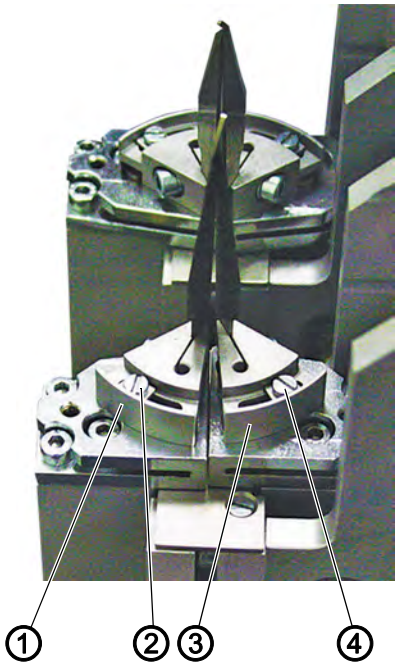
Fig. 36: Adjust corner knife (automatic corner knife station)

Corner knife straight



(1) - Knife holder
(2) - Screw

Corner knife slanted



(3) - Knife holder
(4) - Screw

Adjusting the angle of the corner knife station



To adjust the angle of the corner knife station:

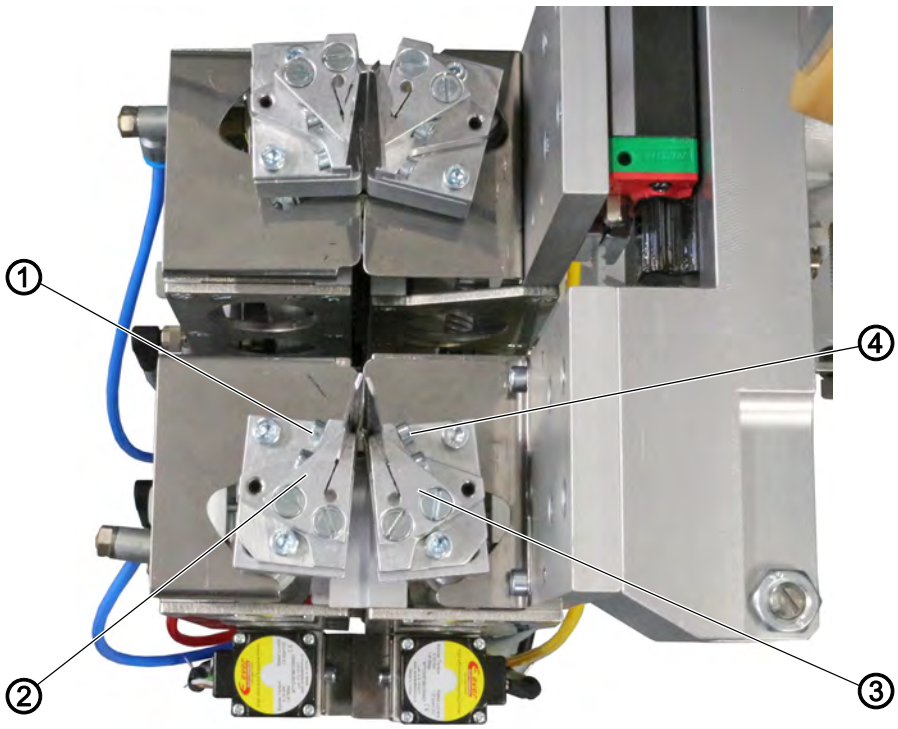
1. Swivel out the corner knife station (📖 *p. 45*).
2. Loosen screws (2) and (4).
3. Turn the knife holders (1) and (3) evenly.
4. Tighten screws (2) and (4).
5. Adjust the angle at the other pair of knives accordingly.
6. Swivel in the corner knife station.

Adjusting the height of the corner knives

The height of the corner knives cannot be adjusted. The knives always cut through completely.

4.17.3 Adjusting the corner knives (multi-functional corner knife station)

Fig. 37: Adjusting the corner knives (multi-functional corner knife station)



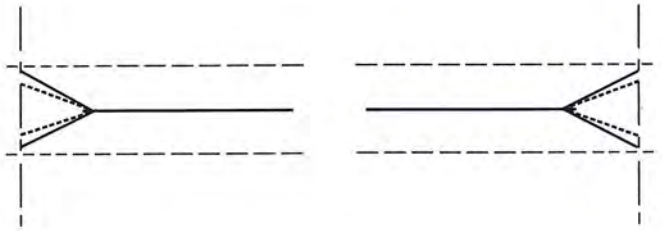
(1) - Screw
(2) - Knife holder
(3) - Knife holder
(4) - Screw

The corner knives are adjusted by stepper motors.

You adjust the corner knife cuts at the OP7000 control panel. `Program parameters > Corner knives` (📖 *p. 153*).

Checking the cutting pattern

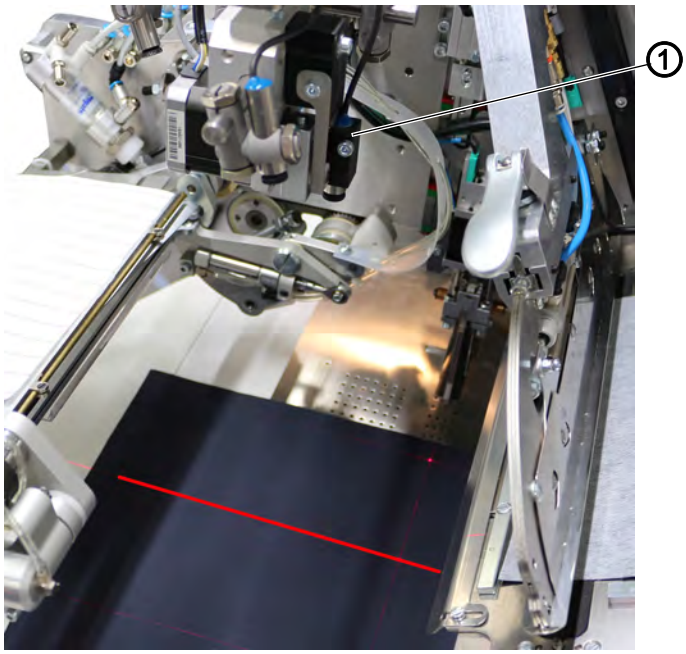
Fig. 38: Checking the cutting pattern



- **Straight pocket corners**: the right and the left corner knife cuts are parallel to one another
- **Slanted pocket corners**: the left corner knife cut is offset by +/- 13 mm relative to the right corner knife cut

4.18 Adjusting the programmable marking lamp (lengthwise)

Fig. 39: Adjusting the programmable marking lamp



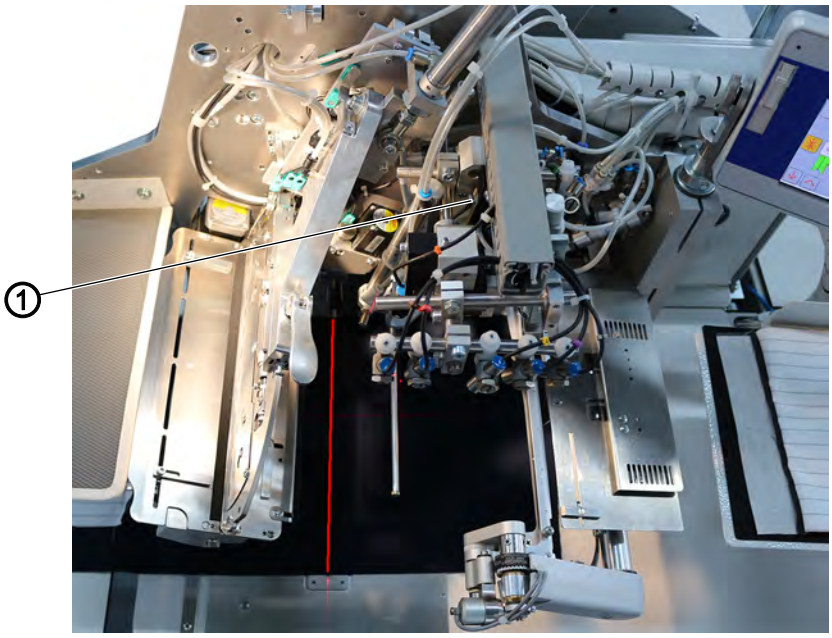
(1) - programmable marking lamp

The programmable marking lamp (1) can be programmed in sewing direction. The marking lamp lines up automatically with the corresponding positioning point (front/middle/back).

The programmable marking lamp (1) is set using the OP7000 control panel. `Program parameters > Vertical programmable marking lamps` (📖 *p. 145*).

4.19 Adjusting the programmable marking lamp (crosswise)

Fig. 40: Adjusting the programmable marking lamp



(1) - programmable marking lamp

The programmable marking lamp (1) can be programmed crosswise to the sewing direction for the sewing material that needs to be processed (for example, different trouser sizes).

The programmable marking lamp (1) is set using the OP7000 control panel. `Program parameters > Horizontal programmable marking lamps` (📖 *p. 146*).

4.20 Needle transport

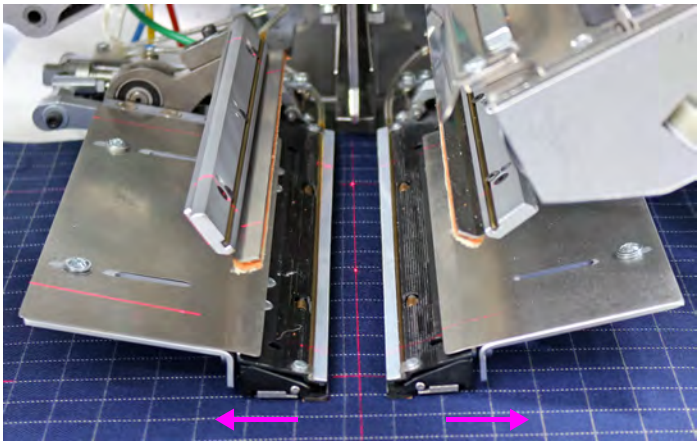
Needle transport improves seam quality in difficult-to-sew and difficult-to-feed materials such as stretch material, patterned and stripe material, knitwear, coats and leather goods. The transport length can be individually adapted to the material and stored in the program.

The needle transport setting varies with the sewing material and the achieved sewing result.

The needle transport is adjusted using the OP7000 control panel. *Program parameters > Sewing head parameters > Needle transport* (📖 *p. 150*).

4.21 Stepper motor-controlled transport clamp adjustment with material spreading

Fig. 41: Spreading the transport clamp



The positions of the transport clamps relative to the folder sole can be set individually and depending on the material in the program. This is made possible by the automatic conversion from double pipe to single pipe and program storage to a wide range of material thicknesses.
It is, furthermore, possible to spread the material after lowering the transport clamps in order to achieve better seam quality and more precise corner cuts.

The setting for the transport clamps is made using the OP7000 control panel. *Program parameters > Process of transport clamp > Spread transport clamp* (📖 *p. 170*).

4.22 Moving to the reference position

The reference position is necessary in order to obtain a defined initial position.

To move to the reference position:

1. Switch on the machine.

↳ The control is initialized.
The control checks whether the transport carriage is at its rear end position. If not, the display shows the message Reference run:

Warning 9000   .

2. Press the left pedal back.

↳ The reference run starts.
The transport carriage moves to its rear end position.

4.23 Performing a quick stop

To perform a quick stop:

1. Press the left pedal back.

↳ The positioning sequence / cycle process is stopped immediately.
The display shows the following message:

Warning 9601 

.

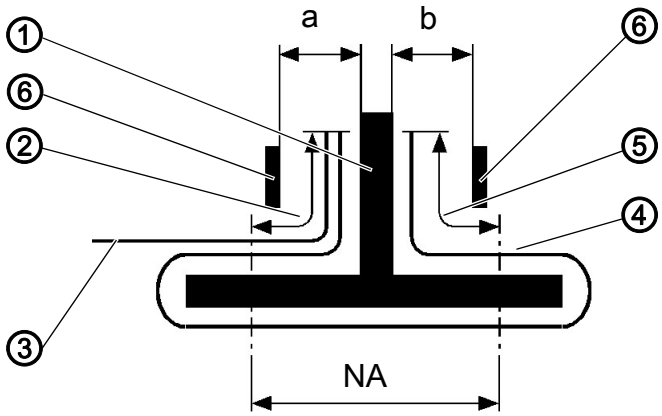
2. Press the left pedal back again.

↳ The transport carriage moves to its rear end position.

4.24 Flap and piping projection

Unhindered passage of the workpieces at the folder/pick-up folder requires that the maximum projections of piping, flap and material thickness (see diagram) not exceed the permissible limit. For the maximum allowable piping strip widths for the respective sewing equipment (E-No.), refer to the Equipment Sheets of the 756.

Fig. 42: Flap and piping projection



(1) - Folder
(2) - Flap projection
(3) - Flap
(4) - Piping strip
(5) - Piping projection max. 50 mm
(6) - Guiding plate at the folder

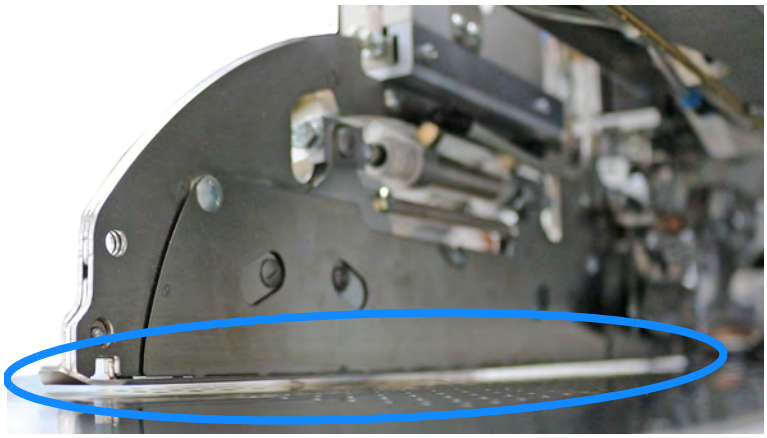
NA: Seam projection
a, b: Material passage at the folder

4.25 Adjusting to the sewing material thickness

The machine can be adjusted perfectly to different sewing material thicknesses by programming the height of folder and guiding plates.

4.25.1 Height of the pick-up folder

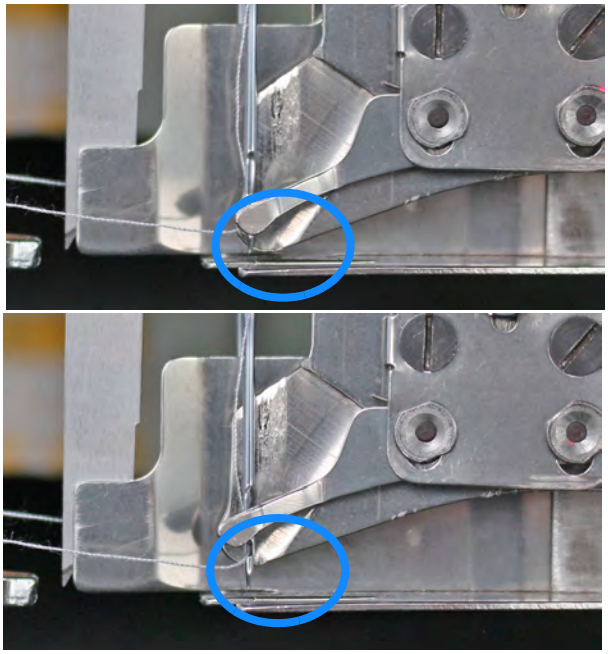
Fig. 43: Height of the pick-up folder



The height of the pick-up folder is adjusted using the OP7000 control panel. `Program parameters > Guiding plates and folder` (📖 *p. 182*).

4.25.2 Height of the guiding plates

Fig. 44: Height of the guiding plates



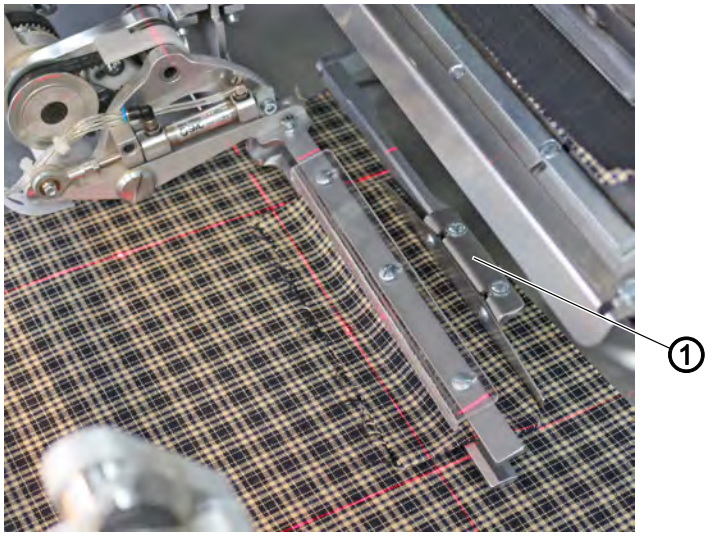
The height of the guiding plates is adjusted using the OP7000 control panel. `Program parameters > Guiding plates and folder` (📖 *p. 182*).

4.26 Stripe correction (class 756 only, method F)

The stripe correction can only be used in combination with the turning device for flaps.

You adjust the stripe correction at the OP7000 control panel.
`Program parameters > Pattern matching` (📖 *p. 184*).

Fig. 45: Stripe correction (1)



(1) - Flap stopper

To adjust the stripe correction:

1. Insert piping.
2. Place the flap into the retracted and open turning device.
3. Position the flap in the longitudinal direction relative to the jacket front part, which must be aligned and fixed in place by vacuum. Depending on the model, the flap projects 10 to 15 mm over the breast dart.
4. At the same time, position the flap at the lowered mechanical flap stopper (1).
5. Press the left pedal forward.

↳ The clamping bar closes and holds the flap in place. The mechanical flap stopper swivels up.

6. Press the right pedal backwards.

↳ The vacuum is switched off.

Fig. 46: Stripe correction (2)



7. Accurately align the jacket front part below the clamped flap as per the pattern.
8. Press the right pedal forward.

↳ The vacuum is switched on.

9. Press the left pedal forward.

↳ The turning device swivels back and transfers the flap to the open flap feeding device. The flap is fed and sewn on.

Fig. 47: Stripe correction (3)



10. If a lateral shift from the pattern is discernible after sewing, this shift can be offset by using stripe correction in the software (📖 *p. 184*):
    Shift of the flap to the left = lower value
    Shift of the flap to the right = higher value
11. Take off the flap before repositioning and re-aligning it.
12. Sew on and check the flap; correct again if necessary.

4.27 Additional equipment

4.27.1 Blow-out device

The blow-out device (1) is used in conjunction with the bundle clamp. The blow tube conveys the sewing material out of the stacking position.

Fig. 48: Blow-out device



(1) - Blow-out device

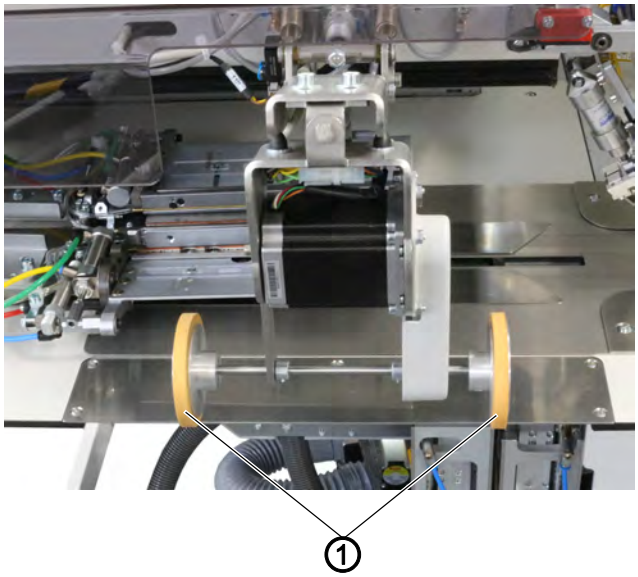
The setting for the blow-out device is made using the OP7000 control panel. *Program parameters > Stacker/smoother/ blow-off/ roll-off* (📖 *p. 179*).

Information

The blow tube continues to blow until the light barrier used for stacker control is clear.

4.27.2 Outfeed roller

Fig. 49: Outfeed roller



(1) - Transport rollers

The transport rollers (1) convey the workpiece into the stacker opening.

- This is necessary for workpieces positioned in the longitudinal direction
- It is also necessary for workpieces which are too short to be seized by the throw-over stacker
- Minimum distance: 200 mm from the middle of the pocket opening to the edge of the workpiece

The setting for the roll-off speed and the duty cycle is made using the OP7000 control panel. `Program parameters > Stacker/smoother/blow-off/roll-off` (📖 *p. 179*)

Information

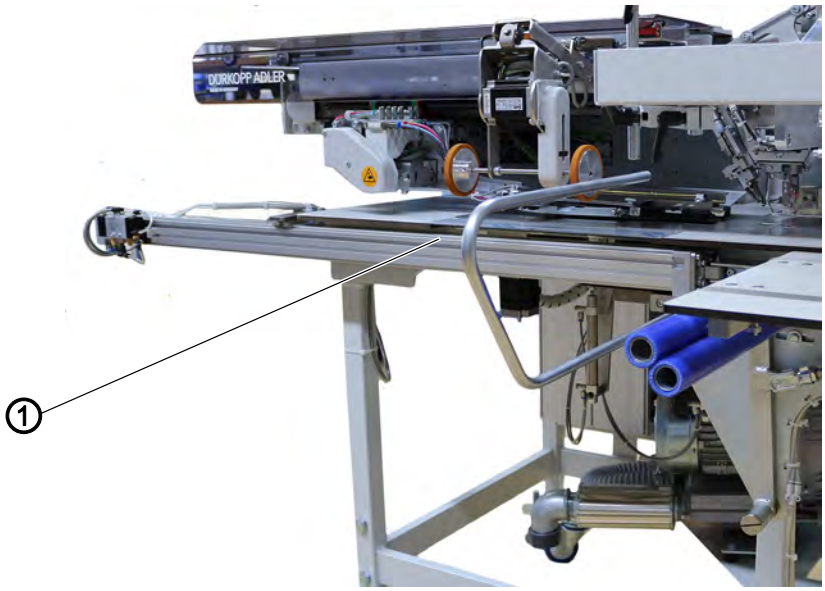
The outfeed roller serves a dual function:

- Stacker switched on: Outfeed roller as stacker extension during the production of jackets
- Outfeed roller as ejector in combination with the bundle clamp during the production of trousers

4.27.3 Smoother

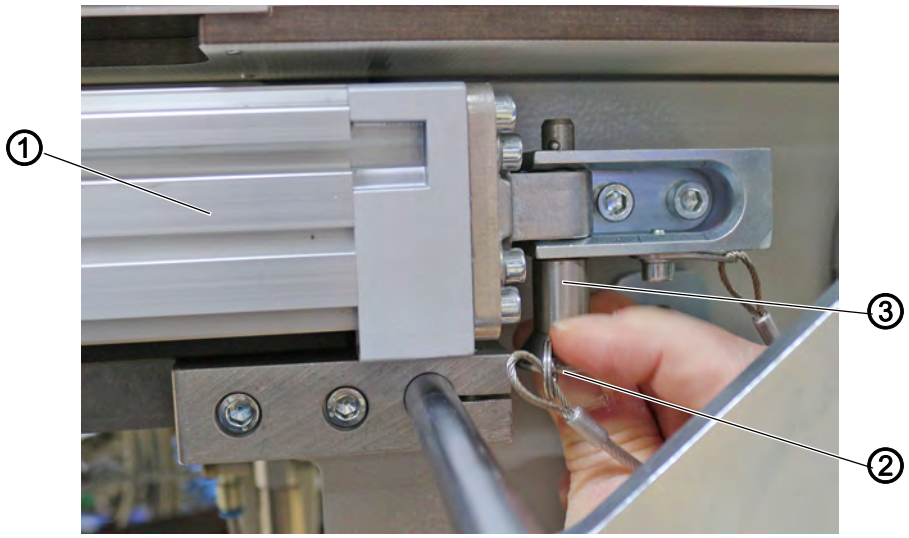
The smoother keeps the sewn trousers parts from twisting if a bundle clamp is used during sewing. The sewn trousers parts are thus positioned straight and neatly in the bundle.

Fig. 50: Smoother (1)



(1) - Smoother

Fig. 51: Smoother (2)



(1) - Smoother
(2) - Button
(3) - Pin

To unlock the smoother:

1. Press the button (2) into pin (3) while pulling pin (2) down at the same time.

   ↳ The smoother (1) can be swiveled to the side to make the corner knife station accessible.

The setting for the smoother is made using the OP7000 control panel. `Program parameters > Stacker/smoother/ blow-off/roll-off` (📖 *p. 179*).

4.27.4 Throw-over stacker

The throw-over stacker is used to clamp and stack jackets or trousers. It can be adjusted to the stacking height and the distance to the machine.

Fig. 52: Throw-over stacker



For instructions on how to assemble the throw-over stacker, refer to the Setup chapter, 📖 *p. 313*.

The setting for the throw-over stacker is made using the OP7000 control panel. `Program parameters > Stacker/smoother/ blow-off/ roll-off` (📖 *p. 179*).

4.27.5 Pincer stacker

The pincer stacker can be used for stacking long and short workpieces.

Fig. 53: Pincer stacker



The setting for the pincer stacker is made using the OP7000 control panel. `Program parameters > Stacker/smoother/ blow-off/roll-off` (📖 *p. 179*).

4.27.6 Bundle clamp

The bundle clamp including rest table are suitable for the production of trousers. The bundles are placed on the table and clamped. After sewing, they are removed with the help of the outfeed roller or the blow-out device and descend while being held by the bundle clamp.

CAUTION

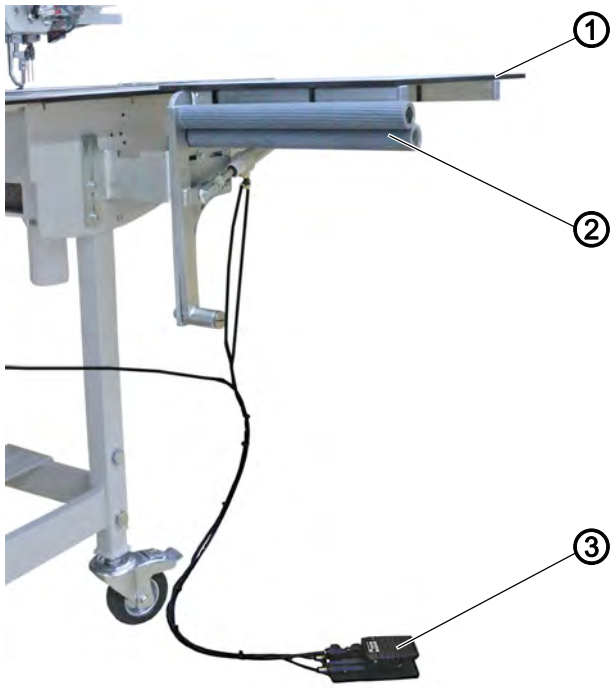


Risk of injury from moving parts!

Crushing possible.

NEVER reach between the arms of the bundle clamp.

Fig. 54: Bundle clamp



(1) - Table extension
(2) - Bundle clamp
(3) - Pedal

To operate the bundle clamp:

1. Press the pedal (3) and hold it down.
   ↳ The bundle clamp (2) opens.
2. Insert the hind trousers parts into the bundle clamp (2).
3. Release the pedal (3).
   ↳ The bundle clamp (2) closes.
4. Deposit the clamped hind trousers parts on the table extension (1).

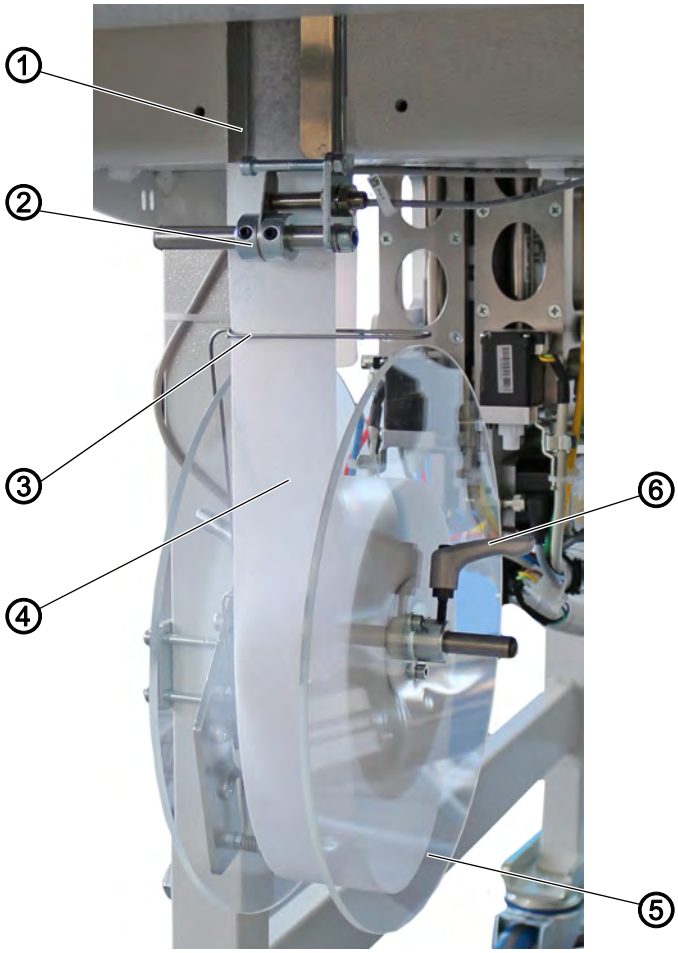
4.27.7 Tape feeder and automatic cutter

The electromotive, length-controlled tape feeder with automatic cutter transports the reinforcement strip under the pocket opening and cuts it off at the seam end.

The process is carried out during the cycle time. No further positioning and working times are required.

Inserting the reinforcement strip

Fig. 55: Tape feeder and automatic cutter (1)



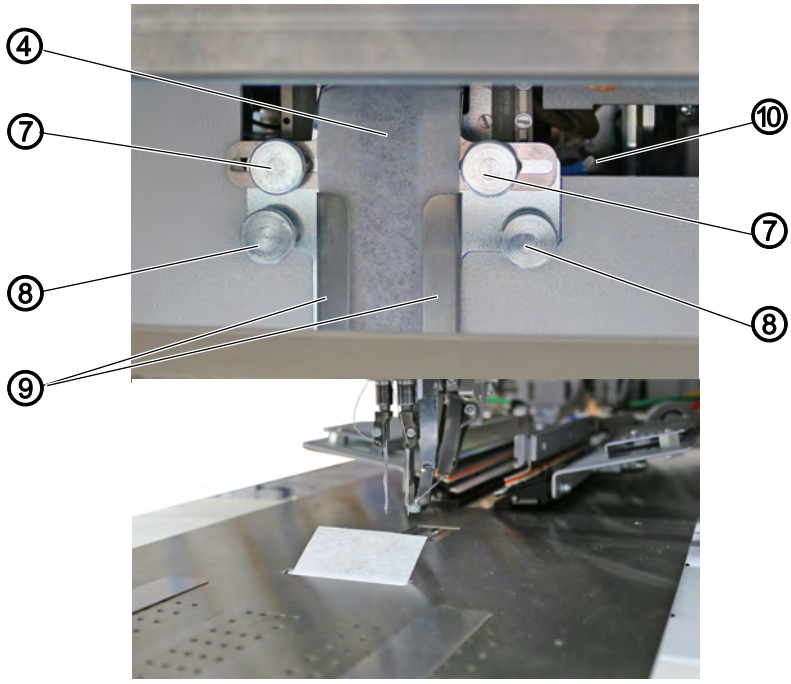
(1) - Guide
(2) - Tape monitor
(3) - Advancing device
(4) - Reinforcement strip
(5) - Washer
(6) - Locking lever

To insert the reinforcement strip:

1. Loosen the locking lever (6) and pull the washer (5) off to the side.
2. Insert the tape roll as shown above.
3. Place the washer (5) and tighten the locking lever (6).
   Ensure that the tape roll is clamped securely.
4. Feed the reinforcement strip (4) from bottom to top through the advancing device (3).

5. Insert the reinforcement strip (4) into the guide (1) behind the tape monitor (2).

Fig. 56: Tape feeder and automatic cutter (2)



(4) - Reinforcement strip
(7) - Knurled screws
(8) - Knurled screws
(9) - Guide
(10) - Hook

6. Feed the reinforcement strip (4) into the guide (9).
7. Pull down the hook (10) and the reinforcement strip (4) until the reinforcement strip (4) juts out through the cutout in the fabric sliding plate.

Information

You can use knurled screws (7) to adjust the guide (9) individually to the width of the reinforcement strip (4), while knurled screws (8) let you make a lateral adjustment of the guide (9) as a whole.

8. Switch on the machine.
9. Press the  button.

↳ The reinforcement strip (4) is cut to the correct length.

Information

The setting for the tape projection at seam beginning and seam end is made using the OP7000 control panel. `Program parameters > Automatic tape feeder` (📖 *p. 162*).

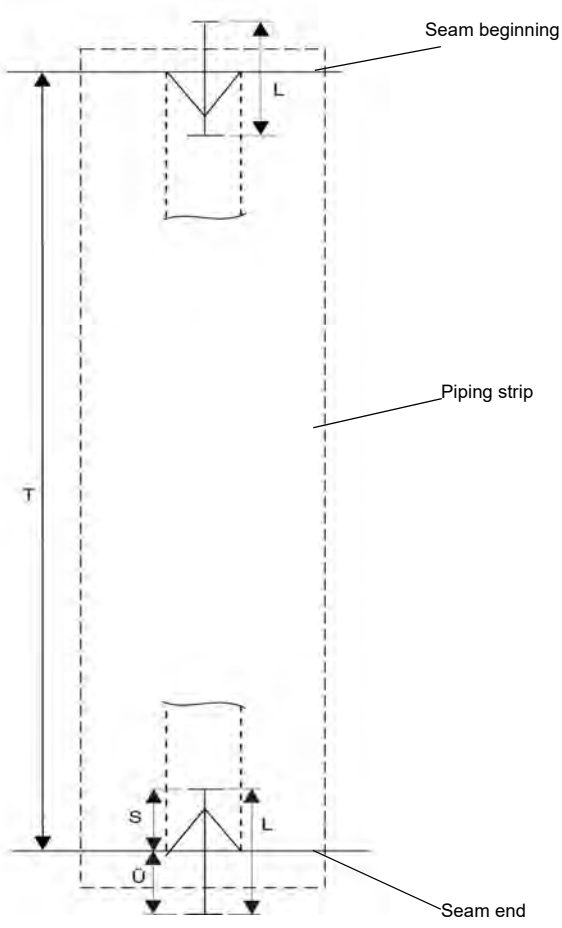
4.27.8 Automatic incision device for piping ends

With the automatic incision device for piping ends the piping strip end is cut open from the middle knife incision to the piping ends. The cutting areas are adapted to the respective seam length as well as to the positioning point.

Position of the cutting areas

The setting for the cutting position and the cutting length is made using the OP7000 control panel. `Program parameters > Adjust piping knife` (📖 *p. 181*).

Fig. 57: Position of the cutting areas



T	Pocket length
L	programmable cutting length of the piping knife
S	Cutting length within the pocket length
Ü	Cut-open piping projection

The total length **L** of a piping incision can be programmed and is preset. It can be changed as needed. The programmable value **S** indicates the length of the cut within the pocket length **T**.
The value **S** is preset and can be adjusted in the menu Adjust piping knife (📖 *p. 232*).

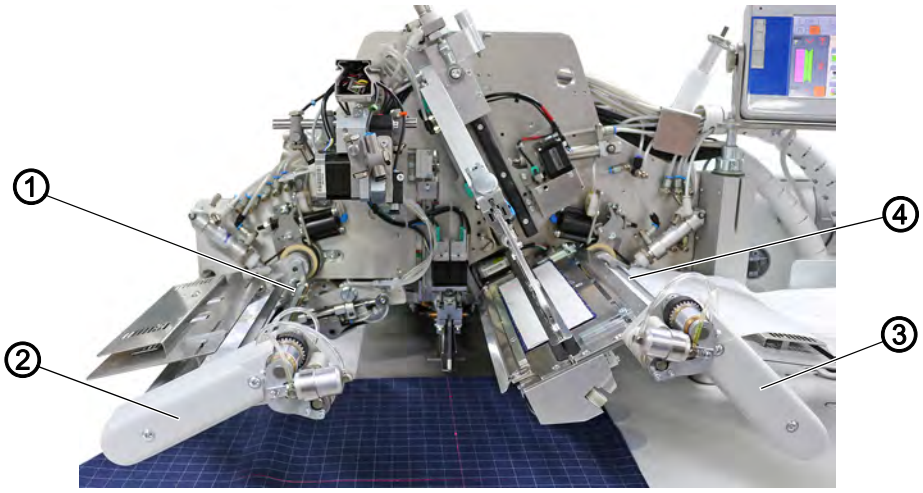
Important

The incision device for piping ends must be cleaned regularly. Depending on the material, the knives may have to be replaced as well. For a detailed description, refer to the maintenance instructions (📖 *p. 291*).

4.27.9 Feeding devices for flaps and pocket bags and/or additional parts

Thanks to these feeding devices, flap and pocket bags are positioned manually as early as during the cycle time.

Fig. 58: Feeding devices for flaps and pocket bags



(1) - Clamp left
(2) - Feeding device left
(3) - Feeding device right
(4) - Clamp right

To operate the feeding devices:

1. The settings for the feeding devices for flaps and pocket bags are made using the OP7000 control panel. `Program parameters > Program loading process > Feeder on` (📖 p. 171).

↳ The feeding device is switched on.

2. Press the right pedal forward and keep it there.

↳ Both clamps (1) and (4) of feeding devices (2) and (3) open.

3. Insert the flap or additional part into the feeding device on the left (2) and/or the right (3).
4. Release the right pedal.

↳ Clamps (1) and (4) close.

5. Press the right pedal back and keep it there.

↳ The clamp of the right feeding device (3) opens.

6. Position the flap or additional part at the stops of the feeding device (3).
7. Release the right pedal.

↳ The clamp (4) of the feeding device on the right (3) closes.

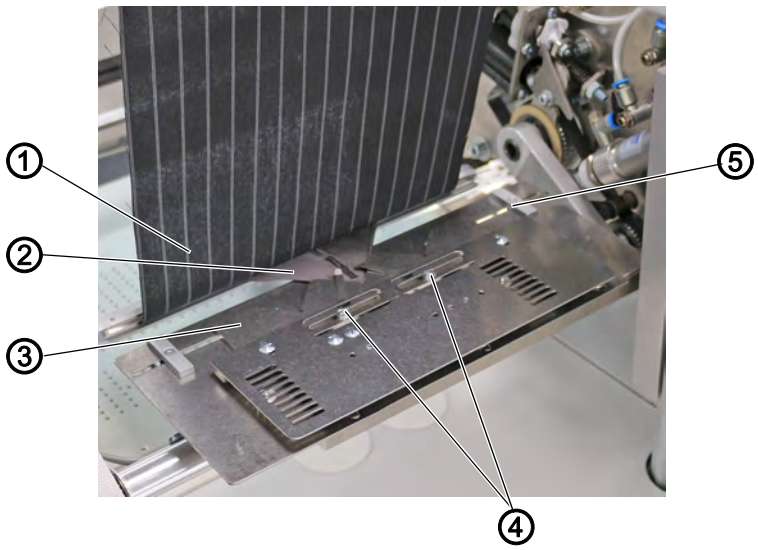
8. Press the left pedal forward.

↳ The folding process is initiated. The clamps of feeding devices (2) and (3) swivel out of the loading area and feed the flap or additional parts.

4.27.10 Shaped guide lining loop triangle

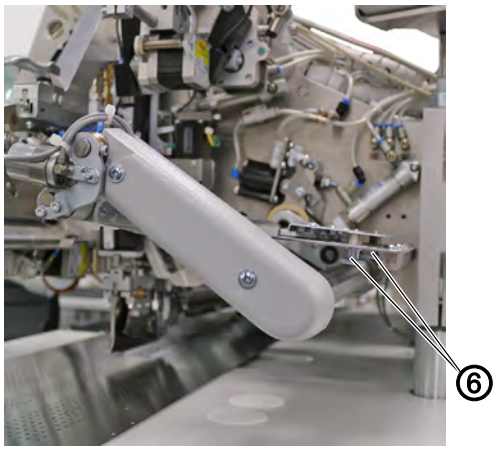
This kit is used to automatically feed the lining loop triangle along with the pocket bag when sewing inside pockets.

Fig. 59: Shaped guide lining loop triangle



(1) - Pocket bag
(2) - Lining loop triangle
(3) - Shaped guide
(4) - Screws
(5) - Stop

Fig. 60: Shaped guide lining loop triangle



(6) - Knurled screws

Adjusting the shaped guide



To set the shaped guide:

1. Loosen the screws (4).
2. Set the shaped guide (3) in sewing direction towards the middle of the pocket length.
3. Tighten the screws (4).
4. Set the sewing depth of the lining loop triangle (2) by shifting the shaped guide (3) with the help of the knurled screws (6).

5. Tighten the knurled screws (6).

Using the shaped guide



To use the shaped guide:

1. Insert the lining loop triangle (2) into the shaped guide (3).
2. Position the pocket bag (1) at stop (5) or your own positioning mark.
3. Press the right pedal backwards.

↳ The pocket bag (1) and the lining loop triangle (2) are clamped together.
Make sure the lining loop triangle (2) cannot slip.

4. Release the right pedal.
5. Press the left pedal forward.

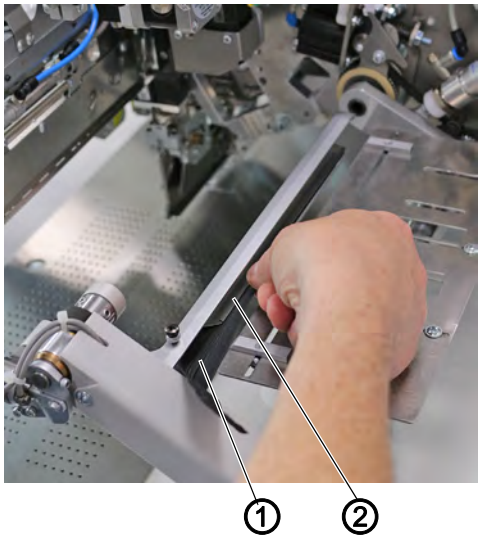
↳ The pocket bag (1) and the lining loop triangle (2) are fed.
The sewing process starts.

4.27.11 Zipper feeders

Zipper feeders are used to process zippers that must meet the following requirements:

- Cut to length
- No slider
- Total width 24 mm
- Chain width approx. 4 mm

Fig. 61: Zipper feeders



(1) - Zipper

(2) - Guide bar



To use the zipper feeder:

1. Cut the zipper (1) to the desired length.
2. Apply custom positioning marks on the rest table.
3. Push the zipper (1) into the guide bar (2) up to the positioning mark.
4. If required, position and feed a pocket bag.
5. Start sewing.

4.27.12 Downholder and pocket bag clamp

This equipment is used to safely hold hind trousers and pocket bags when the fullness caused by the dart is smoothed out.

The equipment consists of the following components:

- Downholder (1)
- Pocket bag clamp (2)

CAUTION

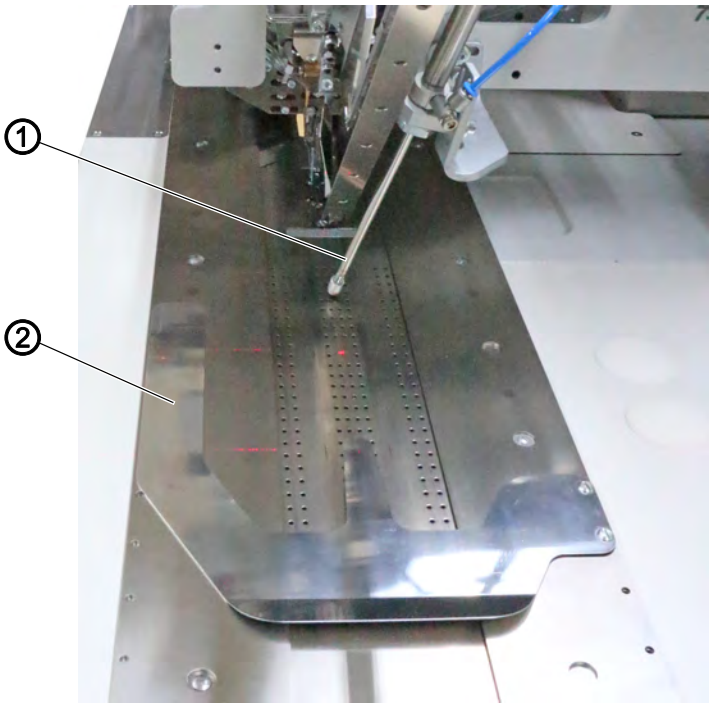


Risk of injury from moving parts!

Crushing possible.

Do NOT reach under the downholder during the positioning process.

Fig. 62: Downholder and pocket bag clamp



(1) - Downholder *(2) - Pocket bag clamp*

To operate the downholder and the pocket bag clamp:

1. Push the pocket bag under the pocket bag clamp (2) and align.
2. Position the hind trousers and align.
3. Press the left pedal forward.

↳ The downholder (1) lowers and clamps the hind trousers in their position.

4. Smooth out the clamped hind trousers laterally and to the front.

Information

The setting for the downholder - also in combination with downholder / vacuum - is made using the OP7000 control panel. *Program parameters > Program loading process > Select downholder mode* (📖 *p. 171*).

4.27.13 Waistband clamp

The waistband clamp holds the upper waistband edge of the trousers in place, thus allowing for optimal smoothing out of the fullness in the entire pocket area.

Fig. 63: Waistband clamp



(1) - Waistband clamp

To operate the waistband clamp:

1. Push the pocket bag under the pocket bag clamp.
2. Align the pocket bag.
3. Push the hind trousers under the open waistband clamp (1).
4. Align the hind trousers.
5. Press the left pedal forward.

↳ Downholder and waistband clamp (1) lower and clamp the hind trousers in their position.

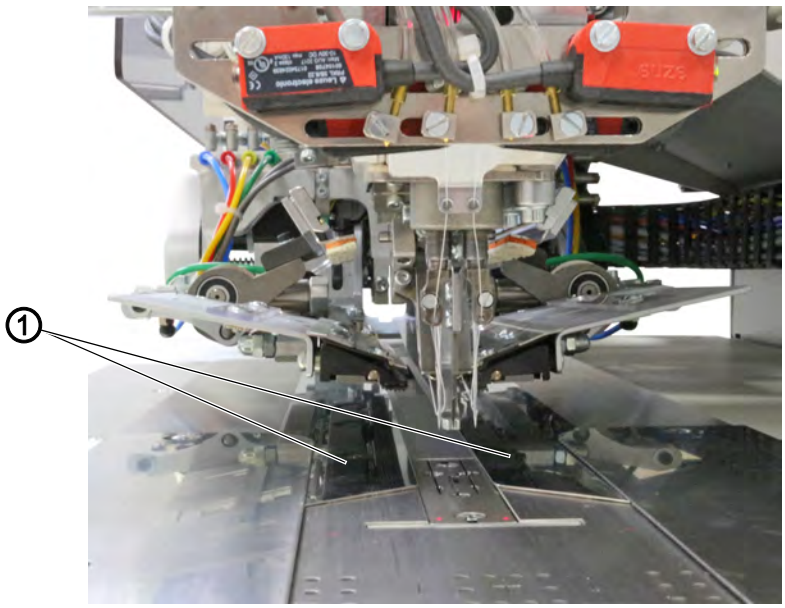
6. Smooth out the clamped hind trousers laterally and to the front.

Information

The setting for the downholder, pocket bag clamp (pneumatic) and waistband clamp - also in combination with downholder / vacuum - is made using the OP7000 control panel. `Program parameters > Program loading process > Select downholder mode` (📖 *p. 171*).

4.27.14 Shims

Fig. 64: Shims



(1) - Shims

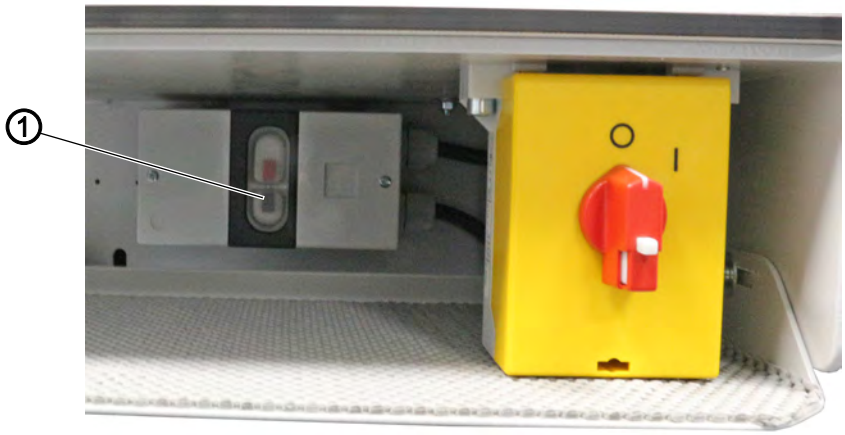
The shims kit can be used for materials that are difficult to sew or transport such as lining, viscose, leather and rubber coated fabrics.
While being fed, the sewing material is held in place by the transport clamps and the shim to keep the layers of material from shifting.

The shims can be switched on and off in the `Machine configuration` at the OP7000 control panel (📖 *p. 187*). When the shims are switched on, the corresponding icon is displayed on the start screen.

4.27.15 Vacuum device

If no in-house vacuum system is available, the vacuum device is required for an accurate positioning of the workpieces.

Fig. 65: Vacuum device



(1) - Switch

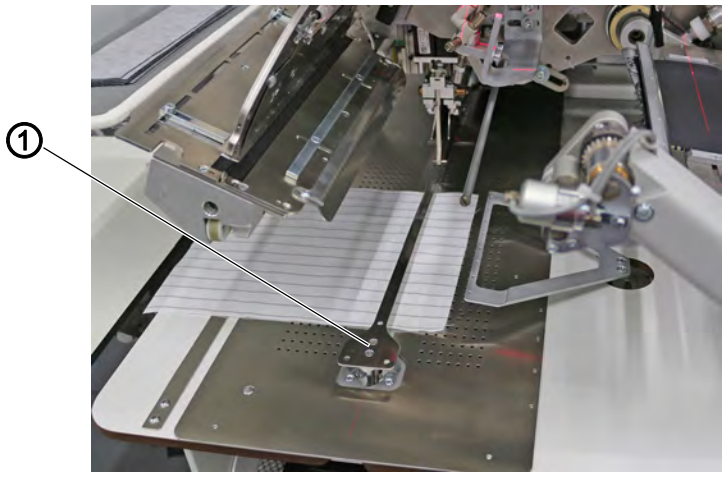
To switch on the vacuum device:

1. Switch on the switch (1) of the vacuum device.
2. Go to the menu *Program parameters > Program loading process > Switch on vacuum* to activate the vacuum (📖 *p. 171*).

4.27.16 Pneumatic pocket bag clamp: Loading from the left

The pneumatic pocket bag clamp makes it possible to load the pocket bag from the left side. You can choose from 3 different processes within the work cycle and select them in the *Program parameters* menu.

Fig. 66: Pneumatic pocket bag clamp



(1) - Pocket bag clamp

The setting for the mode of the pneumatic pocket bag clamp (1) is made using the OP7000 control panel. *Program parameters* > *Program loading process* (📖 *p. 171*).

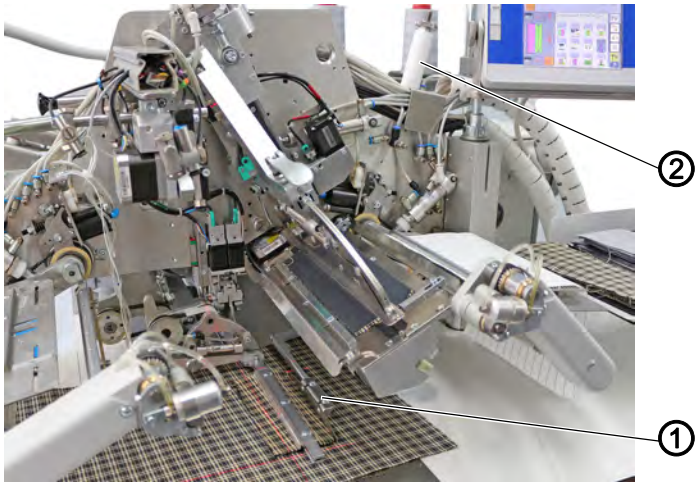
Information

The setting for the downholder, pocket bag clamp (pneumatic) and waistband clamp - also in combination with downholder / vacuum - is made using the OP7000 control panel. *Program parameters > Program loading process > Select downholder mode* (📖 *p. 171*).

4.27.17 Flap stopper (mechanical) - method F

The mechanical flap stopper ensures that the distance between the flap's outer edge and the seam always stays the same when the flap is loaded into the retracted and open turning device. The adjustment range is between 35 and 75 mm.

Fig. 67: Flap stopper (mechanical) (1)

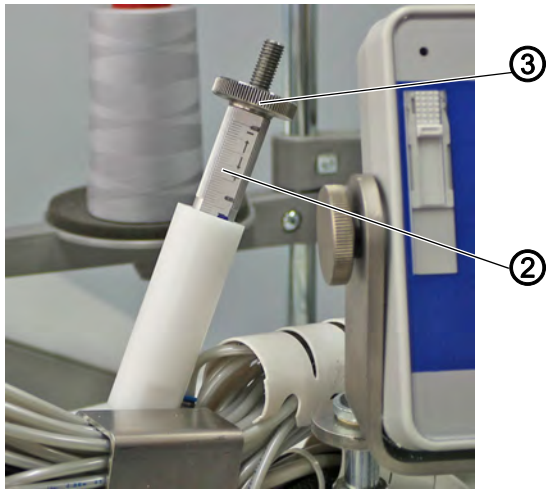


(1) - Flap stopper *(2) - Screw with scale*

To adjust the mechanical flap stopper:

1. The mechanical adjustment of the flap stopper (1) is made at the top using the screw with scale (2) when the flap stopper (1) is swiveled out.

Fig. 68: Flap stopper (mechanical) (2)



(2) - Screw with scale *(3) - Counternut*

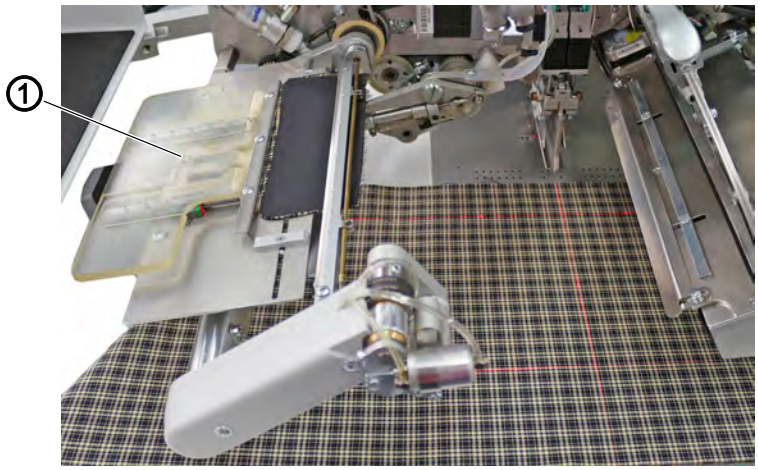
2. Swivel down the flap stopper (1).
3. Loosen the counternut (3).
4. Screw the screw with scale (2) in or out:
   screwing in:
   the stopper is moved to the right - increasing the distance for wider flaps
   screwing out:
   the stopper is moved to the left - reducing the distance for narrower flaps

5. Re-tighten the counternut (3).
6. Swivel in the flap stopper (1).
7. The setting for the mode of the mechanical flap stopper is made using the OP7000 control panel. `Program parameters` > `Pattern matching` > `Flap stopper` (📖 p. 184).

4.27.18 Flap stopper (motor-driven)

The motor-adjustable flap stopper can be used to sew a succession of pocket openings with flaps of different widths within a preset sewing sequence. The motor-driven flap stopper moves in accordance with the value previously set for the corresponding pocket opening. It can be used for flaps with a width of 30 - 75 mm.

Fig. 69: Flap stopper (motor-driven)



(1) - Flap stopper

The setting for the motor-driven flap stopper is made using the OP7000 control panel. `Program parameters` > `Program loading process` (📖 p. 171).

4.28 Sewing

4.28.1 Start sewing



To start the sewing process:

1. Press the left pedal forward.

↳ The various steps of the positioning sequence are triggered successively by actuating the left pedal several times.

2. For positioning corrections:
   - Press the pedal back.

↳ The last step of the positioning sequence is canceled. The workpiece can be positioned again.

3. Press the left pedal forward.

↳ The sewing procedure is started.

The following is a brief description of the machines' working methods:

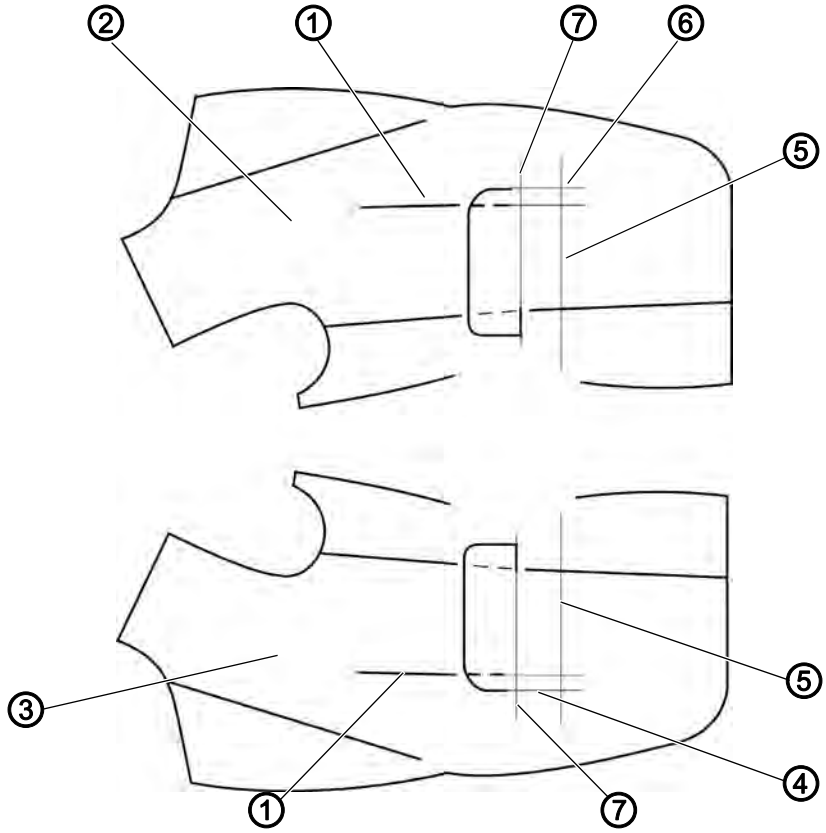
Working method	Explanation
B 📖 *p. 80*	• Piped pockets • automatic feeding of the piping strip • with/without incision of the piping ends • optional automatic feed of flap and additional parts from the right/left/both sides
F 📖 *p. 89*	• Piped pockets • automatic feed of piping strip and additional parts • automatic aligning and feed of the flap • with/without incision of the piping ends

4.28.2 Method B

Sewing pocket openings with flap in jacket front parts

Positioning points for left or right jacket front parts

Fig. 70: Sewing pocket openings with flap in jacket front parts (1)



(1) - Dart
(2) - Right jacket front part
(3) - Left jacket front part
(4) - Light spot seam end
(5) - Light spot flap's outer edge
(6) - Light spot seam beginning
(7) - Light spot middle knife incision

Important

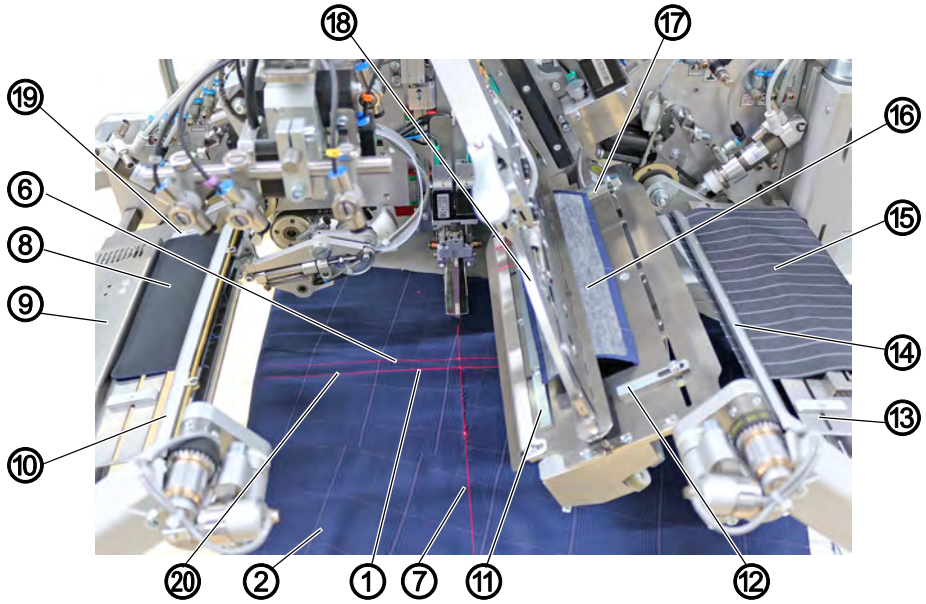
To achieve the best possible result when sewing the flap to the jacket front part, you will need to ensure a good match of stripes and checks even while preparing the sewing materials.
The alignment needed to match checks and stripes should always be made in the front to middle section of the flap relative to the jacket front part.

Information

Please note: Check and stripe material requires that you mark the flap manually.

Sewing right jacket front parts

Fig. 71: Sewing pocket openings with flap in jacket front parts (2)



(1) - Dart
(2) - Right jacket front part
(6) - Light spot seam beginning
(7) - Light spot middle knife incision
(8) - Flap
(9) - Flap stopper
(10) - Feeding device
(11) - Stop piping strip
(12) - Stop piping strip
(13) - Rest table
(14) - Feeding device
(15) - Pocket bag
(16) - Piping strip
(17) - Stop piping strip
(18) - Pick-up folder
(19) - Flap stopper
(20) - Light spot dart



To sew pocket openings with flap into right jacket front parts:

1. For a **right jacket front part**, position the piping strip (16) at stop (17).
2. Position the piping strip at stop (11).
3. Press the right pedal forward and keep it there.
   ↳ The left feeding device (10) opens.
4. Position the flap (8) at stops (9) and (19).
5. Release the right pedal.
   ↳ The left feeding device (10) closes.
6. Press the right pedal back and keep it there.
   ↳ The right feeding device (14) opens.
7. Align the pocket bag (15) with the positioning mark on the rest table (13).
8. Release the right pedal.
   ↳ The right feeding device (14) closes.
9. Position the right jacket front part (2) with the dart (1) at the light spot (20).
10. Align the pocket incision at the middle knife incision (7).

11. Press the left pedal forward.

↳ The vacuum is switched on and fixes the jacket front part in place.
The piping strip is incised and picked up by the pick-up folder (18).
The transport carriage moves to the loading position.
The transport clamps are lowered.

12. Press the left pedal forward.

↳ The pick-up folder (18) with the piping strip is lowered.
The locking plates close.
The feeding device (10) with the flap (8) and the feeding device (14) with the pocket bag (15) swivel in.

13. Press the left pedal forward.

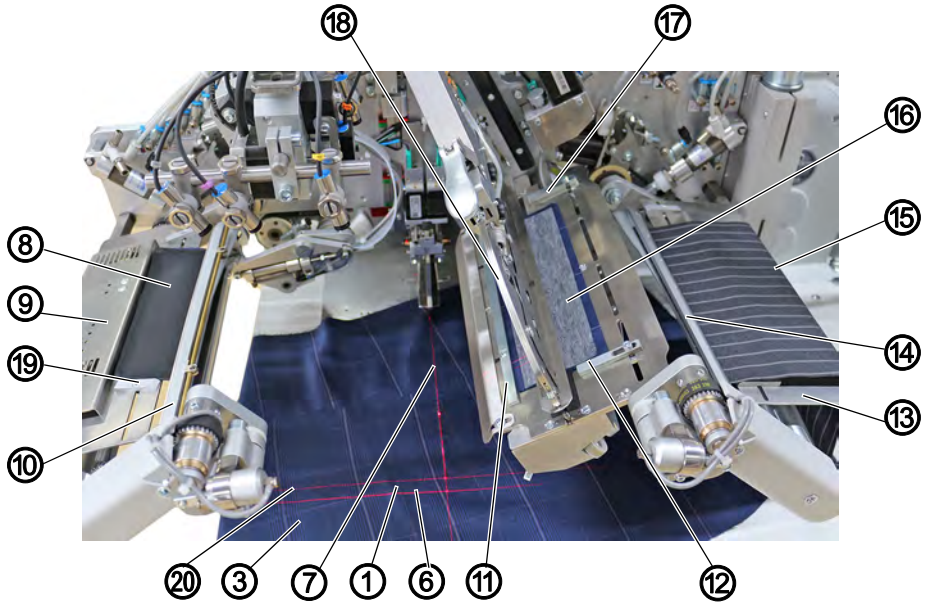
↳ The flap clamps close.
Feeding devices (10) and (14) open.

14. Press the left pedal forward.

↳ The sewing process starts.

Sewing left jacket front parts

Fig. 72: Sewing pocket openings with flap in jacket front parts (3)



(1) - Dart
(3) - Left jacket front part
(6) - Light spot seam end
(7) - Light spot middle knife incision
(8) - Flap
(9) - Flap stopper
(10) - Feeding device
(11) - Stop piping strip
(12) - Stop piping strip
(13) - Rest table
(14) - Feeding device
(15) - Pocket bag
(16) - Piping strip
(18) - Pick-up folder
(19) - Flap stopper
(20) - Light spot dart

To sew pocket openings with flap into left jacket front parts:

1. For a **left jacket front part**, position the piping strip (16) at stop (12).
2. Position the piping strip at stop (11).

3. Press the right pedal forward and keep it there.

↳ The left feeding device (10) opens.

4. Position the flap (8) at stops (9) and (19).
5. Release the right pedal.

↳ The left feeding device (10) closes.

6. Press the right pedal back and keep it there.

↳ The right feeding device (14) opens.

7. Align the pocket bag (15) with the positioning mark on the rest table (13).
8. Release the right pedal.

↳ The right feeding device (14) closes.

9. Position the left jacket front part (3) with the dart (1) at the light spot (20).
10. Align the pocket incision at the middle knife incision (7).
11. Press the left pedal forward.

↳ The vacuum is switched on and fixes the jacket front part in place.
The piping strip is incised and picked up by the pick-up folder (18).
The transport carriage moves to the loading position.
The transport clamps are lowered.

12. Press the left pedal forward.

↳ The pick-up folder (18) with the piping strip is lowered.
The locking plates close.
The feeding device (10) with the flap (8) and the feeding device (14) with the pocket bag (15) swivel in.

13. Press the left pedal forward.

↳ The flap clamps close.
Feeding devices (10) and (14) open.

14. Press the left pedal forward.

↳ The sewing process starts.

Positioning correction



To make **positioning corrections**:

1. Press the left pedal back.
   - 1st pedal tap: The flap clamps open
   - 2nd pedal tap: The feeding devices swivel back
   - 3rd pedal tap: The folding plates open, and the pick-up folder swivels back to its initial position
   - 4th pedal tap: The transport clamps lift
   - 5th pedal tap: The transport carriage returns to its waiting position

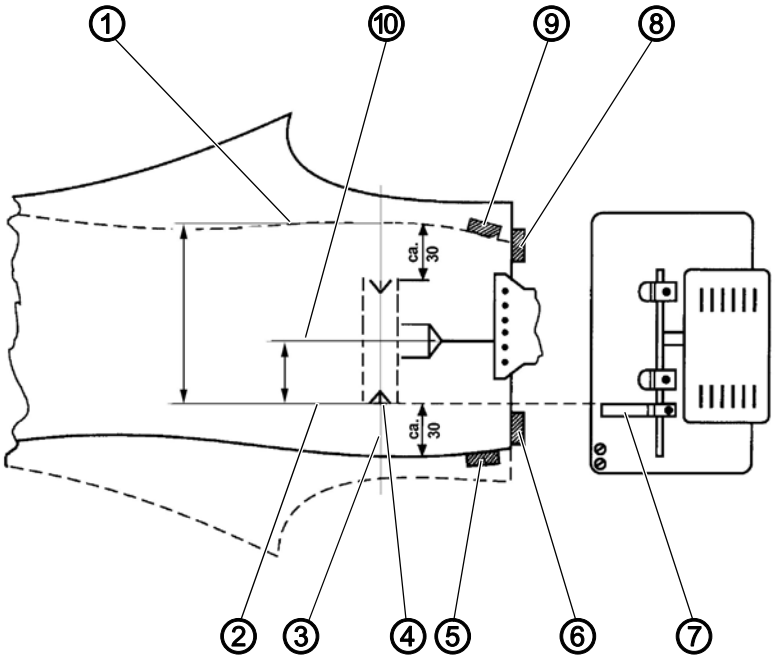
Information

Depending on the selected pedal mode (📖 *p. 178*), the loading process is completed either using inching operation or automatically.

With a press of the  button on the start screen, the previously picked-up piping strip can be released again.

Sewing pocket openings with or without flap in hind trousers

Fig. 73: Sewing pocket openings with or without flap in hind trousers (1)



(1) - Light spot
(2) - Light spot
(3) - Light spot
(4) - Pocket opening end
(5) - Positioning mark
(6) - Positioning aid
(7) - Stop
(8) - Positioning aid
(9) - Positioning mark
(10) - Light spot

Aligning the positioning aids

Hind trousers can be positioned according to 2 methods:

- **Positioning method a**: symmetrical at the central light spot (10)
- **Positioning method b**: at positioning marks (5) / (9)

The preferred option is to align the end of the pocket opening (4) at the rear light spot (2).

Position the hind trousers as close to the operator as possible. This allows for the hind trousers - once positioned - to be safely smoothed out when the transport clamps move forward.

To align the hind trousers symmetrically (**positioning method a**):

1. Align the light spot (10) such that it lines up exactly on top of the dart.

To align the hind trousers at positioning marks (5) and (9) (**positioning method B**):

1. Position the right hind trousers.

2. Attach a positioning mark (5) to the hip bow of the right hind trousers.

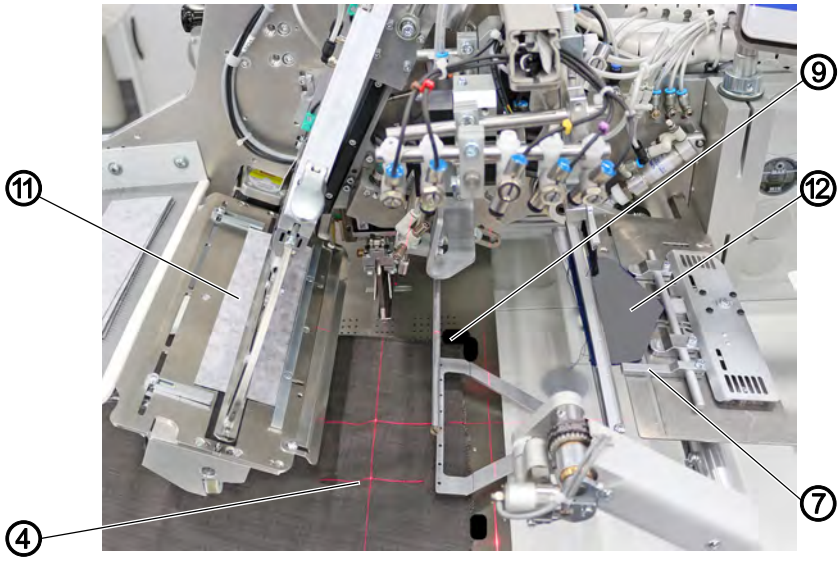
↳ The distance between hip bow and pocket opening end (4) must amount to approx. 30 mm.

OR

1. Position the left hind trousers.
2. Attach positioning mark (9).

↳ The distance between positioning mark (9) and the light spot (2) must be 30 mm + pocket length.

Fig. 74: Sewing pocket openings with or without flap in hind trousers (2)

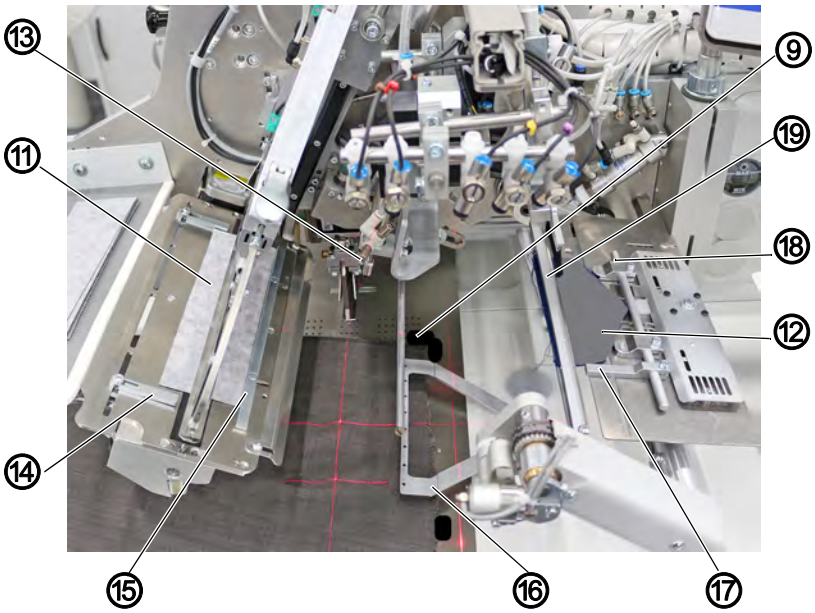


(4) - Pocket opening end
(7) - Stop piping strip
(9) - Positioning mark
(11) - Piping
(12) - Flap



3. Set the stop (7) relative to the pocket opening end (4).

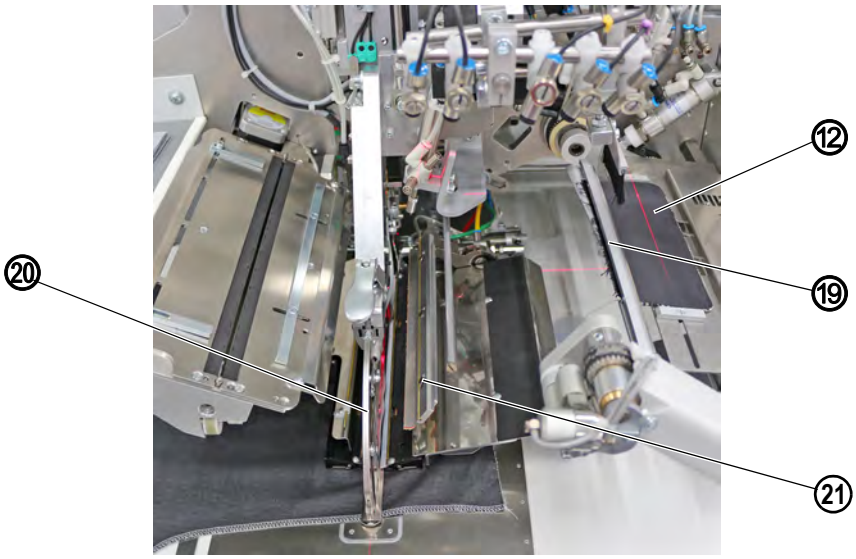
Fig. 75: Sewing pocket openings with or without flap in hind trousers (3)



(9) - Positioning mark
(11) - Piping
(12) - Flap
(13) - Downholder
(14) - Stop
(15) - Stop
(16) - Waistband clamp
(17) - Stop
(18) - Stop
(19) - Feeding device

4. Position the piping strip at lateral stops (14) and (15).
5. Press the right pedal back and keep it there.
   ↳ The feeding device (19) opens.
6. Position the flap (12) at stops (17) and (18).
7. Release the right pedal.
   ↳ The feeding device (19) closes.
8. Align the hind trousers according to **positioning method a** or **positioning method b** (📖 *p. 85*).
9. Press the left pedal forward.
   ↳ Downholder (13) and waistband clamp (16) lower and clamp the hind trousers in their position.
10. Smooth out the clamped hind trousers laterally and to the front.
11. Press the left pedal forward.
    ↳ The vacuum is switched on.
12. Press the left pedal forward.
    ↳ The piping (11) is incised and picked up.
    The transport carriage moves to the loading position.
    The transport clamps are lowered.

Fig. 76: Sewing pocket openings with or without flap in hind trousers (4)



(12) - Flap
(19) - Feeding device
(20) - Pick-up folder
(21) - Flap clamp

13. Press the left pedal forward.

↳ The pick-up folder (20) with the piping strip is lowered onto the hind trousers.
The folding plates close.

14. Press the left pedal forward.

↳ The feeding device (19) with the flap (12) swivels in.

15. Press the left pedal forward.

↳ The flap clamp (21) closes.
The sewing process starts.

Positioning correction

To make **positioning corrections**:

1. Press the left pedal back.
   - 1st pedal tap: The flap clamp opens
   - 2nd pedal tap: The feeding device swivels back
   - 3rd pedal tap: The folding plates open, and the pick-up folder swivels back to its initial position
   - 4th pedal tap: The transport clamps lift
   - 5th pedal tap: The transport carriage returns to its waiting position

Information

Depending on the selected pedal mode (🕮 *p. 178*), the loading process is completed either using inching operation or automatically.

With a press of the  button on the start screen, the previously picked-up piping strip can be released again.

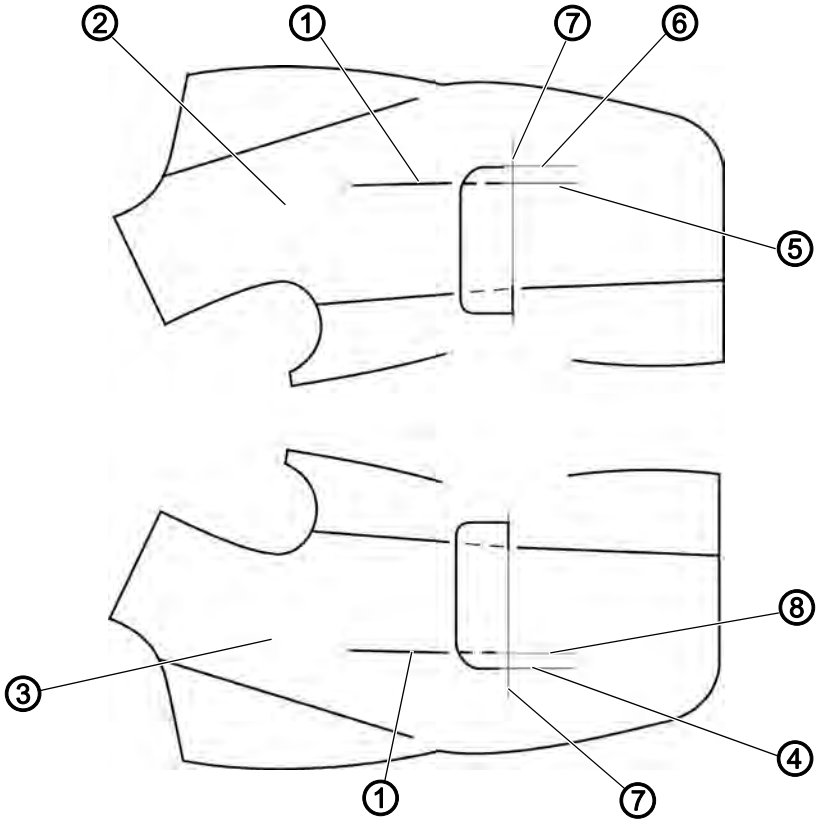
4.28.3 Method F

Working method F allows for the alignment of the flap as per the pattern. This eliminates the need to mark the flap manually.

You switch on method F at the OP7000 control panel.
`Program parameters > Pattern matching` (📖 *p. 184*).

Positioning points for left or right jacket front parts

Fig. 77: Sewing pocket openings with flap in jacket front parts (1)



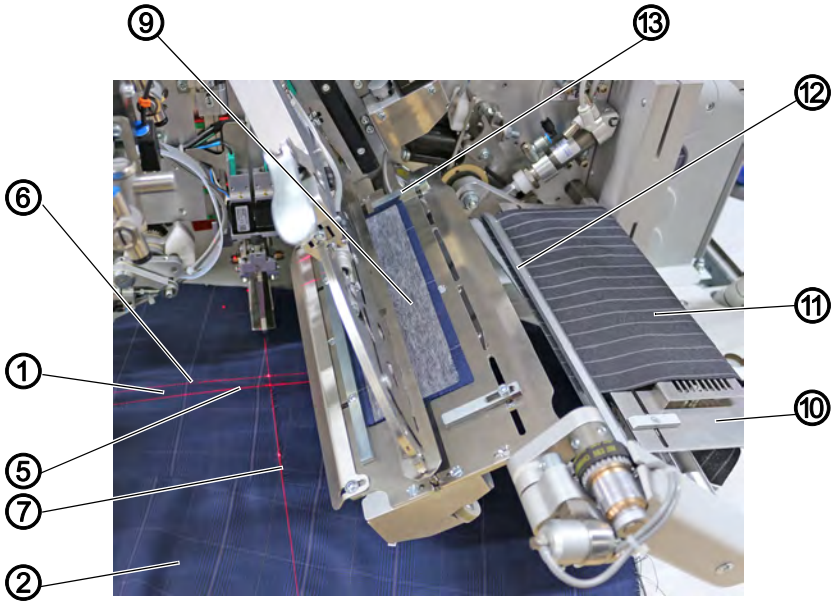
(1) - Dart
(2) - Right jacket front part
(3) - Left jacket front part
(4) - Light spot seam end
(5) - Light spot dart position
(6) - Light spot seam beginning
(7) - Light spot middle knife incision
(8) - Light spot dart position

Important

To achieve the best possible result when sewing the flap to the jacket front part, you will need to ensure a good match of stripes and checks even while preparing the sewing materials.
The alignment needed to match checks and stripes should always be made in the front to middle section of the flap relative to the jacket front part.

Sewing right jacket front parts

Fig. 78: Sewing pocket openings with flap in jacket front parts (2)

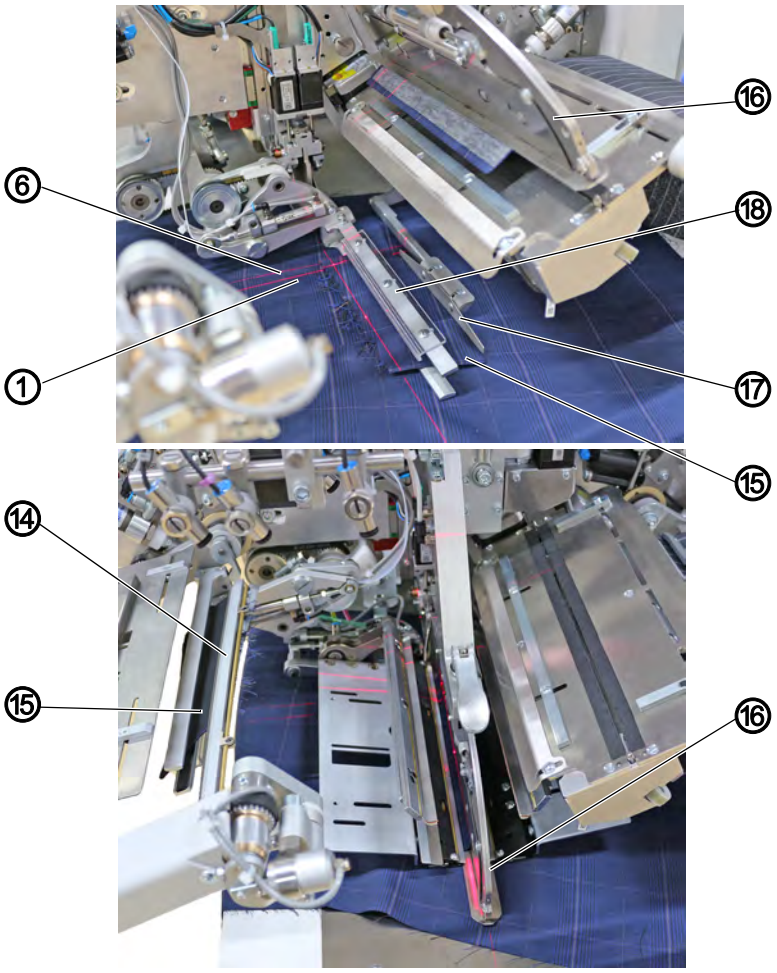


(1) - Dart
(2) - right jacket front part
(5) - Light spot dart position
(6) - Light spot seam beginning
(7) - Light spot middle knife incision
(9) - Piping strip
(10) - Rest table
(11) - Pocket bag
(12) - Feeding device
(13) - Stop

To sew pocket openings with flap into right jacket front parts:

1. For a **right jacket front part**, position the piping strip (9) at stop (13).
2. Position the piping strip (9) at the lateral stop.
3. Press the right pedal back and keep it there.
   ↳ The feeding device (12) for the pocket bag (11) opens.
4. Align the pocket bag (11) with the positioning mark on the rest table (10).
5. Release the right pedal.
   ↳ The feeding device (12) closes.
6. Position the right jacket front part (2) with the dart (1) at the light spot (5).
7. Align the pocket incision at the light spot (7) (middle knife incision).
8. Press the left pedal forward.
   ↳ The vacuum is switched on.

Fig. 79: Sewing pocket openings with flap in jacket front parts (3)



(1) - Dart
(6) - Light spot seam beginning
(14) - Feeding device
(15) - Flap
(16) - Pick-up folder
(17) - Flap stopper
(18) - Turning device

9. Press the left pedal forward.

↳ The turning device (18) swivels into the alignment area and opens the flap clamping bar, while the flap stopper (17) is lowered.

10. Insert the flap (15) into the flap clamping bar.
11. Pull the front edge of the flap (15) up to the light spot (6). Make sure that the lateral edge of the flap (15) abuts on the flap stopper (17).
12. Press the left pedal forward.

↳ The flap clamping bar closes and fixes the flap in place (15).

13. Press the right pedal backwards.

↳ The vacuum is switched off.

14. Use both hands to manually align the jacket front part under the clamped flap exactly as per the pattern.

15. Press the right pedal forward.

↳ The vacuum is switched on to fix the jacket front part in place.

16. Press the left pedal forward.

↳ The flap turning device swivels up and turns the flap (15).
The feeding device (14) grasps the flap (15) and clamps it.
The transport carriage moves to the loading position.
The transport clamps are lowered.

17. Press the left pedal forward.

↳ Holding the picked-up and incised piping strip, the pick-up folder (16) swivels into the vertical position and lowers the jacket front part.
The folding plates close.

18. Press the left pedal forward.

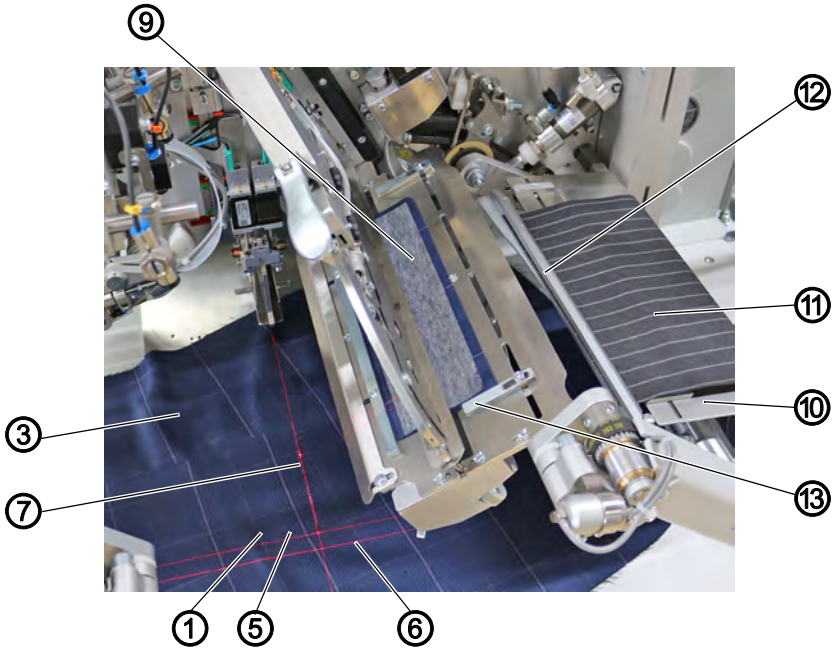
↳ The feeding device (14) with the flap (15) swivels in.
The feeding device (12) holding the pocket bag (11) swivels in.
The flap clamps on the transport clamps close.

19. Press the left pedal forward.

↳ The sewing process starts.

Sewing left jacket front parts

Fig. 80: Sewing pocket openings with flap in jacket front parts (4)



(1) - Dart
(3) - Left jacket front part
(5) - Light spot dart position
(6) - Light spot seam end
(7) - Light spot middle knife incision
(9) - Piping strip
(10) - Rest table
(11) - Pocket bag
(12) - Feeding device
(13) - Stop



To sew pocket openings with flap into left jacket front parts:

1. For a **left jacket front part**, position the piping strip (9) at stop (13).
2. Position the piping strip (9) at the lateral stop.
3. Press the right pedal back and keep it there.

↳ The feeding device (12) for the pocket bag (11) opens.

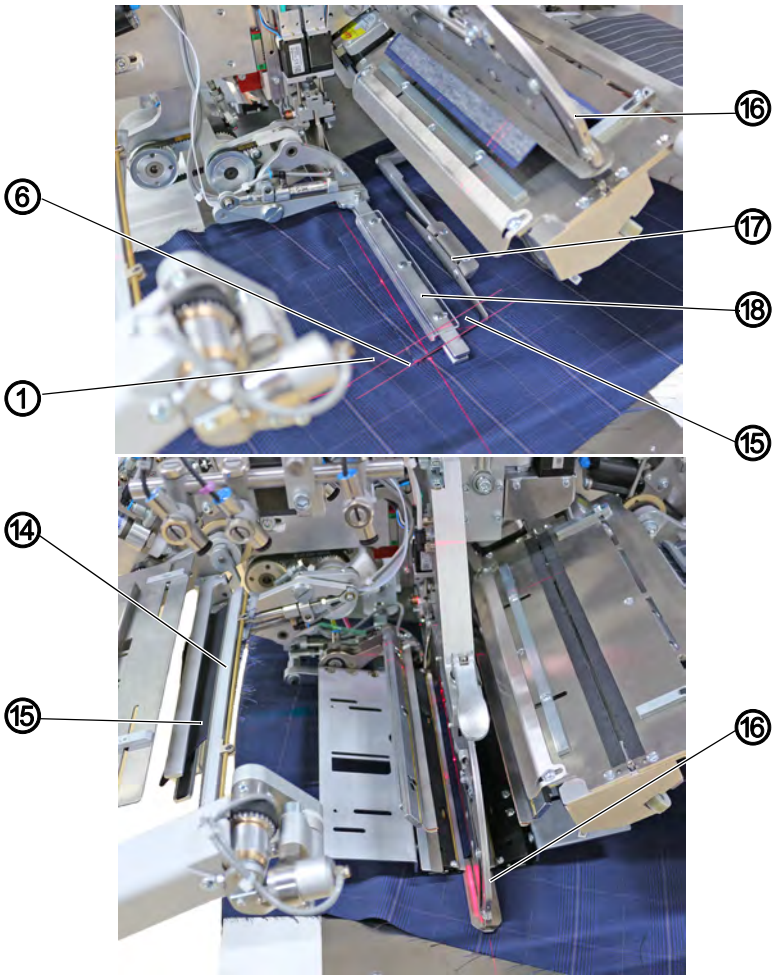
4. Align the pocket bag (11) with the positioning mark on the rest table (10).
5. Release the right pedal.

↳ The feeding device (12) closes.

6. Position the left jacket front part (3) with the dart (1) at the light spot (5).
7. Align the pocket incision at the light spot (7) (middle knife incision).
8. Press the left pedal forward.

↳ The vacuum is switched on.

Fig. 81: Sewing pocket openings with flap in jacket front parts (5)



(1) - Dart
(6) - Light spot seam end
(14) - Feeding device
(15) - Flap
(16) - Pick-up folder
(17) - Flap stopper
(18) - Turning device

9. Press the left pedal forward.

↳ The turning device (18) swivels into the alignment area and opens the flap clamping bar, while the flap stopper (17) is lowered.

10. Insert the flap (15) into the flap clamping bar.
11. Pull the rear edge of the flap (15) up to the light spot (6). Make sure that the lateral edge of the flap (15) abuts on the flap stopper (17).
12. Press the left pedal forward.

↳ The flap clamping bar closes and fixes the flap in place (15).

13. Press the right pedal backwards.

↳ The vacuum is switched off.

14. Use both hands to manually align the jacket front part under the clamped flap (15) exactly as per the pattern.

15. Press the right pedal forward.

↳ The vacuum is switched on to fix the jacket front part in place.

16. Press the left pedal forward.

↳ The flap turning device swivels up and turns the flap (15).
The feeding device (14) grasps the flap (15) and clamps it.
The transport carriage moves to the loading position.
The transport clamps are lowered.

17. Press the left pedal forward.

↳ Holding the picked-up and incised piping strip, the pick-up folder (16) swivels into the vertical position and lowers the jacket front part.
The folding plates close.

18. Press the left pedal forward.

↳ The feeding device (14) with the flap (15) swivels in.
The feeding device (12) holding the pocket bag (11) swivels in.
The flap clamps on the transport clamps close.

19. Press the left pedal forward.

↳ The sewing process starts.

Positioning correction



To make **positioning corrections**:

1. Press the left pedal back.
   - 1st pedal tap: The flap clamps open
   - 2nd pedal tap: The feeding devices swivel back
   - 3rd pedal tap: The folding plates open, and the pick-up folder swivels back to its initial position
   - 4th pedal tap: The transport clamps lift
   - 5th pedal tap: The transport carriage returns to its waiting position



Information

Any visible offset of checks / stripes after the flap has been pulled through the respective jacket front part can be compensated by making adjustments at the control panel.

You adjust the stripe correction at the control panel OP7000.
Program parameters > Pattern matching (📖 *p. 56* and 📖 *p. 184*)

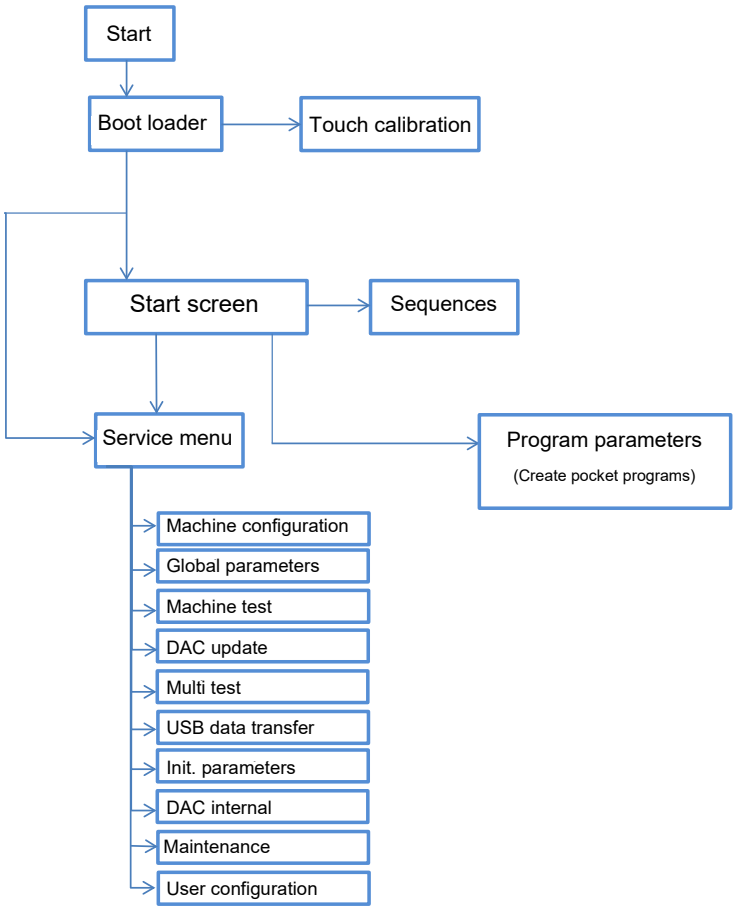
Information

Depending on the selected pedal mode (📖 *p. 178*), the loading process is completed either using inching operation or automatically.

With a press of the  button on the start screen, the previously picked-up piping strip can be released again.

5 Programming

Structure of the software



Software quick access

The numbering of the software quick access corresponds to the numbering on the display of the OP7000.

Menu item	Option/described on page
1.0 Machine configuration	
1.1 Select working method	🕮 *p. 190*
1.3 Select needle distance	🕮 *p. 191*
Needle transport On/Off (756 A only)	🕮 *p. 188*
Programmable marking lamps On/Off	🕮 *p. 188*
Pocket bag clamp On/Off	🕮 *p. 188*
Hook thread monitor On/Off	🕮 *p. 188*
QONDAC On/Off	🕮 *p. 188*

Menu item	Option/described on page
Feeding device On/Off	🕮 p. 188
Tape feeder On/Off	🕮 p. 188
Vacuum On/Off	🕮 p. 188
Downholder On/Off	🕮 p. 188
1.13 Select stacker/smoother	🕮 p. 188
Piping knife On/Off	🕮 p. 188
Roll-off On/Off	🕮 p. 189
1.17 Select flap clamps	🕮 p. 189
1.18 Light barrier scan	🕮 p. 193
Waistband clamp On/Off	🕮 p. 189
1.20 Transport clamp adjustment	🕮 p. 189
1.22 Select corner knife device	🕮 p. 189
1.23 Select pedal operation	🕮 p. 194
Programmable guiding plates and folder height On/Off	🕮 p. 189
1.25 Toolbox configuration	🕮 p. 195
Uninterrupted power supply On/Off	🕮 p. 189
Select transport clamp type	🕮 p. 190
Shims On/Off	🕮 p. 190
Adjustable transport clamp pressure On/Off	🕮 p. 190
2.0 Machine test	
2.1 Adjust and test hook thread monitor	🕮 p. 207
2.2 Test roll-off device	🕮 p. 208
2.3 Adjust and align light barriers	🕮 p. 209
2.4 Test corner knife position	🕮 p. 211
Adjust corner knife angle seam begin./seam end	🕮 p. 213
2.4.1 Adjust corner knife	🕮 p. 214
Adjust offset angle seam begin./seam end	🕮 p. 215
2.5 Adjust and test sewing motor	🕮 p. 217
Switch split needle bar On/Off	🕮 p. 217

Menu item	Option/described on page
2.5.1 Adjust sewing motor	🕮 *p. 218*
Adjust sewing motor position	🕮 *p. 218*
Adjust the maximum sewing motor speed	🕮 *p. 218*
2.5.2 Adjust sewing motor speed	🕮 *p. 217*
2.6 Test tape feeder	🕮 *p. 205*
2.7 Machine workflow test	🕮 *p. 219*
Loading process test	🕮 *p. 220*
Test step by step	🕮 *p. 221*
Test cycle time	🕮 *p. 222*
Test turning device	🕮 *p. 223*
2.8 Test stepper motor	🕮 *p. 225*
2.10 Test piping knife	🕮 *p. 231*
2.10.1 Adjust piping knife	🕮 *p. 232*
2.11 Adjust and test needle transport	🕮 *p. 233*
2.11.1 Adjust needle transport	🕮 *p. 232*
2.12 Test pick-up folder	🕮 *p. 235*
2.12.1 Folder adjustment	🕮 *p. 236*
Adjust and testing control panel	🕮 *p. 227*
2.13 Test middle knife	🕮 *p. 237*
2.13.1 Adjust middle knife	🕮 *p. 238*
2.14 Test programmable marking lamps	🕮 *p. 240*
2.14.1 Adjust programmable marking lamps (lengthwise)	🕮 *p. 242*
2.14.2 Adjust programmable marking lamps (crosswise)	🕮 *p. 244*
2.15 Test transport clamp	🕮 *p. 245*
2.15.1 Adjust transport clamp	🕮 *p. 246*
2.16 USB logger	🕮 *p. 206*
2.17 Test guiding plates	🕮 *p. 248*
2.17.1 Adjust guiding plates	🕮 *p. 249*
2.18 Test turning device	🕮 *p. 250*
2.18.1 Adjust turning device	🕮 *p. 251*

Menu item	Option/described on page
3.0 Multi test	
3.3 Internal devices	🕮 *p. 263*
3.4 External devices	🕮 *p. 265*
3.5 Input/output test	🕮 *p. 259*
3.6 Sewing drive test	🕮 *p. 267*
3.7 Error messages	🕮 *p. 258*
RAM test	🕮 *p. 264*
ROM test	🕮 *p. 266*
4.0 User configuration	
4.1 Language selection	🕮 *p. 282*
User password setup	🕮 *p. 283*
Button beep On/Off	🕮 *p. 281*
5.0 Start screen	
5.0.2 Overview of sequences	🕮 *p. 117*
5.0.2.1 Copy sequence	🕮 *p. 123*
5.0.2.0 Select source of sequence	🕮 *p. 123*
5.0.2.3 Select program	🕮 *p. 116* , 🕮 *p. 117*
Piece counter	🕮 *p. 112*
Activate automatic sequence process	🕮 *p. 126*
5.1 Program parameters	
5.1.1 Select pocket program	🕮 *p. 129*
5.1.2 Enter name of pocket program	🕮 *p. 130*
5.1.3 Copy pocket program	🕮 *p. 130*
5.1.4 Create/change seam program	🕮 *p. 132*
5.1.4.5 Adjust securement seam beginning left needle	🕮 *p. 135*
5.1.4.6 Adjust securement seam beginning right needle	🕮 *p. 136*

Menu item	Option/described on page
5.1.4.7 Adjust securement seam end left needle	🕮 *p. 136*
5.1.4.8 Adjust securement seam end right needle	🕮 *p. 137*
5.1.4.9 Select flap right/left	🕮 *p. 134*
5.1.4.10 Select positioning points	🕮 *p. 134*
5.1.4.11 Adjust stitch length main seam	🕮 *p. 134*
5.1.4.12 Activate flap	🕮 *p. 139*
5.1.5 Correction light barrier	🕮 *p. 141*
5.1.5.1 Correction seam begin.	🕮 *p. 141*
5.1.5.2 Correction seam end	🕮 *p. 141*
5.1.6 Marking lamps 1-16	🕮 *p. 143*
5.1.6.1 Activate marking lamps 1-16	🕮 *p. 144*
5.1.6.2 Adjust programmable marking lamps	🕮 *p. 145*
Adjust programmable marking lamp X-axis	🕮 *p. 145*
Adjust programmable marking lamp Y-axis	🕮 *p. 146*
5.1.7 Sewing head parameters	🕮 *p. 147*
5.1.7.1 Adjust sewing speed	🕮 *p. 147*
5.1.7.2 Adjust soft start parameters	🕮 *p. 148*
Continuous or intermittent transport	🕮 *p. 147*
5.1.7.4 Needle transport (756 A only)	🕮 *p. 150*
5.1.7.5 Seam securement	🕮 *p. 149*
5.1.7.6 Additional thread tension	🕮 *p. 147*
5.1.8 Middle knife parameters	🕮 *p. 151*
Middle knife On/Off	🕮 *p. 151*
5.1.8.2 Speed middle knife	🕮 *p. 151*
5.1.8.3 Adjust middle knife correction seam begin.	🕮 *p. 151*
5.1.8.4 Adjust middle knife correction seam end	🕮 *p. 151*
5.1.8.5 Adjust loading position	🕮 *p. 151*
Automatic speed adjustment On/Off	🕮 *p. 151*
5.1.9 Corner knife (straight pocket) Corner knife (slanted pocket, **automatic**) Corner knife (slanted pocket, **multi-functional**)	🕮 *p. 153* 🕮 *p. 155* 🕮 *p. 158*

Menu item	Option/described on page
5.1.9.2 Corner knife correction seam begin. (straight pocket)	🕮 *p. 153*
5.1.9.3 Corner knife correction seam end (straight pocket)	🕮 *p. 153*
5.1.9.8 Corner knife correction seam begin. left (slanted pocket, **automatic**) Adjust corner knife correction seam begin. left (slanted pocket, **multi-functional**)	🕮 *p. 155* 🕮 *p. 158*
5.1.9.9 Corner knife correction seam begin. right (slanted pocket, **automatic**) Corner knife correction seam begin. right (slanted pocket, **multi-functional**)	🕮 *p. 155* 🕮 *p. 158*
5.1.9.10 Corner knife correction seam end left (slanted pocket, **automatic**) Adjust corner knife correction seam end left (slanted pocket, **multi-functional**)	🕮 *p. 156* 🕮 *p. 159*
5.1.9.11 Corner knife correction seam end right (slanted pocket, **automatic**) Corner knife correction seam end right (slanted pocket, **multi-functional**)	🕮 *p. 156* 🕮 *p. 159*
5.1.9.12 Corner knife angle correction seam begin. left (slanted pocket, **multi-functional**)	🕮 *p. 158*
5.1.9.13 Corner knife angle correction seam begin. right (slanted pocket, **multi-functional**)	🕮 *p. 158*
5.1.9.14 Corner knife angle correction seam end left (slanted pocket, **multi-functional**)	🕮 *p. 159*
5.1.9.15 Corner knife angle correction seam end right (slanted pocket, **multi-functional**)	🕮 *p. 159*
5.1.10 Automatic tape feeder	🕮 *p. 162*
5.1.10.2 Adjust length of tape at seam begin.	🕮 *p. 162*
5.1.10.3 Adjust length of tape at seam end	🕮 *p. 162*
5.1.10.4 Adjust clamp speed while transport	🕮 *p. 162*
5.1.11 Transport clamp	🕮 *p. 163*
5.1.11.1 Adjust return speed	🕮 *p. 163*
5.1.11.2 Adjust insertion speed	🕮 *p. 163*
5.1.11.3 Softstart for insertion speed	🕮 *p. 163*
5.1.11.4 Return of transport clamp	🕮 *p. 164*
5.1.11.5 Waiting position of transport clamp	🕮 *p. 165*
5.1.12 Process of transport clamp	🕮 *p. 166*
5.1.12.2 Select process of transport clamp	🕮 *p. 168*

Menu item	Option/described on page
5.1.12.3 Select piping type	🕮 *p. 169*
5.1.12.4 Spread transport clamp	🕮 *p. 170*
5.1.12.7 Adjust transport clamp pressure	🕮 *p. 166*
5.1.13 Program loading process	🕮 *p. 171*
5.1.13.1 Select flap clamps	🕮 *p. 171*
Vacuum On/Off	🕮 *p. 171*
Downholder On/Off	🕮 *p. 171*
5.1.13.4 Select downholder mode	🕮 *p. 173*
Waistband clamp On/Off	🕮 *p. 171*
5.1.13.6 Select pocket bag clamp mode	🕮 *p. 172*
5.1.13.7 Select blowing mode	🕮 *p. 175*
Breast welt mode On/Off	🕮 *p. 172*
5.1.13.10 Select pedal mode	🕮 *p. 178*
5.1.15 Stacker/smoother/blow-off/roll-off	🕮 *p. 179*
Stacker On/Off	🕮 *p. 179*
5.1.15.1 Select clamping time	🕮 *p. 179*
Smoother On/Off	🕮 *p. 179*
Adjust smoother: Start after corner cut	🕮 *p. 179*
5.1.15.3 Adjust duration of grip stacker signal	🕮 *p. 179*
5.1.15.4 Lift transport clamp after corner cut	🕮 *p. 179*
Blow-off On/Off	🕮 *p. 179*
5.1.15.11 Adjust blow-off time	🕮 *p. 179*
Roll-off On/Off	🕮 *p. 179*
5.1.15.6 Roll-off: Time after corner cut	🕮 *p. 180*
5.1.15.7 Time after roll-off until lift-up	🕮 *p. 180*
5.1.15.8 Roll-off Time	🕮 *p. 180*
5.1.15.9 Roll-off Speed	🕮 *p. 180*
5.1.17 Adjust guiding plates and folder	🕮 *p. 182*
5.1.18 Pattern matching	🕮 *p. 184*
5.1.20 Adjust piping knife	🕮 *p. 181*

Menu item	Option/described on page
5.2 Global parameters	
5.2.1 Adjust positioning point seam begin./center/end	🕮 *p. 198*
5.2.2 Adjust transport clamp	🕮 *p. 200*
Lower transport clamp automatically On/Off	🕮 *p. 200*
5.2.2.2 Clamp down: Time until next action	🕮 *p. 200*
5.2.2.3 Speed to corner knife position	🕮 *p. 200*
5.2.2.4 Speed to waiting position	🕮 *p. 200*
5.2.2.6 Delay till clamp moves to seam begin.	🕮 *p. 200*
Automatic transport clamp return On/Off	🕮 *p. 200*
5.2.3 Adjust needle thread-clamp/-catcher/-tension	🕮 *p. 201*
5.2.3.1 Time: Thread clamp open	🕮 *p. 201*
5.2.3.2 Seam end: mm till thread clamp opens	🕮 *p. 201*
5.2.3.3 mm with needle thread catcher open	🕮 *p. 201*
Adjust corner knife distance	🕮 *p. 198*
5.2.6 Adjust corner knife	🕮 *p. 198*
5.2.6.1 Duration of corner knife On	🕮 *p. 198*
5.2.7 Maximum hook thread counter	🕮 *p. 198*
5.2.8 Adjust guiding plates and folder height	🕮 *p. 202*
Needle thread monitor On/Off	🕮 *p. 198*
Select flap clamp feeding mode	🕮 *p. 198*
Transport clamp quick adjustment	🕮 *p. 199*
5.2.11 Adjust machine process speed	🕮 *p. 199*
5.2.18 Adjust password protection	🕮 *p. 203*
Adjust counting direction of piece counter UP/DOWN	🕮 *p. 199*
Knitwear mode On/Off	🕮 *p. 199*
6.0 DAC internal	For DA staff only
7.0 DAC update	🕮 *p. 254*

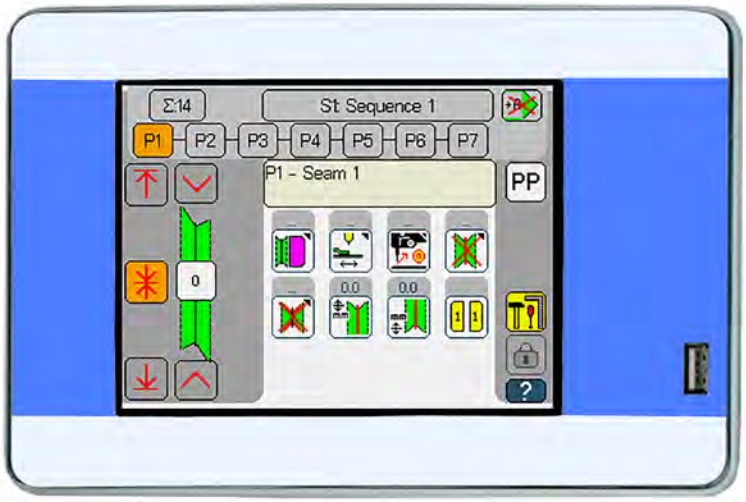
Menu item	Option/described on page
8.0 USB data transfer	
8.1 Data transfer to USB	🕮 *p. 270*
8.2 Data transfer from USB	🕮 *p. 273*
9.0 Init. parameters	
Initialize machine configuration	🕮 *p. 276*
Initialize global parameters	🕮 *p. 276*
Initialize all seam programs	🕮 *p. 276*
Initialize all sequences	🕮 *p. 276*
Initialize RAM	🕮 *p. 276*
10.0 Maintenance	
10.3 Display software version	🕮 *p. 279*
10.4 Enter date and time	🕮 *p. 280*
Internal information (password-protected) (for DA staff only)	
Updating the machine software	🕮 *p. 285*

Control panel OP7000

All settings for the machine are performed using the OP7000 control panel.

The activation of the sewing motor and the stepper motors is performed by the DAC comfort control in conjunction with the OP7000 control panel with the user interface in symbolic representation.

Fig. 82: Control panel OP7000



Switching on the machine

After the machine has been switched on, the control and the OP7000 control panel will start up. Next, the machine prompts the user to start the reference run on the control panel.

The user must enable the machine for use after the display of the welcome message goes out. Follow the instructions shown on the display for this purpose:

To switch on the machine:

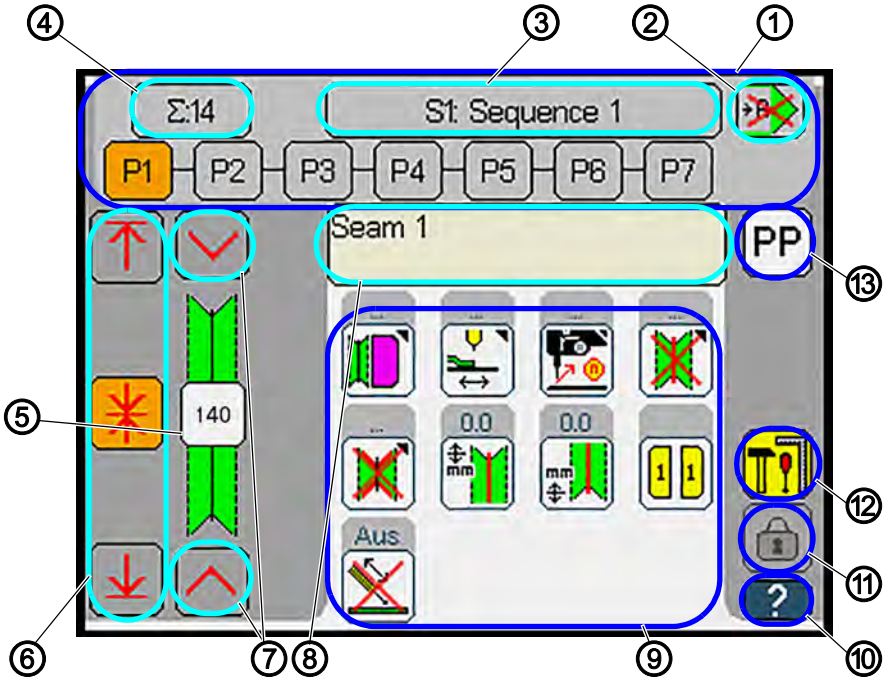
1. Press the pedal.

↳ The control panel is enabled.

Basic operation

The menu items of the software are numbered. For a quick overview, refer to the table included in the chapter **Software quick access** (📖 *p. 97*).

Fig. 83: Basic operation



(1) - Pocket programs in sequence
(2) - Automatic seam sequence
(3) - Overview of seam sequences
(4) - Piece counter
(5) - Seam pattern
(6) - Positioning points
(7) - Quick selection corner knife correction
(8) - Info field
(9) - Toolbox
(10) - Help
(11) - User password
(12) - Service menu
(13) - Program parameters

The control panel is controlled via a touch pad. The start screen is divided into the areas below:

No.	Control panel	Description	
①		Display of pocket programs in sequence	
②		Automatic seam sequence ON/OFF	📖 *p. 126*
③		Editing a seam sequence	📖 *p. 113*
④		Piece counter	📖 *p. 112*

No.	Control panel	Description	
⑤		Display of selected seam pattern • the display changes with the setting of the pocket program (with/without flap).	
⑥		Positioning point seam begin. Positioning point seam center Positioning point seam end	📖 p. 134
⑦		Quick selection corner knife correction seam begin. Quick selection corner knife correction seam end	📖 p. 153 📖 p. 153
⑧		Info field displaying current status information / program name	
⑨		Toolbox	📖 p. 195
⑩		Help	📖 p. 108
⑪		User password	📖 p. 283
⑫		Service menu	📖 p. 186
⑬		Program parameters • Configuring pocket programs	📖 p. 127

Important

Some settings via software are protected with a password. Password-protected settings are used to set up the basic machine configuration and may only be adjusted by qualified personnel.

The password is 25483.

Displaying Help

To display Help:

1. Press the **Help**  button.

↳ The button is highlighted with a red circle  .

2. Press the desired button for which you wish to display a Help text.

↳ The selected button and a Help text are displayed.

3. Press on the Help text.

↳ The Help text disappears.

Information

To activate Help permanently, press and hold the **Help** button for approx. 3 seconds. The button is highlighted with a red circle and dots on the side.

↳ Help is activated permanently. A Help text is displayed for every button you press.

Press the **Help** button again to deactivate this mode.

Help is deactivated automatically when the user exits the menu level.

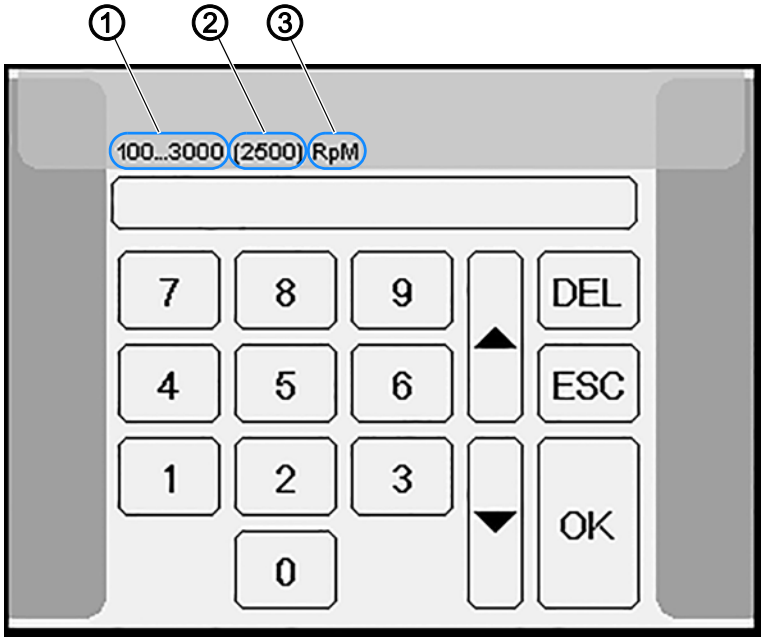
Home button and Return button

Many menus allow the user to exit with a press of the **Home button** or the **Return button**.

Button	Function
	Home button • saves the settings in the menu • Return to the start screen
	Return button • saves the settings in the menu • Return to next higher menu level

Entering values using the numeric keypad

Fig. 84: Entering values using the numeric keypad



(1) - Value range
(2) - Preset value
(3) - Unit

To enter values using the numeric keypad:

1. Enter the desired value.
2. Confirm with **OK**.

To enter a negative value on the numeric keypad:

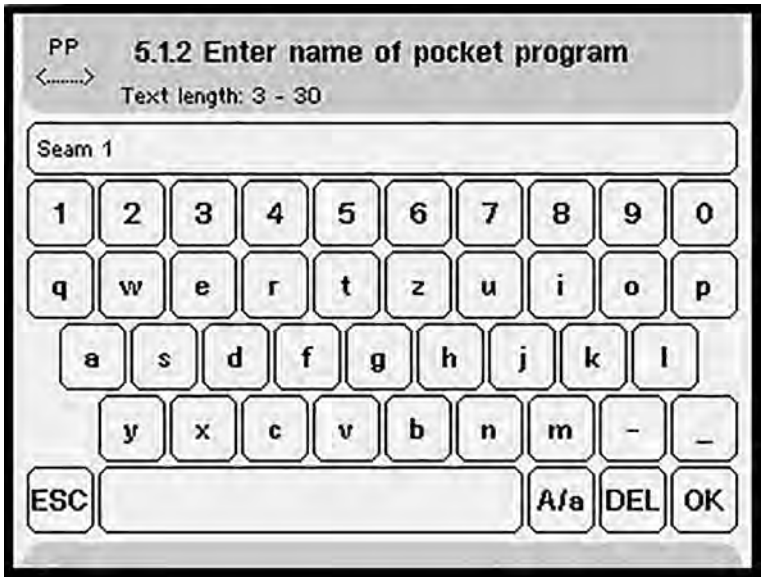
1. Enter the desired value.
2. Press the **+/-** button.

↳ The value is given a - sign and becomes negative.

3. Confirm with **OK**.

Entering text using the text editor

Fig. 85: Entering text using the text editor



To enter text using the text editor:

1. Use the keyboard to enter text.
2. If you need to correct or delete text, press the DEL button and delete the letters or numbers you wish to delete.

OR

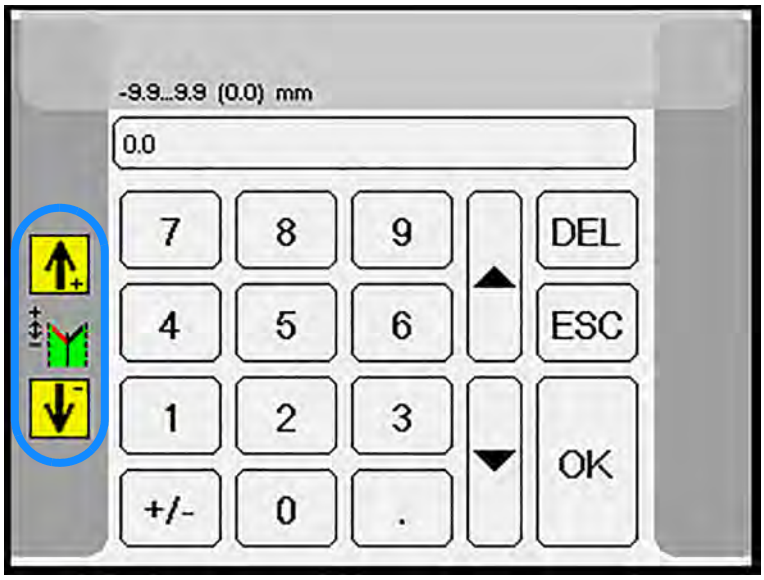
3. In the text you have already entered: tap on the place where you wish to enter new text.

↳ The text will be deleted starting at the place where you tapped.

Information

For values corrected relative to the sewing field, the system will show a correction aid in the left half of the display. The correction indicates the direction in which the correction will take effect.

Fig. 86: Entering values using the numeric keypad (2)



Piece counter

Reset piece counter

To reset the piece counter:

1. Press the button Σ159 briefly.

↳ The piece counter is reset to 0.

Adjusting initial piece counter value

To adjust the initial piece counter value:

1. Press and hold the button Σ159 for approx. 2 seconds.

↳ The display switches to Edit mode.

2. Use the numeric keypad to set the desired number of pieces (0-10000).
3. Confirm with **OK**.

↳ The display returns to the start screen.

Creating or changing a seam sequence

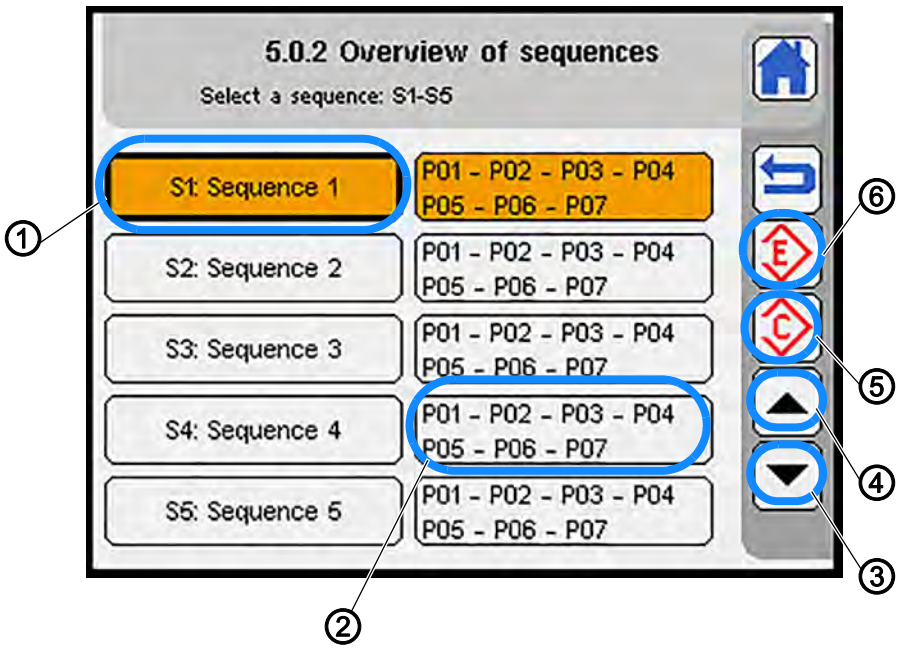
The user can save different seam programs in the same seam sequence. The seam programs will be sewn in the order in which they have been saved.
You can choose from 40 seam sequences and 200 seam programs.

To create or change a seam sequence:

1. Press the **Edit seam sequence** S1: Sequence 1 button.

↳ The display switches to *Overview of sequences*.

Fig. 87: Creating or changing a seam sequence (1)



(1) - Selected seam sequence
(2) - Display of pocket programs in the sequence
(3) - Scroll down seam sequences
(4) - Scroll up seam sequences
(5) - Copy seam sequence
(6) - Create seam sequence
(7) - Save settings and return to previous level
(8) - Save settings and return to start screen

No.	Symbols	Description
①	Varies with the programming	Selected seam sequence
②	Varies with the programming	Display of pocket programs assigned to the seam sequence
③	▼	Call up additional seam sequences • in steps of 5

No.	Symbols	Description
④		Call up additional seam sequences • in steps of 5
⑤		Copy seam sequence
⑥		Create and change seam sequence



2. Select the desired seam sequence from the list.

↳ To scroll up and down the list of sequences, press the buttons  and  .

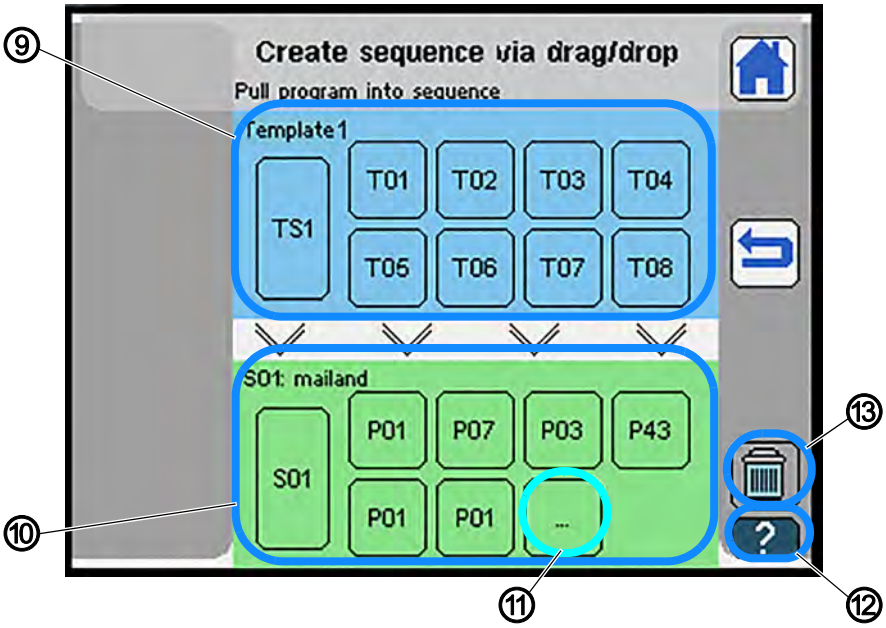
3. Press the desired seam sequence.

↳ The selected seam sequence is highlighted with a bold frame and the color orange (1).

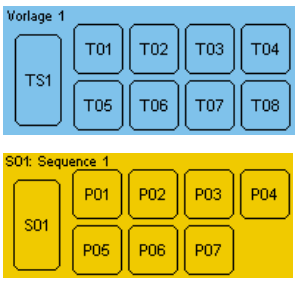
4. Press the  button.

↳ The display switches to `Create sequence via drag/drop`.

Fig. 88: Creating or changing a seam sequence (2)



(9) - Seam sequence template
(10) - Seam sequence to be created
(11) - Available pocket program slot
(12) - Help
(13) - Delete pocket program

No.	Symbols	Description
⑨		Seam sequence template • Sequence template has been selected (blue) • Call up a previously created seam sequence (yellow)
⑩		Seam sequence to be created
⑪		Available pocket program slot • Quick access to pocket programs • Pocket programs already in use are highlighted in blue
⑫		Help
⑬		• Delete a pocket program from seam sequence: via drag and drop • Delete all pocket programs: with a tap

Information

The programs in the seam sequence template (9) contain programs that represent common seam patterns.

A seam sequence can contain up to 8 seam programs. Once a seam sequence is full, the arrows ⌄ ⌄ between seam sequence template and seam sequence to be created will disappear.

At least one pocket program MUST remain in the seam sequence.

If a pocket program is positioned via *Drag and Drop*, the left half of the display will show the seam pattern of the pocket program.

The pocket programs will be stored in the seam sequence in the order in which they were added to the seam sequence.

Selecting pocket programs from the seam sequence template

To select a pocket program from the seam sequence template:

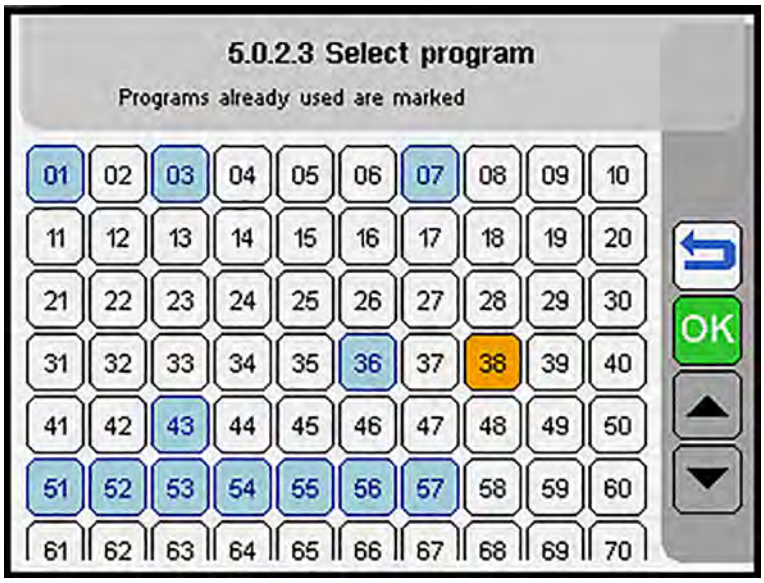
1. Use *Drag and Drop* to drag any pocket programs you do not need from the sequence to be created (10) to the trash **OR** tap on the trash to delete all pocket programs.

↳ The pocket programs are deleted from the sequence.

2. Use *Drag and Drop* to drag the desired pocket program from the template to an available pocket program slot.

↳ The display switches to `Select program`.

Fig. 89: Selecting pocket programs from the seam sequence template



3. Select the desired pocket program slot.

↳ To scroll up and down the list of pocket programs, press the buttons and .

4. Press the OK button to save the setting and return to the previous level.

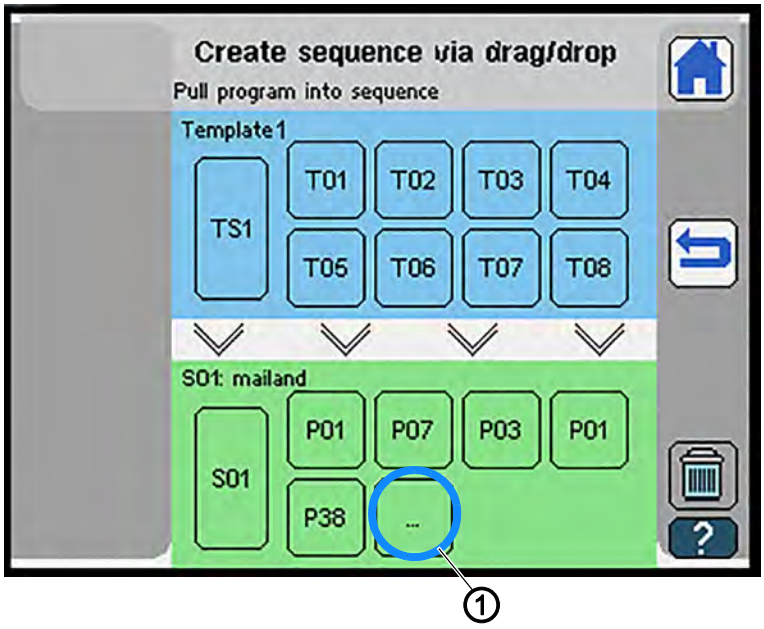
Important

The preset program is copied to the selected pocket program slot, **deleting the previous program**.

5. Select additional preset programs as described above and add them to the sequence.

Assigning an available pocket program slot

Fig. 90: Assigning an available pocket program slot (1)



(1) - Available pocket program slot

To create a seam sequence:

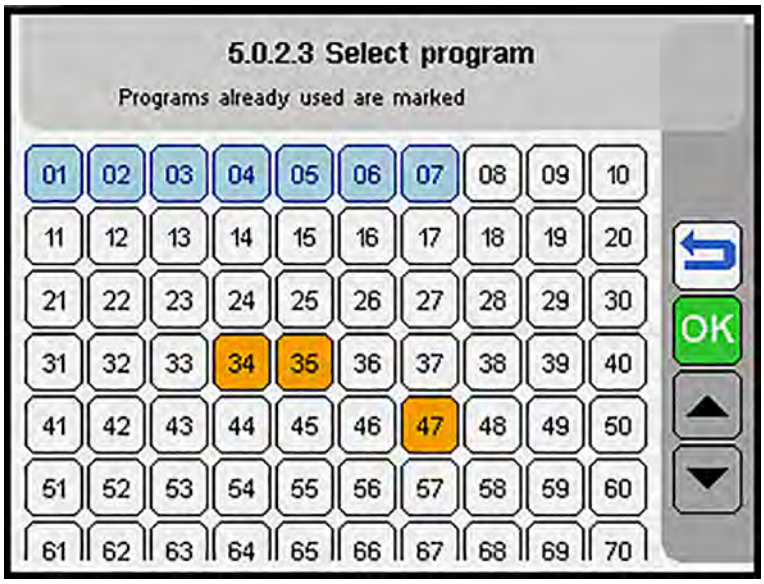
1. Use *Drag and Drop* to drag any pocket programs you do not need from the sequence to be created (10) to the trash **OR** tap on the trash to delete all pocket programs.

   ↳ The pocket programs are deleted from the sequence.

2. Press the ... button (1).

   ↳ The display switches to `Select program`.

Fig. 91: Assigning an available pocket program slot (2)



Information

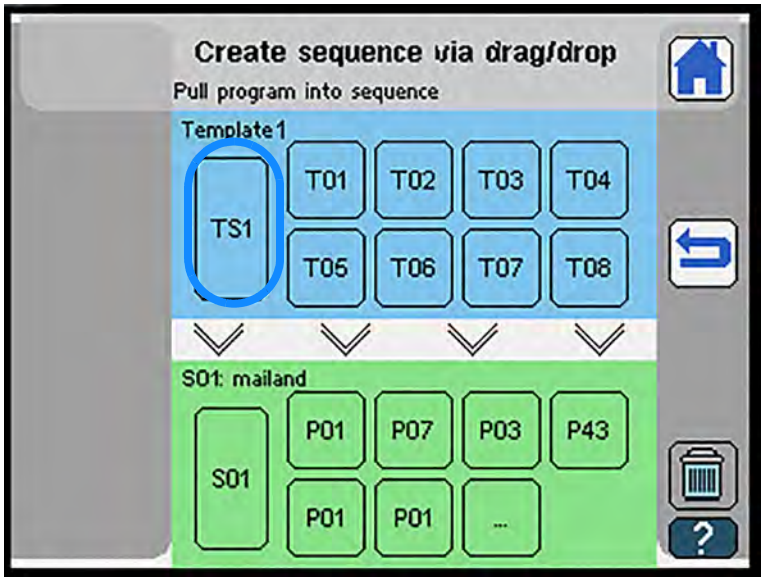
Pocket programs highlighted in blue are already in use in other seam sequences.
The currently selected pocket program is highlighted in orange.

3. Select the desired pocket program.
   You can select no more pocket programs than there are available pocket program slots (up to 8).
   The order in which they are selected corresponds to the order of the programs in the seam sequence.

↳ To scroll up and down the list of pocket programs, press the buttons ▼ and ▲.

Changing the seam sequence template

Fig. 92: Changing the seam sequence template (1)

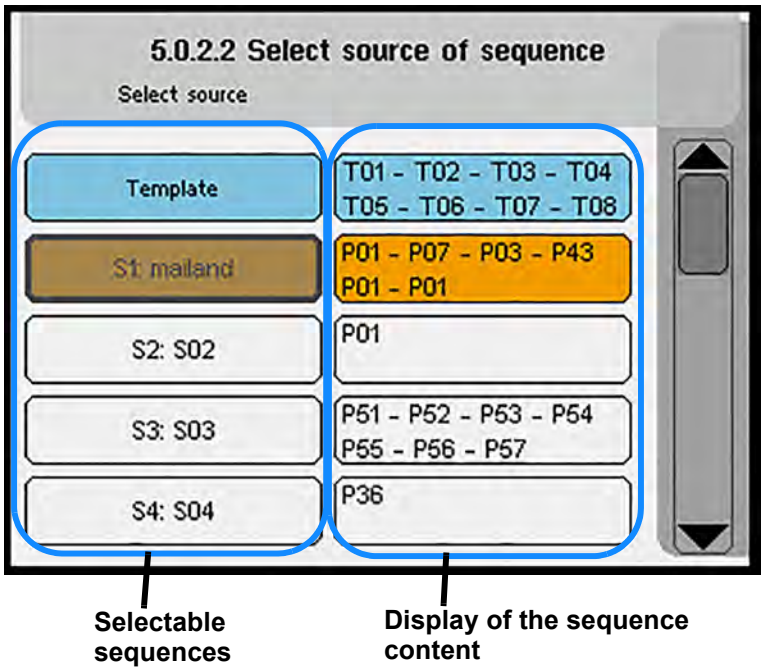


To change the seam sequence template:

1. Press the **S01** button.

↳ The display switches to *Select source of sequence*.

Fig. 93: Changing the seam sequence template (2)



↳ The destination sequence is grayed out and cannot be selected.

2. Select the desired seam sequence from the list.

↳ To scroll up and down the list of sequences, press the buttons ▼ and ▲ **OR** drag the bar up or down.

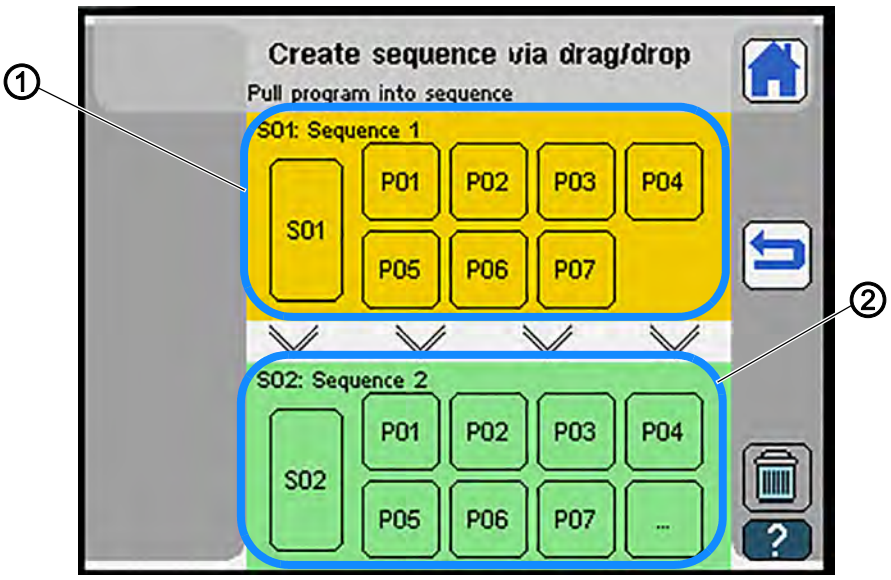
3. Press the desired seam sequence.

↳ The display returns to `Create sequence via drag/drop`.

Information

Cancel the selection by pressing the same sequence again.

Fig. 94: Changing the seam sequence template (3)

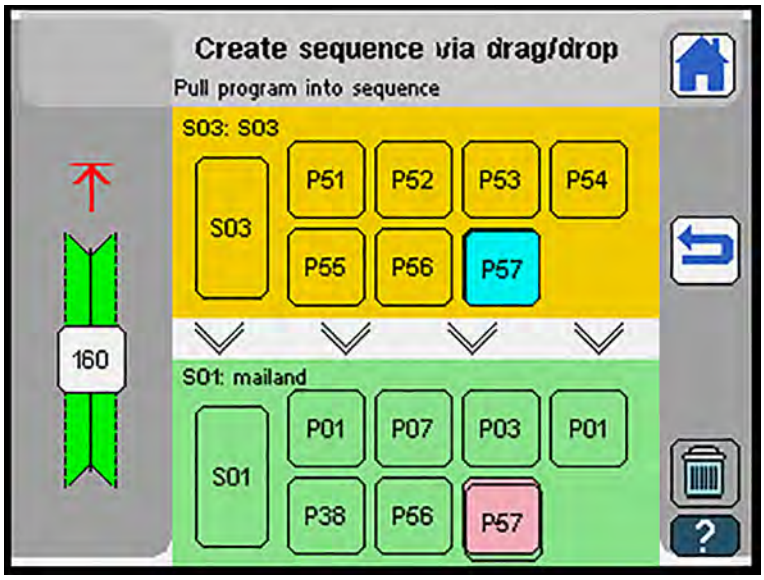


(2) - Seam sequence template *(3) - Sequence to be created*

4. Use *Drag and Drop* to drag any pocket programs you do not need from the sequence to be created (3) to the 🗑 trash **OR** tap on the trash 🗑 to delete all pocket programs.

↳ The pocket programs are deleted from the sequence.

Fig. 95: Changing the seam sequence template (4)



5. Use *Drag and Drop* to drag the desired pocket program from the seam sequence template (1) to an available pocket program slot.
   OR
   Press the ··· button to select the desired pocket program from the list.
6. Press the button to save the setting and return to the previous level.

↳ The display returns to `Overview of sequences`.

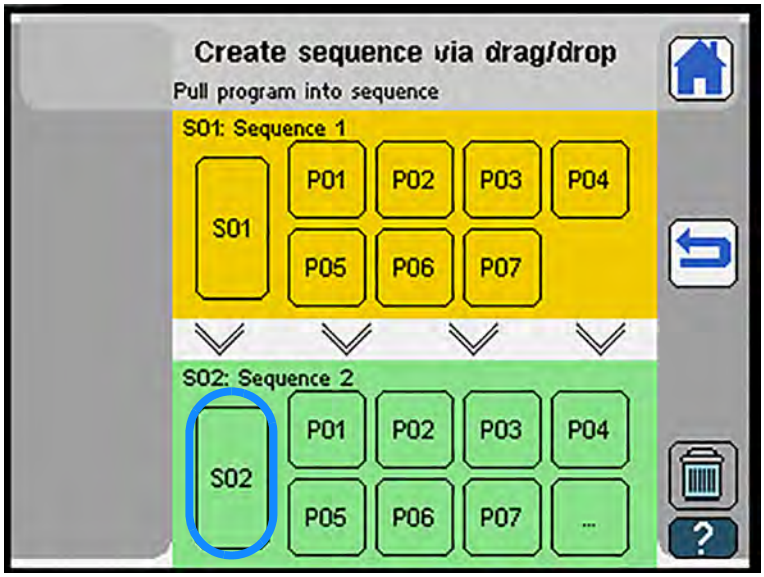
OR

7. Press the button to save the setting and return to the start screen.

↳ You can start sewing with the new seam sequence right away.

Naming a seam sequence

Fig. 96: Naming a seam sequence (1)

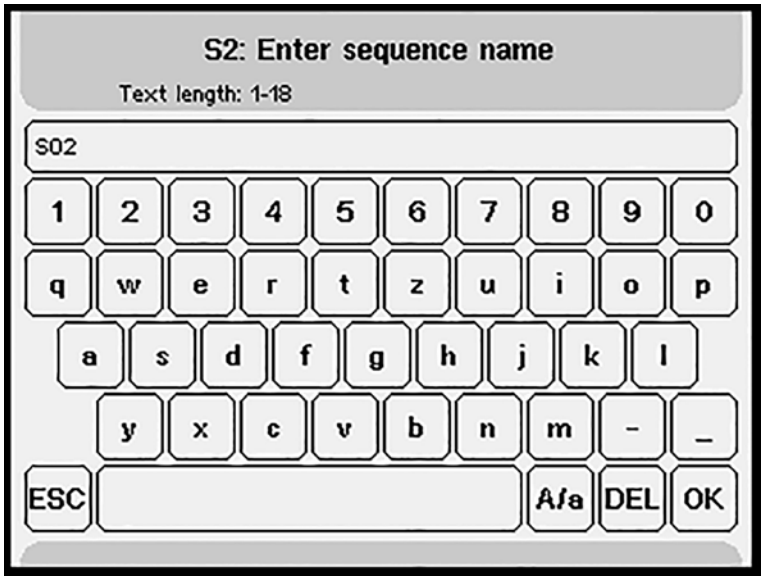


To enter a name for a seam sequence:

1. Press the button **S02-S20** (depending on which seam sequence you have selected).

↳ The display switches to a keypad.

Fig. 97: Naming a seam sequence (2)



2. Enter the desired sequence name.
   You can enter up to 18 characters.
   Every sequence must be given a name.
3. Confirm with **OK**.

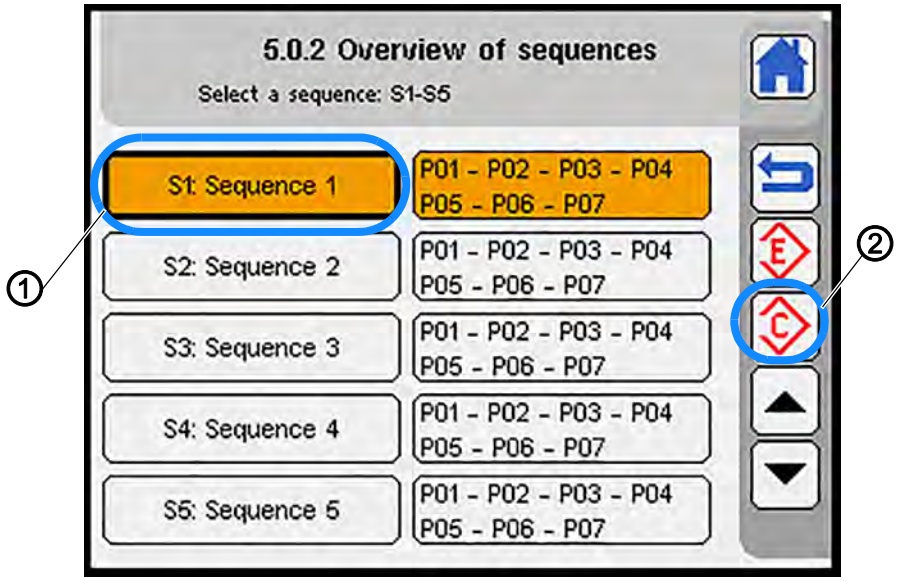
Copying a seam sequence

To copy a seam sequence:

1. Press the **Edit seam sequence** button.

↳ The display switches to `Overview of sequences`.

Fig. 98: Copying a seam sequence (1)



(1) - Selected seam sequence *(2) - Copy seam sequence*

2. Select the seam sequence you wish to copy from the list.

↳ To scroll up and down the list of sequences, press the buttons and .

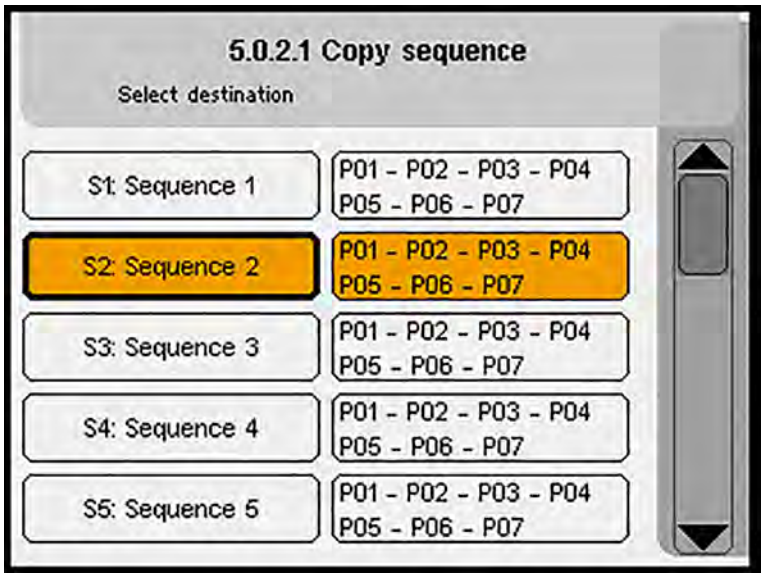
3. Press the desired seam sequence.

↳ The selected seam sequence is highlighted with a bold frame and the color orange (1).

4. Press the button.

↳ The display switches to `Copy sequence`.

Fig. 99: Copying a seam sequence (2)



↳ The source sequence is highlighted with a bold frame and the color orange.

5. Select the seam sequence you wish to overwrite from the list.

↳ To scroll up and down the list of sequences, press the buttons ▼ and ▲ **OR** drag the bar up or down.

Information

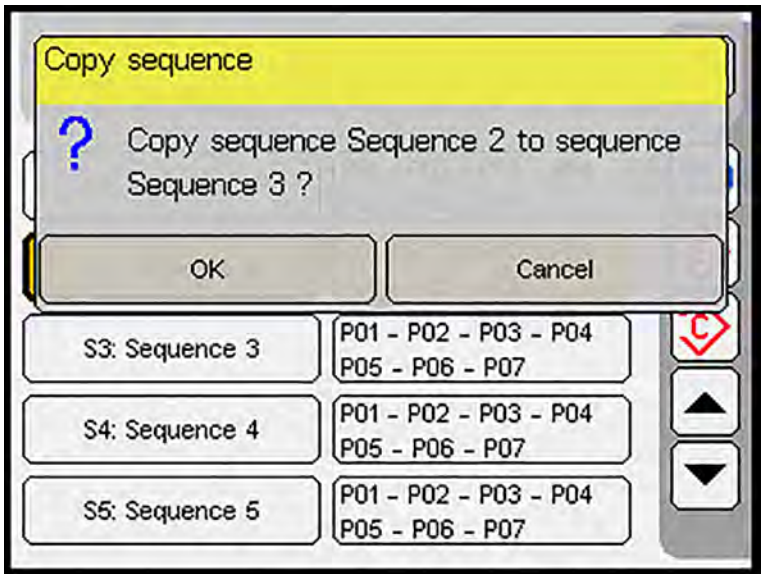
Cancel the selection by pressing the same sequence again.

---

6. Press the desired seam sequence.

↳ The display shows an info field.

Fig. 100: Copying a seam sequence (3)



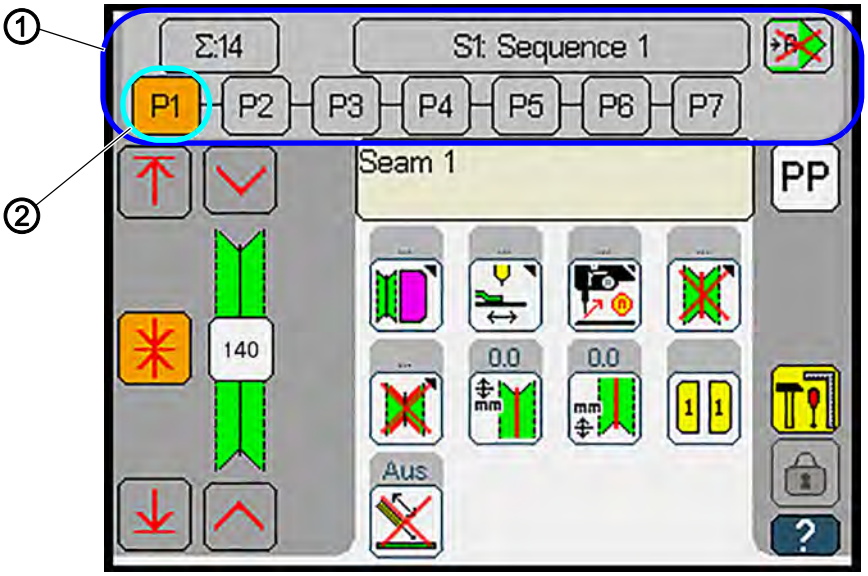
- To copy, press **OK** to confirm
- To cancel, press the **Cancel** button

↳ The display returns to `Overview of sequences`.

Activating a pocket program from the seam sequence

You can activate a single pocket program stored in the seam sequence if you wish to sew a specific pocket program that is not up next in the sequence.

Fig. 101: Activating a pocket program from the seam sequence



(1) - Pocket programs in sequence *(2) - selected pocket program*

To activate a pocket program in an active seam sequence:

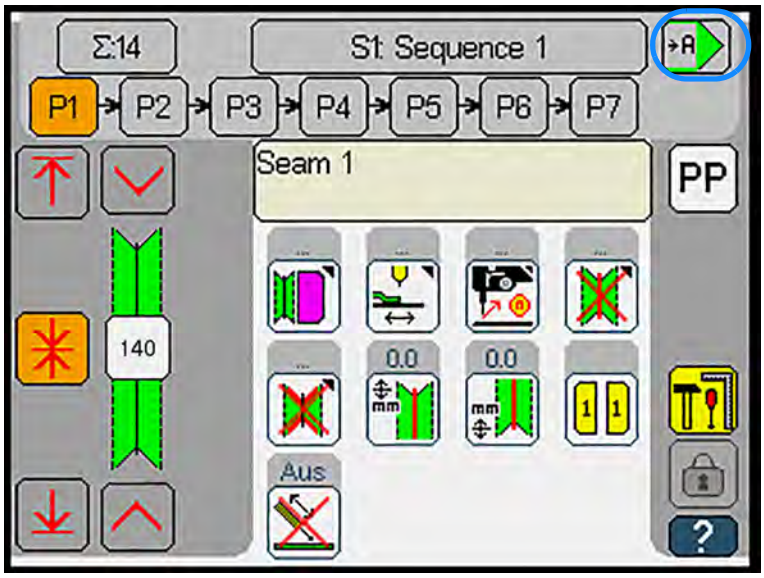
1. Press the desired pocket program in the sequence (1) shown on the pocket program display.

↳ The selected pocket program (2) is highlighted in orange.
The machine always sews using the selected pocket program.

Activating the automatic seam sequence

If the automatic seam sequence is activated, the machine will automatically sew the next pocket program in the sequence after completing the current pocket program.

Fig. 102: Activating the automatic seam sequence



To activate the automatic seam sequence:

1. Press the  button.

↳ The start screen shows arrows between the seam sequences.
The arrows indicate that the automatic seam sequence has been activated.

Program parameters

The *Program parameters* menu allows you to configure, name and save up to 200 different pocket programs.

Information

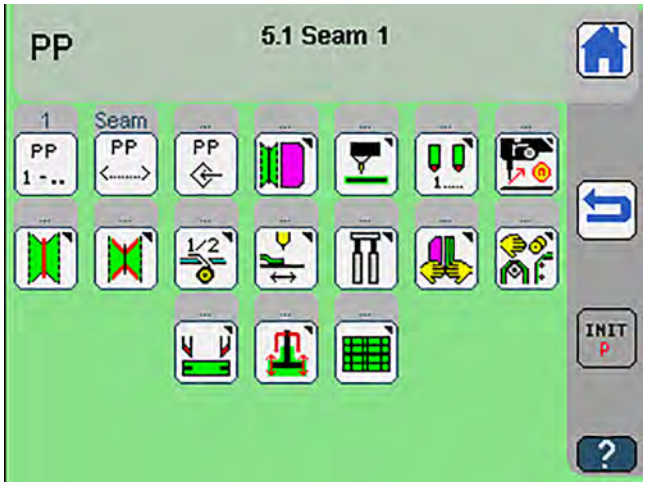
If an option is not available or grayed out, it must be set up in the *Machine configuration* menu (📖 *p. 187*). Otherwise, the option will be unavailable in this class.

To configure pocket programs:

1. Press the **Program parameters** button.

↳ The display switches to *Configure pocket programs*.

Fig. 103: Program parameters



Symbols	Meaning
	Select pocket program 📖 *p. 129*
	Enter name of pocket program 📖 *p. 130*
	Copy pocket program 📖 *p. 130*
	Create or change seam program 📖 *p. 132*

Symbols	Meaning
	Correction light barrier 🕮 *p. 141*
	Marking lamps 1-16 🕮 *p. 143*
	Sewing head parameters 🕮 *p. 147*
	Middle knife parameters 🕮 *p. 151*
	Corner knife 🕮 *p. 153*
	Automatic tape feeder (optional, 🕮 *p. 162*)
	Transport clamp 🕮 *p. 163*
	Process of transport clamp 🕮 *p. 166*
	Program loading process 🕮 *p. 171*
	Stacker/smoother/blow-off/roll-off 🕮 *p. 179*
	Reset seam program to default values
	Adjust piping knife 🕮 *p. 181*
	Adjust guiding plates and folder 🕮 *p. 182*
	Pattern matching (756 F only) 🕮 *p. 184* • **not active unless a seam program with flap has been selected**(🕮 *Create seam program* 🕮 *p. 132*)



2. Press the desired button.

↳ The user interface for setting the desired item is displayed.



Selecting a pocket program

Information

By default, the seam program currently selected will be active on the start screen.
You can use the option **Select pocket program** to quickly configure several pocket programs in a row.

To select a pocket program:

1. Use the numeric keypad to set the desired pocket program (1-200).
2. Confirm with **OK**.

↳ The display switches to the selected pocket program.
You can configure the selected pocket program as described below.

Important

When you return to the start screen after configuring the selected pocket program, the previous pocket program will be active again.
To activate the pocket program you configured, you must add it to the seam sequence (📖 *p. 113*).

If the pocket program has already been copied to the selected seam sequence, you can activate it in the seam sequence (📖 *p. 125*).

Entering the name of a pocket program

To enter the name of a pocket program:

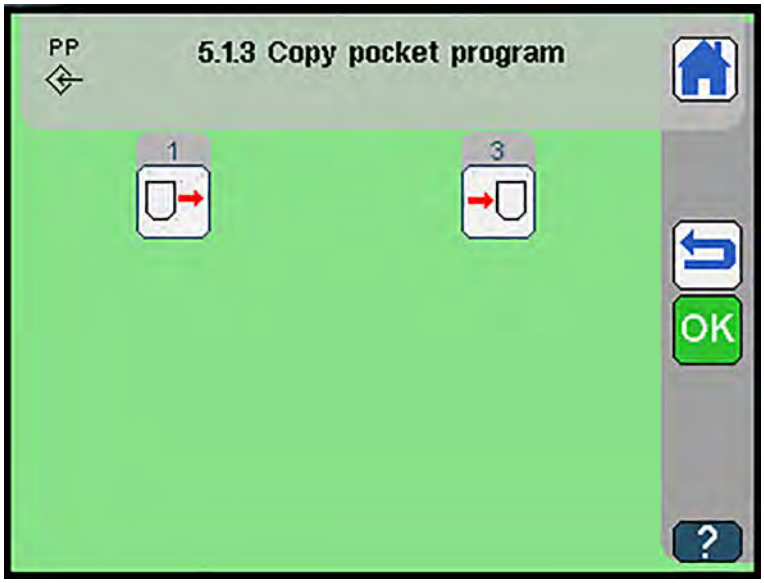
1. Use the letter and numeric buttons to enter the desired name of the pocket program.
2. Confirm with **OK**.

↳ The display switches to the selected pocket program.

Copying a pocket program

↳ The display switches to `Copy pocket program`.

Fig. 104: Copying a pocket program (1)



Symbols	Meaning
	Select source • Select the pocket program you wish to copy
	Select destination • Select the pocket program you wish to overwrite
OK	Save settings

To copy a pocket program:

1. Press the button.

Information

The active pocket program has been set as the source.

2. Enter the source using the numeric keypad.
3. Confirm with **OK**.

↳ The display returns to `Copy pocket program`.

4. Press the button.
5. Enter the destination using the numeric keypad.

Important

The destination program will be overwritten during the copying process. If necessary, you will have to make additional adjustments in the software. If selecting a destination that is already used in another sequence, you will be shown a safety check message prompting you to confirm that you really want to overwrite the sequence:

Fig. 105: Copying a pocket program (2)



6. Confirm with **OK**.

↳ The selected pocket program is copied.
The message `Copy was successful` is displayed.

7. Confirm with **OK**.

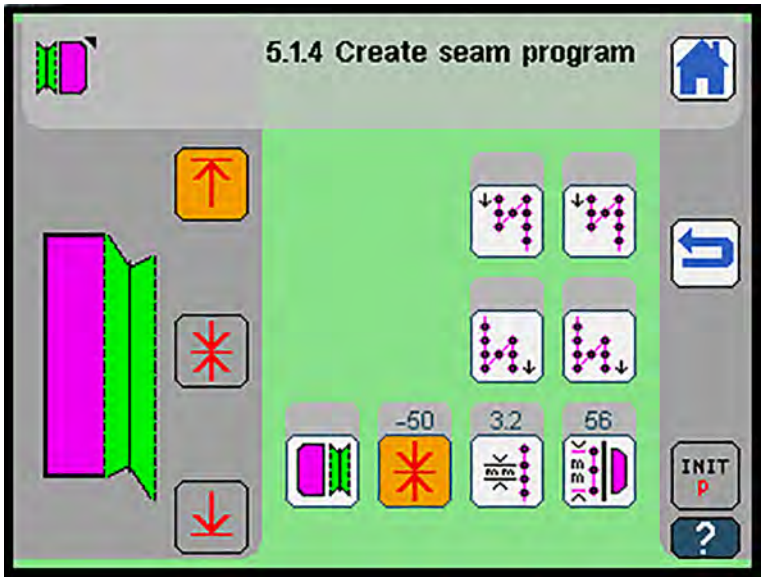
↳ The display switches to the selected seam program.



Creating a seam program

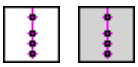
↳ The display switches to `Create seam program`.

Fig. 106: Creating a seam program



Press a button to either open another submenu or enter the desired values directly using the numeric keypad.

Symbols	Meaning
	Flap shape seam begin. •  straight •  slanted •  slanted •  Adjust slanted flap shape seam begin. (1 - 13 mm)
	Pocket shape seam begin. •  straight •  slanted •  slanted •  Adjust pocket shape seam begin. (1 - 13 mm)
 	Securement seam beginning left/right needle • Stitch condensing **OR** • Single backtack **OR** • Double backtack
	Flap shape seam end •  straight •  slanted •  slanted •  Adjust slanted flap shape seam end (1 - 13 mm)
	Pocket shape seam end •  straight •  slanted •  slanted •  Adjust slanted pocket shape seam end (1 - 13 mm)

Symbols	Meaning
	Securement seam end left/right needle • Stitch condensing **OR** • Single backtack **OR** • Double backtack
	Flap left **OR** Flap right
	Adjust correction value of positioning point at seam beginning 🕮 *p. 138* • -100 mm - 100 mm Adjust correction value of positioning point in the middle of the seam 🕮 *p. 138* • -100 mm - 100 mm Adjust correction value of positioning point at seam end 🕮 *p. 138* • -100 mm - 100 mm • **The correction value will be adopted when you switch positioning points** • **The basic values for the positioning points seam beginning/ middle of the seam/seam end are set in the Global parameters** (🕮 *p. 198*)
	Adjust stitch length main seam • 1.5 mm - 4.5 mm
	Adjust flap scan 🕮 *p. 139* • Fixed seam length • 1 light barrier • Automatic flap scan left
	Reset seam program



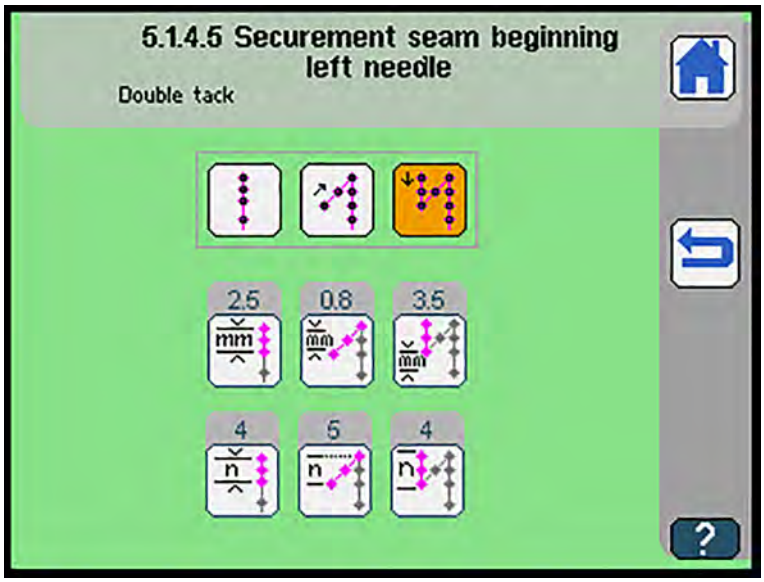
To create a seam program:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting securement seam beginning left needle

↳ The display switches to *Securement seam beginning left needle*.

Fig. 107: Adjusting securement seam beginning left needle



Symbols	Meaning
	Select stitch condensing • Adjust stitch length for stitch condensing at seam beginning (0.5 - 4.5 mm) • Adjust number of stitches for stitch condensing at seam beginning (0 - 10)
	Select single tack • Adjust stitch length for single tack at seam beginning (0.5 - 4.5 mm) • Adjust number of stitches for single tack at seam beginning (0 - 10)
	Select double tack • Adjust stitch length for double tack at seam beginning (0.5 - 4.5 mm) • Adjust number of stitches for double tack at seam beginning (0 - 10)

To set the securement of the left seam beginning:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Information

If the seam pattern is straight, you only have to set the left seam securement. The setting for the right needle is adopted.

Adjusting securement seam beginning right needle

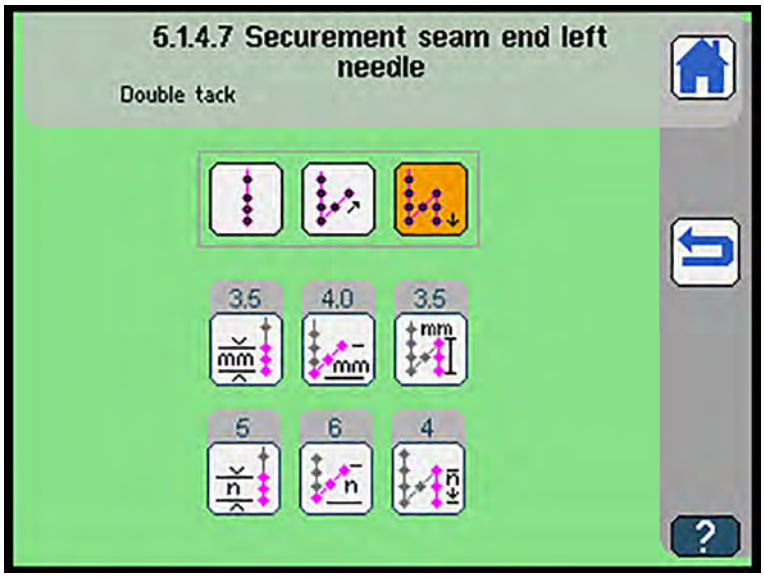
Information

The settings in sub-item *Securement seam beginning right needle* are adopted automatically from the settings for the *Securement seam beginning left needle* (📖 *p. 135*).

Adjusting securement seam end left needle

↳ The display switches to *Securement seam end left needle*.

Fig. 108: Adjusting securement seam end left needle



Symbols	Meaning
	Select stitch condensing •  Adjust stitch length for stitch condensing at seam end (0.5 - 4.5 mm) •  Adjust number of stitches for stitch condensing at seam end (0 - 10)
	Select single tack •  Adjust stitch length for single tack at seam end (0.5 - 4.5 mm) •  Adjust number of stitches for single tack at seam end (0 - 10)
	Select double tack •  Adjust stitch length for double tack at seam end (0.5 - 4.5 mm) •  Adjust number of stitches for double tack at seam end (0 - 10)

To set the securement of the right seam end:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

 Adjusting securement seam end right needle

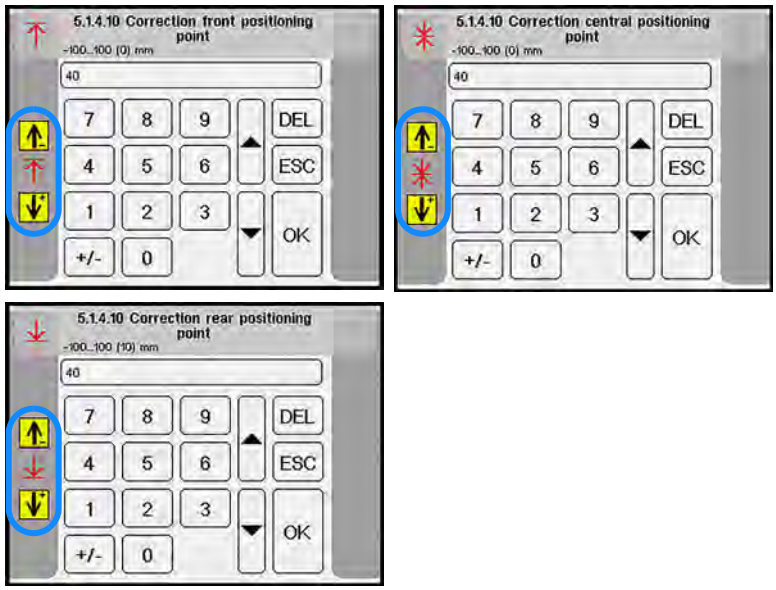
Information

The settings in sub-item *Securement seam end right needle* are adopted automatically from the settings for the *Securement seam end left needle* (📖 *p. 136*).

Adjusting correction values of the positioning points

↳ The display switches to *Adjust positioning point correction value*:

Fig. 109: Adjusting correction values of the positioning points



Information

The arrows in the left half of the display indicate the correction direction:

Correction inward

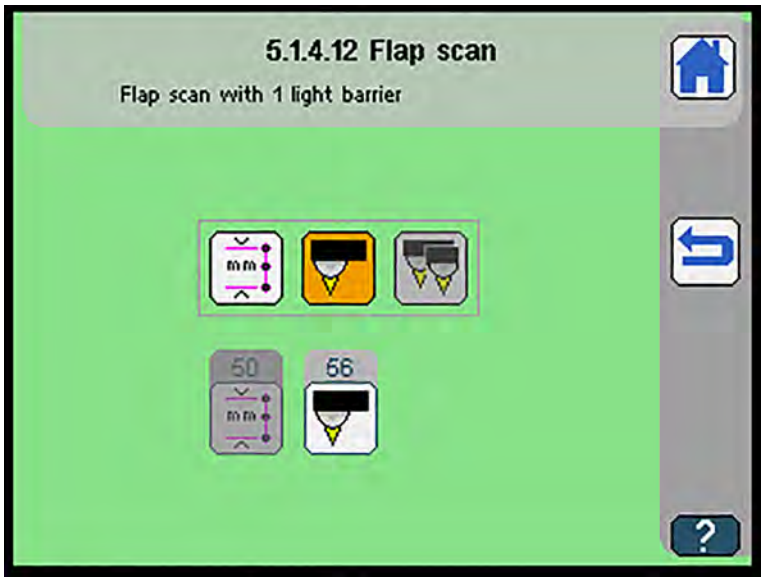
Correction outward

The set correction value is adopted for all 3 positioning points when you switch positioning points.

Activating the flap

↳ The display switches to `Flap scan`.

Fig. 110: Activating the flap (1)



Symbols	Meaning
	Activate fixed seam length • **manual** working method • Adjust sewing length Not available unless Activate sewing length has been selected • 20 mm - 180 mm/200 mm/220 mm/240 mm (depending on the sewing length set)
	Activate flap scan with 1 light barrier • **semi-automatic** working method • Adjust maximum flap length Not available unless Activate flap scan has been selected (📖 *p. 193*) • 20 mm - 185 mm/205 mm/225 mm/245 mm (depending on the flap length set)
	Activate automatic flap scan left (📖 *p. 193*) • **fully automatic** working method

To activate the flap:

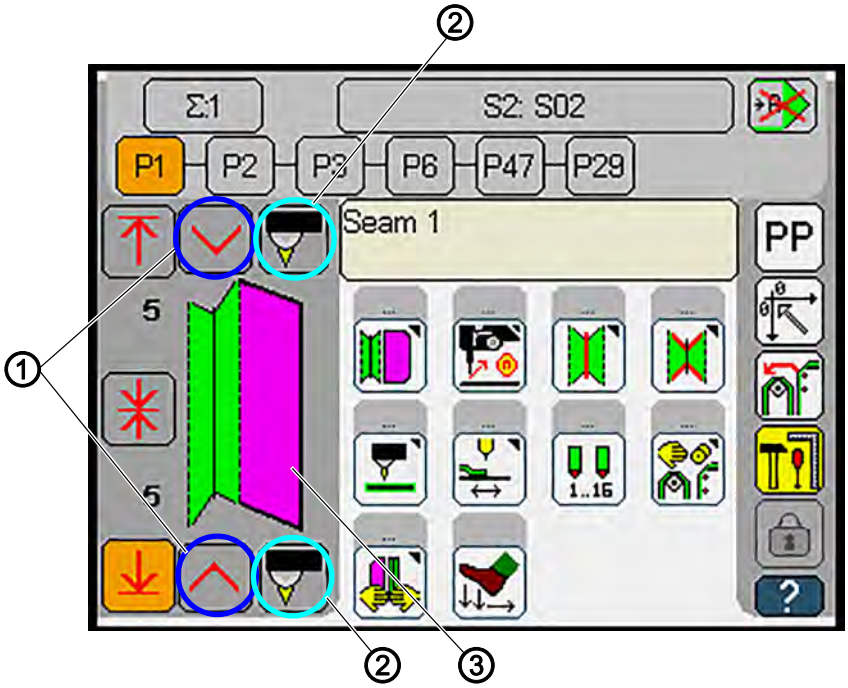
1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Information

If flap scan has been set, the display will switch from the seam program to the start screen.

The display shows the flap, and the flap scan and corner knife correction can be set via the quick access menu.

Fig. 111: Activating the flap (2)



(1) - Quick access corner knife correction

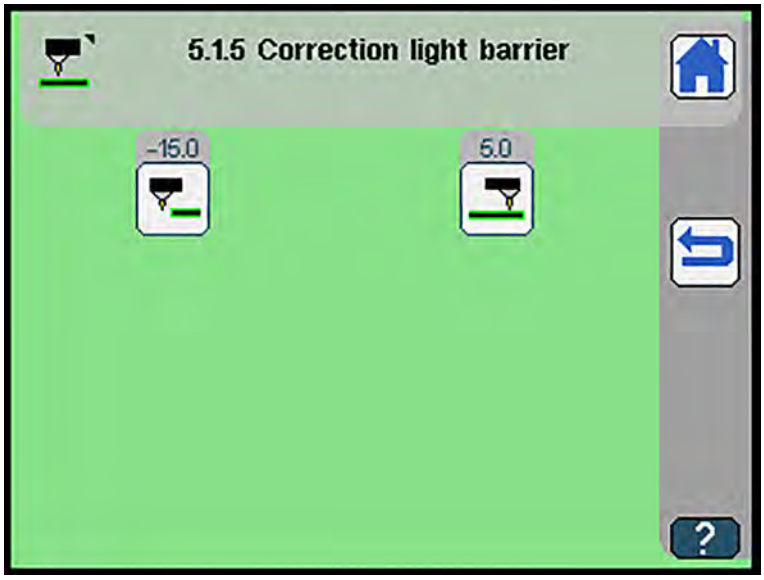
(2) - Quick access flap correction

(3) - Display of flap

Correction light barrier

↳ The display switches to `Correction light barrier`.

Fig. 112: Correction light barrier.



Symbols	Meaning
	Adjust correction light barrier seam begin. • -20 mm - +20 mm
	Adjust correction light barrier seam end • -20 mm - +20 mm

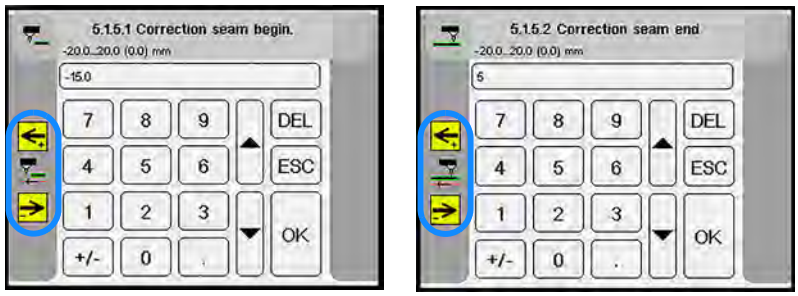
To make a correction to the light barrier:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting correction light barrier seam begin./end

↳ The display switches to *Correction light barrier seam begin./end*.

Fig. 113: Adjusting correction light barrier seam begin./end



Information

The arrows in the left half of the display indicate the correction direction:

Seam beginning

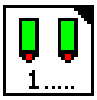
Correction outward

Correction inward

Seam end

Correction outward

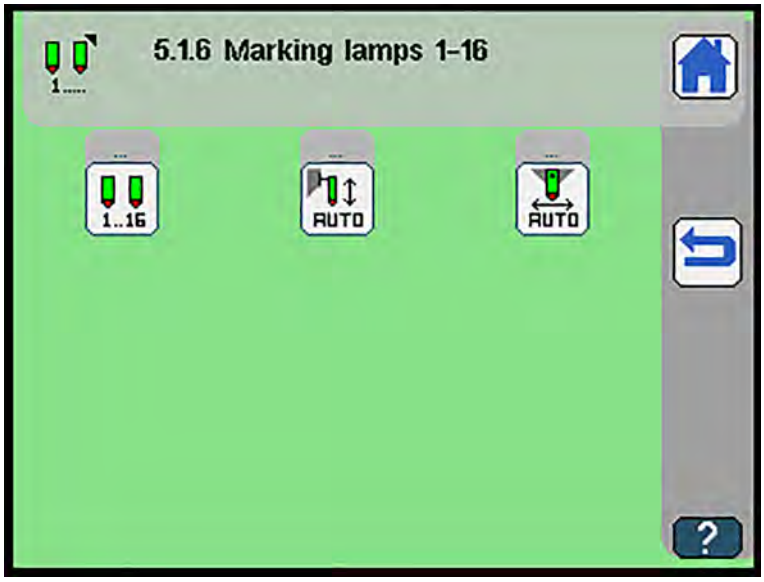
Correction inward



Marking lamps 1 - 16

↳ The display switches to *Marking lamps 1 - 16*.

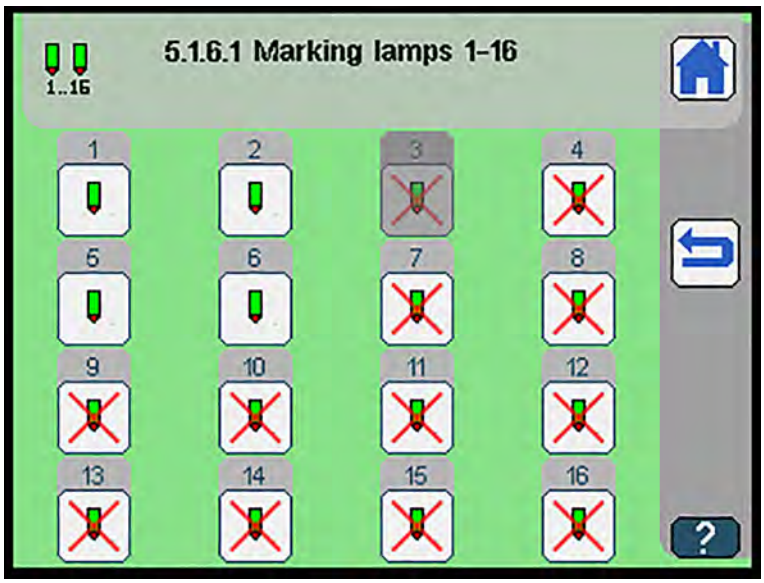
Fig. 114: Marking lamps 1-16



Symbols	Meaning
	Activate marking lamps 1 - 16 📖 *p. 144*
	Programmable marking lamps in sewing direction 📖 *p. 145*
	Programmable marking lamps crosswise to the sewing direction 📖 *p. 146*

Activating marking lamps 1 - 16

Fig. 115: Activate marking lamps 1-16



Symbols	Meaning
	Marking lamp activated
	Marking lamp deactivated

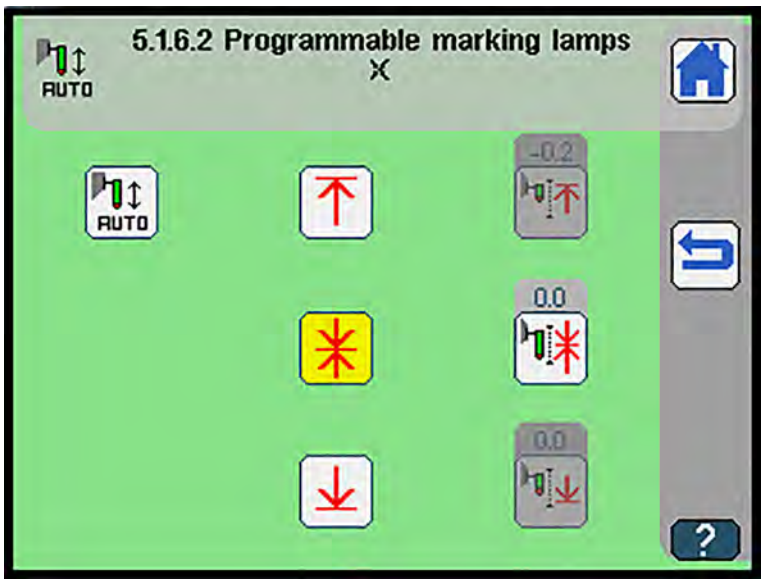
To activate the marking lamps:

1. Press the button of the desired marking lamp.

↳ The marking lamp is (de)activated.

Programmable marking lamps X-axis

Fig. 116: Programmable marking lamps X-axis



Symbols	Meaning
AUTO	Programmable marking lamps in longitudinal direction On/Off
	Adjust programmable marking lamp seam beginning • -120 - 120
	Adjust programmable marking lamp seam center • -120 - 120
	Adjust programmable marking lamp seam end • -120 - 120

To program the programmable marking lamps for the X-axis:

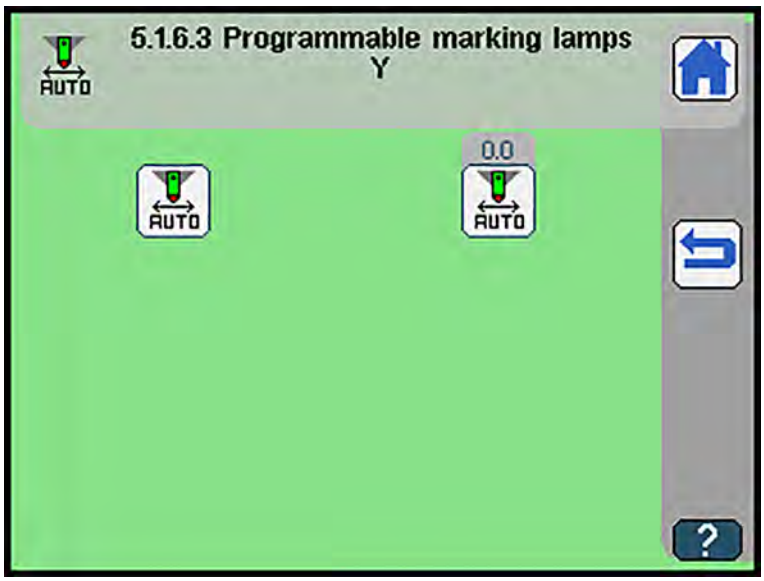
1. Press the button , or .

↳ The desired marking lamp moves to the corresponding position.

2. Press the button , or .
3. Enter the desired correction value using the numeric keypad.
4. Confirm with **OK**.

Programmable marking lamps Y-axis

Fig. 117: Programmable marking lamps Y-axis



Symbols	Meaning
	Programmable marking lamps in crosswise direction On/Off
	Adjust programmable marking lamp Y-axis • -120 - 120

To program the programmable marking lamps for the Y-axis:

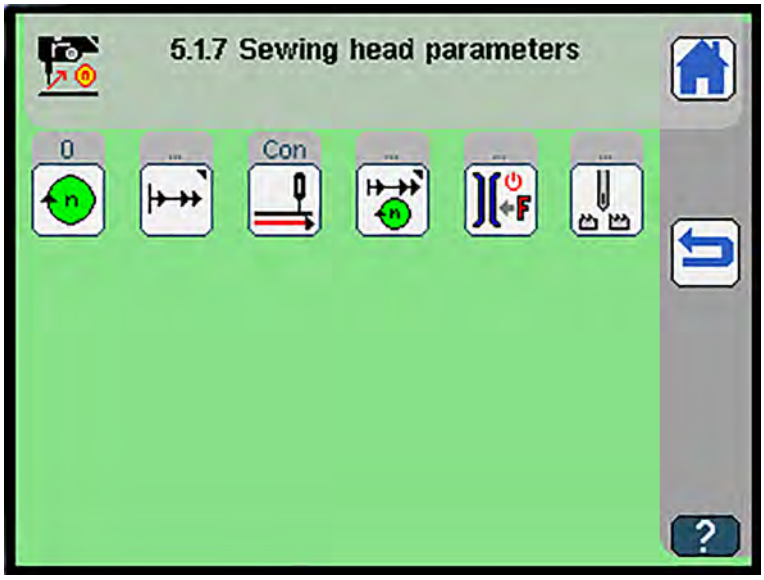
1. Enter the desired correction value using the numeric keypad.
2. Confirm with **OK**.



Sewing head parameters

↳ The display switches to *Sewing head parameters*.

Fig. 118: Sewing head parameters



Press a button to either open another submenu or enter the desired values directly using the numeric keypad.

Symbols	Meaning
	Adjust sewing speed • 100 RPM - 3200 RPM
	Adjust soft start parameters 🕮 *p. 148* • Soft start On/Off • Soft start speed • Number of stitches soft start • Number of stitches needle thread clamp open
 	Adjust continuous transport (standard) **OR** Activate intermittent transport (custom applications)
	Adjust seam securement 🕮 *p. 149* • R.p.m. seam begin. (100 - 1500 RPM) • R.p.m. seam end (100 RPM - 1500 RPM)
	Additional thread tension •  Additional thread tension seam begin. On/Off •  Additional thread tension seam end On/Off
	Needle transport 🕮 *p. 150*

To edit the sewing head parameters:

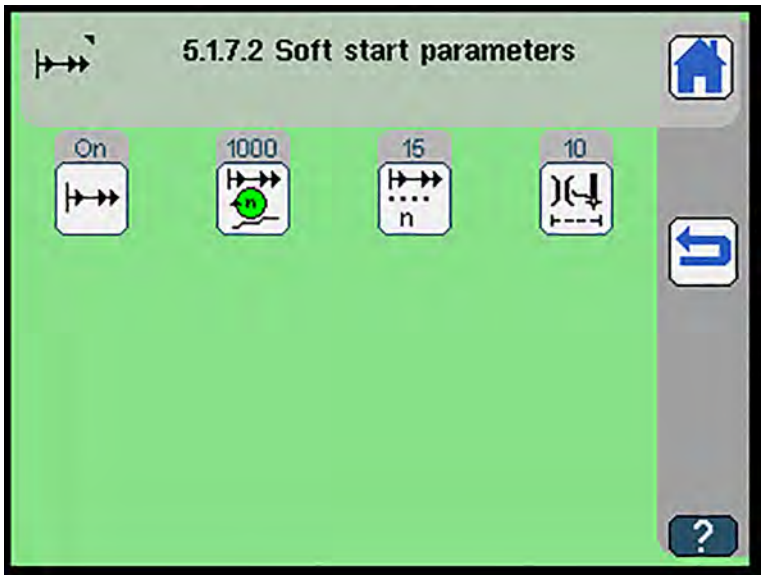
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Adjusting soft start parameters

↳ The display switches to *Soft start parameters*.

Fig. 119: Adjusting soft start parameters



Symbols	Meaning
	Soft start On/Off
	Adjust soft start speed • 100 RPM - 1500 RPM
	Adjust number of stitches for soft start • 1 - 20
	Number of stitches for loosening the needle thread clamp • 1 - 20

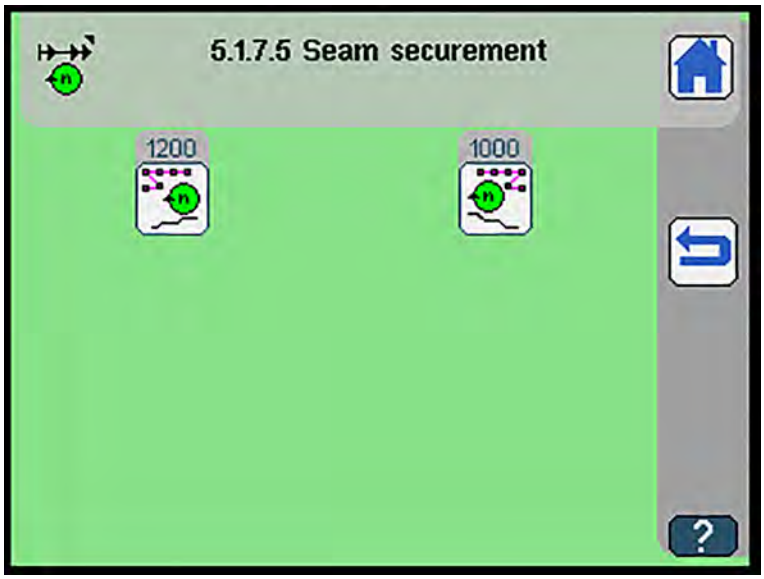
To edit the soft start parameters:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting seam securement

↳ The display switches to *Seam securement*

Fig. 120: Adjusting seam securement.



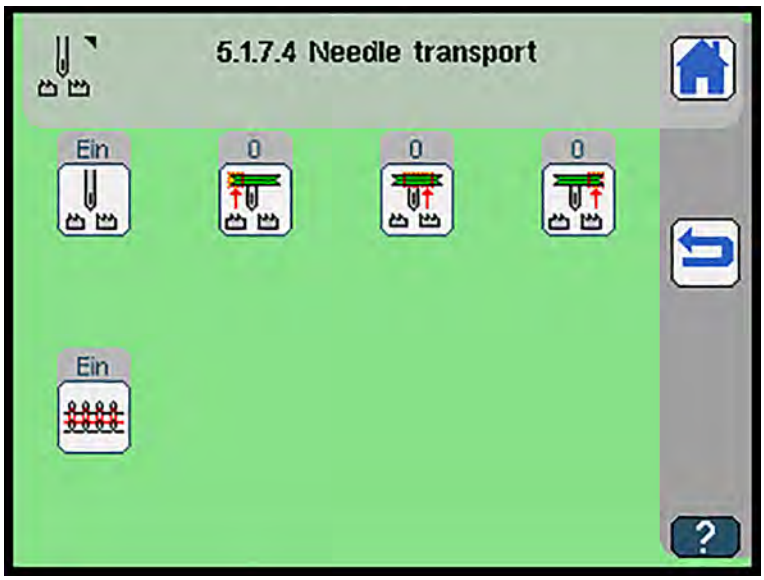
Symbols	Meaning
	Adjust r.p.m. seam begin. • 100 RPM - 1500 RPM
	Adjust r.p.m. seam end • 100 RPM - 1500 RPM

To adjust the speed of the seam securement:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Needle transport

Fig. 121: Needle transport

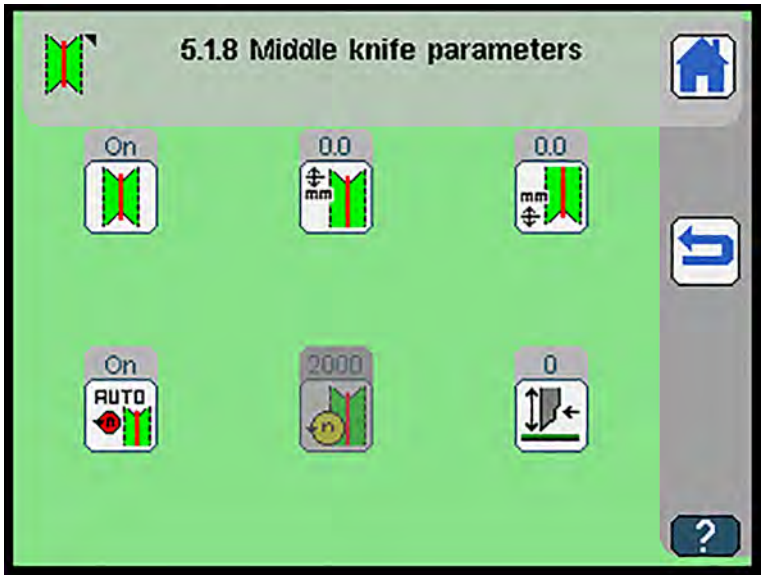


Symbols	Meaning
	Needle transport On/Off
	Adjust needle transport at seam beginning • 0 - 100 %
	Adjust needle transport in main seam • 0 - 100 %
	Adjust needle transport at seam end • 0 - 100 %

Middle knife parameters

↳ The display switches to `Middle knife parameters`.

Fig. 122: Middle knife parameters



Symbols	Meaning
	Middle knife On/Off
	Adjust middle knife correction seam begin. 📖 *p. 152* • -9.9 mm - 9.9 mm
	Adjust middle knife correction seam end 📖 *p. 152* • -9.9 mm - 9.9 mm
	Automatic speed adjustment On/Off • **if automatic speed adjustment is enabled, the option `Adjust speed middle knife` is not available**
	Adjust speed middle knife manually • 100 RPM - 2000 RPM • **if this option is enabled, the option `Automatic speed adjustment On/Off` is not available**
	Adjust middle knife position at insertion • 0 mm - 30 mm

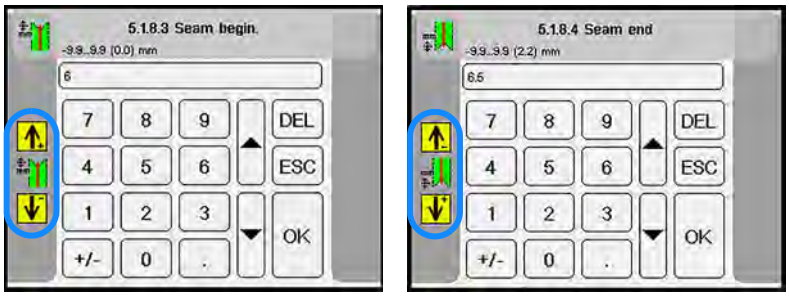
To set the middle knife parameters:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting middle knife correction seam begin./seam end

↳ The display switches to Adjust middle knife correction seam begin./ seam end:

Fig. 123: Adjusting middle knife correction seam begin./seam end



Information

The arrows in the left half of the display indicate the correction direction:

Seam beginning

Correction outward

Correction inward

Seam end

Correction inward

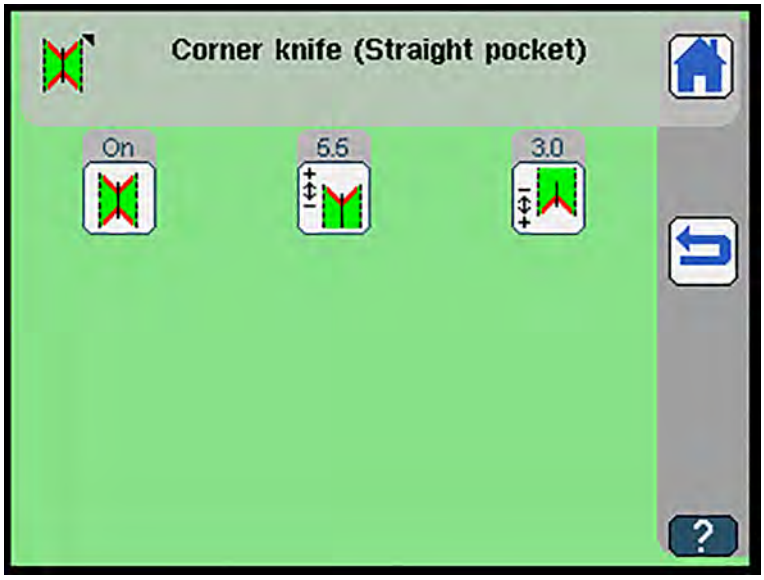
Correction outward



Corner knife (straight pocket)

↳ The display switches to *Corner knife (Straight pocket).*

Fig. 124: Corner knife (Straight pocket)



Symbols	Meaning
	Corner knife On/Off
	Adjust corner knife correction seam begin. 📖 *p. 154* • -9.9 mm - 9.9 mm
	Adjust corner knife correction seam end 📖 *p. 154* • -9.9 mm - 9.9 mm

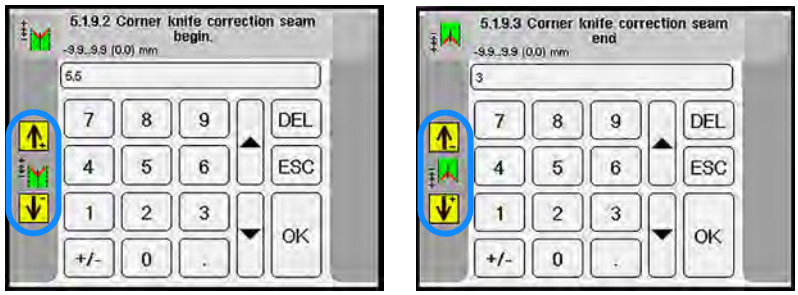


To adjust the corner knife:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting corner knife correction seam begin./seam end

Fig. 125: Adjusting corner knife correction seam begin./seam end



Information

The arrows in the left half of the display indicate the correction direction:

Seam beginning

Correction outward

Correction inward

Seam end

Correction inward

Correction outward

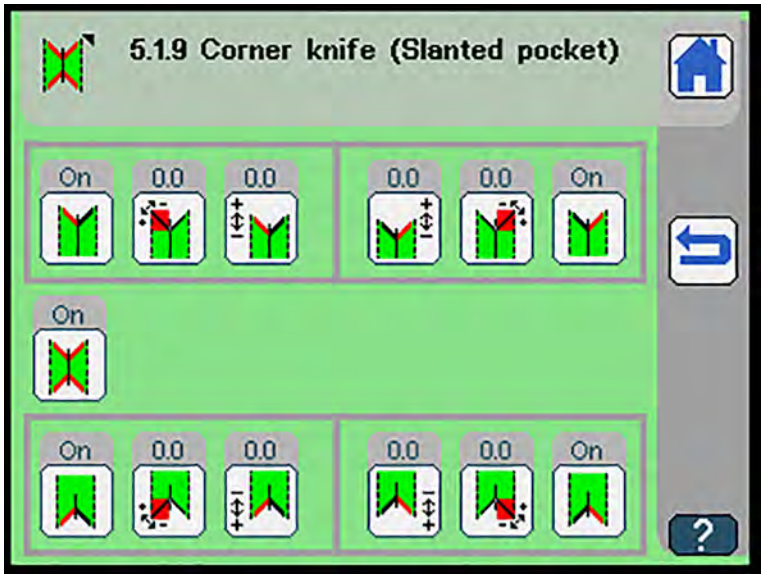
Corner knife (slanted pocket, automatic corner knife station)

Important

Before you can set the corner knife parameters for the slanted pocket, you must select the option Straight/Slanted pocket or automatic corner knife station in the submenu Corner knife device in the `Machine configuration` (📖 *p. 187*). After making the conversion in the `Machine configuration`, you must restart the machine.

The display switches to `Corner knife (Slanted pocket)`.

Fig. 126: Corner knife (slanted pocket)



Symbols	Meaning
	All corner knives On/Off
	Corner knife seam begin. left On/Off
	Correction seam begin. left 📖 *p. 156* • -9.9 mm - 9.9 mm
	Correction seam begin. right 📖 *p. 156* • -9.9 mm - 9.9 mm
	Corner knife seam begin. right On/Off
	Corner knife seam end left On/Off

Symbols	Meaning
	Correction seam end left 📖 *p. 156* • -9.9 mm - 9.9 mm
	Correction seam end right 📖 *p. 156* • -9.9 mm - 9.9 mm
	Corner knife seam end right On/Off

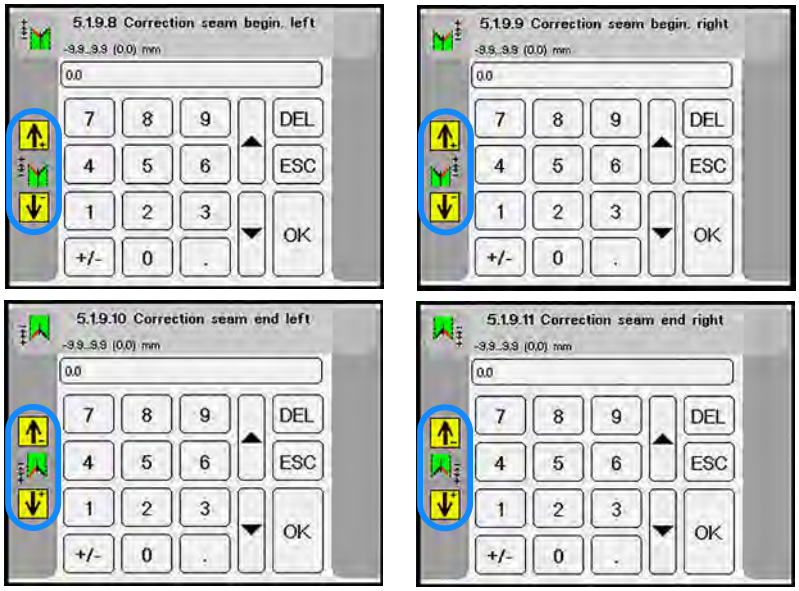
To adjust the corner knife:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting corner knife correction seam begin./seam end

Fig. 127: Adjusting corner knife correction seam begin./seam end



Information

The arrows in the left half of the display indicate the correction direction:

Seam beginning

 Correction outward

 Correction inward

Seam end

 Correction inward

 Correction outward

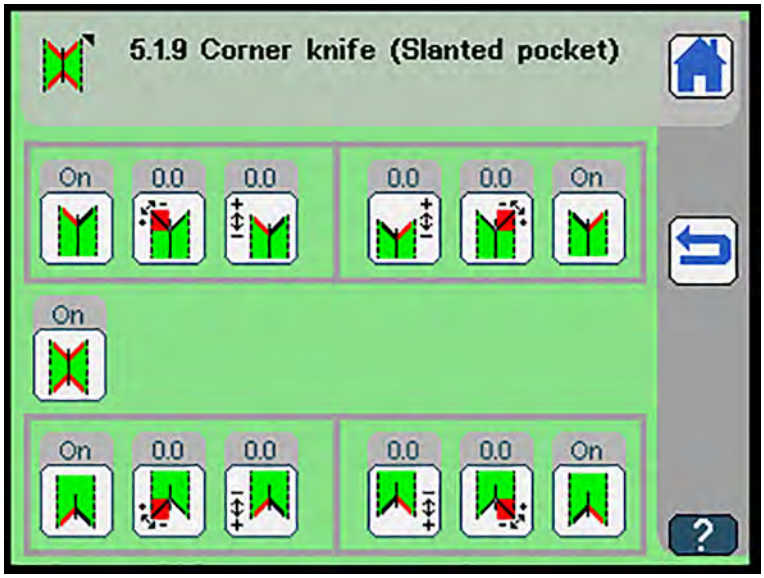
Corner knife (slanted pocket, multi-functional corner knife station)

Important

Before you can set the corner knife parameters for the slanted pocket, you must select the option Straight/Slanted pocket or multi-functional corner knife station in the submenu Corner knife device in the `Machine configuration` (📖 *p. 187*). After making the conversion in the `Machine configuration`, you must restart the machine.

↳ The display switches to `Corner knife (Slanted pocket)`.

Fig. 128: Corner knife (slanted pocket)



Symbols	Meaning
	All corner knives On/Off
	Corner knife seam begin. left On/Off
	Correct corner knife angle seam begin. left 📖 *p. 160* • -9.9° - 9.9°
	Correction seam begin. left 📖 *p. 159* • -9.9 mm - 9.9 mm
	Correction seam begin. right 📖 *p. 159* • -9.9 mm - 9.9 mm
	Correct corner knife angle seam begin. right 📖 *p. 160* • -9.9° - 9.9°
	Corner knife seam begin. right On/Off

Symbols	Meaning
	Corner knife seam end left On/Off
	Correct corner knife angle seam end left 📖 *p. 160* • -9.9° - 9.9°
	Correction seam end left 📖 *p. 159* • -9.9 mm - 9.9 mm
	Correction seam end right 📖 *p. 159* • -9.9 mm - 9.9 mm
	Correct corner knife angle seam end right 📖 *p. 160* • -9.9° - 9.9°
	Corner knife seam end right On/Off

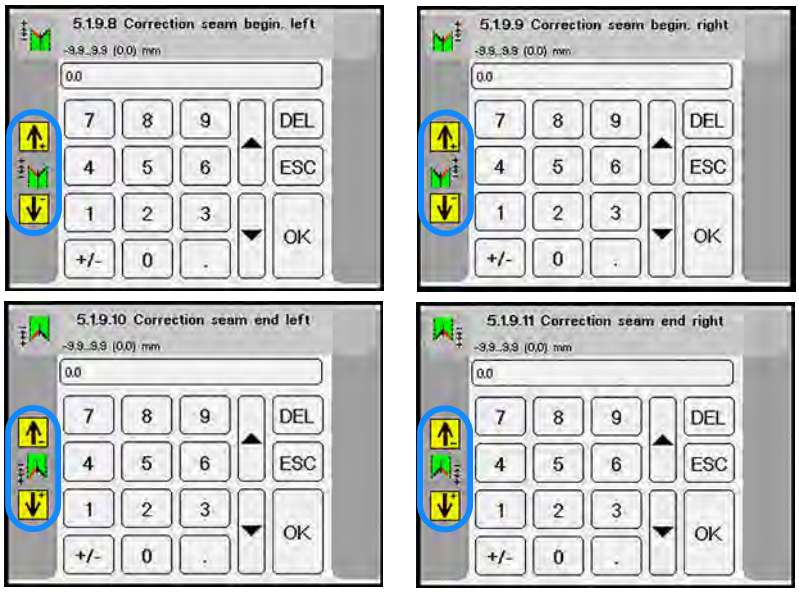


To adjust the corner knife:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

 **Adjusting corner knife correction seam begin./seam end**

Fig. 129: Adjusting corner knife correction seam begin./seam end



Information

The arrows in the left half of the display indicate the correction direction:

Seam beginning

Correction outward

Correction inward

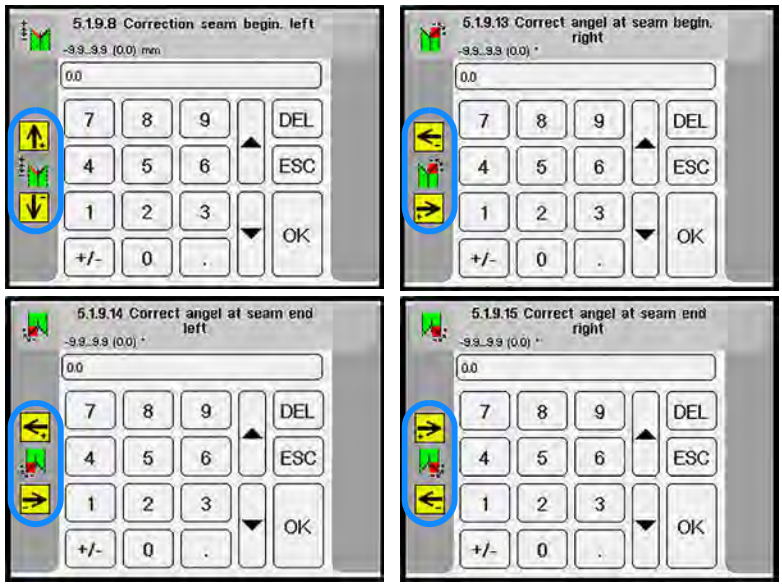
Seam end

Correction inward

Correction outward

Correcting corner knife angle seam begin./seam end

Fig. 130: Correcting corner knife angle seam begin./seam end



Information

The arrows in the left half of the display indicate the correction direction.

Seam beginning

 Correction inward (smaller angle)

 Correction outward (greater angle)

Seam end

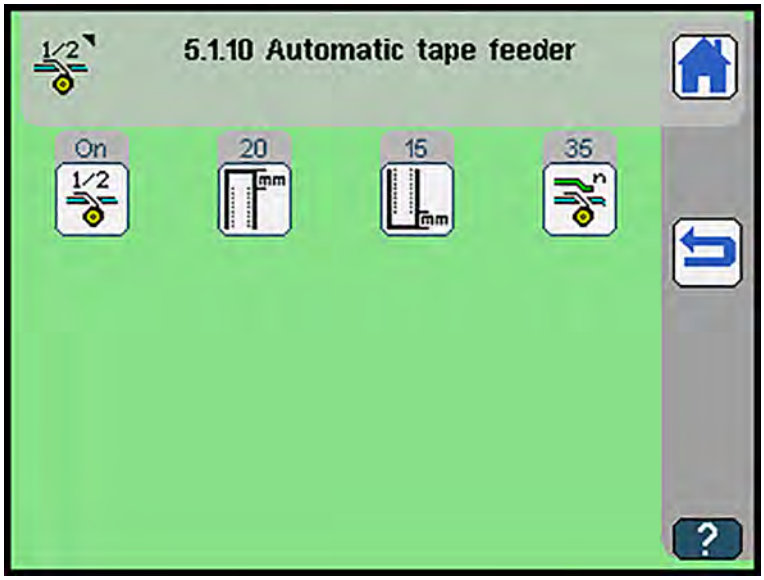
 Correction outward (greater angle)

 Correction inward (smaller angle)

Automatic tape feeder

↳ The display switches to `Automatic tape feeder`.

Fig. 131: Automatic tape feeder



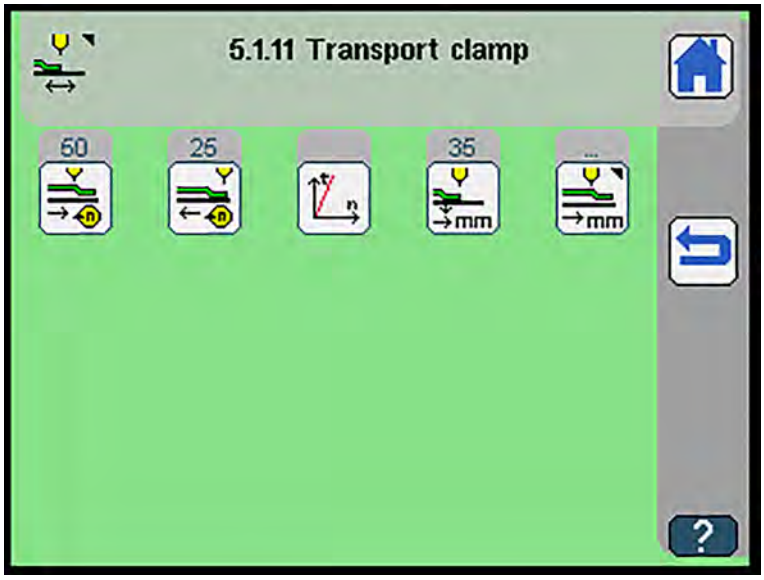
Symbols	Meaning
	Automatic tape feeder On/Off
	Adjust length of tape at seam begin. • 0 - 99 mm
	Adjust length of tape at seam end • 0 - 99 mm
	Adjust clamp speed during transport with tape feed switched on • 10 - 100 %



Transport clamp

↳ The display switches to `Transport clamp`.

Fig. 132: Transport clamp



Press a button to either open another submenu or enter the desired values directly using the numeric keypad.

Symbols	Meaning
	Adjust return speed • 10% - 100%
	Adjust insertion speed • 10% - 100%
	Adjust softstart for insertion speed •  Insertion speed fast •  Insertion speed middle •  Insertion speed slow
	Adjust return of transport clamp 📖 *p. 164* • Without transport • Transport up to stacking position • Transport up to loading position
	Adjust waiting position of transport clamp 📖 *p. 165*

To adjust the transport clamps:

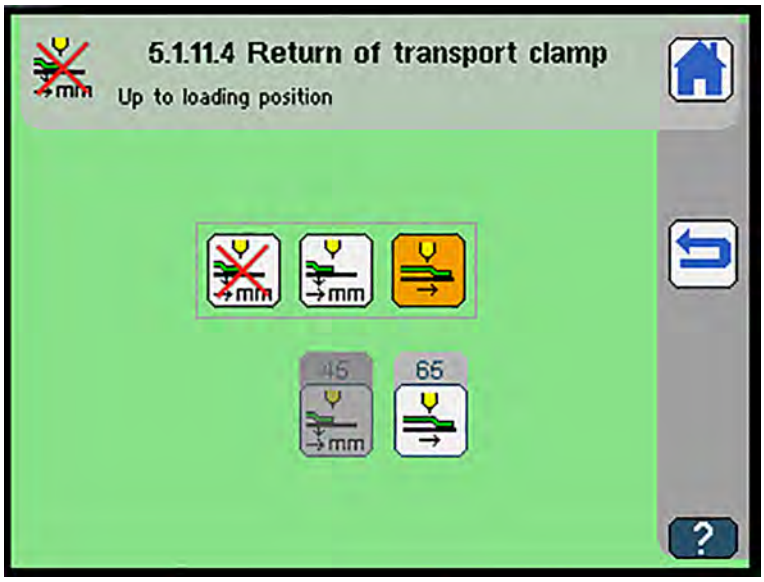
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Adjusting return of transport clamp

↳ The display switches to `Return of transport clamp`.

Fig. 133: Adjusting return of transport clamp



Symbols	Meaning
	Activate without transport
	Adjust transport up to stacking position • 60 1 mm - 100 mm
	Activate transport up to loading position
	• **Not active unless the option has been activated in the Global parameters** 📖 *p. 200* • The transport clamp automatically moves to the loading position after sewing before returning to its waiting position • 0 mm - 300 mm (set position of the loading position)

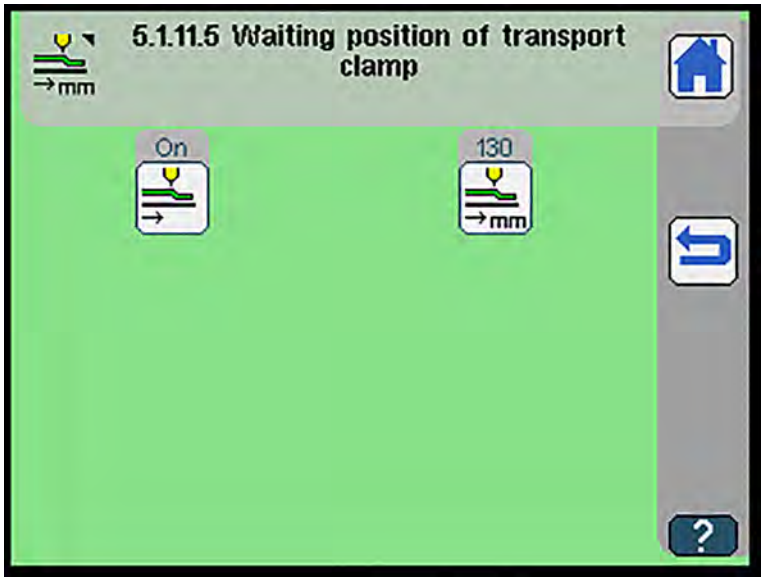
To adjust the transport clamp return:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting waiting position of transport clamp

↳ The display switches to *Waiting position of transport clamp*.

Fig. 134: Adjusting waiting position of transport clamp



Symbols	Meaning
	Waiting position of transport clamp On/Off
	Adjust up to waiting pos. of transport clamp • 1 mm - 515 mm

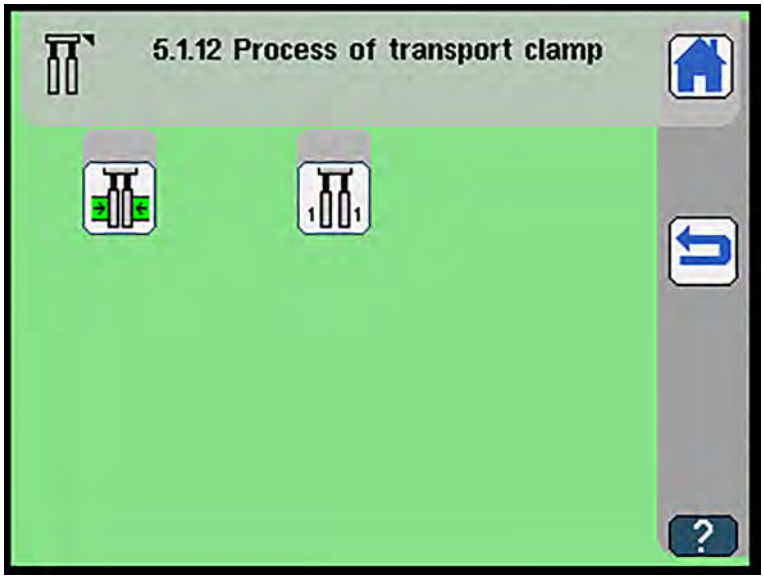
To adjust the waiting position of the transport clamp:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Process of transport clamp

↳ The display switches to `Process of transport clamp`.

Fig. 135: Process of transport clamp



Symbols	Meaning
	Transport clamp quick adjustment 🕮 *p. 167* • **only active if the transport clamp adjustment in the machine configuration is set to manual**
	Select process of transport clamp 🕮 *p. 168*
	Select piping type 🕮 *p. 169* • **only active if the transport clamp adjustment in the machine configuration is set to automatic**
	Spread transport clamp 🕮 *p. 170* • **only active if the transport clamp adjustment in the machine configuration is set to automatic**
	Adjust transport clamp pressure • Adjustment of the clamp to different materials (e. g. lining fabrics) • 30 - 100 %

To adjust the process of the transport clamp:

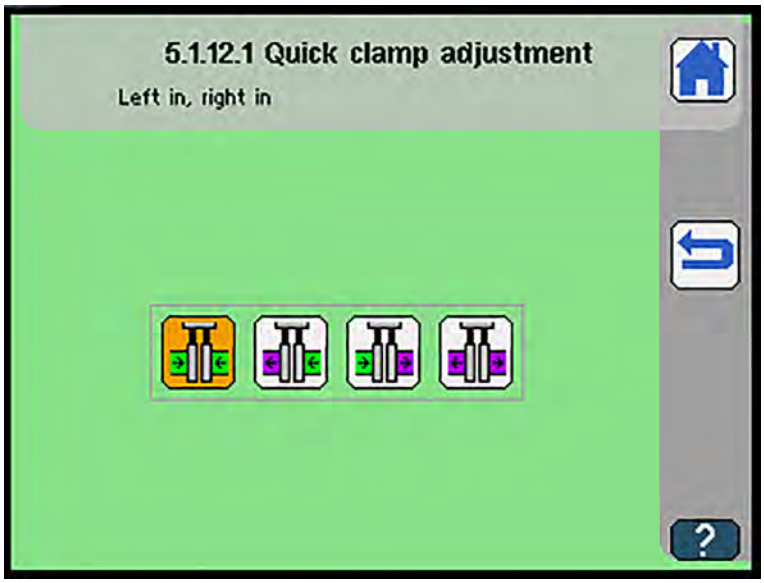
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Selecting transport clamp quick adjustment

The display switches to `Quick clamp adjustment`.

Fig. 136: Selecting transport clamp quick adjustment



Symbols	Meaning
	Left in, right in (double pipe)
	Left out, right in (single pipe left)
	Left in, right out (single pipe right)
	Left out, right out

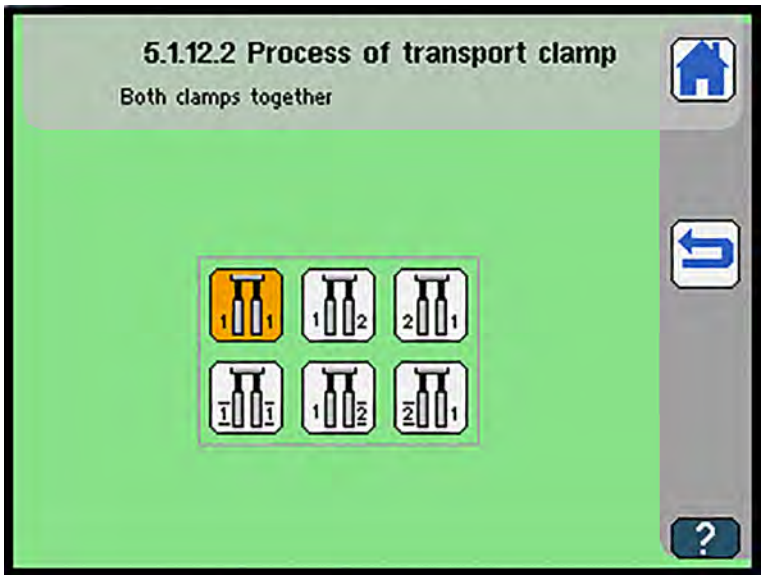
To select the transport clamp quick adjustment:

↳ Press the desired button.

Selecting process of transport clamp

The display switches to `Process of transport clamp.`

Fig. 137: Selecting process of transport clamp



Symbols	Meaning
	Lower both transport clamps together
	Lower left transport clamp first
	Lower right transport clamp first
	Depressurize both transport clamps together
	Lower left transport clamp first, depressurize right transport clamp
	Lower right transport clamp first, depressurize left transport clamp
	Vacuum off after lowering the left transport clamp
	Vacuum off after lowering the right transport clamp

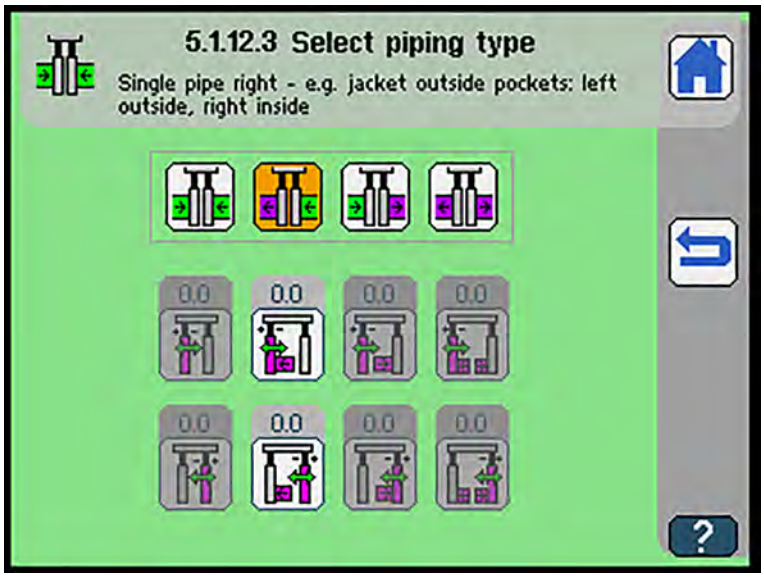
To select the process of the transport clamp:

1. Press the desired button.

Selecting the piping type

The display switches to *Select piping type.*

Fig. 138: Select the piping type



Symbols	Meaning
	Left in, right in (double pipe) • Correction clamp left inside, double pipe -9.9 mm - 9.9 mm • Correction clamp right inside, double pipe -9.9 mm - 9.9 mm
	Left out, right in (single pipe left) • Correction clamp left outside, single pipe left -9.9 mm - 9.9 mm • Correction clamp right inside, single pipe left -9.9 mm - 9.9 mm
	Left in, right out (single pipe right) • Correction clamp left inside, single pipe right -9.9 mm - 9.9 mm • Correction clamp right outside, single pipe right -9.9 mm - 9.9 mm
	Left out, right out (custom applications) • Correction clamp left outside -9.9 mm - 9.9 mm • Correction clamp right outside -9.9 mm - 9.9 mm

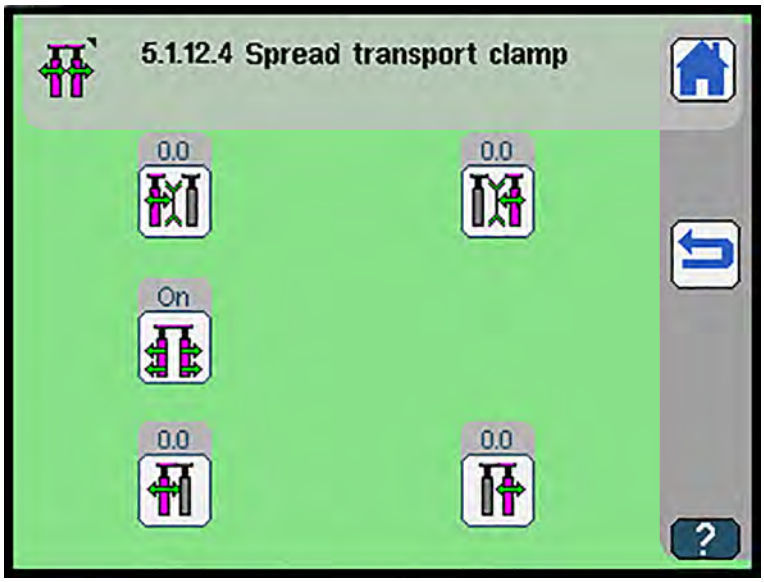
To select the piping type:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Spreading the transport clamp

The display switches to *Spread transport clamp*.

Fig. 139: Spreading the transport clamp



Symbols	Meaning
	Correction value left **before** corner cut • -1.0 mm - 1.0 mm
	Correction value right **before** corner cut -1.0 mm - 1.0 mm
	Spread transport clamp On/Off
	Spread clamp left **before** transport start • -1.0 mm - 1.0 mm
	Spread clamp right **before** transport start • -1.0 mm - 1.0 mm

To spread the transport clamp:

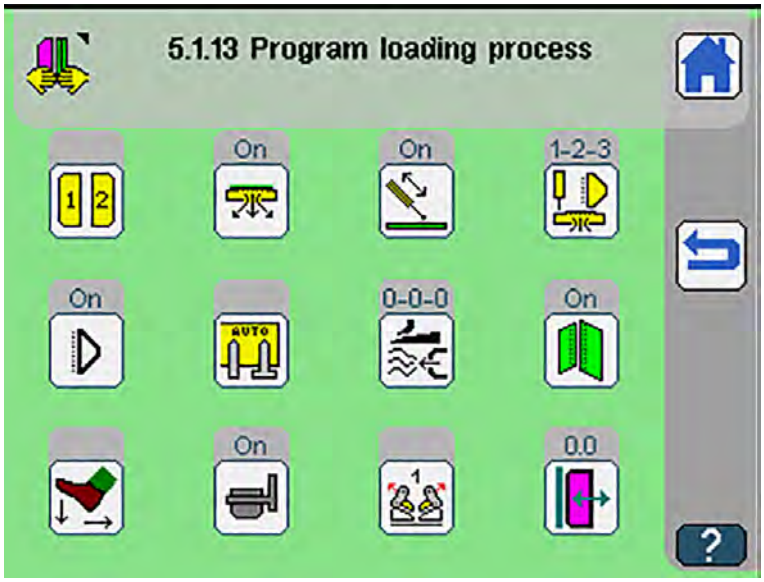
1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.



Programming loading process

↳ The display switches to `Program loading process`.

Fig. 140: Program loading process



Press a button to either open another submenu or enter the desired values directly using the numeric keypad.

Symbols	Meaning
	Select flap clamps •  Both flap clamps close together •  Left flap clamp closes first •  Right flap clamp closes first
	Vacuum On/Off
	Downholder On/Off **(only for 755 B and 756 B)**
	Select downholder mode 🕮 *p. 173* **(only for 755 B and 756 B)**
	Waistband clamp On/Off **(only for 755 B and 756 B)**

Symbols	Meaning
	Select pocket bag clamp mode • **only for 755 B and 756 B** •  Load mode from left •  Press pedal backwards for pocket bag clamp •  Open pocket bag clamp automatically
	Select blowing mode 🕮 *p. 175*
	Breast welt mode On/Off • **breast welt mode depends on the equipment; folder and transport clamp must be replaced**
	Select pedal mode 🕮 *p. 178*
	Feeding device On/Off
	Feeding device mode •  Swivel out without lowering (Standard mode for fast reloading of all additional parts) •  Feeding device remains swiveled in, without lowering (e. g. for zipper) •  Feeding device remains swiveled in, with lowering before closing the flap clamps (e. g. for zipper or thin, dull flaps) •  Feeding device remains swiveled in, with lowering after closing of the flap clamps (e. g. for thin, dull flaps) •  Swivel out with lowering before closing the flap clamps (e. g. thick, stiff flaps) •  Swivel out with lowering after closing the flap clamps (e. g. thick, stiff flaps)
	Flap width correction factor (**not possible unless feeder, plain material pattern detection, and light barrier are active**🕮 *p. 132*)



To program the loading process:

1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

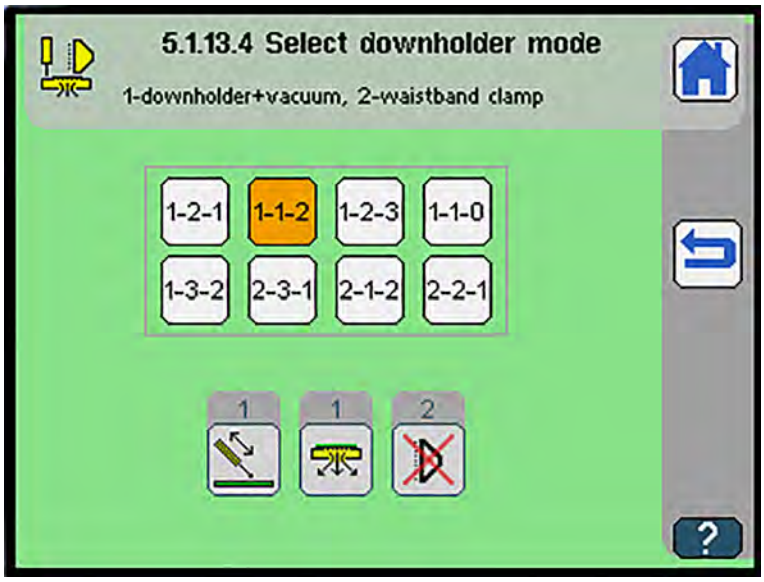
Selecting downholder mode

Information

Downholder, vacuum and waistband clamp must be activated in the machine configuration (📖 *p. 187*).

↳ The display switches to `Select downholder mode`.

Fig. 141: Selecting downholder mode



Symbols	Meaning
1-2-1	1: Downholder + waistband clamp 2: Vacuum
1-1-2	1: Downholder + vacuum 2: Waistband clamp
1-2-3	1: Downholder 2: Vacuum 3: Waistband clamp
1-1-0	1: Downholder + vacuum Waistband clamp off
1-3-2	1: Downholder 2: Waistband clamp 3: Vacuum

Symbols	Meaning
	1: Waistband clamp 2: Downholder 3: Vacuum
	1: Vacuum 2: Downholder + waistband clamp
	1: Waistband clamp 2: Downholder + vacuum



To select downholder mode:

1. Press the desired button.



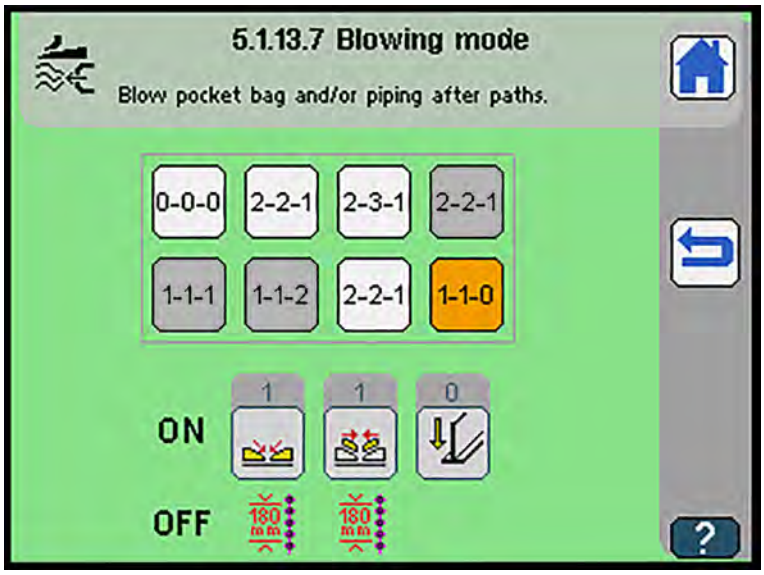
Information

The numbering of the buttons downholder  , vacuum  and waistband clamp  in the lower half of the display changes with the selected setting.

Adjusting blowing mode

↳ The display switches to `Blowing mode`.

Fig. 142: Adjusting blowing mode



Symbols	Meaning
0-0-0	Function off
2-2-1	1: Lower folder 2: Blowing ON at flap clamp + folding plate
2-3-1	1: Lower folder 2: Blowing ON at folding plate 3: Blowing ON at flap clamp
2-2-1	1: Lower folder 2: Blowing ON at flap clamp, blowing ON at folding plate for 10 mm seam path • **Not active in 755 A and 756 A**
1-1-1	1: Lower pickup folder, blowing ON at flap clamp + folding plate • **Not active in 755 A and 756 A**
1-1-2	1: Blowing ON at flap clamp + folding plate 2: Lower folder • **Not active in 755 A and 756 A**
2-2-1	1: Lower folder 2: Blowing ON at folding plate 180 mm + blowing ON at flap clamp
1-1-0	1: Blowing ON at flap clamp, blowing ON at folding plate for 180 mm seam path

To select blowing mode:

1. Press the desired button.

Information

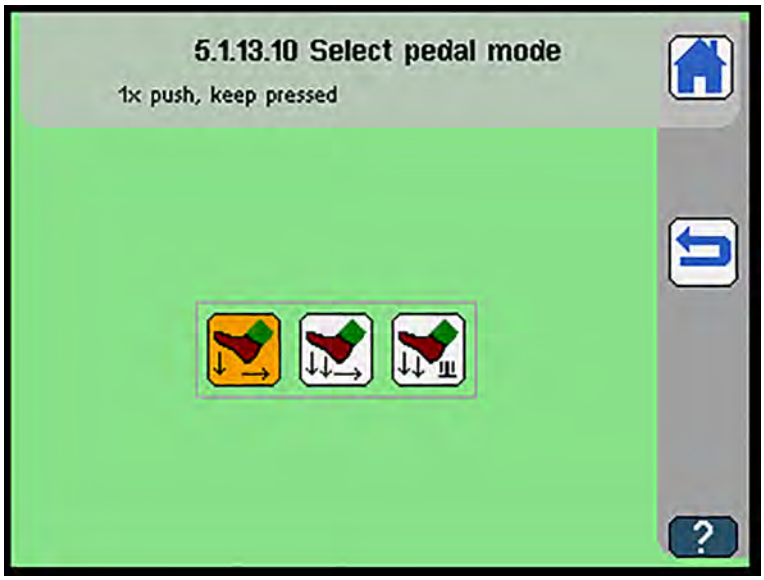
The numbering of the buttons folding plate  , flap clamp  and lower pickup folder  in the lower half of the display changes with the selected setting.

		Valve Y32			Valve Y124			
Mode	**Method**	**Position**	**Blowing ON**	**Blowing OFF**	**Position**	**Blowing ON**	**Blowing OFF**	**Sequence**
Mode 0 			-	active		-	active	Function off
Mode 1 	A-B-F	Blow tube in folding plate	Folding plate closed	Needles ON	Blow tube in flap clamps	Flap clamps closed	Needles ON	Blow pocket bag and/or piping to the seam beginning simultaneously.
Mode 2 	A-B-F	Blow tube in folding plate	Folding plate closed	Flap clamps closed	Blow tube in flap clamps	Flap clamps closed	Needles ON	Blow pocket bag and piping alternately up to seam beginning.
Mode 3 	B-F	Blow tube in folding plate	Lower folder	10 mm after loading position	Blow tube in flap clamps	Flap clamps closed	10 mm after loading position	Blow pocket bag and/or piping briefly. Blow piping already while folder is lowering.
Mode 4 	B-F	Blow tube in folding plate	Lower folder	Flap clamps closed	Blow tube in flap clamps	Flap clamps closed	Needles ON	Blow pocket bag and piping alternately up to the seam beginning. Blow piping during the lowering of the folder already.
Mode 5 	B	Blow tube in flap clamp right	Flap clamp closed	Needles ON	Blow tube in flap clamp left	5 mm after loading position	Needles ON	Blow pocket bag on flap.
Mode 6 	A-B-F	Blow tube in folding plate	Folding plate closed	180 mm after loading position	Blow tube in flap clamps	Flap clamps closed	Needles ON	Blow pocket bag and/or piping at the same time. Blow piping after path.
Mode 7 	A-B-F	Blow tube in folding plate	20 mm after loading position	180 mm after loading position	Blow tube in flap clamps	10 mm after loading position	180 mm after loading position	Blow pocket bag and/or piping after paths.

Selecting pedal mode

↳ The display switches to *Select pedal mode*

Fig. 143: Selecting pedal mode



Symbols	Meaning
	Press pedal 1 x and keep it there • the loading process is completed without stop
	Push pedal after each step • Vacuum, downholder and transport clamp are each triggered with one step during the loading process • the sewing process starts after the flap clamps have been lowered
	Transport clamp start after pushing pedal • Vacuum, downholder and transport clamp are each triggered with one step during the loading process • The flap clamps can be opened or closed again after the flap clamps have been lowered, and the sewing process is started

To select pedal mode:

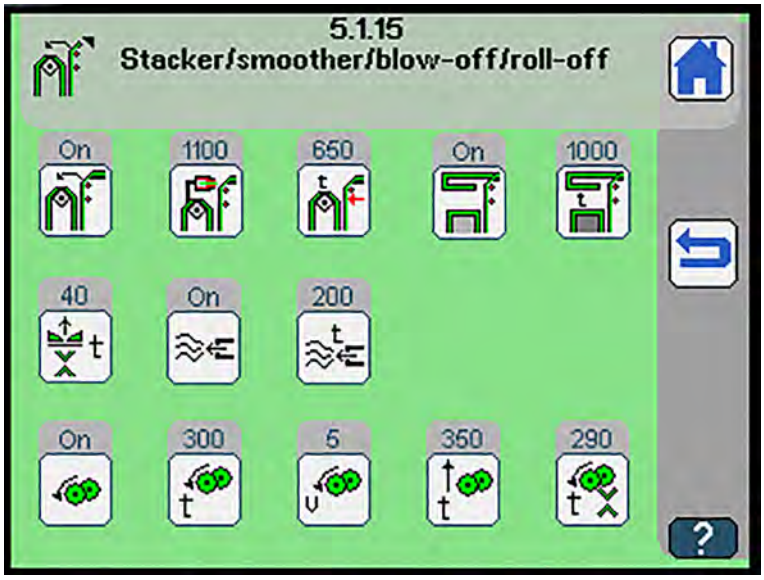
1. Press the desired button.



Stacker/smoother/blow-off/roll-off

↳ The display switches to *Stacker/smoother/blow-off/roll-off*.

Fig. 144: Stacker/smoother/blow-off/roll-off



Symbols	Meaning
	Stacker On/Off • **only with active throw-over stacker or pincer stacker**
	Adjust duration of grip stacker signal • **only with active pincer stacker** • 0 ms - 2000 ms
	Select earlier clamping time • **only with active throw-over stacker** • 0 ms - 1000 ms
	Smoother On/Off • **only with active smoother**
	Adjust duration of smoother signal • **only with active smoother** • 0 ms - 1000 ms
	Adjust delayed lifting of transport clamp after corner cut • 0 ms - 1000 ms
	Blow-off On/Off • **only with active blow-out device**
	Adjust the duration for which the blow-out device will be blowing • **only with active blow-out device** • 0 ms - 1000 ms
	Roll-off On/Off

Symbols	Meaning
	Adjust roll-off time • 0 ms - 3000 ms
	Adjust roll-off speed • 1 - 15
	Adjust time after roll-off until lift-up • 0 ms - 1000 ms
	Adjust roll-off: Time after corner cut • 0 ms - 1000 ms



To adjust the stacker, the smoother, the blow-out device, and the outfeed roller:

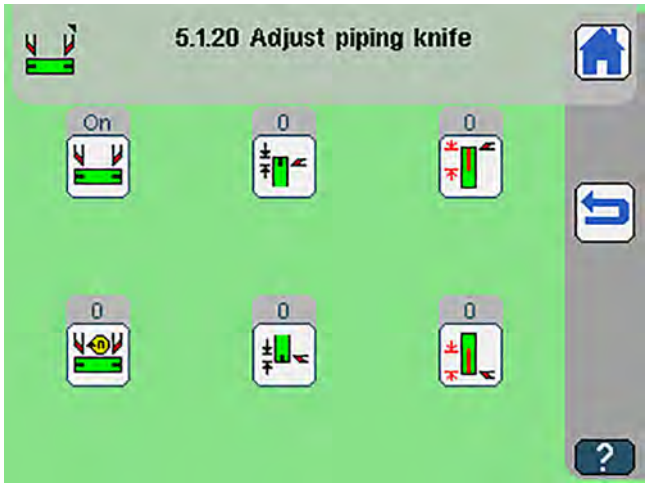
1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.



Adjusting piping knife

↳ The display switches to `Adjust piping knife`.

Fig. 145: Adjusting piping knife



Symbols	Meaning
	Piping knife On/Off
	Adjust cutting position at seam beginning • Value range: 0 - 150 mm
	Adjust cutting length at seam beginning • Value range: 0 - 120 mm
	Adjust piping knife speed • Value range: 10 - 100%
	Adjust cutting position at seam end • Value range: 0 - 150 mm
	Adjust cutting length at seam end • Value range: 0 - 120 mm



To adjust the piping knife:

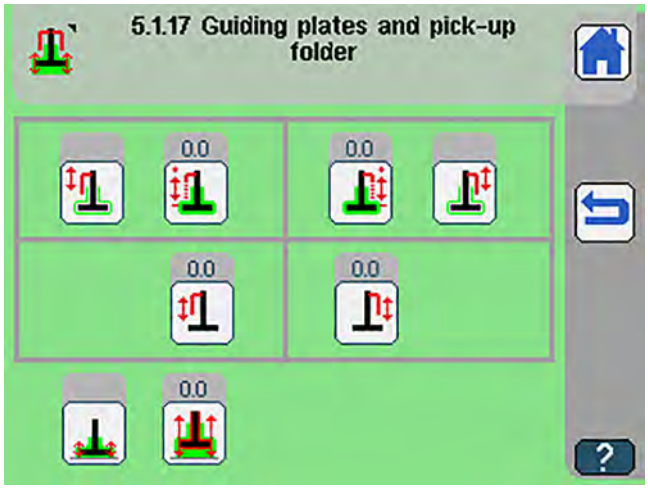
1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.



Adjusting guiding plates and folder

↳ The display switches to `Guiding plates and folder`.

Fig. 146: Adjusting guiding plates and folder



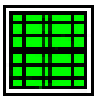
Symbols	Meaning
	Guiding plates and folder left • thin • middle • thick
	Adjust offset value left • Value range: -2 - 2 mm
	Adjust offset value right • Value range: -2 - 2 mm
	Guiding plates and folder right • thin • middle • thick
	Lift guiding plates left (lift up to seam beginning, for extra thick material) • Value range 0 - 6 mm

Symbols	Meaning
	Lift guiding plates right (lift up to seam beginning, for extra thick material) Value range 0 - 6 mm
	Folder height •  down •  middle •  top
	Adjust folder height offset value • Value range: 0 - 6 mm



To adjust the guiding plates and the folder:

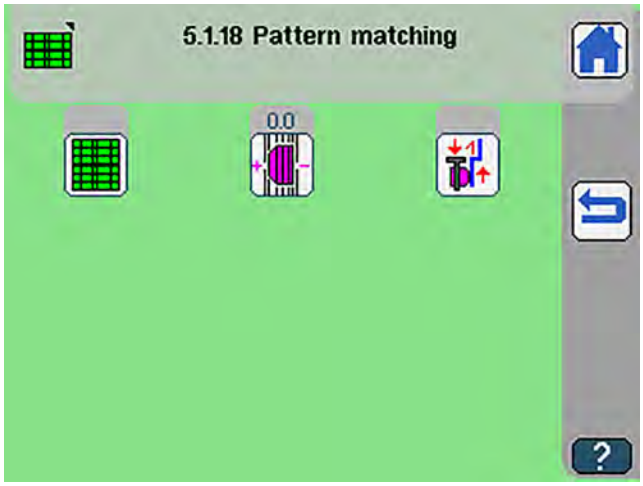
1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.



Pattern matching

↳ The display switches to `Pattern matching`.

Fig. 147: Pattern matching



Symbols	Meaning
	Patterned or plain material
	Flap projection • -3.0 mm - 3.0 mm
	Flap stopper 📖 *p. 185*

Flap stopper

↳ The display switches to `Flap stopper`.

Fig. 148: Flap stopper



Symbols	Meaning
	The flap stopper automatically rises after the flap clamp is closed
	The flap stopper can be alternately raised and lowered using the left pedal
	The flap stopper rises and lowers together with the turning device

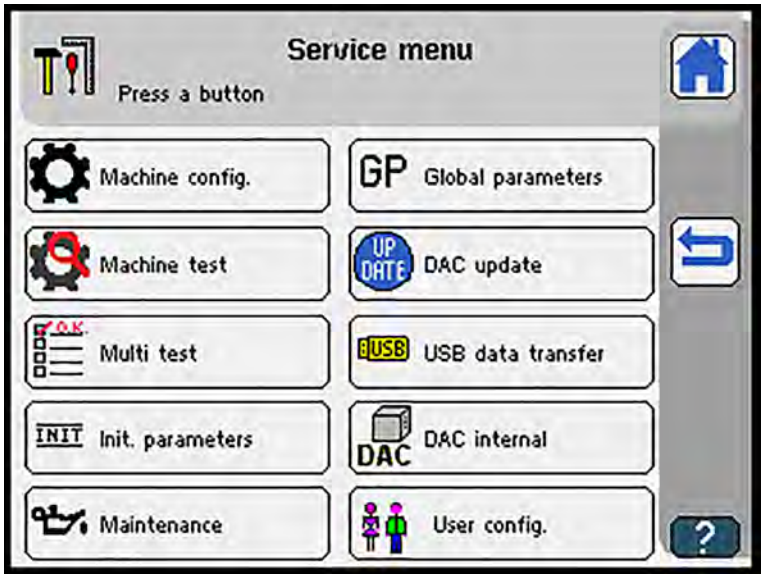
Service menu

To access the service menu:

1. Press the **Service menu** button .

↳ The display switches to the *Service menu*.

Fig. 149: Service menu



Button	Meaning
Maschinenkonfig.	Configure machine settings 🕮 *p. 187*
GP Globale Parameter	Adjust basic machine parameters 🕮 *p. 197*
Maschinentest	Test and set individual machine functions 🕮 *p. 204*
DAC-Update	Perform system updates 🕮 *p. 254*
Multitest	Test machine settings 🕮 *p. 257*
USB-Datentransfer	Read/write data to/from a USB key 🕮 *p. 269*
Parameter init.	Initialize machine parameters 🕮 *p. 276*

Button	Meaning
DAC-intern	Only available to Dürkopp Adler • Adjust internal machine parameters
Wartung	Show software version, set date/time, show internal information p. 278
Benutzerkonfig.	Adjust language, button beep and user password p. 281

To set the parameters in the service menu:

1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

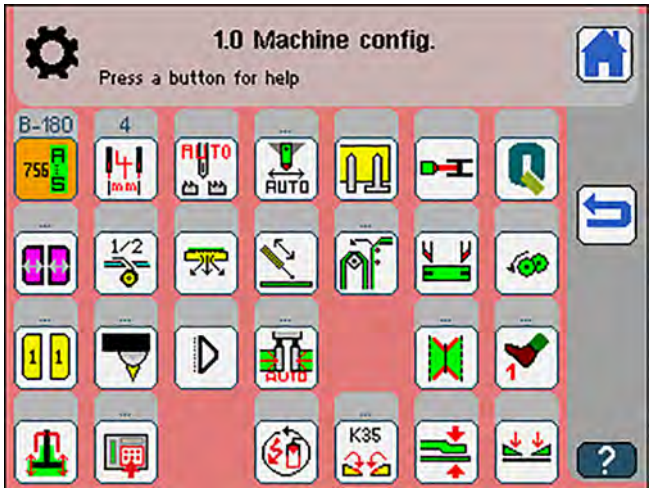
Machine configuration

Important

The *Machine configuration* menu is protected with a password. You use this menu to set basic machine functions. The password is 25483.

↳ The display switches to *Machine config.*.

Fig. 150: Machine configuration



Press a button to either open another submenu or select the desired options directly.

Symbol	Description
	Select working method 📖 *p. 190* • Class • Working method • Maximal sewing length
	Select needle distance 📖 *p. 191*
	Needle transport On/Off
	Programmable marking lamps On/Off
	Pocket bag clamp On/Off
	Hook thread monitor On/Off • If **activated**, the hook thread monitor does not appear in the Global parameters 📖 *p. 197* • If the hook thread monitor is **deactivated**, the maximum bobbin thread counter appears in the Global parameters and must be configured manually 📖 *p. 197*
	QONDAC On/Off
	Feeding device and programmable flap stopper 📖 *p. 192*
	Tape feeder On/Off
	Vacuum On/Off
	Downholder On/Off **(only for 755 B and 756 B)**
	Select stacker/pincer stacker/smoother/blow-out device •  Stacker not available •  Throw-over stacker •  Pincer stacker •  Smoother •  Blow-out device
	Piping knife On/Off

Symbol	Description
	Roll-off On/Off
	Select flap clamps •  no flap clamp •  left flap clamp only •  right flap clamp only •  left and right flap clamp
	Light barrier scan 📖 *p. 193*
	Waistband clamp On/Off **(only for 755 B and 756 B)**
	Transport clamp adjustment •  manual •  automatic
	Corner knife device •  without corner knife device •  straight pocket (manual corner knife device) •  straight pocket (automatic corner knife device) •  straight/slanted pocket (automatic corner knife device) •  multi-functional corner knife device
	Pedal operation 📖 *p. 194*
	Programmable guiding plates and folder height ON/OFF
	Toolbox configuration 📖 *p. 195*
	Uninterrupted power supply ON/OFF

Symbol	Description
	Select transport clamp type •  K35 •  K69 **(Not active in 755 B and 756B/F)** •  K40 •  K6 **(Not active in 755 B and 756B/F)**
	Shims On/Off
	Adjustable transport clamp pressure On/Off



To adjust the machine configuration:

1. Press the desired button.

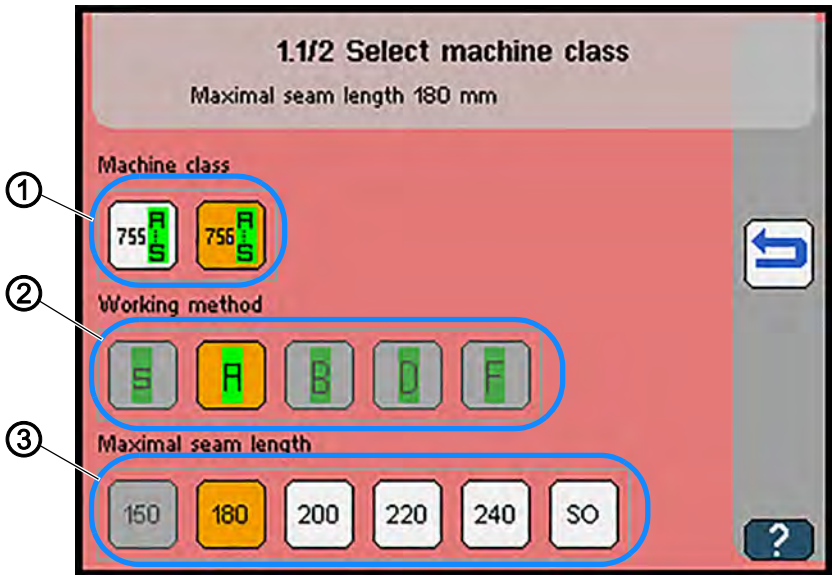
↳ The user interface for setting the desired item is displayed.



Selecting working method

The display switches to *`Select machine class`*:

Fig. 151: Selecting the machine class



(1) - Class
(2) - Working method
(3) - Maximal seam length



To select the machine class and the matching seam length:

1. Select the desired class (1).
2. Select the desired working method (2).

3. Select the desired maximal seam length (3).

Information

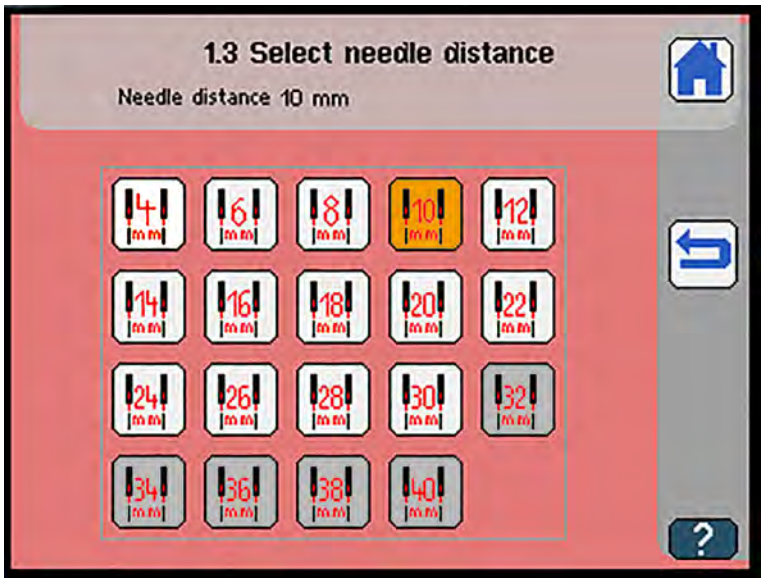
The maximum seam lengths depend on the equipment.

When you switch to another class, tools that are not available for the selected class may be removed from the toolbox on the start screen.

Selecting needle distance

↳ The display switches to `Select needle distance`:

Fig. 152: Selecting the needle distance



To select the needle distance:

1. Select the desired needle distance.

Feeder and programmable flap stopper

↳ The display switches to *Feeder and programmable flap stopper*:

Fig. 153: Feeder and programmable flap stopper



Symbol	Meaning
	automatic flap feeder deactivated
	automatic flap feeder active
	programmable flap stopper
	programmable flap stopper right and left

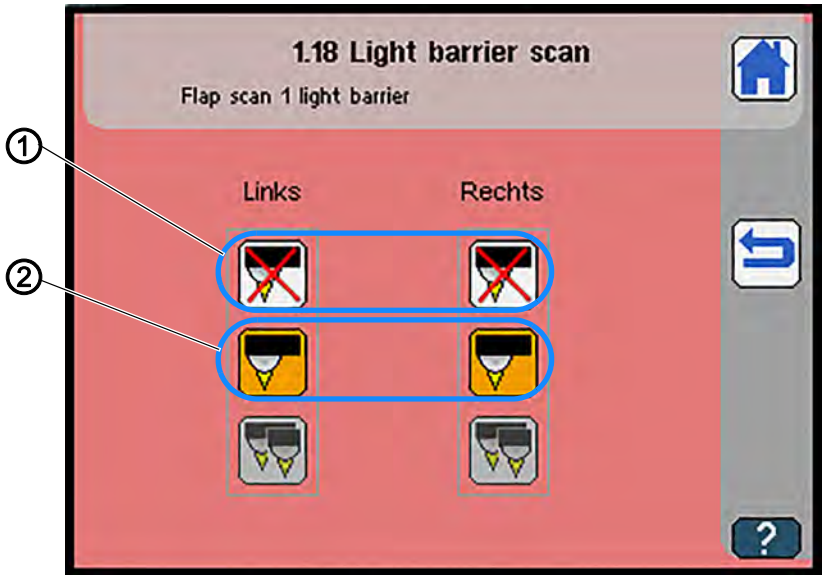
To adjust the feeder:

1. Press the desired button.

Light barrier scan

↳ The display switches to `Light barrier scan`:

Fig. 154: Light barrier scan



(1) - Light barrier scan Off *(2) - Flap scan with 1 light barrier left/right*

To adjust the light barrier scan:

1. Press the desired button.

↳ The settings for the left and the right light barrier can be configured separately.

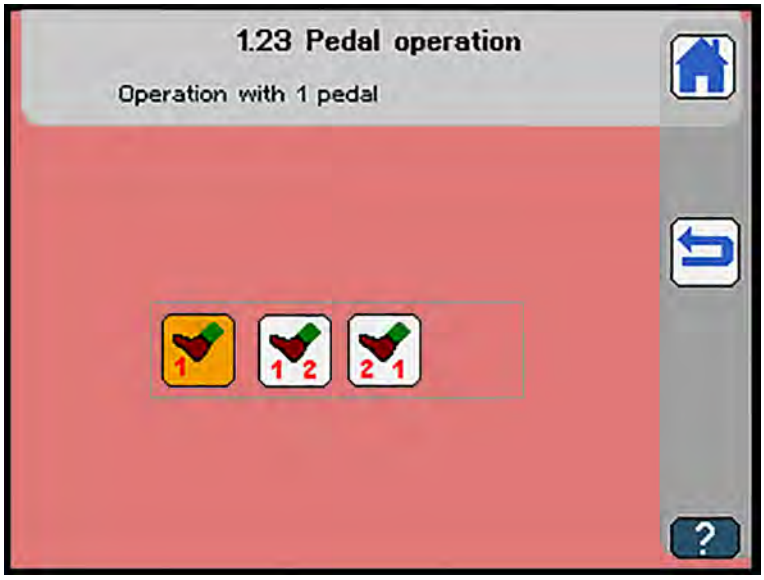
Information

The available options vary with the selected class.
You can configure no more than 4 light barriers at a time.

Pedal operation

↳ The display switches to `Pedal operation`.

Fig. 155: Pedal operation



Symbol	Meaning
	Operation with 1 pedal
	Operation with 2 pedals • 1st pedal right (function pedal) • 2nd pedal left
	Operation with 2 pedals • 1st pedal left (function pedal) • 2nd pedal right

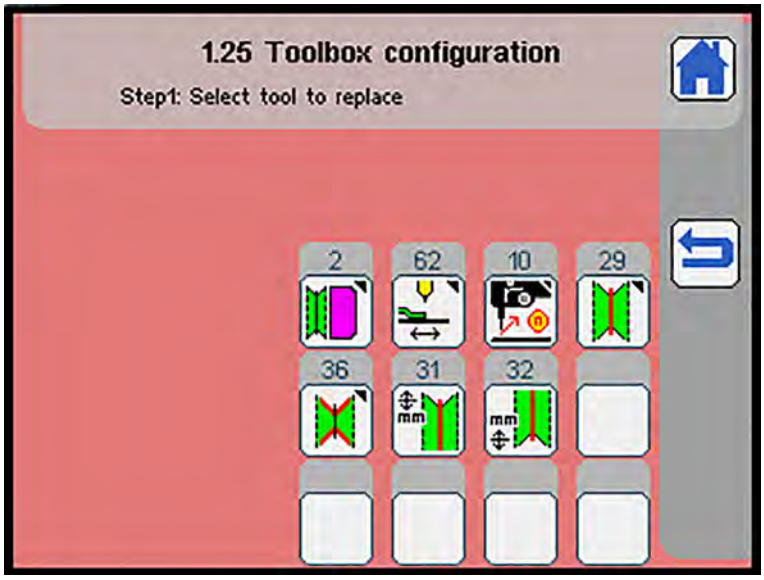
To adjust the pedal operation:

Press the desired button.

Toolbox configuration

↳ The display switches to *Toolbox configuration*.

Fig. 156: Toolbox configuration (1)



The toolbox can be loaded with 12 tools.
These 12 tools are linked in a quick-access menu on the start screen.
Empty fields indicate that no tool has been selected for this position yet.
Depending on the class and method, the display will only show the tools available and configured for that class and method.

To configure the toolbox:

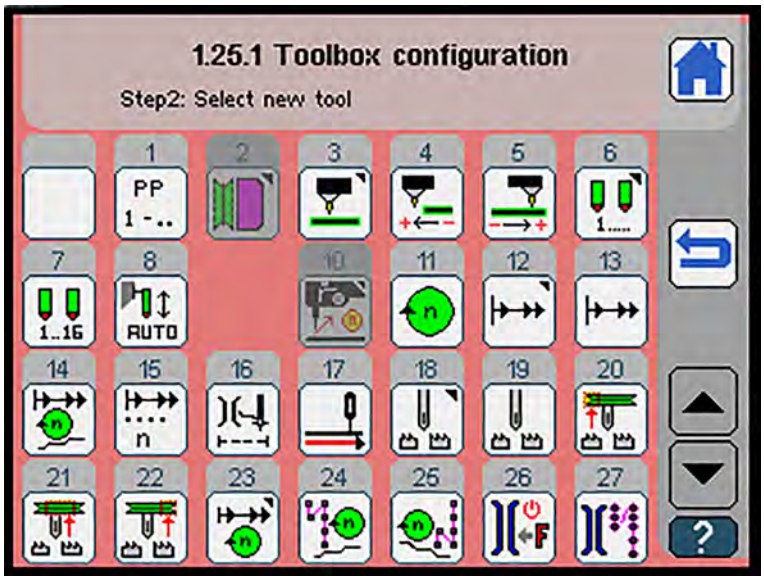
1. Press on a blank field to assign an available position.

OR

1. Press on a position that has already been assigned in order to change the setting.

↳ The display switches to an overview of the possible tools. Tools that have already been selected are highlighted in gray.
The display will only show the tools available for the selected class.

Fig. 157: Toolbox configuration (2)



Information

You can use the button [ ] to remove a previously selected tool from the toolbox again.

Tools already in use are grayed out.

2. To navigate up and down the list, use the arrow buttons [▲] [▼].
3. Press the selected tool to select it.

↳ The display returns to `Machine config.`

Global parameters

Important

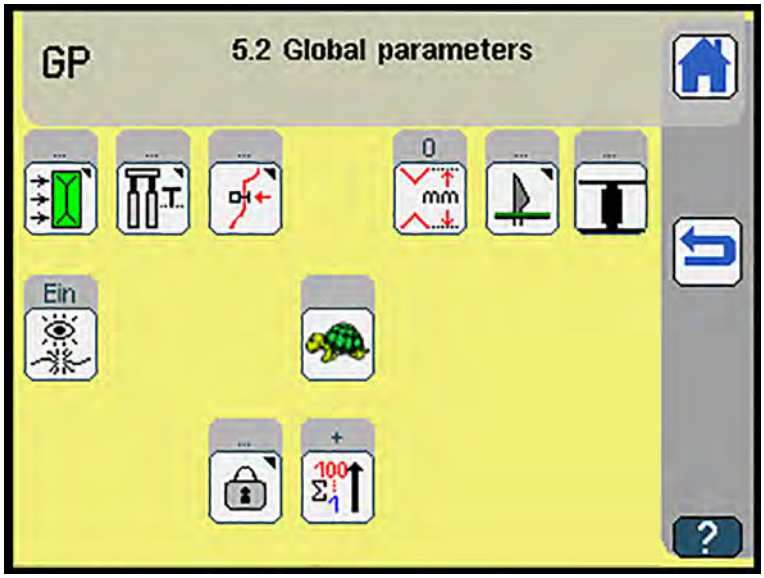
The *Global parameters* is protected with a password. You use this option to set the program parameters for all pocket programs.
The password is 25483.

Information

If an option is not available or grayed out, it must be set up in the *Machine configuration* menu (📖 *p. 187*). Otherwise, the option will be unavailable in this class.

↳ The display switches to *Global parameters*.

Fig. 158: Global parameters



Press a button to either open another submenu, enter the desired values directly using the numeric keypad or select the desired options directly

Symbol	Description
	Adjust positioning point seam begin./center/end •  Adjust positioning point seam begin. (100 mm - 300 mm) •  Adjust positioning point seam center (100 mm - 300 mm) •  Adjust positioning point seam end (100 mm - 300 mm)
	Adjust transport clamp 📖 *p. 200*
	Adjust needle thread-clamp/-catcher/-tension 📖 *p. 201*
	Adjust corner knife distance (reference pocket length) • 20 - 240 mm
	Adjust corner knife •  Adjust cutting duration (0 ms - 1000 ms)
	set maximum hook thread counter • **only visible in global parameters if hook thread monitor is deactivated in the machine configuration** 📖 *p. 188* •  Maximum hook thread counter On/Off •  Use the numeric keypad to enter the length of the hook thread in meters which will fit on the bobbin
	Adjust guiding plates and folder height 📖 *p. 202*
	Needle thread monitor On/Off
	Select flap clamp feeding mode •  open both together •  Pedal forward = open left Pedal back = open right

Symbol	Description
	Transport clamp quick adjustment • **only visible in global parameters if transport clamp adjustment is set to AUTOMATIC in the machine configuration** •  without bypass •  bypass left •  bypass right •  bypass left and right
	Adjust machine process speed •  slow •  middle •  fast
	Adjust password protection 📖 *p. 203*
 	Adjust counting direction of piece counter UP **OR** Adjust counting direction of piece counter DOWN
	Knitwear mode On/Off • only in combination with needle transport. The needle transport is set via the sewing head parameters 📖 *p. 150*



To set the global parameters:

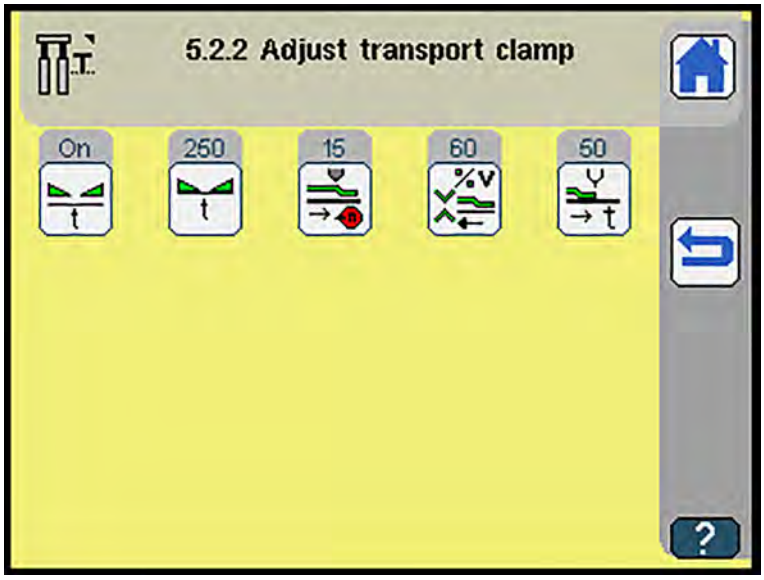
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Adjusting the transport clamp

↳ The display switches to `Adjust transport clamp`.

Fig. 159: Adjusting the transport clamp



Symbol	Meaning
	Lower transport clamp automatically On/Off
	Adjust delayed lifting of transport clamp • 0 ms - 1000 ms
	Adjust transport clamp speed to waiting position • 10% - 100%
	Adjust transport clamp speed to corner knife • 10% - 100%
	Adjust waiting time until transport clamp moves to seam begin. • Return transport delayed • 0 ms - 1000 ms
	Automatic transport clamp return On/Off • is set in the program parameters 🕮 *p. 164*

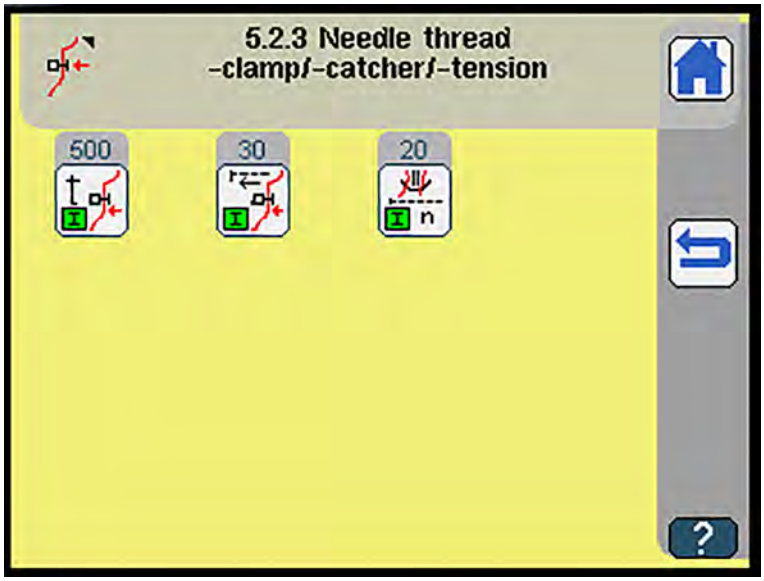
To adjust the transport clamp:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting needle thread-clamp/-catcher/-tension

↳ The display switches to *Needle thread-clamp/-catcher/-tension*.

Fig. 160: Adjusting needle thread-clamp/-catcher/-tension



Symbol	Meaning
	Adjust time: loosen needle thread clamp (seam beginning) • 0 ms - 1000 ms
	Adjust seam end: mm till thread clamp opens • 0 mm - 100 mm
	Adjust mm with needle thread catcher open • 0 mm - 50 mm

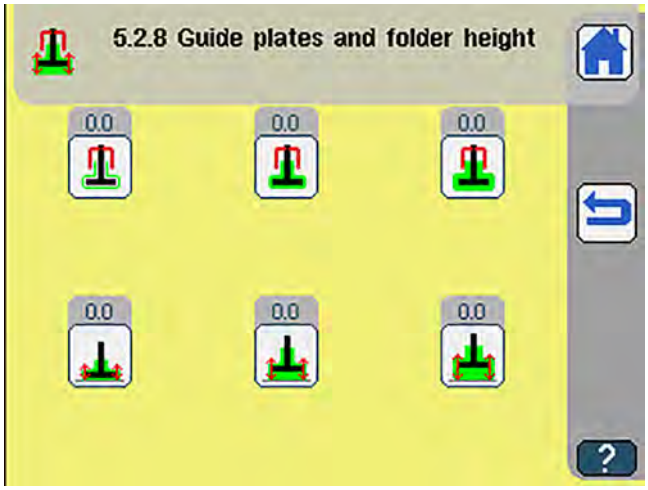
To adjust the needle thread clamp, the needle thread catcher and the needle thread tension:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Guiding plates and folder height

↳ The display switches to `Guide plates and folder height`.

Fig. 161: Guiding plates and folder height



Symbol	Meaning
	Default Guiding Plate thin • 0 - 10 mm
	Default Guiding Plate middle • 0 - 10 mm
	Default Guiding Plate thick • 0 - 10 mm
	Default Folder Height down • 0 - 6 mm
	Default Folder Height middle • 0 - 6 mm
	Default Folder Height top • 0 - 6 mm

To adjust the guiding plates and the folder height:

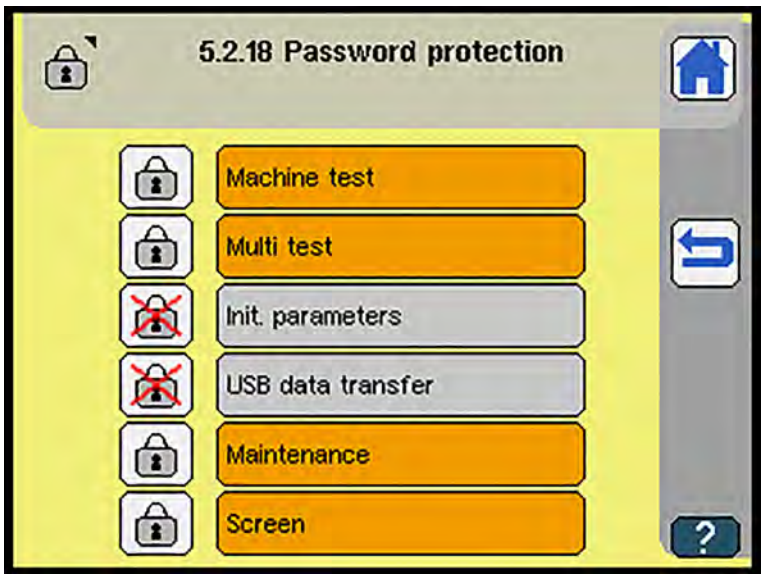
1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting password protection

You use this menu to switch the default passwords for the levels listed below on or off.

↳ The display switches to `Adjust password protection`:

Fig. 162: Adjusting password protection



To adjust password protection:

1. Press the button in front of the desired area to enable or disable password protection.

Information

Locking the screen requires that you assign a user password (📖 *p. 283*).

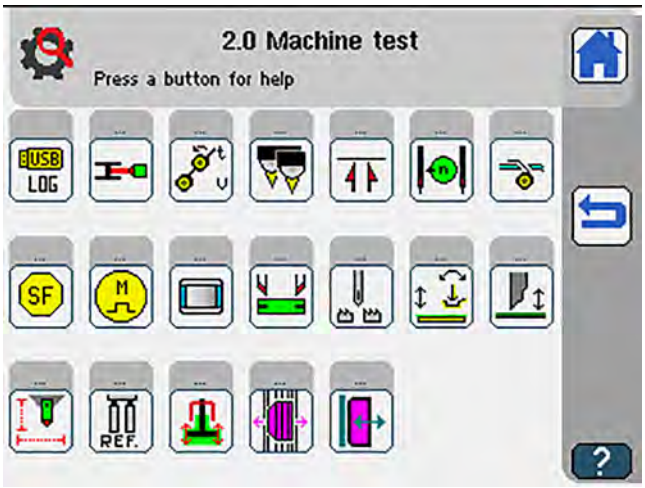
Machine test

Important

The `Machine test` menu is protected with a password. You use this option to test assemblies and eliminate errors. The password is 25483.

↳ The display switches to `Machine test`.
The display varies with the machine configuration (📖 *p. 187*).

Fig. 163: Machine test



Symbol	Description
	USB logger 📖 *p. 206*
	Adjust and test hook thread monitor 📖 *p. 207*
	Test roll-off device 📖 *p. 208*
	Adjust and align light barriers 📖 *p. 209*
	Test corner knife position 📖 *p. 211*
	Adjust and test sewing motor 📖 *p. 217*

Symbol	Description
	Test tape feeder •  Tape throwing •  Tape trimming
	Machine workflow test 🕮 *p. 219*
	Test stepper motor 🕮 *p. 225*
	Adjust and test control panel 🕮 *p. 227*
	Test piping knife 🕮 *p. 231*
	Adjust and test needle transport 🕮 *p. 233*
	Test pick-up folder 🕮 *p. 235*
	Test and set middle knife 🕮 *p. 237*
	Adjust and test programmable marking lamps 🕮 *p. 240* • **only if the programmable marking lamps have been activated in the machine configuration**
	Adjust and test transport clamp 🕮 *p. 245* • **only if automatic transport clamp adjustment has been activated in the machine configuration**
	Test guiding plates 🕮 *p. 248*
	Test turning device 🕮 *p. 250*
	Test programmable flap stopper 🕮 *p. 252*



To test the machine:

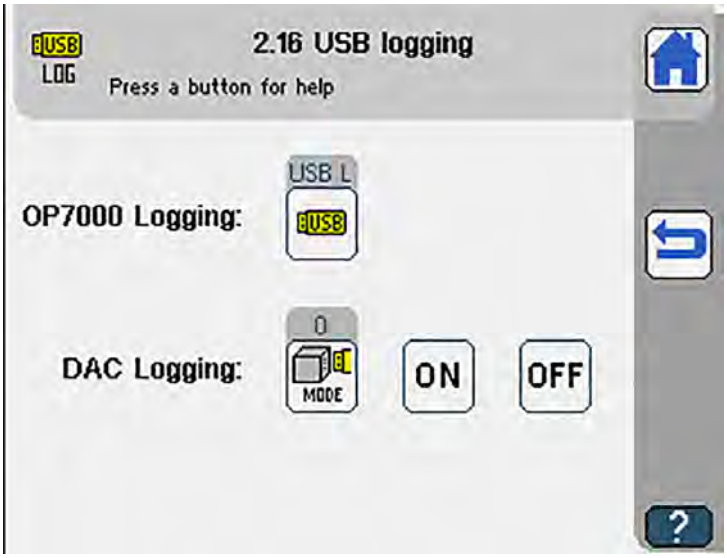
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

USB logger

↳ The display switches to *USB logging*.

Fig. 164: USB Logging



Symbol	Description
MODE	DAC modes: • **for DA service technicians only**

To perform a **OP7000 logging**:

1. Create a *Log.txt* file on a computer.
2. Load the *Log.txt* file onto a USB key.
3. Plug the USB key with the *Log.txt* file into the USB port on the control panel.
4. Confirm with **OK**.

↳ OP7000 logging automatically writes all status messages of the OP7000 to the *Log.txt* file until the machine is switched off.

Information

The **DAC logging** is performed by DA service technicians only.

Adjusting and testing hook thread monitor

↳ The display switches to *Test bobbin thread monitor*.

Information

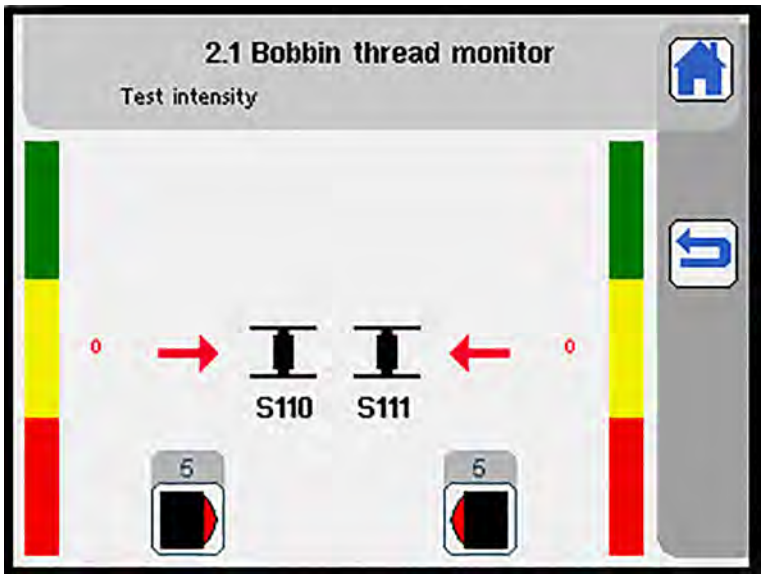
When the light barriers are correctly aligned, a reflection occurs when an empty bobbin is turned.
The intensity of the reflection is illustrated by a black bar and a number between **1** and **15**.
If the value is above the minimum value of **8**, the display shows an arrow between reflecting head and hook thread bobbin. A signal tone will sound at the same time.

Important

If the light barrier setting is correct, the maximum value of **15** must be reached when the infrared beam hits the area of the reflecting surface of the bobbin.

↳ The black bar is within the green range.

Fig. 165: Adjusting and testing hook thread monitor

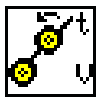


Symbols	Meaning
	Adjust sensitivity left • 0 - 15
	Adjust sensitivity right • 0 - 15

To adjust the hook thread monitor:

1. Press the desired button.

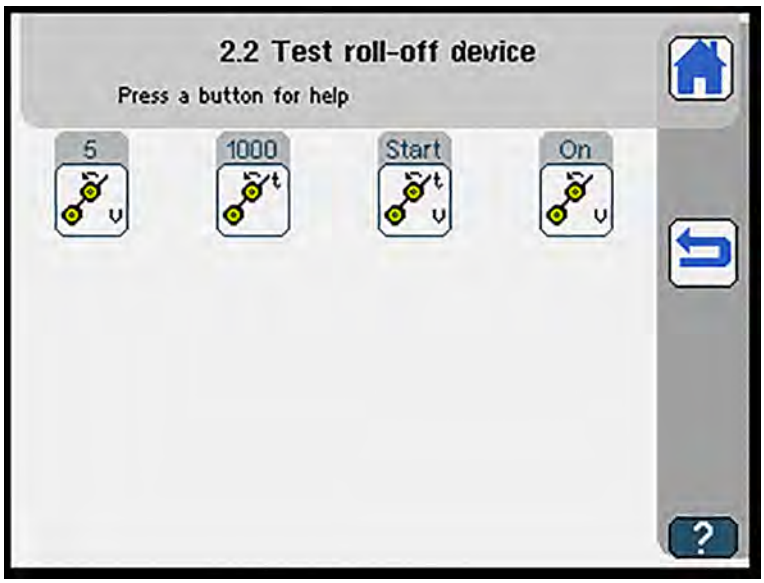
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.



Testing the outfeed roller

↳ The display switches to *Test roll-off device*.

Fig. 166: Testing the outfeed roller



Symbols	Meaning
	Adjust roll-off speed • 1 - 15
	Test roll-off duration • 0 ms - 1000 ms
	Start roll-off test
	Roll-off On/Off



To test the outfeed roller:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Testing the light barriers

CAUTION



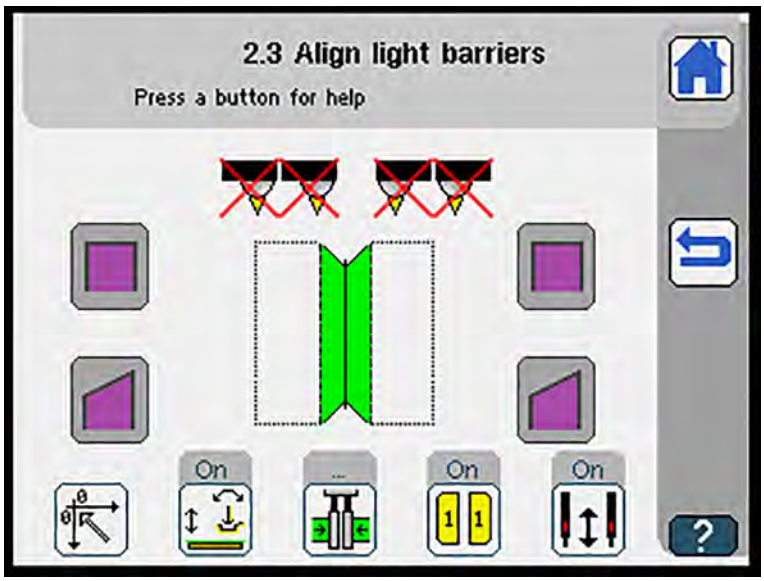
Risk of injury from moving parts!

Crushing possible.

Do NOT reach into the moving part of the machine.

↳ The display switches to `Align light barriers`.

Fig. 167: Testing the light barriers



Information

Refer to the 🕮 *Service Instructions* for instructions on how to align the light barriers with the help of templates.
For information on how to connect the light barriers, see the wiring diagram included in the **Appendix** (🕮 *p. 353*).

To test the light barriers:

1. Press the  button.

↳ Reference run is carried out.

The following table lists the items that can be set in the *Align light barriers* menu item:

Symbol	Meaning
	Reference
	Lift pick-up folder/lower pick-up folder depressurized
	Transport clamp quick adjustment 📖 *p. 169*
	Open/Close flap clamp
	Split needle bar On/Off
	Scan straight flap
	Scan slanted flap



2. Press the desired button.

Adjusting and testing corner knife

CAUTION



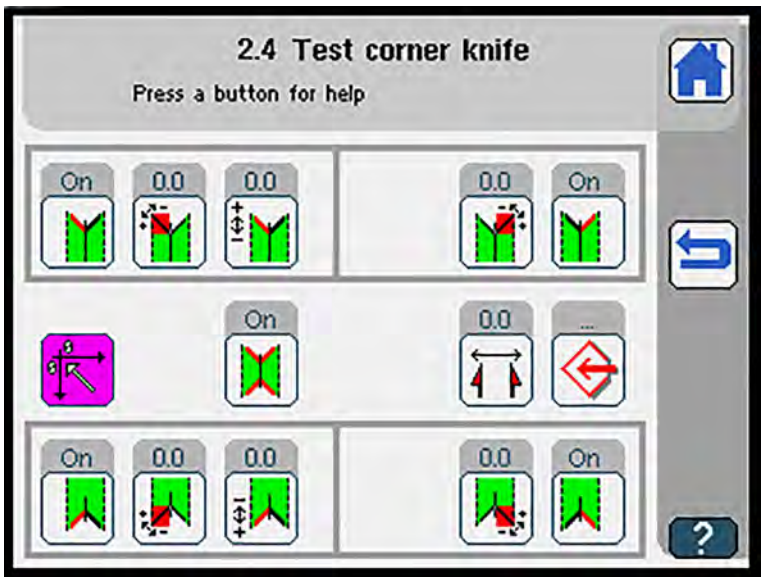
Risk of injury from moving parts!

Crushing.

Do NOT reach into the moving part of the machine.

↳ The display switches to *Test corner knife*.

Fig. 168: Adjusting and testing corner knife



To adjust the corner knife station:

1. Press the button.

↳ Reference run is carried out.

The following table lists the items that can be set in the *Test corner knife* menu item:

Symbols	Meaning
	Reference
	Test corner knife function of all corner knives On/Off
	Corner knife distance • **only for configuration: Automatic corner knife station** • 80 mm - 220 mm

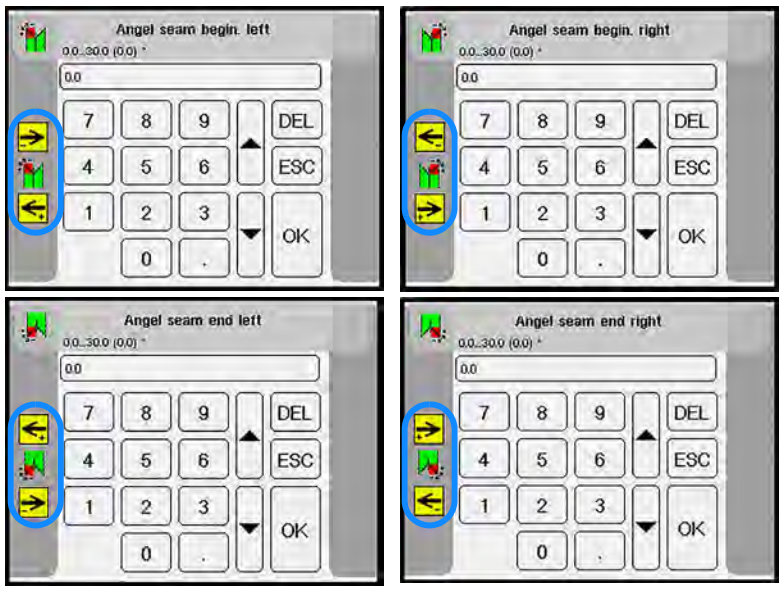
Symbols	Meaning
	Adjust corner knife 🕮 *p. 214*
	Corner knife seam begin. left On/Off
	Adjust angle seam begin. left 🕮 *p. 213* • **only for configuration: multi-functional corner knife station** • 0.0° - 30.0°
	Adjust knife block seam begin left • -13mm - 13 mm
	Adjust angle seam begin. right 🕮 *p. 213* • **only for configuration: multi-functional corner knife station** • 0.0° - 30.0°
	Corner knife seam begin. right On/Off
	Corner knife seam end left On/Off
	Adjust angle seam end left 🕮 *p. 213* • **only for configuration: multi-functional corner knife station** • 0.0° - 30.0°
	Adjust knife block seam end left
	Adjust angle seam end right 🕮 *p. 213* • **only for configuration: multi-functional corner knife station** • 0.0° - 30.0°
	Corner knife seam end right On/Off



2. Press the desired button.
3. Enter the desired value using the numeric keypad.
4. Confirm with **OK**.

Adjusting corner knife angle seam begin./seam end

Fig. 169: Adjusting corner knife angle seam begin./seam end



Information

The arrows in the left half of the display indicate the correction direction.

Seam beginning

Correction inward (smaller angle)

Correction outward (greater angle)

Seam end

Correction outward (greater angle)

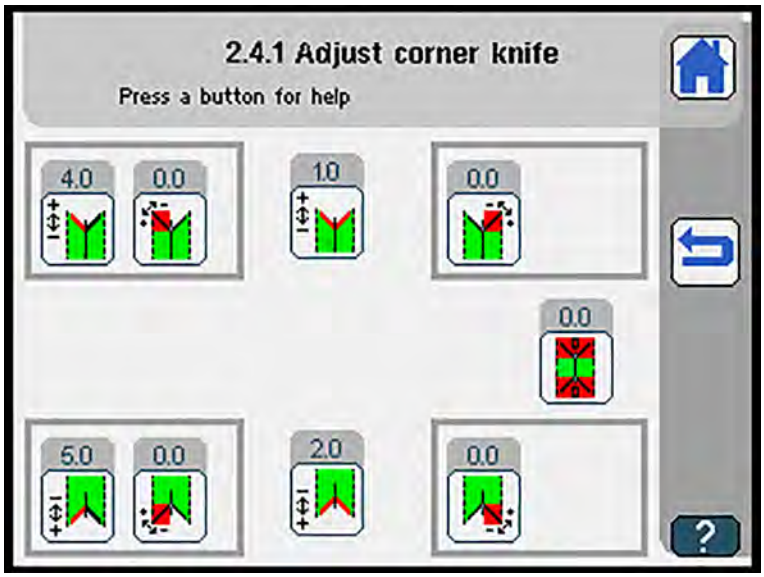
Correction inward (smaller angle)

Adjusting the corner knives

This setting is protected with a password. The password is 25483.

↳ The display switches to `Adjust corner knife`.

Fig. 170: Adjusting the corner knives



Symbols	Meaning
	Offset corner knife at seam begin. zero • -13 mm - 13 mm
	Offset corner knife at seam begin. left zero 🕮 *p. 215* • **only for configuration: multi-functional corner knife station** • 0° - 30°
	Correction value corner knife seam begin. • -99.9 mm - 99.9 mm
	Offset corner knife at seam begin. right zero 🕮 *p. 215* • **only for configuration: multi-functional corner knife station** • 0° - 30°
	Base angle • **only for configuration: multi-functional corner knife station** • 0° - 30°
	Offset corner knife at seam end zero • -13 mm - 13 mm

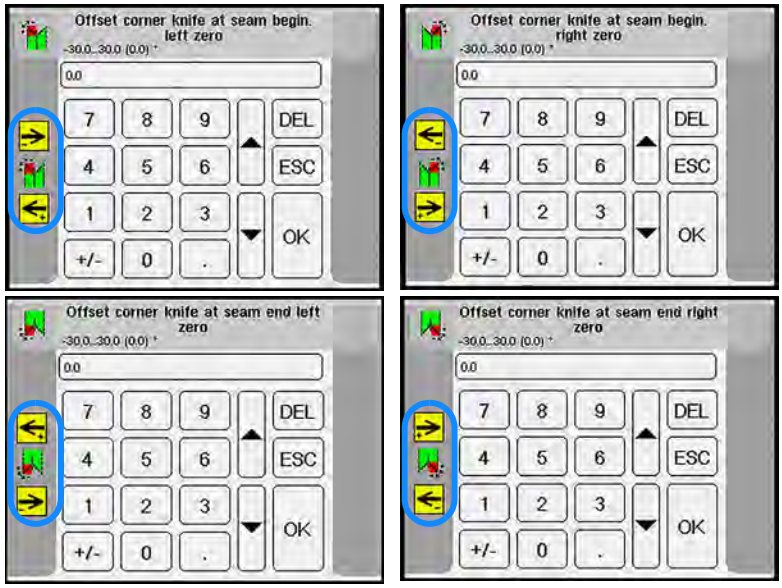
Symbols	Meaning
	Offset corner knife at seam end left zero 📖 p. 215 • **only for configuration: multi-functional corner knife station** • 0° - 30°
	Adjust corner knife correction seam end • -99.9 mm - 99.9 mm
	Offset corner knife at seam end right zero 📖 p. 215 • **only for configuration: multi-functional corner knife station** • 0° - 30°

To adjust the corner knives:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

  Adjusting offset angle seam begin./seam end

Fig. 171: Adjusting offset angle seam begin./seam end



Information

The arrows in the left half of the display indicate the correction direction.

Seam beginning

 Correction inward (smaller angle)

 Correction outward (greater angle)

Seam end

 Correction outward (greater angle)

 Correction inward (smaller angle)

Adjusting and testing sewing motor

NOTICE

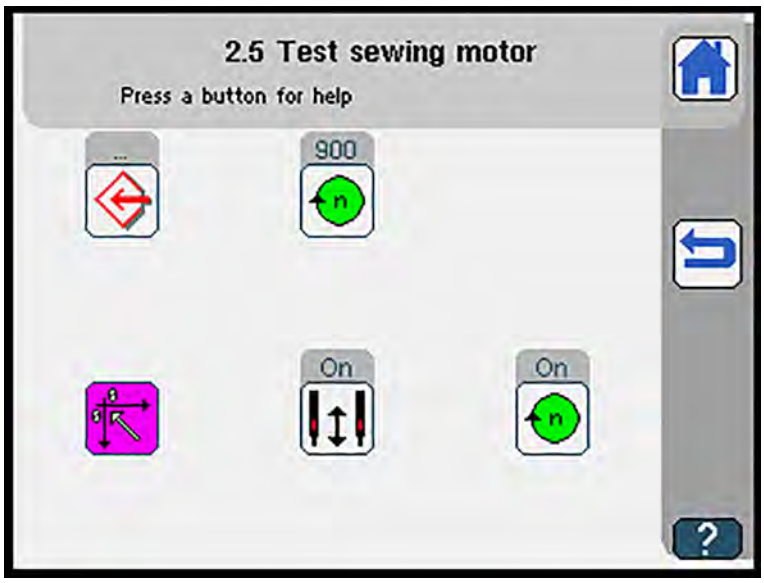
Property damage may occur!

Jamming of the machine.

Unthread the needle thread before starting the sewing motor.

↳ The display switches to `Test sewing motor.`

Fig. 172: Testing the sewing motor



Symbols	Meaning
	Adjust sewing motor 🕮 *p. 218*
	Adjust sewing motor speed • 100 RPM - 3200 RPM (**class 755 A**) • 100 RPM - 3000 RPM (**class 756 A**)
	Reference
	Switch split needle bar On/Off
Ein	Sewing motor On/Off

To test the sewing motor:

1. Press the  button.

↳ Reference run is carried out.

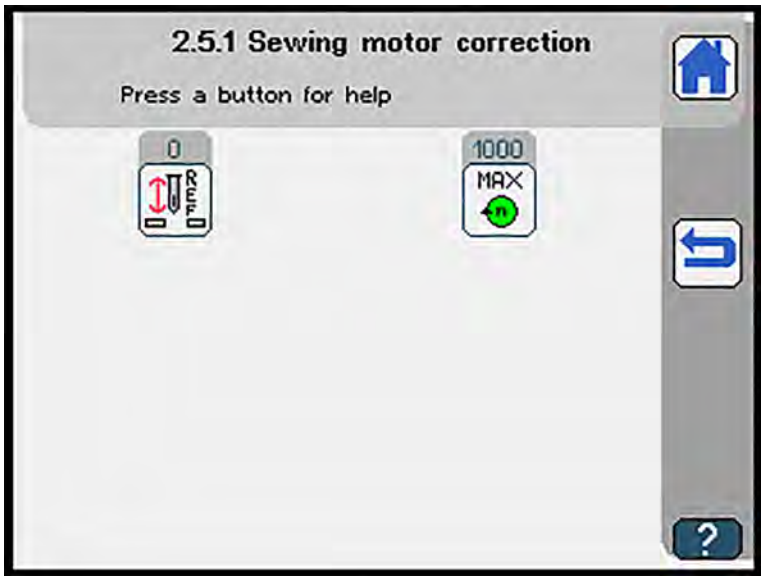
2. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Adjusting the sewing motor

↳ The display switches to `Adjust sewing motor`.

Fig. 173: Adjusting the sewing motor



Symbols	Meaning
	Adjust the position of the sewing motor • 70°- -70°
	Adjust the maximum sewing motor speed • 100 RPM - 3200 RPM (**class 755 A**) • 100 RPM - 3000 RPM (**class 756 A**)

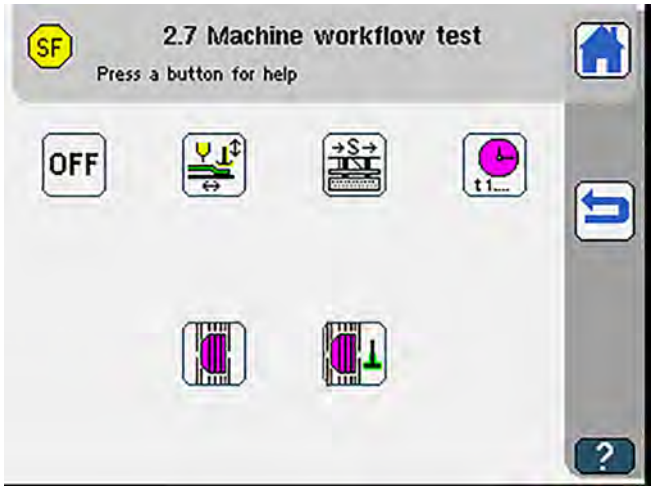
To adjust the sewing motor:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Machine workflow test

↳ The display switches to `Machine workflow test.`

Fig. 174: Machine workflow test



Symbols	Meaning
OFF	Exit current machine test, return to start screen
	Loading process test, test loading process step by step 📖 *p. 220*
	Test step by step 📖 *p. 221*
t1...	Display cycle time 📖 *p. 222*
	Test turning device w/o folder 📖 *p. 223*
	Test turning device w/ folder 📖 *p. 224*

To perform a machine workflow test:

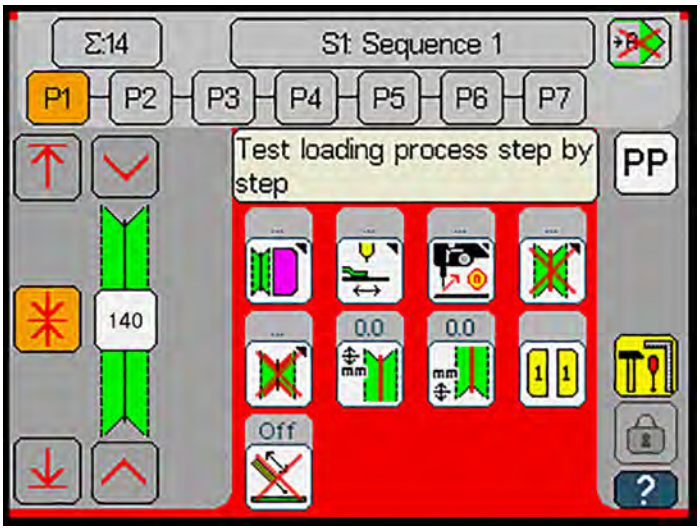
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Loading process test

↳ The display switches to *Loading process test*.

Fig. 175: Loading process test



The sewing material is fed through the sewing path without sewing including all functions stored in the seam program.
The loading process test is designed to check if the flaps and piping strips are transported correctly through the sewing path.

Information

To monitor the transport path of the sewing material, reduce the insertion speed prior to the loading process test (📖 *p. 163*).

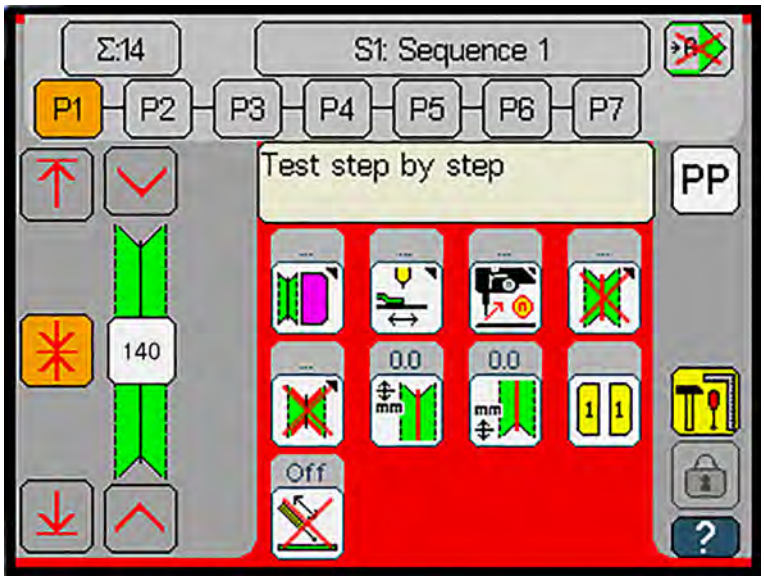
To perform a loading process test:

1. Press the **Loading process test** button.
↳ The machine boots up.
2. Perform a reference run.
↳ The load mode is active.
3. Insert the sewing material.
4. Press the pedal to close the transport clamp.
↳ The display shows the message .
5. Press the right pedal.
↳ The loading process is completed without sewing by performing pedal strokes.
6. To exit the test: access the menu *Service > Machine test > Machine workflow test* again and press the OFF button.

Test step by step

↳ The display switches to *Test step by step*.

Fig. 176: Test step by step



To carry out a step-by-step test:

1. Press the **Test step by step** button.
2. Press the pedal after every single work step.

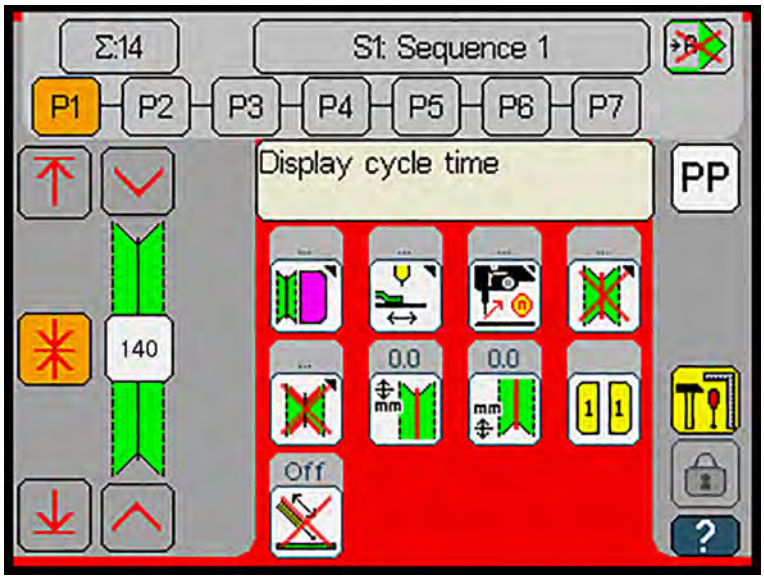
↳ The step by step test allows you to test the machine workflow.

3. To exit the test: access the menu *Service > Machine test > Machine workflow test* again and press the OFF button.

Cycle time

↳ The display switches to *Cycle time*.

Fig. 177: Cycle time



To test the cycle time:

1. Sew.

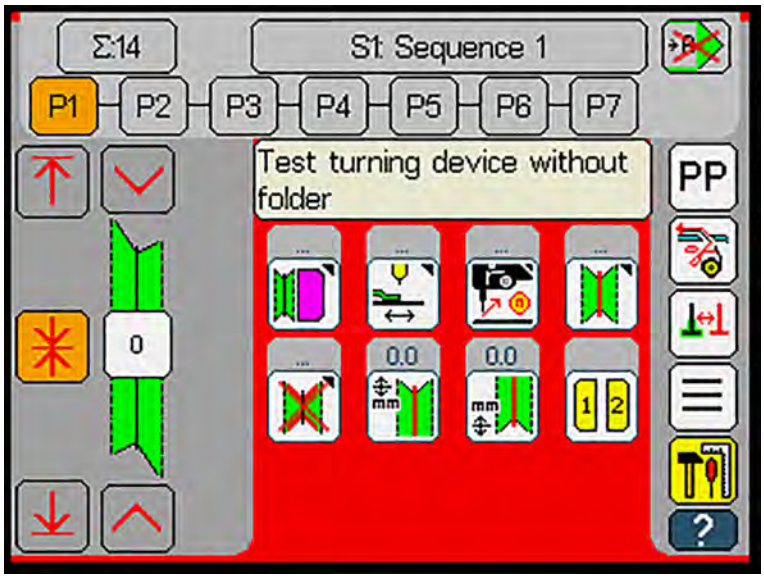
↳ The display shows the time in ms.
The cycle time allows you to optimize the machine settings.

2. To exit the test: access the menu *Service > Machine test > Machine workflow test* again and press the OFF button.

Testing turning device without folder

↳ The display switches to *Test turning device w/o folder*.

Fig. 178: Testing turning device without folder



To test the turning device without folder:

1. Press the **Test turning device w/o folder** button.
2. Press the pedal after every single work step.

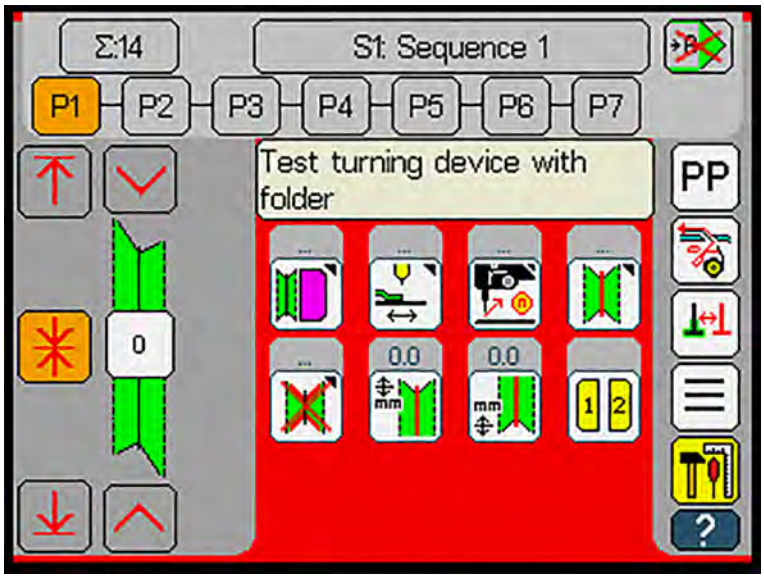
↳ The step-by-step test allows you to test the feeding process.

3. To exit the test: access the menu *Service > Machine test > Machine workflow test* again and press the OFF button.

Testing the turning device with folder

↳ The display switches to *Test turning device w/ folder*.

Fig. 179: Testing the turning device with folder



To test the turning device with folder:

1. Press the **Test turning device w/ folder** button.
2. Press the pedal after every single work step.

↳ The step-by-step test allows you to test the feeding process.

3. To exit the test: access the menu *Service > Machine test > Machine workflow test* again and press the OFF button.

Testing stepper motor

CAUTION



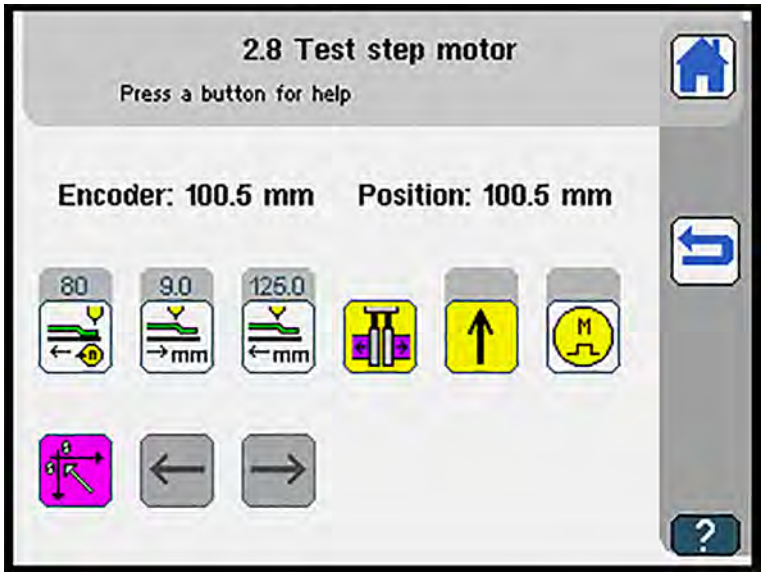
Risk of injury from moving parts!

Crushing possible.

When you advance the transport clamp, the transport clamp will start at the set speed.
Do NOT reach into the movement area of the transport clamp.
Do not place any objects in the movement area of the transport clamp.

↳ The display switches to *Test stepper motor*.

Fig. 180: Testing stepper motor

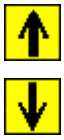


To test the stepper motor:

1. Press the  button.

↳ Reference run is carried out.

The following table lists the items that can be set in the *Test stepper motor* menu:

Symbol	Meaning
	Adjust clamp speed • 10% - 100%
	Adjust stepper motor pos. 1 • 0 - 517.5 mm • Starting position transport clamp
	Adjust stepper motor pos. 2 • 0 - 517.5 mm • End position transport clamp
	Transport clamp quick adjustment
	Lift transport clamp **OR** Lower transport clamp • **When lowered, the transport clamp must rest on fabric as the machine will otherwise sustain damage**
	Switch stepper motor current-free On/Off • The transport clamp can be moved manually
	Reference
	Advance transport clamp • **Caution!** Transport clamp moves forward
	Return transport clamp
	Adjust transport clamp pressure • 10 - 100%



2. Press the desired button.
3. Enter the desired value using the numeric keypad.
4. Confirm with **OK**.



Information

When the transport clamps are moved, the *Encoder* and *Position* values must not deviate from one another by more than 0.2. There is a risk of step losses if the value changes exceed the permissible limit when the transport clamps are moved.

If there is a difference between the *Encoder* and *Position* values, you can reset the values by carrying out a reference run.

Adjusting and testing control panel

↳ The display switches to `Adjust and test control panel`.

Fig. 181: Adjusting and testing control panel



Symbol	Meaning
	Adjust brightness and contrast 📖 *p. 228*
	Touch calibration 📖 *p. 229*
	Touch test 📖 *p. 230*
	Display showing the technical information of the control panel

To adjust and test the control panel:

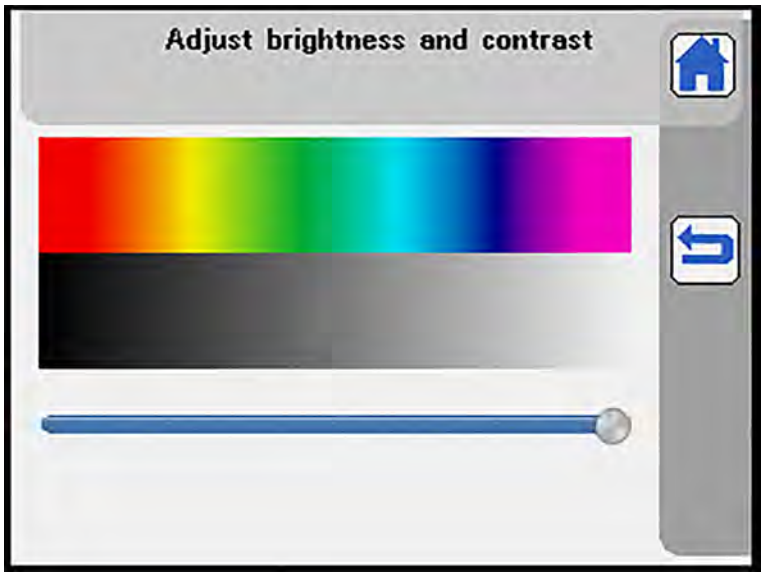
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Adjusting brightness and contrast

↳ The display switches to *Adjust brightness and contrast.*

Fig. 182: Adjust brightness and contrast



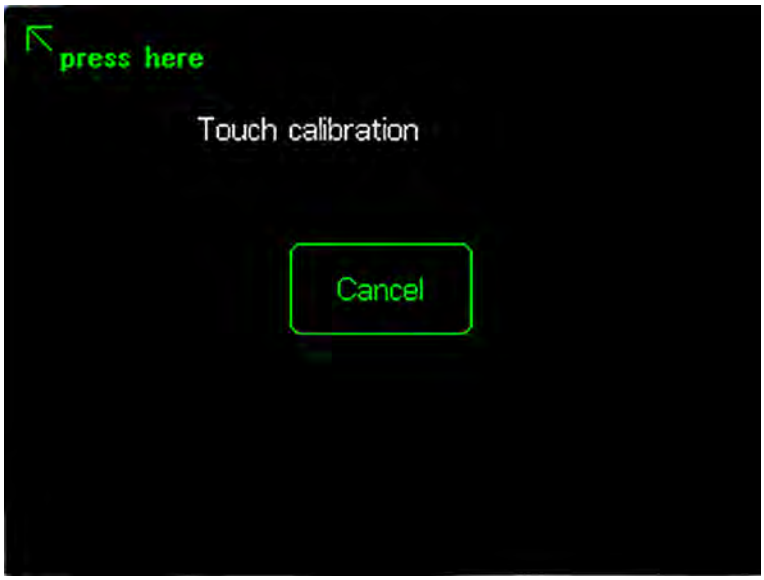
To adjust the brightness of the display:

1. Move the controller.
   - Increase brightness: Slide the controller to the right
   - Reduce brightness: Slide the controller to the left

Touch calibration

↳ The display switches to *Touch calibration*.

Fig. 183: Touch calibration



To carry out the touch calibration:

1. Successively press on the places indicated by the green arrow.

↳ Touch calibration is carried out.
The display returns to *Adjust and test control panel*.

OR:

1. Press **Cancel**.

↳ Touch calibration is canceled.
The display returns to *Adjust and test control panel*.

Information

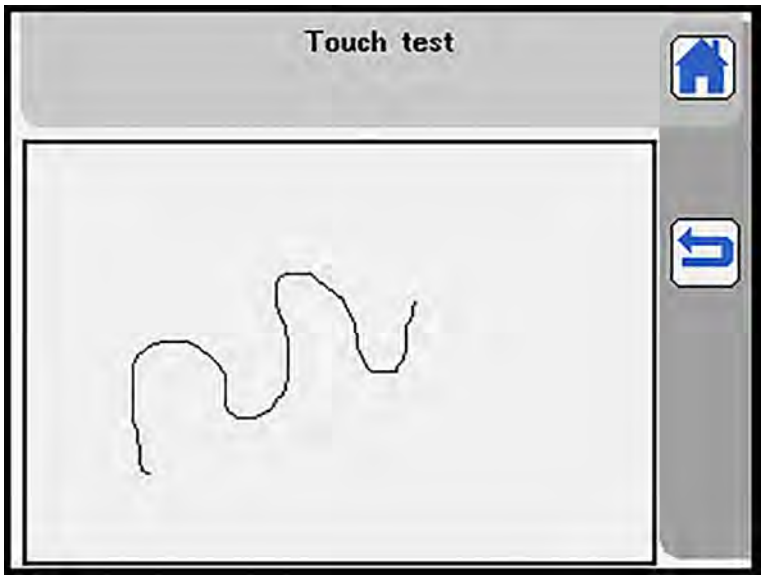
Another option is to perform the touch calibration using the boot loader.

To do so, press your finger on the control panel while the control panel boots up until the boot loader appears.
The boot loader shows the current calibration values in the Device information menu.

Touch test

↳ The display switches to `Touch test`.

Fig. 184: Touch test

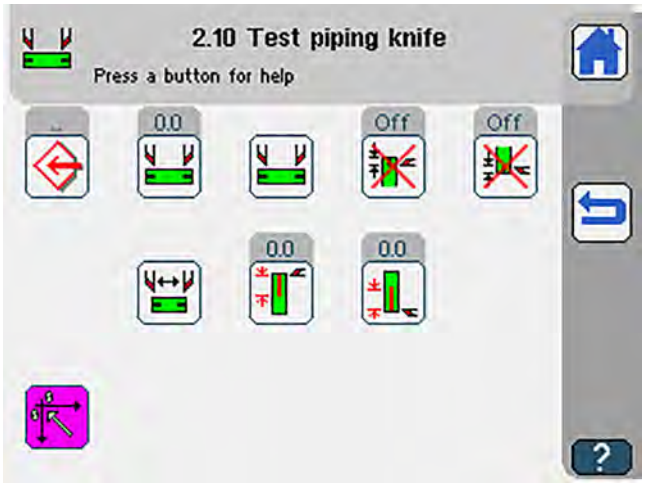


The Touch test menu item allows you to draw on the touch screen.

Adjusting and testing piping knife

↳ The display switches to *Test piping knife*.

Fig. 185: Testing piping knife



Symbol	Meaning
	Adjust piping knife 📖 *p. 232*
	Test cutting process • 0 - 180 mm
	Test cutting process both knives
	Piping knife seam beginning On/Off
	Piping knife seam end On/Off
	Piping knife change position
	Drive position seam begin. • 0 - 150 mm
	Drive position seam end • 0 - 150 mm
	Reference
	Stepper motor On/Off

To test the piping knife:

1. Press the  button.

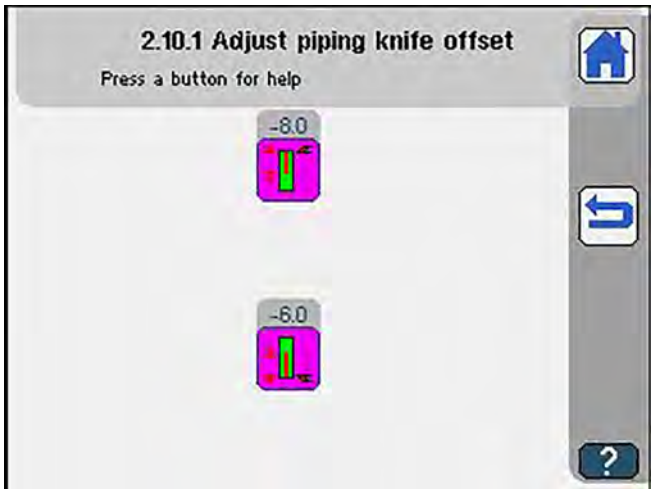
↳ Reference run is carried out.

2. Press the desired button.

Adjusting piping knife

↳ The display switches to `Adjust piping knife offset`.

Fig. 186: Adjusting piping knife



Symbol	Meaning
	Correction of adjustment offset seam begin. • -5.0 mm - 5.0 mm
	Correction of adjustment offset seam end • -5.0 mm - 5.0 mm

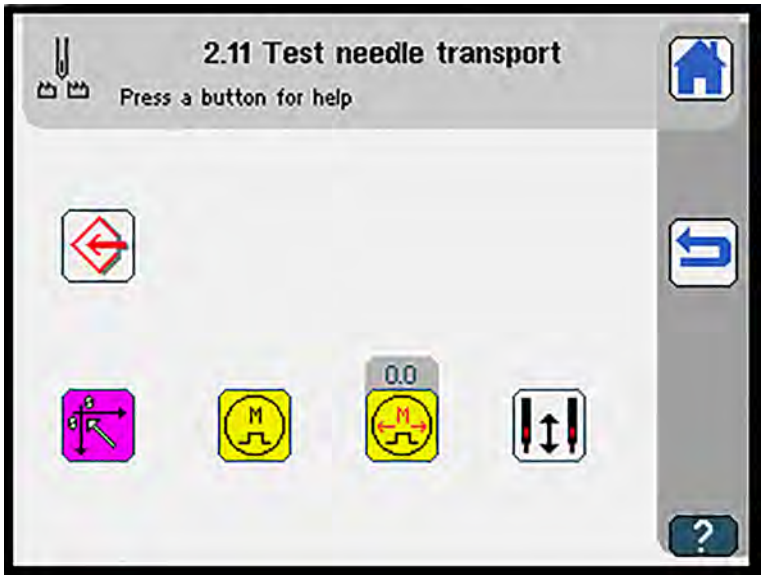
To adjust the piping knife:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting and testing needle transport

↳ The display switches to *Test needle transport*.

Fig. 187: Testing needle transport



Symbol	Meaning
	Adjust needle transport 📖 *p. 232*
	Reference
	Stepper motor On/Off
	Adjust motor drive position • +3.5: Needle transport in sewing direction • -3.5: Needle transport against sewing direction
	Split needle bar On/Off

To test the needle transport:

1. Press the button.

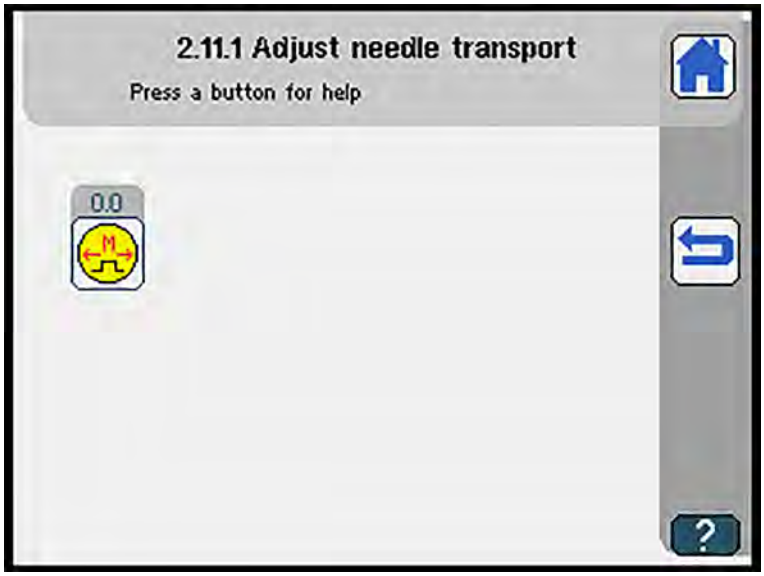
↳ Reference run is carried out.

2. Press the desired button.

Adjusting needle transport

↳ The display switches to *Adjust needle transport*.

Fig. 188: Adjusting needle transport



Symbol	Meaning
	Correction of the needle transport reference position.

To adjust the needle transport:

1. Press the  button.
2. Enter the desired correction value using the numeric keypad.

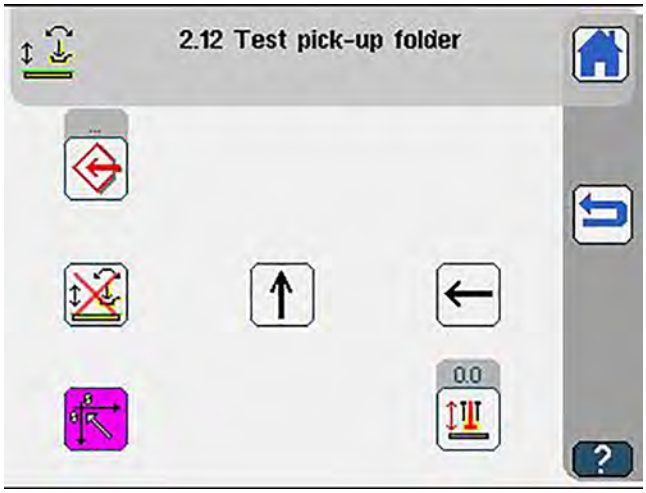
↳ The needle bar moves to the specified position.

3. Keep correcting the value until the needle pierces exactly in the center of the throat plate cutout.

Adjusting and testing pick-up folder

↳ The display switches to *Test pick-up folder*.

Fig. 189: Testing pick-up folder



Symbol	Meaning
	Folder adjustment 📖 *p. 236*
	Pick-up folder depressurized On/Off
	Pick-up folder Up/Down
	Pick-up folder Left/Right
	Reference
	Folder drive position X-axis • 0 - 6 mm

To test the pick-up folder:

1. Press the button.

↳ Reference run is carried out.

2. Press the desired button.

Folder adjustment

↳ The display switches to `Folder adjustment`.

Fig. 190: Folder adjustment



Symbol	Meaning
REF.	Offset correction • -5.0 mm - 5.0 mm

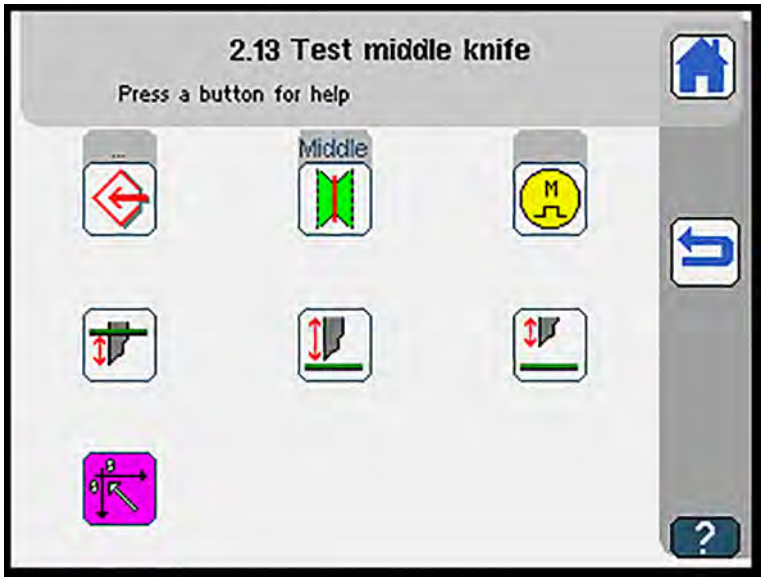
To adjust the folder:

1. Press the REF. button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting and testing middle knife

↳ The display switches to *Test middle knife*.

Fig. 191: Testing middle knife



Symbol	Meaning
	Adjust middle knife 🕮 *p. 238*
	Middle knife On/Off
	Stepper motor On/Off
	Move middle knife to lower position (cutting position) 🕮 *p. 239*
	Move to height of stroke 🕮 *p. 239*
	Move middle knife to upper position 🕮 *p. 239*
	Reference

To test the middle knife:

1. Press the button.

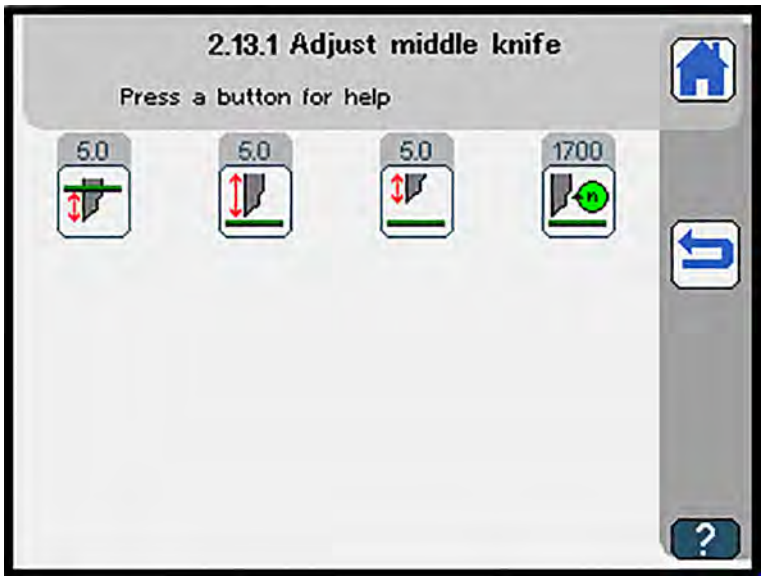
↳ Reference run is carried out.

2. Press the desired button.

Adjusting middle knife

↳ The display switches to `Adjust middle knife`.

Fig. 192: Adjusting middle knife



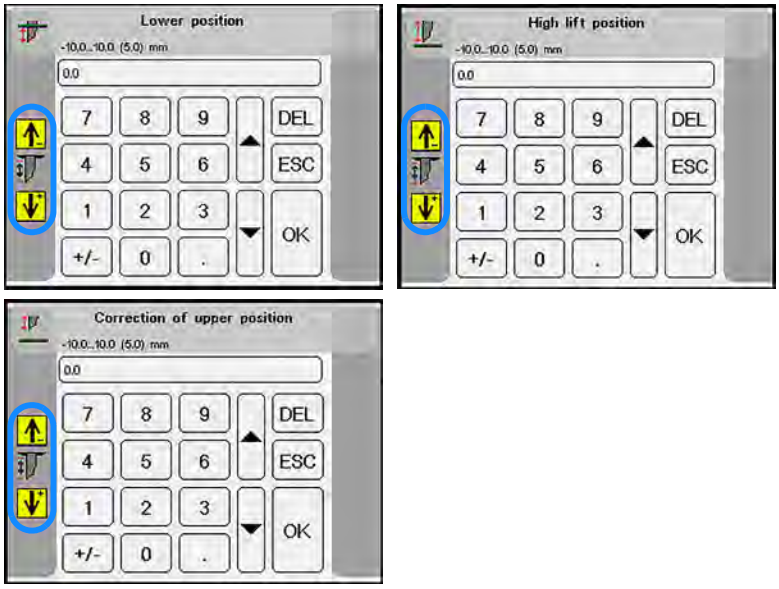
Symbol	Meaning
	Adjust correction lower position (cutting position) • -10 mm - 10 mm
	Adjust height of stroke • 1 mm - 7 mm
	Adjust correction upper position • -10 mm - 10 mm
	Adjust maximum speed limit middle knife • 100 RPM - 2000 RPM
	Adjust the distance of the middle knife incision to the seam beginning • -99 mm - 99 mm
	Adjust the distance of the middle knife incision to the seam end -99 mm - 99 mm

To adjust the middle knife:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Middle knife correction upper/lower position, height of stroke

Fig. 193: Middle knife correction upper/lower position, height of stroke



Information

The arrows in the left half of the display indicate the correction direction:

Correction upward (middle knife less deep)

Correction downward (middle knife deeper)

The values produced by the test are used as reference values for all programs.

Testing programmable marking lamps

↳ The display switches to `Progr. marking lamps test`.

Fig. 194: Testing programmable marking lamps



Symbol	Meaning
	Test programmable marking lamps (lengthwise: in sewing direction) 📖 *p. 241*
	Test programmable marking lamps (crosswise to sewing direction) 📖 *p. 243*

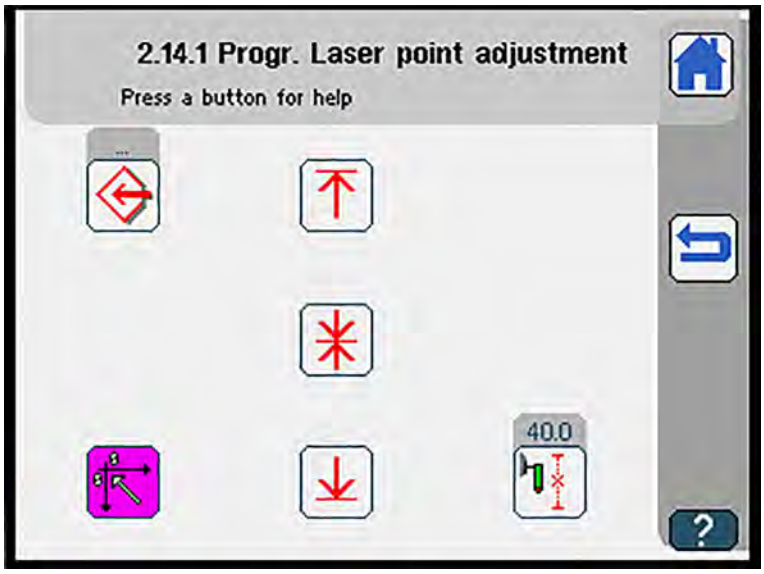
Information

If only one of the programmable marking lamps is active, the menu switches directly to the corresponding submenu.

Testing programmable marking lamps (lengthwise)

↳ The display switches to `Progr. marking lamps test`.

Fig. 195: Testing programmable marking lamps



Symbol	Meaning
	Adjust programmable marking lamps 📖 *p. 242*
	Reference
	Select positioning point seam begin.
	Select positioning point seam center
	Select positioning point seam end
	Move to any position • 0 mm - 220 mm

To test the programmable marking lamps:

1. Press the button.

↳ Reference run is carried out.

2. Press the button , , or .

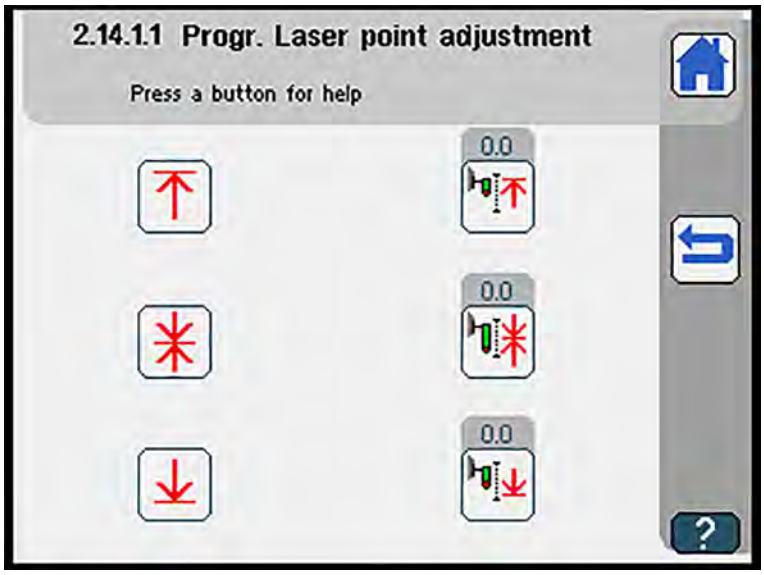
↳ The desired positioning point has been selected.

3. Press the button.
4. Enter the desired value using the numeric keypad.
5. Confirm with **OK**.

Adjusting programmable marking lamps (lengthwise)

↳ The display switches to `Adjust programmable marking lamps`.

Fig. 196: Adjusting programmable marking lamps (lengthwise)



Symbol	Meaning
	Select front positioning point
	Select central positioning point
	Select rear positioning point
	Adjust programmable marking lamp position 1 • -100 - 100
	Adjust programmable marking lamp position 2 • -100 - 100
	Adjust programmable marking lamp position 3 • -100 - 100

Testing programmable marking lamps (crosswise)

↳ The display switches to *Progr. marking lamps test*.

Fig. 197: Testing programmable marking lamps



Symbol	Meaning
	Adjust programmable marking lamps 📖 *p. 244*
	Reference
	Enter position X • 0 mm - 220 mm

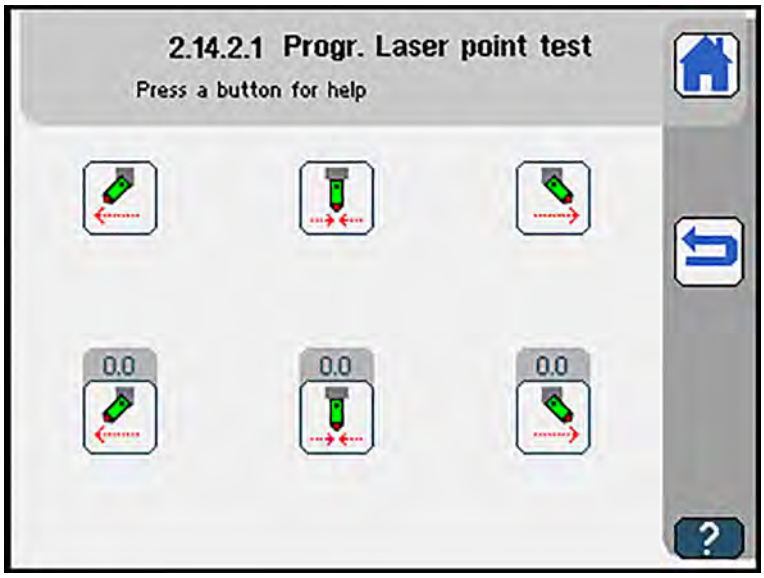
To test the programmable marking lamps:

1. Press the button.
↳ Reference run is carried out.
2. Press the button , or .
↳ The desired positioning point has been selected.
3. Press the button.
4. Enter the desired value using the numeric keypad.
5. Confirm with **OK**.

Adjusting programmable marking lamps (crosswise)

↳ The display switches to `Adjust programmable marking lamps`.

Fig. 198: Adjusting programmable marking lamps (crosswise)

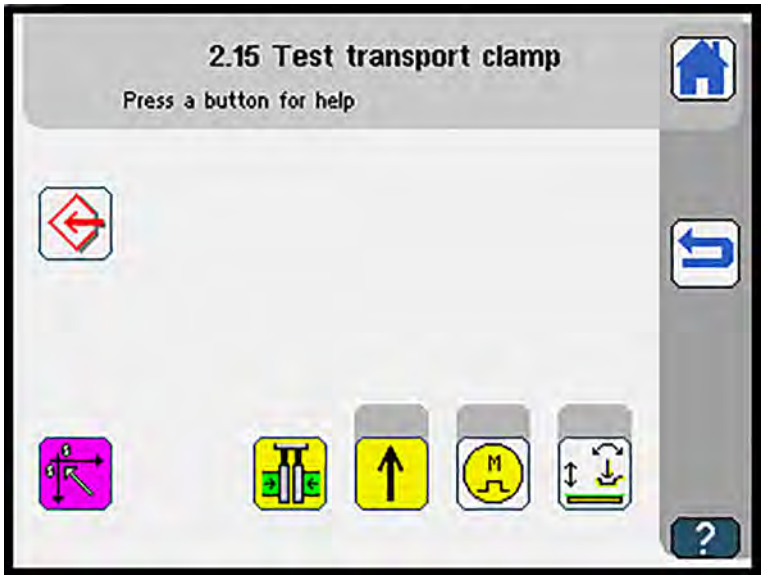


Symbol	Meaning
	Adjust programmable marking lamp position 1 • 0.0 Value range -100 - 100
	Adjust programmable marking lamp position 2 • 0.0 Value range -100 - 100
	Adjust programmable marking lamp position 3 • 0.0 Value range -100 - 100

Testing transport clamp

↳ The display switches to *Test transport clamp*.

Fig. 199: Testing transport clamp



Symbol	Meaning
	Adjust transport clamp 📖 *p. 246* • also used for direct troubleshooting in case of error codes *2501*, *2505*, *2601* and *2605* If error codes are displayed, press the  button immediately to correct the values
	Reference
	Transport clamp quick adjustment 📖 *p. 169*
	Lift/lower transport clamp
	Switch stepper motor current-free
	Switch pick-up folder pressureless

To test the transport clamp:

1. Press the  button.

↳ Reference run is carried out.

2. Press the desired button.

Adjusting transport clamp

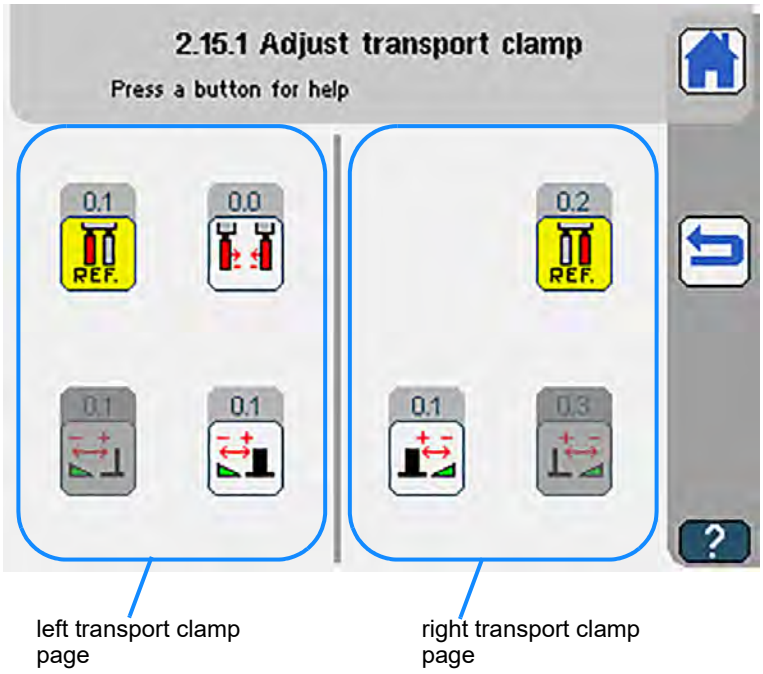
NOTICE

Property damage may occur!

Damage to the transport clamp from incorrect setting.
Jamming of the stepper motor.

↳ The display switches to `Adjust transport clamp`.

Fig. 200: Adjusting transport clamp



Symbol	Meaning
	Adjust correction value left clamp • -10.0 mm - 10.0 mm
	Adjust distance outer position left clamp, single pipe left • 0.0 mm - 40.0 mm
	Adjust distance inner position left clamp, double pipe • 0.0 mm - 40.0 mm
	Limit to inner travel path • -9.0 mm - 0.0 mm

Symbol	Meaning
	Adjust correction value right clamp • -10.0 mm - 10.0 mm
	Adjust distance inner position right clamp, double pipe • -0.0 mm - 40.0 mm
	Adjust distance outer position right clamp, single pipe right • 0.0 mm - 40.0 mm

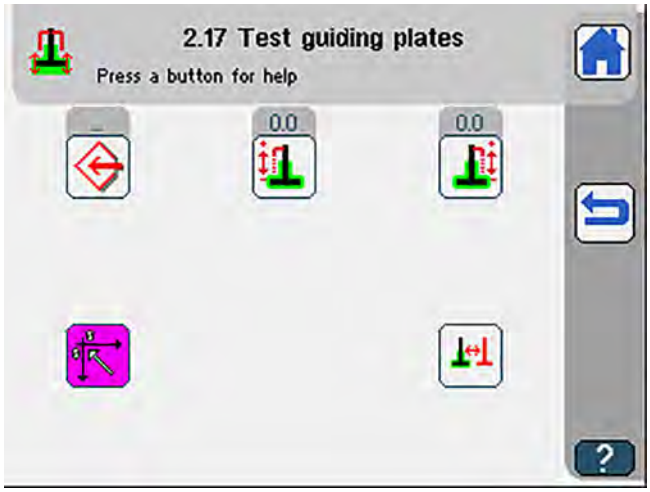
Information

The position of the clamps varies with the transport clamp quick adjustment (📖 *p. 169*).

Adjusting and testing guiding plates

↳ The display switches to *Test guiding plates*.

Fig. 201: Testing guiding plates



Symbol	Meaning
	Adjust guiding plates 📖 *p. 249*
	Left drive position • -5 mm - 2.5 mm
	Right drive position • -5 mm - 1.2 mm
	Reference
	Folder change position

To test the guiding plates:

1. Press the button.

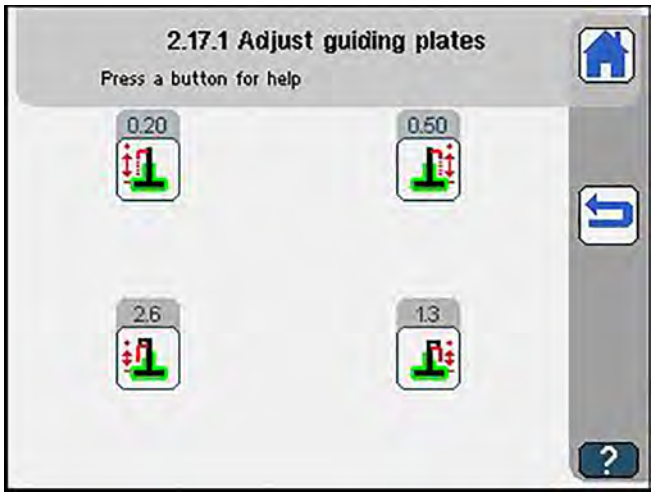
↳ Reference run is carried out.

2. Press the desired button.

Adjusting guiding plates

↳ The display switches to *Adjust guiding plates*.

Fig. 202: Adjusting guiding plates



Symbol	Meaning
	Correction of adjustment offset left • -25.0 mm - 25.0 mm
	max. limit value left • 0.0 mm - 6.0 mm
	Right drive position • -25.0 mm - 25.0 mm
	max. limit value right • 0.0 mm - 6.0 mm

To adjust the guiding plates:

1. Press the desired button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting and testing turning device

↳ The display switches to *Test turning device*.

Fig. 203: Testing turning device



Symbol	Meaning
	Adjust turning device 📖 *p. 251*
	Drive position • -5 mm - 5 mm
	Reference
	Align turning device On/Off

To test the turning device:

1. Press the button.

↳ Reference run is carried out.

2. Press the desired button.

Adjusting turning device

↳ The display switches to *Adjust turning device*.

Fig. 204: Adjusting turning device



Symbol	Meaning
REF.	Correction of adjustment offset • -0.5 mm - 5.0 mm

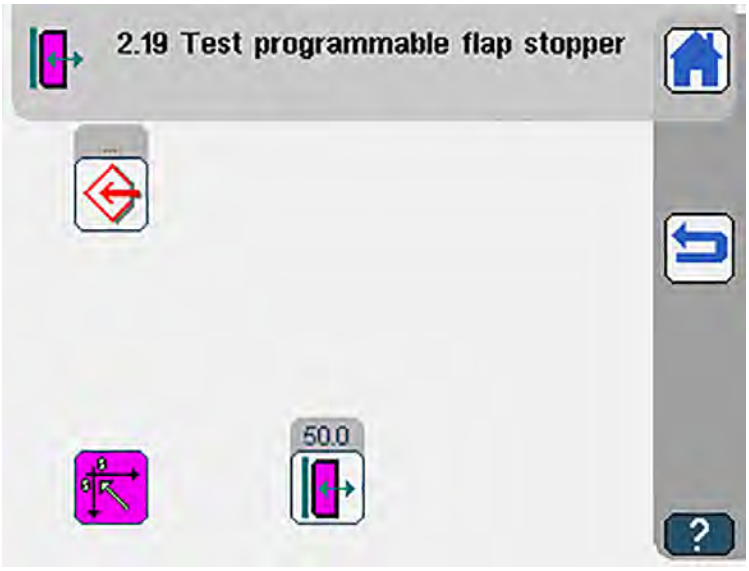
To adjust the turning device:

1. Press the REF. button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

Adjusting and testing programmable flap stopper

↳ The display switches to *Test programmable flap stopper*.

Fig. 205: Testing programmable flap stopper



Symbol	Meaning
	Adjust flap stopper 📖 *p. 253*
	Drive position • 30 mm - 75 mm
	Reference

To test the programmable flap stopper:

1. Press the button.

↳ Reference run is carried out.

2. Press the desired button.

Adjusting programmable flap stopper

↳ The display switches to *Adjust programmable flap stopper*.

Fig. 206: Adjusting programmable flap stopper



Symbol	Meaning
REF.	Correction of adjustment offset • 30 mm - 75 mm

To adjust the programmable flap stopper:

1. Press the REF. button.
2. Enter the desired value using the numeric keypad.
3. Confirm with **OK**.

DAC update

↳ The display switches to `DAC update`:

Fig. 207: DAC update (1)



Important

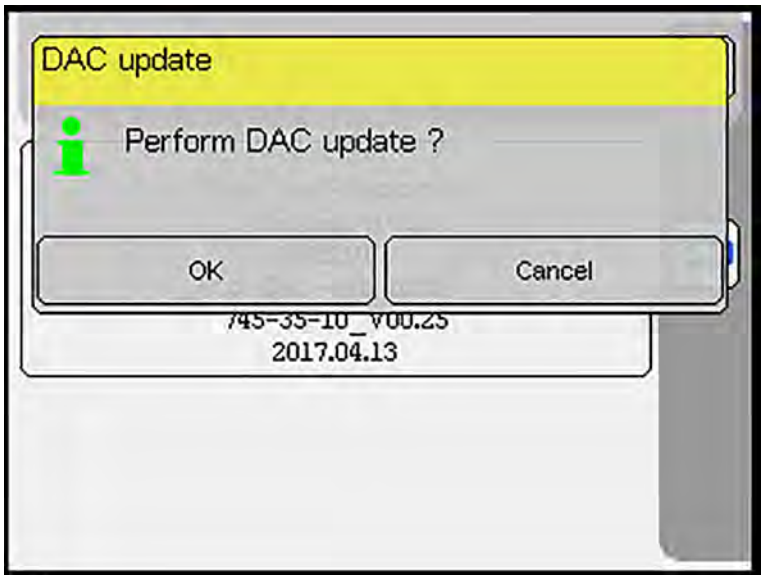
While booting up, the machine will compare the software version of control panel and control.
If the software versions do not match, the system will suggest an update.
You can use this submenu to execute the update of the control manually if the automatic update fails, is canceled or skipped.

To perform an update:

1. Press on the screen.

↳ A prompt appears on the display asking if you wish to perform the update.

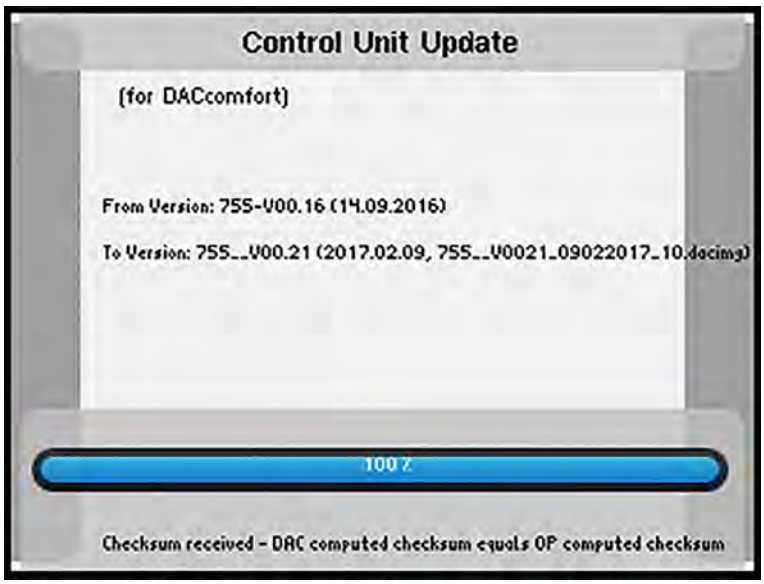
Fig. 208: DAC update (2)



2. Confirm with **OK**.

↳ The update is carried out.

Fig. 209: DAC update (3)

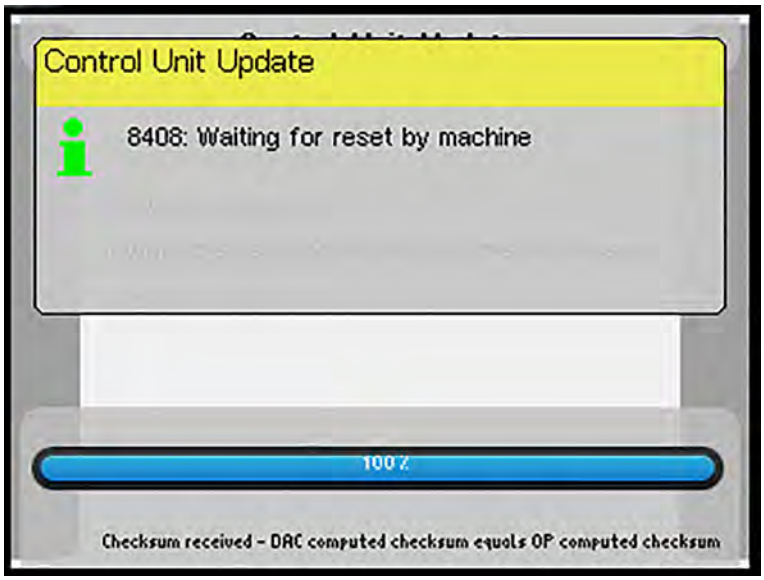


Important

Do not switch off the machine while the update is in progress!

↳ The display shows notice 8408: *Waiting for Reset by machine*.

Fig. 210: DAC update (4)



↳ The machine restarts automatically.
After restarting, the machine loads the start screen and is ready for operation.
The progress of the update is indicated by a progress bar.
When the update is complete, the control panel will perform a restart.

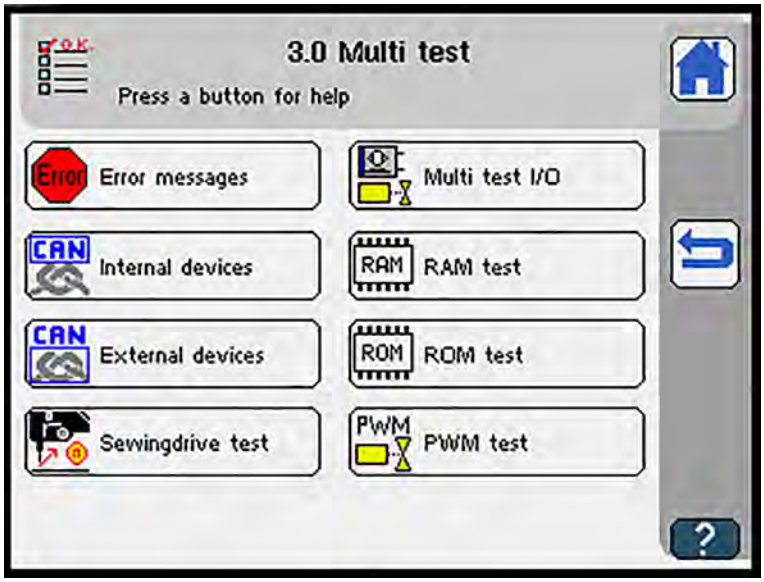
Multi test

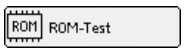
Important

The `Multi test` menu is protected with a password. You use this menu to check basic machine functions. The password is 25483.

↳ The display switches to `Multi test`.

Fig. 211: Multi test



Symbols	Meaning
	A press of the button will bring up a list: • The last 10 error messages • Date of the error • Time of the error 📖 *p. 258*
	Test inputs and outputs 📖 *p. 259*
	Display of the internal devices 📖 *p. 263*
	Test the working memory RAM 📖 *p. 264*
	Display of the external devices 📖 *p. 265*
	Test the read-only memory ROM 📖 *p. 266*
	Sewing drive test 📖 *p. 267*

To carry out the individual tests:

1. Press the desired button.

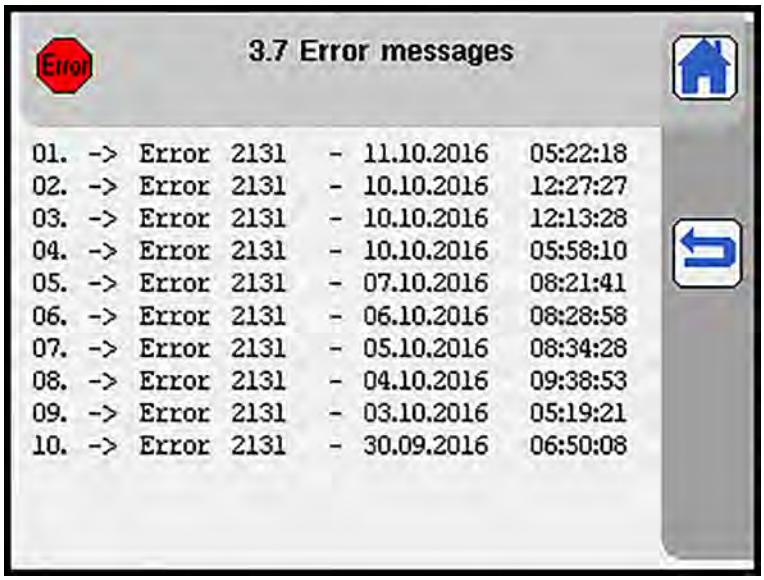
↳ The user interface for setting the desired item is displayed.



Error Messages

↳ The display switches to `Error messages`.

Fig. 212: Error Messages



The list contains the last 10 error messages as well as the date and time of each error.

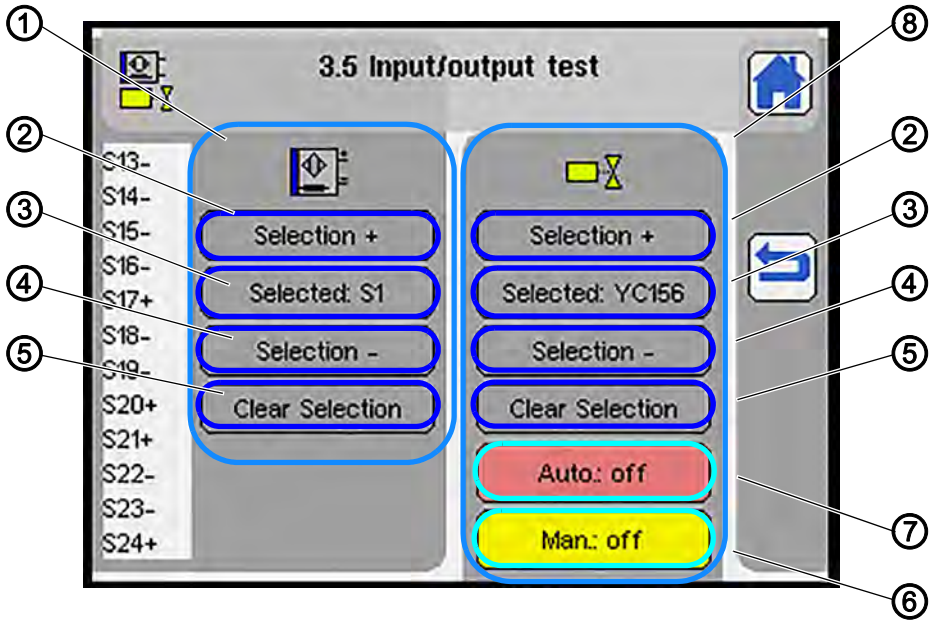
Information

The correct display of date and time requires that you set date and time in the `Maintenance` menu item (📖 *p. 278*).

Multi test I/O

↳ The display switches to `Multi test I/O`.

Fig. 213: Multi test I/O



(1) - Input
(2) - Increase selection by 1
(3) - Display of the selected input
(4) - Reduce selection by 1
(5) - Clear selection
(6) - Manual test On/Off
(7) - Automatic test On/Off
(8) - Output

To carry out an input and output test:

1. Select an input in the left area:

Inputs

S0	Main switch
S1	Needle thread monitor left
S2	Needle thread monitor right
S3	Pressure switch
S4	Corner knife station swiveled in
S5	Sewing material removal
S9	Lower pickup folder
S10	Folding station in initial position
S11	Folder single pipe
S12	Folder double pipe
S13	Top pickup folder
S14	Pickup folder on top of piping table
S15	Vertical pickup folder

S16	Slanted pickup folder
S17	Flap scan 1
S20	Flap scan 2
S21	Flap slant left
S24	Flap slant right
S90	Switch sewing light
S101	Ref. transport unit
S103	Ref. stepper motor pocket length
S104	Reference needle transport
S105	Ref. clamp left
S106	Ref. clamp right
S201	Pedal right, forward
S202	Pedal right, backward
S203	Pedal left, forward
S204	Pedal left, backward
S601	Reference slanted seam end
S602	Reference slanted seam beginning
S701	Ref. knife right, seam beginning
S702	Ref. knife left, seam beginning
S801	Ref. knife right, seam end
S802	Ref. knife left, seam end
S902	Tape control
S1001	Reference laser 1
S1002	Reference laser 2
S1101	Ref. piping cutter, seam beginning
S1102	Ref. piping cutter, seam end
S1201	Ref. guiding plate adjustment left
S1202	Ref. guiding plate adjustment right
S1301	Ref. stop folder height
S1302	Ref. stop turning device



2. Select an output in the right area:

Outputs

Y1	Needle thread trimmer
Y2	Hook thread trimmer
Y3	Needle thread tension on
Y4	2nd needle thread tension left
Y5	Blow out fluff, remaining thread monitor + thread advancing device
Y6	2nd needle thread tension right
Y7	Needle left on
Y8	Needle right on
Y9	Lift pick-up folder
Y10	Lower pick-up folder
Y11	Vacuum on
Y13	Marking lamp 1
Y14	Marking lamp 2
Y15	Marking lamp 3
Y16	Marking lamp 4
Y17	Lower left transport clamp
Y18	Lower right transport clamp
Y19	Lift left transport clamp
Y20	Lift right transport clamp
Y21	Close folding plates
Y22	Open left flap clamp
Y23	Open right flap clamp
Y24	Blowing On (flap clamp)
Y25	Stacker on/stacker tongs forward
Y26	Stacker bracket swiveled out
Y27	Corner knife up seam begin. left
Y28	Corner knife up seam end left
Y29	Corner knife up seam begin. right
Y30	Corner knife up seam end right
Y31	Lower outfeed roller
Y32	Blowing on (folding plate)
Y103	Cut tape
Y104	Press on/loosen tape
YC101	Marking lamp 5
YC102	Marking lamp 6

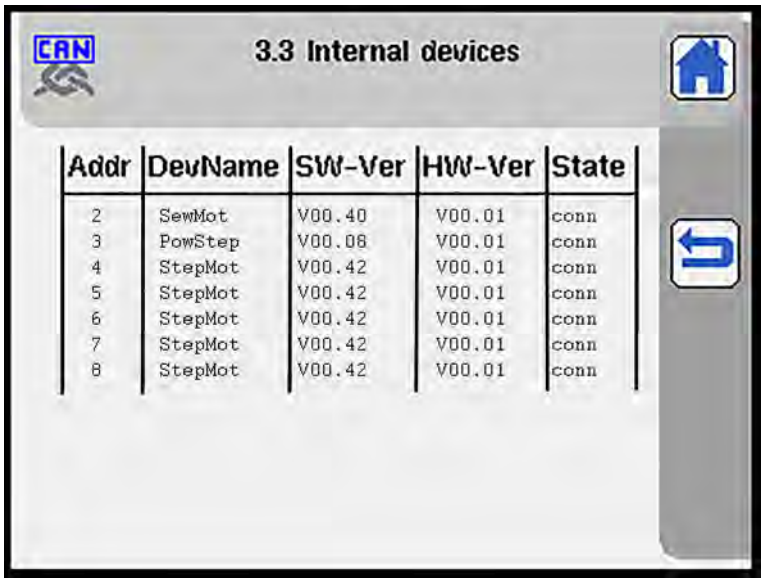
YC103	Marking lamp 7
YC104	Marking lamp 8
YC105	Open waistband clamp
YC106	Close waistband clamp
YC107	Needles waistband clamp
YC108	Pocket bag clamp
YC109	Stopper flap feed (mechanical)
YC110	Lower the turning device
YC111	Swivel the turning device
YC112	Close the turning device
YC201	Marking lamp 9
YC202	Marking lamp 10
YC203	Marking lamp 11
YC204	Marking lamp 12
YC205	Marking lamp 13
YC206	Marking lamp 14
YC207	Marking lamp 15
YC208	Marking lamp 16
YC209	Reserve
YC210	Reserve
YC211	Reserve
YC301	Spread the needles
YC302	Lift the folder
YC303	Blow tube right/left
YC304	Swivel the flap feeders in
YC305	Open the left flap feeder
YC306	Open the right flap feeder
YC307	Close the left flap feeder
YC308	Close the right flap feeder
YC309	Lift the flap feeders
YC310	Lower the stop motion device
YC311	Lift stop
YC312	Piping knife up seam begin.
YC313	Piping knife up seam end
YC314	Swivel pick-up folder



Internal devices

↳ The display switches to *Internal devices*.

Fig. 214: Internal devices



Addr	DevName	Meaning
2	SewMot	Sewing motor
3	PowStep	Motor transport axis
4	StepMot	Middle knife motor
5	StepMot	Corner knife block
6	StepMot	Needle transport
7	StepMot	Transport clamp left
8	StepMot	Transport clamp right

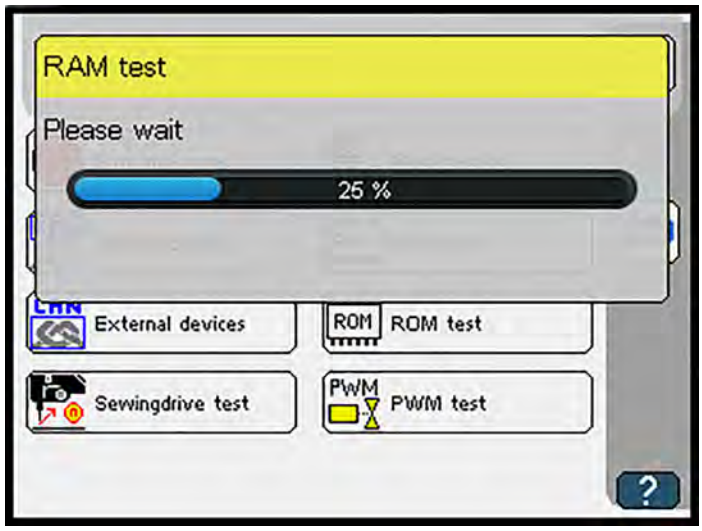
The area *State* can display 3 different status messages:

- conn = connected
- nc = not connected
- err = error

RAM-Test **RAM test**

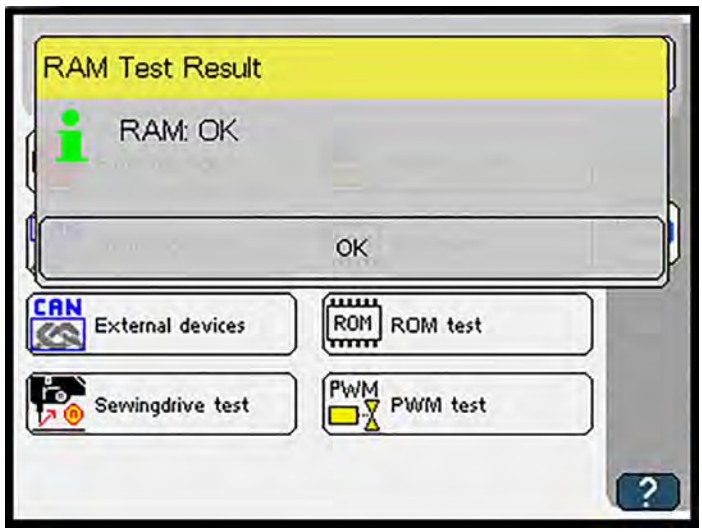
↳ The RAM test of the control is carried out. The progress of the test is indicated by a progress bar

Fig. 215: RAM test (1).



↳ The test result is displayed.

Fig. 216: RAM test (2)



1. If the result is shown as `OK`, press **OK** to confirm.

↳ The display returns to `Multi test`.

Information

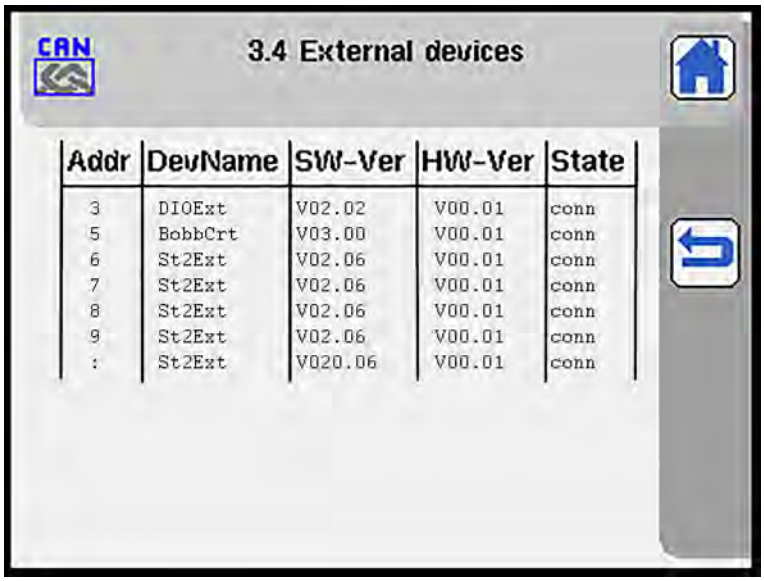
If the RAM test shows an error, back up your data and contact **Customer Service** (📖 *p. 331*).



External devices

↳ The display switches to *External devices*.

Fig. 217: External devices

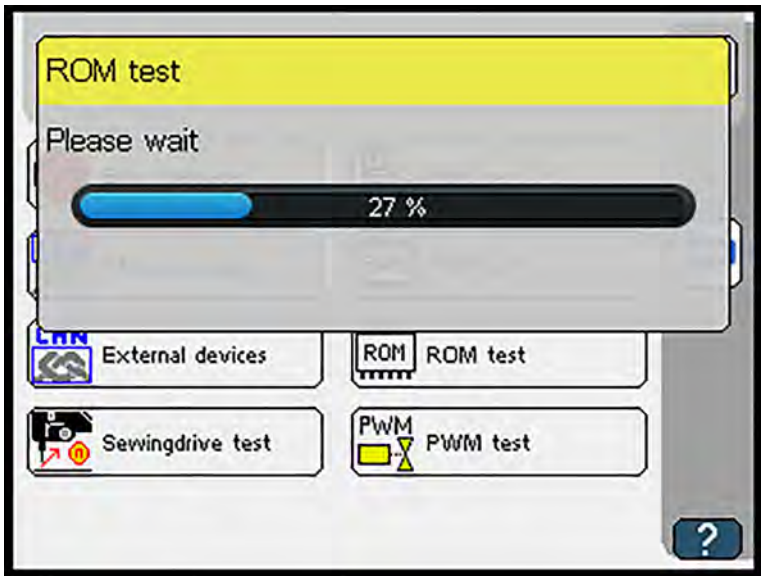


Addr	DevName	Meaning
2	DIOExt	Digital IO card
3	DIOExt	Digital IO card
4	DIOExt	Digital IO card
5	BobbCrt	Remaining thread monitor
6	St2Ext	Corner knife station: Slant activation seam beginning/seam end
7	St2Ext	Corner knife station: Angle adjustment seam beginning right/left
8	St2Ext	Corner knife station: Angle adjustment seam end right/left
9	St2Ext	Outfeed roller/tape feeder
10	St2Ext	Laser adjustment horizontal/vertical
11	St2Ext	Piping cutter
12	St2Ext	Guiding plate adjustment
13	St2Ext	Stop turning device/folder height

ROM-Test **ROM test**

↳ The ROM test of the control is carried out. The progress of the test is indicated by a progress bar.

Fig. 218: ROM test



↳ The test result is displayed. ROM error-free **OR** ROM defective.

1. If the result is shown as `OK`, press the **OK** button to confirm.

↳ The display returns to `Multi test`.

Information

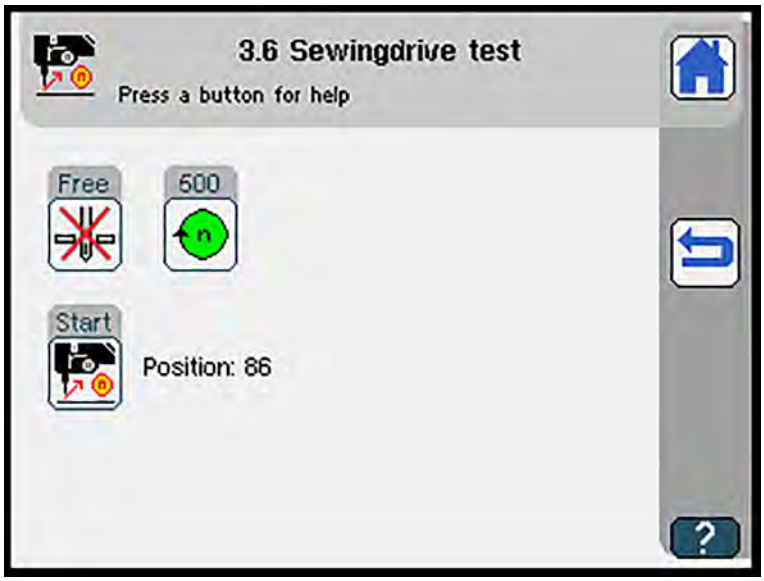
If the ROM test shows an error, back up your data and contact **Customer Service** (📖 *p. 331*).



Sewing drive test

↳ The display switches to *Sewing drive test*.

Fig. 219: Sewing drive test



Symbols	Meaning
	Select needle position •  Needle not positioned •  Needle down •  Needle up
	Adjust speed • 70 RPM - 3000 RPM
	Start sewing drive • Indicated position: Value of the motor setpoint device (exact motor position)



To test the sewing drive:

1. Press the desired button.
2. Enter the desired values using the numeric keypad.
3. Confirm with **OK**.

Starting the sewing drive 

CAUTION



Risk of injury from sharp or moving parts!

Puncture or crushing possible.

Do NOT reach into the moving part of the machine.

NOTICE

Property damage may occur!

Jamming of the machine.

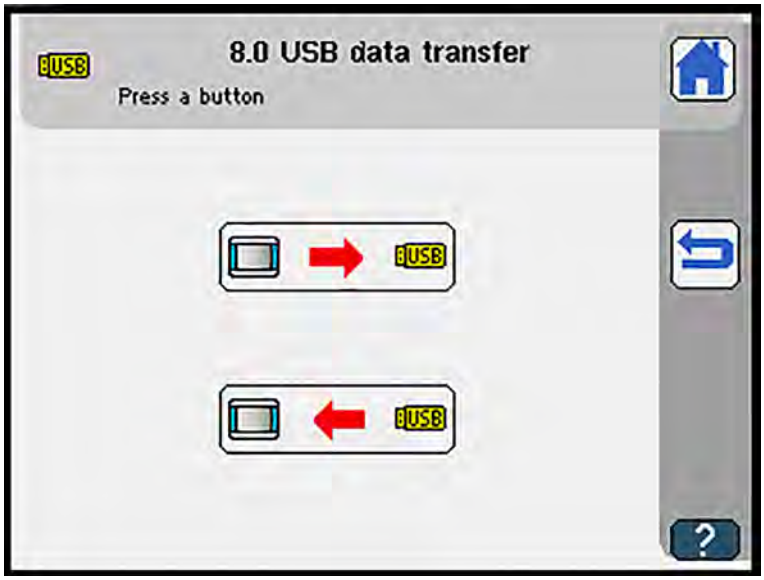
Unthread the needle thread before starting the sewing drive.

↳ The sewing drive starts at the set speed.

USB data transfer

↳ The display switches to `USB data transfer`.

Fig. 220: USB data transfer



Symbols	Meaning
	Write data to the USB key 📖 *p. 270*
	Read data from the USB key 📖 *p. 273*

To read and write data to and from the USB key:

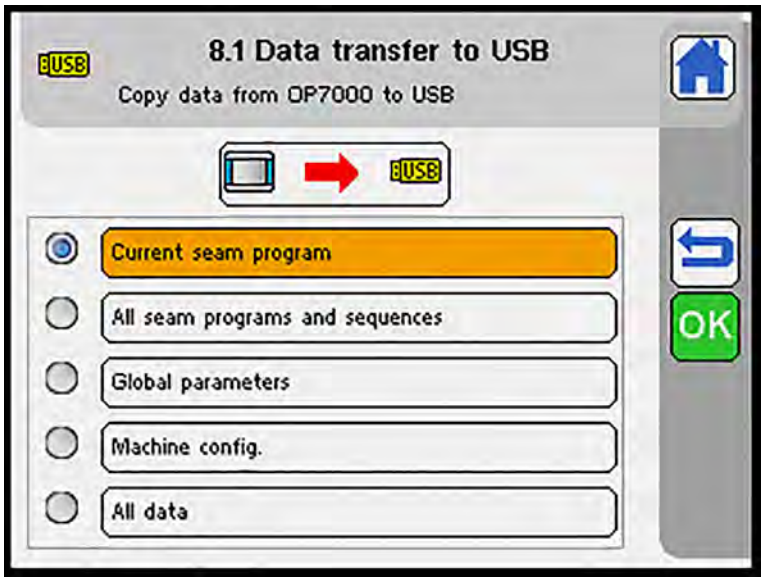
1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Writing data from the system to the USB key

↳ The display switches to *Data transfer to USB*.

Fig. 221: Data transfer to USB (1)



To write data from the system to the USB key:

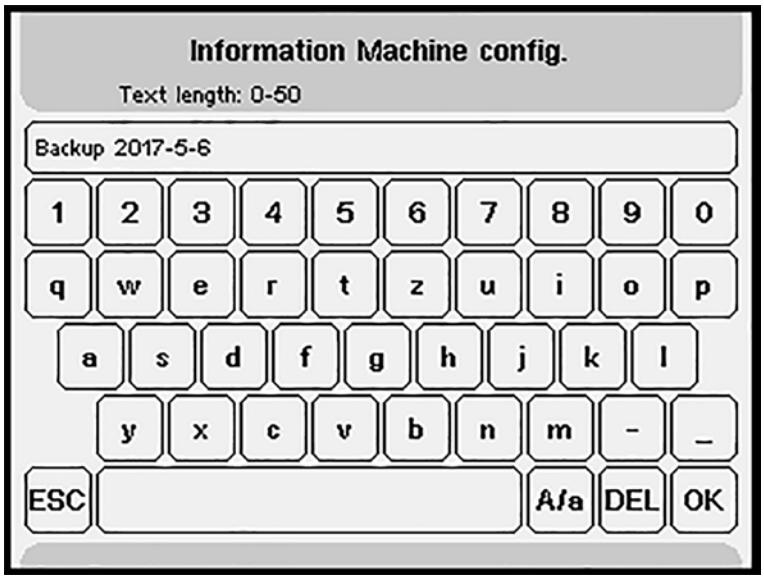
1. Select which data you wish to store on the USB key:
   - Current seam program
   - All seam programs and sequences
   - Global parameters
   - Machine config.
   - All data

↳ The selected option is highlighted in orange.

2. Press the OK button to confirm.

↳ The display switches to a keypad.

Fig. 222: Data transfer to USB (2)



3. You can use the keypad to enter an information text about the backup file.
   The information text is displayed again the next time the backup file is loaded.
   If you do not wish to enter an information text, press the **ESC** button.
4. Confirm with **OK**.

↳ The software checks the USB key.
The selected option is written to the USB key.
Depending on the amount of data selected, the process may take anywhere from a few seconds to approx. 2 minutes.

Information

You can cancel the USB data transfer with a press of the button.

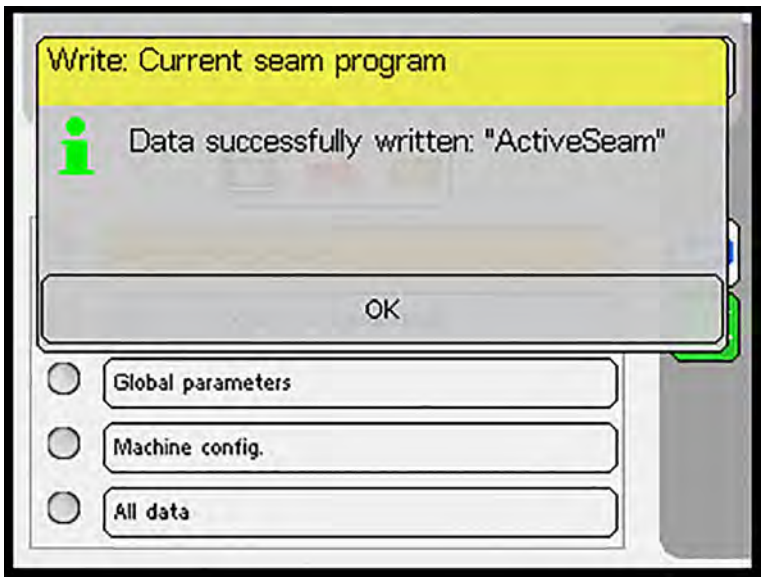
The following notice will appear if the selected data has already been stored on the USB key: *Already existing on USB: XY. Write? YES/NO*.

- Press **YES**: Data on the USB key is overwritten.
- Press **NO**: The display returns to `USB data transfer`.

The write process can take between a few seconds and several minutes depending on which write option has been selected.

↳ When the data has been written to the USB key, the display shows the message *Data successfully written: XY.*

Fig. 223: Data transfer to USB (3)



5. Press **OK**.

↳ The display returns to `USB data transfer.`

Reading data from the USB key to the system

NOTICE

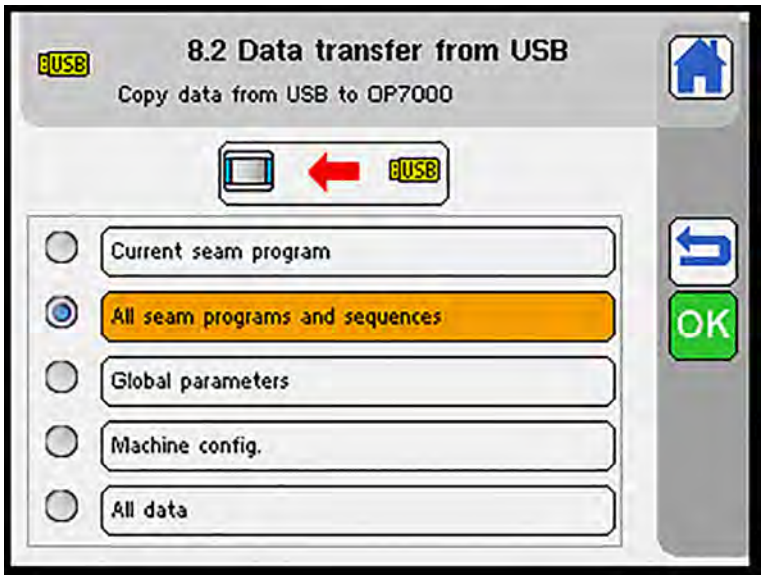
Property damage may occur!

The machine will not work if you load data from a wrong class. Loading data from an incorrect class will generate irregular error messages.

Check the class before loading *Machine configuration* or *All data*. After loading *Machine configuration* or *All data*, check the class and the configuration in the `Machine configuration` menu.

↳ The display switches to `Data transfer from USB`.

Fig. 224: Data transfer from USB

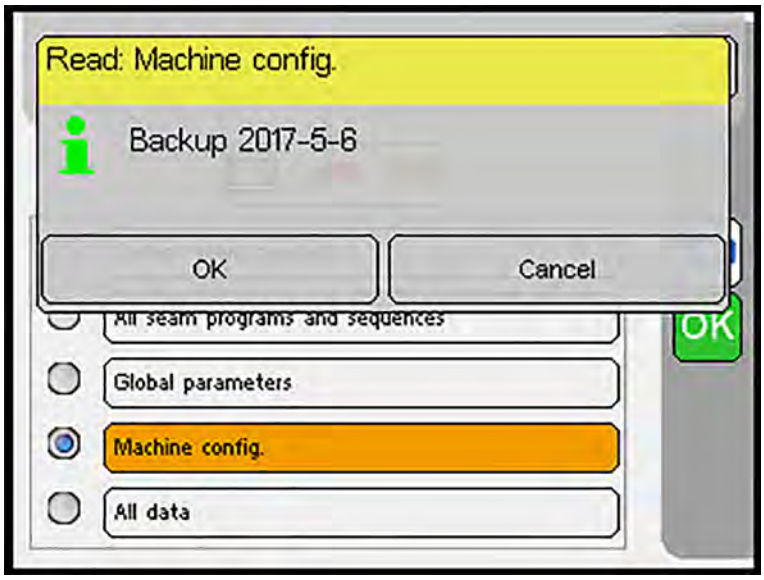


To read data from the USB key to the system:

1. Select which data you wish to store in the control:
   - Current seam program
   - All seam programs
   - All seam programs and sequences
   - Global parameters
   - Machine config.
2. Press the OK button to confirm.

↳ The software checks the USB key.
If you saved an information text for the backup file, the text will be displayed.

Fig. 225: Data transfer from USB



3. Confirm with **OK**.

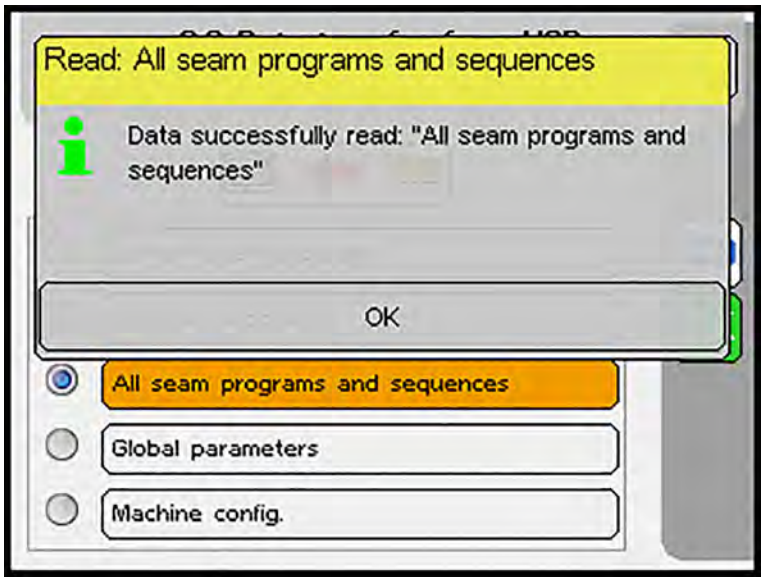
↳ The selected option is written to the OP7000.

Information

You can cancel the USB data transfer with a press of the button.

The write process can take between a few seconds and several minutes depending on which write option has been selected.

↳ When the data has been written to the OP7000, the display shows the message *Data successfully read: XY.*



4. Press **OK**.

↳ The display returns to `USB data transfer.`

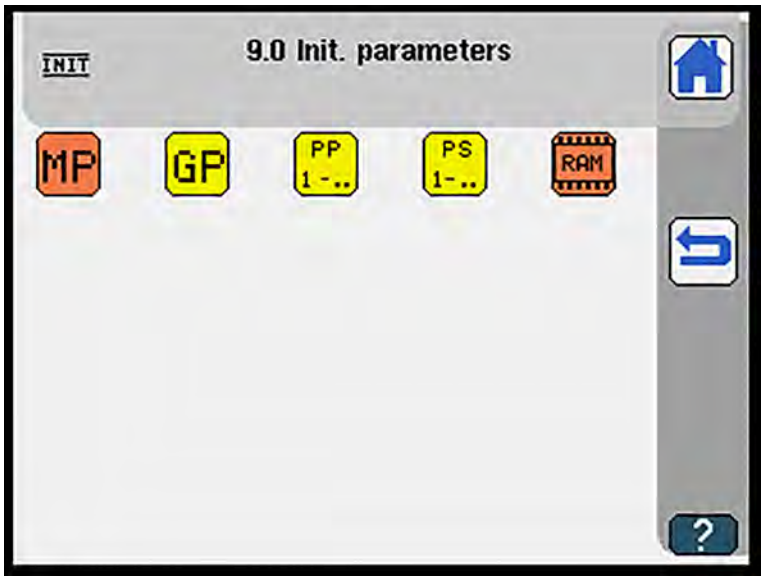
Init. parameters

Important

The *Parameter init.* Is protected with a password. Use this option to reset the basic machine parameters.
The password is 25483.

↳ The display switches to *Init. parameters*.

Fig. 226: Init. parameters



Symbols	Meaning
MP	Initialize machine configuration • **All stored data will be lost** • Machine parameters will be reset to the factory default settings
GP	Initialize global parameters • **All stored data will be lost** • Global parameters will be reset to the factory setting
PP 1 -..	Initialize all seam programs • **All stored data will be lost** • All seam programs will be reset to the factory default settings
PS 1-..	Initialize all sequences • **All stored sequences will be lost** • All sequences will be reset to the factory default settings
RAM	Initialize RAM • **All stored data will be lost** **All machine data is initialized at the same time (master reset)** • All settings will be reset to the factory setting

To initialize the parameters:

1. Press the desired button.
2. Press **OK** to reset the values to their factory settings.
3. Press **Cancel** to cancel the initialization.

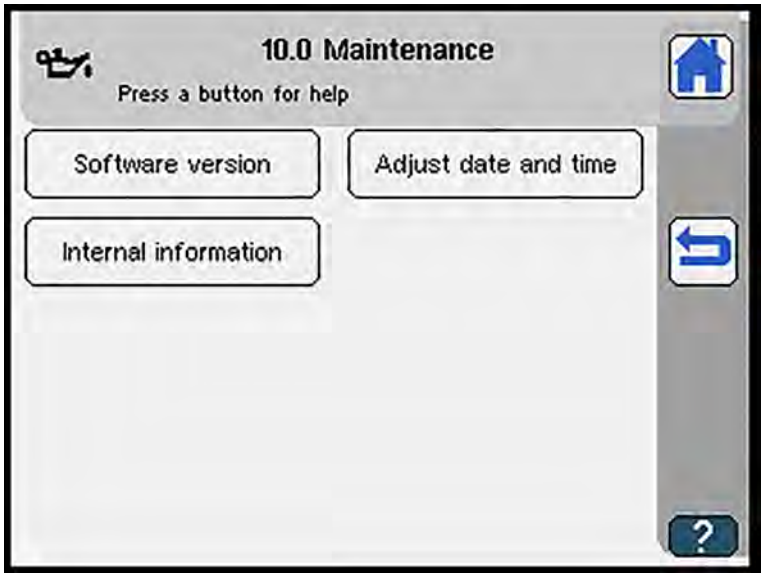
Information

New reference data will be loaded internally from the control or, if available, from the machine ID.

Maintenance

↳ The display switches to `Maintenance`.

Fig. 227: Maintenance



Symbols	Meaning
Softwareversion	Displays the current software version 📖 *p. 279*
Datum	Enter date and time 📖 *p. 280*
Interne Informationen	for DA service staff only

To edit the parameters in the `Maintenance` menu item:

1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

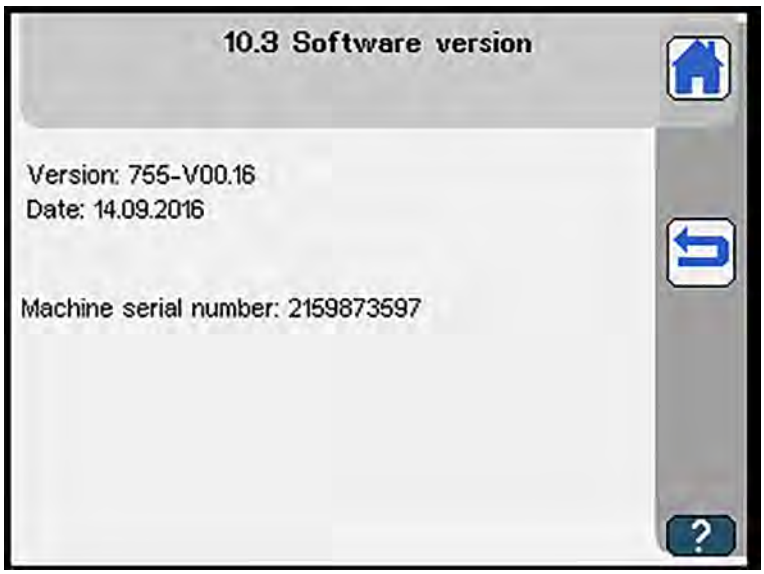
Software version **Software version**

To display the software version:

1. Press the **Software version** button.

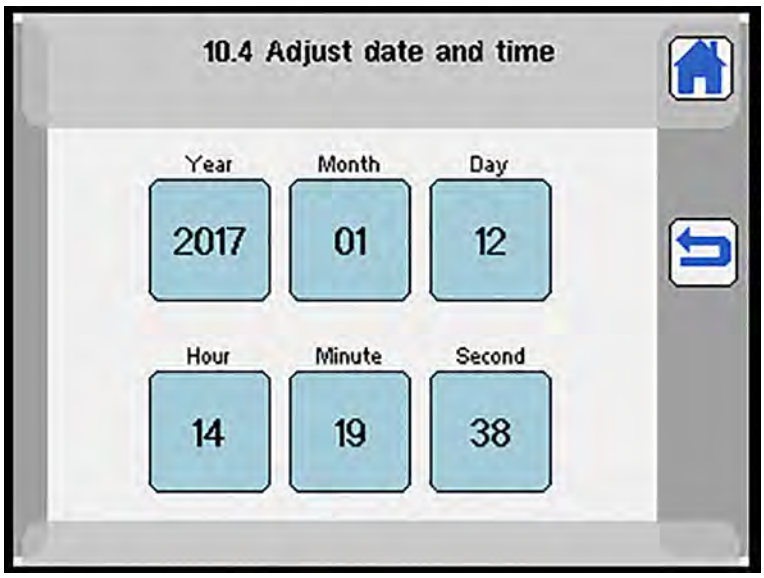
↳ The display shows the current software version.
You will need this information when contacting the DA service department for assistance.

Fig. 228: Software version



Datum **Date and time**

Fig. 229: Date and time



To enter date and time:

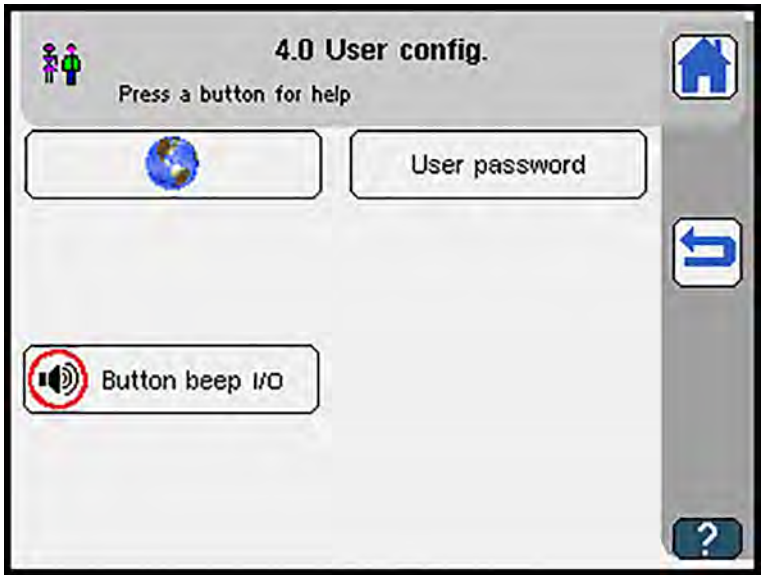
1. Press the **Date** button.
2. Use the numeric keypad to enter the desired date.
3. Use the numeric keypad to enter the desired time.

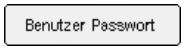


User configuration

↳ The display switches to `User config.`

Fig. 230: User configuration



Symbols	Meaning
	Language selection 📖 *p. 282*
	Set user password 📖 *p. 283*
	Button beep On/Off



To adjust the user configuration:

1. Press the desired button.

↳ The user interface for setting the desired item is displayed.

Language selection

↳ The display switches to *Language selection*.

Fig. 231: Language selection



To select the language:

1. Select the desired language.

↳ The system restarts with the new language setting.

Benutzer Passwort **User password setup**

Information

To set up a user password, the user password option must be activated in the Global parameters (📖 *p. 203*).

If a user password already exists, you need to enter this password before you can create a new user password.

To activate password protection, you need to restart the machine. When the machine starts up, you will be prompted to enter the user password you created.

Fig. 232: User password setup (1)



To set up a user password:

1. Enter the desired 4-digit PIN.
2. Confirm with **OK**.
3. Re-enter the password (password check).
4. Confirm with **OK**.

Information

After setting up a user password, you can lock the start screen for other operators with a press of the button.

Fig. 233: User password setup (2)



Updating the machine software

Information

There is a .zip file (9899_DAC001_000_A01.27_2016-02-14.jcbi) containing

- the update file for the control panel
- the update file for the control

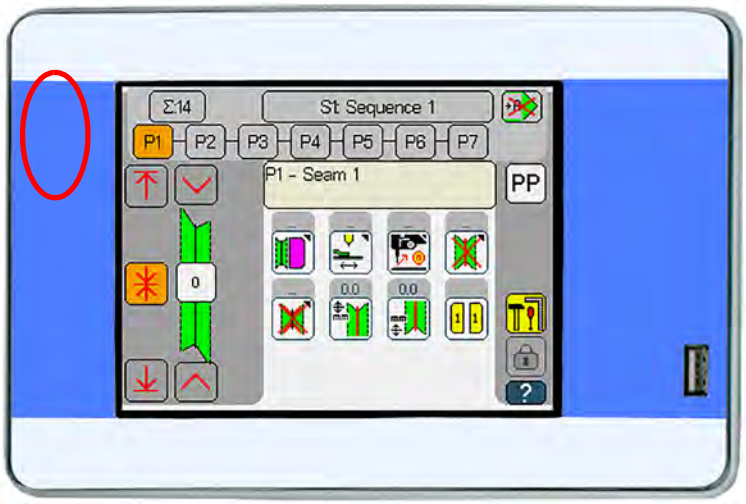
The update is performed in 2 steps.

The control panel OP7000 is updated first.
In a second step, a software update is performed for the control (DAC comfort).

To perform an update of the machine software:

1. Download the update file from Dürkopp Adler's website.
   The file is named, for example:
   9899_DAC001_000_A01.27_2016-02-14.jcbi
2. Copy the update file to a blank Dürkopp Adler USB key (part number 9835 301003).

Fig. 234: Updating the machine software (1)



3. Switch off the machine and wait for approx. 15 seconds.
4. Connect the Dürkopp Adler USB key to the OP7000.
5. Restart the machine.

↳ The OP7000 boot loader appears:

Fig. 235: Updating the machine software (2)



↳ The OP7000 detects the USB key and updates the operating software first.

Fig. 236: Updating the machine software (3)



↳ The update will take approx. 2 minutes.

Important

Do not switch off the machine while the update is in progress!

6. Remove the USB key when prompted to do so.

↳ The machine restarts automatically.
The display shows notice 8403: *Machine has an outdated program. Should the new program be transmitted?*

7. If the machine fails to restart: Switch off and on the machine again.

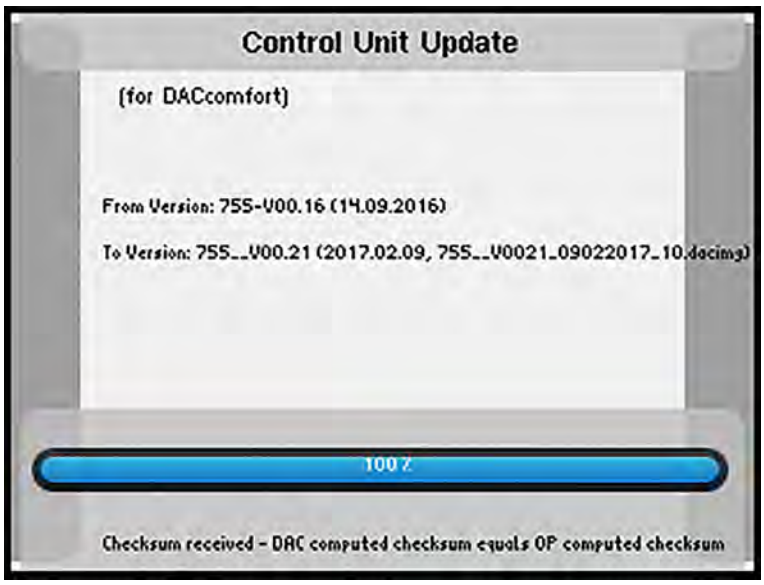
Fig. 237: Updating the machine software (4)



8. Confirm with **OK**.

↳ The update is carried out.

Fig. 238: Updating the machine software (5)

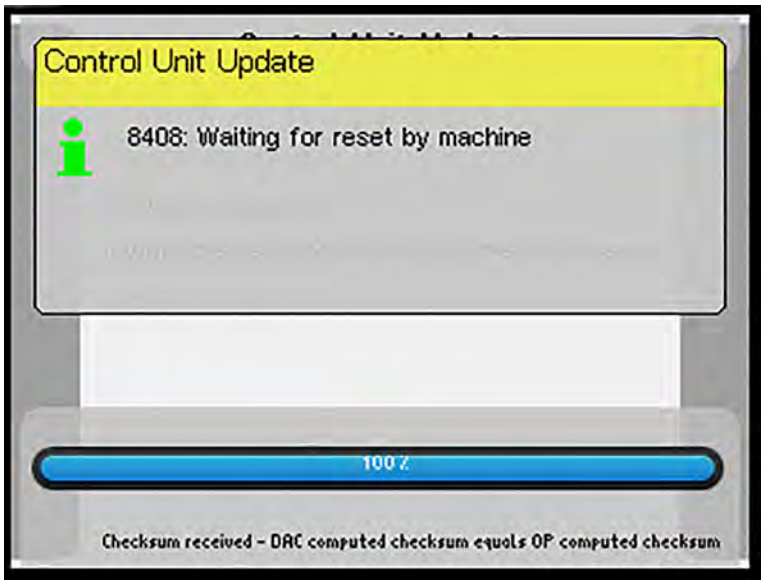


Important

Do not switch off the machine while the update is in progress!

↳ The display shows notice 8408: *Waiting for Reset by machine*.

Fig. 239: Updating the machine software (6)



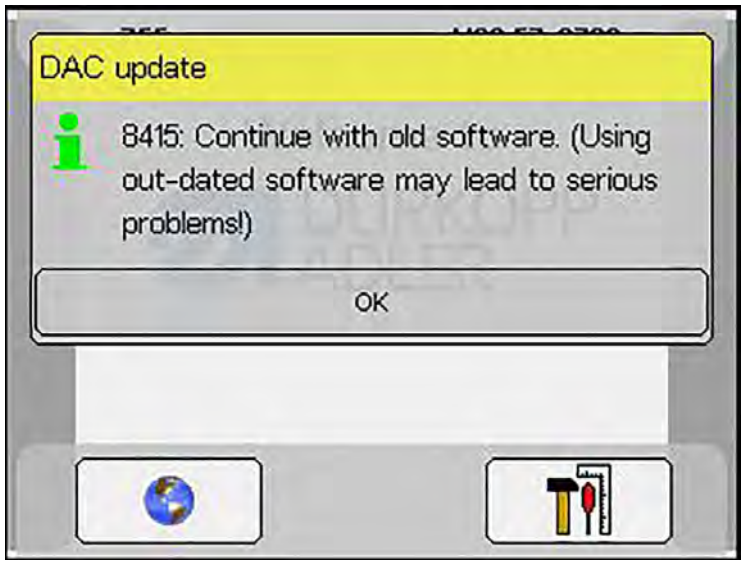
↳ The machine restarts automatically.
After restarting, the machine loads the start screen and is ready for operation.

OR

9. Press **CANCEL** to cancel the update.

↳ The following warning appears:

Fig. 240: Updating the machine software (7)



↳ After confirming with **OK**, you can continue working with the old control software.

Information

If the update fails, you can restart it in the service menu under DAC update (📖 *p. 254*).

6 Maintenance

This chapter describes maintenance work that needs to be carried out on a regular basis to extend the service life of the machine and achieve the desired seam quality.

Advanced maintenance work may only be carried out by qualified specialists, (🕮 *Service Instructions*).

WARNING



Risk of injury from sharp parts!

Punctures and cutting possible.

Prior to any maintenance work, switch off the machine or set the machine to threading mode.

WARNING



Risk of injury from moving parts!

Crushing possible.

Prior to any maintenance work, switch off the machine or set the machine to threading mode.

Maintenance intervals

Work to be carried out	Operating hours			
	8	40	160	500
Removing sewing dust and thread residues	●			
Cleaning the lenses of the light barriers	●			
Checking the water level	●			
Checking the oil reservoir	●			
Checking the pneumatic system	●			
Cleaning the incision device for piping ends		●		

6.1 Cleaning

WARNING



Risk of injury from flying particles!

Flying particles can enter the eyes, causing injury.

Wear safety goggles.
Hold the compressed air gun so that the particles do not fly close to people.
Make sure no particles fly into the oil pan.

NOTICE

Property damage from soiling!

Sewing dust and thread residues can impair the operation of the machine.

Clean the machine as described.

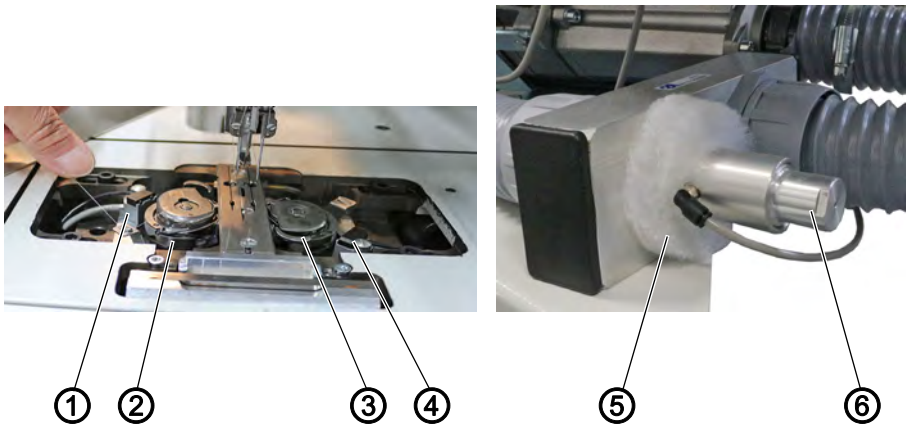
NOTICE

Property damage from solvent-based cleaners!

Solvent-based cleaners will damage paintwork.

Use only solvent-free substances for cleaning.

Fig. 241: Cleaning



(1) - Light barrier
(2) - Hook
(3) - Hook
(4) - Light barrier
(5) - Filter ring
(6) - Vacuum valve

Check and clean daily

- Use a compressed air gun to clean the areas of hook (2) and (3).
- Clean the lenses of light barriers (1) and (4) at the remaining thread monitor with a soft cloth every time you change the bobbin.
- To clean the filter ring (5) at the vacuum valve (6): Blow out the filter using a compressed air gun.

6.2 Cleaning the incision device for piping ends

WARNING



Risk of injury from sharp parts!

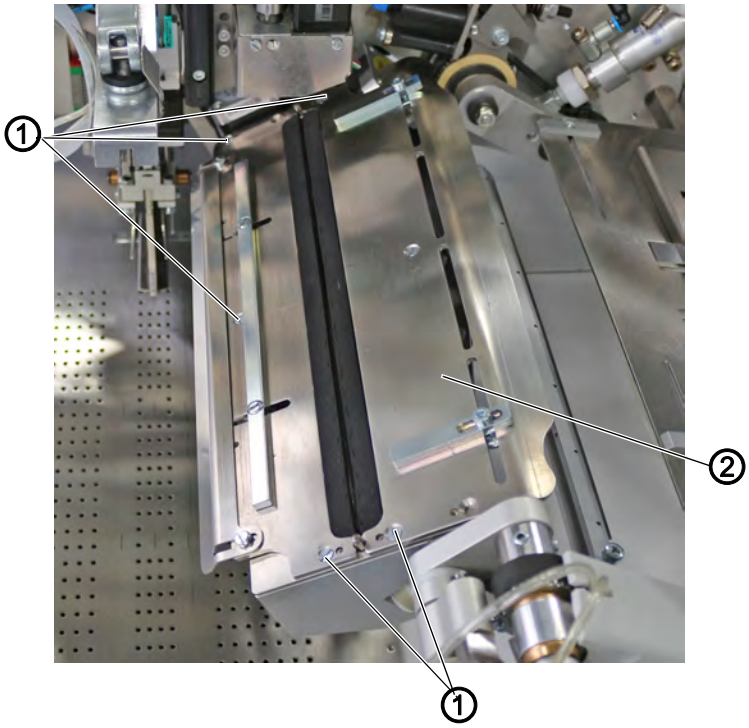
Punctures and cutting possible.

Switch off the machine prior to any maintenance work.

To clean the incision device for piping ends:

1. Switch off the machine.
2. Remove the pick-up folder.

Fig. 242: Cleaning the incision device for piping ends (1)

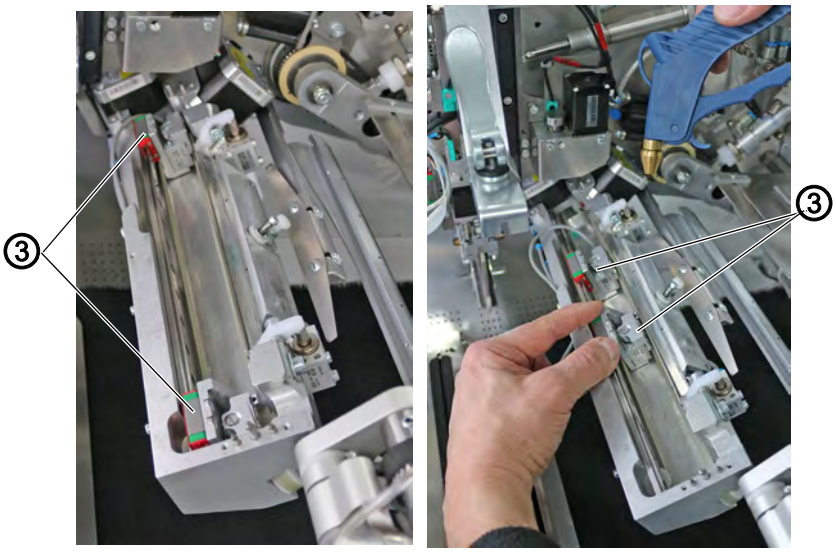


(1) - Screws

(2) - Piping strip rest table

3. Loosen the screws (1).
4. Remove the piping strip rest table (2).

Fig. 243: Cleaning the incision device for piping ends (2)



(3) - Linear guides

5. Move the linear guide (3) by hand while carefully cleaning all areas with compressed air.
6. Replace the piping strip rest table (2).
7. Re-tighten the screws (1).
8. Re-assemble the pick-up folder.
9. Switch on the machine.

↳ The machine completes a reference run and is afterwards ready for sewing.

6.3 Replacing the incision knives for piping ends

WARNING



Risk of injury from sharp parts!

Punctures and cutting possible.

Switch off the machine prior to any maintenance work.

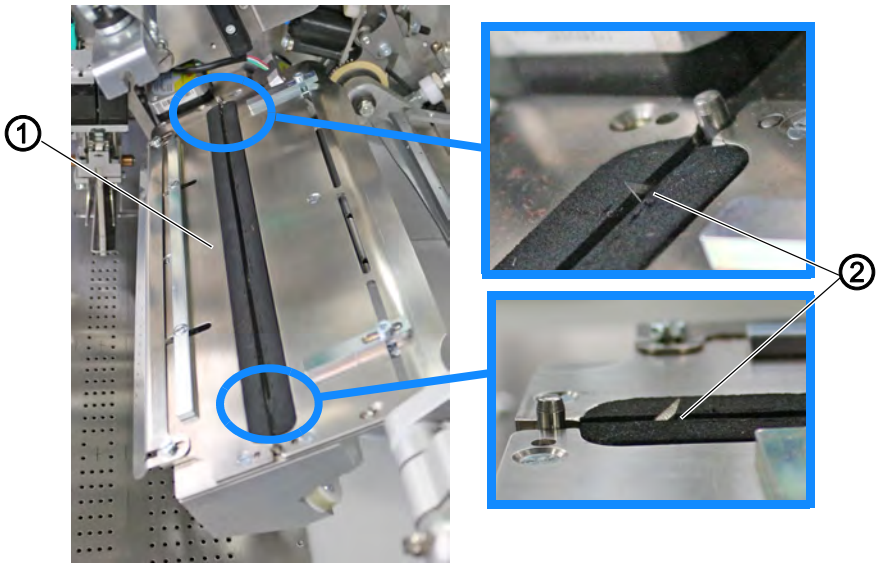
To replace the knives of the incision device for piping ends:

1. Remove the pick-up folder.
2. Via software: Select *Service menu* > *Machine test* > *Test piping knife*  > *Referencing*  .

3. Next, select *Knife change position*  .

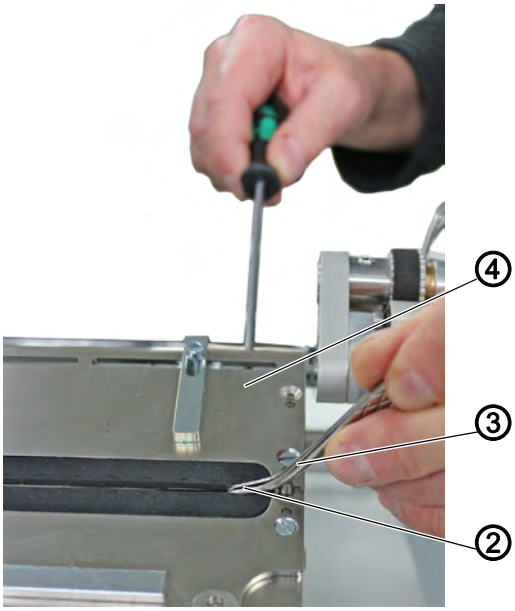
↳ The knives (2) extend with a clicking sound and can be seen at the piping strip rest table (1).

Fig. 244: Replacing the incision knives for piping ends (1)



(1) - Piping strip rest table
(2) - Knife

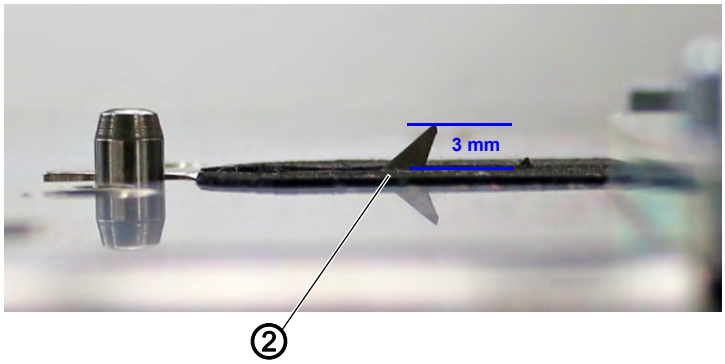
Fig. 245: Replacing the incision knives for piping ends (2)



(2) - Knife
(3) - Tweezers
(4) - Screw (covered)

4. Loosen the screw (4) by a 1/4 turn while holding in place and removing the knife (2) with a pair of tweezers (3).

Fig. 246: Replacing the incision knives for piping ends (3)



(2) - Knife

5. Insert a new knife (2) and tighten the screw (4) - IMPORTANT: the knife (2) must protrude 3 mm.
6. Exit the software with a press of the  button.

↳ The machine completes a reference run

7. Re-assemble the pick-up folder.

↳ The machine is ready to sew again.

6.4 Lubricating

CAUTION



Risk of injury from contact with oil!

Oil can cause a rash if it comes into contact with skin.

Avoid skin contact with oil.
If oil has come into contact with your skin, wash the affected areas thoroughly.

NOTICE

Property damage from incorrect oil!

Incorrect oil types can result in damage to the machine.

Only use oil that complies with the data in the instructions.

CAUTION



Risk of environmental damage from old oil!

Incorrect handling of old oil can result in severe environmental damage.

ALWAYS observe the legally prescribed regulations for handling and disposal of mineral oil.

Take care to ensure that oil is NEVER spilled.

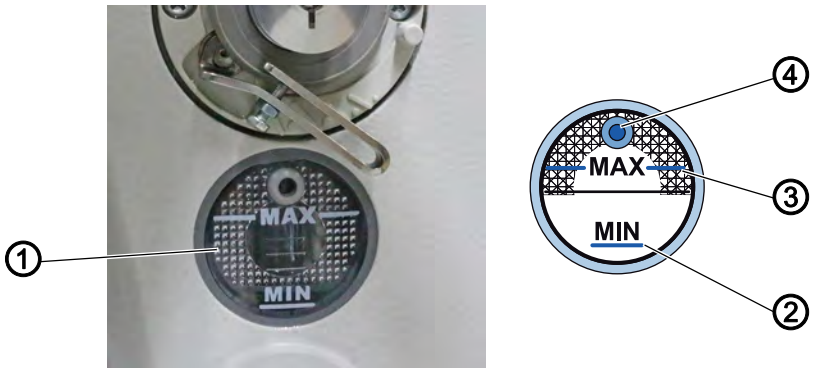
For topping off the oil reservoir, use only lubricating oil **DA 10** or oil of equivalent quality with the following specifications:

- Viscosity at 40 °C: 10 mm²/s
- Flash point: 150 °C

You can order the lubricating oil from our sales offices using the following part numbers:

Container	Part no.
250 ml	9047 000011
1 l	9047 000012
2 l	9047 000013
5 l	9047 000014

Fig. 247: Lubricating



(1) - Oil reservoir
(2) - MIN marking
(3) - MAX marking
(4) - Hole

Proper setting

The oil level must not raise above the MAX marking (3) or drop below the MIN marking (2).

To top off the oil:

1. Refill oil through the hole (4) in the inspection glass until the oil level reaches the MAX marking (3).

2. Check the oil level and top off if necessary.

Information

The OP7000 control panel displays a message when the oil level is low.

6.5 Servicing the pneumatic system

6.5.1 Disconnecting the compressed air supply

Fig. 248: Disconnecting the compressed air supply



(1) - Handle

To disconnect the compressed air supply:

1. Pull the handle (1) on the compressed air maintenance unit to the left.

6.5.2 Adjusting the operating pressure

NOTICE

Property damage from incorrect adjustment!

Incorrect operating pressure can result in damage to the machine.

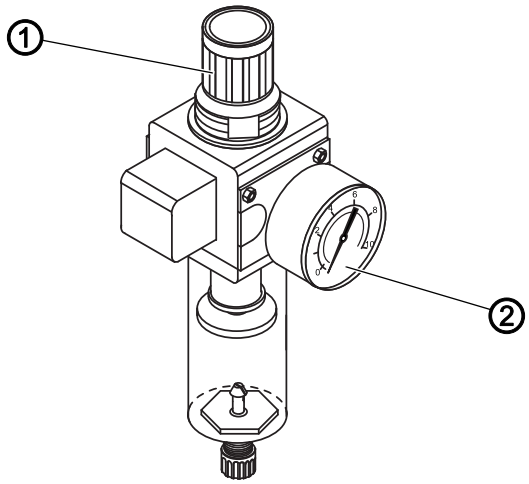
Ensure that the machine is only used when the operating pressure is set correctly.

Proper setting

Refer to the **Technical Data** (📖 *p. 351*) chapter for the permissible operating pressure. The operating pressure cannot deviate by more than ± 0.5 bar.

Check the operating pressure on a daily basis.

Fig. 249: Adjusting the operating pressure



(1) - Pressure regulator *(2) - Pressure gage*

To adjust the operating pressure:

1. Pull the pressure regulator (1) up.
2. Turn the pressure regulator until the pressure gage (2) indicates the proper setting:
   - Increase pressure = turn clockwise
   - Reduce pressure = turn counterclockwise
3. Push the pressure regulator (1) down.

Information

The OP7000 control panel displays a message if there is no air pressure or the air pressure is insufficient. The machine will not be ready to sew again until the compressed air supply has been restored.

6.5.3 Draining the water-oil mixture

NOTICE

Property damage from excess liquid!

Too much liquid can result in damage to the machine.

Drain liquid as required.

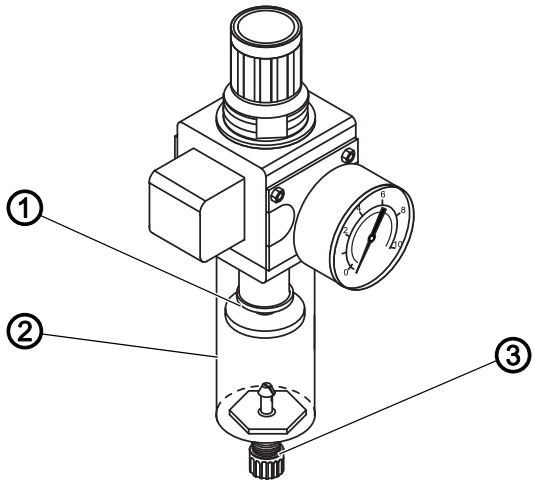
The collection tray (2) of the pressure regulator will show accumulation of a water-oil mixture.

Proper setting

The water-oil mixture must not rise up to the level of the filter element (1).

Check the level of the water-oil mixture in the collection tray (2).

Fig. 250: Draining the water-oil mixture



(1) - Filter element
(2) - Collection tray
(3) - Drain screw

To drain the water-oil mixture:

1. Disconnect the machine from the compressed air supply.
2. Place the vessel under the drain screw (3).
3. Loosen the drain screw (3) completely.
4. Allow the water-oil mixture to drain into the vessel.
5. Tighten the drain screw (3).
6. Connect the machine to the compressed air supply.

6.5.4 Cleaning the filter element

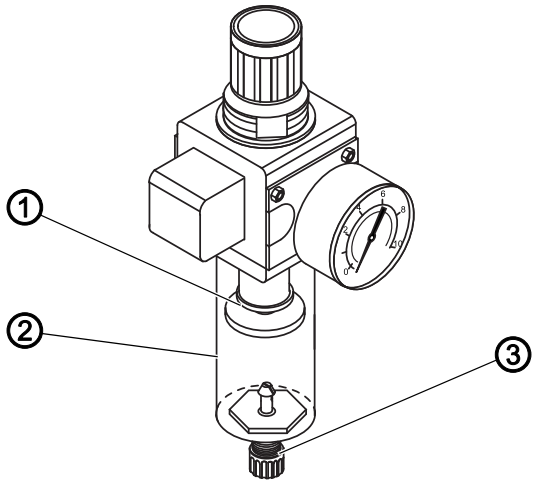
NOTICE

Damage to the paintwork from solvent-based cleaners!

Solvent-based cleaners damage the filter.

Use only solvent-free substances for washing out the filter tray.

Fig. 251: Cleaning the filter element



(1) - Filter element
(2) - Collection tray
(3) - Drain screw

To clean the filter element:

1. Disconnect the machine from the compressed air supply.
2. Drain the water-oil mixture (📖 *p. 300*).
3. Unscrew the collection tray (2).
4. Unscrew the filter element (1).
5. Blow out the filter element (1) using the compressed air gun.
6. Wash out the filter tray using benzine.
7. Tighten the filter element (1).
8. Tighten the collection tray (2).
9. Tighten the drain screw (3).
10. Connect the machine to the compressed air supply.

6.6 Parts list

A parts list can be ordered from Dürkopp Adler. Or visit our website for further information at:

www.duerkopp-adler.com

7 Setup

WARNING



Risk of injury from a lack of specialist knowledge!

Inadequate specialist knowledge can result in serious injuries when setting up the machine.

Allow ONLY trained personnel to setup the machine.

DANGER



Risk of injury from electricity!

Unprotected contact with electricity can result in serious injuries or death.

Work on the electrical system must ONLY be carried out by qualified electricians or appropriately trained and authorized personnel.

ALWAYS pull the power plug before working on the electrical equipment.

7.1 Scope of delivery

The scope of delivery depends on your specific order. Check that all parts are present before setting up the machine:

- Basic equipment
- Additional equipment
- Small parts in an accessory pack

7.2 Transport

WARNING



Risk of injury from incorrect transport!

Crushing.

Do NOT lift the machine at the tabletops.

ALWAYS use lifting carriage or stacker.

WARNING



Risk of injury from unstable footing!

Crushing.

Before commissioning the machine, loosen the stand feet until a secure footing is achieved.

7.2.1 Lifting the machine

Important

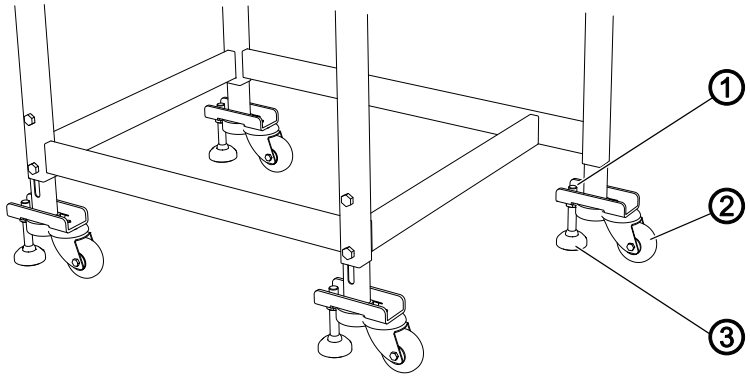
When lifting the stand without casters, ONLY use a lifting carriage or stacker.

7.2.2 Rolling the machine

Information

For in-house transport the stand can be equipped with 4 casters.

Fig. 252: Rolling the machine



(1) - Nuts
(2) - Casters
(3) - Stand feet

To roll the machine:

1. To transport the machine on casters, loosen the nuts (1) of the stand feet (3) and screw in the stand feet (3).
2. When transport is complete, loosen the stand feet (3) until the casters (2) lift off the ground.
3. Tighten the nuts (1).

7.2.3 Removing the transport locks

Remove all transport locks before setting up the machine.

All moving parts must be unlocked:

- Transport carriage
- Method plate
- Corner knife station
- Middle knife
- Feeder
- Assembly groups, e. g. stacker

Important

If you wish to transport the machine to a different location, you have to attach the transport locks again.

When removing/fitting the transport locks, also observe the information given in the supplementary sheet included with the machine.

7.2.4 Adjusting the working height

The working height can be adjusted between 797 mm and 1138 mm (measured to the upper edge of the tabletop).

The sewing unit has been set to the lowest working height of 797 mm at the factory.

WARNING

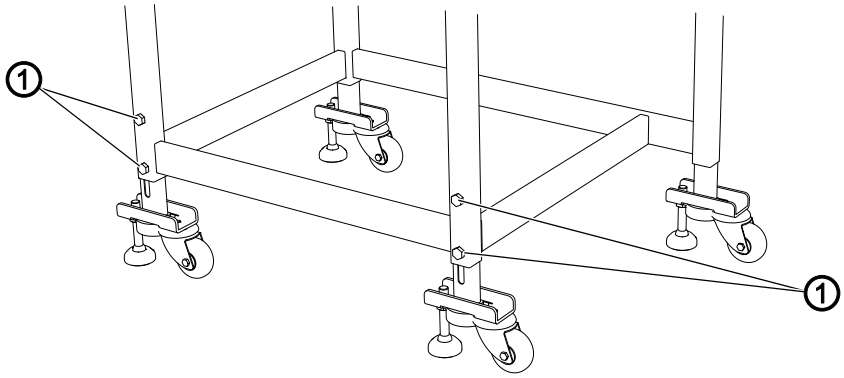


Risk of injury from unstable footing!

Tipping of the machine.

Use caution when loosening the screws.

Fig. 253: Adjusting the working height



(1) - Screws

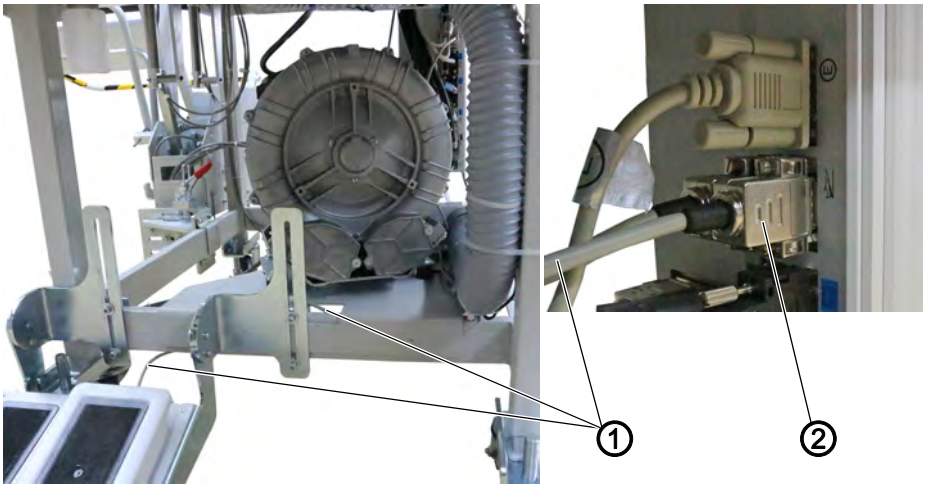


To set the desired working height:

1. Loosen the screws (1).
   Do not loosen the screws (1) all the way.
2. Set the tabletop to the desired working height.
3. To avoid jamming, slide the stand tubes in or out evenly on both sides.
4. Tighten the screws (1).

7.2.5 Connecting the pedals

Fig. 254: Connecting the pedals



(1) - Cable *(2) - Plug*

To connect the pedals:

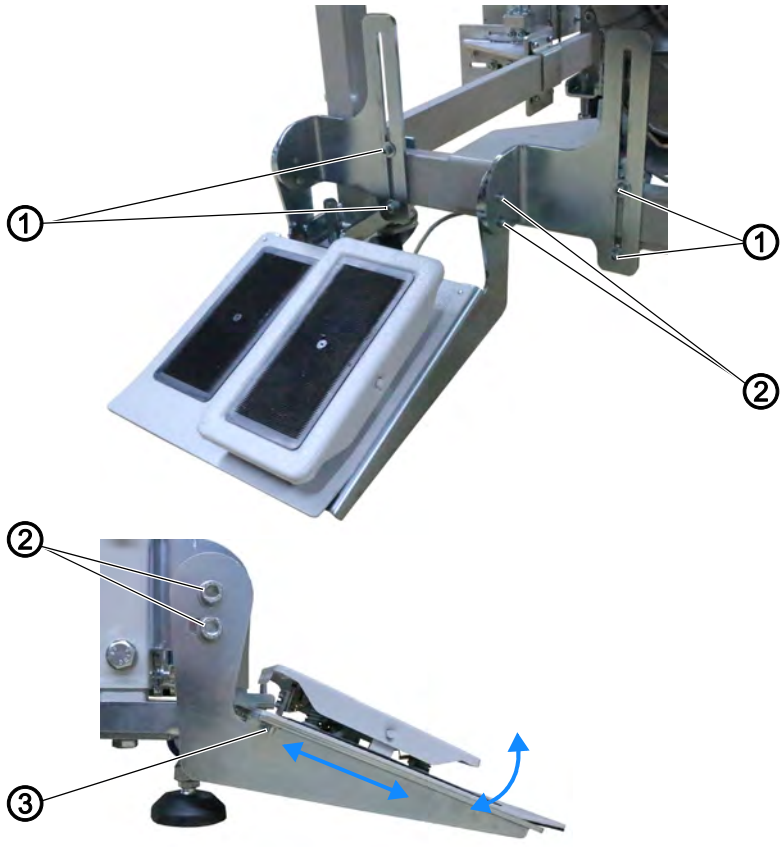
1. Lay the cable (1) in such a way that it cannot be damaged when the stand is lifted with a forklift.
2. Connect the plug (2) with the control.

7.2.6 Adjusting the pedals

Information

The pedals can be adjusted in height, angle of inclination, lateral position and alignment towards the front or rear.

Fig. 255: Adjusting the pedals



(1) - Screws
(2) - Screws
(3) - Screws

To adjust the **height** of the pedals:

1. Loosen the screws (1).
2. Shift the position of the screws (1) in the slotted hole.
   Make sure the height of the pedal is even.
3. Tighten the screws (1).

To adjust the pedals' **angle** of inclination:

1. Loosen the screws (2).
2. Swivel the pedal.
3. Tighten the screws (2) at the pedals' desired angle of inclination.

To adjust the **lateral position** of the pedals:

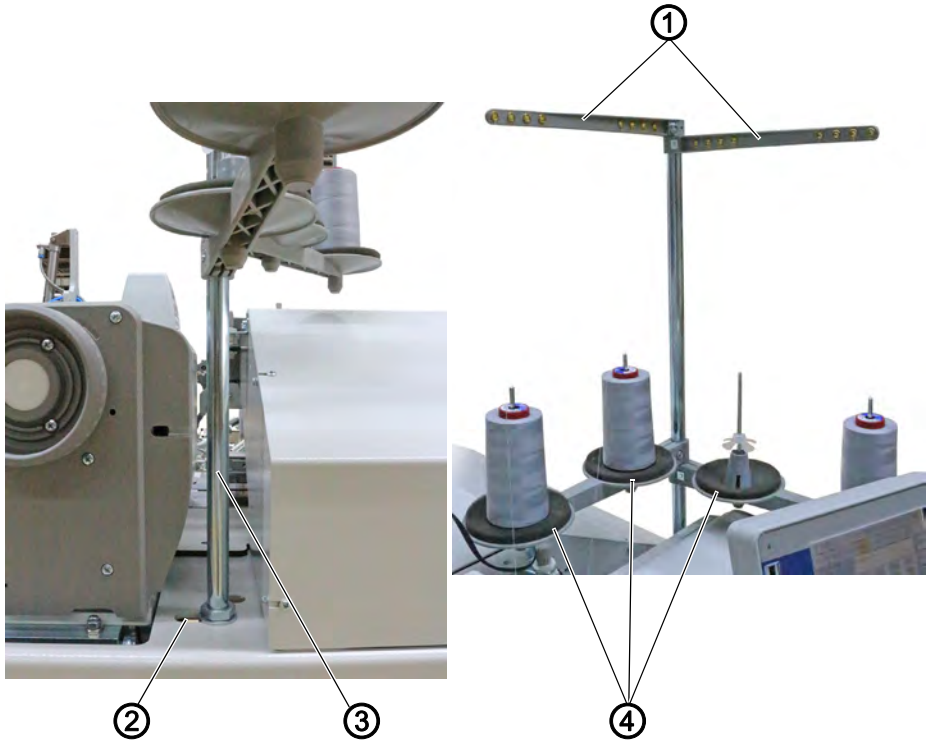
1. Loosen the screws (1).
2. Shift the pedal laterally on the stand bar.
3. Tighten the screws (1).

To shift the position of the pedals **to the front or the rear**:

1. Loosen the screws (3).
2. Slide the pedals forward or backward.
3. Tighten the screws (3).

7.3 Assembling the reel stand

Fig. 256: Assembling the reel stand



(1) - Unwinder arms
(2) - Slotted hole
(3) - Reel stand
(4) - Reel plate

To assemble the reel stand:

1. Insert the reel stand (3) into the slotted hole (2) in the tabletop and assemble it with washer and nut below the tabletop.
2. Assemble and align the reel plate (4) and the unwinder arms (1) as shown in the figure.

7.4 Assembling the control panel

Fig. 257: Assembling the control panel



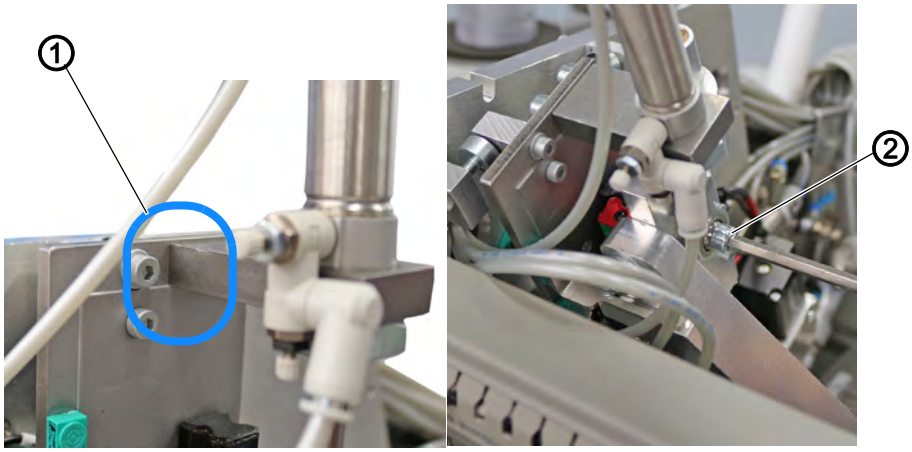
(1) - Control panel
(2) - Screws
(3) - Plug

To assemble the control panel:

1. Tighten the control panel (1) to the control panel holder using the screws (2).
2. Insert and tighten the plug (3).

7.5 Assembling the cylinder for the pick-up folder stroke

(4) - Assembling the cylinder for the pick-up folder stroke (1)

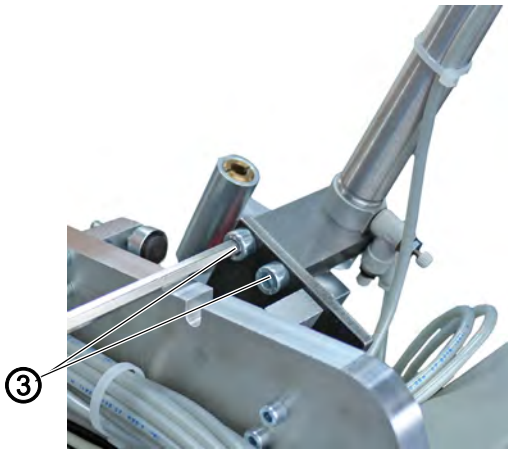


(1) - push up against
(2) - Screw

To assemble the cylinder for the pick-up folder stroke.

1. Push the cylinder up against the holder (1).
2. Tighten the screws (3) loosely.
3. Tighten the screw (2).

Fig. 258: Assembling the cylinder for the pick-up folder stroke (2)



(3) - Screws

4. Tighten the screws (3).
5. Move the mounting plate for the pick-up folder by hand.

↳ The movement must be smooth along the entire length of the cylinder stroke.

7.6 Assembling the throw-over stacker

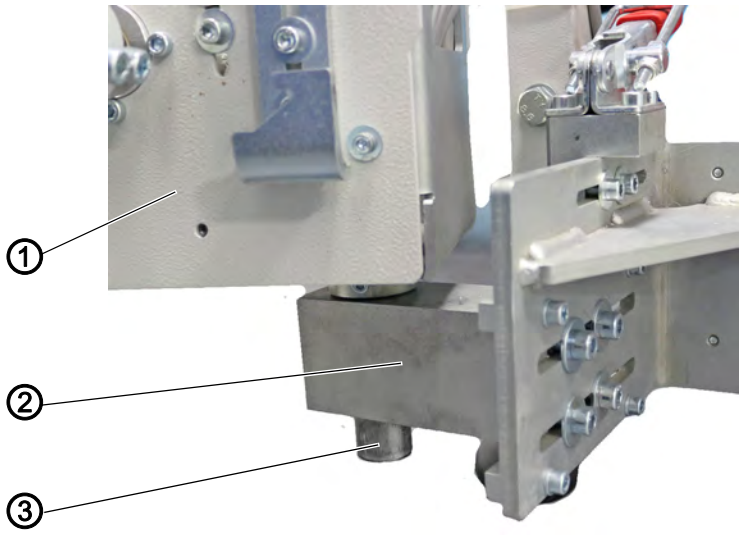
While adapted to the machine at the factory, the throw-over stacker still needs to be hooked into its holder after delivery.

Fig. 259: Assembling the throw-over stacker (1)



(1) - Throw-over stacker

Fig. 260: Assembling the throw-over stacker (2)

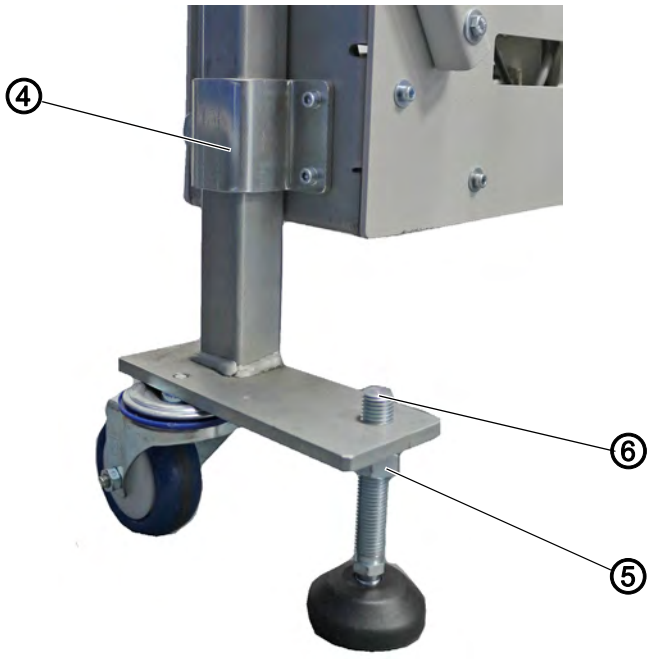


(1) - Throw-over stacker
(2) - Mounting plate
(3) - Tube

To assemble the throw-over stacker:

1. Insert the tube (3) of the throw-over stacker (1) into the hole of the mounting plate (2).

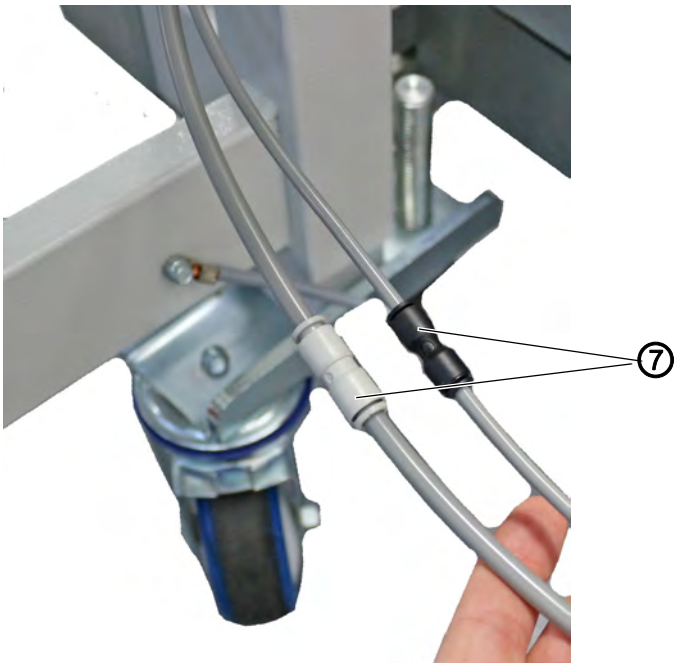
Fig. 261: Assembling the throw-over stacker (3)



(4) - Clamping piece
(5) - Nut
(6) - Threaded rod

2. Adjust the height of the throw-over stacker:
   minor adjustment - via nut (5) and threaded rod (6)
   major adjustment - via clamping piece (4)

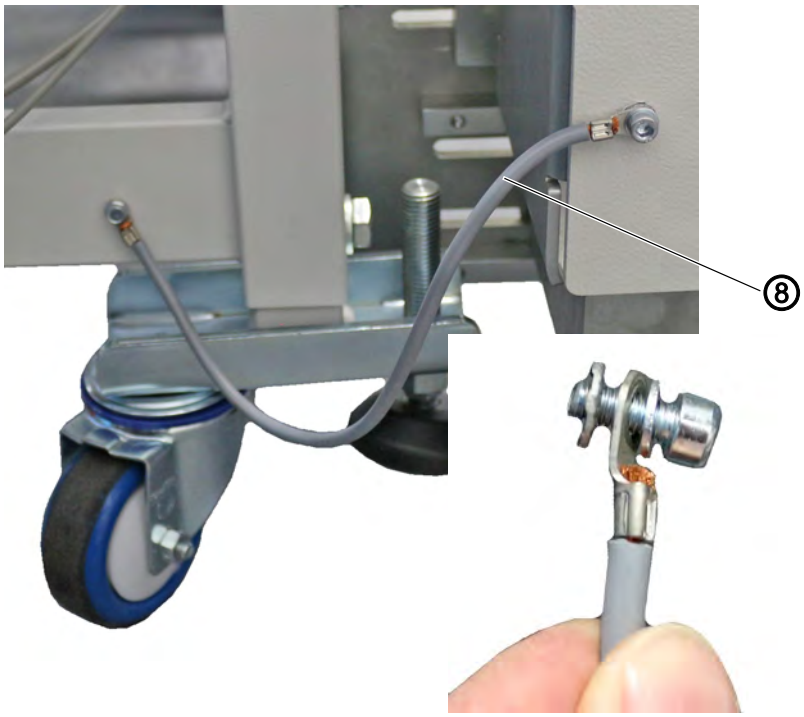
Fig. 262: Assembling the throw-over stacker (4)



(7) - Pneumatic hoses

3. Connect the pneumatic hoses (7) of throw-over stacker and machine.

Fig. 263: Assembling the throw-over stacker (4)



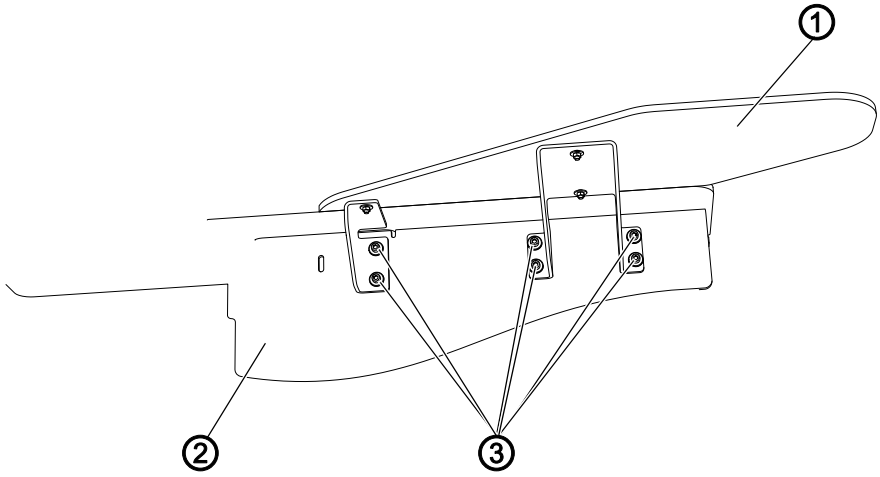
(8) -

4. Screw on the equipotential bonding (8) in the order of contact washer, equipotential bonding (8), washer, and screw (see photo).

7.7 Assembling the table extensions (additional equipment)

7.7.1 Table extension (small, slanted)

Fig. 264: Table extension (small, slanted)



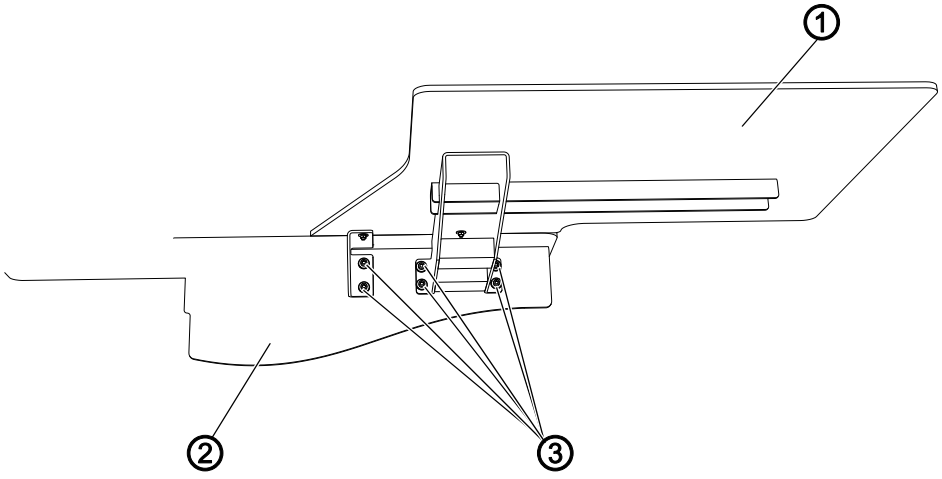
(1) - Table extension
(2) - Tabletop
(3) - Screws

To assemble the table extension (small, slanted):

1. Screw the table extension (1) to the left side of the tabletop (2) using the screws (3).

7.7.2 Table extension (large)

Fig. 265: Table extension (large)



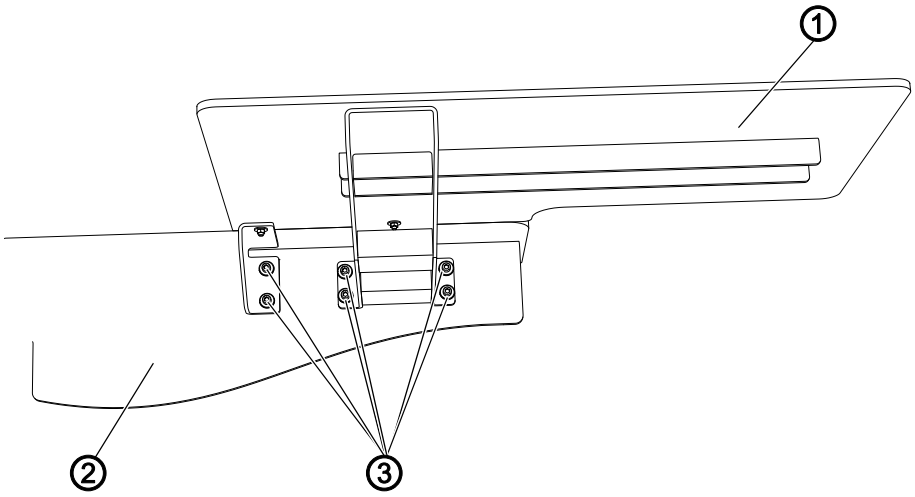
(1) - Table extension
(2) - Tabletop
(3) - Screws

To assemble the table extension (large):

1. Screw the table extension (1) to the left side of the tabletop (2) using the screws (3).

7.7.3 Table extension (small)

Fig. 266: Table extension (small)



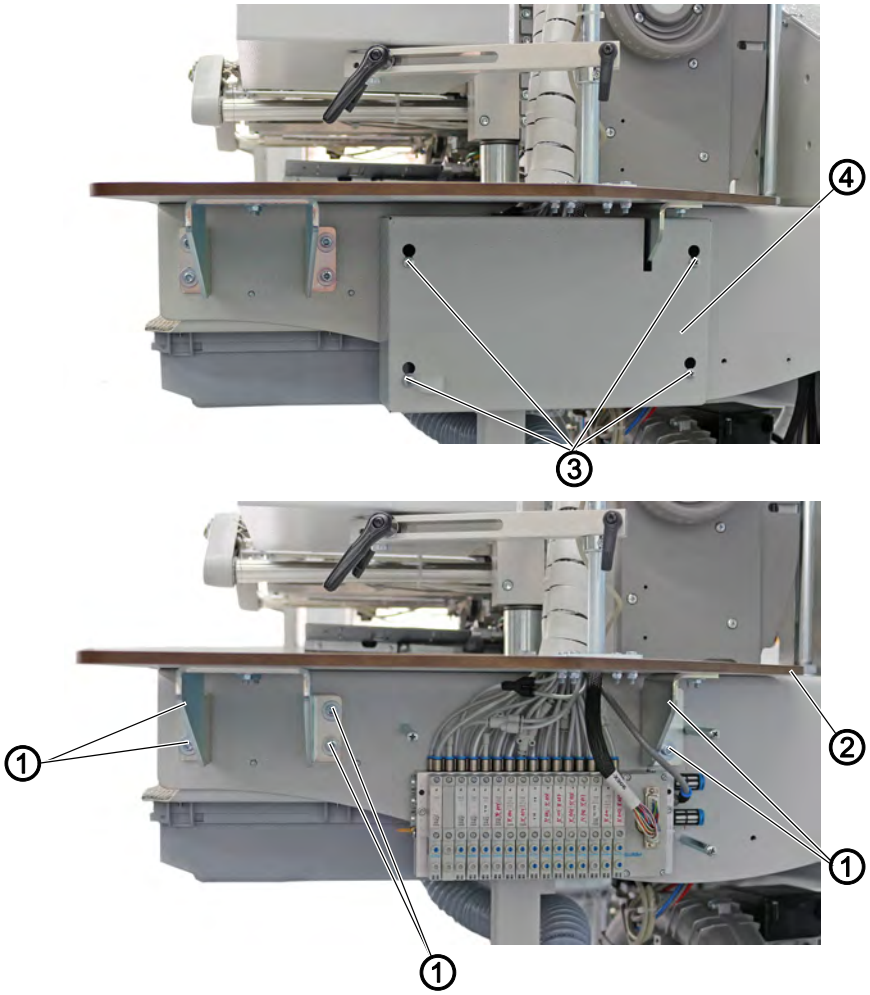
(1) - Table extension
(2) - Tabletop
(3) - Screws

To assemble the table extension (small):

1. Screw the table extension (1) to the left side of the tabletop (2) using the screws (3).

7.7.4 Table extension (right)

Fig. 267: Table extension (right) (1)

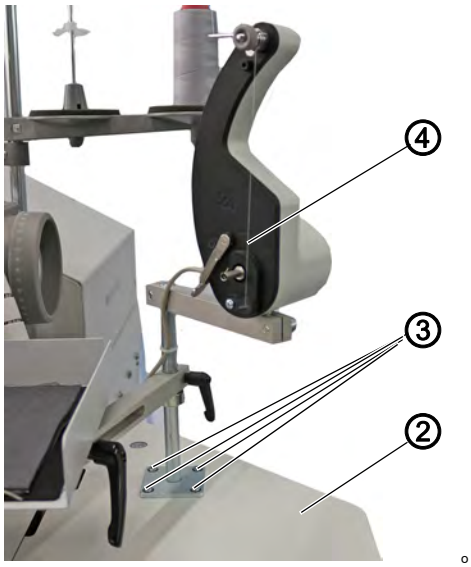


(1) - Screws
(2) - Table extension
(3) - Screws
(4) - Cover

To assemble the table extension (right):

1. Loosen the screws (3) of the valve block.
2. Remove cover (4).
3. Tighten the table extension (2) to the right side of the machine using the screws (1).
4. Fit the cover (4) and tighten it using the screws (3).

Fig. 268: Table extension (right) (2)



(2) - Table extension
(5) - Screws
(6) - Winder

5. Tighten the winder (4) to the table extension (2) using 4 screws (3).
6. Connect the winder (4) (📖 *p. 319*).

7.8 Electrical connection

DANGER



Risk of injury from electricity!

Unprotected contact with electricity can result in serious injuries or death.

Work on the electrical system must ONLY be carried out by qualified electricians or appropriately trained and authorized personnel.

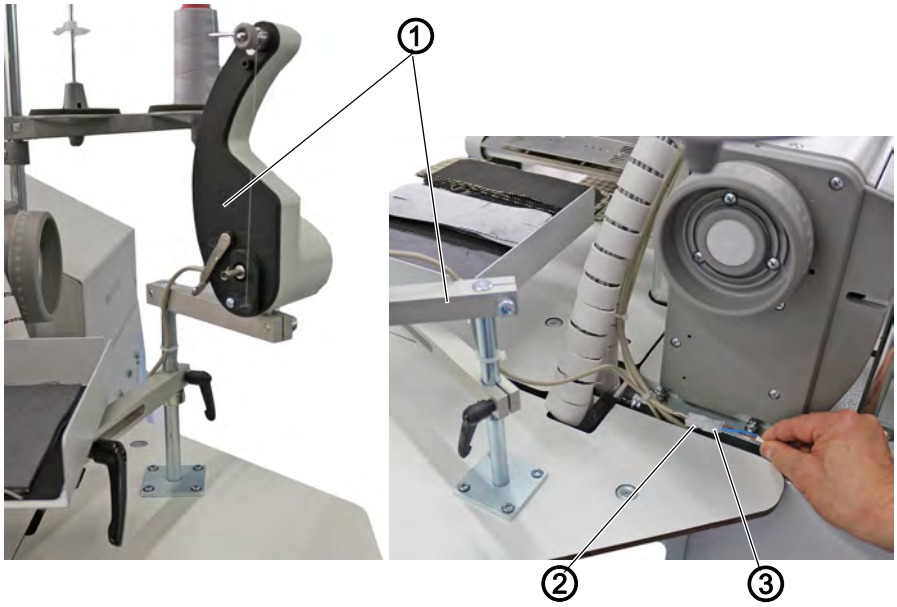
ALWAYS pull the power plug before working on the electrical equipment.

Important

The voltage on the type plate of the sewing motor must correspond to the mains voltage.

Connecting the electric winder

Fig. 269: Connecting the electric winder



(1) - Winder
(2) - Plug
(3) - Socket

To connect the electric winder:

1. Connect the plug (2) with the socket (3) of cable X702.
2. Guide the cable carefully behind the tabletop.

7.9 Pneumatic connection

The pneumatic system of the machine and of the additional equipment must be supplied with dry and oil-free compressed air. The supply pressure must lie between 8 and 10 bar.

NOTICE

Property damage from oily compressed air!

Oil particles in the compressed air can cause malfunctions of the machine and soil the sewing material.

Ensure that no oil particles enter the compressed air supply.

NOTICE

Property damage from incorrect adjustment!

Incorrect system pressure can result in damage to the machine.

Ensure that the machine is only used when the system pressure is set correctly.

7.9.1 Assembling the compressed air maintenance unit

To assemble the compressed air maintenance unit:



1. Connect the connection hose to the compressed air supply using a hose coupling R 1/4”.

7.9.2 Adjusting the operating pressure

NOTICE

Property damage from incorrect operating pressure!

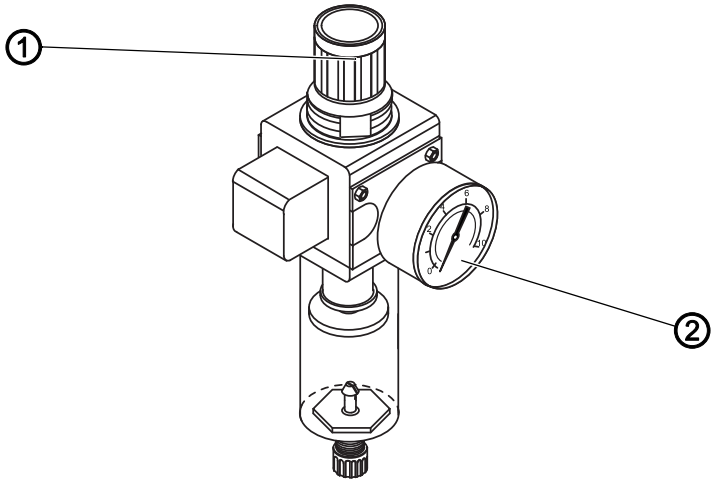
Incorrect operating pressure can result in damage to the machine.

Ensure that the machine is only used when the operating pressure is set correctly.

Proper setting

Refer to the **Technical Data** (📖 *p. 351*) chapter for the permissible operating pressure. The operating pressure cannot deviate by more than ± 0.5 bar.

Fig. 270: Adjusting the operating pressure



(1) - Pressure regulator *(2) - Pressure gage*

To adjust the operating pressure:

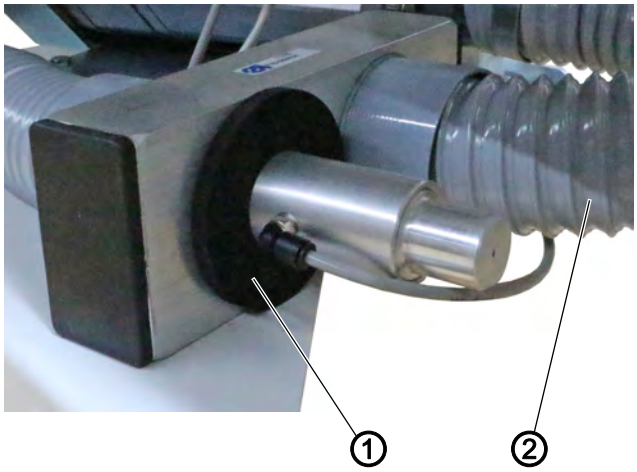
1. Pull the pressure regulator (1) up.
2. Turn the pressure regulator until the pressure gage (2) indicates the proper setting:
   - Increase pressure = turn clockwise
   - Reduce pressure = turn counterclockwise
3. Push the pressure regulator (1) down.

7.10 Connection to the in-house vacuum system

Information

If no in-house vacuum system is available, you will have to order the vacuum fan in addition.

Fig. 271: Connection to the in-house vacuum system



(1) - Sealing ring

(2) - Hose

To connect the in-house vacuum system:

1. Connect the hose (2) to the in-house vacuum system.
2. Fit the sealing ring (1).

7.11 Connecting the vacuum compressor in the machine

NOTICE

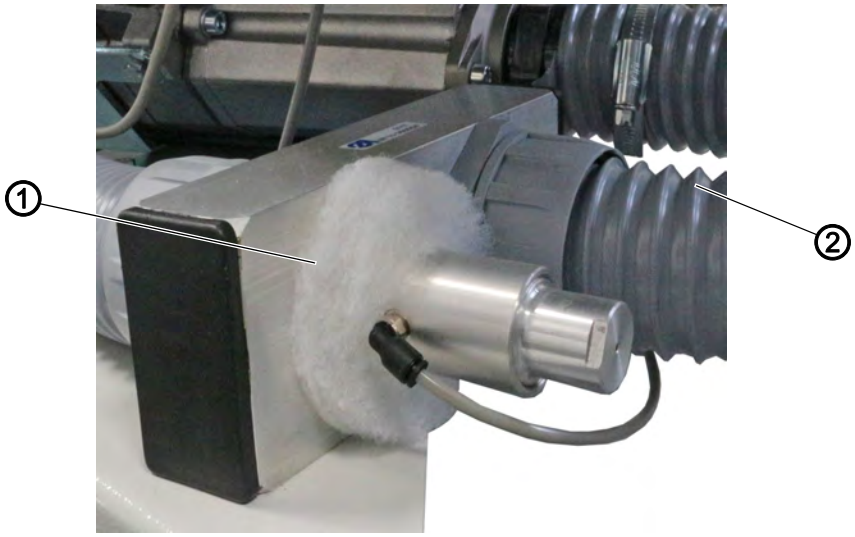
Property damage may occur!

The blower overheats.
The motor winding becomes damaged.

When mounting the vacuum device (side-channel blower), you MUST replace the sealing ring (black) with a filter ring (1) (white).

The filter ring (1) is included in the accessory pack.

Fig. 272: Connecting the vacuum compressor in the machine



(1) - Filter ring *(2) - Hose*

To connect the vacuum compressor in the machine:

1. Connect the hose (2) of the vacuum compressor.
2. Fit the filter ring (1).

7.12 Commissioning

You should perform a sewing test when finished setting up the sewing unit.

WARNING



Risk of injury from sharp parts and laser light!

Puncture or blindness.

Turn off the main switch before threading needle thread and hook thread.

Do NOT look directly into the light source of the laser beam.

NOTICE

Property damage may occur!

Moving the transport carriage without sewing material damages the transport clamp coating.

Before starting to sew, make sure there is sewing material under the transport clamps.



To perform a sewing test:

1. Supply the machine with compressed air.
2. Insert the power plug.
3. Thread the needle threads (📖 *p. 21*).
4. Insert the bobbins (📖 *p. 26*).
5. Switch on the machine.

↳ The control is initialized.

6. Press the left pedal backwards.

↳ The reference run starts.
The transport carriage moves to its rear end position.

The reference run is necessary in order to obtain a defined starting position of the transport carriage.

7. Select the seam program (📖 *p. 106*).
8. Insert the sewing material.
9. Press the left pedal forward.

↳ The different steps of the positioning procedure are triggered one after another.
The sewing procedure is started.

8 Decommissioning

WARNING



Risk of injury from a lack of care!

Serious injuries may occur.

ONLY clean the machine when it is switched off.
Allow ONLY trained personnel to disconnect the machine.

CAUTION



Risk of injury from contact with oil!

Oil can cause a rash if it comes into contact with skin.

Avoid skin contact with oil.
If oil has come into contact with your skin, wash the affected areas thoroughly.



To decommission the machine:

1. Switch off the machine.
2. Unplug the power plug.
3. If applicable, disconnect the machine from the compressed air supply.
4. Remove residual oil from the oil pan using a cloth.
5. Cover the control panel to protect it from soiling.
6. Cover the control to protect it from soiling.
7. Cover the entire machine if possible to protect it from contamination and damage.

9 Disposal

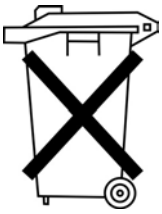
CAUTION



Risk of environmental damage from improper disposal!

Improper disposal of the machine can result in serious environmental damage.

ALWAYS comply with the national regulations regarding disposal.



The machine must not be disposed of in the normal household waste.

The machine must be disposed of in a suitable manner in accordance with all applicable national regulations.

When disposing of the machine, be aware that it consists of a range of different materials (steel, plastic, electronic components, etc.). Follow the national regulations when disposing these materials.

10 Troubleshooting

10.1 Customer Service

Contact for repairs and issues with the machine:

Dürkopp Adler GmbH

Potsdamer Str. 190
33719 Bielefeld, Germany

Tel. +49 (0) 180 5 383 756
Fax +49 (0) 521 925 2594
Email: service@duerkopp-adler.com
Internet: www.duerkopp-adler.com

10.2 Messages of the software

Please contact customer service if an error occurs that is not described here. Do not attempt to correct the error yourself.

Error code	Symbol	Meaning	Remedial action
Error code 0-1999: Error messages sewing motor control			
0000		Unknown error	Switch off and on the machine again
1000		• Encoder cable not connected • Encoder cable defective • Encoder defective	• Check encoder cable • Replace encoder cable
1001		Sewing motor plug (AMP) not connected	• Connect sewing motor cable • Check sewing motor cable • Test sewing motor phases (R= 2.8 Ohm, high impedance to PE) • Replace sewing motor cable • Replace encoder • Replace sewing motor • Replace control

Error code	Symbol	Meaning	Remedial action
1002		Sewing motor insulation fault	• Check motor phase and PE for low-impedance connection • Replace sewing motor encoder • Replace sewing motor
1004		Sewing motor error: Incorrect direction of rotation	• Replace encoder • Check plug assignment and change, if necessary • Check wiring in machine distributor and change it, if necessary • Test motor phases and check for correct value
1005		• Sewing motor blocked • Encoder cable not connected • Encoder cable defective • Encoder defective	• Remove blockage • Check encoder cable and replace, if necessary • Replace sewing motor
1006		• Sewing motor error: Maximum speed exceeded • Sewing motor cable defective • Sewing motor defective	• Switch off and on the machine again • Check class • Replace encoder • Replace sewing motor
1007		Error in the reference run	• Replace encoder • Check for stiff movement
1008		Fault in sewing motor encoder	Replace encoder
1010		• Cable to sewing motor reference switch defective • Reference switch defective	• Replace cable • Replace reference switch (part number 9815 935006)
1011		Sewing motor synchronization error (encoder Z pulse missing)	Switch off the control, use handwheel to turn, and switch on the control again. If error is not corrected, check encoder
1012		Sewing motor synchronization error	Replace synchronizer
1051		Sewing motor timeout • Cable to sewing motor reference switch defective • Machine head not moving freely • excessively high toothed belt tension	• Replace cable • Replace reference switch • Eliminate seizing • Check toothed belt tension
1052		Sewing motor excess current, internal current increase to over 25 A	• Replace sewing motor cable • Replace encoder • Replace sewing motor • Replace control
1053		Mains voltage too high	Check mains voltage

Error code	Symbol	Meaning	Remedial action
1054		Internal short circuit	Replace control
1055		Sewing motor overload • Sewing motor blocked/not moving freely • Sewing motor defective • Control defective	• Eliminate seizing/stiff movement • Replace sewing motor • Replace control
1056		Sewing motor overtemperature • Sewing motor not moving freely • Sewing motor defective • Control defective	• Eliminate seizing
1058		Sewing motor speed • Sewing motor defective	• Replace sewing motor
1060		• Sewing motor excess current/ excess voltage • Encoder defective	• Replace sewing motor cable • Replace encoder • Replace sewing motor • Replace control
1061		• Encoder defective • Sewing motor excess current/ excess voltage	• Replace sewing motor cable • Replace encoder • Replace sewing motor • Replace control
1062		• Sewing motor IDMA auto increment disturbance	• Switch off and on the machine again
1120		Software error: Parameter not initialized	• Perform software update 📖 *p. 285* • Check class
1203		Sewing motor: Position not reached	• Check mechanical changes to the machine (e.g. thread cutting setting, belt tension) • Check position of thread lever at top dead center
1302		Sewing motor current feed fault • Sewing motor blocked • Encoder cable not connected or defective • Encoder defective	• Remove blockage • Check encoder cable and replace, if necessary • Replace sewing motor
1330		No response from sewing motor	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Replace control
1342-1344		Internal sewing motor error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Replace control

Error code	Symbol	Meaning	Remedial action
Error code 2000-2999: Error messages motors			
2101		Stepper motor transport clamp timeout reference • Faulty cable to the reference switch • Reference switch defective	• Replace cable • Replace reference switch
2102		Stepper motor transport clamp overload • Blocked/sluggish, defective • Control defective	• Fix blockage • Check encoder cable and replace, if necessary • Replace stepper motor
2103		Stepper motor transport • Stepper motor transport clamp (transport clamp) has step loss	Check seizing of the transport clamp
2121		Transport clamp stepper motor: • Encoder plug (Sub-D, 9-pin) not connected or defective • Encoder defective	• Check the encoder cable connection and replace encoder cable, if necessary
2122		Pulse wheel search time out	• Check connection cables • Check stepper motor for stiff movement
2130		Transport clamp stepper motor not responding: Stepper motor card defective	• Perform software update 📖 *p. 285* • Replace stepper motor card • Replace control
2152		Stepper motor transport clamp excess current	• Replace transport clamp stepper motor • Replace control
2153		Stepper motor transport clamp excess voltage	Check mains voltage
2155		Stepper motor transport clamp overload • Blocked/sluggish • Defective • Control defective	• Eliminate seizing/stiff movement • Replace stepper motor • Replace control
2156		Stepper motor transport clamp overheat • Stepper motor transport clamp seized up • Faulty stepper motor transport clamp • Control defective	• Eliminate seizing • Replace transport clamp stepper motor • Replace control
2201		Stepper motor middle knife time-out reference • Faulty cable to the reference switch • Reference switch defective	• Replace cable • Replace reference switch

Error code	Symbol	Meaning	Remedial action
2202		Stepper motor middle knife overload • Blocked/sluggish • Defective • Control defective	• Eliminate seizing/stiff movement • Check encoder cable and replace, if necessary • Replace stepper motor
2221		Stepper motor middle knife • Encoder plug (Sub-D, 9-pin) not connected or defective • n-Encoder defective	• Check plug of the encoder cable and if necessary replace it.
2222		Stepper motor middle knife pulse-wheel search time out	• Check connection cables motor / encoder \n-Check stepper motor for stiff movement
2230		Stepper motor middle knife drive not responding: Stepper motor card defective	• Perform software update 🕮 *p. 285* • Replace stepper motor card • Replace control
2252		Stepper motor middle knife excess current	• Replace stepper motor middle knife • Replace control
2253		Stepper motor middle knife excess voltage • Mains voltage too high	• Check mains voltage
2255		Stepper motor middle knife overload • Blocked/sluggish • Defective • Control defective	• Eliminate seizing/stiff movement • Replace stepper motor • Replace control
2256		• Stepper motor middle knife overtemperature • Stepper motor corner knife support seized up/defective • Control defective	• Eliminate seizing • Replace stepper motor corner knife • Replace control
2301		Stepper motor corner knife timeout reference • Faulty cable to the reference switch • Reference switch defective	• Replace cable • Replace reference switch
2302		Stepper motor corner knife overload • Blocked/sluggish • Defective • Control defective	• Eliminate seizing/stiff movement • Check encoder cable and replace, if necessary • Replace stepper motor

Error code	Symbol	Meaning	Remedial action
2330		Stepper motor corner knife not responding: Stepper motor card defective	• Perform software update 🕮 *p. 285* • Replace stepper motor card • Replace control
2353		Stepper motor tape feeder excess voltage - mains voltage too high	Check mains voltage
2355		Stroke position stepper motor overload • Blocked/sluggish • Defective • Control defective	• Eliminate seizing/stiff movement • Replace stepper motor • Replace control
2356		Stepper motor tape feeder over-temperature • sluggish • defective • Control defective	• Eliminate seizing • Replace stepper motor tape feeder • Replace control
2401		Reference time out stepper motor needle transport	• Fix blockage/sluggishness • Replace stepper motor • Check reference switch • Check cable
2430		Stepper motor needle transport not responding: Stepper motor card defective	• Perform software update 🕮 *p. 285* • Replace stepper motor card • Replace control
2501		Reference time out stepper motor transport clamp adjustment left	• Eliminate blockage or seizing • Replace stepper motor, check reference switch
2505		Error stepper motor transport clamp adjustment left	• Eliminate blockage or seizing
2506		Error stepper motor transport clamp adjustment left at mechanical stop	• Adjust stop • Change correction values
2521		Stepper motor clamp adjustment left: • Encoder plug (Sub-D, 9-pin) not connected or defective • Encoder defective	• Check plug of the encoder cable and if necessary replace it.
2522		Stepper motor transport clamp left pulse-wheel search time out	• Check connection cables motor / encoder • Check stepper motor for stiff movement

Error code	Symbol	Meaning	Remedial action
2530		Stepper motor transport clamp adjustment left not responding: Stepper motor card defective	• Perform software update 📖 *p. 285* • Replace stepper motor card • Replace control
2601		Reference time out stepper motor transport clamp adjustment right	• Eliminate blockage or seizing • Replace stepper motor • Check reference switch
2605		Error stepper motor transport clamp adjustment right	• Eliminate blockage or seizing
2606		Error stepper motor transport clamp adjustment right at mechanical stop	• Adjust stop • Change correction values
2621		Stepper motor transport clamp adjustment right: • Encoder plug (Sub-D, 9-pin) not connected or defective • Encoder defective	• Check plug of the encoder cable and if necessary replace it.
2622		Stepper motor transport clamp right pulse-wheel search time out	• Check connection cables motor / encoder • Check stepper motor for stiff movement
2630		Stepper motor quick clamp adjustment right not responding: Stepper motor card defective	• Perform software update 📖 *p. 285* • Replace stepper motor card • Replace control
2901		Reference time out	
Error code 3000-3999: Error messages machine			
3010		Control: 100V voltage error	• Check connections • Replace control
3011		Control: 100V voltage error	• Check connections • Replace control
3012		Control: Voltage error 100V (I2T)	• Switch off and on the machine again • Check connections • Replace control
3020		Short circuit at input or output 24V	• Check connections • Replace control
3021		Short circuit at input or output 24V	• Check connections • Replace control

Error code	Symbol	Meaning	Remedial action
3022		Control: Voltage error 24V (I2T)	• Switch off and on the machine again • Check connections • Replace control
3030		Sewing motor: Phase error	• Test sewing motor phases (R=2.8 OHM, high impedance to PE) • Replace encoder • Replace sewing motor • Replace control
3040		Line voltage drop	Check mains voltage
3100		Control voltage: Temporary line voltage drop	Check mains voltage
3101		Power voltage: Temporary line voltage drop	Check mains voltage
3102		Voltage sewing motor: Temporary line voltage drop	Check mains voltage
3103		Voltage stepper motors: Temporary line voltage drop	Check mains voltage
3104		• Pedal not in rest position • Setpoint device defective	• Do not press the pedal when starting up the machine • Replace setpoint device
3107		Machine temperature • Ventilation openings closed • Ventilation grille dirty	• Check ventilation openings • Clean ventilation grille
3108		Speed limited due to insufficient mains voltage	Check mains voltage
3109		*Safety stop* active	*Switch safety stop* off
3121		• Compressed air missing • Compressed air insufficient	• Turn on compressed air • Stabilize compressed air
3123		Oil level too low	Top off the oil 🕮 *p. 296*
3210		• Thread broken	Insert thread 🕮 *p. 21*
3215		• Empty bobbin	Change bobbin 🕮 *p. 26*

Error code	Symbol	Meaning	Remedial action
3220		• Empty bobbin	Change bobbin 📖 *p. 26*
3500		• Error Command Interpreter • Motor synchronization Internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Feedback to Dürkopp Adler Service
3501		The X and Y position are out of min/max range	Change the contour program
3502		The X and Y position are within forbidden area	Change the contour program
3503-3507, 3520-3530		• Error Command Interpreter • Motor synchronization Internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Feedback to Dürkopp Adler Service
3540, 3545		• Error Command Interpreter • Motor synchronization Internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Feedback to Dürkopp Adler Service
3721, 3722		• Error Command Interpreter • Motor synchronization Internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Feedback to Dürkopp Adler Service
Error code 4000-4999: Error messages USB			
4200		Machine configuration adopted from the USB file	Check machine configuration
4301		No USB key at the control unit	Insert USB key
4304		Wrong USB key	Replace USB key
4681	 Icon BFT not available yet	No communication with DAC	Check cable connection, Check OP7000 cable at X170b DAC, Check DAC flashing code

Error code	Symbol	Meaning	Remedial action
4682	 Icon BFT not available yet	No active seam program from DAC	Check communication, switch seam program, delete seam program, clear sequence
4683	 Icon BFT not available yet	No valid sequence number	Check communication, switch sequence, check software version OP7000 and DAC
Error code 5000-5999: Error messages machine configuration			
5201		Error stepper motor corner knife, slanted seam end	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5202		Error stepper motor corner knife, slanted seam beginning	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5203		Error stepper motor corner knife, angle seam begin right	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5204		Error stepper motor corner knife, angle seam begin left	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5205		Error stepper motor corner knife, angle seam end right	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5206		Error stepper motor corner knife, angle seam end left	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5209		Error horizontal stepper motor laser marking lamp	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5210		Error vertical stepper motor laser marking lamp	• Check cable to reference switch • Check reference switch • Check motor for stiff movement
5211		Reference time out stepper motor piping cutter seam begin.	• Fix blockage/sluggishness • Replace stepper motor • Check reference switch
5212		Reference time out stepper motor piping cutter seam end	• Fix blockage/sluggishness • Replace stepper motor • Check reference switch
5213		Reference time out stepper motor guiding plate adjustment left	• Fix blockage/sluggishness • Replace stepper motor • Check reference switch

Error code	Symbol	Meaning	Remedial action
5214		Reference time out stepper motor guiding plate adjustment right	• Fix blockage/sluggishness • Replace stepper motor • Check reference switch
5215		Reference time out stepper motor folder height stop	• Fix blockage/sluggishness • Replace stepper motor • Check reference switch
5216		Reference time out stepper motor turning stop	• Fix blockage/sluggishness • Replace stepper motor • Check reference switch
Error code 6000-6999: Error messages control			
6000		Internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
6301		Data loaded from the machine ID	Check machine configuration
6351		Control defective (I2C)	Replace control
6353		Internal EEprom communication error	Switch off the control, wait until the LED has gone out, and then switch on the machine again
6354		Machine ID communication error	Switch off the control, check the connection to the machine ID
6360		Data of machine ID not valid for this machine	Connect correct machine ID
6361		No machine ID connected	Connect machine ID
6400		Internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
6401		Default data loaded	Check machine configuration
6408		No changes of machine configuration.	Use USB data from this machine

Error code	Symbol	Meaning	Remedial action
6551-6554		Error in machine head position • AD converter • internal process error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
6651-6653		Error in machine head position • AD converter • internal process error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
6751-6761		Error in machine head position • AD converter • internal process error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
6952		Internal error stepper motor driver	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
Error code 7000-7999: Error messages communication			
7200		Failure in CAN-Module corner knife (AC001)	Check the CAN-Module corner knife
7201		Failure in CAN-Module corner knife (AC001), power failure	• Check cable • Check jumpers • Check voltage supply
7202		Failure in CAN-Module corner knife support unit (AC001). Excess temperature.	• Check cable • Check jumpers • Check voltage supply • Check output stage • Check motors
7203, 7204		Voltage error in I/O CAN-Module	• Check cable • Check jumpers • Check voltage supply • CAN-Module defective
7205		Voltage error in hook thread monitor CAN-Module	• Check cable • Check jumpers • Check voltage supply • CAN-Module defective

Error code	Symbol	Meaning	Remedial action
7206		Voltage error in corner knife support slanted CAN-Module	• Check cable • Check jumpers • Check voltage supply • CAN-Module defective
7207		Voltage error in corner knife angle seam begin CAN-Module	• Check cable • Check jumpers • Check voltage supply • CAN-Module defective
7208		Voltage error in corner knife angle seam end CAN-Module	• Check cable • Check jumpers • Check voltage supply • CAN-Module defective
7209		Voltage error in roll-off/tape feeder CAN-Module	• Check cable • Check jumpers • Check voltage supply • CAN-Module defective
7210		Voltage error in laser CAN-Module	• Check cable • Check jumpers • Check voltage supply • CAN-Module defective
7211		Failure in CAN - Module transport unit (AC101), power failure	• Check cable • Check jumpers • Check voltage supply
7215		Failure in CAN - Module transport unit (AC101), outputs overload/ short circuit	Check output cable and output plug
7219		Failure in CAN - Module transport unit (AC101), wrong module recognized at address	Check jumpers/DIP switch
7260		General error CAN-Modules	• Check set class • Check working method • Check cable
7302		Failure in I/O CAN-Module	• Check cable, jumper setting, power supply • Change CAN-Module
7303		Failure in I/O CAN-Module	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7305		Failure in bobbin thread monitor CAN-Module	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module

Error code	Symbol	Meaning	Remedial action
7306		Failure in corner knife slanted CAN-Module	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7307		Failure in corner knife angle seam begin CAN-Module	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7308		Failure in corner knife angle seam end CAN-Module	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7309		Failure in roll-off/tape feeder CAN-Module	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7310		Failure in laser CAN-Module	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7311		Internal failure piping cutter step-per motor	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7312		Internal failure guiding plates	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7313		Internal failure stop folder height/ turner	• Check cable • Check jumpers • Check voltage supply • Change CAN-Module
7402		Failure in I/O CAN-Module: wrong module at address.	Check jumpers/DIP switch
7403, 7404		Failure in I/O CAN-Module: wrong module at address	Check jumpers/DIP switch
7405		Failure in bobbin thread monitor CAN-Module: wrong module at address	Check jumpers/DIP switch
7406		Failure in corner knife slanted CAN-Module: wrong module at address	Check jumpers/DIP switch
7407		Failure in corner knife angle seam begin CAN-Module: wrong module at address	Check jumpers/DIP switch

Error code	Symbol	Meaning	Remedial action
7408		Failure in corner knife angle seam end CAN-Module: wrong module at address	Check jumpers/DIP switch
7409		Failure in roll-off/tape feeder CAN-Module: wrong module at address	Check jumpers/DIP switch
7410		Failure in laser CAN-Module: wrong module at address	Check jumpers/DIP switch
7411		Failure in stepper motor piping cutter CAN-Module.	Check jumpers/DIP switch
7412		Failure in guiding plates stepper motor CAN-Module.	Check jumpers/DIP switch
7413		Failure in stop folder height/turner stepper motor CAN-Module.	Check jumpers/DIP switch
7500		Failure in CAN - Module bobbin thread monitor.	• Check cable • Check jumpers • Check voltage supply
7502		Failure I/O Module not active (valves method B/D/F)	• Check cable, jumper setting, power supply
7503, 7504		Failure I/O Module not active	• Check cable • Check jumpers • Check voltage supply
7505		Failure in CAN - Module bobbin thread monitor	• Check cable • Check jumpers • Check voltage supply
7506		Stepper motor card error at corner knife • Slanted seam beginning/seam end not present	• Check cable • Check jumpers • Check voltage supply
7507		Stepper motor card error at corner knife • Angle seam beginning not present	• Check cable • Check jumpers • Check voltage supply
7508		Stepper motor card error at corner knife • Angle seam end not present	• Check cable • Check jumpers • Check voltage supply
7509		Stepper motor card error • Outfeed roller/tape feeder not present	• Check cable • Check jumpers • Check voltage supply
7510		Stepper motor card error • Laser lengthwise/crosswise not present	• Check cable • Check jumpers • Check voltage supply

Error code	Symbol	Meaning	Remedial action
7511		Failure piping cutter stepper motor Module not active	• Check cable, jumper setting, power supply
7512		Failure guiding plates stepper motor Module not active	• Check cable, jumper setting, power supply
7513		Failure stop folder height/turner stepper motor Module not active	• Check cable, jumper setting, power supply
7551-7555		Control panel interface communication: internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
7556, 7557		Control panel interface communication • Cable disturbance • Cable to control panel interface defective	• Eliminate source of disturbance • Replace cable
7558, 7559		Control panel interface communication: internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
7801		Control panel interface communication • Cable disturbance • Cable to control panel interface defective	• Eliminate source of disturbance • Replace cable
Error code 8000-8999: Error messages displays			
8151	Information	ADSP Boot/Xilinx Boot/ Boot error: internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service
8152-8154	Information	IDMA error\n- Internal error	• Switch off and on the machine again • Perform software update 📖 *p. 285* • Inform Dürkopp Adler Customer Service

Error code	Symbol	Meaning	Remedial action
8156-8159	Information	ADSP Boot/Xilinx Boot/ Boot error: internal error	• Switch off and on the machine again • Perform software update 📖 p. 285 • Inform Dürkopp Adler Customer Service
8252-8254, 8256-8258	Information	ADSP Boot/Xilinx Boot/ Boot error: Disturbance	Switch off and on the machine again
8351	Information	Error in test pins, signal processing, event processing, memory wrapper, list functions: internal error	• Switch off and on the machine again • Perform software update 📖 p. 285 • Inform Dürkopp Adler Customer Service
8400	Information	No readable update-program for the control panel available. The control panel program should be updated as soon as possible. Continue with OK.	
8401	Information	Check panel cable and plug control! • Possible communication error • No valid program for the machine available. Should a new program be transmitted?	
8402	Information	Machine has a program for another class. Should a new program be transmitted?	
8403	Information	Machine has an outdated program. Should a new program be transmitted?	
8404, 8405	Information	Update failed! The control panel program may have to be reloaded. Should the program be retransmitted nevertheless?	
8406	Information	Update failed! Please check the connection to the machine. Should a new update be tried nevertheless?	
8407	Information	Update failed! Should the program be retransmitted?	
8408	Information	Waiting for RESET by machine.	
8409	Information	Switch off and on the machine again.	
8410	Information	Update failed! Should the program be retransmitted?	
8411	Information	Machine is checking new program. This process can take up to 30 sec.	
8412, 8413	Information	Update failed! Should the program be retransmitted?	
8414	Information	Update completed!	
8415	Information	Continue with old software. (Use may result in serious problems!)	
8801-8806, 8890, 8891	Information	Error in test pins, signal processing, event processing, memory wrapper, list functions: internal error	• Switch off and on the machine again • Perform software update 📖 p. 285 • Inform Dürkopp Adler Customer Service

Error code	Symbol	Meaning	Remedial action
Error code 9000-9999: Error messages general machine-specific errors			
9000		Reminder to execute the reference run after switching on	Press the left pedal backwards
9001		Corner knife station swiveled out during sewing	Check/set fastening of corner knife station
9002		Folding station swiveled out during sewing	Check/set fastening of folding station
9003		Wrong needle position	Manually turn the handwheel to the upper position of the thread lever (top dead center)
9005		Waiting for RESET	Push the RESET-Switch
9006		RESET-Switch active	Release the RESET switch
9007		Test the loading process	Resume the process after pushing the start pedal
9013		Tape missing	Insert tape
9014		Position of transport clamp doesn't match the installed folder	Correct position of transport clamp in the program parameters 🕮 *p. 163*
9015		Wrong setting of flap scanning in the seam program	Correct seam program
9016		Seam program not active	• Activate seam program • Select a different seam program
9100		Piece counter has reached the preset value	Reset counter value
9500		Test loading process step by step	Resume the process after pushing the start pedal
9501		Test step by step	Use pedal for progress
9601		Pedal was pressed backwards during sewing	Press pedal again
9602		Empty bobbin	Change bobbin 🕮 *p. 26*

Error code	Symbol	Meaning	Remedial action
9603		Thread breaking	Insert thread 📖 *p. 21*
9604		Light barrier for sewing material removal not active	Adjust light barrier for sewing material removal
9605		Transport clamp moves	
9700		Folder not up	Correct folder setting
9701		Folder not down	Correct folder setting
9702		Folder not vertical	Correct folder setting
9703		Folder not slanted	Correct folder setting
9704		Folder not on the piping table	Correct folder setting
9705		Front corner knife not down	Correct the corner knife setting
9706		Rear corner knife not down	Correct the corner knife setting
9707		Scissors not down	Correct the scissors setting
9708		Scissors not up	Correct the scissors setting
9709		Downholder not up	Correct the downholder setting
9710		Switch S05 for the loading station does not react	Adjust the switch S05 for the loading station
9720		Error during flap scanning with light barrier	• Check reflecting foil • Check alignment of the light barriers
9721		Flap has been positioned in front of the front positioning point	Insert the flap correctly
9722		Flap projects beyond the maximum sewing area (behind the rear positioning point)	• Check flap size • Insert the flap correctly

Error code	Symbol	Meaning	Remedial action
9723		Fluff at the flap beginning	• Insert flaps with smooth edges • Check reflecting foil
9725		• Flap angle too great • Flap too small	• Check flap angle • Check alignment of the light barriers • Adjust sewing parameters (seam securement possibly too long for small flaps)
9726		• Flap too large • Reflecting foil dirty/damaged	• Check flap size • Check reflecting foil
9727		Stop section insufficient for the flap angle	Reduce the insertion speed 🕮 *p. 163*
9728		Flap too small	Check the flap size; insert a larger flap
9730		Corner knife cut impossible	• Increase seam length • Change positioning point
9800		Middle knife not ready for use	Check cable
9810		Outfeed roller not ready for use	Check cable
9900		Defective machine parameters (Checksum error)	• Initialize machine parameters again
9901		Defective pocket sequence (checksum error)	• Initialize pocket sequences again
9902		Defective pocket programs (Checksum error)	• Initialize pocket programs again
9911			• Switch Off
9920		Serial number active	
9921		Serial number not accepted	Re-enter serial number
9999		Machine configuration has been changed	Switch off and on the machine again

11 Technical data

11.1 Data and characteristic values

Technical data	Unit	755 B	756 B	756 F
Type of stitches		301 Double lockstitch		
Hook type		Vertical hook		
Number of needles		2		
Needle system		134-35		
Needle strength	[Nm]	80 - 110		
Thread strength	[Nm]	75 - 120		
Stitch length	[mm]	0.5 - 4.5		
Speed maximum	[min^{-1}]	3200	3000	
Speed on delivery	[min^{-1}]	2750		
Mains voltage	[V]	1x 190 - 240		
Mains frequency	[Hz]	50/60		
Operating pressure	[bar]	6		
Length	[mm]	1500		
Width	[mm]	750		
Height	[mm]	1250		
Weight	[kg]	240 - 260		

11.2 Requirements for fault-free operation

Compressed air quality must conform to ISO 8573-1: 2010 [7:4:4].

12 Appendix

Fig. 273: Wiring diagram

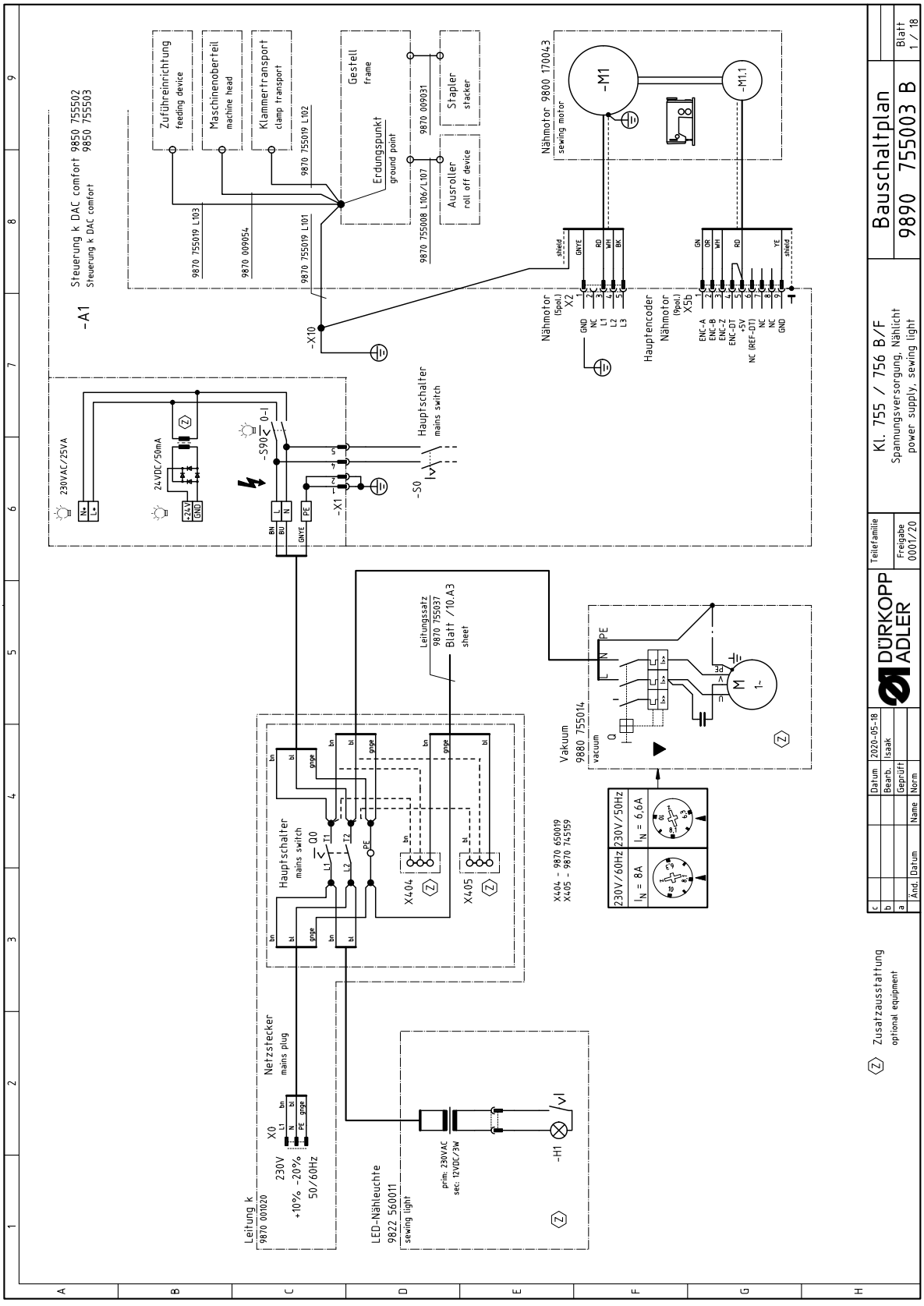


Fig. 274: Wiring diagram

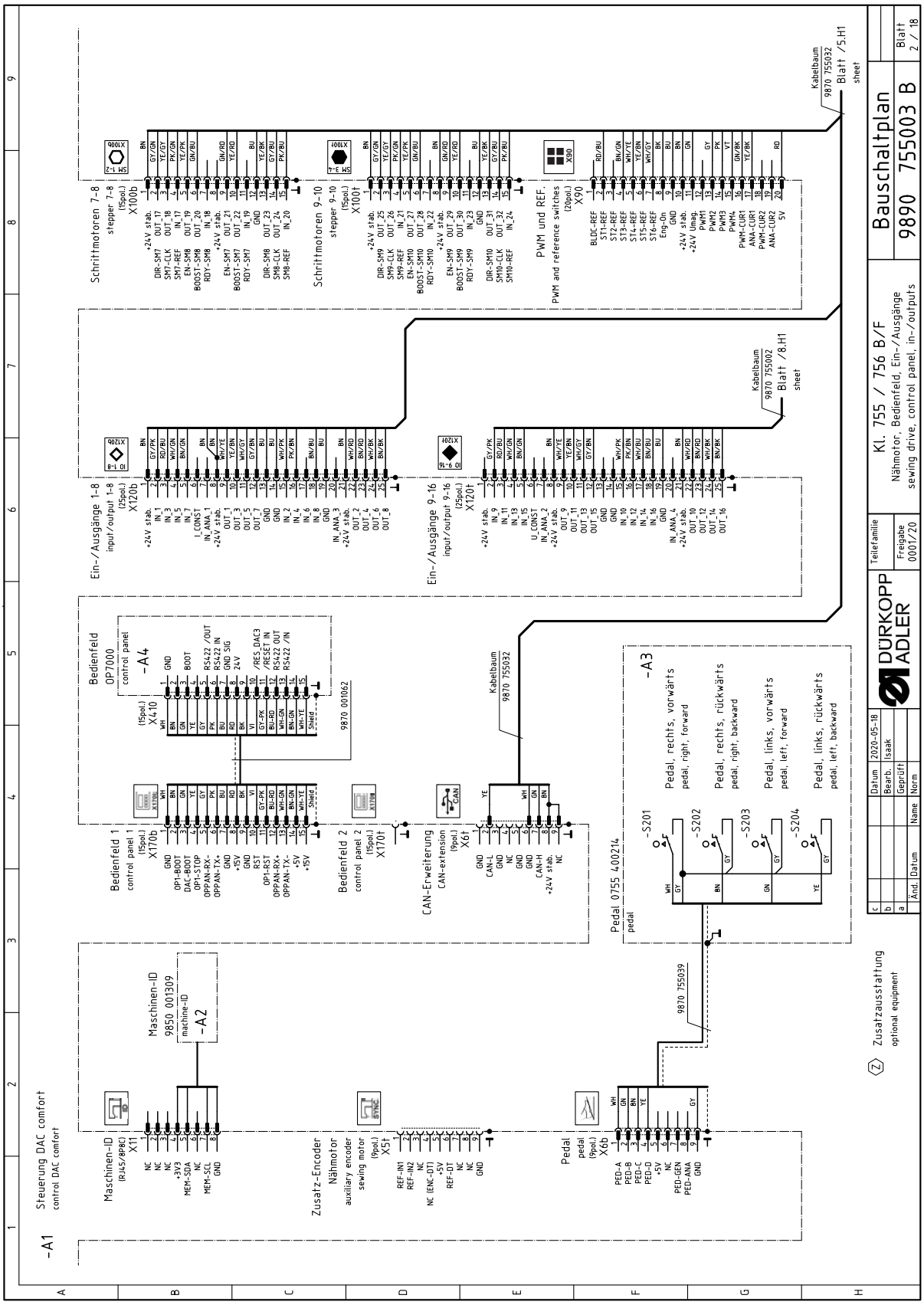


Fig. 275: Wiring diagram

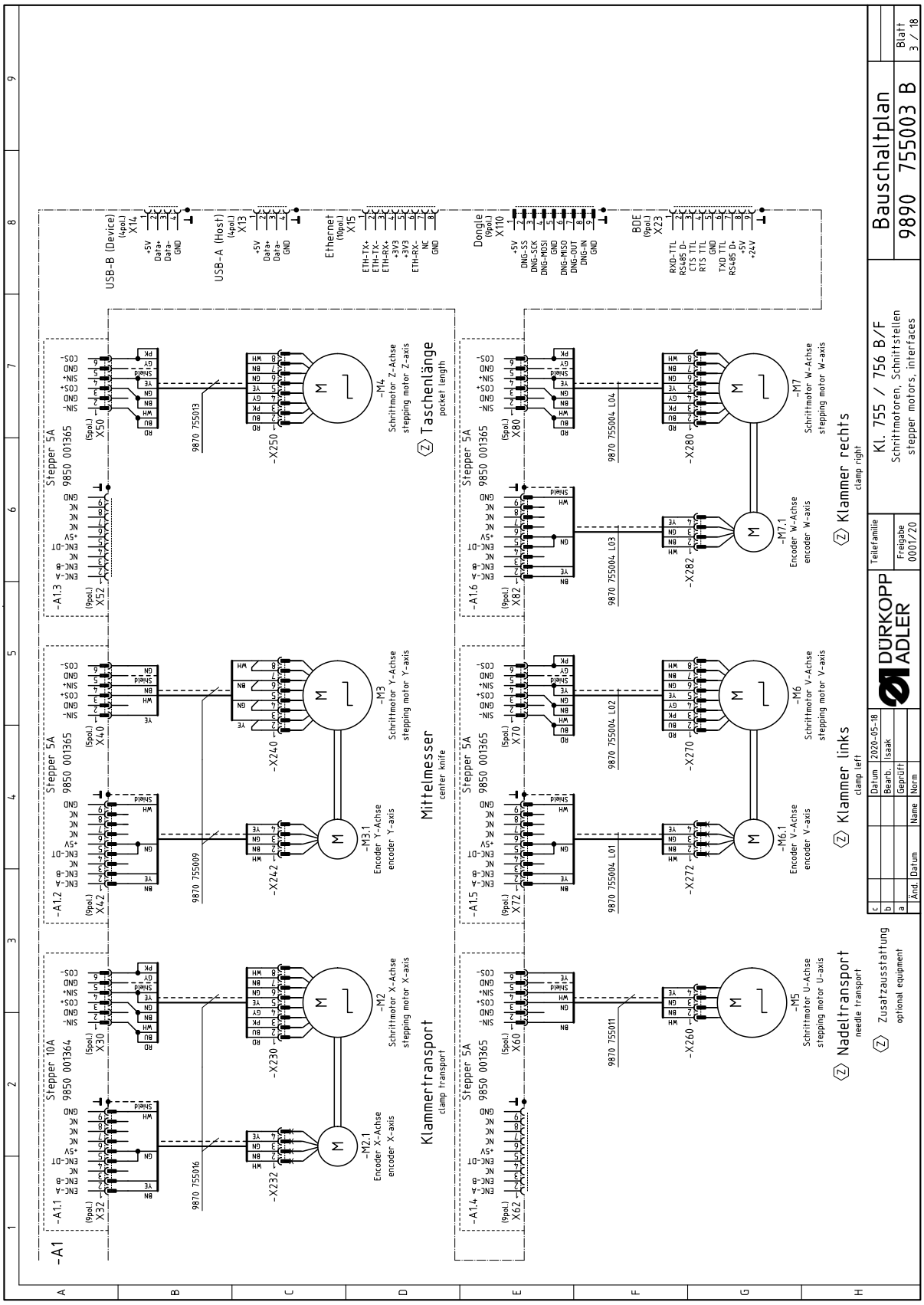


Fig. 276: Wiring diagram

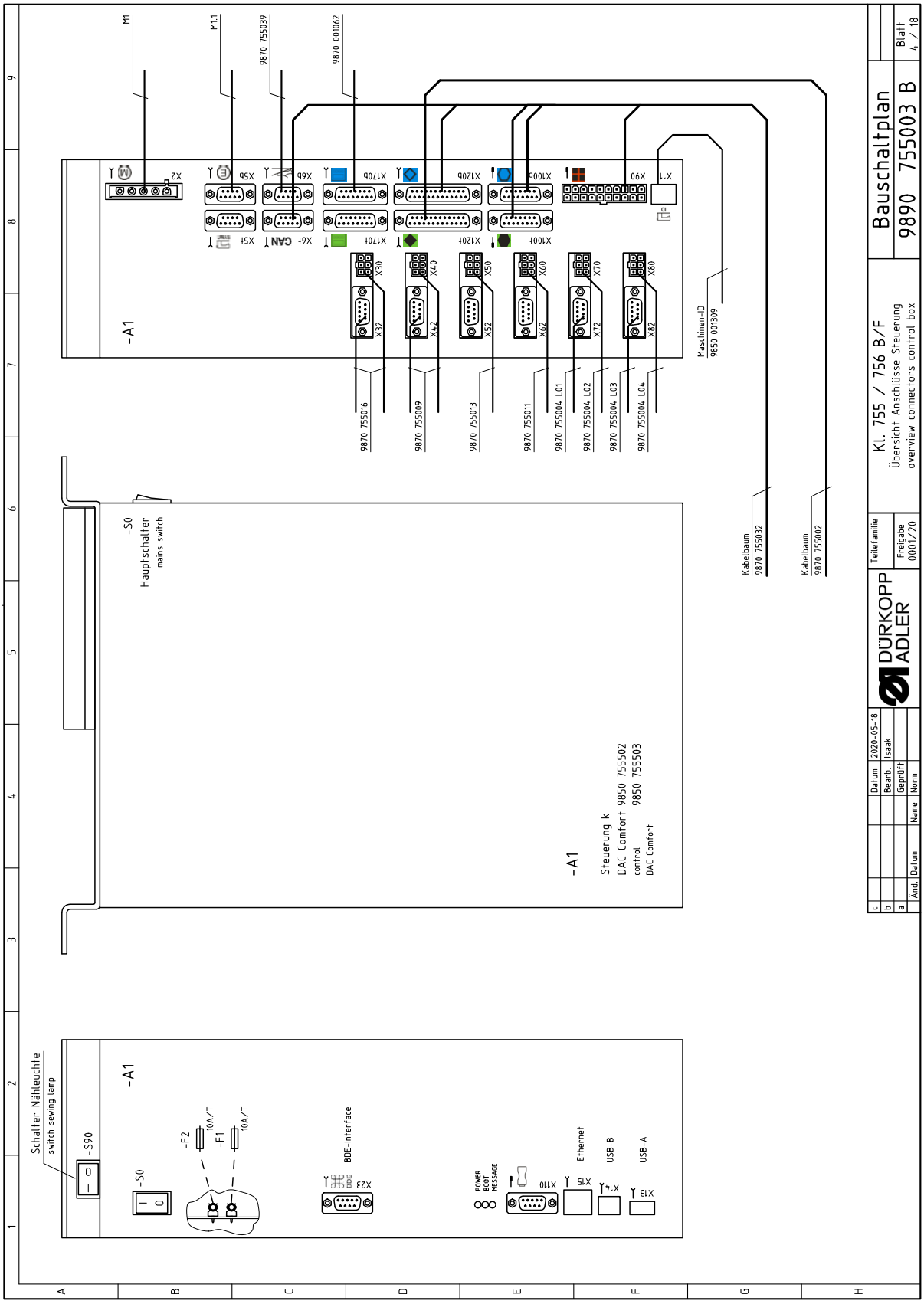


Fig. 277: Wiring diagram

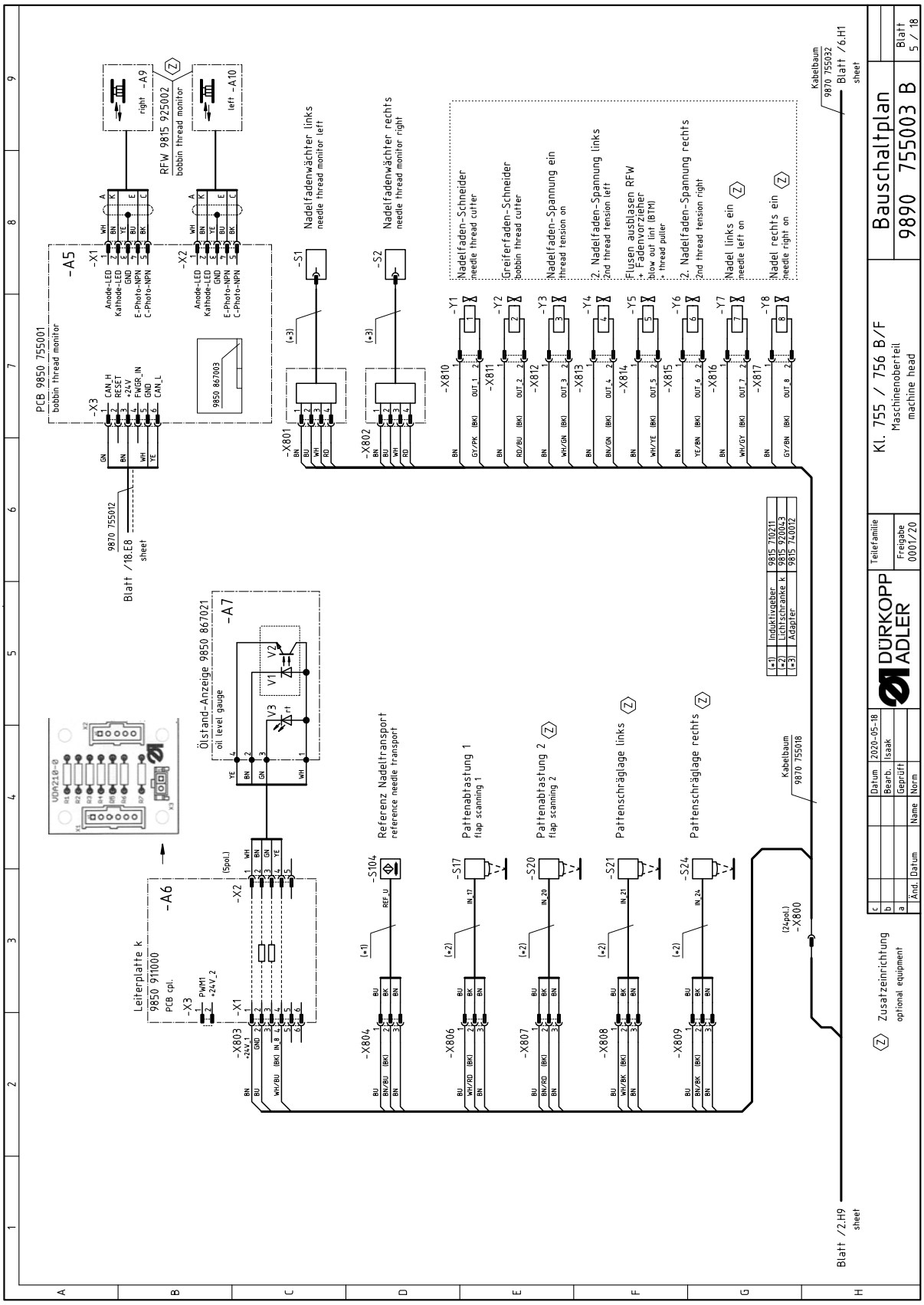


Fig. 278: Wiring diagram

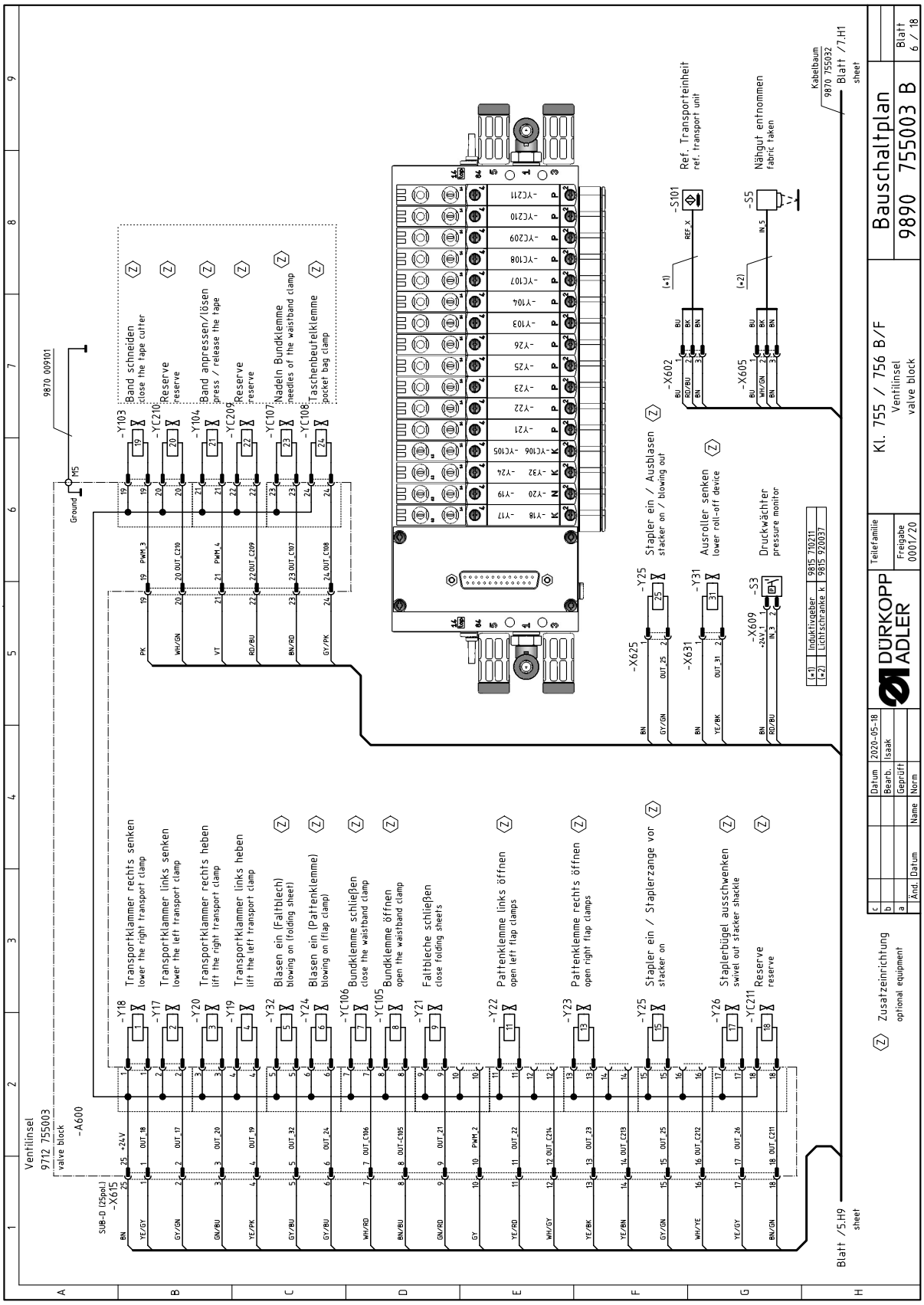


Fig. 279: Wiring diagram

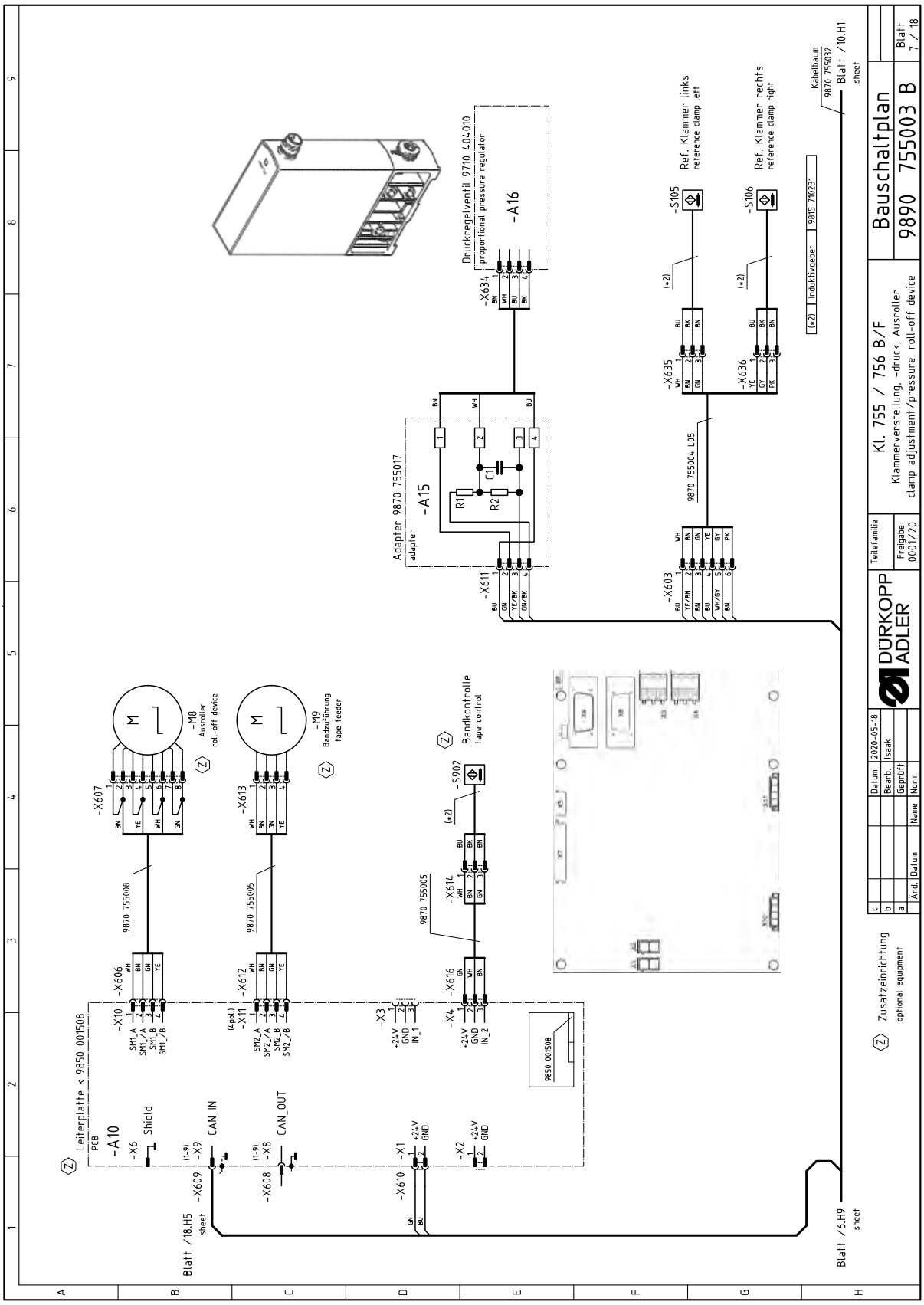


Fig. 280: Wiring diagram

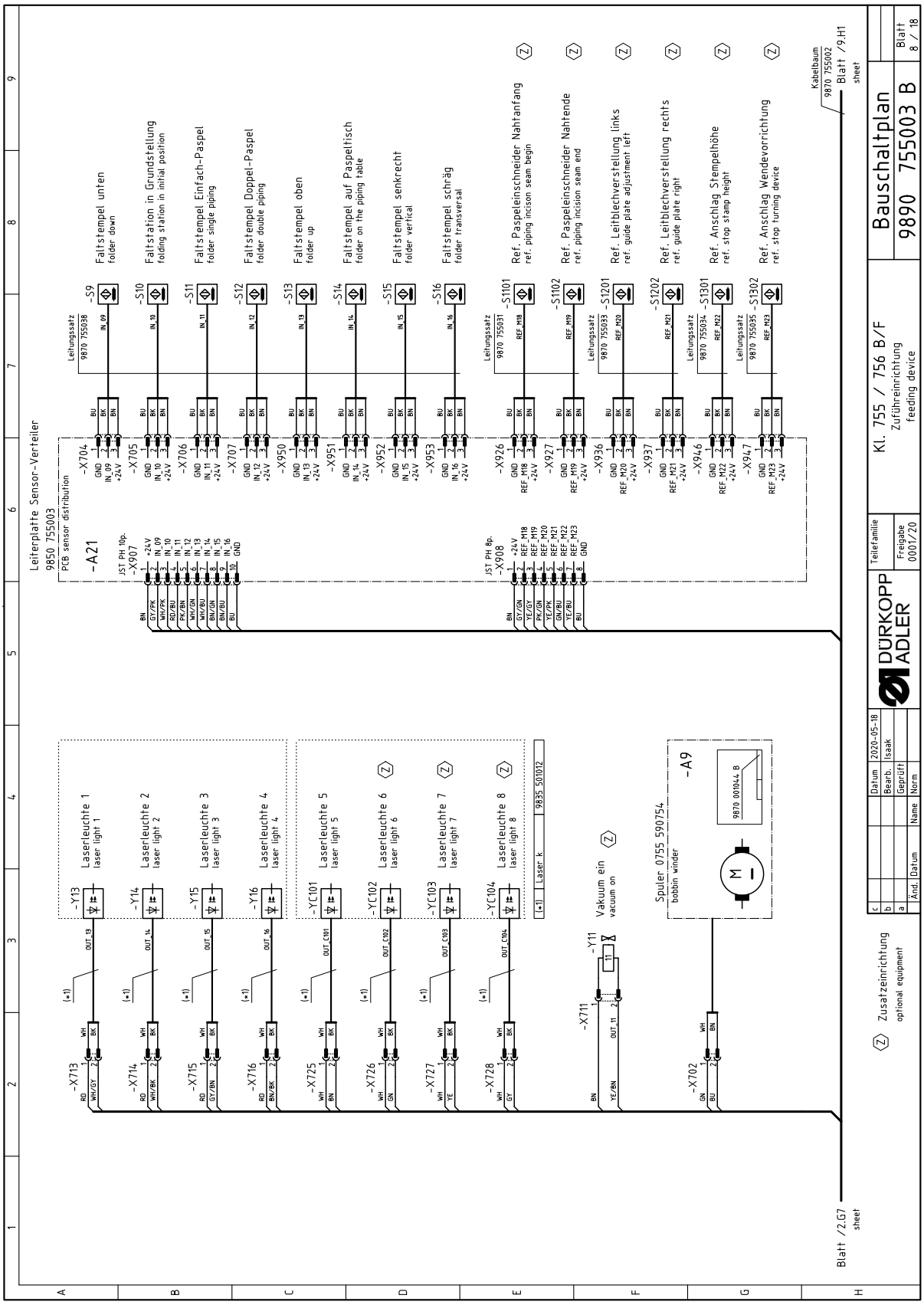


Fig. 281: Wiring diagram

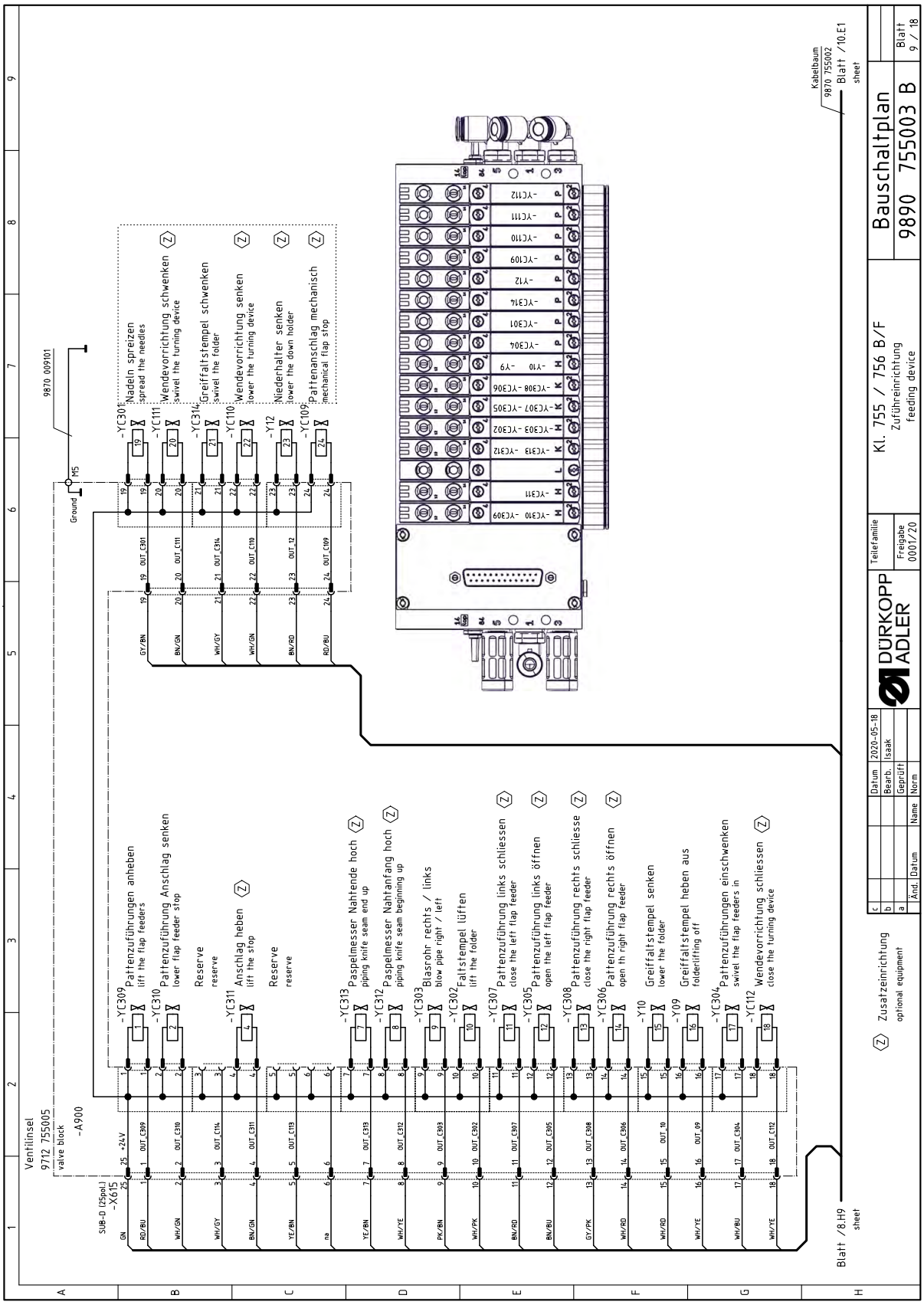


Fig. 282: Wiring diagram

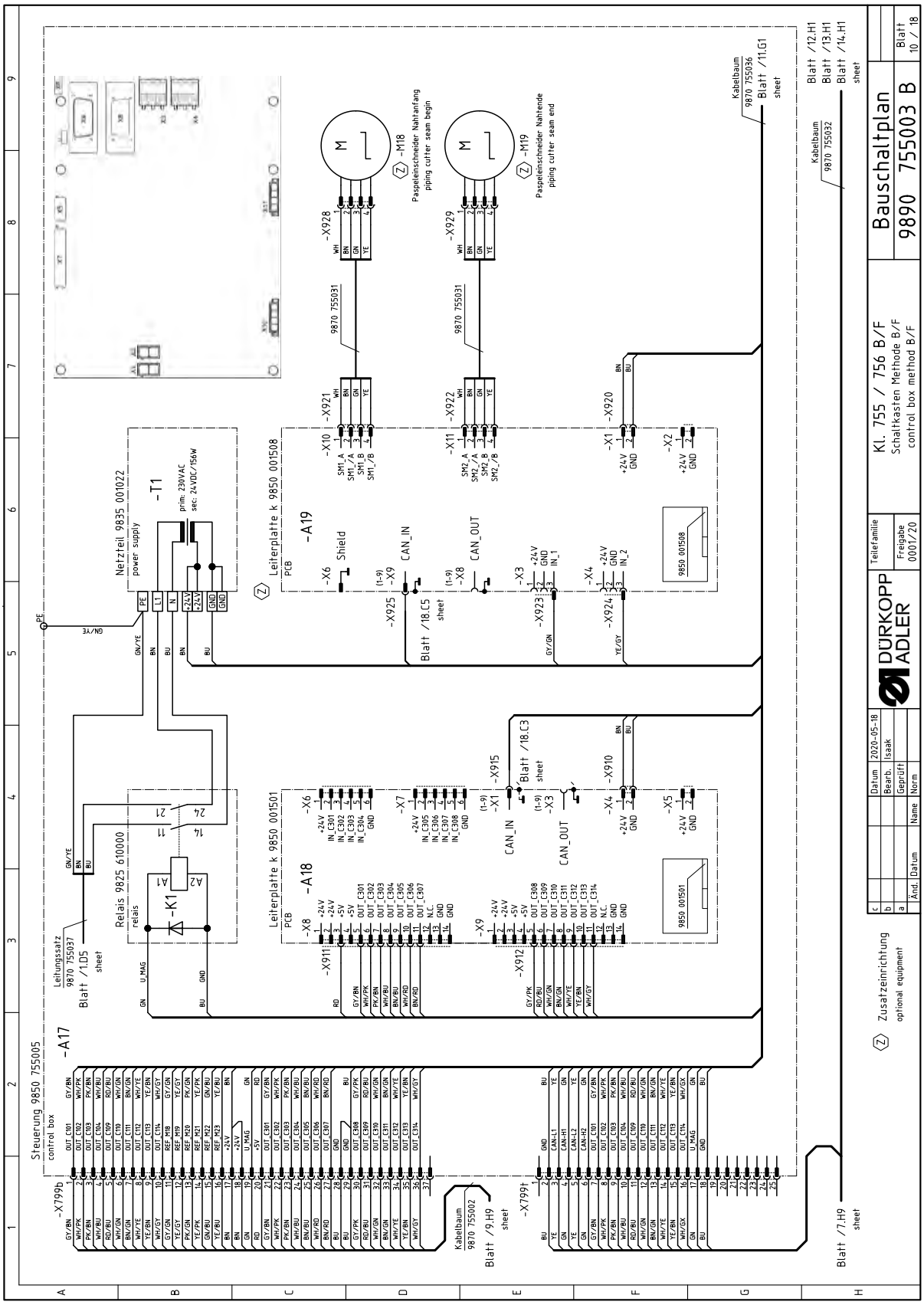


Fig. 283: Wiring diagram

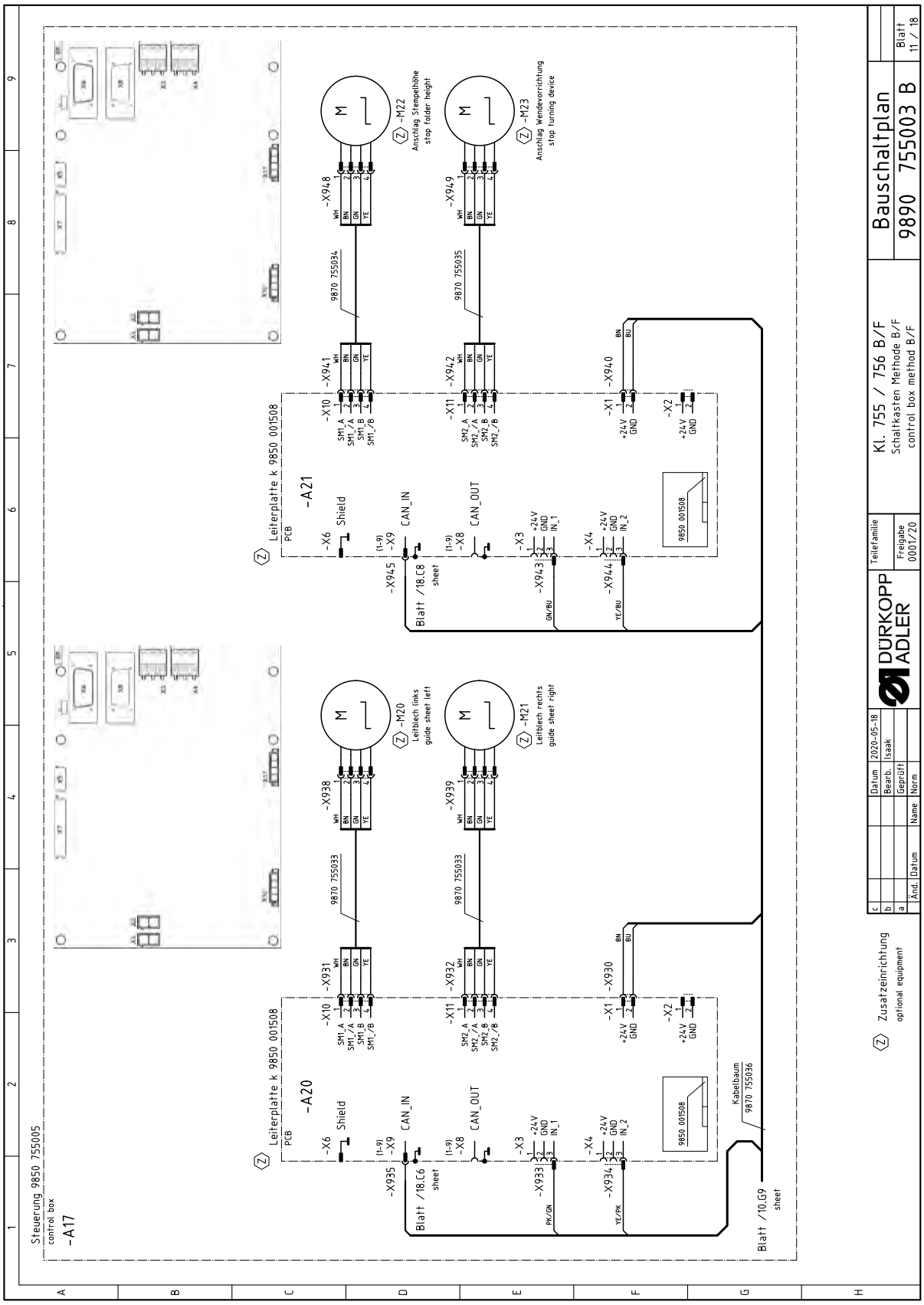


Fig. 284: Wiring diagram

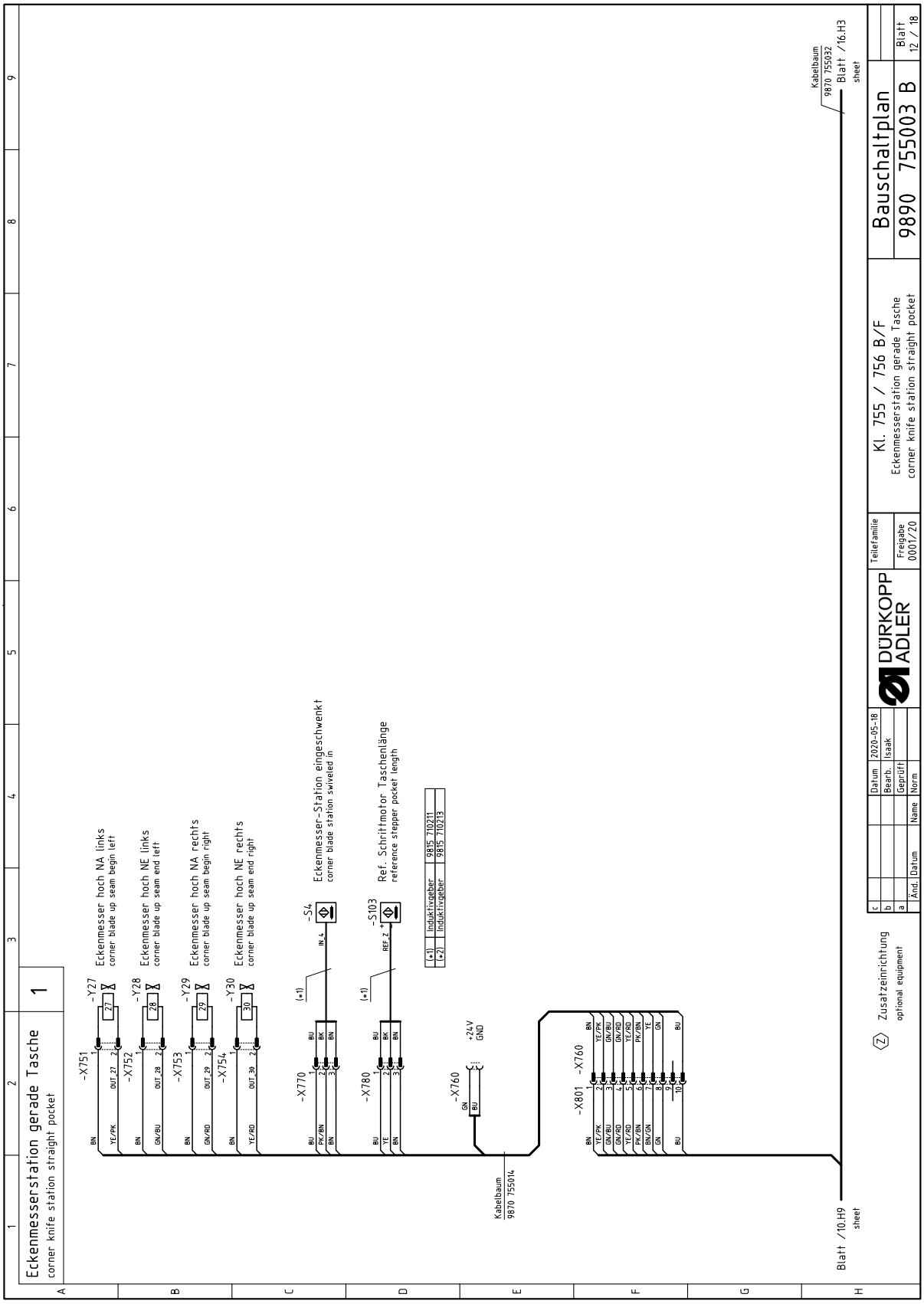


Fig. 285: Wiring diagram

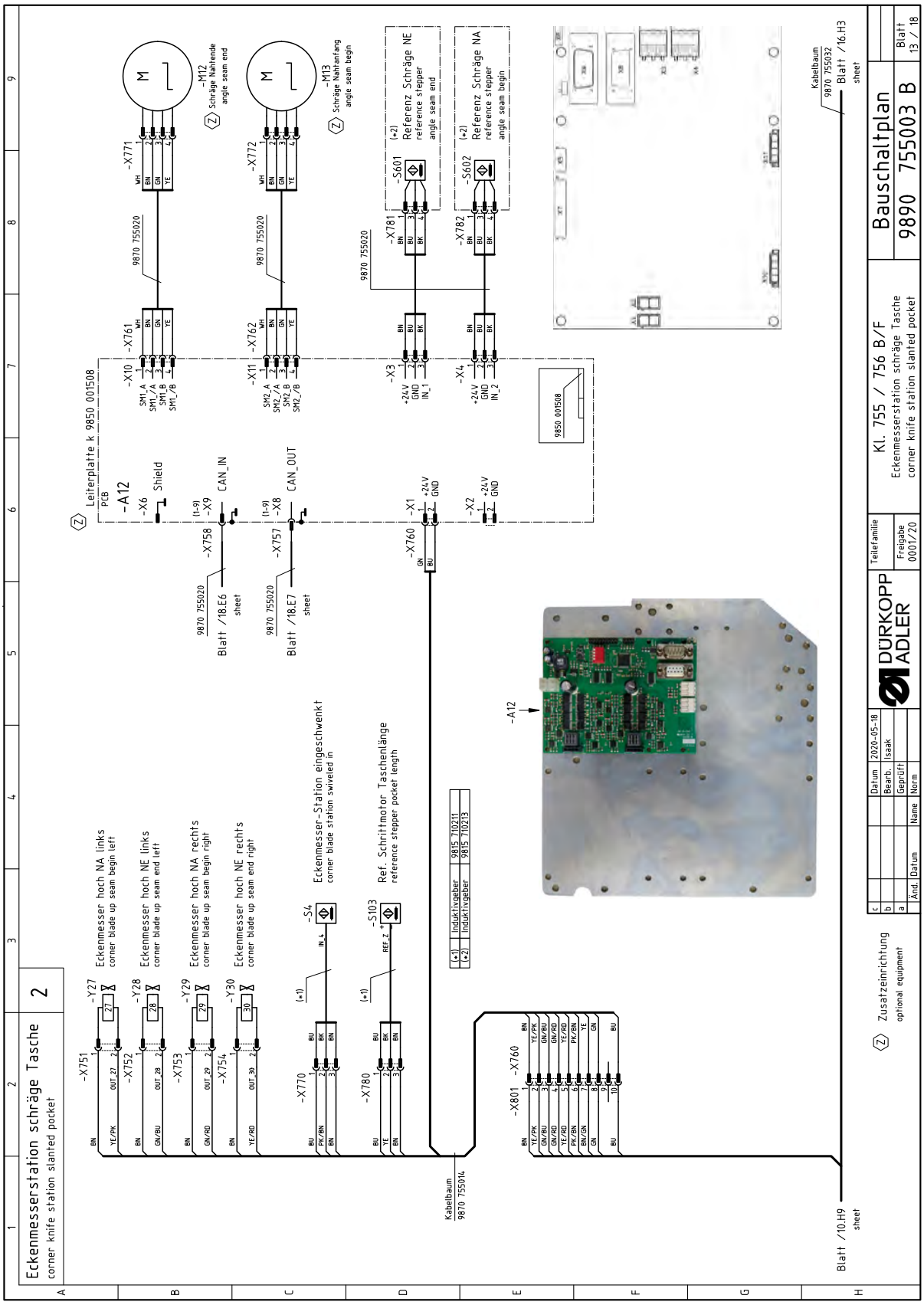


Fig. 286: Wiring diagram

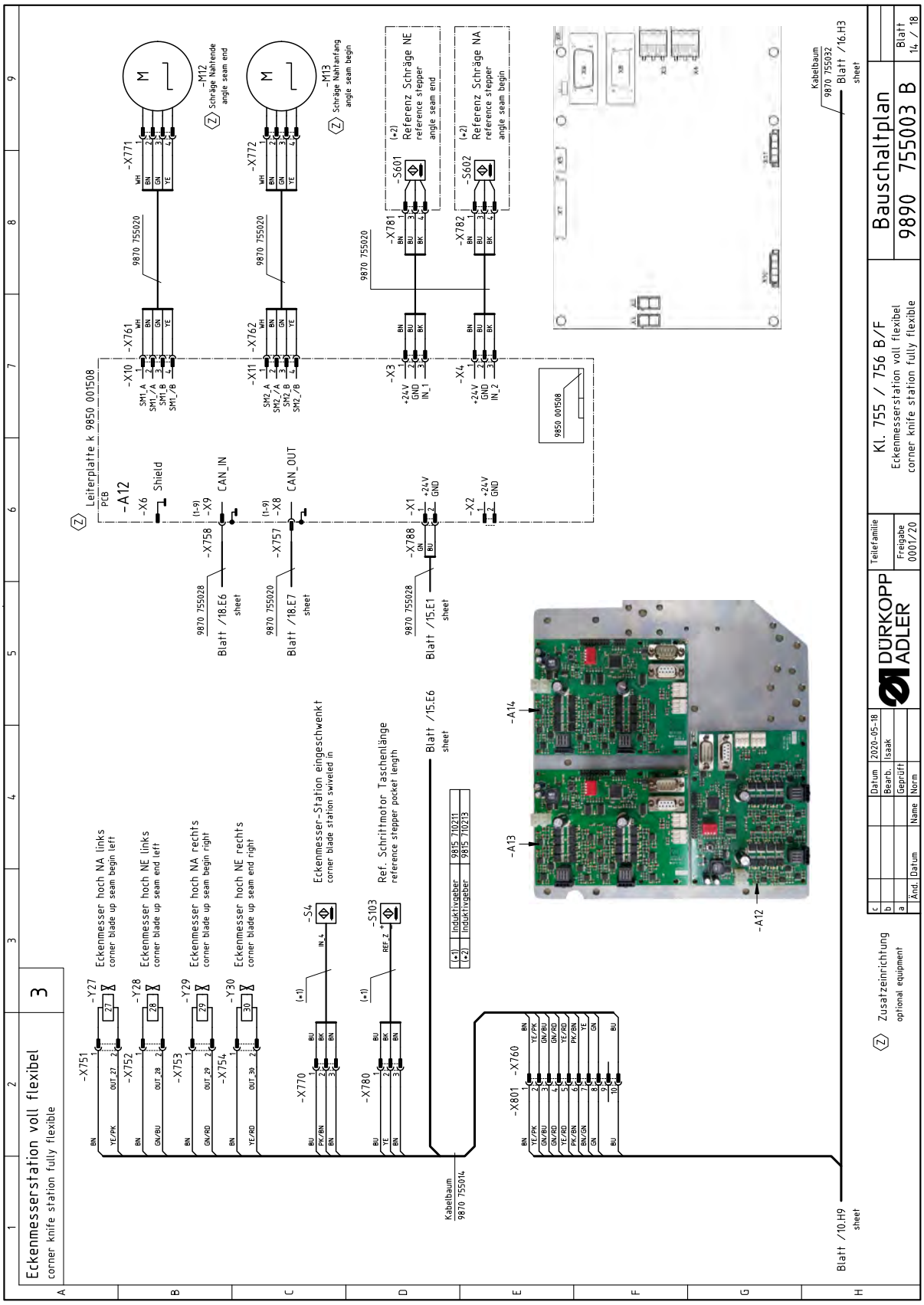


Fig. 287: Wiring diagram

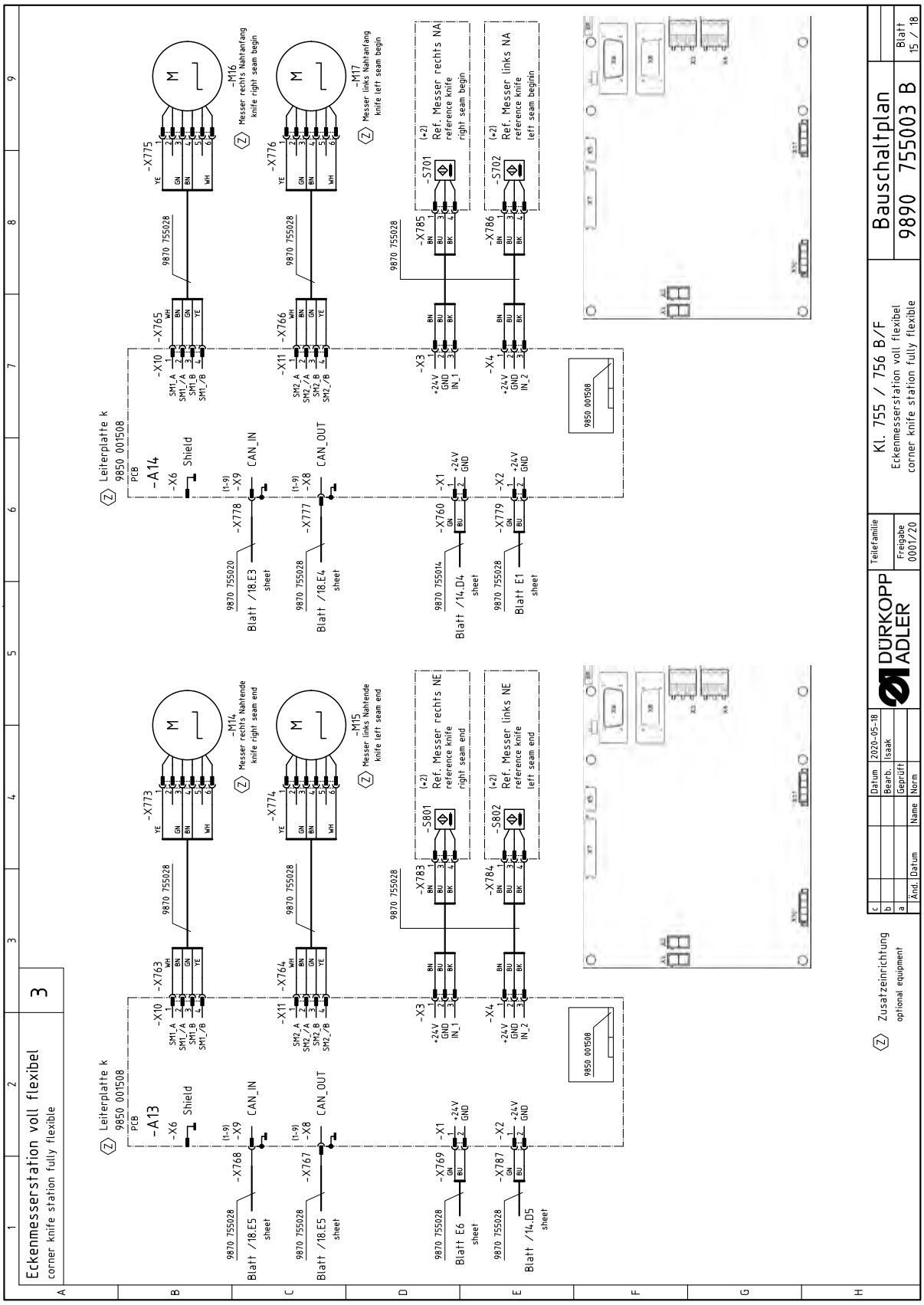


Fig. 288: Wiring diagram

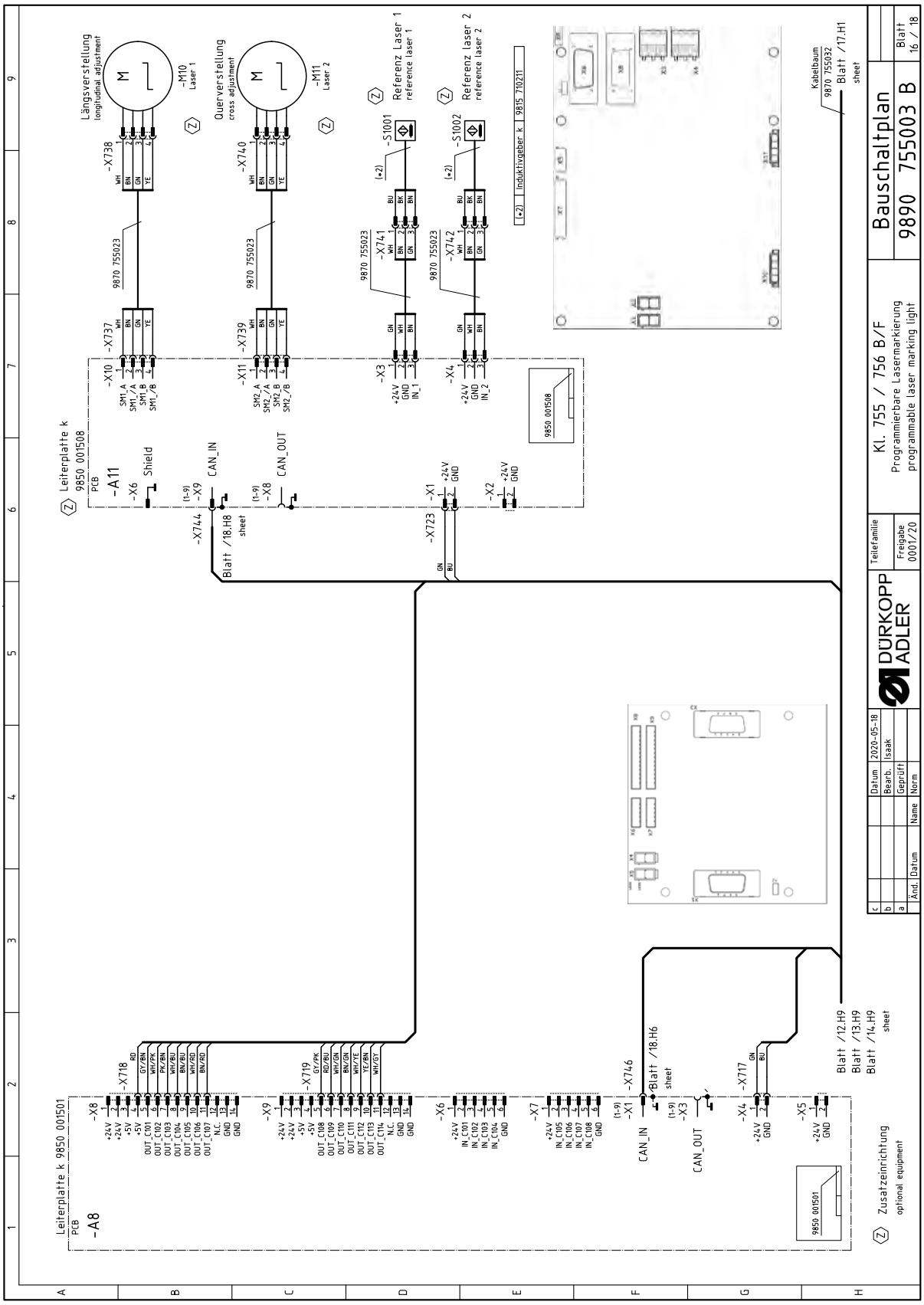


Fig. 289: Wiring diagram

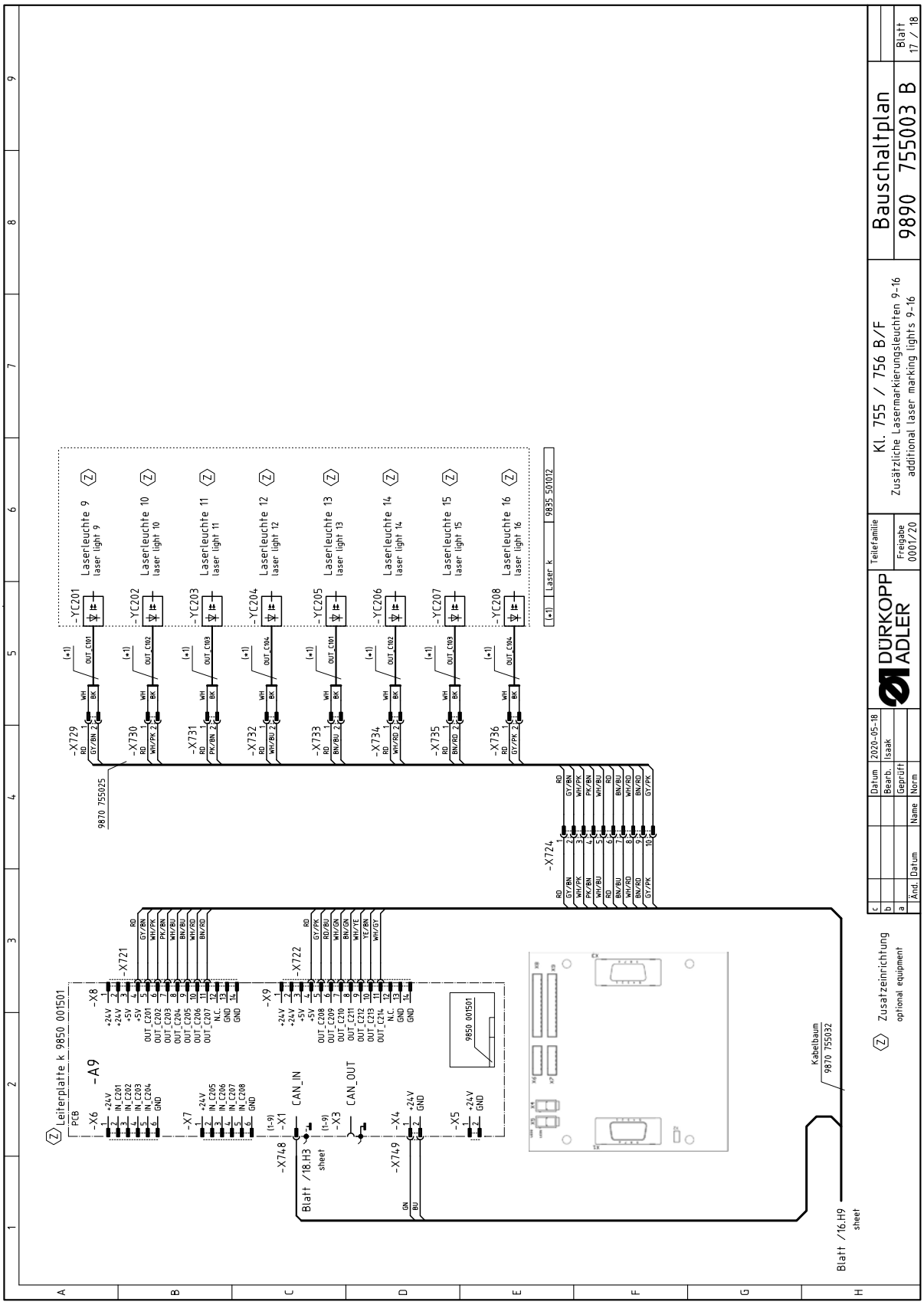
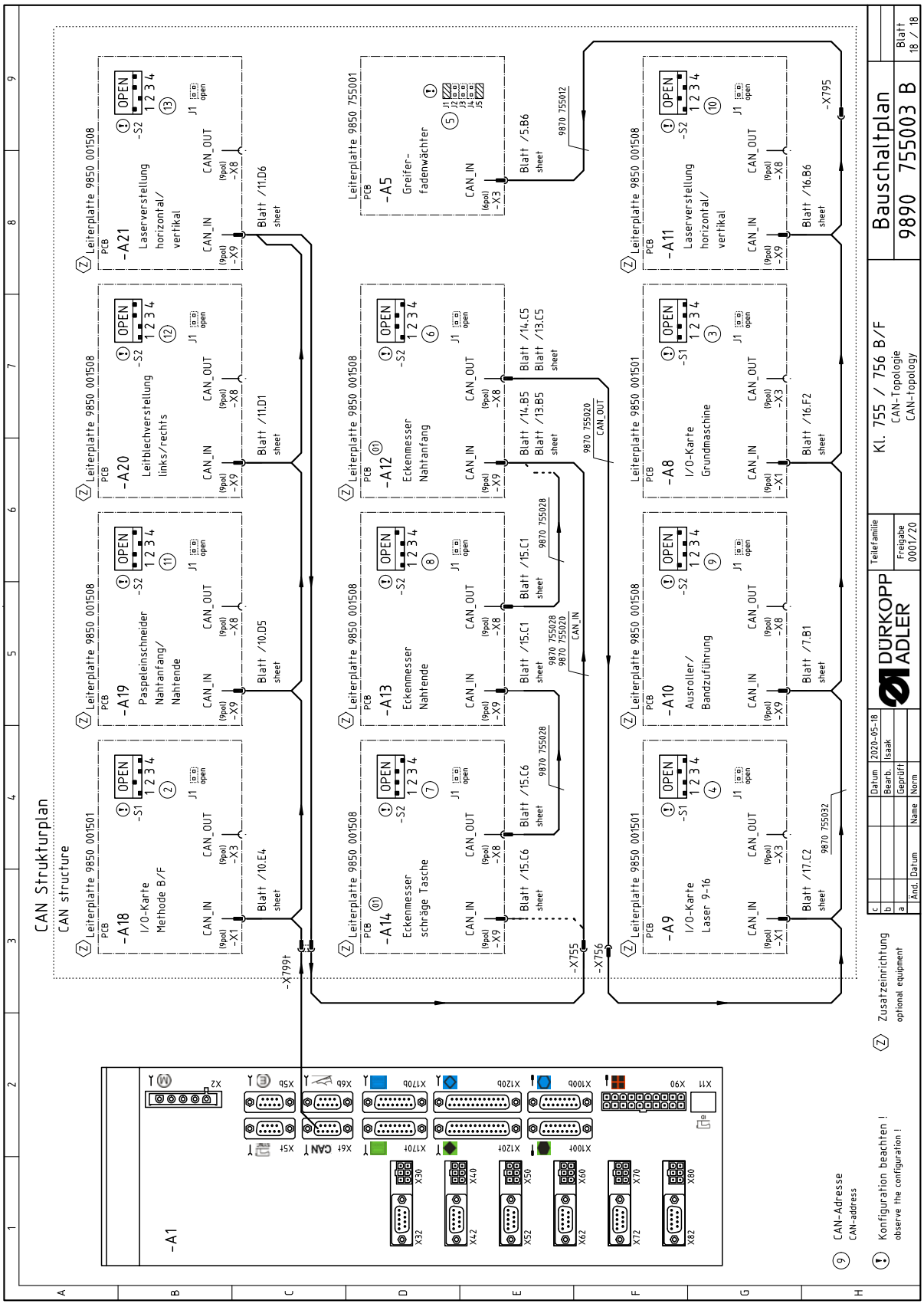
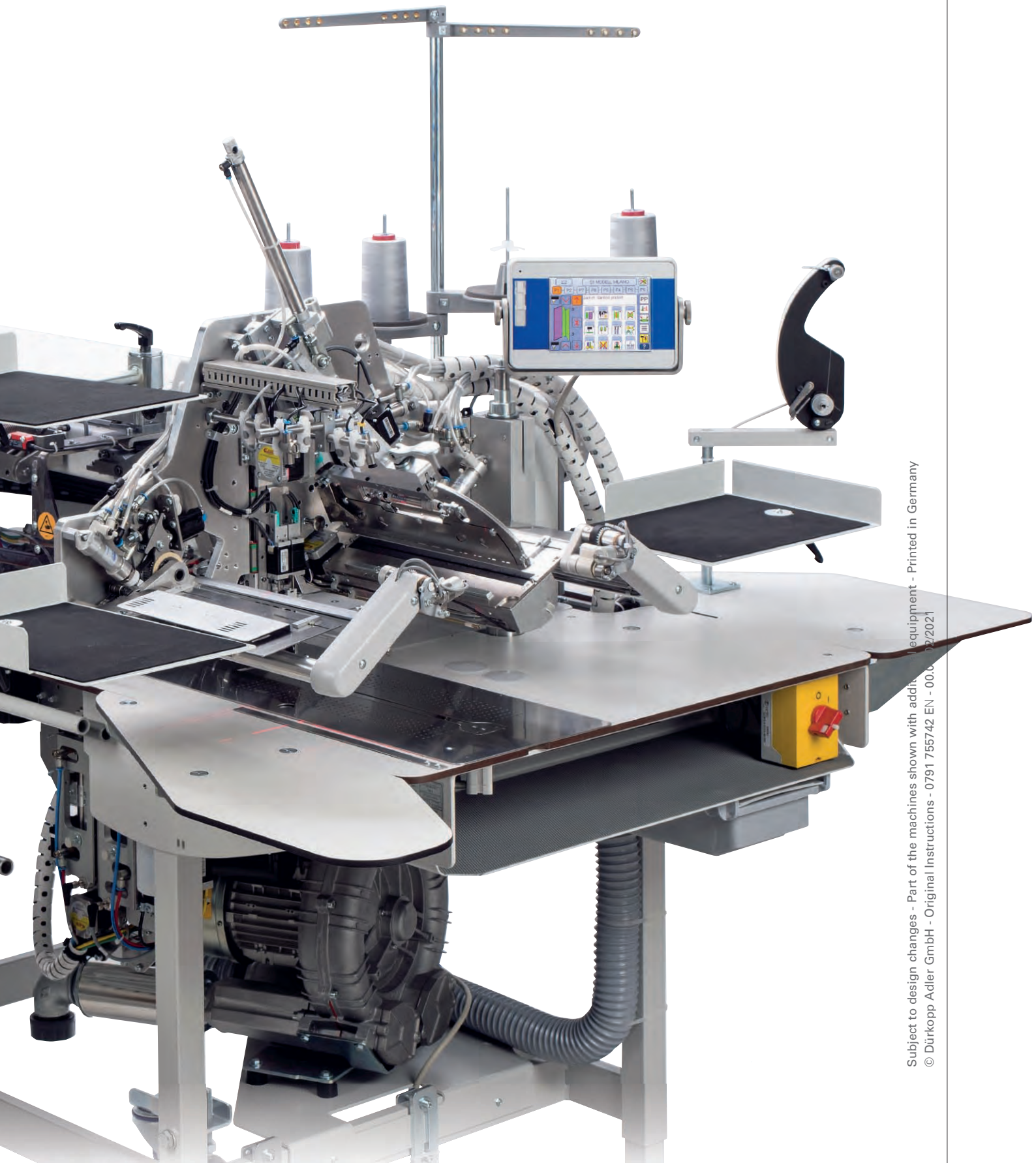


Fig. 290: Wiring diagram



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Subject to design changes - Part of the machines shown with additional equipment - Printed in Germany
© Dürkopp Adler GmbH - Original Instructions - 0791 755742 EN - 00.0 - 02/2021