



Conversion kit EFKA AB386C/DC1600 for class 806

1 To order the conversion kit two parts set must be ordered

1 x 9880 806010

Conversion part set
(without sewing drive DC1550/AB386C)

1 x 9800 130110 R

Sewing drive DC1550/AB386C
(softwareversion AB386C 5425D 14121116 43DE or higher)

WARNING



Danger of electric shock from live parts!

Serious injuries to life and limb.

Conversion shall only be done by qualified specialists.
Unplug the power cord before working at the electric equipment.
Secure the machine against unintentional switching on.

Steps of conversion

1. Remove machine stacker/frame covers
2. Remove the EFKA Control box AB85a/Synchronizer
3. Assemble the motor
4. Setting of motor gear in relation to second needle position
5. Assemble synchronizer
6. Assemble machine stacker/frame covers



2 Remove frame covers and machine stacker

1. Remove stacker.
2. Remove plate.
3. Remove left cover.

Fig. 1



4. Remove side covers.

Fig. 2



3 Remove the EFKA Control box AB85a/Synchronizer

1. Remove 220V power supply and all other plugs from the EFKA Control.

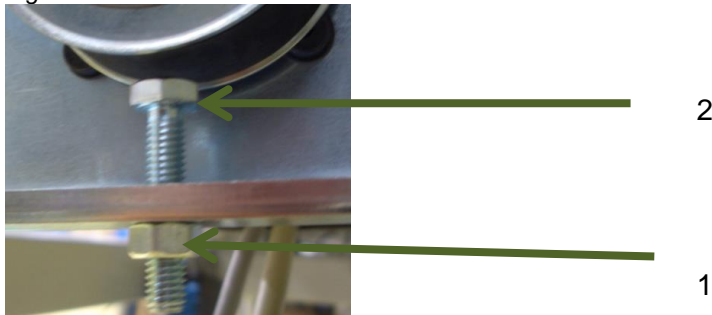
Fig. 3 Belt guide





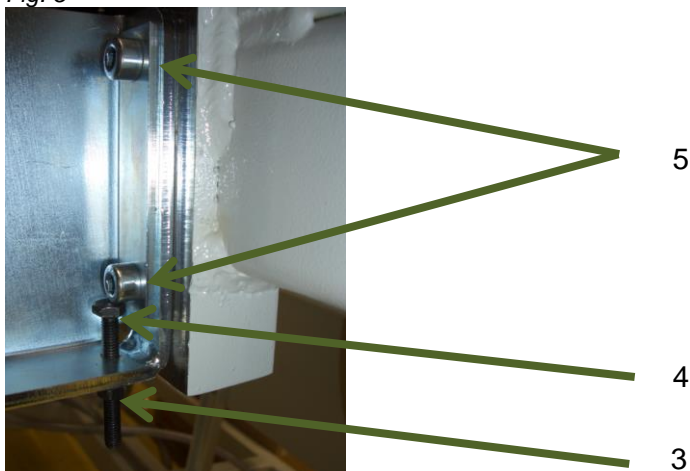
2. In order to remove the EFKA AB85a loosen nut 1 and turn in screw 2.

Fig. 4



3. Open nut 3, turn in screw number 4 until the screw head of number 5 is free.

Fig. 5



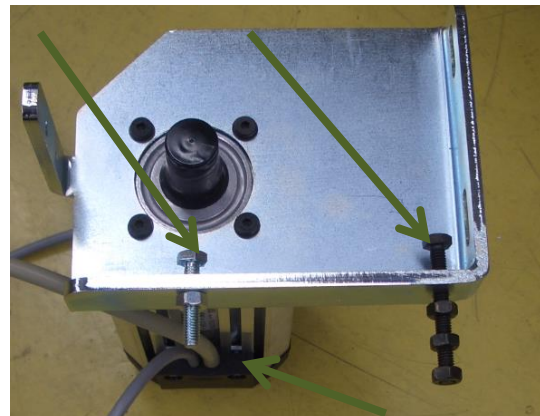
4. Hold the EFKA AB85a and remove screw number 5.

5. Remove old synchronizer.

4 Assemble the new motor

1. Keep the screws from the old motor holder and use them with the new holder.

Fig. 6

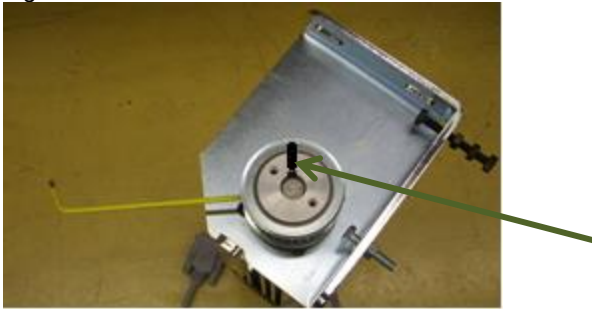


2. Take care about the direction of motor cables.

3. Mount the gear, (the position in relation to the belt must be adjusted when the motor is mounted).



Fig. 7



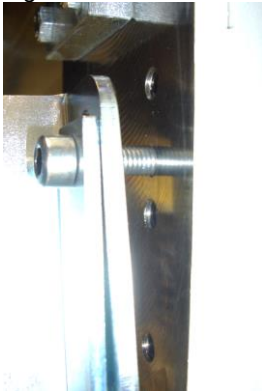
4. Mark the groove of the gear with permanent marker.
5. Mount the motor.

Second hole from top.

Do not tighten the screws strongly.

The belt tension must be adjusted in the next step.

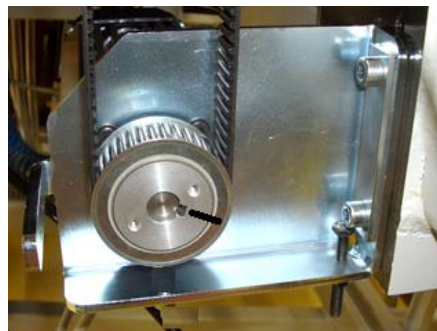
Fig. 8



4.1 Adjusting the belt tension

1. Tighten the screws and nuts.

Fig. 9





5 Setting of motor gear in relation to second needle position

NOTICE

Risk of property damage and disturbance by wrong setting!

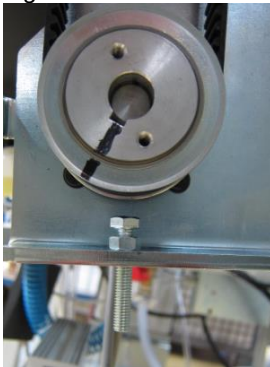
The following setting is very important.

Wrong setting is definitely causing Error 30077 and 110077!

Rule

In second needle position the notch of the motor gear must be at 8 o'clock (considering the outgoing cable of motor at 6 o'clock).

Fig. 10



1. Move transfer plate out of sewing area (the metal base plate must be free).
2. Switch off the main air supply.
3. Swivel down the sewing head by unlocking the lash.
4. Turn the machine into second needle position.
5. Check the mark on the gear according to the rule.

If not correct:

1. Unlock the complete sewing head, lift the sewing head and turn the gear (do not turn the belt) and bring down the sewing head.
2. Check your setting again according to the rule until it is correct.

If correct:

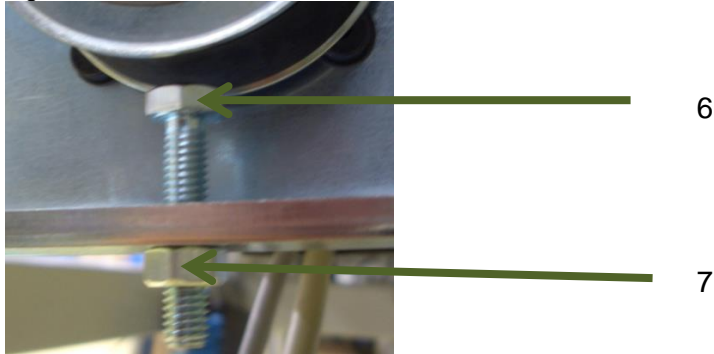
1. Lock the complete sewing head.
2. Lift upper head.



5.1 Adjust belt guide

1. Screw in the screw **6**. The screw head should not touch the belt.
2. Tighten the nut **7**.

Fig. 11



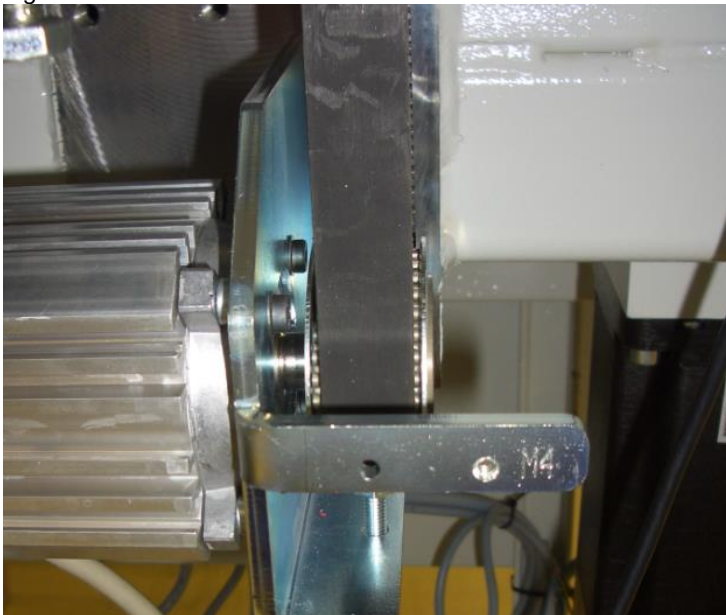
5.2 Adjust position of gear in relation to the belt

Rule

The belt should run in the middle of the gear.

1. Tighten the screw of gear.

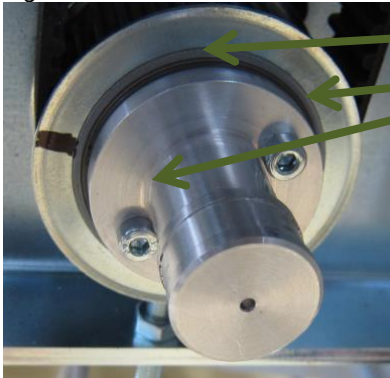
Fig. 12





5.3 Mount the flange for synchronizer

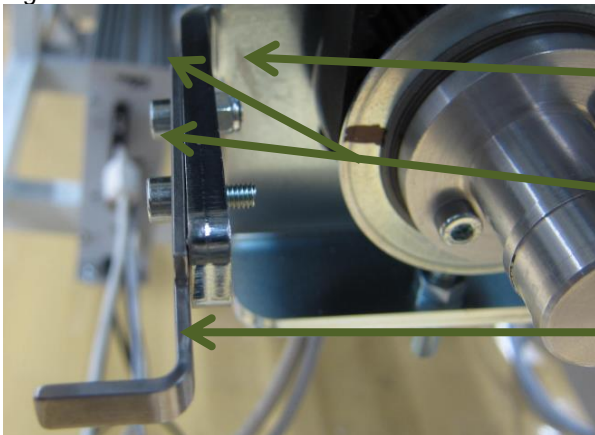
Fig. 13



1 x 0806 490050
2 x 9202 002087 (M4 x 12)

5.4 Mount synchronizer holder

Fig. 14



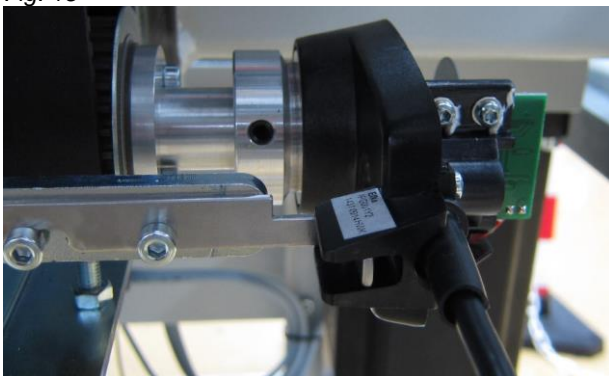
1 x 9234 000077

2 x 9202 002087 (M4 x 12)

0806 490060

6 Mount synchronizer

Fig. 15



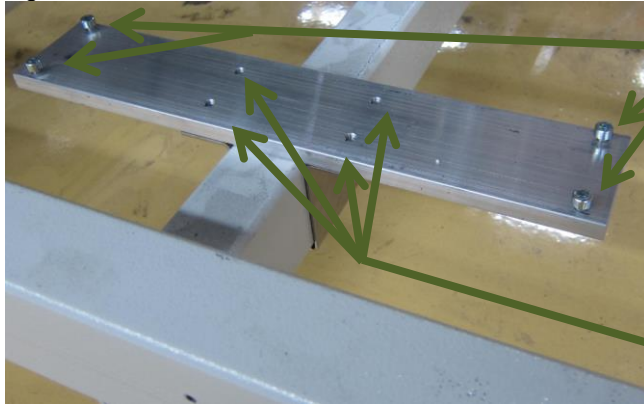
1. Remove the cover of synchronizer.
2. Mount the synchronizer and tighten the screws (the 180° disc will be adjusted later on).



6.1 Mount the control box

1. Mount the bracket and plate.

Fig. 16



4 x 9202 002487 (M5 x 12)

4 x 9202 002487 (M6 x 10)

Make sure that it is not sitting directly under the air maintenance unit because water could drop down.



Fig. 17



2. Tighten 4 x holding screws for control box.

Fig. 18

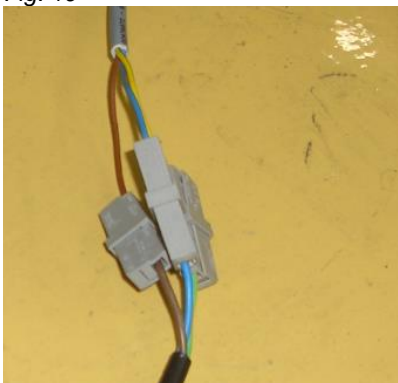


Connect all plugs to control box.

6.2 Electrical connection

1. Connect the quick connector to the power cable.

Fig. 19



2. Earth the wire of the DA power supply cable by cutting the wire and adding an end sleeve.



3. Connect the quick connector.

Fig. 20



4. Use cable ties to hold the cables together.

6.3 Setting of second needle position

1. Connect the power supply, and switch on the machine.
2. See whether the machine in general is positioning and starting normal.
(the positioning of take up lever will wrong !!).

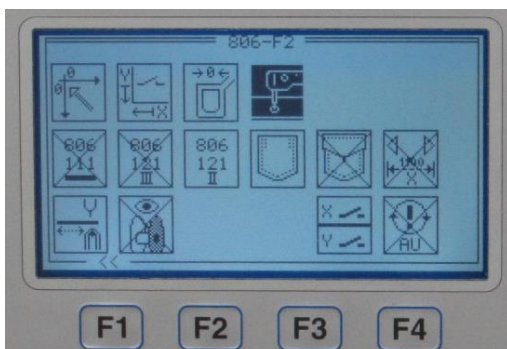
If the start up for positioning is normal, switch of the machine.



**Make sure there is a stable power supply for the next operation.
Make sure that the "F2" menu is left with the "F1" button after finishing the settings.**


Both will cause loss of the operation system ("MP" "GP"), which has to be reset by authorized personal only.

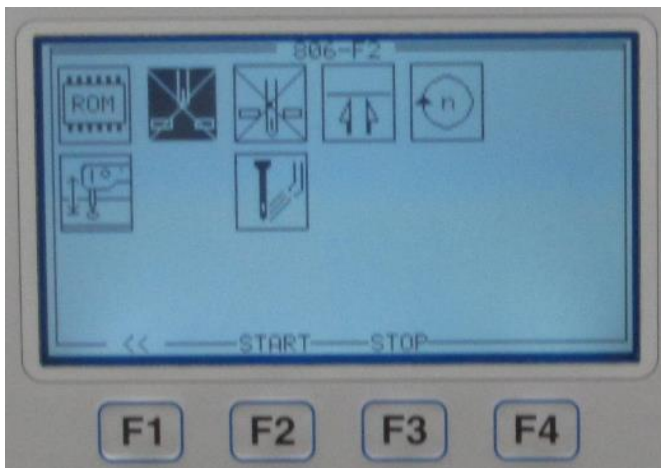
1. Press the "F2" button and switch on the machine and hold the "F2" button until you see the menu below.



2. Go to **Test of sewing head** (black icon).

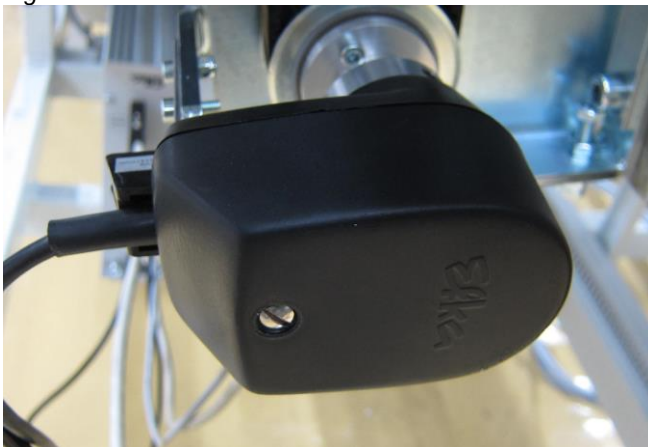


1. Push  to swivel down the sewing head.
2. Select needle (tack up lever) upper position.
3. Press "F3" for start and "F4" for stop.
4. Hold the 180° disc of synchronizer and turn the hand wheel until the second position (short behind the tack up lever top position).
5. Test your settings.
6. Go out with pressing "F1" (otherwise "MP" "GP").
7. Go out with pressing "F1" (otherwise "MP" "GP").



1. Close the cover of the synchronizer.

Fig. 21



2. Start up and run the machine for test.



If the test was successful mount the frame covers and stacker.

7 Mount frame covers and machine stacker

1. Mount side covers.

Fig. 22



2. Mount stacker.
3. Mount plate.
4. Mount left cover.

Fig. 23





Scope of delivery of parts set 9880 806010

	Part No	Qty	Unit	Name of the item	Description
1	0791 806771 EN	1	pc.	Conversion instructions	KI.806 AB386C
2	0806 408180	1	pc.	Angle	
3	0806 408193	1	pc.	Toothed washer	
4	0806 490030	1	pc.	Plate	
5	0806 490040	1	pc.	Holder	
6	0806 490050	1	pc.	Flange	
7	0806 490060	1	pc.	Holder Encoder	
8	9202 002087	4	pcs.	Cyl. screw	M4x12
9	9202 002487	4	pcs.	Cyl. screw	M5x12
10	9202 002877	4	pcs.	Cyl. screw	M6x10
11	9234 000067	1	pc.	Hexagonal nut	M4 self-locking
12	9840 121001	4	pcs.	Cable tie	
13	9825 570105	3	pcs.	Quick connector	WAGO 224

Scope of delivery of parts set 9800 130110 R

	Part No	Qty	Unit	Name of the item	Description
1		1	pc.	Efka control AB386C	AB386C
2		1	pc.	Sewing motor	DC1500
3		1	pc.	Positioner	IGP001
4		1	pc	Set mounting parts motor	
5		1	pc	Operating instructions / parameter list	



Sometimes the scope of delivery of 9800 1300110 R consists also of a pedal switch and a programming plug.

There is no need to use those items in regard of this conversion kit !!!