

**Part 2: Installation Instructions Cl. 558**

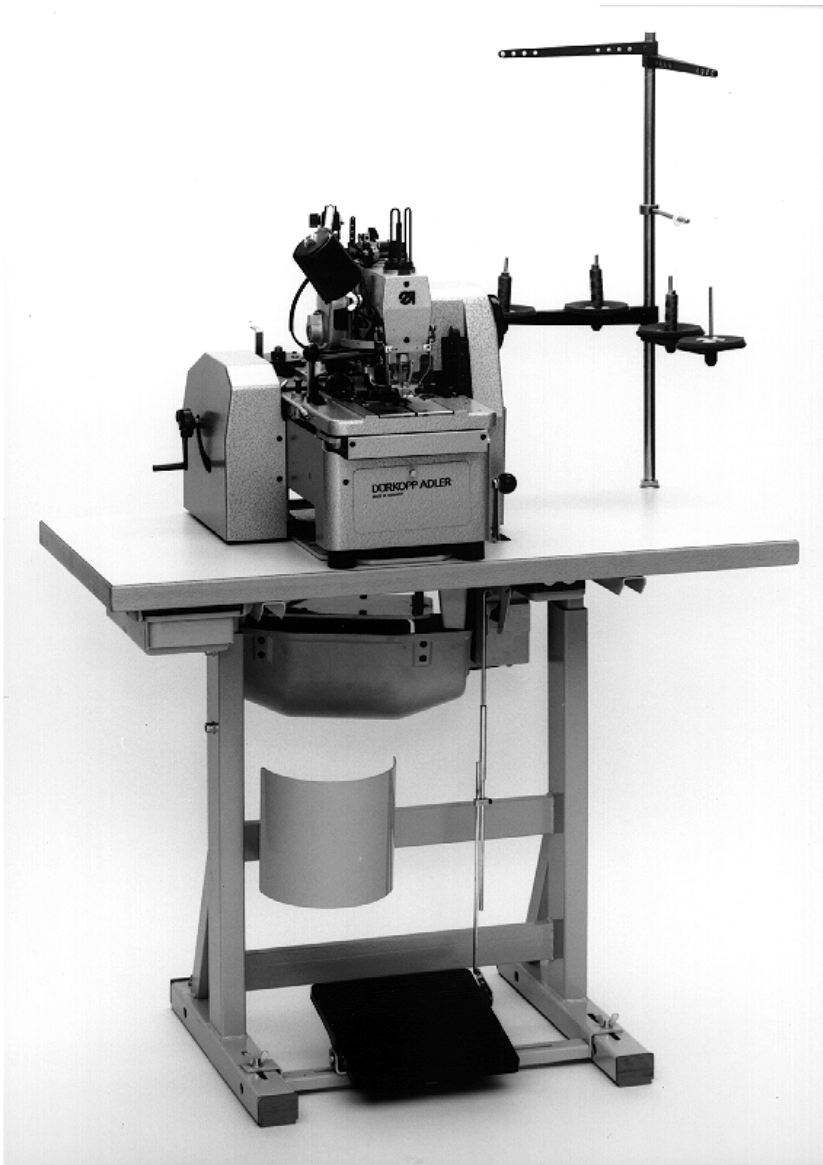
<b>1.</b>	<b>Scope of Delivery</b> . . . . .	<b>3</b>
<b>2.</b>	<b>Installation</b> . . . . .	<b>4</b>
2.1	Transport . . . . .	5
2.2	Work Height . . . . .	5
2.3	Shift Linkage . . . . .	5
2.4	Yarn Unreeler for Yarn and Wool Cones . . . . .	7
2.5	Yarn Stand . . . . .	7
<b>3.</b>	<b>Electrical Connection</b> . . . . .	<b>8</b>
3.1	Nominal Voltage . . . . .	9
3.2	Drive Package . . . . .	9
3.3	Direction of Motor Turn . . . . .	10
3.4	V-belt Tension . . . . .	11
<b>4.</b>	<b>Installation of a Sewing Light</b> . . . . .	<b>12</b>
<b>5.</b>	<b>Filling the Oil Reservoir</b> . . . . .	<b>14</b>

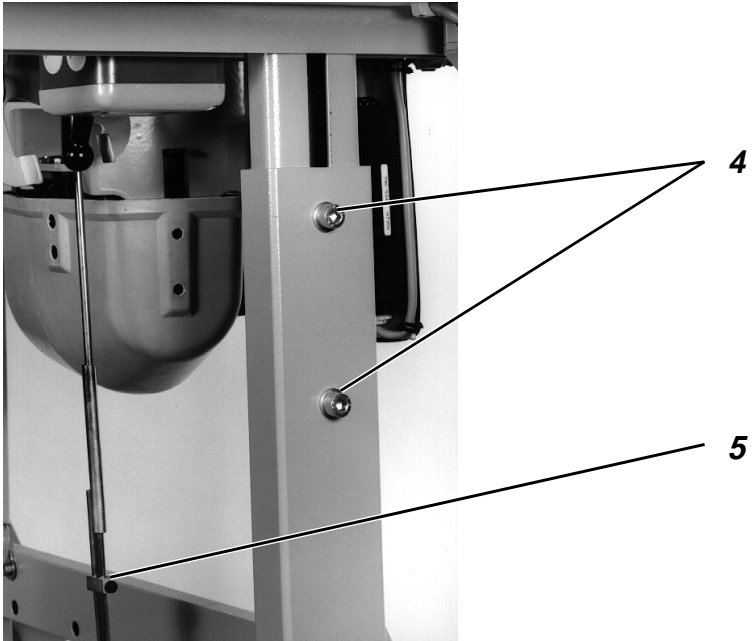
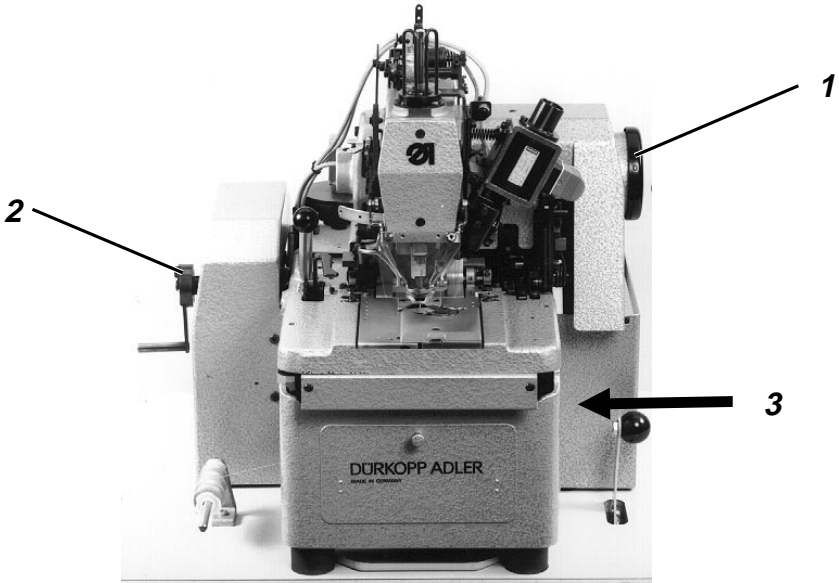




## 1. Scope of Delivery

- Basic equipment, depending on sub-class, with short trimmers and electromagnetic upper thread catcher
- Yarn stand
- Small parts in the accessories pack







## 2. Installation



### **ATTENTION !**

The buttonhole machine may only be installed by trained personnel.

Prior to installation the following work must be conducted:

- Remove the transport fastening screw 3 !  
The screw is marked red.
- The needle bar is turned into its low position for transport.  
By turning the handwheel 1 in the direction of the arrow bring the needle bar into the high position !
- Push on crank handle 2 and lock in place !

### 2.1 Transport

For in-house transport the machine must be lifted and transported on a suitable wagon (e.g. pallet truck).

### 2.2 Work Height

The work height is adjustable between 76 and 104 cm.

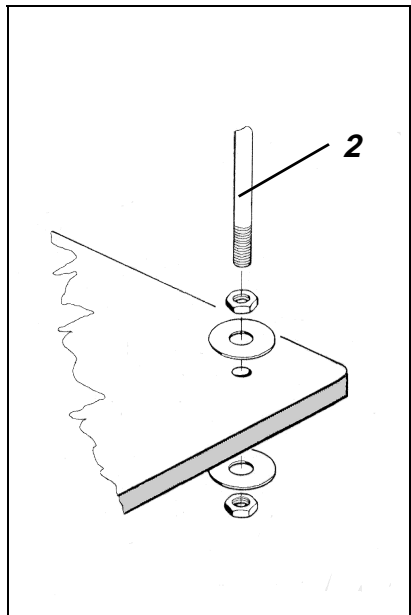
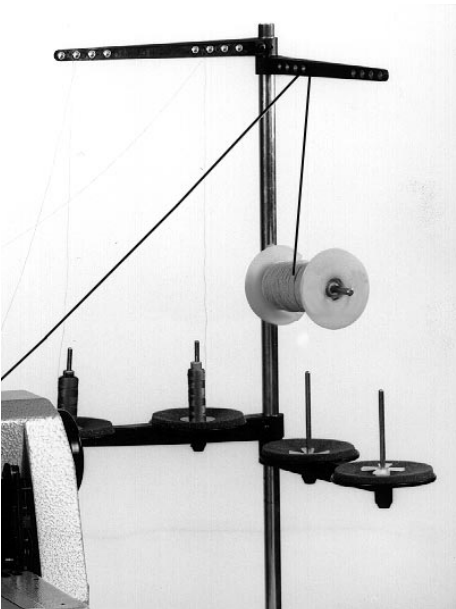
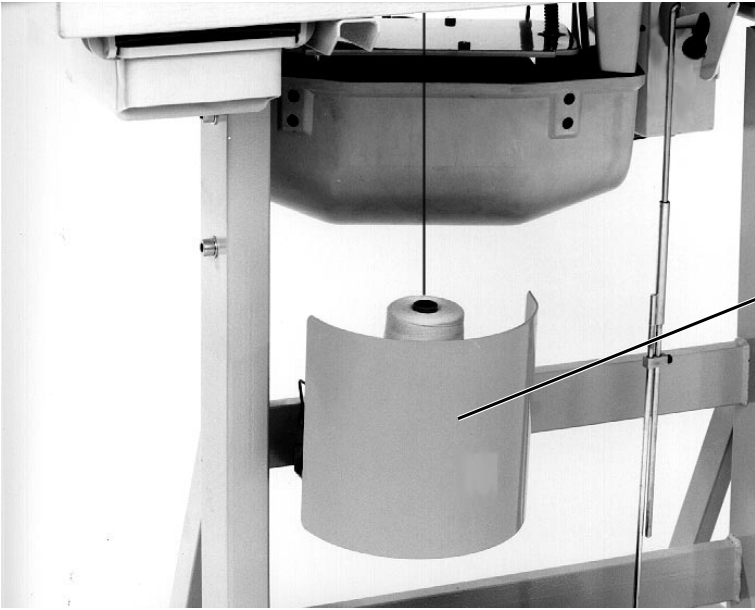
The machine was set at a work height of 82 cm at the factory.

- Loosen screws 4.
- Set the machine horizontally at the desired work height.
- Tighten screws 4.

### 2.3 Shift Linkage

The shift linkage from the hand shift lever to the pedal is to be set appropriate to the work height.

- Loosen screw 5.
- Set the pedal.  
The operator must be able to switch off the machine unhindered by stepping forward on the pedal.
- Tighten screw 5.





## 2.4 Yarn Unreeler for Yarn and Wool Cones

### Optional equipment Article no. 558 3001

The yarn unreeler 1 is fastened to the middle traverse.

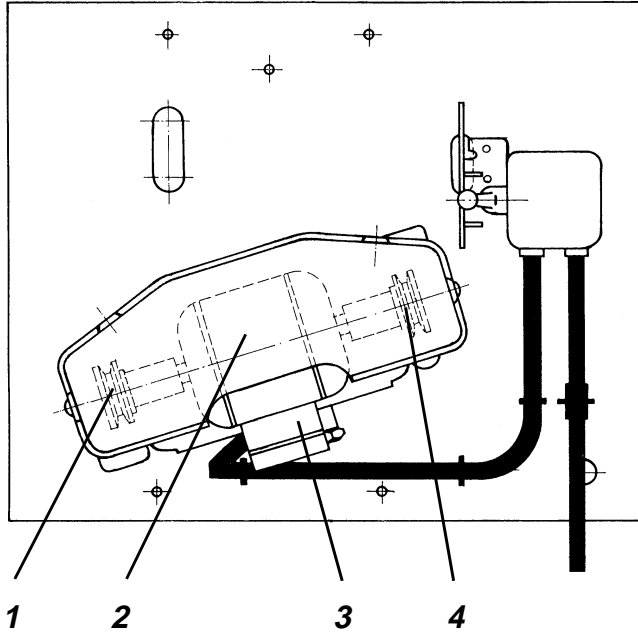
Additionally, the yarn unreeler can be equipped with a drawer.

This could be necessary, for example, when a small table is used and there is thus no room available under the table.

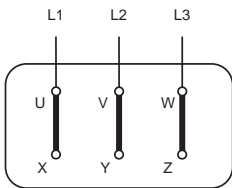
## 2.5 Yarn Stand

The mounting and position of the yarn stand can be seen in the illustration alongside.

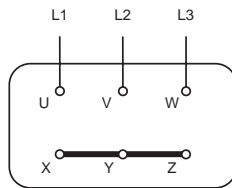
- Insert stand 2 and fasten as shown in the picture with the nuts and washers.
- Fasten the yarn roll holder and take-off arms.  
The yarn roll holder and take-off arms must stand vertically above one another.



**" Star "**



**" Delta "**







### 3. Electrical Connection



#### **ATTENTION !**

All work on the electrical equipment of the buttonhole machine may only be conducted by electricians or suitably instructed personnel.  
The mains plug must be disconnected.

#### 3.1 Nominal Voltage

The nominal voltage listed on the motor rating plate and the mains voltage must be the same !

#### 3.2 Drive Package

For conversion to a different mains voltage the appropriate drive package must be mounted.

The drive package consists of:

Motor **2**, belt pulleys **1 + 4**, V-belt and switch.

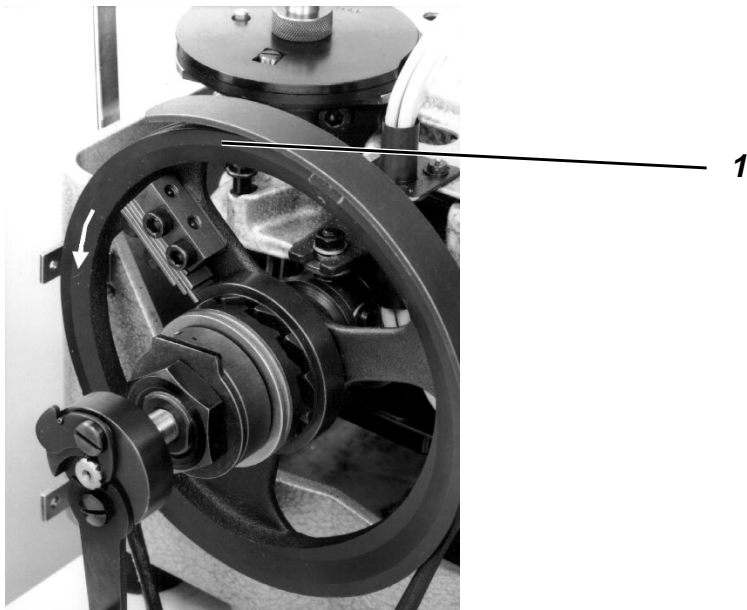
<b>Order no.:</b>	<b>Nominal voltage:</b>
- 2410591	3 ~ 400 V + N, 50 Hz
- 2410575	3 ~ 230 V, 60 Hz
- 2295482	3 ~ 230 V, 50 Hz
- 2410540	1 ~ 230 V, 50 Hz
- 2410478	1 ~ 230 V, 60 Hz

For conversion to a different mains voltage the following changes are to be made:

- If changed from 3-phase to 2-phase or vice versa, the whole drive package must be changed.
- If changed from 50 Hz to 60 Hz or vice versa, only the belt pulley and the V-belt must be replaced.
- If changed from 3 ~ 400 V to 3 ~ 230 V or vice versa, the bridges in the motor terminal box **3** must be switched in "**Star**" or "**Delta**", appropriate to the mains voltage !  
The wiring is shown in the hook-up diagram.



### 3.3 Checking the Direction of Motor Turn



#### **ATTENTION !**

Before commissioning the buttonhole machine it is essential that the direction of motor turn be checked.

Turning on the machine with an incorrect direction of motor turn can lead to damage of unit.

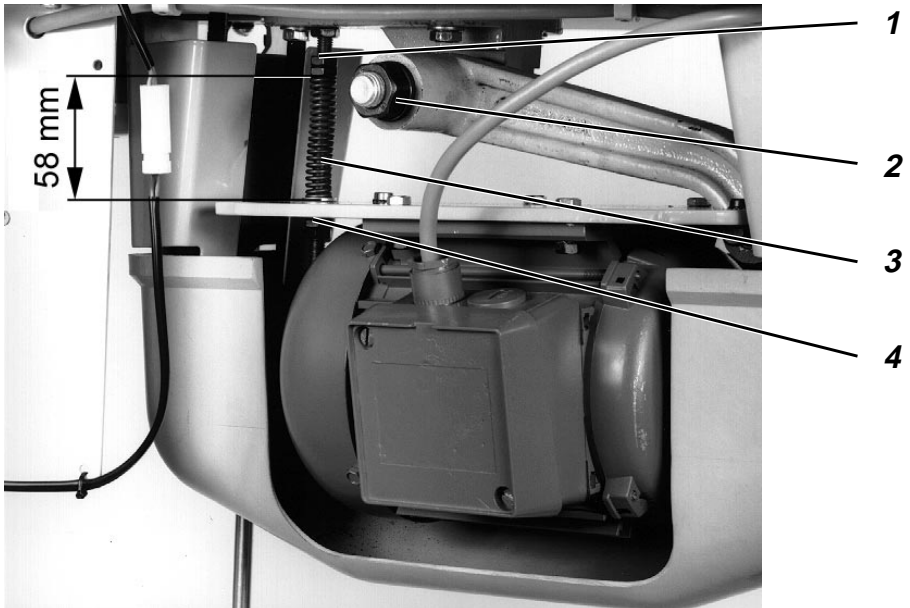
With single phase, alternating current motors the direction of turn is set automatically if terminal connections are made according to the hook-up diagram.

With 3-phase motors the direction of turn must be checked.

- The correct direction of turn is shown by the arrow on the high-speed wheel 1.
- If the direction of turn is incorrect, then a check must be made if the voltage supply generates a clockwise rotary field. If this is the case, then 2 phases in the connecting plug must be interchanged.



### 3.4 V-belt Tension

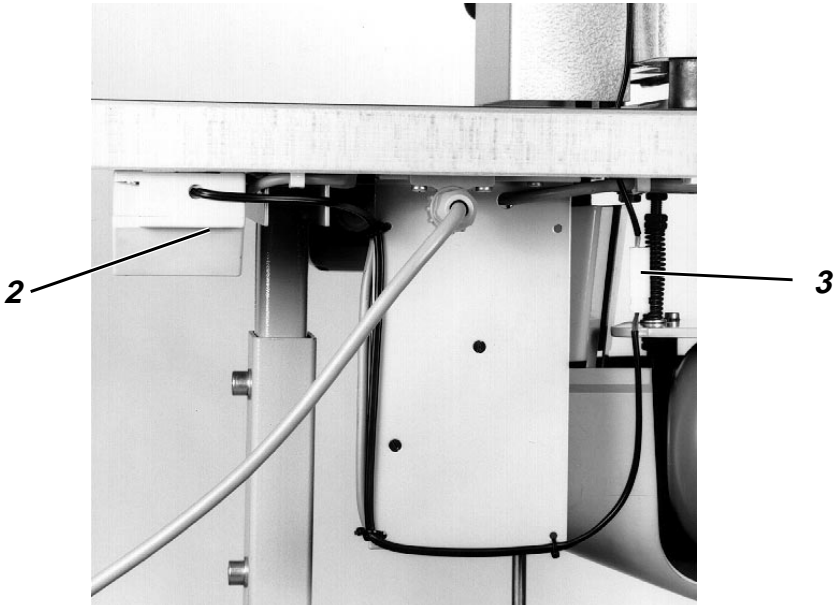
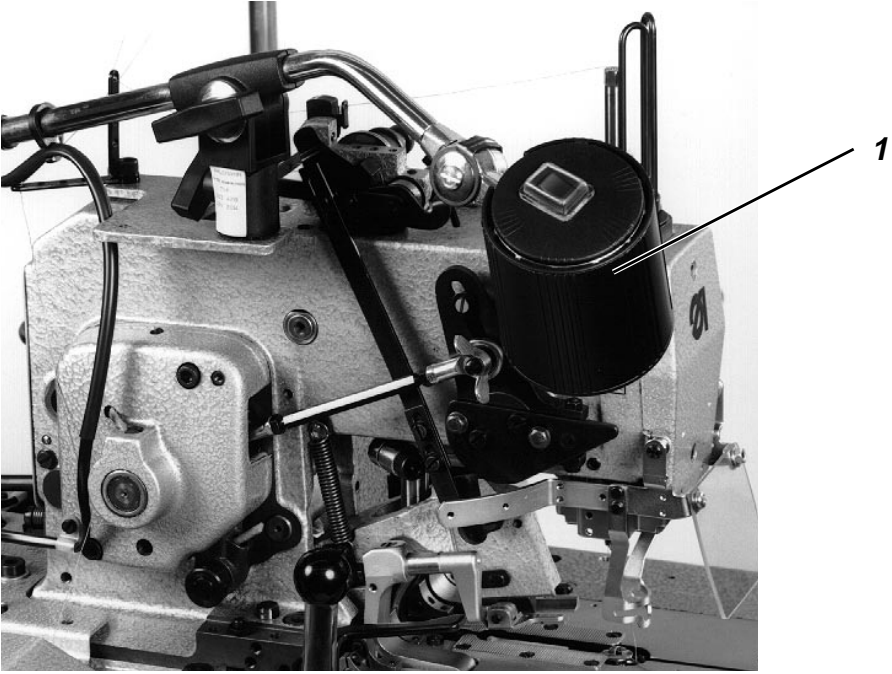


#### Setting V-belt tension left:

- Loosen screw 2.
- Turn the nuts 4 back so far that they do not lie onto the motor support plate. The motor's own weight sets the correct tension for the left V-belt (at the right in the picture).
- Tighten screw 2 again.

#### Setting V-belt tension right:

- Turn the nuts 4 back so far that they do not lie onto the motor support plate. The weight of the motor is now held by the V-belt.
- Set the pressure spring 3 with the nuts 1 so that there is a clearance of 58 mm between the nuts and the plate.
- Screw the nuts 4 until they touch and then tighten one more turn. This raises the support plate and slightly relieves the V-belt.





## 4. Installation of a Sewing Light

The sewing light is available as optional equipment.

<b>Order no.:</b>	<b>Article:</b>
App. 1062	Halogen sewing light
App. 1541	Attachment kit
798 500088	Sewing light transformer



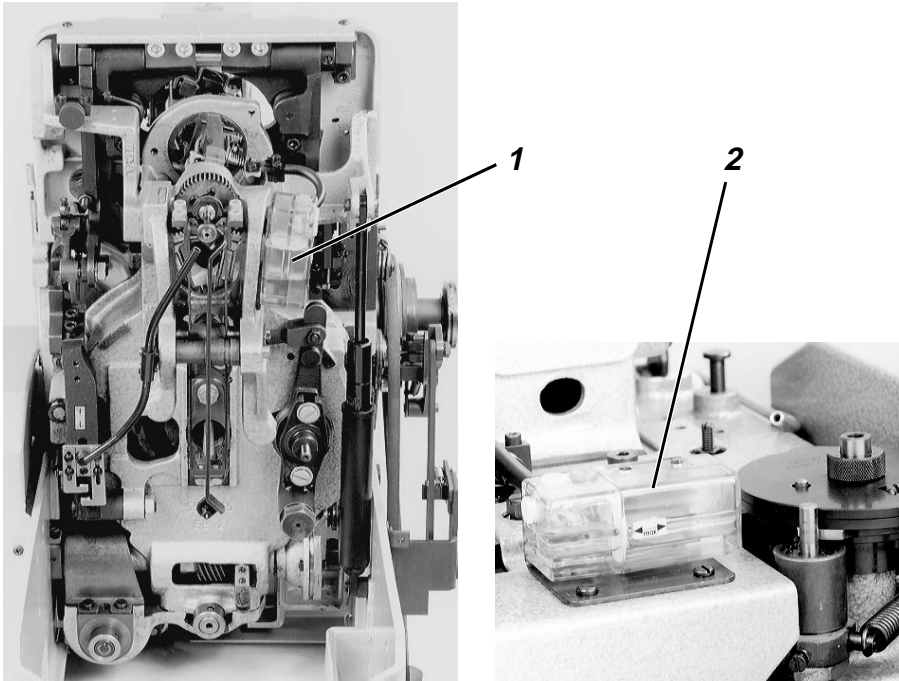
### **ATTENTION !**

Pull the mains plug !  
The electrical connection may only be made by electricians  
or appropriately instructed personnel.

- Attach the sewing light 1 as shown in the picture alongside.
- Lay the sewing light wiring on the housing and guide through the table top opening.
- Attach the sewing light transformer 2 under the table top.
- Fasten the wiring lead to the sewing light. Connect the socket 3 and plug.
- Lay the 220 V wiring lead (2 strand) between the switch and the sewing light transformer (see hook-up diagram).



## 5. Filling the Oil Reservoir



### ATTENTION !

Before commissioning the machine the oil reservoirs 1 and 2 must be filled to the " max. " marking.

The lubrication of the buttonhole machine occur out of 2 reservoirs via an oil wick system.

Additionally, the marked areas on the material carrier plate and the guide curve housing must be oiled (see Operating Instructions 558).

As lubricating oil **ESSO SP-NK 10** or an equivalent oil is to be used.

The lubricating oil is available at **DÜRKOPP-ADLER AG** business offices.

For the first filling there is an oil pillow in the accessories pack. The filling to be conducted with the enclosed oil can.