



1200-7

Operating Instructions

IMPORTANT
READ CAREFULLY BEFORE USE KEEP
FOR FUTURE REFERENCE

All rights reserved.

Property of Dürkopp Adler GmbH and protected by copyright. Any reuse of these contents, including extracts, is prohibited without the prior written approval of Dürkopp Adler GmbH.

Copyright © Dürkopp Adler GmbH 2024


1	About these instructions.....	5
1.1	For whom are these instructions intended?	5
1.2	Representation conventions – symbols and characters	6
1.3	Other documents	7
1.4	Liability	8
2	Safety	9
2.1	Basic safety instructions	9
2.2	Signal words and symbols used in warnings	10
3	Machine description	13
3.1	Components of the machine	13
3.2	Proper use	13
3.3	Declaration of Conformity	14
4	Operation.....	15
4.1	Preparing the machine for operation.....	15
4.2	Switching on and off the machine	15
4.3	Operating the machine head.....	16
4.4	Using threading diagram.....	16
4.5	Disassembling and assembling the fabric sliding plate.....	17
4.6	Adjusting the differential feed.....	19
4.7	Operating the fusing station	20
4.7.1	Inserting/changing the tape	20
4.7.2	Switching on the fusing station	22
4.7.3	Set temperature	22
4.7.4	Fusing knee lining and front trousers.....	23
4.7.5	Adjusting the tape feed	25
4.7.6	Cleaning the stamp	26
4.8	Contour guide	27
4.8.1	Adjusting the contour guide	27
4.8.2	Adjusting the help roller	28
4.8.3	Operating the contour guide	29
4.9	Light barrier.....	31
4.9.1	Aligning the light barrier	31
4.9.2	Adjusting the light barrier intensity	32
4.10	Stacker.....	33
4.10.1	Operating the flip stacker	33
4.10.2	Operating the clamping stacker	35
4.11	Air nozzles in the tabletop.....	36
4.11.1	Adjusting the air nozzles in the tabletop	36
4.11.2	Adjusting the air supply	37
4.11.3	Adjusting the air supply intensity.....	38
4.11.4	Pneumatic swing out device with stamp	39
4.12	Swiveling sword device.....	41
4.13	Sewing	42
4.14	Foot pedal (optional).....	43
5	Programming Commander Pro.....	45
5.1	Commander Pro control panel.....	45
5.1.1	Starting up the screen.....	45
5.2	LED light strip.....	45

5.3	Navigating the Commander Pro control panel	46
5.3.1	Symbols and tiles	48
5.4	Locking the screen	51
5.5	Calling up threading mode	52
5.5.1	Threading diagram	53
5.6	Entering numerical values	55
5.7	Changing program or sequence names	56
5.8	Navigation menu	57
5.9	Settings	57
5.9.1	User Configuration	58
5.9.2	Setting the language	59
5.9.3	Adjusting the brightness	60
5.9.4	Adjusting the audio volume	60
5.9.5	Information	61
5.9.6	Machine Configuration	63
5.9.7	Service	66
5.9.8	Global Parameters	70
5.9.9	Software update	76
5.9.10	Manual data transfer	76
5.9.11	Searching settings	79
5.10	Tutorials	79
5.11	Login/Logout	81
5.12	Software operating modes	82
5.12.1	Buttons in the operating modes	82
5.13	Piece counter	83
5.14	Program parameters	84
5.14.1	User interface Program parameters	85
5.14.2	Current Sequence/Current Program	86
5.14.3	Program templates	87
5.14.4	Copying program parameters	92
5.14.5	Search	94
5.14.6	Resetting program parameters	95
5.14.7	Program parameter search	95
5.14.8	Adjusting the program parameters	96
5.14.9	Additional setting options for program parameters	101
5.14.10	Setting options for differential bottom feed	103
5.14.11	Setting options for stop in seam	105
5.15	Sequence programming	107
5.15.1	Sequence programming user interface	107
5.15.2	Programs in the sequence	109
5.15.3	Adding programs to a sequence	109
5.15.4	Removing a program from the sequence	111
5.15.5	Program position	112
5.15.6	Sequence search	113
5.15.7	Copying sequences	113
5.16	Quick access panel	114
5.16.1	Configuration of the quick access icons	114
5.17	Using manual data transfer	116
5.17.1	Exporting data	117
5.17.2	Importing data	121
5.18	Software update for the control panel	125
5.19	Software update for the control	127

5.19.1	Checking the version	128
5.19.2	Switching off the control.....	128
5.19.3	Performing a software update.....	129
6	Maintenance	131
6.1	Cleaning.....	132
6.2	Lubricating	133
6.2.1	Checking the lubrication of the machine head	134
6.3	Servicing the pneumatic system	135
6.3.1	Adjusting the operating pressure	135
6.3.2	Draining the water condensation	136
6.3.3	Cleaning the filter element	137
6.4	Parts list	138
7	Setup	139
7.1	Checking the scope of delivery	139
7.2	Removing the transport locks	139
7.3	Adjusting the working height.....	140
7.4	Assembling the reel stand.....	142
7.5	Assembling the flip stacker	143
7.6	Assembling the delivery table	144
7.7	Assembling the tray extension	145
7.8	Electrical connection	146
7.9	Pneumatic connection.....	147
7.9.1	Assembling the compressed air maintenance unit	147
7.9.2	Adjusting the operating pressure	147
7.10	Performing a test run	148
8	Decommissioning	149
9	Disposal.....	151
10	Troubleshooting.....	153
10.1	Customer Service	153
10.2	Messages of the software	153
10.3	Errors in sewing process.....	157
11	Technical data	159
11.1	Data and characteristic values.....	159
11.2	Requirements for fault-free operation	160
11.3	Recommended threads.....	161

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. 153).


Consider the instructions as part of the product and store them in a place where they are readily available.

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. 15) is important for the operators.
- Specialists:
This group has the appropriate technical training for performing maintenance or repairing malfunctions. Specifically, the chapter **Setup** ( p. 139) 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 are 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 setting.



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
- ... The steps must always be followed in the specified order.
- Lists are marked by bullet points.



Result of performing an operation

Change on 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 a setting.

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. Be sure to follow the information in the safety instructions. 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.

The instructions should 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	<p>Follow the country-specific safety and accident prevention regulations and the legal regulations concerning industrial safety and the protection of the environment.</p> <p>All the warnings and safety signs on the machine must always be in legible condition. Do not remove!</p> <p>Missing or damaged warnings and safety signs must be replaced immediately.</p>
Requirements to be met by the personnel	<p>Only qualified specialists may be used for:</p> <ul style="list-style-type: none"> • Setting up the machine/putting the machine into operation • Performing maintenance work and repairs • Performing work on electrical equipment <p>Only authorized persons may work on the machine and must first have understood these instructions.</p>

- 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.

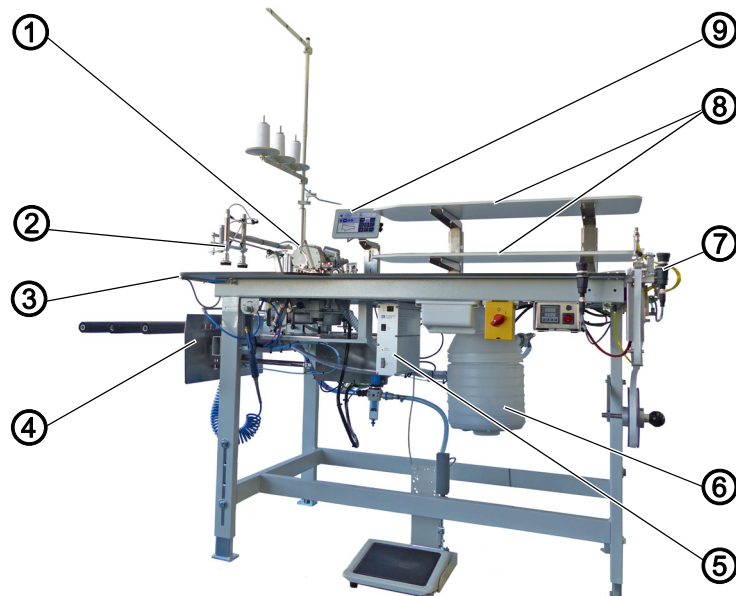
Measures for avoiding the danger.

- ↪ 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



- | | |
|---|---|
| (1) - Machine head | (5) - Control |
| (2) - Pneumatic stamp, swiveling | (6) - Dirt suction container |
| (3) - Pneumatic sword device, swiveling | (7) - Fusing station |
| (4) - Clamping stacker with tray, dual
(standard), triple (optional) | (8) - Sewing material tray, single
(standard), dual (optional) |
| | (9) - Touch control panel |

3.2 Proper 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.

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

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

The needle thicknesses permissible for the machine are listed in the **Technical data** (📖 p. 159) chapter.

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.

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.



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.

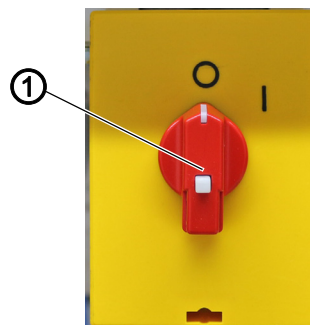
If possible, make preparations only when the machine is switched off.

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

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

4.2 Switching on and off the machine

Fig. 2: Switching on and off the machine



(1) - Main switch



To switch the machine on and off:

1. Turn the main switch (1) to the **I** position.
 - ↳ The machine starts up.
The control and the control panel of the machine start up.
 - ↳ The machine performs a reference run and is afterwards ready for sewing.
2. Turn the main switch (1) to the **O** position.
 - ↳ The machine switches off.

4.3 Operating the machine head

WARNING



Risk of injury from sharp and moving parts!

Puncture or crushing possible.

If possible, operate the machine head only when the machine is switched off.



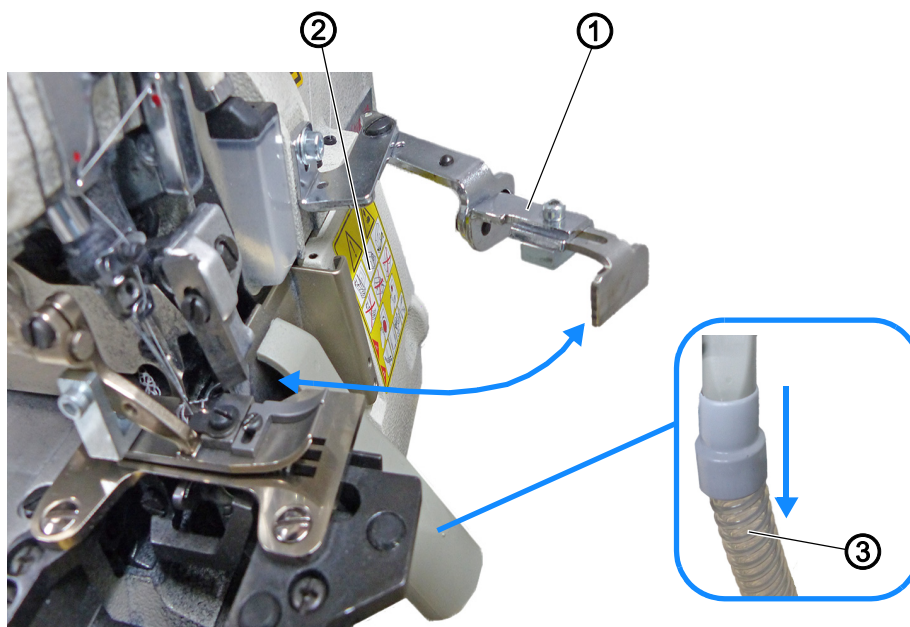
Information

The operation of the machine head (needle insertion or change, threading of needle thread and hook thread etc.) is described in the separately included Pegasus Operating Instructions.

The Pegasus Operating Instructions are included in the accessories of the machine.

4.4 Using threading diagram

Fig. 3: Using threading diagram



(1) - Edge guide
(2) - Cover

(3) - Suction hose



To use the threading diagram:

1. Remove fabric sliding plate (📖 p. 17).
2. Pull the suction hose (3) down.

3. Swing out edge guide (1).
4. Slide the cover (2) outwards.
- ↵ Cover (2) opens downwards.
5. Threading diagram for the machine head is visible on the inside of the cover.

**Information**

The threading diagram can be accessed via the control panel (📖 p. 52)

4.5 Disassembling and assembling the fabric sliding plate

WARNING

Risk of injury from sharp and moving parts!

Puncture or crushing possible.

Do not put the machine back into operation until
AFTER the fabric sliding plate has been assembled.

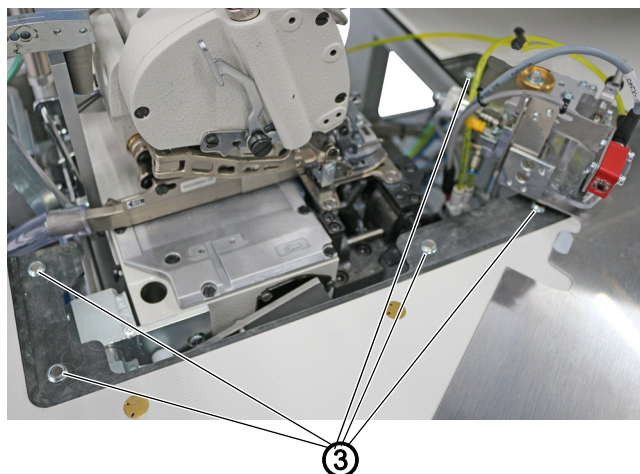
Fig. 4: Disassembling and assembling the fabric sliding plate (1)



(1) - Fabric sliding plate

(2) - Contour guide

Fig. 5: Disassembling and assembling the fabric sliding plate (2)



(3) - Magnets

The fabric sliding plate (1) is held in place in the tabletop cut-out by the magnets (3).

The contour guide (2) is attached to the fabric sliding plate.

Disassembling the fabric sliding plate



To disassemble the fabric sliding plate:

1. Carefully pull the contour guide (2) up and off the magnets (3).
2. Swivel the fabric sliding plate (1) aside.

✎ The bottom section of the machine head is now accessible.

Assembling the fabric sliding plate

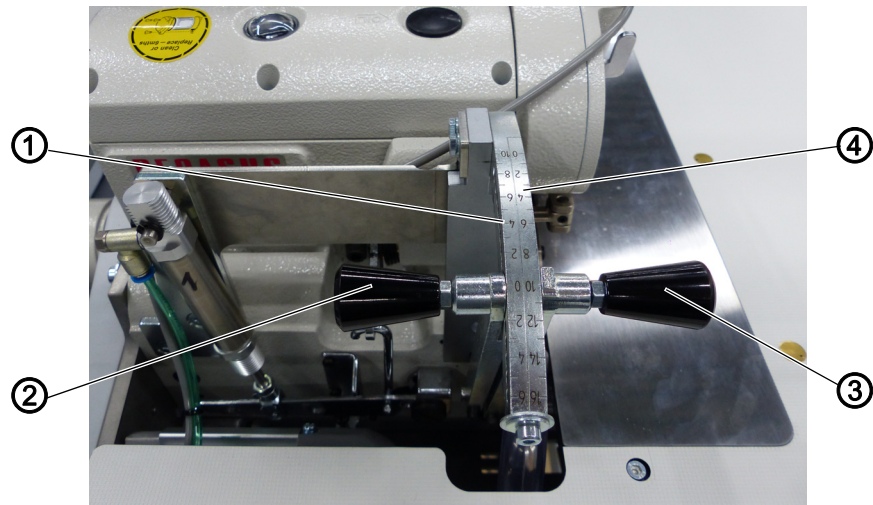


To assemble the fabric sliding plate:

1. Insert the fabric sliding plate (1) into the tabletop cut-out.
- ✎ Make sure it is engaged by the magnets (3).

4.6 Adjusting the differential feed

Fig. 6: Adjusting the differential feed



- | | |
|---|---|
| (1) - Scale for the main feed | (3) - Lever for adjusting the differential feed |
| (2) - Lever for adjusting the main feed | (4) - Scale for the differential feed |

Adjusting the main feed

The main feed is active throughout the entire seam. The adjustment range on the scale for the main feed (1) extends from -10 to +6.



To adjust the main feed:

1. Pull and adjust the level for adjusting the main feed (2).
 - **Default:** the value is set to 0.
For a smooth result during bottom feed.
 - **Increased fullness:** Pull the lever for adjusting the main feed (2) and move it further into the plus range of the scale for the main feed (1).
 - **Less to no fullness:** Move the lever for adjusting the main feed (2) further into the minus range of the scale for the main feed (1).

Adjusting the differential feed

The differential feed can be switched on using the control in the program and is only active for the selected seam sections. The seam can be divided in up to 5 sections. The differential feed for inserting fullness can be set separately for each section. The adjustment range on the scale for the differential feed (4) extends from 0 to +16.



To adjust the differential feed:

1. Pull and adjust the lever for adjusting the differential feed (3).
 - **Increased fullness:** Move the lever for adjusting the differential feed (3) further into the plus range.
 - **Less to no fullness:** Move the lever for adjusting the differential feed (3) further into the zero range of the scale for the differential feed (4).



Important

When processing knee lining, always make sure the lining is at the bottom!

4.7 Operating the fusing station

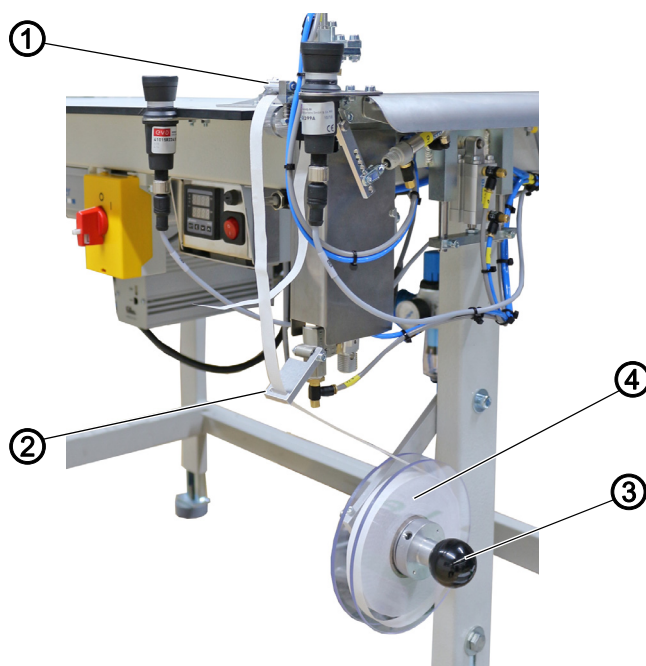


Information

The exact operation of the fusing station is available in the separately enclosed A-senco TR-81 Universal Temperature Controller operating Instructions described. The A-senco TR-81 Universal Temperature Controller operating Instructions are included in the accessories of the machine.

4.7.1 Inserting/changing the tape

Fig. 7: Inserting/changing the tape (1)



- (1) - Flap
- (2) - Guide

- (3) - Handle of the tape holder
- (4) - Tape with backing material

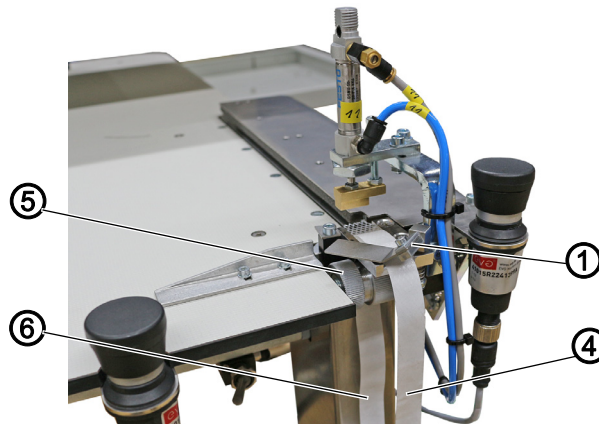


To insert the tape:

1. Forcefully pull on the handle of the tape holder (3) and pull off the support plate on the right.

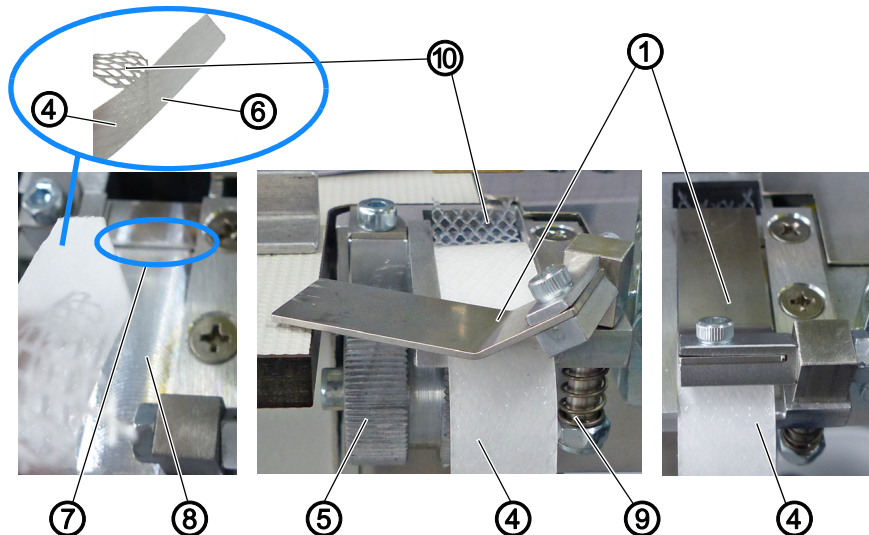
2. Insert a new roll of tape with backing material (4).
 - Make sure the entire roll turns counterclockwise when being unwound.
 - Make sure that the transparent adhesive side of the tape with backing material (4) is forward displays.
3. Slide the right support plate back onto the shaft and snap it.
4. Feed the tape with backing material (4) through the guide (2).

Fig. 8: Inserting/ changing the tape (2)



- | | |
|----------------------------------|------------------------|
| (1) - Flap | (5) - Transport roller |
| (4) - Tape with backing material | (6) - Backing material |

Fig. 9: Inserting/changing the tape (3)



- | | |
|----------------------------------|-------------------------|
| (1) - Flap | (7) - Slot |
| (4) - Tape with backing material | (8) - Groove |
| (5) - Transport roller | (9) - Spring |
| (6) - Backing material | (10) - Transparent tape |



5. Turn the flap (1) up and to the side by pressing the spring (9).
6. Separate tape with backing material (4) from the backing material (6).
7. Bend the backing material (6) slightly and insert it into the slot (7).
8. Insert tape with backing material (4) into the groove (8).

9. Manually rotate the transport roller (5) and thus guide the backing material (6) downwards and behind the transport roller (5).
10. Check the position of the tape with backing material (4) in the groove (8) and lower the flap (1) over it.

4.7.2 Switching on the fusing station

Fig. 10: Switching on the fusing station



(1) - Main switch

(2) - Toggle switch



To switch the fusing station on and off:

1. Turn the main switch (1) to the I position.
↳ The machine switches on.
2. Turn the toggle switch (2) to the I position.
↳ The toggle switch illuminates.

4.7.3 Set temperature



Important

The upper value:

PV = Actual value and display
Displays the current calorific value.


The lower value:

SV = Setpoint and status display
Displays the preset calorific value alternating with *Low Alarm*.



To set the temperature:

1. Switching on the fusing station (📖 p. 22).
↳ The temperature controller displays the current temperature.
2. Press the *SET* button until *Su* appears on the display.
3. Press the button .
↳ The actual value display changes its value downwards.
↳ The longer the button is pressed, the faster the value is changed.

4. Press the button .
- ↪ The actual value display changes its value upwards.
- ↪ The longer the button is pressed, the faster the value is changed.

4.7.4 Fusing knee lining and front trousers

WARNING

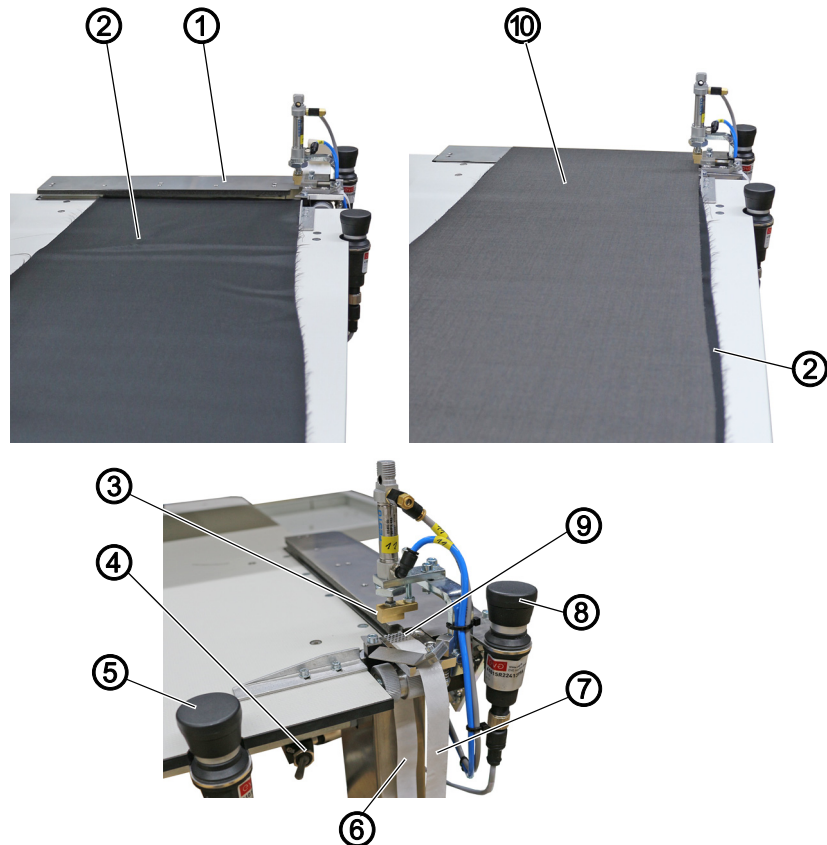


Risk of injury from hot fusing stamp!

Risk of burns.

Do not touch the area around the fusing station as the lower stamp is very hot.

Fig. 11: Fusing knee lining and front trousers



- | | |
|---|--|
| (1) - Knee lining clamping device | (6) - Backing material |
| (2) - Knee lining | (7) - Tape with backing material |
| (3) - Upper stamp | (8) - Button for triggering the fusing process |
| (4) - Toggle switch | (9) - Transparent Tape |
| (5) - Button for lowering the knee lining clamping device | (10) - Front trousers |



Important

To keep the knee lining from shifting during sewing, you need to set a fusing point with the fusing station that will keep the lining in place at the correct position. Only after this point has been set will you be able to sew the knee lining from the hem to the waistband edge.



To fuse the knee lining and the front trousers:

1. Position the knee lining (2) under the knee lining clamping device (1).
2. Press the button for lowering the knee lining clamping device (5).
 - ↳ The knee lining clamping device (1) is lowered and clamps the knee lining (2) at the edge of the hem.
At the same time, the tape with the backing material (7) is advanced, separating the transparent tape (9) from the backing material (6).
3. Position the front trousers (10) and align it with the knee lining (2).
 - ↳ When positioning the knee lining (2), make sure it protrudes in accordance with the desired fullness.
4. Press the button for triggering the fusing process (8).
 - ↳ The upper stamp (3) moves down while the lower heated stamp moves up. The stamps press the front trousers (10) and the knee lining (2) together with the transparent tape (9) positioned in between and fix the tape in place.

Following the preset fusing time, the upper stamp (3) and the knee lining clamping device (1) are raised automatically, while the lower stamp is lowered.

Knee lining (2) and front trousers (10) have been fused and can be positioned for serging.



Information

The toggle switch (4) allows 2 different positions for the lower, heated stamp.

1. **Toggle switch (4) placed to the left:**
The lower, heated stamp is at the bottom and comes up for the bonding process.
2. **Toggle switch (4) placed to the right:**
The lower, heated stamp moves upwards and remains at the top during the entire work process.

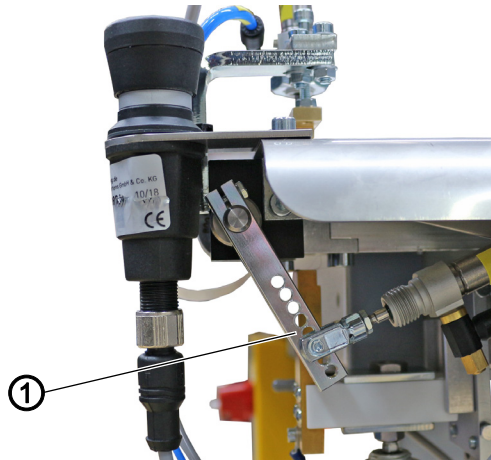


Important

In position 2 (toggle switch (4) placed to the right), the knee lining can be damaged or melted by too high a temperature.

4.7.5 Adjusting the tape feed

Fig. 12: Adjusting the tape feed



(1) - Lever

You can use the lever (1) to adjust the amount of tape that will be advanced.



To adjust the tape feed:

1. Use the lever (1) to select the desired hole:
 - **more tape:** select higher hole
 - **less tape:** select lower hole

4.7.6 Cleaning the stamp

WARNING

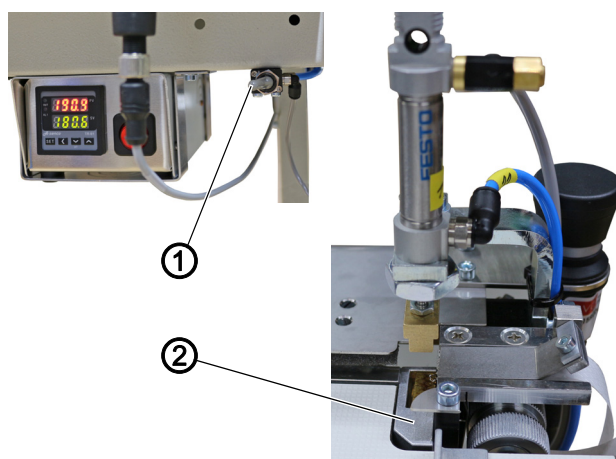


Risk of injury from hot fusing stamp!

Risk of burns.

Allow the stamp to cool down before cleaning it.

Fig. 13: Cleaning the stamp



(1) - Toggle switch

(2) - lower stamp



To clean the stamp:

1. Flip the toggle switch (1).

↪ The lower stamp (2) moves up and will remain in the up position for the duration of the work process.



Important

In this position the knee lining may sustain damage or melt if the temperature is too high.



2. Clean the stamp.

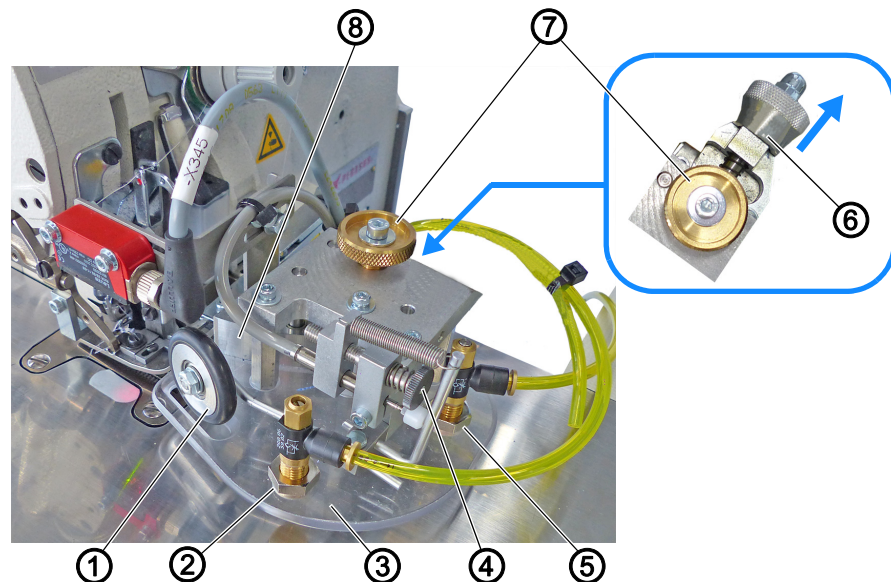
3. Flip the toggle switch (1).

↪ The lower stamp (2) moves down.

4.8 Contour guide

4.8.1 Adjusting the contour guide

Fig. 14: Adjusting the contour guide



- | | |
|--|--|
| (1) - Help roller | (6) - Adjusting wheel for adjusting the height of the contour guide |
| (2) - Blow-on air nozzle | (7) - Adjusting wheel for the fine adjustment of the material height |
| (3) - Contour guide | (8) - Edge guide in the contour guide |
| (4) - Adjusting wheel for the help roller pressure | |
| (5) - Blow-out air nozzle | |

The height-adjustable contour guide (3) ensures that the sewing material is positioned and guided evenly in front of the sewing head. The height of the contour guide (3) can be adjusted with the adjusting wheel for adjusting the height of the contour guide (6) to match the thickness of the sewing material.

The help roller (1) ensures that the sewing material is precisely fed up to the edge guide (8) in the contour guide (3). At the same time, the material is guided towards the edge guide (8) by the blow-on air nozzle (2).

The fly blow-out nozzle (5) is used when the inseam is sewn from the hem. Blowing out prevents folding over and unintentional sewing of material in the fly/seat seam.



Information

You can use the program parameters on the control panel (📖 p. 96) to program the air nozzle (5) for blowing out the fly/seat seam (7.1).

Adjusting the height of the contour guide



To adjust the height of the contour guide:

1. Pull the adjusting wheel for adjusting the height of the contour guide (6) in the direction of the arrow.
2. Turn the adjusting wheel for adjusting the height of the contour guide (6) to one of the 4 catch positions.
 - **Position 1:** lowest height
 - **Position 4:** greatest possible height

Adjusting the fine adjustment of the contour guide

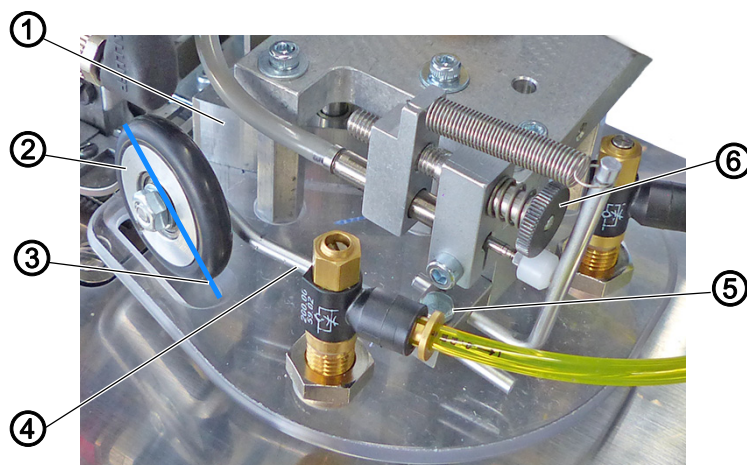


To adjust the fine adjustment of the contour guide:

1. Turn the adjusting wheel for the fine adjustment of the material height (7).
 - **Material height low:** turn clockwise.
 - **Material height high:** turn counterclockwise.

4.8.2 Adjusting the help roller

Fig. 15: Adjusting the help roller



- | | |
|---------------------------------------|--|
| (1) - Edge guide in the contour guide | (4) - Help roller rod |
| (2) - Help roller | (5) - Screw |
| (3) - Tilt direction | (6) - Adjusting wheel for the help roller pressure |

Adjusting the pressure of the help roller



To adjust the pressure of the help roller:

1. Turn the adjusting wheel for the help roller pressure (6).
 - **Greater help roller pressure (2):** turn clockwise.
 - **Lower help roller pressure (2):** turn counterclockwise.

Adjusting the inclination of the help roller



Proper setting

The help roller (2) should be slightly tilted towards the edge guide (1) in the contour guide. This helps the transport of the sewing material.



To adjust the inclination of the help roller:

1. Loosen screw (5).
2. Slightly turn the help roller rod (4) to position it in the tilt direction (3).
3. Tighten the screw (5).



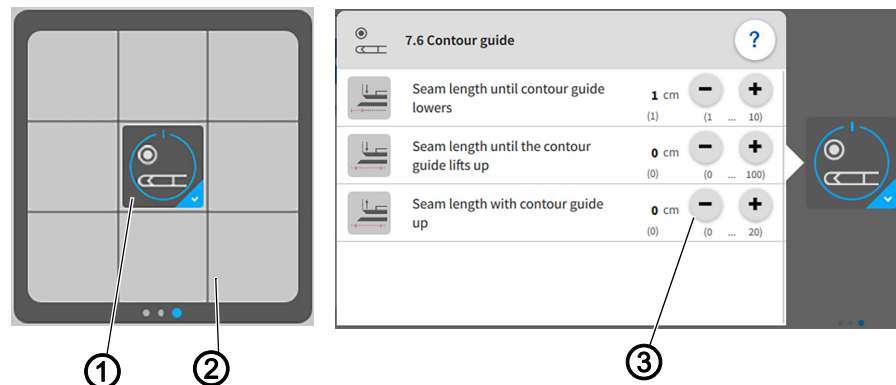
Information

The help roller should be activated approx. 15 cm before the seam end to keep the fabric edge from running out at the seam end.

You can use the program parameters on the control panel (📖 p. 96) to program the help roller (7.5).

4.8.3 Operating the contour guide

Fig. 16: Operating the contour guide







- (1) - Button Parameters Contour Guide (3) - Setting parameters
 (2) - Quick Access Icons

In case of material/seam thickness, the contour guide can be raised within the seam section to prevent material blockage at thicker points, e.g. in the area of pocket openings. This happens when the front trouser pockets have been worked into the front trousers before the knee lining was sewn in and the lining is sewn on afterwards. In that case, the pocket bag will later be positioned between lining and front trousers.

You can open and change the setting parameters (3) easily using the quick access icons (2) on the control panel found on the main page.




To operate the contour guide:

1. Briefly press the button Parameters Contour Guide (1) once.
 The contour guide switches ON/OFF.
2. Perform a long press on the button Parameters Contour Guide (1).
 The window for the setting parameters (3) opens.
3. You can change the setting parameters to your requirements.
 The new values are adopted automatically.
4. Press briefly outside of the setting parameters (3).
 The display returns to the main screen.



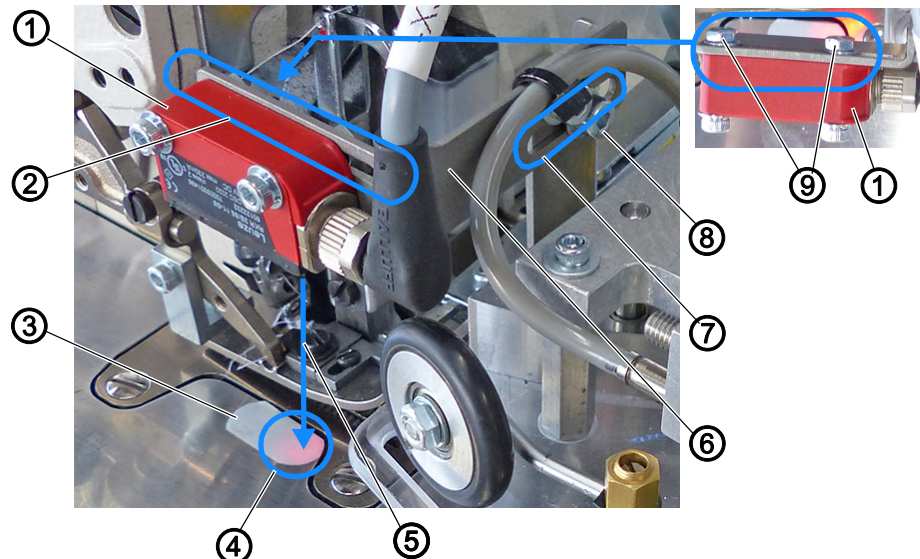
Information

You can use the program parameters on the control panel ( p. 96) to program the contour guide (7.6).

4.9 Light barrier

4.9.1 Aligning the light barrier

Fig. 17: Aligning the light barrier



- | | |
|-------------------------------------|--------------------|
| (1) - Light barrier | (6) - Holder |
| (2) - Slotted hole | (7) - Slotted hole |
| (3) - Reflecting foil | (8) - Screw |
| (4) - Concentricity from the circle | (9) - Screws |
| (5) - Light beam | |



Proper setting

The light beam (5) must be aligned concentrically from the circle (4) on the reflecting foil (3).

- Automatic sewing start later: move the light barrier (1) in the slotted hole (2) with the sewing direction.
- Automatic sewing start earlier: move light barrier (1) in the slotted hole (2) against the sewing direction.



To align the light barrier:

1. Loosen the screws (9).
2. Move the light barrier in the area of the slotted hole (2) with the sewing direction.
3. Tighten the screws (9).
4. Loosen screw (8).
5. Move the holder (6) with the light barrier (1) in the area of the slotted hole (7).
6. Tighten the screw (8).

4.9.2 Adjusting the light barrier intensity



Important

Adjustments to the light barrier are made with the sewing unit switched on.

WARNING

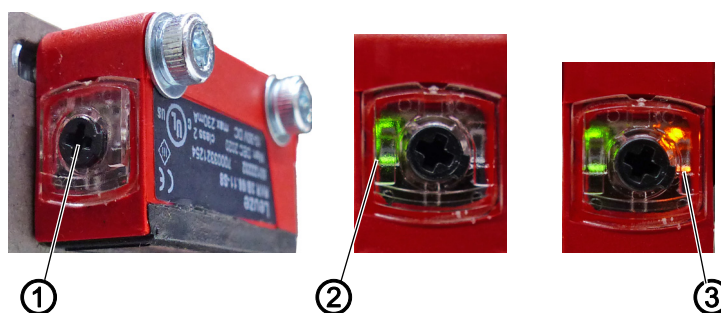


Risk of injury from sharp and moving parts!

Puncture or crushing possible.

Proceed with utmost caution when adjusting the settings and performing the function test.

Fig. 18: Adjusting the light barrier intensity



(1) - Potentiometer
(2) - LED

(3) - LED



Proper setting

The LED (3) on the potentiometer (1) lights up orange permanently.



To adjust the intensity of the light barrier:

1. Turn the potentiometer (1) counterclockwise as far as it will go.
↳ The LED (2) lights up green.
Green = light barrier has power and is active.
2. Turn the potentiometer (1) clockwise until the LED (3) starts flashing.
3. Continue to turn the potentiometer (1) until the LED (3) is lit orange reliably and permanently.
↳ The process is now complete.



Information

If the LED is not lit, you should clean, readjust or replace the light barrier.

4.10 Stacker

WARNING



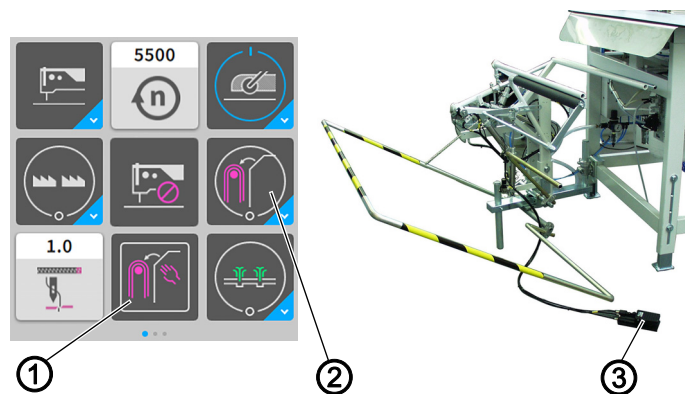
Risk of injury from moving parts!

Crushing possible.

While stacking is in progress, **DO NOT** reach into the working area of the flip/clamping stacker.

4.10.1 Operating the flip stacker

Fig. 19: Operating the flip stacker (1)



(1) - Button Trigger stacking process manually

(2) - Button Parameters for the stacking process

(3) - Pedal for opening the clamping stacker

The finished sewn products are stacked on the flip stacker.

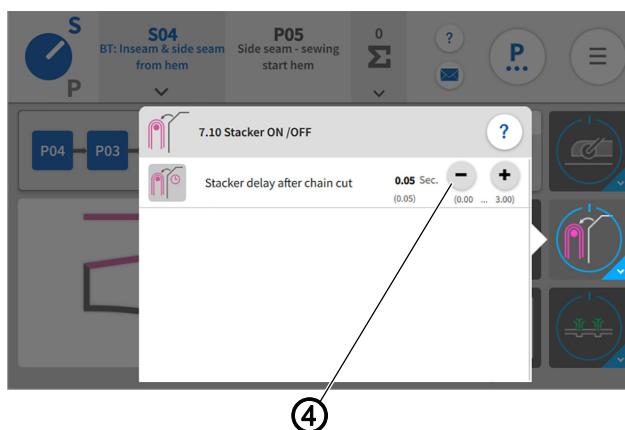
Stacking the sewing material



To stack the sewing material:

1. Press the button Trigger stacking process manually (1).
 ↳ The stacking process is executed once.
2. Briefly press the button Parameters for the stacking process (2) once.
 ↳ The stacker switches ON/OFF.
 ↳ The stacking process is executed/not executed.

Fig. 20: Operating the flip stacker (2)



(4) - Setting parameters



3. Perform a long press on the button Parameters for the stacking process (2).

↳ The window for the setting parameters (4) opens.

4. You can change the setting parameters to your requirements.

↳ The new values are adopted automatically.

Removing stacked pieces



To remove stacked pieces:

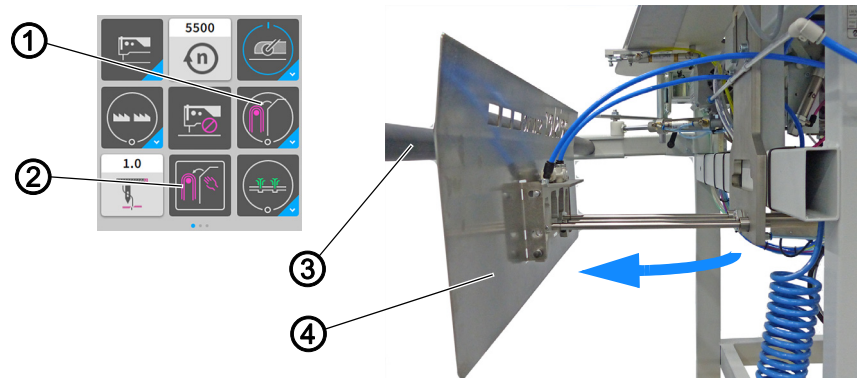
1. Press the pedal for opening the clamping stacker (3) and keep it there.

↳ The flip stacker opens.

2. Remove the stacked pieces.

4.10.2 Operating the clamping stacker

Fig. 21: Operating the clamping stacker (1)



- | | |
|--|------------------------|
| (1) - Button Parameters for the stacking process | (3) - Stacker tray |
| (2) - Button Trigger stacking process manually | (4) - Clamping stacker |

The clamping stacker (4) is used to stack the finished sewn products during the ongoing sewing process. By default, the clamping stacker (4) is equipped with two arms for the stacker tray (3). An additional arm is available as an extension for the stacker tray if the sewing material is large/long (📖 p. 145)

Stacking the sewing material



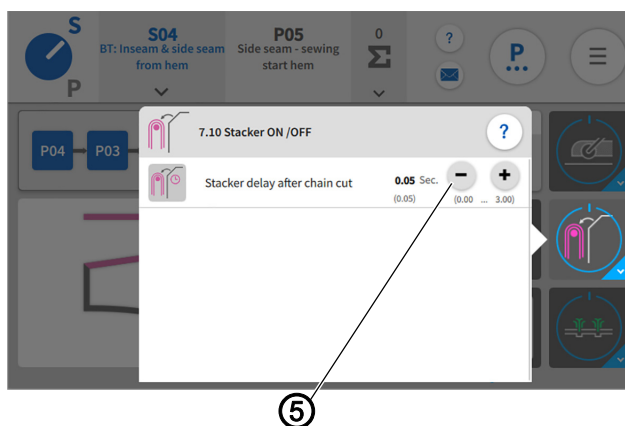
To stack the sewing material:

1. Press the button Trigger stacking process manually (2).
 ↳ The stacking process is executed once.
2. Briefly press the button Parameters for the stacking process (1) once.
 ↳ The stacker switches ON/OFF.
 ↳ The stacking process is executed/not executed.

Stacking process:

- Once the sewing material is fully sewn and has reached the level of the clamping stacker (4), the clamping stacker (4) moves towards the stacker tray (3) (see blue arrow).
- The sewing material is deposited automatically on the stacker tray (3).

Fig. 22: Operating the clamping stacker (2)



(5) - Setting parameters



3. Perform a long press on the button Parameters for the stacking process (1).
- ↳ The window for the setting parameters opens.
4. You can change the setting parameters (5) to your requirements.
- ↳ The new values are adopted automatically
- ↳ You can remove the sewing material directly from the stacker tray.



Information

You can use the program parameters on the control panel (📖 p. 96) to program the stacker (7.10).

4.11 Air nozzles in the tabletop

4.11.1 Adjusting the air nozzles in the tabletop

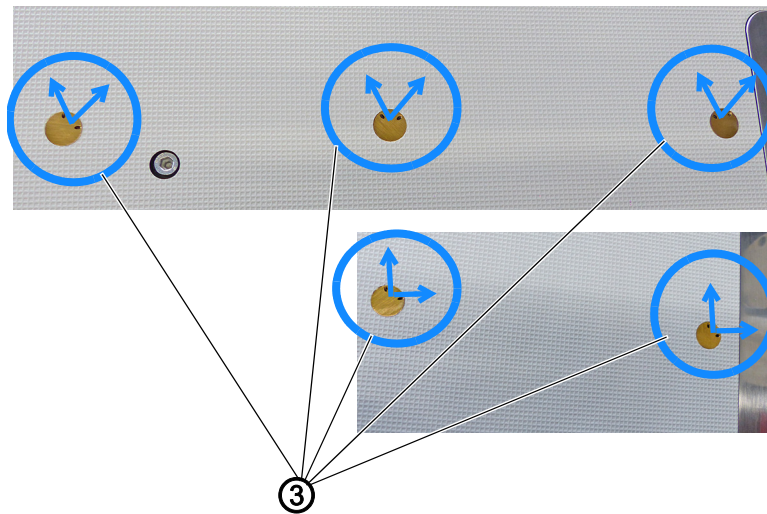
Fig. 23: Adjusting the air nozzles in the tabletop (1)



(1) - Air nozzles facing the stacker

(2) - Air nozzles facing the sewing head

Fig. 24: Adjusting the air nozzles in the tabletop (2)



(3) - Air nozzle orientation

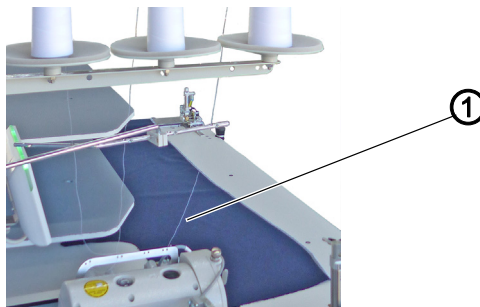

Proper setting

Align the air nozzles facing the stacker (1) in the 11 o'clock and the 1 o'clock position to support transport to the stacker.

Align the air nozzles facing the sewing head (2) in the 12 o'clock and the 3 o'clock position. This supports the feed of material to the sewing head during the sewing process.

4.11.2 Adjusting the air supply

Fig. 25: Adjusting the air supply



(1) - Sewing material


Proper setting

The air supply to the air nozzles must be adjusted to the corresponding thickness of the sewing material.



To adjust the air supply to the air nozzles:

1. Place the sewing material (1) on the sewing table above the air nozzles.
2. Log in as a Default technician (📖 p. 81) on the control panel.

3. Test the air supply using the Input/Output Test (📖 p. 66) menu item.
- 👉 The air should slightly lift the sewing material, allowing you to push the sewing material towards the sewing head/stacker using merely 2 fingers/almost automatically.

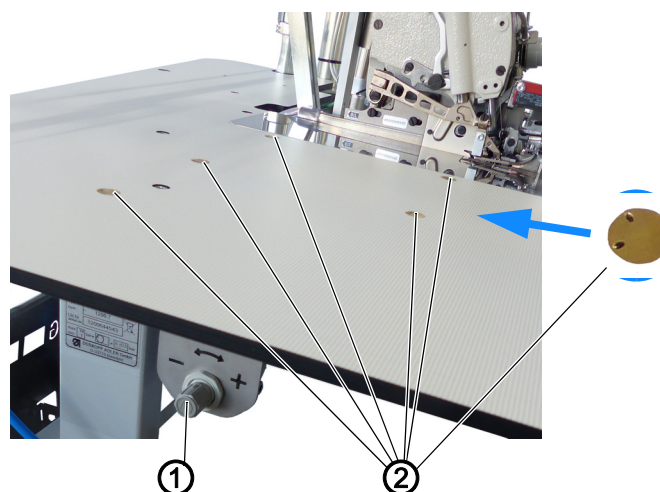


Information

If the sewing material is **not** pushed towards the stacker/sewing head, the air nozzles in the tabletop need to be adjusted (📖 p. 36) accordingly.

4.11.3 Adjusting the air supply intensity

Fig. 26: Adjusting the air supply intensity



(1) - Adjusting wheel

(2) - Air nozzles

The air nozzles (2) in the tabletop help the sewing material to be fed properly during the ongoing sewing process. Lifting and advancing the sewing material towards the stacker reduces the risk of the sewing material becoming caught.



To adjust the air supply intensity:

1. Turn the adjusting wheel (1).
 - **Blowing air more intense:** turn towards +
 - **Blowing air less intense:** turn towards -



Information

You can use the program parameters on the control panel (📖 p. 96) to program the air nozzles (7.4).

4.11.4 Pneumatic swing out device with stamp

WARNING

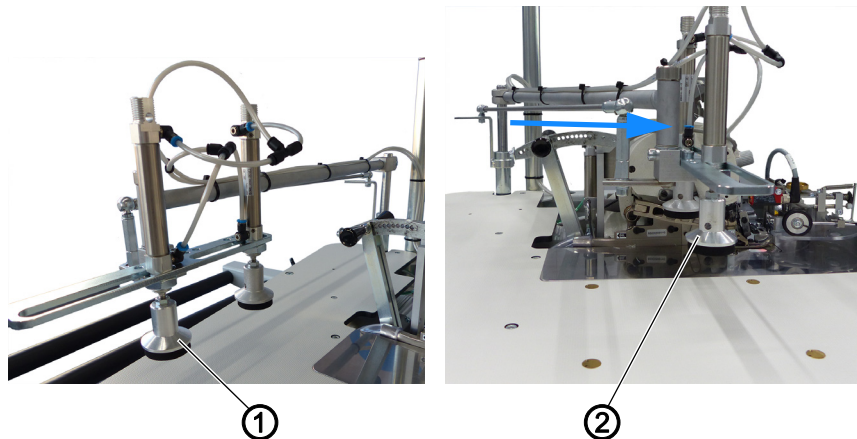


Risk of injury from moving parts!

Crushing possible.

While swiveling is in progress, DO NOT reach into the working area of the stamp.

Fig. 27: Swiveling stamp (1)



(1) - Position left

(2) - Position right

The pneumatic stamp assists the sewing material while it is being swung towards the stacker following the sewing process. The pneumatic stamp works exceptionally well on short sewing material and when sewing starts at the trousers hem.

The pneumatic stamp on the tabletop can swivel.

- The position on the left (1) indicates the initial position of the stamp.
- The blue arrow indicates the swivel direction of the stamp.
- The position on the right (2) indicates the completed swivel movement of the stamp.

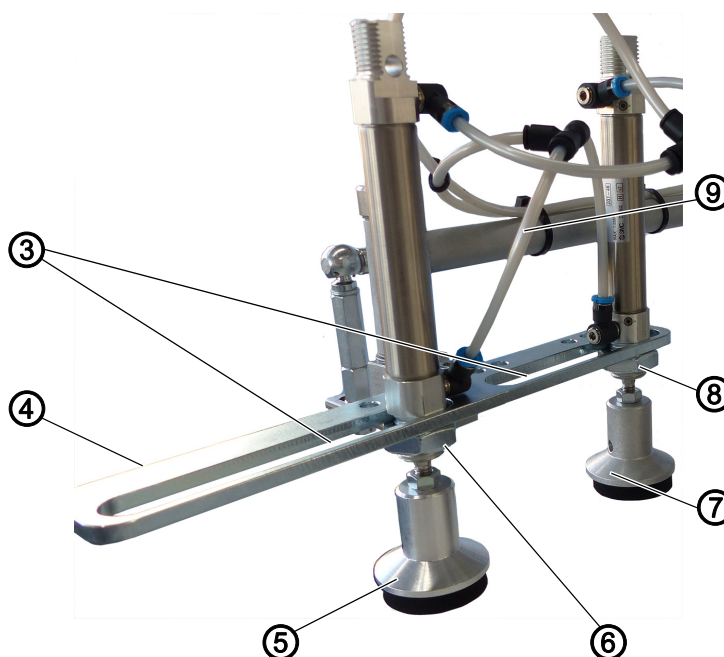
When the sewing process has finished, the stamps lower to position (2) before the sewing material is first swiveled towards the stacker and then stacked.



Information

You can use the program parameters on the control panel (📖 p. 96) to program the pneumatic stacker (7.7, 7.8, 7.8.4).

Fig. 28: Swiveling stamp (2)



- (3) - Slot
- (4) - Holder
- (5) - Stamp

- (6) - Screw
- (7) - Stamp
- (8) - Screw
- (9) - Compressed air line

Stamp positions

The positions of stamps (5) and (7) can be set individually as needed and to match the size of the sewing material.



To adjust the stamp positions:

1. Loosen screw (6) and/or screw (8).
2. Slide stamp (5) and/or stamp (7) to the desired position in their respective slot (3).
3. Tighten screw (6) and/or screw (8).

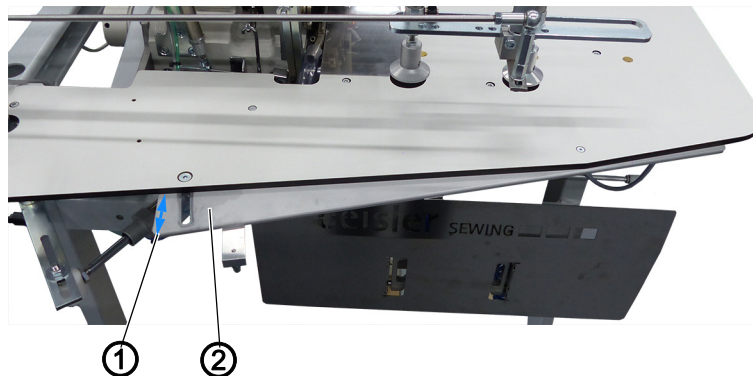


Important

The compressed air line (9) must have enough play to keep it from being torn off during the swiveling process.

4.12 Swiveling sword device

Fig. 29: Swiveling sword device



(1) - Swing out/in

(2) - Sword

The sword (2) can be swung out/in (1) to lightly turn the sewing material during the sewing process. This is recommended for improving control over the hip bow and when sewing starts at the trousers hem.

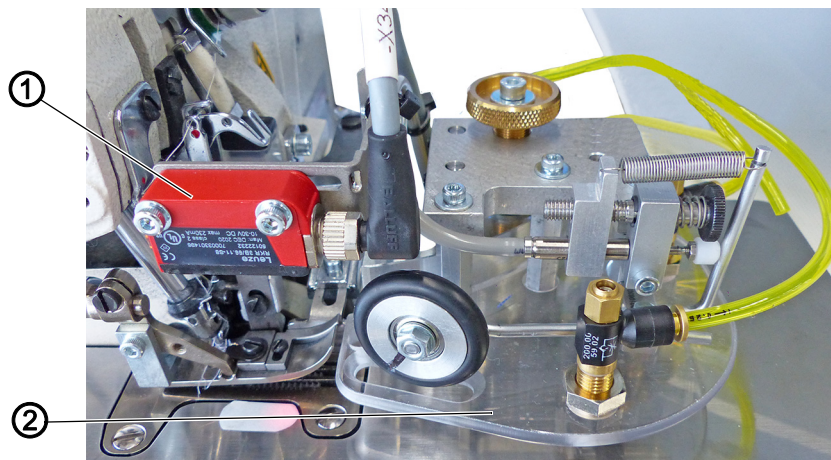


Information

You can use the program parameters on the control panel (📖 p. 96) to program the pneumatic, swiveling sword device (7.9).

4.13 Sewing

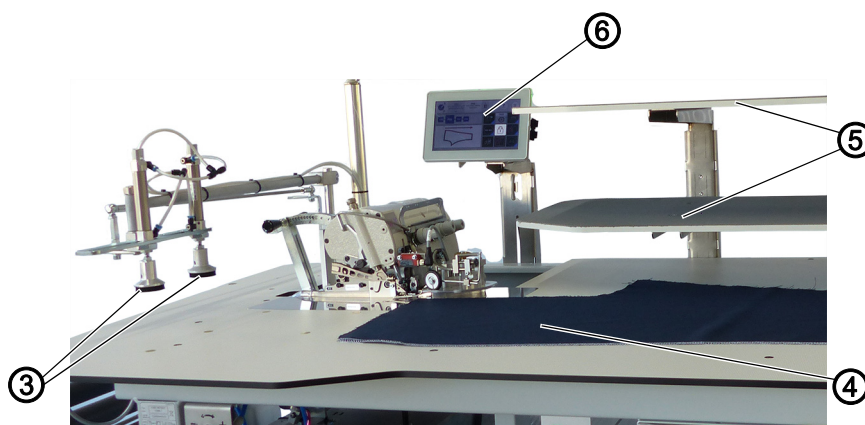
Fig. 30: Sewing (1)



(1) - Light barrier

(2) - Contour guide

Fig. 31: Sewing (2)



(3) - Stamp

(4) - Sewing material

(5) - Delivery table

(6) - Touch display



To sew:

1. Deposit the sewing material (4) on the delivery table (5).
 - Upper tray for trouser parts.
 - Lower tray for knee lining.
2. Use the touch display (6) (📖 p. 46) to call up the desired seam program (📖 p. 84).
3. Place the sewing material (4) on the tabletop.
4. Fuse knee lining and front trousers (📖 p. 23).
5. Reposition the sewing material (4) on the tabletop.
Make sure the sewing material (4) lies straight under the contour guide (2).

**Important**

As soon as the sewing material (4) is pushed under the light barrier (1), the contour guide (2) is lowered. The sewing process may begin automatically depending on the program selection.



6. Push the sewing material (4) under the light barrier (1).

➡ The sewing process starts automatically if you selected start mode 1 (📖 p. 101).

When the sewing process is complete, the stamps (3) lower, and the sewing material (4) is stacked.

**Important**

The light barrier (1) will only be able to reliably detect the sewing material subsequently fed during the ongoing sewing process if the minimum distance to the subsequent sewing material is kept between 1.50 cm - 2.00 cm.

4.14 Foot pedal (optional)

Fig. 32: Foot pedal



(1) - Foot pedal

**Information**

There are various options for the Manual sewing by foot pedal, which is converted into an automatic sewing start.

You can use the program parameters on the control panel (📖 p. 101) to program the start mode (7.2.6).

The foot pedal (optional) is recommended for seams with seam stops, e.g. labels in the seam, or for the manual sewing start. This requires that the start mode be set to Start Mode 2 (7.2.6.2) or 3 (7.2.6.3) (📖 p. 101).

5 Programming Commander Pro

5.1 Commander Pro control panel

Fig. 33: Commander Pro control panel



All settings in the software are performed using the Commander Pro control panel.

5.1.1 Starting up the screen

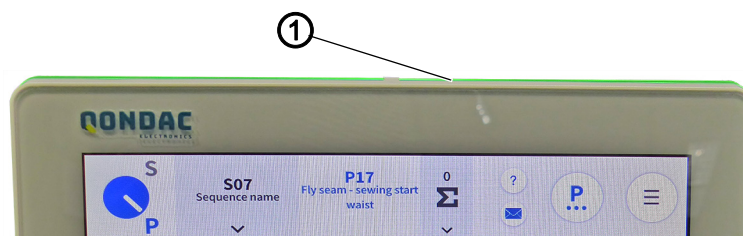


To start up the screen:

1. Turn on the main switch of the machine (📖 p. 15).
- ↳ The machine starts up.
The control initializes.
The start screen is displayed.

5.2 LED light strip

Fig. 34: Control panel LED light strip



(1) - LED light strip

The color of the LED light strip (1) indicates to the user to which mode the machine is currently set. There are 4 colors, all assigned to a specific area.

The meaning of the 4 colors is specified below:

- green = normal status
- blue = information notice
- yellow = warning
- red = error message

5.3 Navigating the Commander Pro control panel

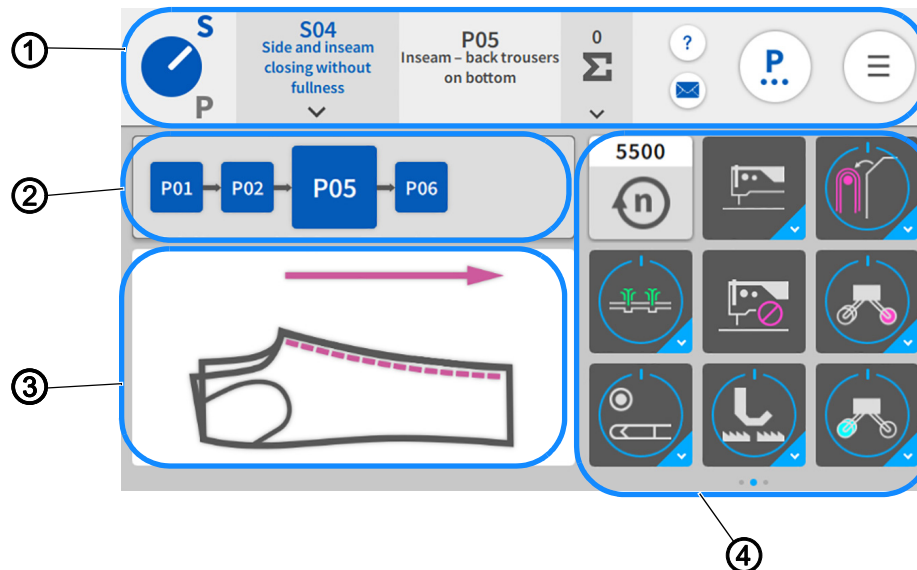
You navigate the control panel by tapping the screen with your fingers. There is no need for an input device.

You can open menus by pressing the corresponding button with your finger. You switch between the different pages of the start screen by swiping with one finger to the right or the left.

In the submenus the user can switch between entries by scrolling. Manual entries to change names or numerical values can be made with a long press or a quick double click. The switch of a program sequence or of the quick access icons is made using the interaction: Drag and drop.

When the control panel has finished starting up, you can immediately access the user interface. The tiles on the control panel can be selected as soon as they have become visible.

Fig. 35: Navigating the Commander Pro control panel (1)



(1) - Status bar
(2) - Sequence bar

(3) - Sewing graphics
(4) - Quick access panel

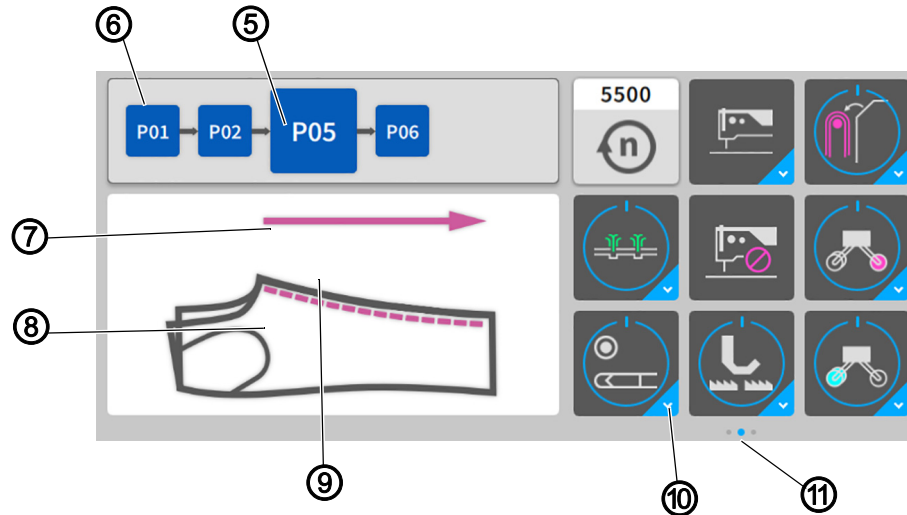


This is what the start screen looks like.

The start screen also functions as the main screen and the main level on which the machine is ready to sew. The screen is divided into 4 areas.

1. Status bar (1) (📖 p. 48)
2. Sequence bar (2)
3. Sewing graphics (3)
4. You can customize the quick access panel (4) per sequence and swipe across its 3 pages from the right to the left.

Fig. 36: Navigating the Commander Pro control panel (2)



(5) - Program sequence
 (6) - Active program
 (7) - Red arrow
 (8) - Sewing material


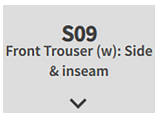
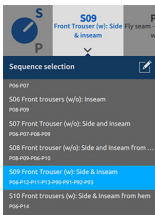










(9) - Red seam
 (10) - Tiles
 (11) - Pages


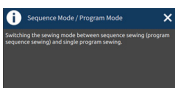



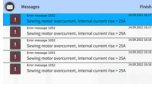













Displayed in the sequence bar (2) is the program sequence (5) of the current sequence. The active program (6) is always highlighted in bold and displayed as a red seam (9) next to the sewing graphics (3) immediately on the sewing material (8). The red seam (9) in the sewing graphics (3) changes along with each program change in the program sequence (5). The red arrow (7) indicates the sewing direction.




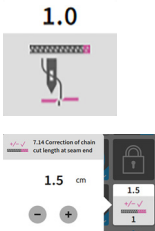






The quick access panel (4) holds the tiles (10) that are used to change the program parameters. They can be customized and grouped across 3 pages (11) and 27 placeholders (📖 p. 114). The blue dot indicates the active page (11).

5.3.1 Symbols and tiles

Explanation of recurring symbols and tiles:

Symbol	Meaning
	<p>S/P toggle</p> <p>S = sequence mode</p> <p>P = program mode</p> <p>The blue letter indicates the active mode.</p> <p>Press the symbol to toggle between the two modes.</p> <p>The white pointer indicates the active mode.</p>
 	<p>Sequence name</p> <p>Display of the number and name of the active sequence.</p> <p>A press of the  symbol takes the user to the sequence selection. The sequence selection allows the user to change between 40 different sequences and enter the sequence programming level with a press of the  symbol ( p. 107).</p>
	<p>Program name</p> <p>Display of the number and name of the current program.</p>
	<p>Piece counter</p> <p>Display in accordance with the counting setting.</p> <p>A press of the  symbol takes the user to the option for adjusting additional settings ( p. 83)</p>
	<p>Context-sensitive help</p> <p>The information  about the desired symbol is displayed.</p> <p>Short press: The help function is highlighted in gray = 1x Help</p> <p>Long press: The help function is highlighted in light blue = use Help several times in a row.</p> <p>To release: Press x1.</p>
	<p>Press on the area for which you need help - this brings up a window containing a Help text.</p> <p>Press X; the window closes.</p> <p>The help function highlighted in gray becomes inactive automatically.</p>

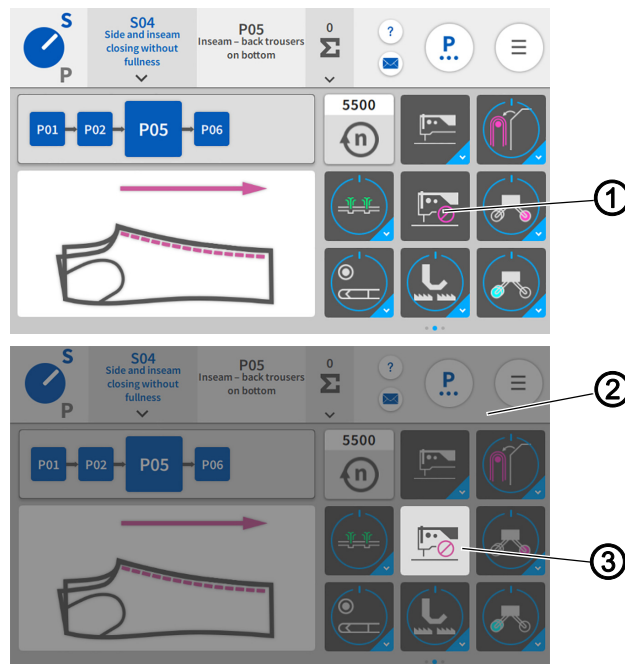
Symbol	Meaning
	<p>Press on the area for which you need help - this brings up a window containing a Help text.</p> <p>Press X; the window closes. The help function highlighted in light blue remains active and allows the user to request help in other areas. Not until the area is pressed again will the light blue help function become inactive.</p>
	<p>Window and Help text</p> <p>Help text is marked for the user by the symbol .</p> <p>Help texts explaining the function are displayed for the individual menu items.</p> <p>The Help window is closed with a press of .</p>
 	<p>Messages</p> <p>The protocol data of the machine is displayed.</p> <p>All messages and error messages along with their respective error code that have occurred until this point will be displayed.</p>
	<p>Navigation menu</p> <p>A press of this button always takes the user to the navigation menu with the following options: Sequence Programming, Program Parameters, Settings, Tutorials, Logout/Change current user ( p. 57).</p>
	<p>Sequence Programming</p> <p>Access via the main screen or the navigation menu ( p. 107).</p>
	<p>Program Parameters</p> <p>The parameter view with different programs and templates is displayed.</p> <p>Access via the main screen, the navigation menu or the program parameters ( p. 85).</p>
	<p>Settings</p> <p>Access via the navigation menu ( p. 57).</p>
	<p>Tutorials</p> <p>Help videos and PDF files provided by the manufacturer on operating and cleaning the machine.</p> <p>Access via the navigation menu ( p. 79).</p>
	<p>Home</p> <p>A press of this button always takes the user back to the start screen ( p. 46).</p>
	<p>Back</p> <p>A press of this button always takes the user back to the previous screen page</p>

Symbol	Meaning
	Quick access panel To change the program parameters for the selected program on the main screen (📖 p. 114).
	Machine function active = sewing head on dark tile The screen is active and can be used immediately using the touch display. All machine functions are available. The machine is ready for sewing.
	Machine function inactive = sewing head on bright tile The screen is locked (📖 p. 51). All machine functions are locked. The machine is not ready for sewing.
	Bright tiles The numerical value integrated in the white line indicates the value for this parameter. A press of the button brings up a window allowing the user to change the range of values using the + and - buttons. The corresponding measuring unit is displayed to make this task easier. The new numerical value is adopted into the white line.
	Dark tiles The dark tiles can be set to active or inactive by pressing on them. A tap of the tile will trigger the desired process once.
	Dark tiles with a lower blue corner A press of such a tile automatically takes the user to the parameter section where values can be input and changed.
	Multifunction button with lower blue corner Dark tiles with round blue line = ON Dark tiles with round gray line = OFF The tile can be set to ON/OFF with a short press. A long press automatically takes the user to the parameter section where values can be input and changed.
	Threading mode All relevant machine functions are set to safety stop to allow for threading. At the same time, a threading diagram is displayed to provide assistance during threading (📖 p. 53).
grayed-out e.g. 	The function is inactive
blue e.g. 	The function is active

5.4 Locking the screen

The user interface can be locked to prevent inadvertent taps.

Fig. 37: Locking the screen



(1) - Lock

(2) - User interface

(3) - Lock

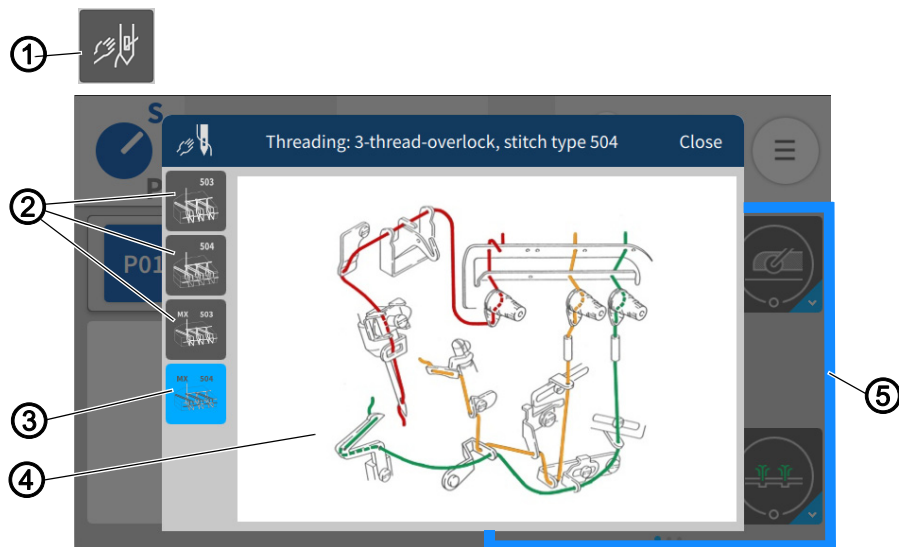


To activate the screen lock

1. Tap the lock (1) highlighted in black.
- The entire user interface (2) is grayed-out. The lock (3) is highlighted in white.
- The screen is locked.
2. To deactivate the screen lock: Perform a long press on the lock (3) highlighted in white
- The screen lock is released again, and the tiles can be selected anew.

5.5 Calling up threading mode

Fig. 38: Calling up threading mode



- | | |
|--------------------------------------|--------------------------|
| (1) - Tile Threading mode | (4) - Threading diagram |
| (2) - Stitch type | (5) - Quick access panel |
| (3) - Stitch type switched to active | |

Threading mode (1) can be activated via the quick access icons (5). The threading diagram (4) is provided as an image to assist the user in threading the machine properly.

The threading diagram (4) is selected via the stitch type (2) and (3) at the top left.



To call up the threading diagram:

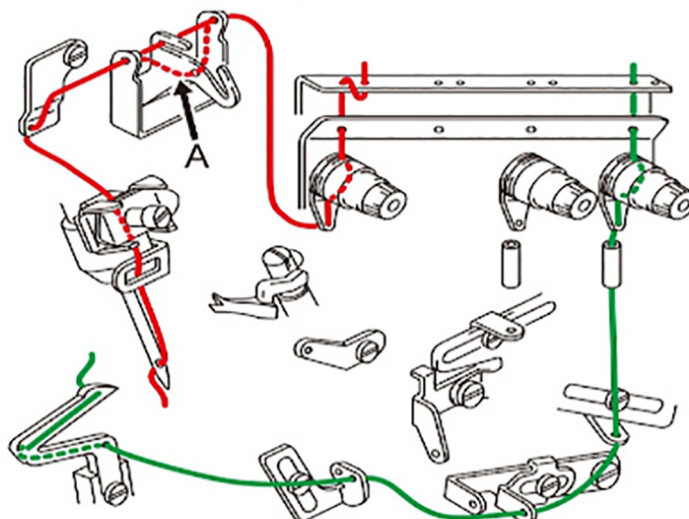
- Press the tile Threading mode (1) on the quick access panel (5).
 ↳ The user interface with the threading diagram (4) opens.
- Press the desired stitch type (2) or (3) at the top left.
 ↳ The stitch type (3) set to active is displayed in the window.
 ↳ You can toggle back and forth between the stitch types.
- Press **Close**.
 ↳ The view returns to the main screen.

5.5.1 Threading diagram

Depending on the sewing equipment, the machine can be threaded as a 2- or a 3-thread variant.

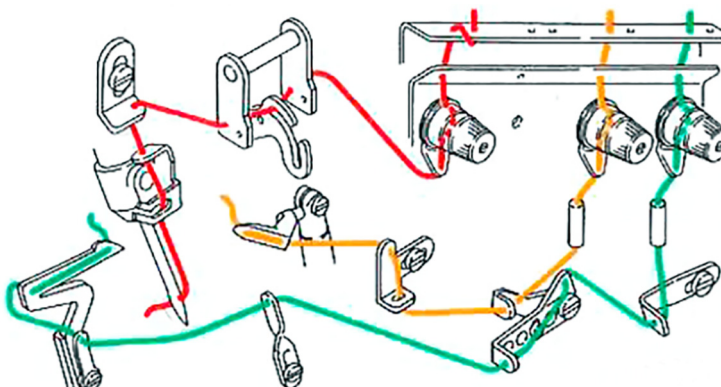
2-thread variant: Stitch type 503, 2-thread overlock chainstitch

Fig. 39: Stitch type 503



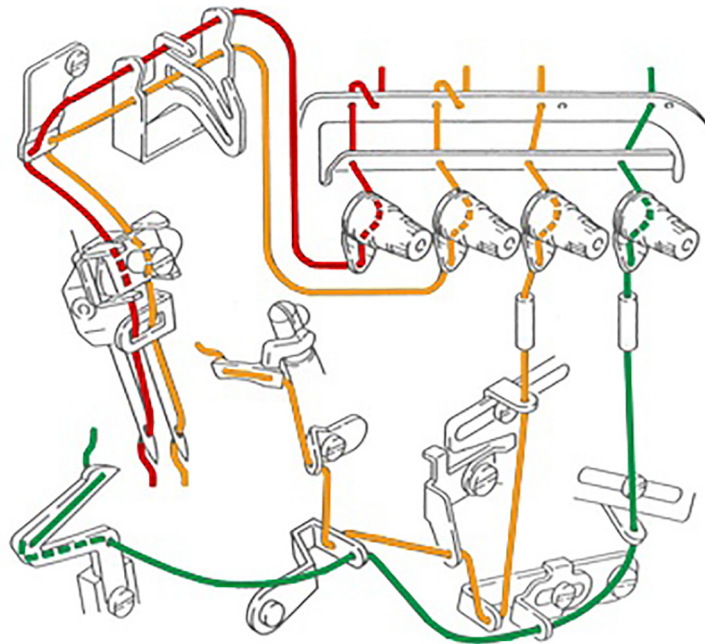
3-thread variant: Stitch type 504/505, 3-thread overlock chainstitch

Fig. 40: Stitch type 504/505



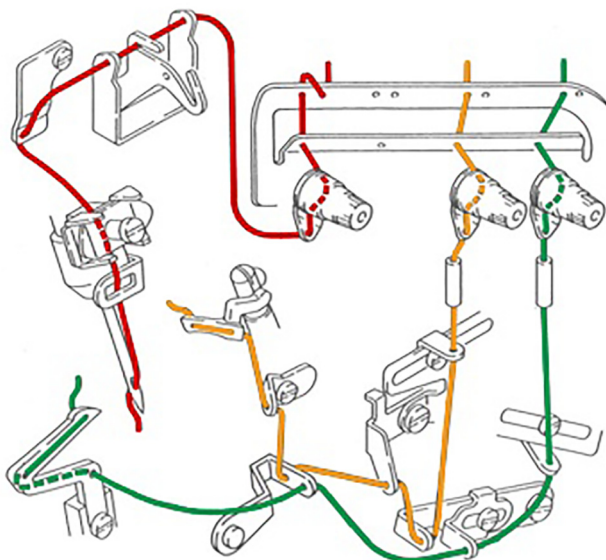
4-thread variant: Stitch type MX-503, 4-thread overlock chainstitch

Fig. 41: Stitch type MX-503



3-thread variant: Stitch type MX-504, 3-thread overlock chainstitch

Fig. 42: Stitch type MX-504



5.6 Entering numerical values

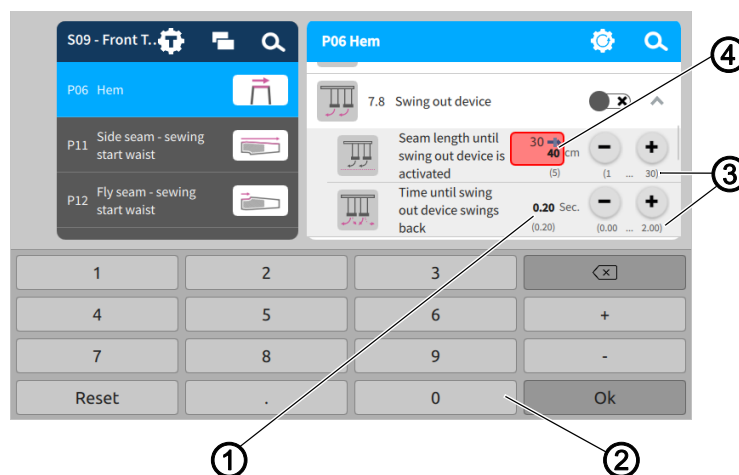


Information

If a numerical value is entered that is not within the specified value range, the software will automatically adopt the limit value which is closest to your entry from the value range.

You can input numerical values (1) using the buttons **-** or **+** or by typing on the integrated on-screen keyboard.

Fig. 43: Entering numerical values



(1) - Numerical value
 (2) - On-screen keyboard

(3) - Specified value range
 (4) - Invalid numerical value



To access the integrated on-screen keyboard:

1. Tap once on the numerical value (1) you wish to change.
- ↳ The integrated on-screen keyboard (2) is displayed, and the numerical value you wish to change is marked by a blue frame.
2. Use the on-screen keyboard (2) to enter the numerical value.
3. Press OK.
- ↳ The value is stored, and the display returns to the previous interface.



Important



Invalid numerical values (4) are highlighted in red and are not within the specified value range (3). The software responds to invalid numerical values (4) by automatically inputting the value range limit. Each specified value range (3) is given in brackets below the buttons **-** or **+**.

5.7 Changing program or sequence names

The names of the individual programs or sequences can be changed manually.



To change the names for programs and sequences:

1. Select the corresponding program
 -  Program Parameters
 -  Sequence Programming
2. Select the program/sequence you wish to change.
 - ↳ The program/sequence is set to active.
3. Press the active program/sequence twice in rapid succession.
 - ↳ The integrated on-screen keyboard is displayed and the text to be changed is marked by a purple frame.
4. Modify the text manually.
5. Press `Close`.
 - ↳ The text is saved and the display returns to the user interface Program Parameters/Sequence Programming.

5.8 Navigation menu


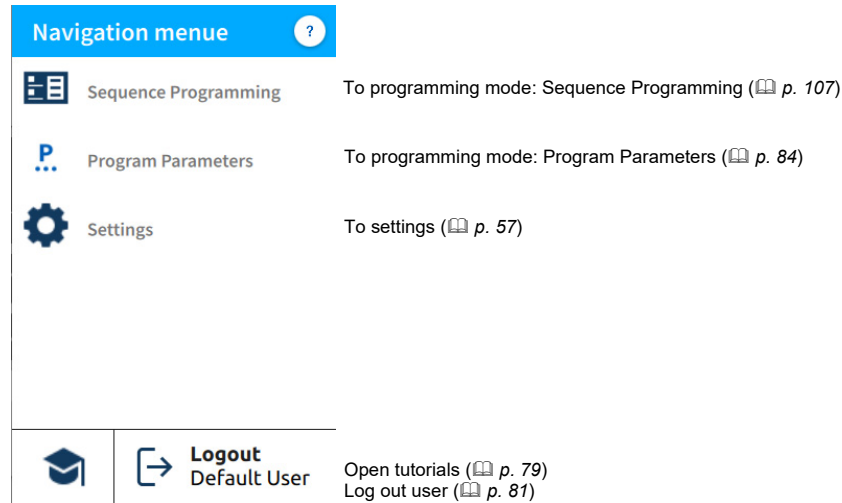
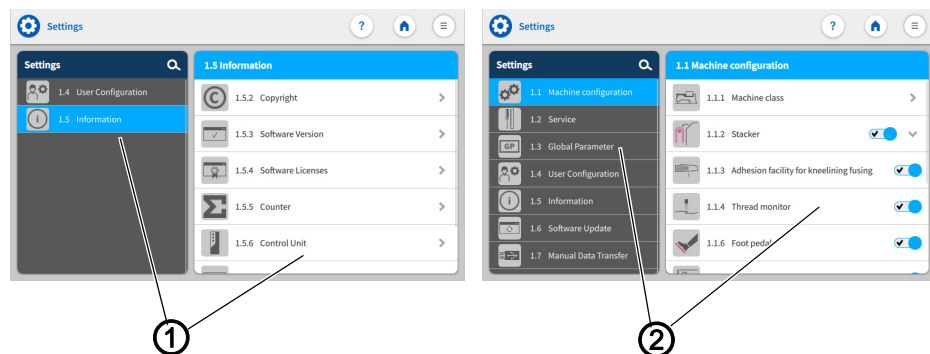
You can open the navigation menu with a press of the symbol .

Fig. 44: Navigation menu



5.9 Settings

Fig. 45: Settings



(1) - *User interface* Default User

(2) - *User interface* Default Technician

The factory setting is such that the Default user will automatically be logged in when the machine starts and the control panel boots up. Displayed in the settings is the user interface Default User (1).

The factory setting for the Default Technician requires that the technician enter their username and password (*technician*, 25483) (p. 81). The Default Technician has more far-reaching authorizations than the Default User. Displayed in the settings is the user interface Default Technician (2).

After a restart of the machine, the user interface is changed back to the Default User (1).

The settings User Configuration and Information are identical for the Default User and the Default Technician. All options are detailed below.



5.9.1 User Configuration

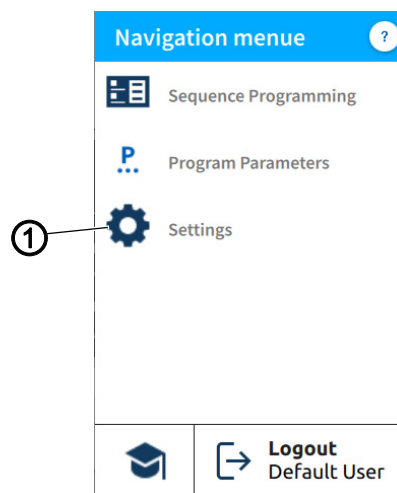
The 1.4 User Configuration allows the currently logged-in user to customize the software interface to their specific needs.



To access the User Configuration:

1. Press the symbol to bring up the navigation pane
 The navigation menu opens.

Fig. 46: User Configuration (1)

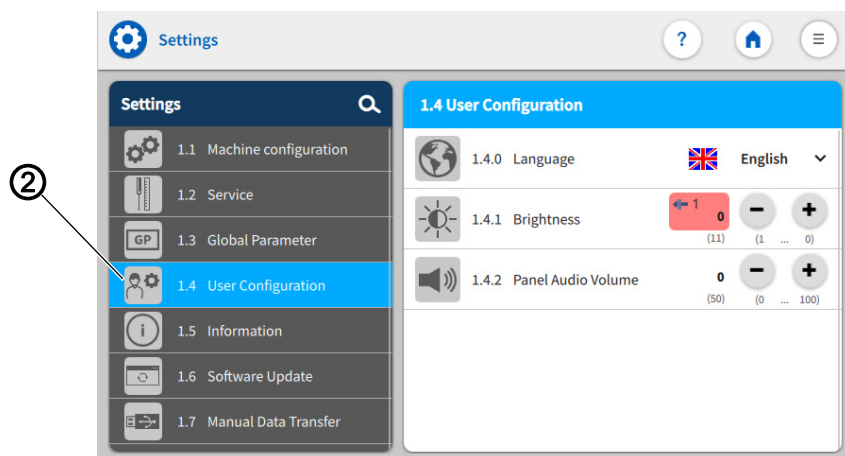


(1) - Settings



2. Press Settings (1).
 This opens the Settings interface.

Fig. 47: User Configuration (2)



(2) - User Configuration



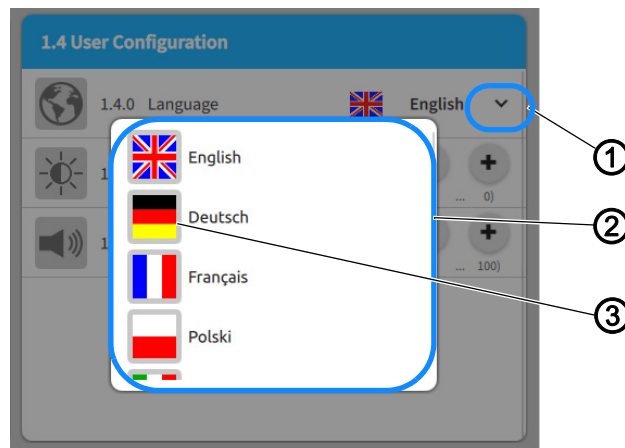
3. Press the option User Configuration (2) on the left.
 ↳ You are in the User Configuration.



5.9.2 Setting the language

Here, you can set the language of the software.

Fig. 48: Setting the language (1)



(1) - Submenu

(2) - List

(3) - Language



To set the language:

You are in the User Configuration (📖 p. 58)

1. Press on the submenu (1) of Language.
 ↳ A list (2) holding the language selection opens:
2. Press on the desired language (3).
3. Restart the machine (📖 p. 15).
 ↳ The language of the control panel is changed.

Fig. 49: Setting the language (2)



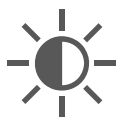
(4) - Symbol

When making changes to text, e.g. when changing program/sequence names (📖 p. 56), the user can switch to a different language using the integrated keyboard.



To switch the language on the integrated keyboard:

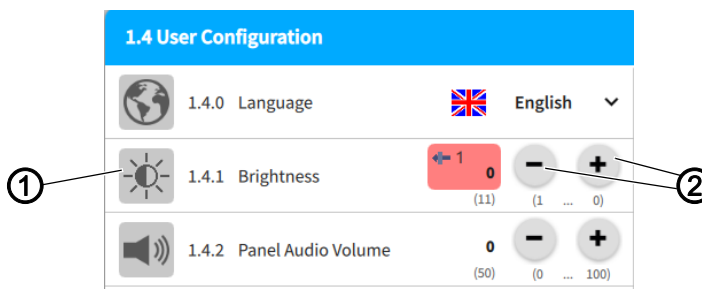
1. Press on the symbol (4) of the language selection.
- ↳ You will be shown a language selection.
2. Select the desired language.
- ↳ The language changes automatically.



5.9.3 Adjusting the brightness

Here, you can adjust the brightness of the control panel.

Fig. 50: Adjusting the brightness



(1) - Brightness indicator

(2) - Buttons



To adjust the brightness:

You are in the User Configuration (📖 p. 58)

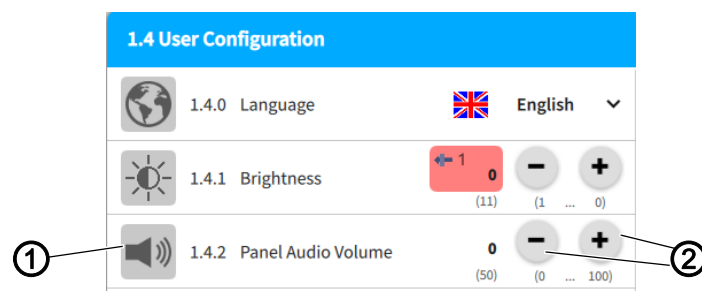
1. Go to the Brightness (1) display and enter the desired value using the buttons (2).
- ↳ The brightness of the control panel is adjusted.



5.9.4 Adjusting the audio volume

Here, you can adjust the volume of the audio output.

Fig. 51: Adjusting the audio volume



(1) - Audio volume indicator

(2) - Buttons



To adjust the audio volume:

You are in the User Configuration (📖 p. 58)

1. Go to the Audio Volume (1) display and enter the desired value using the buttons (2).
- ↳ The volume of the control panel is adjusted.



5.9.5 Information

The 1.5 Information display allows the currently logged-in user to read information about the software, the control, the control panel and the machine.



To access the information:


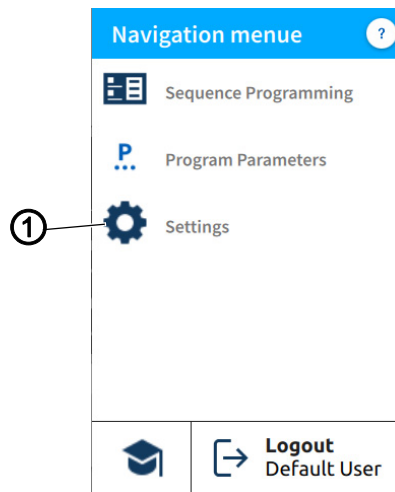
1. Press the symbol  to bring up the navigation pane.
- This opens the navigation interface.

Fig. 52: Information (1)

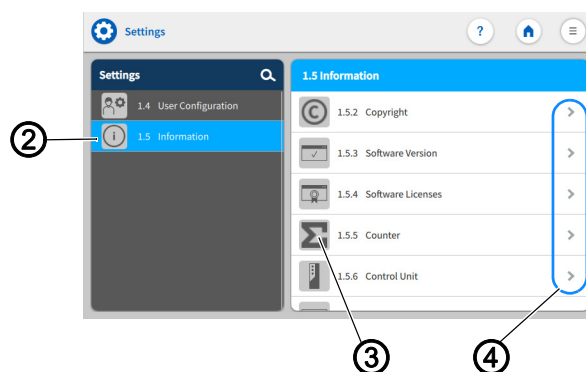


(1) - Settings



2. Press Settings (1).
- This opens the Settings interface.

Fig. 53: Information (2)



(2) - Additional information
(3) - Symbols

(4) - Next page











3. Press the option Information (2) on the left.
- You are on the Information screen. Displayed on the right side is a variety of symbols (3).

4. Next page (4)

☞ All information related to the symbol is displayed.





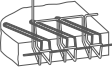

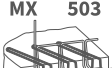
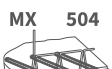
The symbols are listed and explained in the table below.


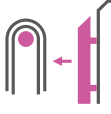
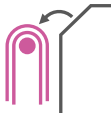
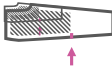




Symbol	Menu item and explanation
	1.5.2 Copyright Dürkopp Adler GmbH
	1.5.3 Software Version Display of the software version for the touch panel and the machine control.
	1.5.4 Software Licenses Software license information.
	1.5.5 Counter Counts the number of cycles/programs since the initial installation of the machine.  $\Sigma:0000$ Machine life time counter: This counter cannot be reset.
	1.5.6 Control Control unit type and its serial number
	1.5.7 Control panel Info Show the information of the panel.
	1.5.8 Machine Show the information of the machine.

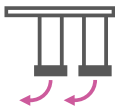




5.9.6 Machine Configuration

The 1.1 Machine Configuration allows the user to change the configuration of the machine. They can define the additional equipment assembled to the machine and adjust it by turning it ON/OFF. The additional equipment enabled here affects the global parameters and the program parameters that can be selected and modified.

Selection	Setting 1	Setting 2
 1.1.1 Class Select the delivery state of the machine class.	 1.1.1.1 1200 Single head serging units	1200 1200 Single head serging units
	1.1.1.2 Sewing head	 EX 1.1.1.2.1 Pegasus EX5204-22/233  MX 1.1.1.2.2 Pegasus MX5204
	1.1.1.3 Stitch type	503  2-thread overlock chainstitch, stitch type 503 504  3-thread overlock chainstitch, stitch type 504 MX 503  4-thread overlock chainstitch, stitch type MX-503 MX 504  3-thread overlock chainstitch, stitch type MX-504









Selection	Setting 1	Setting 2
 <p>1.1.1.2 Stacker For stacking trouser parts or other sewing material. Value range: ON/OFF</p>	<p>Stacker type Select to display the list of stacker types.</p>	 <p>1.1.1.2.2 Clamping stacker</p>  <p>1.1.1.2.3 Flip stacker</p>
 <p>1.1.1.3 Fusing station Adhesion facility for kneeling fusing Value range: ON/OFF</p>		
 <p>1.1.1.4 Thread monitor A classic chain thread monitor, the thread monitor is designed to detect thread breakage and stops the machine at the seam end. Value range: ON/OFF</p>		
 <p>1.1.1.9 Pneumatic sword device The sword can be swung in / out to turn the sewing piece slightly. This is recommended e.g. when sewing side seams with sewing start from the trousers hem. Value range: ON/OFF</p>		
 <p>1/1/2010 Differential feed Value range: ON/OFF</p>	 <p>1.1.10.2 Differential feed Value range: ON/OFF</p>	




















Selection	Setting 1	Setting 2
 <p>1/1/2011 Swing out device Value range: ON/OFF</p>		
 <p>1/1/2012 Thread tension release The thread tension release is used to support the safe chain cutting when serging 3-thread seams. Value range: ON/OFF</p>		
 <p>1/1/2015 Blowing out fly / seat seam Blowing out fly / seat seam should be activated when sewing the inseam from the hem. Blowing out prevents folding over and unintentional sewing of material in the fly and seat seam. Value range: ON/OFF</p>		




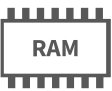

























5.9.7 Service

Overview of the structure under 1.2 Service and its adjustments for services

Selection	Setting 1	Setting 2
 1.2.1 Machine test Enables the following test functions: Help roller (if available), Test puller / roll-out device (if available), Test stepper motors (if available) Test sewing drive/motor, Test foot pedal (if available).	 1.2.1.4 Test help roller Testing the function of the help roller: Lowering of the help roller, height adjustment of the roller on the delivery table. Value range: ON/OFF	
	 1.2.1.7 Test sewing drive	 1.2.1.7.1 Needle position Up/Down
		 1.2.1.7.2 Speed Enter the speed for the sewing motor test. Value range: 300-8000 rpm
		 1.2.1.7.3 Start sewing drive Start sewing drive. Value range: ON/OFF
	 1.2.1.8 Test foot pedal - Manual sewing Function test of the foot pedal for manual sewing.	 Foot pedal position Select to view foot pedal position. Foot pedal position is displayed

Selection	Setting 1	Setting 2
 1.2.2 Multitest	 1.2.2.1 Test input Allows the user to test the incoming signals. E.g. the function of the light barriers, photocells, etc.	 1.2.2.1.1 Grid view Select one / multiple functions in grid view. ↳ All functions are executed once at the same time.  1.2.2.1.2 Reset ↳ The grid is empty.
	 1.2.2.2 Test output Allows the user to test the outgoing signals. E.g. the function of the sewing foot lift, pedal, sword, etc.	List View:  Y01 Sewing foot  Y02 Thread tension  Y03 Contour guide
		 Y04 Stacker  Y05 Down holder  Y06 Help roll  Y07 Swing out device
		 Y09 Sword device  Y10 Differential bottom feed  Y12 Vacuum chain cut
		 Y13 Table blowing  Y14 Waste suction  Y15 Fusing stamp  Y16 Lining clamp Value range: ON/OFF







Selection	Setting 1	Setting 2
		 <p>1.2.2.2.1 Grid view Select one / multiple functions in grid view. ⚡ All functions are executed once at the same time.</p>  <p>1.2.2.2.4 Auto on ⚡ All functions are repeated continuously at the same time.</p>  <p>1.2.2.2.2 Reset The grid is empty again.</p>
	 <p>1.2.2.3 RAM test Memory chip analysis. E.g. to identify a defective RAM module.</p>	 RAM test result
	 <p>1.2.2.4 ROM test Memory chip analysis. E.g. of the read-only memory.</p>	 ROM test result
 <p>1.2.3 Initialise Initialize the data to the default values</p>	  <p>1.2.3.1 Init global parameters</p>	<p>Kindly confirm initialisation!</p>  <p>All the global parameters will be reset to factory default and cannot be recalled! Or: Cancel</p>
	  <p>1.2.3.2 Init sequences</p>	<p>Kindly confirm initialisation!</p>  <p>All the sequences will be reset to factory default and cannot be recalled. Created sequences will be overwritten. Or: Cancel</p>

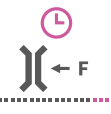

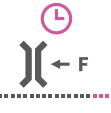



Selection	Setting 1	Setting 2
	  1.2.3.3 Init sewing programs	<p>Kindly confirm initialisation!</p>  All the parameters of Sewing programs will be reset to factory default and cannot be recalled! Or: Cancel
	  1.2.3.4 Master init	<p>Kindly confirm initialisation!</p>  All Global parameters, Sequences and Sewing programs will be reset to factory default and cannot be recalled! Or: Cancel
	  1.2.3.5 Init machine configuration	<p>Kindly confirm initialisation!</p>  All machine configurations will be reset to factory default and cannot be recalled. Created configurations will be overwritten. Or: Cancel
	 1.2.3.6 Remove User Tutorials	<p>Confirm: Remove User Tutorials.</p>  All User Tutorials will be removed. Or: Cancel
	 1.2.3.7 Remove vendor tutorials	<p>Confirm: Remove vendor tutorial.</p>  All vendor tutorials sets by default will be deleted. Or: Cancel

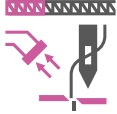
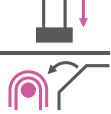

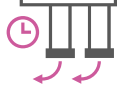

GP


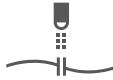




5.9.8 Global Parameters






The global parameters allow the user to set/adjust parameters that apply to all programs. The following tables provides an overview of the structure of the 1.3 Global Parameters (they are valid for all programs).

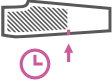

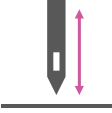

Selection	Setting 1	Setting 2
 <p>1.3.1 Light barrier Select to view photo cell menu</p>	 <p>1.3.1.2 Delay to lower the sewing foot The delay for lowering the presser foot after light barrier detection facilitates material feed under the presser foot.</p>	<p>Default: 0.00 s</p> <p>Value range: 0.00-1.00 s</p>
	 <p>1.3.1.3 Automatic sewing start delay Delay for automatic sewing start, for secure positioning of the sewing material under the presser foot.</p>	<p>Default: 0.00 s</p> <p>Value range: 0.00-5.00 s</p>
	 <p>1.3.1.4 Delay of sewing foot lift after seam end The delay of the sewing foot lift at the seam end ensures that the thread chain cutting works safely.</p>	<p>Default: 0.00 s</p> <p>Value range: 0.00-1.00 s</p>
 <p>1.3.2 Thread tension release The thread tension release is used to support the safe chain cutting when serging 3-thread seams.</p>	 <p>1.3.2.1 Thread tension release at seam begin</p>	<p>Value range: ON/OFF</p>

Selection	Setting 1	Setting 2
	 <p>1.3.2.2 Seam section with thread tension release Enter the seam section for the thread tension release at the seam beginning. This is used to support safe chain cutting when serging 3-thread seams.</p>	Value range: 0-5 cm
	 <p>1.3.2.3 Thread tension release at seam end</p>	Value range: ON/OFF
	 <p>1.3.2.4 Seam section with thread tension release Enter the seam section for thread tension release at the end of the seam. This is used to support safe chain cutting when serging 3-thread seams.</p>	Value range: 0-5 cm
 <p>1.3.3 Thread chain cut Setting the parameters for optimum thread chain cut</p>	 <p>1.3.3.1 Sewing speed during thread chain cut. Reduced sewing speed during thread chain separation to reduce wear parts.</p>	Value range: 500-8000 rpm
	 <p>1.3.3.4 Distance until the start of suction for chain cut at seam end The seam section up to the beginning of the suction for the chain cut at the seam end influences the safe thread chain cutting.</p>	Value range: 0.0-10.0 cm

Selection	Setting 1	Setting 2
	 <p>1.3.3.5 Distance until the start of suction The seam section with the suction for the chain cut at the seam beginning ensures a clean, short chain at the material beginning.</p>	Value range: 0.0-10.0 cm
 <p>1.3.4 Stacker/ Down holder/ Roll-out device Adjusting the parameters for optimum functioning of the stacker and the down holder.</p>	 <p>1.3.4.1 Down holder of the lift delay The time delay for lifting the downholder after the stacker has clamped the material is used to transfer the material into the stacker without sliding off from the tabletop.</p>	Value range: 0.10-3.00 s
	 <p>1.3.4.2 Waiting time until swing out device swings back Waiting time until the swing out device swings back - after sewing stop. This time is helpful when reloading sewing pieces for which the swing out device is to stop at the sewing head.</p>	Value range: 0.00-5.00 s
	 <p>1.3.4.3 Stacker clamping time The stacker clamping time ensures that the material is safely held and stacked.</p>	Value range: 0.10-3.00 s

Selection	Setting 1	Setting 2
	 <p>1.3.4.5 Minimum sewing length for stacking Enter the minimum seam length before the stacking process is to take place.</p>	Value range: 20-100 cm
 <p>1.3.5 Thread monitor The thread monitor is used to detect thread breakage</p>	 <p>1.3.5.1 Thread monitor The thread monitor detects a thread breakage and stops the sewing process.</p>	Value range: ON/OFF
	 <p>1.3.5.2 Thread monitor sensitivity Thread monitor sensitivity is used to adjust to different yarns / colors to detect faulty material.</p>	Value range: 0-100
	 <p>1.3.5.3 Seam length until thread monitor info active Seam length until thread monitor info is activated to avoid faulty detection at the beginning of the seam, which can be caused by thread loops.</p>	Value range: 0.0-10.0 cm
	 <p>1.3.5.4 Sewing speed with thread monitor activated Sewing speed when the thread monitor is activated. When the thread monitor is activated, a certain sewing speed can be set from which the thread monitor is active.</p>	Value range: 500-8000 rpm

Selection	Setting 1	Setting 2
 <p>1.3.6 Needle position at bottom dead center This refers to the needle position at the bottom dead center. Value range: 0-360°</p>		
 <p>1.3.7 Stitch length Input of the mechanically adjusted stitch length to calculate all dependent parameters in the control. Value range: 0.1-3.8 mm</p>		
 <p>1.3.8 Speed Input of the maximum speed for the main seams and for manual sewing via pedal</p>	 <p>1.3.8.1 Max. speed in main seam Setting the maximum allowed sewing speed for the main seams - over all programs. Value range: 100-8000 rpm</p>	 <p>1.3.8.2 Max. speed for manual sewing via pedal Setting the maximum allowed sewing speed for manual sewing via pedal. Value range: 100-8000 rpm</p>

Selection	Setting 1	Setting 2
		
<p>1.3.9 Kneelining fusing station Setting the time to securely glue the knee lining to the outer fabric. This is necessary for sewing start from the hem and processing knee lining. Value range: 0.00-3.00 s</p>		
		
<p>1.3.12 Sewing foot lifting at seam beginning/end For safe feeding and sewing of the material at the seam beginning, the "presser foot position lifted" is recommended. Value range: ON/OFF</p>		
		
<p>1.3.14 Needle position at seam end DOWN For safe feeding and sewing of the material, the "needle position at seam end DOWN" is recommended. If pieces of material are overlapped without the seam chain running out, the "needle position at seam end UP" is necessary. For this, it is necessary to define the parameter under 1.3.6 Needle position at bottom</p> <p>dead center (see 1.3.6 ).</p> <p>Value range: UP/DOWN</p>		



5.9.9 Software update

The 1.6 Software Update allows the user to update the software of the control unit. To do this, follow the instructions in the corresponding chapter (📖 p. 125).



Note the order of software updates for the control panel and controls:



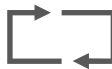


1. Update the control panel (📖 p. 125).
2. Update the controller (📖 p. 127).








Selection	Setting 1	Setting 2
System Update	Select an update file	






5.9.10 Manual data transfer

The following table provides an overview of the structure of the 1.7 Manual Data Transfer.

Selection	Setting 1	Setting 2
 1.7.1 Export Adjustments of the data transfer (📖 p. 117)	 1.7.1.1 Programs With this function the sewing programs available on the machine are exported.	1. Choose export destination, e.g.: USB port ↳ next 2. Select/activate single/multiple programs. ↳ Export 3. Transfer of the file to the USB port complete
	 1.7.1.2 Sequences This function allows to export sequences and their connected programs for import on another machine.	(see above Setting 2: Export programs)
	 1.7.1.3 Global Parameters Allows to export Global Parameters.	(see above Setting 2: Export programs)
	 1.7.1.4 Machine Configuration Allows to export Machine Configuration.	(see above Setting 2: Export programs)

Selection	Setting 1	Setting 2
	 1.7.1.5 Log files This function exports the log files available on the machine.	(see above Setting 2: Export programs)
	 1.7.1.6 Customer Multimedia This function exports official media files from the vendor.	(see above Setting 2: Export programs)
	 1.7.1.7 Vendor Multimedia	(see above Setting 2: Export programs)
 1.7.2 Import (p. 121)	 1.7.2.1 Programs With this function sewing programs are imported.	1. Choose import source e.g.: USB port ↳ next 2. Select/activate single/multiple programs. ↳ Import 3. The import of the following files will overwrite existing programs where necessary Transfer complete Or press: Cancel
	 1.7.2.2 Sequences This function allows to import sequences and their connected programs.	(see above Setting 2: Import programs)
	 1.7.2.3 Global Parameters Imports settings from Global Parameters which had been exported before.	(see above Setting 2: Import programs)



Selection	Setting 1	Setting 2
	 <p>1.7.2.4 Machine Configuration Imports settings from Machine Configuration which had been exported before.</p>	(see above Setting 2: Import programs)
	 <p>1.7.2.5 Customer Multimedia This file imports media files.</p>	(see above Setting 2: Import programs)
	 <p>1.7.2.6 Vendor Multimedia This function imports official media files provided by the vendor.</p>	(see above Setting 2: Import programs)

5.9.11 Searching settings

When on the `Settings` user interface, the user can search for specific settings.



To access the `Search settings` function:

1. Press on the symbol .
 - ↳ This calls up the user interface with a search field, the parameter list, and an integrated keyboard.
 - You can enter the setting you are looking for using the keyboard.
 - You can select a setting directly by scrolling.
 - ↳ The parameter list shows the parameters related to the corresponding setting. You can change these settings individually.
2. Press `Close`.
 - ↳ The adjusted settings are stored, and the display returns to the previous interface.
3. To exit `Search settings`, press .
 - ↳ The `Settings` user interface opens.

5.10 Tutorials

The `Tutorials` menu contains instructions in the form of videos or PDF files, which have been uploaded by the manufacturer.



To access the tutorials:


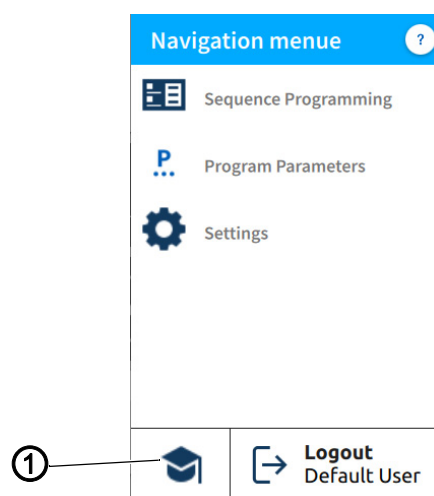
1. Press the symbol  to bring up the navigation pane
 - ↳ This opens the navigation interface.

Fig. 54: Tutorial (1)

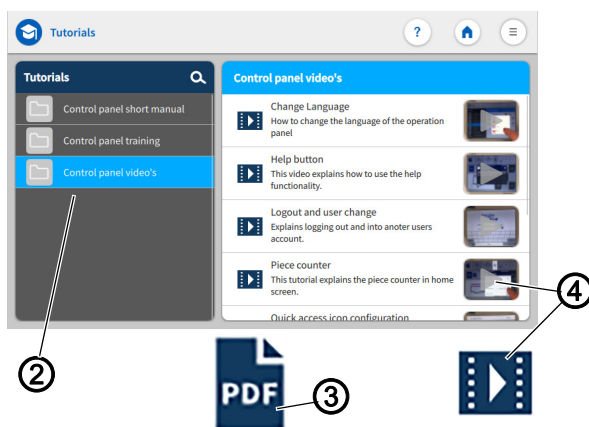


(1) - Tutorial



2. Press Tutorial (1).
- ↳ The Tutorial (2) interface opens.

Fig. 55: Tutorial (2)



- (2) - Tutorials
(3) - PDF

- (4) - Video



3. Select an option in the Tutorials (2):
 - Control panel videos
 - Control panel short manual PDF file
 - Control panel training PDF file
- ↳ A selection appears on the right:
 - Videos (4)
 - PDF files (3).
4. Select Desired video(4)/Desired PDF file (3).
- ↳ The video (4)/PDF file (3) is uploaded.
5. Watch the video pressing Start and Stop.
- ↳ Press the arrow at the top left to return to the Tutorials.
6. View the PDF file by swiping up and down.
- ↳ Press x at the top right to return to the Tutorials (2).

5.11 Login/Logout



To access Login/Logout:


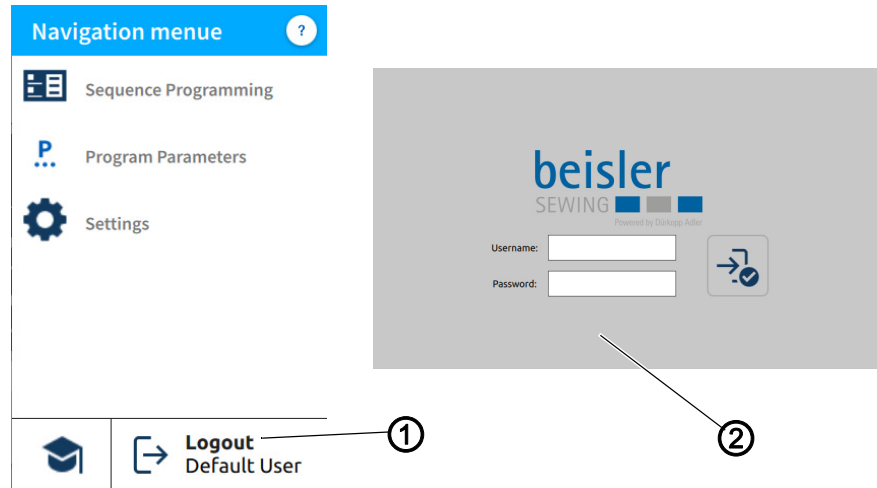
1. Press the symbol  to bring up the navigation pane.
- ↳ This opens the navigation interface.

Fig. 56: Login/Logout



(1) - Logout

(2) - Login interface



2. Press Logout (1).
- ↳ This opens the Login interface (2).



Information


If logged out, the user can log back into the system at any time by entering the username: `user` (no password required).

There are two login options. You can toggle between the `Default User` and the `Technician` user level:

- **Username:** `user` **Password:** -
- **Username:** `technician` **Password:** `25483`

Login with username and password

To log in with username and password:

1. Enter `username` and `password`.
 2. Press on the symbol .
- ↳ If the login information is correct, the user will be logged in.

5.12 Software operating modes







The software of the Commander Pro control panel offers various operating modes:









1. Piece counter
 - The display of the piece counter corresponds to the counting settings and shows how many times a program or a selected number of programs is executed.
2. Program Parameters
 - A program is composed of various parameters.
 - Each program includes a graphical representation of the seam, the sewing graphics.
3. Sequence Programming
 - At least one program is required.
 - A sequence consists of a specific sequence of programs.
 - The program sequence can be configured to individual requirements.
4. Quick access panel
 - The quick access tiles can be used to directly adjust settings and values of the program parameters.
 - The quick access panel is composed of an arrangement of customized tiles on the start screen.
 - The quick access tiles are sequence-specific and customized to fit the program sequence.

The individual operating modes and their uses are explained in detail later on.

5.12.1 Buttons in the operating modes

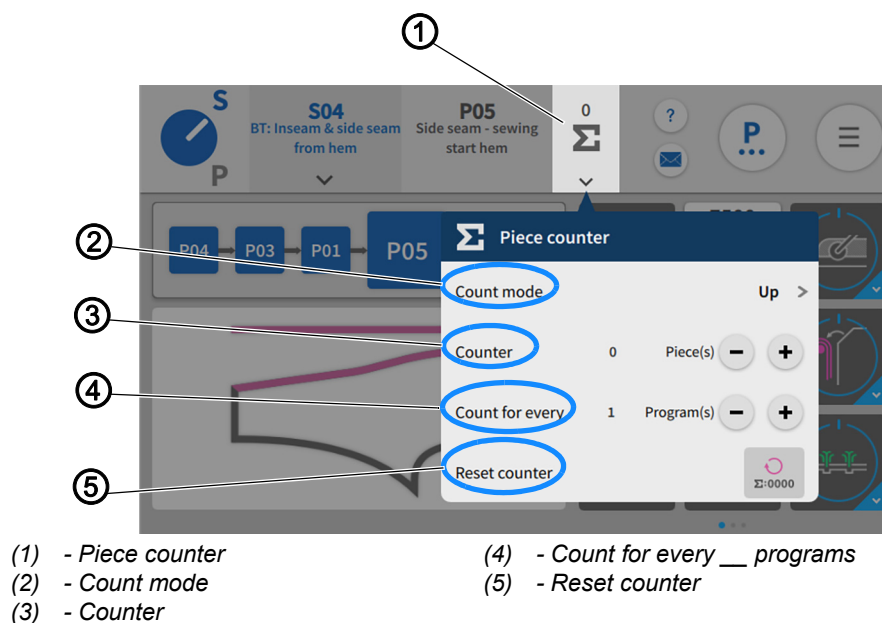
Managing the operating modes is quick and easy thanks to the buttons listed below

Symbol	Description
	Switch ON
	Switch OFF
	Templates Select for overwriting programs.
	Copy from...
	Search for...
	Reset to standard/default factory setting

Symbol	Description
	Switch from the Sequence selection to Sequence Programming.
	Switch from Sequence Programming to Quick Access.
	Add
	Delete
	Back to previous page.
	Close
	Active
	Inactive


5.13 Piece counter

Fig. 57: Piece counter








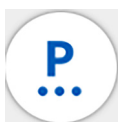
To access the counter setting:

1. Press on the symbol  found on the tile of the piece counter (1) in the status bar.

✎ A window opens that lets you adjust the advanced settings of the piece counter.

Settings for the piece counter

Setting	Explanation
Count mode (2) ✎ Press on the symbol: 	Up: the user can set the counter to counting up. Down: the user can set the counter to counting down. Off: the user can switch the counter off.
Counter (3)	The counter can change the counter result using the corresponding buttons (+/-). Or, you can enter the desired number directly.
Count for every (4) ___ programs	The user can decide after how many programs the count mode Up/Down is supposed to be set = count sequence mode. Change with the button (+/-). Example: Count for every 2 programs = the value is counted up as soon as 2 programs have been sewn.
Reset counter (5)   :0000	Count mode Up: The counter value is reset to 0. Count mode Down: The counter value is reset to 1.



5.14 Program parameters

The machine contains 200 programs.



Information

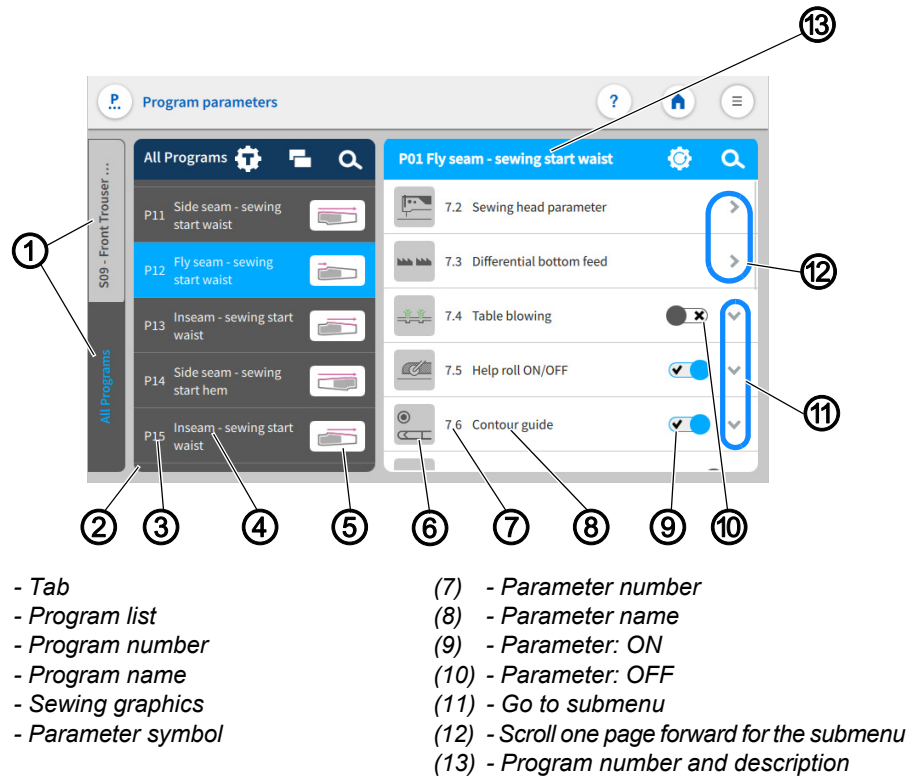
A program cannot be deleted; it can only be added to or removed from a sequence.

Every program is linked to a template. The template contains the factory settings, predefined parameters and the corresponding sewing graphics.

When being assigned to a program, a template resets all previous parameters in the corresponding program and also changes the sewing graphics in accordance with the template.

5.14.1 User interface Program parameters

Fig. 58: User interface Program parameters (1)



To access the function Program parameters:




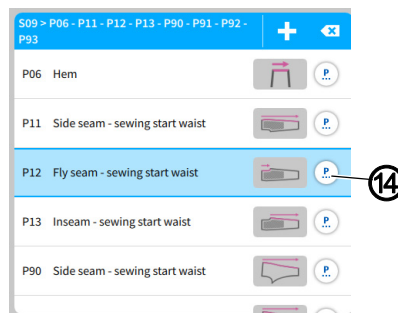
- Press the symbol  on the main page.
- Go to the navigation menu and press the  symbol.
- If the user is in the user interface Sequence Programming, press the symbol (14) .

Fig. 59: User interface Program parameters (2)

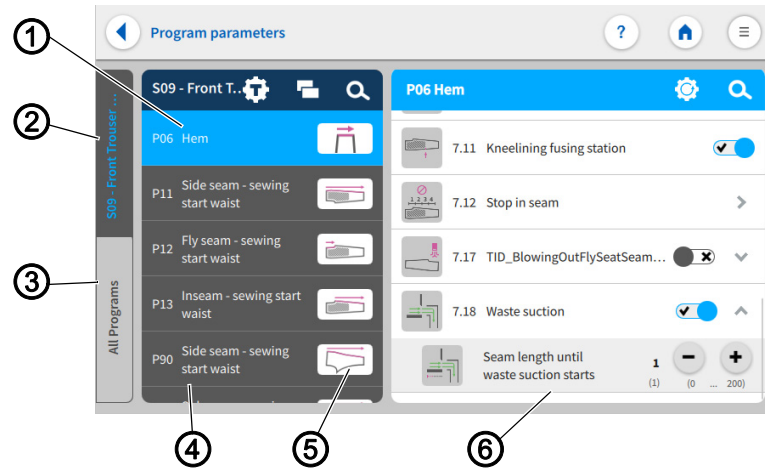


(1) - Symbol

→ The corresponding user interface for the program parameters (p. 85) opens

5.14.2 Current Sequence/Current Program

Fig. 60: Current Sequence/Current Program (1)

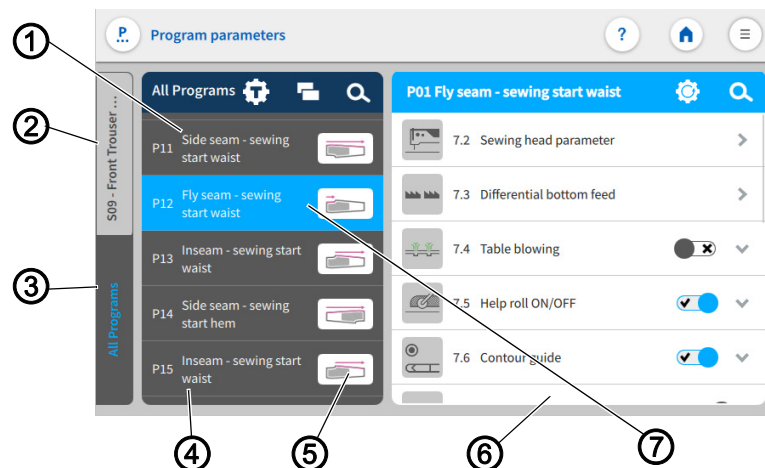


- (1) - Program
- (2) - Sequence
- (3) - All programs
- (4) - List
- (5) - Sewing graphics
- (6) - List

You can toggle between the tabs Sequence (2) and All Programs (3). The user can always tell which tab is active by the blue font placed against the dark background.

The tab: Sequence (2) is active. All programs included in this sequence are shown on the list (4). All parameters have been stored on this list (6) and can be configured individually to match the program (1). The view of the sewing graphics (5) has been included from the corresponding template of the program and is contained in every program.

Fig. 61: Current Sequence/Current Program (2)



- (1) - Program
- (2) - Sequence
- (3) - All programs
- (4) - List
- (5) - Sewing graphics
- (6) - List
- (7) - Active

If the tab: All Programs (3) is active, the list (4) shows all 200 available programs (1) including the sewing graphics (5).

If the sequence/program name is active (7), you can change the name with a double click (📖 p. 55).



Information

The sewing graphics (5) can only be changed by modifying the program template (📖 p. 87).

5.14.3 Program templates

There are 28 preconfigured sewing programs available. They either enable a direct sewing start or serve as a template for modification according to customer requirements:

- Templates 1 to 9 are designed for the serging of hind trousers.
- Template 10 to 18 are for the front trousers without kneelining.
- Template 19 to 27 are for front trousers with kneelining.
- Template 28 is for serging pieces of fabric.



To access the program templates:


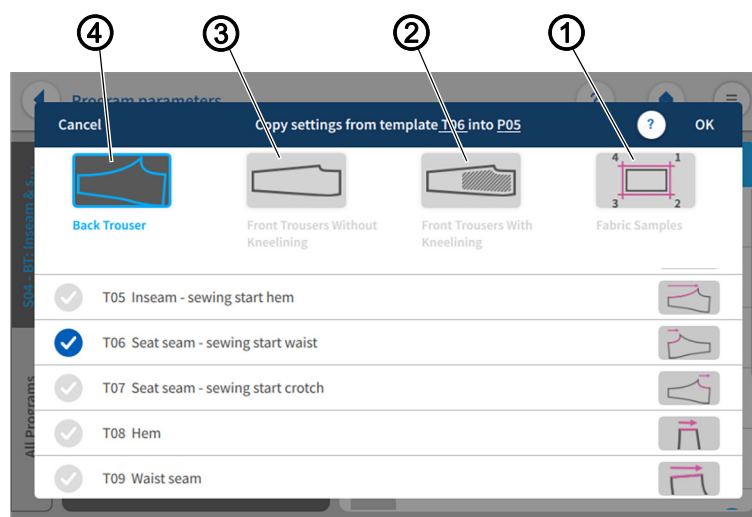
1. Open the user interface *Program parameters* and press the  symbol.
- 👉 The user interface for the program templates opens.

Fig. 62: Program templates





- | | |
|--------------------------------------|----------------------|
| (1) - Fabric Samples | (3) - Front Trousers |
| (2) - Front Trousers With Kneelining | (4) - Back Trouser |






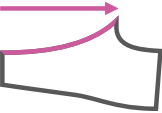



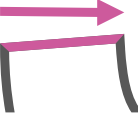
Tab for selecting the template for Back Trouser (4), Front Trousers Without Kneelining (3), Front Trousers With Kneelining (2) and Fabric Samples (1).










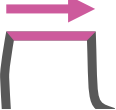
Copy settings from a template of different program to the active program.











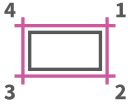
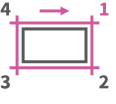


2. Press the desired template (1), (2), (3) or (4).
- ↳ A list with variants opens.
3. Activate the desired variant with a press of the  symbol.
4. Press OK.
- ↳ A warning notices appears reading  All the parameters & names of the program would be changed to template default and cannot be recalled!
5. Press Cancel or Change Template.
- ↳ Cancel: The display returns to the previous user interface.
- ↳ Change Template: The user is prompted to confirm to proceed.

Overview of templates and variants

Template	Variant	Explanation
 Back Trouser		Side seam Sewing start waist
		Side seam Sewing start hem
		Side seam Sewing start hem, with strong hip curve
		Inside leg length Sewing start crotch tip
		Inside leg length Sewing start hem
		Seat seam Sewing start waist
		Seat seam Sewing start crotch tip
		Hem
		Waist seam

Template	Variant	Explanation
 Front Trousers Without Kneelining		Side seam Sewing start waist
		Side seam Sewing start hem
		Side seam Sewing start hem, with strong hip curve
		Inside leg length Sewing start crotch tip
		Inside leg length Sewing start hem
		Front seat seam Sewing start waist
		Front seat seam Sewing start crotch tip
		Hem
		Waist seam

Template	Variant	Explanation
 Front Trousers With Kneelining		Side seam Sewing start waist
		Side seam Sewing start hem
		Side seam Sewing start hem, with strong hip curve
		Inside leg length Sewing start crotch tip
		Inside leg length Sewing start hem
		Front seat seam Sewing start waist
		Front seat seam Sewing start crotch tip
		Hem
		Waist seam
 Fabric Samples		Fabric Samples

5.14.4 Copying program parameters

This option allows the user to copy the program parameters of one program to multiple programs. The copy contains parameters and sewing graphics.



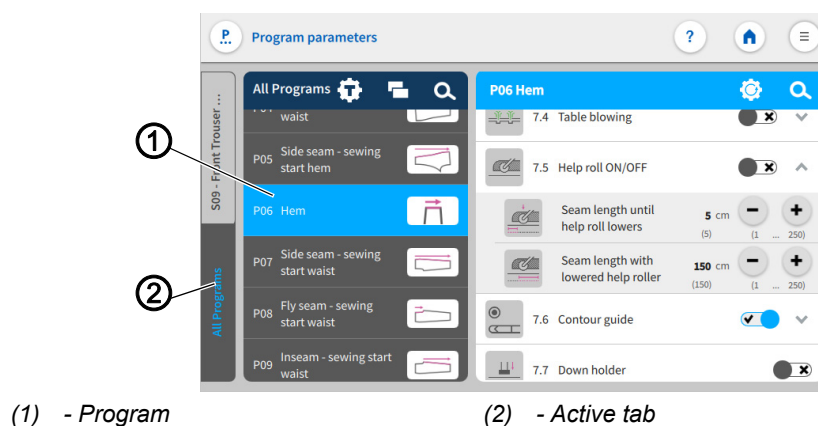
Information

The grid view contains a color indication for the programs. This color indication can help with the selection of the programs (see table Color indicators in grid view).

Color indicators in grid view

	Used in one/multiple sequences
	User in the current sequence
	Modified, but not used in any sequence.
	Not modified and not used.

Fig. 63: Copying program parameters (1)





To copy parameters:


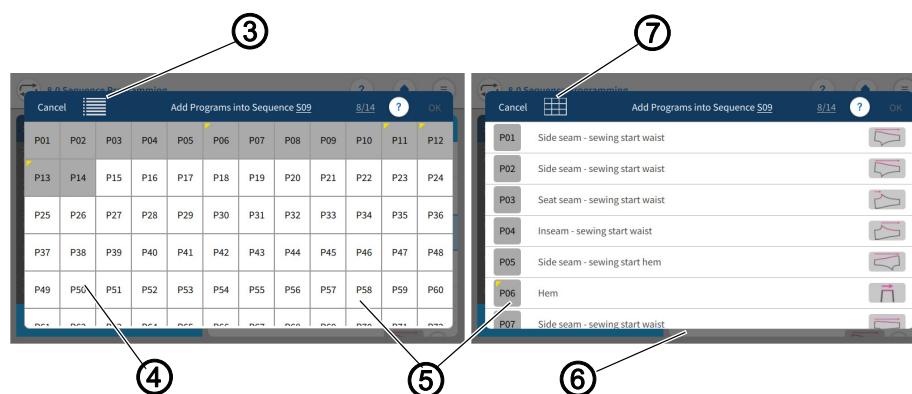


1. Press the program (1) you wish to copy in the active tab (2) All Programs.
- ↳ The program (1) is activated.
2. Press on the symbol .
- ↳ A user interface opens showing the program overview with all 200 programs in grid view (4).
- ↳ In grid view (4), only the program number (5) is visible (see table Color indicators in grid view).

Fig. 64: Copying program parameters (2)



(3) - Symbol List View
 (4) - Grid view

(5) - Program number
 (6) - List view
 (7) - Symbol Grid View




3. The symbol List View (3) allows the user to switch to list view.
- ↳ The list view (6) shows the program number (5), the name and the sewing graphics.
4. The symbol List View (7) allows the user to return to grid view (4).
5. Select one/multiple programs (5) and press OK.
- ↳ A warning notice reading  Kindly confirm Copy! appears. All parameters and names of the program(s) would be changed as per program (e.g. P51) and cannot be recalled!
6. Press Cancel /Copy Parameters.
- ↳ Cancel: the user returns to the user interface Program parameters.
- ↳ Copy Parameters: a warning notice appears reading  Copied- Successfully Copied.
7. Confirm with OK.
- ↳ The parameters have been copied.

5.14.5 Search

The user can search for specific program numbers or program names.



To access the Search function:

1. Select the tab `All Programs`.
 ↳ This opens the interface containing all 200 programs.
2. Press on the symbol .
 ↳ A user interface opens containing a search field, the parameter list and an integrated keyboard.
 - You can use the keyboard to enter the program name/program number ( p. 55).
 - You can select a program directly by scrolling.
 - ↳ The parameter list shows the parameters that are related to the corresponding program and can be altered individually.
 - ↳ Press `Close`.
 - ↳ The adjusted settings are stored, and the display returns to the previous interface.
3. Exit the parameter search with a press of .
 ↳ The user interface `Program parameters` opens.

5.14.6 Resetting program parameters




Important

The action of resetting the parameters cannot be reverted! The reset is always preceded by a warning notice.

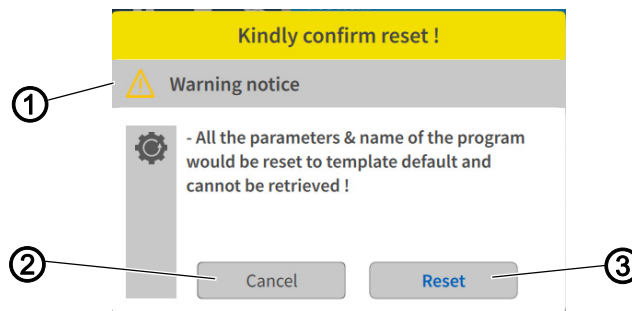


To access the function Reset program parameters.

1. Press on the symbol .

↳ This opens the interface including a warning notice.

Fig. 65: Resetting program parameters



- (1) - Warning notice
(2) - Reset

- (3) - Cancel

The warning notice (1) appears prior to the reset.

2. Press **Reset** (2).

↳ The program parameters are reset to the associated template.


3. Press **Cancel** (3).

↳ The process is canceled.

5.14.7 Program parameter search



To access the function Program parameter search:

1. Press on the symbol .

↳ The user interface containing the program list, the search field and an integrated keyboard opens.

- Use the keyboard to type in the parameter name or the parameter number.
- You can select a parameter directly by scrolling.

↳ The parameter list shows the parameters matching the corresponding program, and you can change the settings to your individual requirements.

2. Press **Close**.

↳ The adjusted settings are stored, and the display returns to the previous interface.






5.14.8 Adjusting the program parameters





















Important


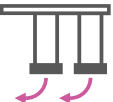


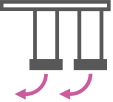




The set program parameters always apply to the currently selected program only.

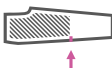




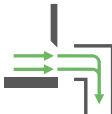
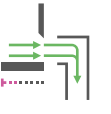
There are various options for setting the cross-program parameters. The following table lists all possible options. Settings that are more complex and therefore require further explanation are described in more detail after the table.

Symbol/parameter	Submenu/setting
 <p>Strong hip curve For all parameters required to sew the strong hip bow. These parameters are only required for side seams from hem to waistband edge. Value range: ON/OFF</p>	 <p>Seam length until "strong hip curve" is switched on Setting of the seam length until the function "strong hip curve" is switched on. Value range: 0-200 cm</p>
	 <p>Seam length with "strong hip curve" activated Setting of the seam length with the function "strong hip curve" activated. Value range: 0-40 cm</p>
	 <p>Reduced sewing speed in strong hip curve Setting of the reduced sewing speed in the area of the "strong hip curve". Value range: 100-8000 rpm</p>
	 <p>Seam length with puller down after strong hip curve is activated Setting of the seam length with puller down with "strong hip curve" activated Value range: 0-30 cm</p>










Symbol/parameter	Submenu/setting
	 Puller speed in strong hip curve Adjustment of the puller speed in the "strong hip curve" for safe further transport of the material. If the puller is too fast, the material runs out of the sewing head. If the puller is too slow, the material stacks up in front of the sewing head. Value range: 0-100%
 7.2 Sewing head parameters Parameters for adjusting the sewing head, e.g. sewing speed, soft start, chain cutting, sewing start mode, etc.	 7.2.1 Sewing speed Setting the sewing speed for the selected program. Value range: 100-8000 rpm
	 7.2.2 Soft start Setting the sewing speed at the seam beginning as soft start, for safe sewing start. Value range: ON/OFF Other setting options (📖 p. 101)
	 7.2.3 Chain cut Parameter for setting the chain cut length at the seam end Value range: ON/OFF Other setting options (📖 p. 101)
	 7.2.6 Start Mode Value range: ON/OFF Other setting options (📖 p. 101)
	 7.2.7 Overrun time at seam end Overrun time at seam end for the thread chain cut Value range: 0.00-3.00 s
 7.3.7 Differential bottom feed The entire seam can be divided in up to 5 seam sections. Parameters can be set independently for each section (📖 p. 103).	



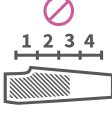

Symbol/parameter	Submenu/setting
 7.4 Table blowing Setting the parameters for the table air nozzles, for lifting and transporting the material towards the stacker during sewing. It reduces the danger of the material getting caught Value range: ON/OFF	 Seam length until table blowing is switched on. Seam length in cm until table blowing is switched on Value range: 0-30 cm
	 Seam Length with table blowing on Seam length in cm with table air nozzles switched on Value range: 1-250 cm
 7.5 Help roller Setting the parameters for the help roller. The help roller is activated to transport the material close to the edge guide. This prevents "seam run-out". The activation of the help roller is generally recommended for the last 20 cm of the seam Value range: ON/OFF	 Seam Length until help roller down Seam length in cm until help roller lowers Value range: 1-250 cm
	 Seam Length with help roller down Seam length in cm with lowered help roller. After the seam length has expired, the help roller lifts again. Value range: 1-250 cm
 7.6 Contour guide Setting the parameters for the contour guide. In case of seam thickness, the contour guide can be raised within the seam section to prevent material blockage at the thicker point. Value range: ON/OFF	 Seam length until contour guide lowers Seam length in cm until the contour guide is lowered at the beginning of the seam. Value range: 1-10 cm
	 Seam length until contour guide lifts Seam length in cm until the contour guide rises to sew over a seam thickness within the seam. Value range: 0-100 cm
	 Seam length with contour guide up Seam length in cm with raised contour guide for the seam thickening area. Value range: 0-20 cm

Symbol/parameter	Submenu/setting
 <p>7.7 Down holder/stamp Activate/deactivate the downholder/stamp at the end of the seam to hold the sewing material during chain cutting. Value range: ON/OFF</p>	
 <p>7.8 Swing out device Value range: ON/OFF</p>	 <p>Seam length in cm until the stacking device swings out Value range: 1-30cm</p>
	 <p>Time in seconds until the swing out device swings back to its base position. Value range: 0.00-2.00 s</p>
 <p>7.8.4 Swing out device position Here you select the position of the swing-out device. ON means that the swing-out device is placed next to the sewing head before the sewing start. OFF means that the swing-out device is positioned to the left of the stacker before the sewing start. Value range: ON/OFF</p>	
 <p>7.9 Sword swivel Value range: ON/OFF</p>	 <p>Seam length in cm until sword is activated. Value range: 0-250cm</p>
 <p>7.10 Staker Setting the parameters for the stacking process Value range: ON/OFF</p>	 <p>7.10.2 Staker delay after chain cut Delay time of the staker in seconds after chain cutting, for safe clamping of the material . Value range: 0.00-3.00 s</p>

Symbol/parameter	Submenu/setting
 7.11 Kneelinging fusing station Value range: ON/OFF	
 7.12 Stop in seam Setting of up to 4 sewing stops within one seam. This can be used, for example, for attaching labels to the seam. For this purpose, the machine stops at the desired seam point and the label or similar can be added manually. The automatic sewing process can then be restarted (📖 p. 105).	
 7.17 Blowing out fly / seat seam Blowing out the fly/seam should be activated during kneelinging fusing when sewing the inseam from the hem. Blowing out prevents folding over and unintentional sewing of material in the fly and seat seam. Value range: ON/OFF	 Seam length until start of blowing out seam Enter the seam length up to the beginning of the blowing out of the fly / seat seam. Use a tape measure to measure the length of the inseam and enter the value. Value range: 1-20cm
	 Duration of blowing out fly/seat seam Entering the time (duration) for blowing out fly/seat seam. Value range: 0.10-3.00 s
 7.18 Waste suction Remove cutting waste by suction Value range: ON/OFF	 Seam length until waste suction starts Seam length in cm until waste suction starts Value range: 0-200cm

5.14.9 Additional setting options for program parameters

Symbol/parameter	Submenu/setting
 7.2.2 Soft start Setting the sewing speed at the seam beginning as soft start, for safe sewing start (p. 96). Value range: ON/OFF	 Soft start sewing speed Setting the sewing speed for the soft start. If the speed is set too high, safe sewing is not guaranteed. Value range: 100-6000 rpm
	 Soft start sewing length Setting the seam length of the soft start in cm. Value range: 0-10cm
 7.2.3 Chain cut Parameter for setting the chain cut length at the seam end (p. 96) Value range: ON/OFF	 Sewing length for chain cut Setting the sewing length until the chain cut is activated. Value range: 1.0-10.0cm
	 Length of chain at seam end Adjust the required chain length at the seam end. This depends on the material. Value range: 0.0-10.0cm
 7.2.6 Start mode (p. 96)	 7.2.6.1 Start mode 1: Automatic sewing start by light barrier Fully automatic sewing start via light barrier recognition Value range: ON/OFF
	 7.2.6.2 Start mode 2: Manual sewing start by foot pedal Manual sewing start/Manual sewing via pedal, then activate the automatic sewing start after xxxx cm. Value range: ON/OFF

Symbol/parameter	Submenu/setting
	 <p>7.2.6.3 Start mode 3: 1.Manual sewing start, 2.contour guide, 3.automatic sewing start by foot pedal. Manual sewing start/Manual sewing via pedal, then press pedal to activate automatic sewing start. Value range: ON/OFF</p>
	 <p>7.2.6.6 Seam length until automatic sewing start Setting the seam length in cm until automatic change to automatic sewing start. Value range: 1-30 cm</p>
 <p>7.12 Stop in seam Setting of up to 4 sewing stops within one seam. This can be used, for example, for attaching labels to the seam. For this purpose, the machine stops at the desired seam point and the label or similar can be added manually. The automatic sewing process can then be restarted (📖 p. 105).</p>	
 <p>7.3 Differential bottom feed (📖 p. 103)</p>	

5.14.10 Setting options for differential bottom feed

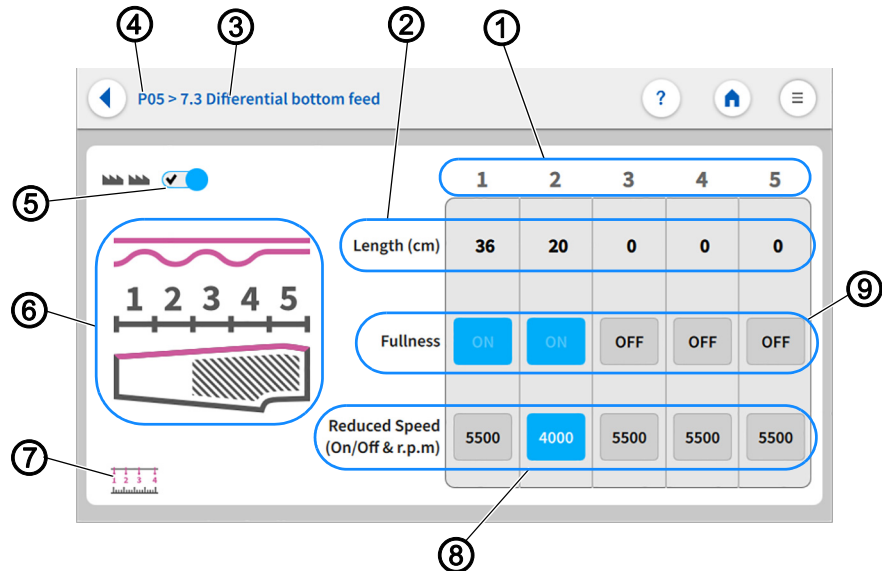
Parameters for adjusting the 7.3 Differential bottom feed.



Important

When processing knee lining and incorporating fullness, always make sure the knee lining is at the bottom!

Fig. 66: Setting options for the differential bottom feed



- | | |
|---------------------------------------|---|
| (1) - Seam sections 1-5 | (6) - Graphic Fullness Distribution |
| (2) - Seam Length | (7) - Reference Dimension |
| (3) - Parameter | (8) - Input of reduced speed and reduced speed ON/OFF |
| (4) - Program number | (9) - Fullness |
| (5) - Differential bottom feed ON/OFF | |


The entire seam can be divided in up to 5 seam sections (1). Parameters can be set independently for each section.

- The seam length (2) is set in the measuring unit: cm.
- The fullness (9) can be switched ON/OFF.
- The reduced sewing speed (8) can be switched ON/OFF.
- The Reduced Speed (8) is set in the measuring unit: RPM and can only be adjusted within the range of values.



To enter the seam length:

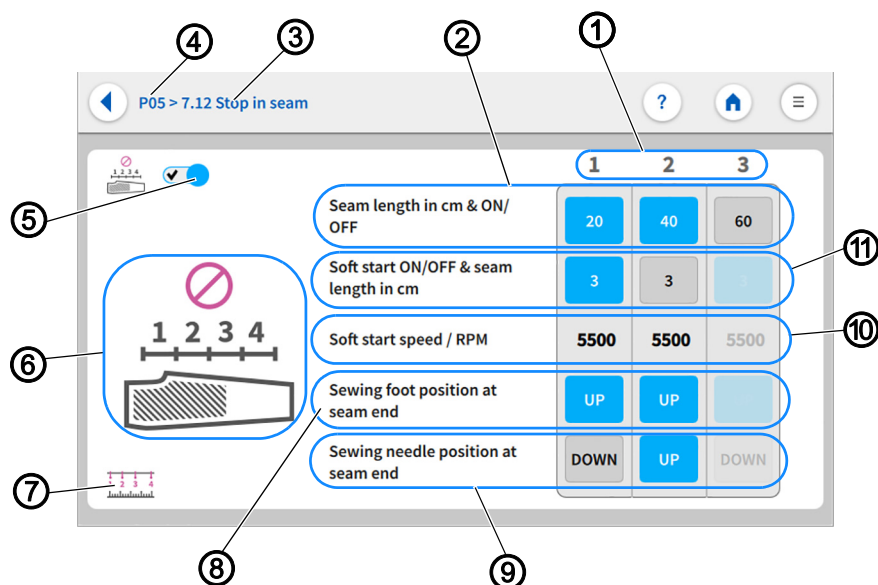
1. Set Differential bottom feed to ON (5).
- ☞ Only if the Differential bottom feed is switched on can the settings on the user interface Differential bottom feed be adjusted.

2. In seam section 1 (1), briefly press the numerical value for the *Seam Length* (2).
 - ↳ The field is activated, and the integrated keyboard opens.
3. Enter the desired seam length (2) in the active field.
4. Press *Ok*.
 - ↳ The numerical value is stored, and the display switches back.
5. In seam section 1 (1), set the *Fullness* (9) to ON/OFF.
 - ↳ If the appearing field is blue, the function is enabled.
 - ↳ If the appearing field is gray, the function is disabled.
6. In the corresponding seam section 1 (1), set the *Reduced Speed* (8) to ON/OFF.
 - ↳ If the appearing field is blue, the function is enabled.
 - ↳ If the appearing field is gray, the function is disabled.
7. Press and hold the active field in *Reduced Speed* (8).
 - ↳ The integrated keyboard opens.
8. Enter the desired sewing speed within the specified value range.
9. Press *Ok*.
 - ↳ The numerical value is stored, and the display returns to the previous interface.
10. Repeat the steps 1-9 for each seam section 1-5 (1).
11. Press on the symbol .
 - ↳ This opens the program parameters page.

5.14.11 Setting options for stop in seam

7.12 Stop in seam is used, for example, for attaching labels to the seam. For this purpose, the machine stops at the desired seam point, and the label or similar can be added manually. The automatic sewing process can then be restarted.

Fig. 67: Setting options for stop in seam



- | | |
|----------------------------------|---------------------------------|
| (1) - Sewing stop 1-3 | (7) - Reference Dimension |
| (2) - Seam Length | (8) - Sewing foot position |
| (3) - Parameter | (9) - Needle position |
| (4) - Program number | (10) - Soft start sewing speed |
| (5) - Switch stop in seam On/Off | (11) - Soft start sewing length |
| (6) - Graphic | |

You can set up to 3 sewing stops (1) along the entire seam. This equals 4 seam sections. The reference dimension (7) serves as a graphical aid, indicating how these seam sections are measured. Setting the sewing foot position (8)/needle position (9) to UP/DOWN at the end of the seam makes it possible to turn the material within the seam without activating thread chain cut. The parameters can be adjusted separately for each seam length (2).

- The seam length (2) can be switched ON/OFF.
- The seam length (2) is set in the measuring unit: cm and can only be adjusted within the range of values.
- The soft start seam length (11) can be switched ON/OFF.
- The soft start seam length (11) is set in the measuring unit: cm.
- The soft start sewing speed (10) is set in the measuring unit: RPM and can only be adjusted within the range of values.
- The sewing foot position (8) can be set to UP/DOWN at the seam end.
- The needle position (9) can be set to UP/DOWN at the seam end.



To enter the seam length:

1. Set **Stop in seam** to ON (5).
 - ↳ Only if **Stop in seam** is switched on can the settings on the user interface **Stop in seam** be adjusted.
2. At sewing stop 1 (1), briefly press the numerical value for the seam length (2).
 - ↳ If the appearing field is blue, the function is enabled.
 - ↳ If the appearing field is gray, the function is disabled
3. Press and hold the active numerical value for the seam length (2).
 - ↳ The integrated keyboard opens.
4. Enter the desired seam length (2) in the active field.
5. Press **Ok**.
 - ↳ The numerical value is stored, and the display returns to the previous interface.
6. Briefly press soft start sewing length (11).
 - ↳ If the appearing field is blue, the function is enabled.
 - ↳ If the appearing field is gray, the function is disabled.
7. Press and hold the active numerical value for the soft start sewing length (11).
 - ↳ The integrated keyboard opens.
8. Enter the desired soft start sewing length within the specified value range.
9. Press **Ok**.
 - ↳ The numerical value is stored, and the display returns to the previous interface.
10. Briefly press soft start sewing speed (10)
 - ↳ The integrated keyboard opens.
11. Enter the desired soft start sewing speed within the specified value range.
12. Press **Ok**.
 - ↳ The numerical value is stored, and the display switches back.
13. Set the sewing foot position at seam end (8) to UP(blue)/DOWN(gray).
14. Set the sewing need position at seam end (9) to UP(blue)/DOWN(gray).
15. Repeat steps 1-14 for each desired seam section 1-3 (1).
16. Press on the symbol .
 - ↳ This opens the program parameters page.



5.15 Sequence programming

The machine includes 40 sequences which the user can customize with programs.



Information

Sequence programming allows the user to add programs to or remove programs from a particular sequence.

It is not possible to create or delete a sequence.

5.15.1 Sequence programming user interface

Fig. 68: Sequence programming user interface (1)

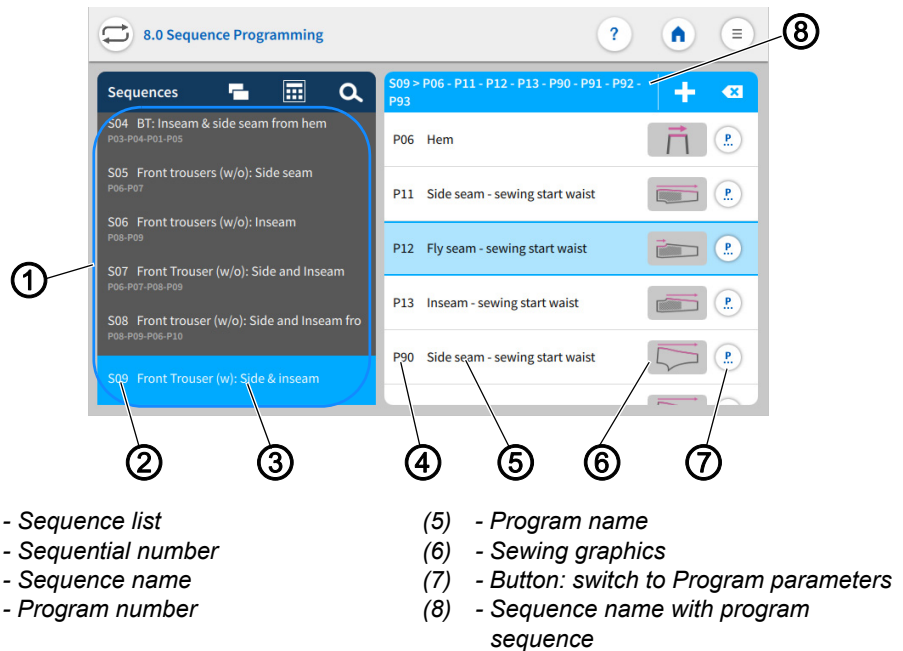
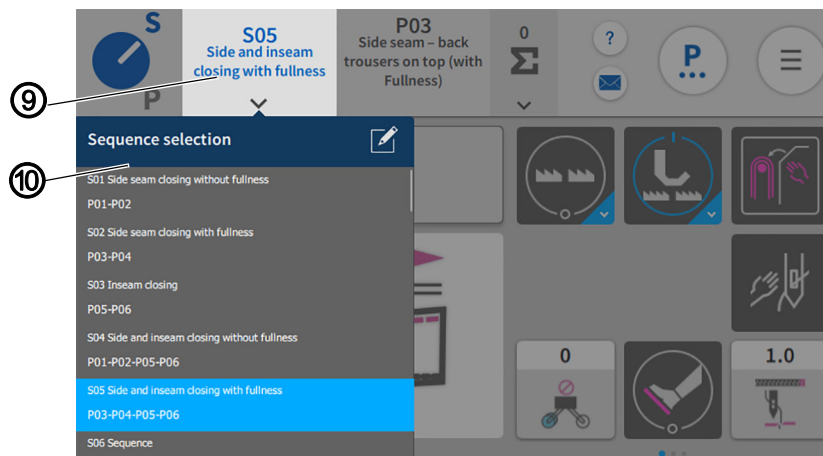


Fig. 69: Sequence programming user interface (2)



(9) - Sequence name

(10) - Sequence selection




To access the function Sequence Programming:

- Select the tile Sequence name (9) in the status bar on the main page.

1. Press the tile Sequence name (9).


↳ The list holding the Sequence selection (10) opens.

2. Press on the symbol .

↳ The user interface Sequence Programming opens.

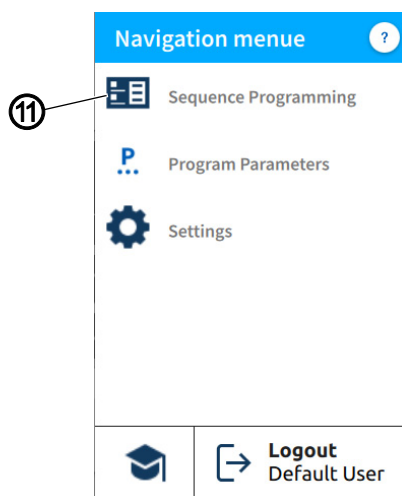
or:

- Via the navigation menu.

1. Press the symbol  to bring up the navigation pane

↳ This opens the navigation interface.

Fig. 70: Sequence programming user interface (3)



(11) - Sequence Programming



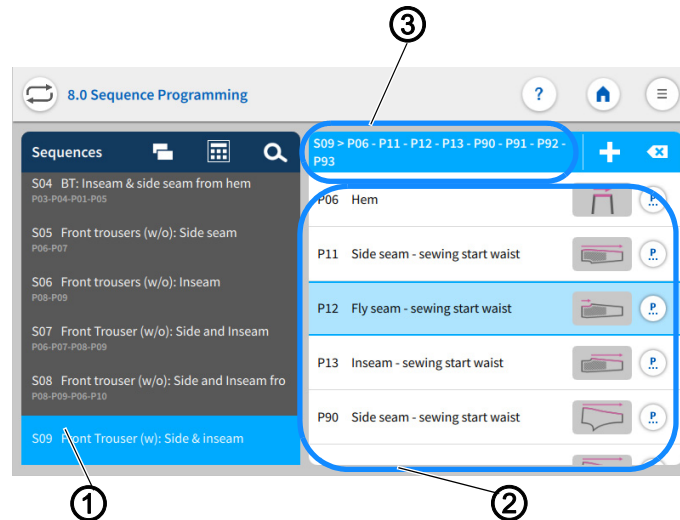
2. Press Sequence Programming (11).

↳ The user interface Sequence Programming opens.

5.15.2 Programs in the sequence

Overview of the programs contained in the active sequence.

Fig. 71: Programs in the sequence



(1) - Sequence
(2) - Programs

(3) - Sequence

The sequence (1) is set to active in the sequence list. Shown on the right is the sequence (3) including the entire program sequence. The corresponding programs (2) are listed underneath.

5.15.3 Adding programs to a sequence



Information

A sequence can never be empty and must always contain at least one program

One sequence can be composed of up to 14 programs.

It is possible to add multiple programs at one time.

The grid view contains a color indication for the programs. This color indication can help with the selection of the programs (see table Color indicators in grid view).

Color indicators in grid view




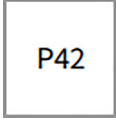
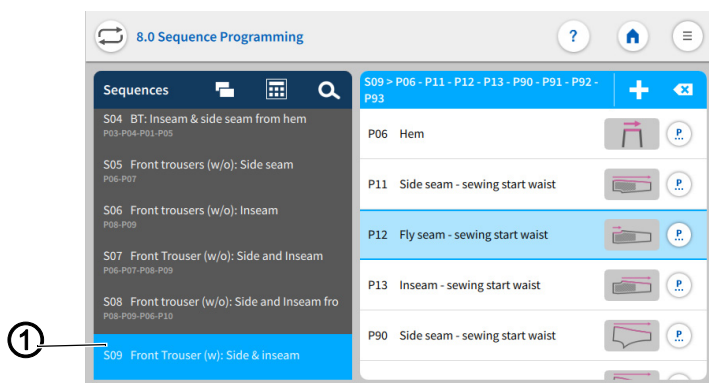
	Used in one/multiple sequences
	User in the current sequence
	Modified, but not used in any sequence.
	Not modified and not used.

Fig. 72: Adding/removing programs (1)



(1) - Sequence



To add programs to a sequence:


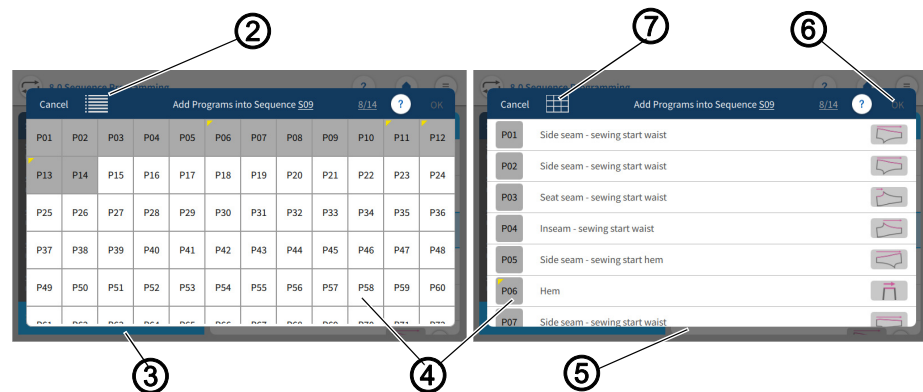
1. Select the desired sequence (1) in the sequence list.
↳ The sequence (1) is set to active.
2. Press on the symbol .
- ↳ A user interface opens showing the program overview with all 200 programs in grid view (3).
- ↳ In grid view (3), only the program number (4) is visible.

Fig. 73: Adding/removing programs (2)

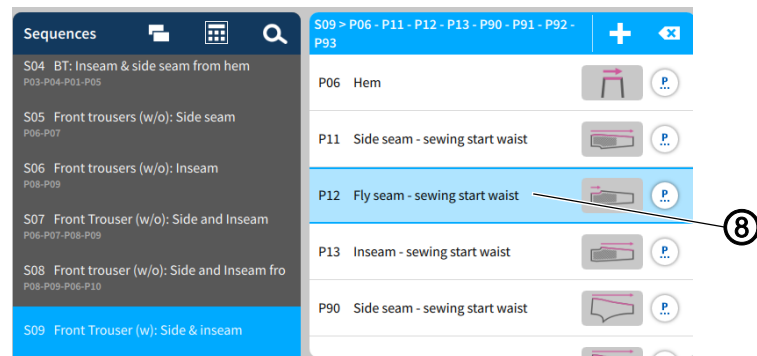


- (2) - Symbol
 (3) - Grid view
 (4) - Program number
 (5) - List view
 (6) - OK
 (7) - Symbol



3. The symbol (2) allows the user to switch to list view (5).
- ↳ The list view (5) shows the program number (4), the name and the sewing graphics.
4. The symbol (7) allows the user to return to grid view (3).
5. Select program.
- ↳ The selected program number is set to active.
6. Press OK.
- ↳ The program is adopted, and the display switches back.

Fig. 74: Adding/removing programs (3)



(8) - Program

- ↳ The program (8) you added is now included in the program list.

5.15.4 Removing a program from the sequence



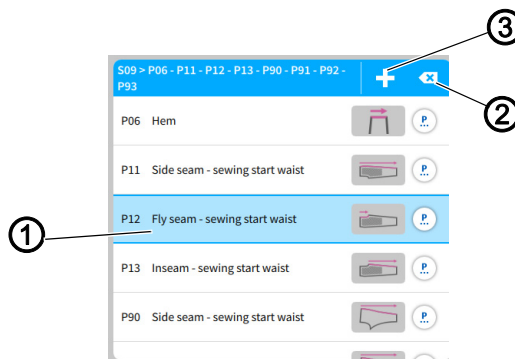
If a user attempts to add more than 14 programs to a sequence, a warning notice ⚠ will be displayed. This notice will prompt the user to remove existing programs in order to add new ones!



To remove a program from a sequence:

1. Select the program (1) you wish to remove in the sequence list.
 ↳ The program (1) is activated.

Fig. 75: Removing a program from the sequence




(1) - Program

(2) - Symbol





(3) - Symbol



2. Briefly press the symbol (2) .
 ↳ The program (1) is deleted from the current sequence without warning.



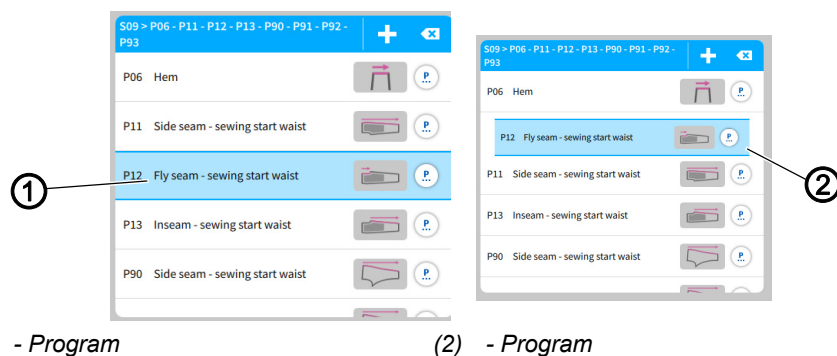
To remove all programs from a sequence:

1. Perform a long press of the symbol (2) .
 ↳ A warning reading  Confirm "Remove All" appears!
 A sequence should contain at least one program.
 Click "Remove All" to remove all programs and add new ones or click "Cancel" to go back.
2. Press Cancel/Remove All.
 ↳ Cancel: the user returns to the user interface Sequence Programming.
 ↳ Remove All: Warning notice  Removed last program appears.
3. Press Add new program.
 ↳ The grid view for programs opens.
4. Select the program you wish to add ( p. 109).
5. Press OK.
 ↳ The program is adopted, and the display switches back.

5.15.5 Program position

The order of the programs in a sequence can be moved quickly up/down.

Fig. 76: Program position



(1) - Program

(2) - Program



To move a program:




1. Select the program (1) you wish to move.
- ↳ The program (1) is activated.
2. Perform a long press of the program (1).
- ↳ The program (2) detaches from the list.
3. Use your finger to drag the program (2) up/down.
4. Release your finger at the desired position.
- ↳ The program (2) settles in at the new position.

5.15.6 Sequence search

When on the *Sequence Programming* user interface, the user can search for specific sequence numbers or sequence names.



To access the function Sequence search.





1. Press the symbol  to bring up the navigation pane.
- ↳ This calls up the user interface with a search field in the sequence list, an overview of the program sequence and an integrated keyboard.
- You can use the keyboard to enter a sequence number or the sequence number.
- You can select a sequence directly by scrolling.
- ↳ The sequence appears and is highlighted in blue.
2. Press **Close**.
3. Exit sequence search with a press of the  symbol.
- ↳ The user interface *Sequence Programming* appears ( p. 107).

5.15.7 Copying sequences

This option lets the user copy the content of a sequence to one or multiple sequences.



To copy sequences.

1. Select the sequence list you wish to copy in the sequence list.
↳ The sequence is highlighted in blue.
2. Press on the symbol .
- ↳ A window opens showing all sequences including their programs.
3. Activate the desired variant with a press of the  symbol.
4. Confirm with OK.
- ↳ A warning notice reading  Kindly confirm Copy appears.
Sequence from (e.g.) S28 will be copied and cannot be recalled!
5. Press Cancel /Copy Sequence.
- ↳ Cancel: the user returns to the user interface Sequence Programming.
- ↳ Copy Sequence: a warning notice appears reading
 Copied-Sequence copied successfully.
6. Press OK.
- ↳ The program sequence is adopted into the new sequence, and the display returns to the previous interface.



Important

The copied program sequence also contains your quick access configuration!

5.16 Quick access panel

The quick access panel is composed of a grid for 3x3 tiles that is spread over three pages. This provides space for 27 placeholders. The required parameters can be grouped individually and matched with the programs held in a sequence.

5.16.1 Configuration of the quick access icons

This option lets the user configure the quick access icons found on the main screen.



Important

Before they can be used, the parameters for quick access must be switched **ON** in the machine configuration!

It is not necessary to populate every grid.



To access the configuration of the quick access icons:


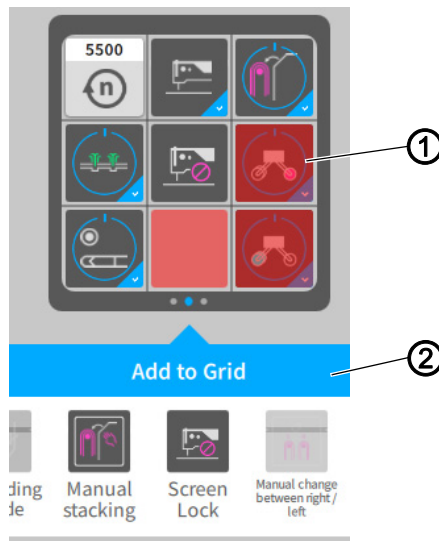
1. Call up the user interface *Sequence Programming*.
 - Use the status bar on the main page to select the tile *Sequence name* (p. 107).
 - Via the navigation menu (p. 107).
 2. On the user interface *Sequence Programming*, press on the symbol .
- ✎ The user interface for the configuration of the *Quick Access Icons* opens.

Fig. 77: Configuration of the quick access icons (1)



(1) - Tile shaded red

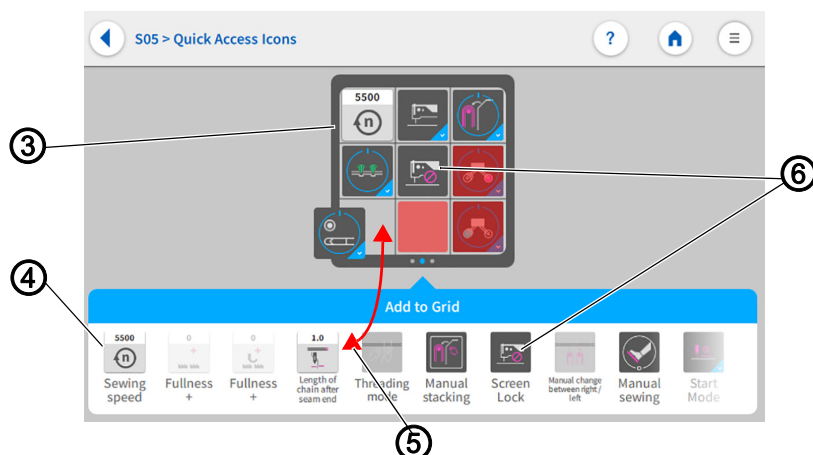
(2) - Bottom bar



Parameters that have not been selected in the machine configuration or that are inactive will not be shown as a tile on the main screen. The red tile will be shaded red (1) on the user interface *Quick Access Icons*.

If dragged and dropped in the bottom bar (2), the red shaded tile (1) will be **set to invisible** for the user.

Fig. 78: Configuration of the quick access icons (2)




- | | |
|-------------------------------|--|
| (3) - Grid of the main screen | (5) - Drag and drop (Drag & Drop function) |
| (4) - Bar (of possible tiles) | (6) - Tile |

All active parameters are contained as tiles (6) in the bottom bar (4).



To configure the tile for quick access:

1. Swipe right/left in the bar (4) to select the desired tile (6).
2. Press and hold the tile (6) in the bar (4).
- ↳ The tile (6) detaches from the bar (4).
3. Use drag & drop (5) to move the tile (6) out of the bar (4) and into the grid (3) at the desired position.
4. Or vice versa: Use drag & drop (5) to move the tile (6) from the grid (3) into the bar (4).
5. Keep repeating the process until all tiles have been moved to the desired position.
6. Press on the symbol .
7. The settings are adopted, and the display returns to Sequence Programming.

5.17 Using manual data transfer

Use this option to transfer data between the machine (or, more precisely, the control panel) and a USB key.

The 1.7 Manual Data Transfer allows you to select different options.

- Exporting data
- Importing data

Programs cannot be imported or exported by the `Default User`. This process requires that the user be logged in as a Technician (📖 p. 81).

A USB key is used to transfer and store the machine software. It is recommended to use a USB key purchased from Dürkopp-Adler.

The USB key makes it possible to transfer program and parameter data to other machines as well.

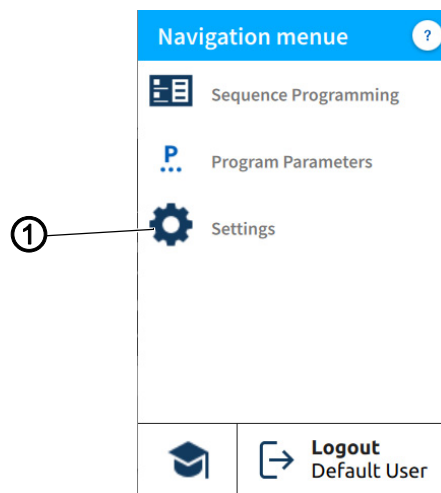
5.17.1 Exporting data



To export data:

1. Connect the USB key at the control panel.
2. Press the symbol to bring up the navigation pane
↳ This opens the navigation interface.

Fig. 79: Exporting data (1)

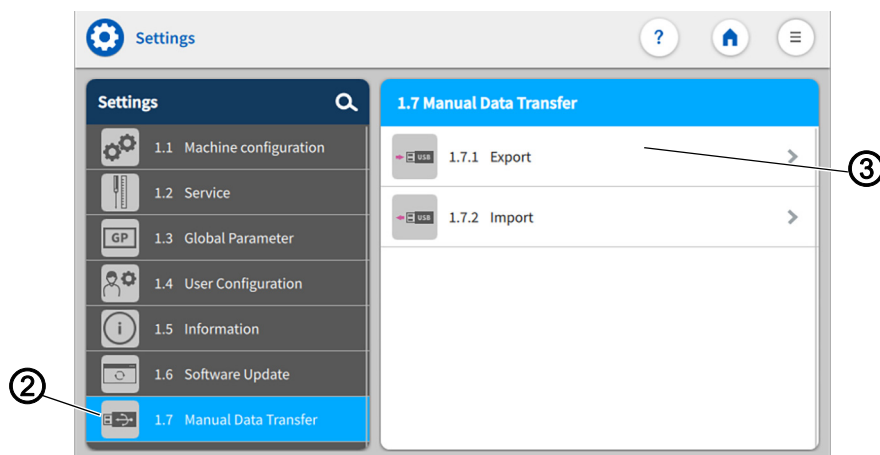


(1) - Settings



3. Press Settings (1).
↳ This opens the Settings interface.


Fig. 80: Exporting data (2)



(2) - Symbol Manual Data Transfer

(3) - Export



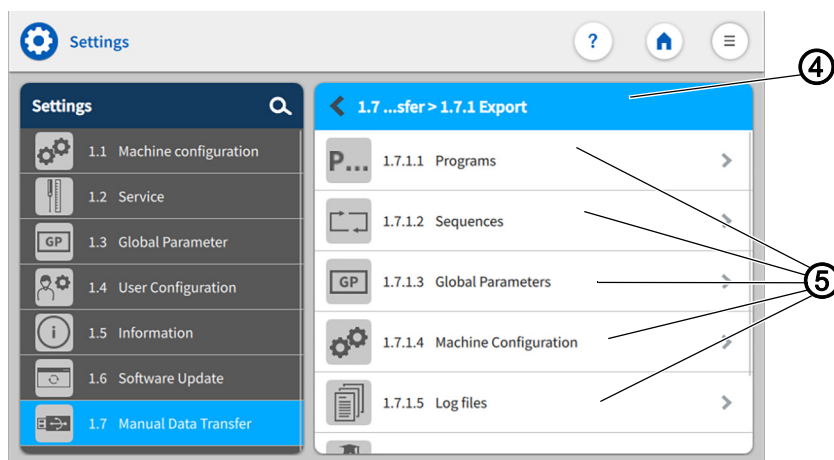
4. Press the symbol  of the Manual Data Transfer (2).

↳ The interface for the Manual Data Transfer opens on the right.

5. Press Export (3).

↳ The export list (4) containing the application data (5) opens on the right.

Fig. 81: Exporting data (3)



(4) - Export list

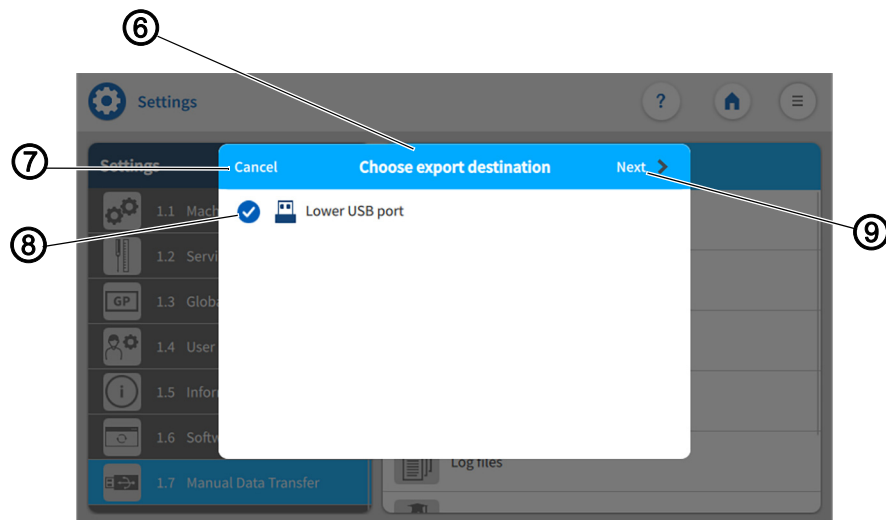
(5) - Application data



6. Select and press an application file (5).

↳ The window Choose export destination (6) opens.

Fig. 82: Exporting data (4)

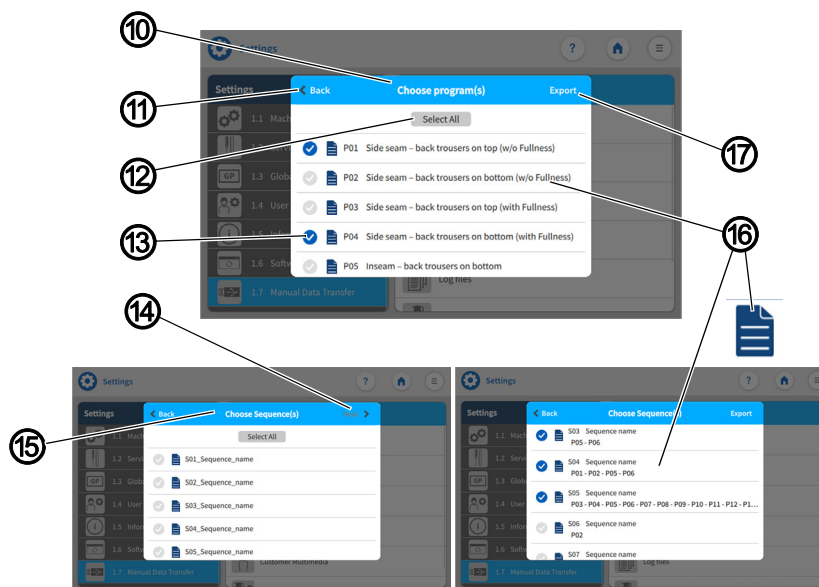


- (6) - Window Choose export destination (8) - Activate
 (7) - Cancel (9) - Next page



7. Activate the export destination (8)
8. Press Cancel (7).
 - ↳ The display returns to the previous interface.
9. Press Next page (9).
 - ↳ The export process continues.
 - ↳ The interface of the selected application file (5) that lets you choose:
 - Program (10)
 - Sequence (15)
 - Global Parameters
 - Machine Configuration
 - Log files
 - Customer Multimedia
 - Vendor Multimedia
 opens.

Fig. 83: Exporting data (5)



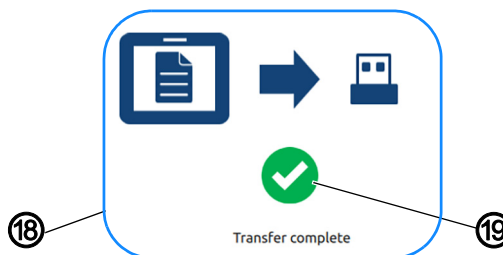
- (10) - Application file Program
(11) - Back
(12) - Select All
(13) - Activate

- (14) - Next page
(15) - Application file Sequence
(16) - File
(17) - Export



10. Select and activate (13) one / multiple files (16).
 - The **Select All** option is used to activate (13) all files (16) contained in the window.
 - You can set individual files (16) to inactive again.
11. When in the application file Sequences (15), the user can press **Next page** (14).
- ↳ You can activate (13) additional files (16).
12. Press **Back** (11)
- ↳ The display returns to the previous interface.
13. Press **Export** (17).
- ↳ A new window (18) opens.

Fig. 84: Exporting data (6)



(18) - Window

(19) - Symbol



14. When the symbol (19) appears,
 - ↳ the transfer has been completed successfully

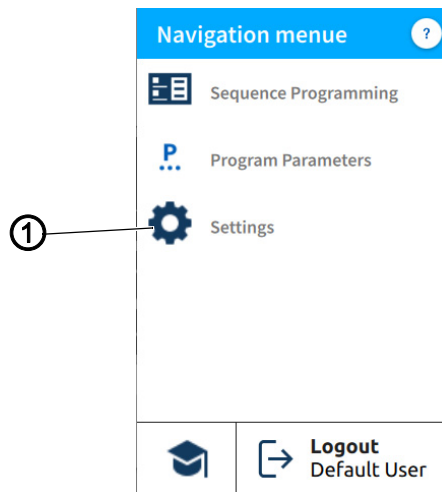
5.17.2 Importing data



To import data:

1. Connect the USB key at the control panel.
 2. Press the symbol to bring up the navigation pane
- ↳ This opens the navigation interface.

Fig. 85: Importing data (1)

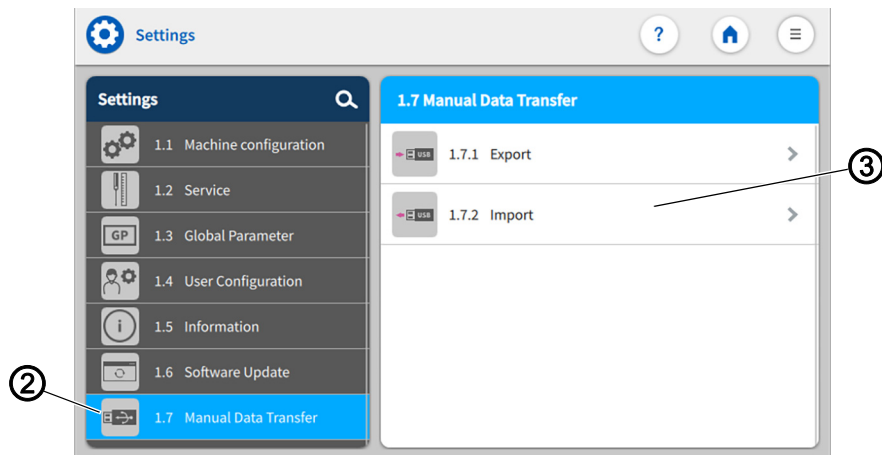


(1) - Settings



3. Press Settings (1).
- ↳ This opens the Settings interface.

Fig. 86: Importing data (2)



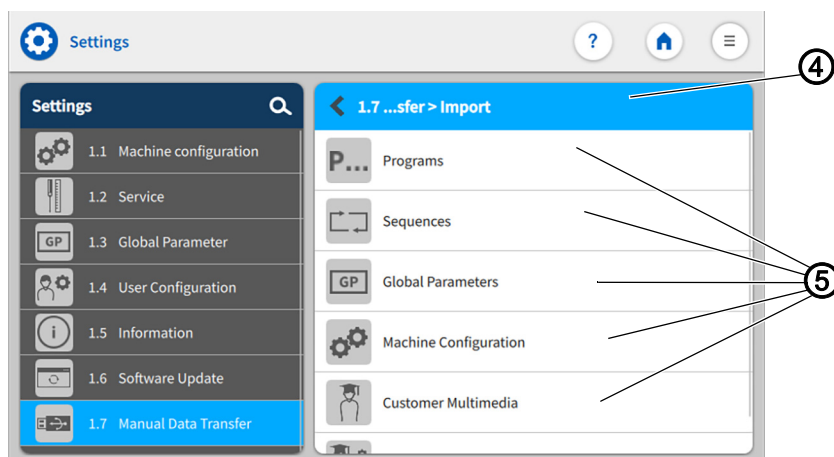
(2) - Symbol Manual Data Transfer

(3) - Import



4. Press the symbol of the Manual Data Transfer (2).
- ↳ The interface for the Manual Data Transfer opens on the right.
5. Press Import (3).
- ↳ The import list (4) containing the application data (5) opens on the right.

Fig. 87: Importing data (3)



(4) - Import list

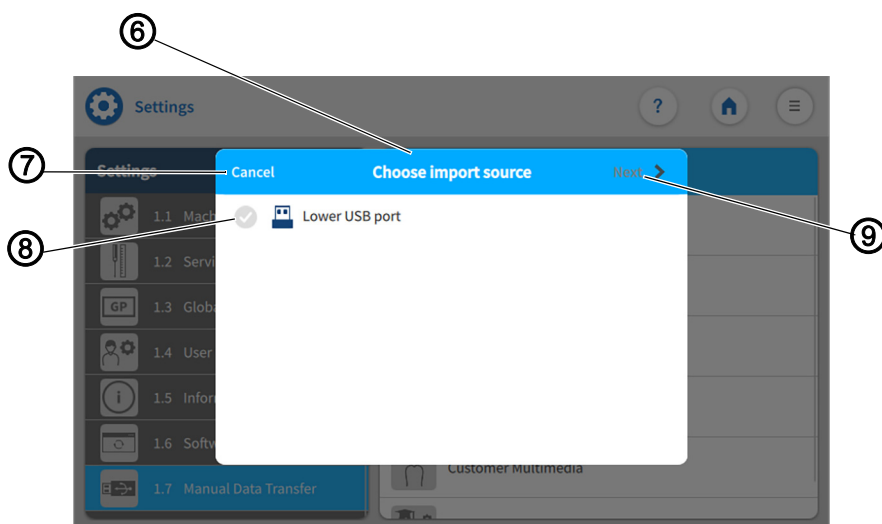
(5) - Application data



6. Select and press an application file (5).

↳ The window Choose import source (6) opens.

Fig. 88: Importing data (4)



(6) - Window Choose import source

(8) - Activate

(7) - Cancel

(9) - Next page



7. Activate the import source (8)

8. Press Cancel (7).

↳ The display returns to the previous interface.

9. Press **Next page** (9).
- ↳ The import process continues.
- ↳ The interface of the previously selected application file (5) that lets you choose
 - Program (10)
 - Sequence (15)
 - Global Parameters
 - Machine Configuration
 - Log files
 - Customer Multimedia
 - Vendor Multimedia
 opens.

Fig. 89: Importing data (5)



(10) - Application file Program

(11) - Back

(12) - Select All

(13) - Activate

(14) - Next page

(15) - Application file Sequence

(16) - File

(17) - Import



10. Select and activate (13) one / multiple files (16).

- The **Select All** option is used to activate (13) all files (16) contained in the window.
- You can set individual files (16) to inactive again.

11. When in the application file Sequences (15), the user can press **Next page** (14).

- ↳ You can activate (13) additional files (16).

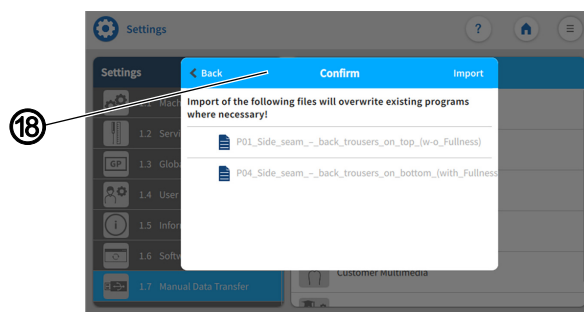
12. Press **Back** (11)

- ↳ The display returns to the previous interface.

13. Press **Import** (17).

- ↳ The window **Confirm** (18) opens.

Fig. 90: Importing data (6)



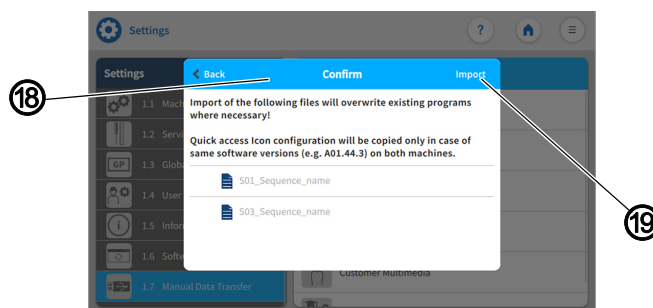
(18) - Window Confirm



The following information is given to the user:

Import of the following files will overwrite existing programs where necessary.

Fig. 91: Importing data (7)



(19) - Import



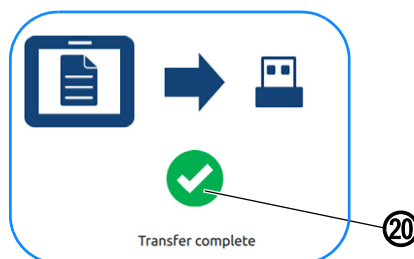
If in the application file (5) of the sequences (15), the user will be given the following additional information:

Quick access icon configuration will be copied only in case of same software version on both machines.

14. Press Import (19).

A new window opens.

Fig. 92: Importing data (8)



(20) - Symbol



15. When the symbol (20) appears,
the transfer has been completed successfully

**Important**

When the import is complete, restart the control panel to check if all imported configurations are compatible.

5.18 Software update for the control panel

**Note the order of software updates for the control panel and controls:**


1. Update the control panel.
2. Update the controller.

A USB stick is required for a software update.

When a new software version is available, it can be downloaded at www.duerkopp-adler.com and be uploaded from a USB key (it is recommended to use a USB key purchased from Dürkopp-Adler). All settings on the machine are retained.


**Information**


For the security of your data, we recommend:

- Before the software update, back up your program data and create a backup ( p. 117).
- To download the new version, use an empty USB stick.



To perform a software update:

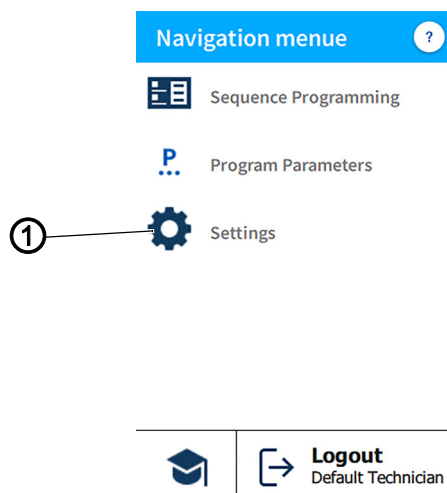
1. Download the latest/desired software version from Dürkopp Adler's website.
2. Save the software version to a USB key.
3. Plug the USB key into the port on the control panel.
4. Press the symbol  to bring up the navigation panel.

 This opens the navigation interface.

**Important**

For this process, the user must be logged in as a *technician* ( p. 81).

Fig. 93: Performing a software update (1)



(1) - Settings


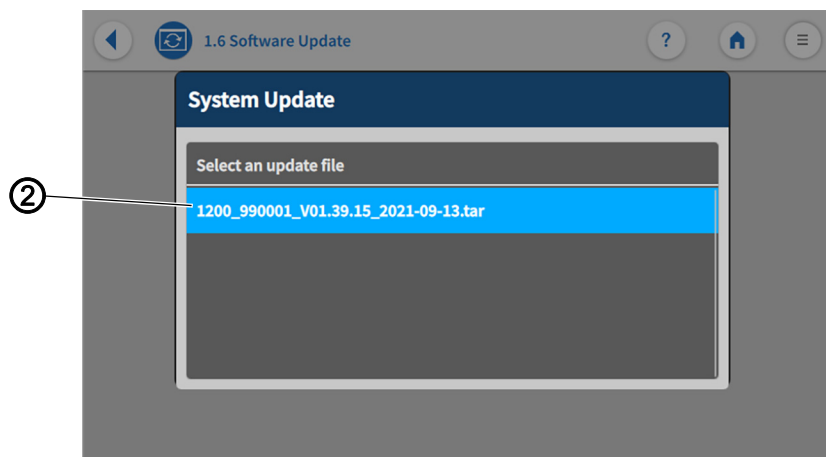
5. Press Settings (1).
6. This opens the Settings interface.
7. Open the menu Settings (1) and press the Software Update  option.
- A window listing the files (2) stored on the USB key opens.

Fig. 94: Performing a software update (2)



(2) - File

8. Select the file (2) containing the software update.
- Another window opens.
9. To start the software update, press on the Start Update button.
10. Wait until advised that the USB key can be removed/that the control panel was restarted.
11. Once the control panel has been restarted, the machine can be used again.
12. The USB key can now be removed.

**Important**

If the restart of the control panel fails, the control requires a software update using the dongle designated for this purpose by Dürkopp Adler.

Abb. 95: Dongle



5.19 Software update for the control

**Note the order of software updates for the control panel and controls:**

1. Update the control panel.
2. Update the controller.

The software of the DAC basic/classic and the standard parameters of the machine can be updated.

A software update requires a dongle and the separate utility program Dongle Copy.

This additional equipment is available on homepage www.duerkopp-adler.com

**Information**

For the security of your data, we recommend:

- Before the software update, back up your program data and create a backup (📖 p. 117).



Observe the correct order when performing the software for the controller update:

1. Check installed software version (📖 p. 128)
2. Switch off the control (📖 p. 128)
3. Download new/desired software version from the Dürkopp-Adler homepage.
4. Perform the software for the controller update (📖 p. 129).

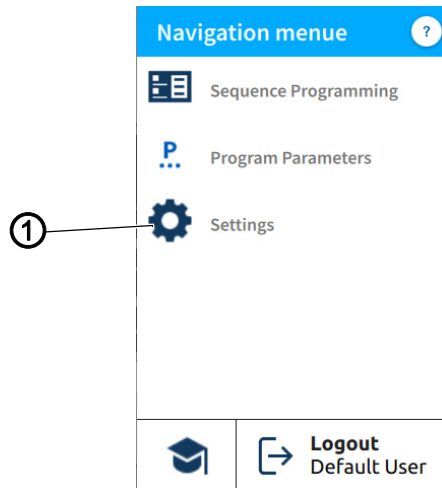
5.19.1 Checking the version



To check the installed software version:

1. Press the symbol to bring up the navigation pane.
- ↳ This opens the navigation interface.

Fig. 96: Software update for the control (1)



(1) - Settings



2. Press Settings (1).
- ↳ This opens the Settings interface.
3. Open the menu Settings (1) and press the Information option.
- ↳ Different symbols are shown in the submenu on the right side (p. 61).
4. Press the symbol Software Version.
- ↳ The software version of the control panel is displayed.
- ↳ The software version of the machine is displayed.

5.19.2 Switching off the control

You can now switch off the control to perform the update.



Important

Do not perform the update if the installed version is newer than the version stored on the dongle.

NOTICE

You can use the Dongle Copy utility to find out which version is stored on the dongle.

5.19.3 Performing a software update

CAUTION



The dongle will overwrite the installed software version!

Loss of data.

Check the version of the installed software before completing the software update.



Important

Before beginning with the update, make sure that the control is switched off (📖 p. 128).



To perform a software update:

1. Insert the dongle with the downloaded software into the controller..
2. Switch on the control.

↳ The two LEDs on the control (POWER and MESSAGE) flash.

↳ When the update is complete, the two LEDs on the control will stop flashing.

- The POWER LED illuminates green.
- The MESSAGE LED is off.

CAUTION



Control malfunction if dongle is removed prematurely!

Loss of data.

Do not remove the dongle until the control is switched off the machine.

3. When the update is complete, switch off the machine at the main switch (📖 p. 15) and wait until the LED light strip (📖 p. 45) on the control panel goes out.
4. Remove the dongle.
5. Switch on the machine again at the main switch (📖 p. 15).
- ↳ The machine starts up.
- ↳ The start screen is displayed.
6. Go to the user interface *Settings* (📖 p. 57) on the touch display and open *Information* (📖 p. 61) to check the *Software Version*.

6 Maintenance

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.

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.

Maintenance intervals

Work to be carried out	Operating hours			
	8	40	160	500
Machine head				
Remove sewing dust and thread residues	●			
Check oil level		●		
First oil change			●	
Subsequent oil changes	every 2 years			
Control box				
Remove sewing dust and thread residues	●			
Air suction device				
Empty container	●			
Remove any sewing dust and thread residues below the sliding plate		●		
Pneumatic system				
Check the water level in the pressure regulator	●			
Clean the filter element in the maintenance unit.				●
Check the tightness of the system	●			

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.

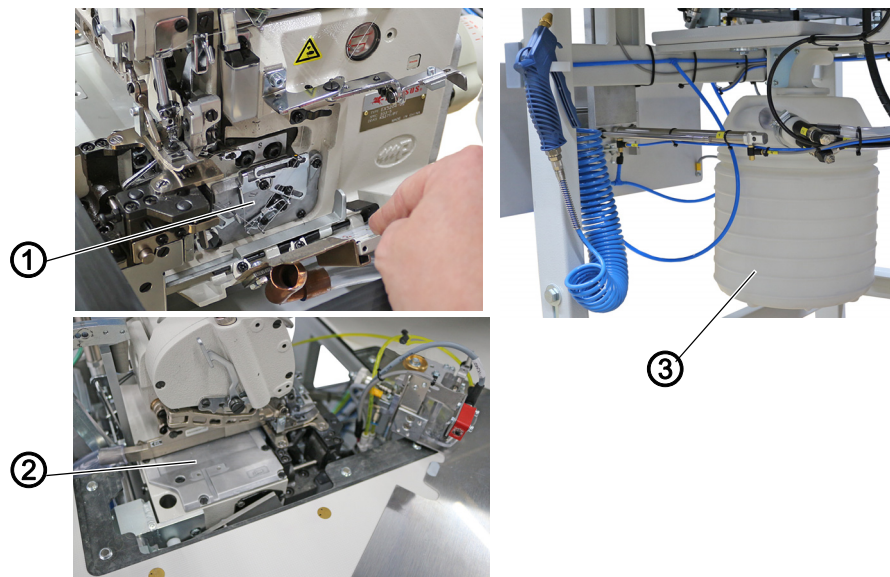
NOTICE

Property damage from solvent-based cleaners!

Solvent-based cleaners will damage paintwork.

Use only solvent-free substances for cleaning.

Fig. 97: Cleaning



(1) - Thread guides

(2) - Under the fabric sliding plate

(3) - Suction container



To clean the machine:

1. Switch off the machine at the main switch.
2. Use a compressed air gun to blow out the entire area around the thread guides (1).
3. Use a compressed air gun to blow out the entire area under the fabric sliding plate (2).
4. Remove and empty the suction container (3).

6.2 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 oil!

Oil is a pollutant and must not enter the sewage system or the soil.

Carefully collect up used oil.

Dispose of used oil and oily machine parts in accordance with national regulations.

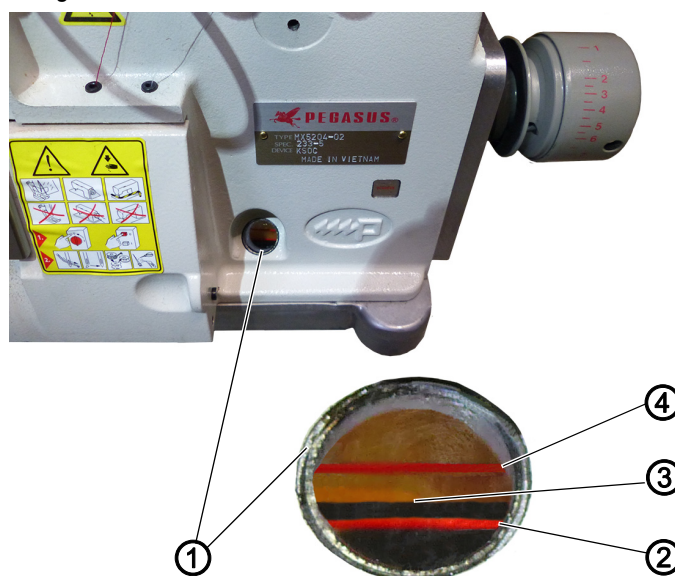
The machine is equipped with a central lubrication system. The bearings are supplied from the oil reservoir.

Information on refilling and the specification of the oil used is provided in the separately included operating Instructions of the sewing head manufacturer (📖 *Operating Instructions Machine Head*).

- Mobile Velcocite Oil No10

6.2.1 Checking the lubrication of the machine head

Fig. 98: Checking the lubrication of the machine head



- (1) - Inspection glass
(2) - Minimum level marking

- (3) - Oil level
(4) - Maximum level marking



Proper setting

The oil level (3) is between the minimum level marking (2) and the maximum level marking (4).

To check the lubrication of the machine head:



1. Check the oil level indicator (3) at the inspection glass (1) every day.
2. Refill oil if the oil level (3) drops to/below the minimum level marking (2) (📖 *Operating Instructions Machine Head*).

6.3 Servicing the pneumatic system

6.3.1 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.

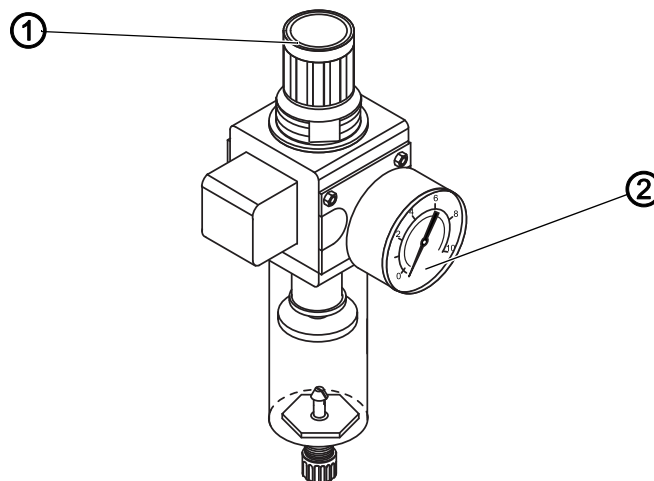


Proper setting

Refer to the **Technical Data** (📖 p. 159) 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. 99: 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.

6.3.2 Draining the water condensation

NOTICE

Property damage from excess water!

Excess water can cause damage to the machine.

Drain water as required.

Water condensation accumulates in the water separator (2) of the pressure regulator.

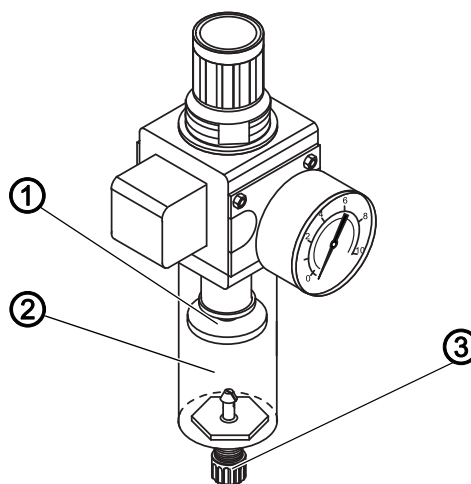


Proper setting

Water condensation must not rise up to the level of the filter element (1).

Check the water level in the water separator (2) on a daily basis.

Fig. 100: Draining the water condensation



(1) - Filter element

(2) - Water separator

(3) - Drain screw



To drain water condensation:

1. Disconnect the machine from the compressed air supply.
2. Place the collection tray under the drain screw (3).
3. Loosen the drain screw (3) completely.
4. Allow water to drain into the collection tray.
5. Tighten the drain screw (3).
6. Connect the machine to the compressed air supply.

6.3.3 Cleaning the filter element

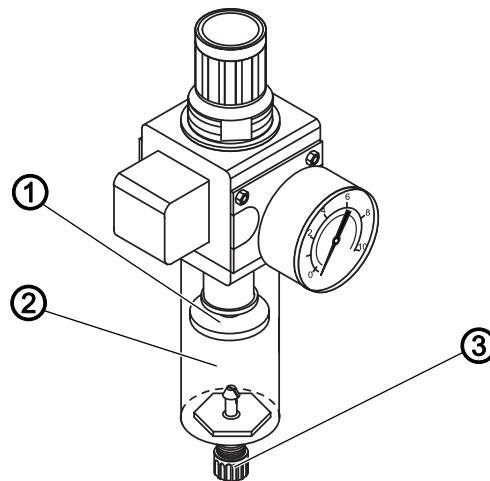
NOTICE

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. 101: Cleaning the filter element



(1) - Filter element
(2) - Water separator

(3) - Drain screw



To clean the filter element:

1. Disconnect the machine from the compressed air supply.
2. Drain the water condensation (📖 p. 136).
3. Loosen the water separator (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 water separator (2).
9. Tighten the drain screw (3).
10. Connect the machine to the compressed air supply.

6.4 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 cutting parts!

Cutting injuries may be sustained while unpacking and setting up the machine.

Only qualified specialists may set up the machine.
Wear safety gloves

WARNING



Risk of injury from moving parts!

Crushing injuries may be sustained while unpacking and setting up the machine.

Only qualified specialists may set up the machine.
Wear safety shoes.

7.1 Checking the scope of delivery

The scope of delivery depends on your specific order. Check that the scope of delivery is correct after taking delivery.

7.2 Removing the transport locks

Remove all transport locks before setting up the machine:

- Protective films
- Lashing straps on reel stand and stand
- Lashing strap on the flip stacker

7.3 Adjusting the working height

WARNING



Risk of injury from moving parts!

The tabletop can sink under its own weight when the screws on the stand bars are loosened. Crushing possible.

Ensure that your hands are not jammed when loosening the screws.

CAUTION

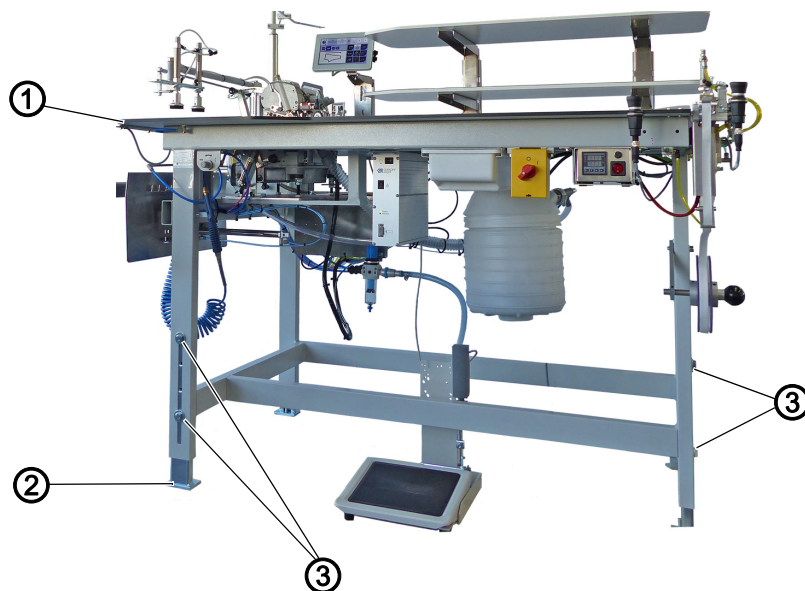


Risk of musculoskeletal damage from incorrect setting!

The operator can sustain musculoskeletal damage if failing to comply with the ergonomic requirements.

Adjust the working height to the body height of the person who will operate the machine.

Fig. 102: Adjusting the working height (1)

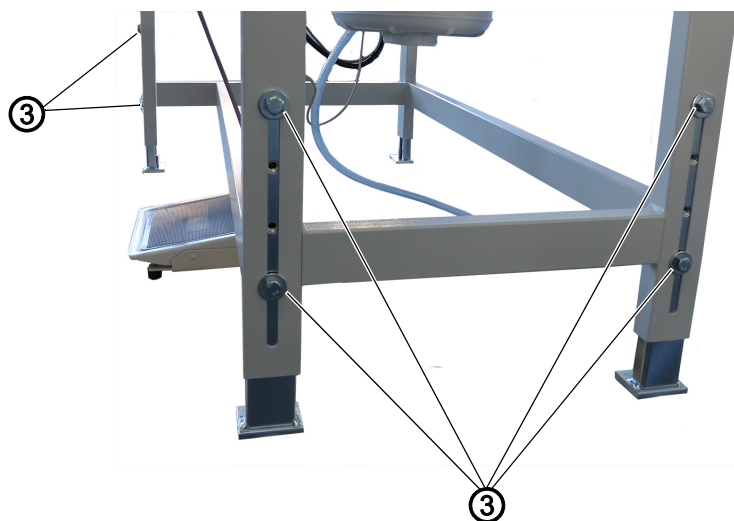


(1) - Upper edge of the tabletop

(2) - Floor

(3) - Screws

The working height can be adjusted between 850 mm and 1200 mm. The distance is measured from the upper edge of the tabletop (1) to the floor (2).

Fig. 103: Adjusting the working height (2)

(3) - Screws



To adjust the working height:

1. Loosen the screws (3) on the stand bars.
2. Adjust the tabletop to the desired height.



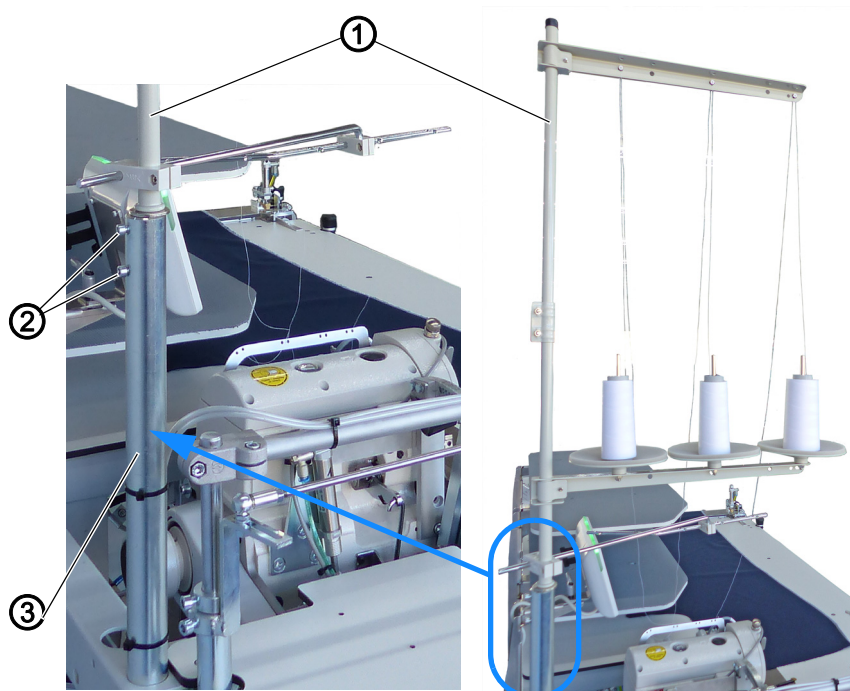
Important

Pull out or push in the tabletop evenly at both sides to prevent it from jamming.

3. Tighten the screws (3).

7.4 Assembling the reel stand

Fig. 104: Assembling the reel stand



(1) - Reel stand tube
(2) - Screws

(3) - Holder

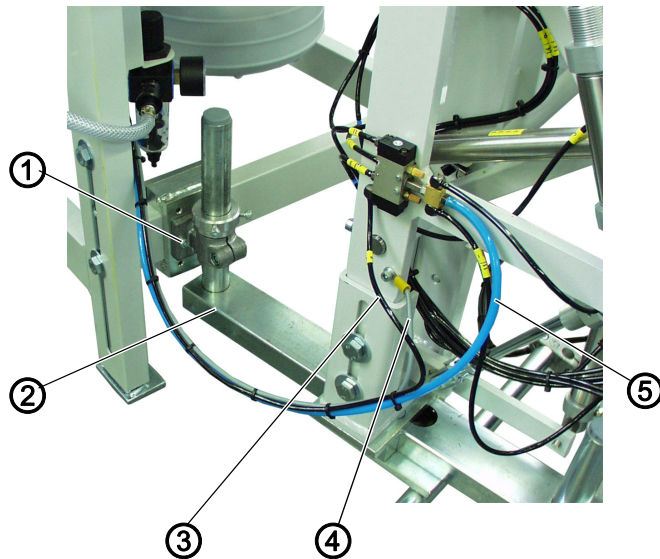


To assemble the reel stand:

1. Insert the reel stand tube (1) into the holder (3).
2. Tighten the screws (2).

7.5 Assembling the flip stacker

Fig. 105: Assembling the flip stacker (1)



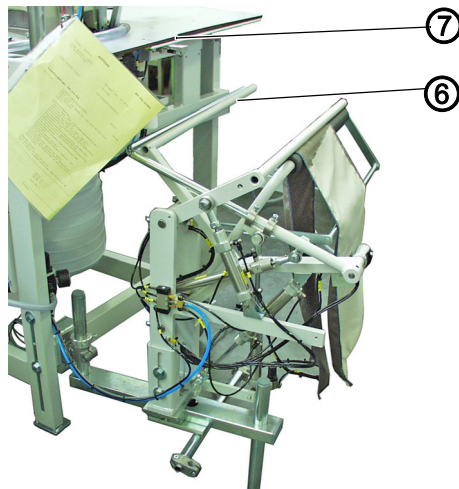
- | | |
|---------------------------|---------------------------|
| (1) - Screws | (4) - Grounding wire |
| (2) - Holder | (5) - Compressed air line |
| (3) - Compressed air line | |



To assemble the flip stacker:

1. Move the flip stacker with holder (2) up to the machine.
2. Tighten the holder (2) to the machine using the screws (1). Do not tighten the screws (1) all the way yet.

Fig. 106: Assembling the flip stacker (2)



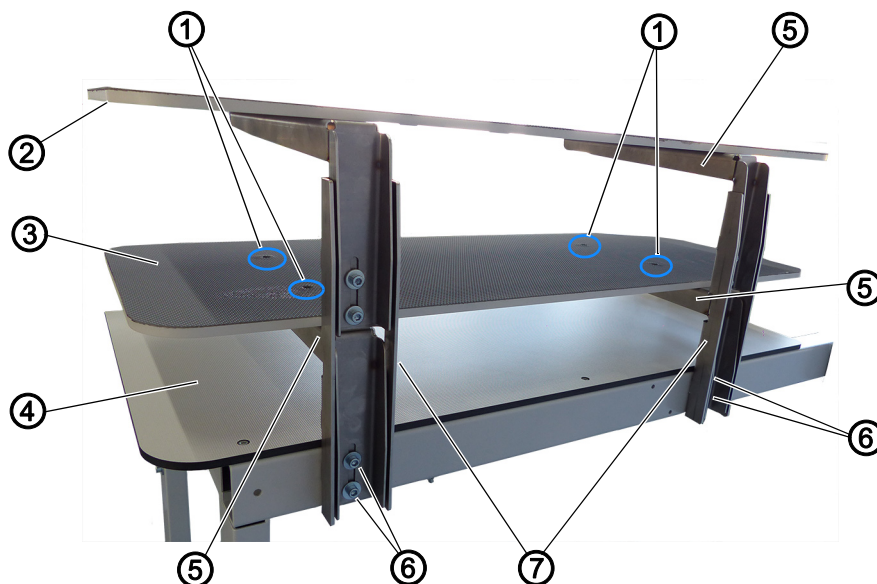
- | | |
|----------------|----------------------------|
| (6) - Smoother | (7) - Edge of the tabletop |
|----------------|----------------------------|



3. Align the flip stacker such that the smoother (6) is parallel to the edge of the tabletop (7).
4. Tighten the screws (1).
5. Tighten the grounding wire (4) to the flip stacker.
6. Fit compressed air lines (3) and (5) onto the distributor.

7.6 Assembling the delivery table

Fig. 107: Assembling the delivery table



- | | |
|----------------------------|------------------------|
| (1) - Screws | (5) - Support brackets |
| (2) - Upper delivery table | (6) - Screws |
| (3) - Lower delivery table | (7) - Track |
| (4) - Sewing table | |

The base model machine is equipped with the lower delivery table (3). The additional option with a dual delivery table is complemented by the upper delivery table (2).



To assemble the delivery table:

1. Slide the support brackets (5) into the track (7) from the direction of the sewing table (4).
2. Tighten the screws (6).
3. Repeat the steps 1. to 2. for the 2nd side.
4. Place the lower delivery table (3) on the support brackets (5).
5. Tighten the screws (1).
6. To assemble the upper delivery table (2), repeat the steps 1. to 5.

Aligning the delivery table



To align the delivery table:

7. Loosen the screws (6)
8. Adjust the delivery table (2) to the desired height.

9. Tighten the screws (6).
10. To align the upper delivery table (2), repeat the steps 7. to 9.

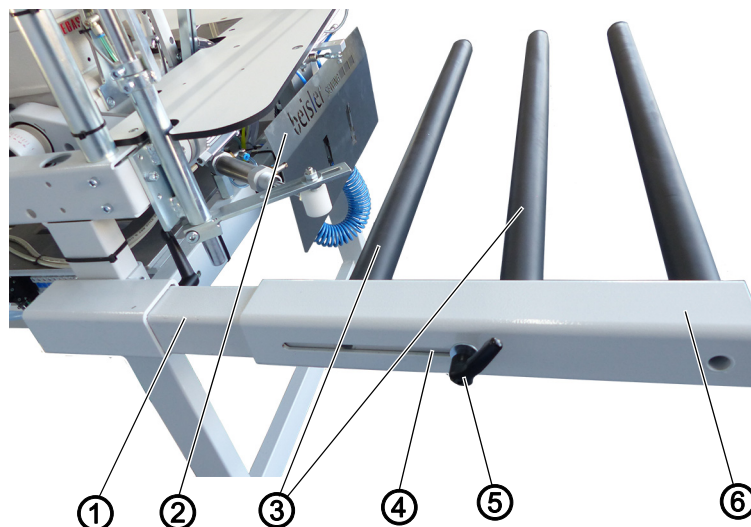


Important

Move the delivery table (2)/(3) on both sides at the same time to keep it from slanting.

7.7 Assembling the tray extension

Fig. 108: Assembling the tray extension



- | | |
|------------------------|----------------------|
| (1) - Holder | (4) - Slot |
| (2) - Clamping stacker | (5) - Lever |
| (3) - Dual tray | (6) - Tray extension |

By default, the base mode machine is equipped with the dual tray (3) for the clamping stacker (2). An additional arm can be added as a tray extension (6) if the sewing material is large/long.



To assemble the tray extension:

1. Slide the tray extension (6) onto the holder (1).
2. Set the tray extension to the desired distance.
 - The minimum/maximum distance is preset by the slot (4).
3. Use the lever (5) to lock the tray extension (6) in place on the holder (1).

7.8 Electrical connection

DANGER



Risk of death from live components!

Unprotected contact with electricity can result in serious injuries or death.

Only qualified specialists may perform work on electrical equipment.



Important

The voltage on the type plate of the sewing motor must correspond to the mains voltage.

Establishing the electrical connection



To establish the electrical connection:

1. Connect the power plug.

7.9 Pneumatic connection

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.

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.

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 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.

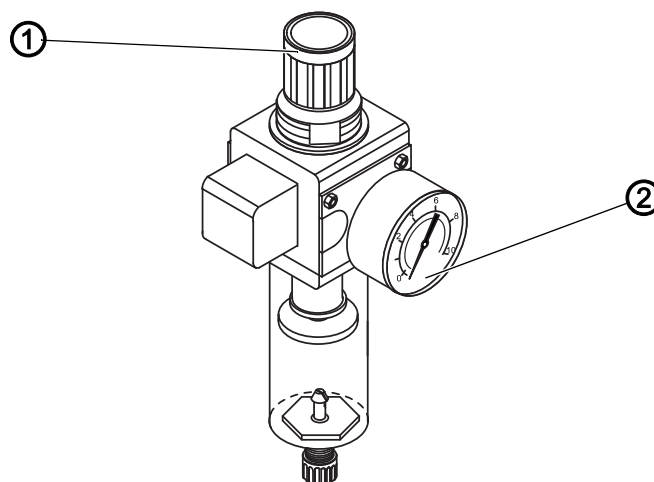


Proper setting

Refer to the **Technical Data** ( p. 159) 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. 109: 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 Performing a test run

When setup is complete, perform a test run to check the functionality of the machine.

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. Wipe up and 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 of 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.

Three groups of messages

Group	Description
Error	Serious error. Switch off the control and eliminate the error.
Warning	Eliminate the cause of the warning. The control will operate normally.
Information	Press the OK button. Operation can continue. It is possible that only emergency operating features will be available.

Error, warning and information messages

Group	Number	Description	Remedial action
Error	1000	Sewing motor encoder plug X5B (Sub-D, 9-pin) not connected	<ul style="list-style-type: none"> • Connect encoder cable to the control • Use correct connection
Error	1001	Sewing motor error Sewing motor plug (AMP) not connected	<ul style="list-style-type: none"> • Check connection and plug in, if necessary • Test sewing motor phases (R= 2.8Ohm, high impedance to PE) • Replace sewing motor • Replace the control
Error	1002	Sewing motor insulation error	<ul style="list-style-type: none"> • Check motor phase and PE for low-impedance connection • Replace sewing motor
Error	1004	Incorrect sewing motor direction of rotation	<ul style="list-style-type: none"> • Replace sewing motor • Check motor plug assignment and change it if necessary • Check wiring in machine distributor and change it, if necessary • Measure motor phases and check for value
Error	1005	Motor blocked	<ul style="list-style-type: none"> • Remedy creep in the sewing machine
Error	1006	Maximum speed exceeded	<ul style="list-style-type: none"> • Replace sewing motor • Carry out a reset • Check machine class
Error	1008	Sewing motor encoder error	<ul style="list-style-type: none"> • Replace sewing motor
Error	1011	Encoder Z pulse missing	<ul style="list-style-type: none"> • Switch off the control. Turn handwheel and switch on the control again. • If error is not corrected, replace sewing motor.
Error	1052	Sewing motor overcurrent, internal current rise > 25A	<ul style="list-style-type: none"> • Replace control unit
Error	1053	Sewing motor overcurrent	<ul style="list-style-type: none"> • Replace control unit
Error	1054	Internal short circuit	<ul style="list-style-type: none"> • Replace the control
Error	1055	Sewing motor overload	<ul style="list-style-type: none"> • Remedy creep in the machine • Replace sewing motor
Error	3100	AC-RDY timeout, DC link voltage has not reached the defined threshold.	<ul style="list-style-type: none"> • Check mains voltage • If mains voltage is OK, replace control unit.
Error	3101	High voltage error, mains voltage > 290V for a long time.	<ul style="list-style-type: none"> • Check mains voltage • Stabilize the mains voltage
Error	3102	Low voltage error (2 nd threshold) (mains voltage < 150V AC)	<ul style="list-style-type: none"> • Check mains voltage • Stabilize the mains voltage
Information	3103	Low voltage warning (1 st threshold) (mains voltage < 180V AC)	<ul style="list-style-type: none"> • Check mains voltage • Stabilize the mains voltage
Warning	3104	Pedal is not in position 0	<ul style="list-style-type: none"> • Take your foot off the pedal when switching on the controller • Check the pedal setting

Group	Number	Description	Remedial action
Error	3105	U24V short circuit	<ul style="list-style-type: none"> • Disconnect 37-pin plug, if error 3105 persists, replace control unit. • Test inputs/outputs for 24V short circuit
Error	3106	U24V (I ² T) overload	<ul style="list-style-type: none"> • One or more of the magnets defective
Information	3107	Foot pedal not connected	<ul style="list-style-type: none"> • Connect pedal to enable starts by foot pedal and intermediate stops.
Information	3108	Speed limited due to insufficient mains voltage	<ul style="list-style-type: none"> • Check mains voltage
Information	3150	Maintenance required	<ul style="list-style-type: none"> • For information on lubricating the machine, see the machine's service manual.
Warning	3151	Maintenance required	<ul style="list-style-type: none"> • Service must be carried out. See the machine's service manual.
Error	6353	Communication error internal EEPROM	<ul style="list-style-type: none"> • Switch off the control unit, wait until the LEDs have gone out, switch on the control unit.
Error	6354	Communication error external EEPROM	<ul style="list-style-type: none"> • Switch off the control unit, wait until the LEDs have gone out, check the machine ID connection. Switch the control unit on again.
Information	6360	No valid data on external EEPROM	<ul style="list-style-type: none"> • Software update
Information	6361	No external EEPROM connected	<ul style="list-style-type: none"> • Connect machine ID
Information	6362	No valid data on internal EEPROM	<ul style="list-style-type: none"> • Check machine ID connection • Switch off the control, wait until the LEDs are off and then switch on again. • Software update.
Information	6363	No valid data on internal and external EEPROM (emergency operating features only)	<ul style="list-style-type: none"> • Check machine ID connection • Switch off the control unit, wait until the LEDs are off and then switch on again. • Software update
Information	6364	No valid data on internal EEPROM and external EEPROM not connected (emergency operating features only)	<ul style="list-style-type: none"> • Check machine ID connection • Switch off the control unit, wait until the LEDs are off and then switch on again. • Software update
Information	6365	Internal EEPROM defective	<ul style="list-style-type: none"> • Replace the control
Information	6366	Internal EEPROM defective and external data not valid (emergency operating features only)	<ul style="list-style-type: none"> • Replace the control
Information	6367	Internal EEPROM defective and external EEPROM not connected (emergency operating features only)	<ul style="list-style-type: none"> • Replace the control
Information	7801	Software version error	<ul style="list-style-type: none"> • Software update • Replace control unit

Group	Number	Description	Remedial action
Information	7802	Software update error	<ul style="list-style-type: none"> • Repeat software update • Replace control unit
Error	8401	Watchdog	<ul style="list-style-type: none"> • Perform a software update on the control unit • Replace the control unit
Error	8402	Internal error	<ul style="list-style-type: none"> • Perform a software update on the control unit • Replace the control unit
Error	8501	Software protection	<ul style="list-style-type: none"> • The DA tool must always be used for the software update.
Warning	9400	Start photocell is occupied	<ul style="list-style-type: none"> • Release the start photocell
Information	9923	Control panel software is not updated	<ul style="list-style-type: none"> • Update the software of the control panel
Warning	9947	Machine shuts down!	<ul style="list-style-type: none"> • Check power supply • Switch on the machine
Information	9948	You have reached your number!	<ul style="list-style-type: none"> • You have reached your desired number - please enter a new value for the piece counter.
Information	9949	No connection between control and control panel	<ul style="list-style-type: none"> • Check plug connection of cable between control panel and control box • Replace cable between control box and control panel • Update the software of the control box • Update the software of the control panel • Change control box • Change control panel
Information	9950	Control box software is not updated	<ul style="list-style-type: none"> • Update Control box software
Information	9951	Check Foot Pedal	<ul style="list-style-type: none"> • Attention: Make sure that a pedal is connected to the machine and activate pedal in machine configuration 1.1.6.

10.3 Errors in sewing process

Error	Possible causes	Remedial action
Unthreading at seam beginning	Needle thread tension is too firm	Check needle thread tension
Thread breaking	Needle thread and hook thread have not been threaded correctly	Check threading path
	Needle is bent or sharp-edged	Replace needle
	Needle is not inserted correctly into the needle bar	Insert the needle correctly into the needle bar
	The thread used is unsuitable	Use recommended thread
	Thread tensions are too tight for the thread used	Check thread tensions
	Thread-guiding parts, such as thread tube, thread guide or thread take-up disk, are sharp-edged	Check threading path
	Throat plate, hook or spread have been damaged by the needle	Have parts reworked by qualified specialists
Skip stitches	Needle thread and hook thread have not been threaded correctly	Check threading path
	Needle is blunt or bent	Replace needle
	Needle is not inserted correctly into the needle bar	Insert the needle correctly into the needle bar
	The needle thickness used is unsuitable	Use recommended needle thickness
	The reel stand is assembled incorrectly	Check the assembly of the reel stand
	Thread tensions are too tight	Check thread tensions
	Throat plate, hook or spread have been damaged by the needle	Have parts reworked by qualified specialists

Error	Possible causes	Remedial action
Loose stitches	Thread tensions are not adjusted to the sewing material, the sewing material thickness or the thread used	Check thread tensions
	Needle thread and hook thread have not been threaded correctly	Check threading path
Needle breakage	Needle thickness is unsuitable for the sewing material or the thread	Use recommended needle thickness

11 Technical data

Geräuschentwicklung

Workstation-specific emission value according to DIN EN ISO 10821:

LpA = 81 dB (A) at

- Stitch length: 3 mm
- Seam length: 1160 mm
- Speed: 7000 r/min
- Material: G1 DIN 23328, 1-layer

Measuring point according to DIN 4895 Part 1:

X = 600 mm, Y = 350 mm, Z = 600 mm

x-axis = at right angles to the feeding direction

y-axis = main feeding direction

z-axis = height

11.1 Data and characteristic values

Technical data	Unit	1200-7
Machine type		Single head serging unit
Stitch type		503 2-thread/504 3-thread
Hook type		Chainstitch hook crosswise to the sewing direction overlock hook
Number of needles		1
Needle system		B27
Needle strength	[Nm]	80 - 110
Thread strength	[Nm]	100-120
Stitch length	[mm]	1-3.8
Speed maximum	[min ⁻¹]	8000
Speed on delivery	[min ⁻¹]	7300
Seam distance	[mm]	4, 5, 6, 8
Sewing material		light/medium/heavy
Mains voltage	[V]	1x230 V
Mains frequency	[Hz]	50/60
Operating pressure	[bar]	6
Length	[mm]	1500
Width	[mm]	900
Height	[mm]	1400

Technical data	Unit	1200-7
Weight	[kg]	120
Rated power	[kVA]	0.9
Power input	[kV]A	0.9

11.2 Requirements for fault-free operation

Compressed air quality must conform to ISO 8573-1: 2010 [7:4:4].

11.3 Recommended threads

Needle system: B27

Recommended needle thickness:

- Nm 80 for extra thin sewing material
- Nm 90 for thin sewing material
- Nm 100 for moderately heavy sewing material
- Nm 110 for heavy sewing material

High sewing security and good sewability are achieved with the following core spun threads:

- Two-ply polyester endless polyester core-spun (e.g. Epic Poly-Poly, Rasant x, Saba C, ...)
- Two-ply polyester endless polyester core-spun (e.g. Frikka, Koban, Rasant, ...)

If these threads are not available, the polyester fiber or cotton threads listed in the table can also be sewn.

Often two-ply core spun threads are offered by the thread manufacturers with the same description as three-ply polyester fiber threads (3cyl.-spun). This causes uncertainty with regard to twisting and thread thickness.

When in doubt, unravel the thread and check whether it is twisted 2- or 3-ply. The label no. 120 on the thread reel of a core spun thread corresponds e.g. to the thread size Nm 80/2 (see table values in brackets).

In case of monofilament threads you can use needle threads and hook threads of the same thickness. The best results are achieved with soft and elastic threads (software) of the thread thickness 130 Denier.

Recommended thread thicknesses

Needle thickness Nm	Core spun thread		Core spun thread	
	Needle thread	Hook thread	Needle thread	Hook thread
	Polyester - endless Label no.	Polyester - core spun Label no.	Polyester - endless Label no.	Cotton - core spun Label no.
80 90 100-110	120 (NM 80/2) 100 (Nm 65/2)	120 (NM 80/2) 100 (Nm 65/2)	120 (NM 80/2) 100 (Nm 65/2)	120 (NM 80/2) 100 (Nm 65/2)
Needle thickness Nm	Polyester filament thread (3cyl.-spun)		Cotton thread	
	Needle thread	Hook thread	Needle thread	Hook thread

Needle thickness Nm	Core spun thread		Core spun thread	
80 90 100-110	Nm 120/3 Nm 80/3-120/3 Nm 70/3-100/3	Nm 120/3 Nm 80/3-120/3 Nm 70/3-100/3	NeB 60/3-80/3 NeB 50/3-70/3 NeB 40/3-60/3 (1NeB = 1.6934 Nm)	NeB 60/3-80/3 NeB 50/3-70/3 NeB 40/3-60/3 (1NeB = 1.6934 Nm)



DÜRKOPP ADLER GmbH
Potsdamer Str. 190
33719 Bielefeld
Germany
Phone: +49 (0) 521 925 00
Email: service@duerkopp-adler.com
www.duerkopp-adler.com