



755 A, B
756 A, B, F

Additional Instructions

Programmable marking lamps

**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 2023

1	General information	3
2	Conversion.....	4
2.1	Disassembling parts	4
2.2	Assembling parts	6
2.2.1	Labeling the cables.....	6
2.2.2	Assembling the programmable marking lamps.....	7
2.2.3	Connecting the programmable marking lamps	8
2.2.4	Assembling the PCB.....	10
2.2.5	Connecting the PCB	11
2.2.6	Adjusting the marking lamps	12
2.3	Adjusting the horizontal programmable marking lamp.....	12
2.4	Adjusting the vertical programmable marking lamp.....	14
3	Software settings.....	16
3.1	Activation in the machine configuration	16
3.2	Settings in the Program parameters area.....	18
3.3	Settings in the Machine test area	23
3.3.1	Programmable marking lamps test (vertical)	25
3.3.2	Programmable marking lamps adjustment (vertical)	26
3.3.3	Programmable marking lamps test (horizontal).....	27
3.3.4	Programmable marking lamps adjustment (horizontal)	28
4	Appendix	29

1 General information

The programmable vertical/vertical marking lamps are used for the automatic or manual switch during the sewing of preset pocket openings. As it can be corrected individually in the program, the position of the marking lamps can be adjusted to different positioning points via fine adjustment, eliminating the need for an individual mechanical adjustment during a model change.

Components of the kit

Check whether the scope of delivery for kit 0755 590434 VES / 0755 590444 VES is correct prior to installation.

Kit 0755 590434 VES

Part number	Quantity	Description
0755 590434	1	vertical progr. marking lamp
0755 591714	1	Dual SM card
0791 755702 EN	1	Additional Instructions

Kit 0755 590444 VES

Part number	Quantity	Description
0755 590444	1	horizontal progr. marking lamp
0755 591714	1	Dual SM card
0791 755702 EN	1	Additional Instructions

Information



The version 756-F equipped with the option Automatic Flap Stopper does NOT allow for the use of the horizontal programmable marking lamp.

2 Conversion

DANGER



Risk of injury from laser light!

Risk of sustaining eye damage and going blind.

NEVER look into the laser light source.

DANGER



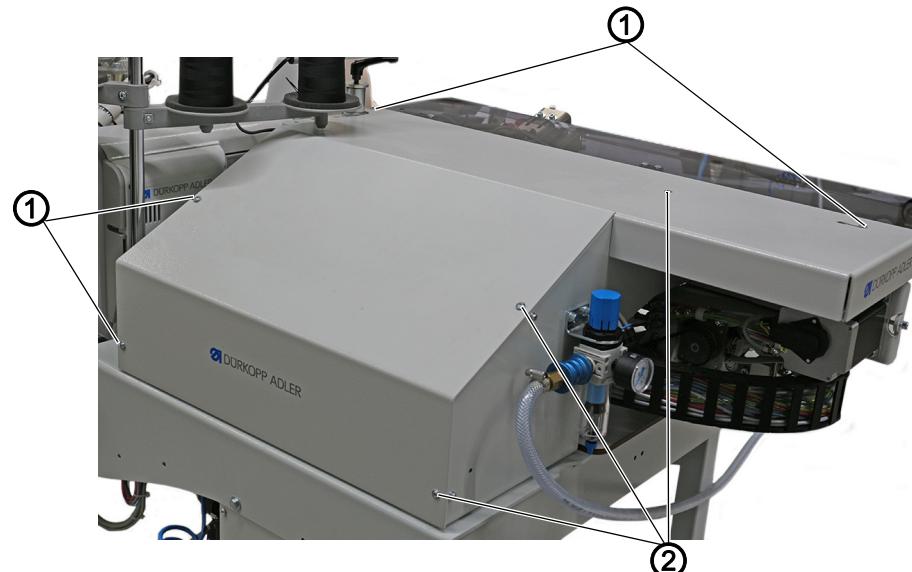
Risk of death from live components!

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

Only qualified specialists may perform work on electrical equipment. Switch off the machine and disconnect it from the power supply before working on live components.

2.1 Disassembling parts

Fig. 1: Disassembling parts (1)



- (1) - Screws
(2) - Screws

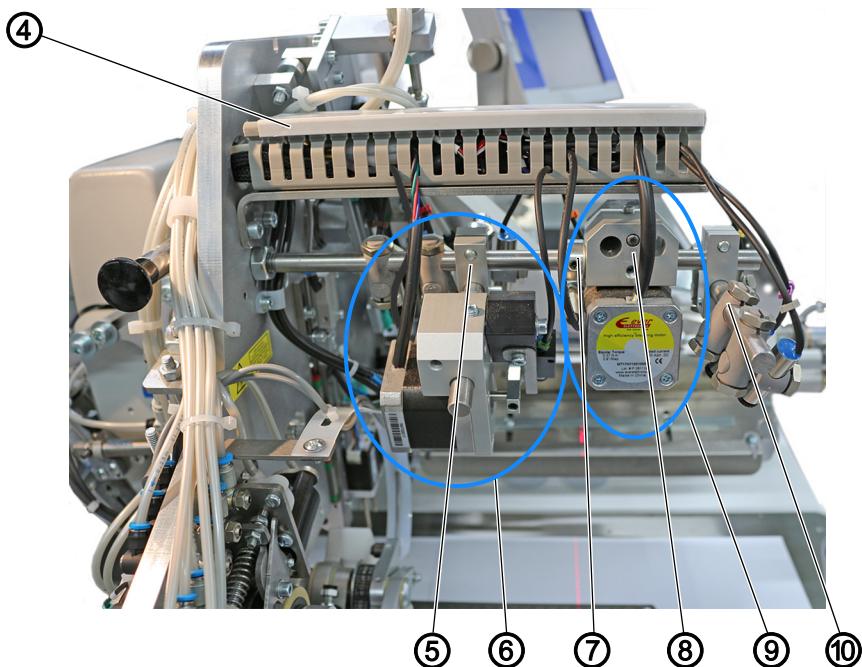
- (3) - Hood



To disassemble the hood (3):

1. Loosen the screws (1).
2. Loosen the screws (2) completely.
3. Remove the hood (3).

Fig. 2: Disassembling parts (2)



- (4) - Cover cable duct (8) - Holder vertical marking lamp
(5) - Holder horizontal marking lamp (9) - Vertical marking lamp with motor
(6) - Horizontal marking lamp with motor (10) - Marking lamps
(7) - Set collar



To temporarily disassemble the non-required components:

1. To open the cable duct, pull off the cover cable duct (4) towards the front.
 2. Disassemble all parts such as the marking lamps (10) that have been assembled in front of the position of the holder horizontal marking lamp (5).

2.2 Assembling parts

NOTICE

Property damage may occur!

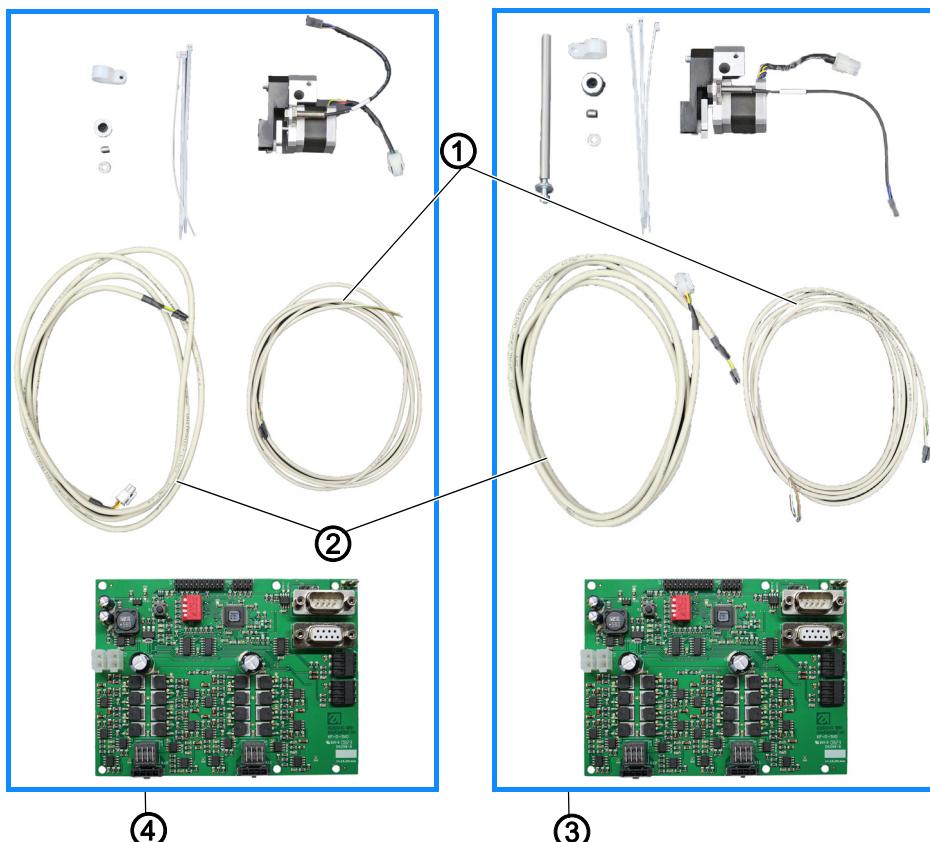
Cables may become damaged and impair the operation of the machine.

Always lay the cables so as not to create any chafing or pinching points. If necessary, use cable ties to assemble additional cables to the outside of the cable harness.

To avoid confusion while laying the cables, the cables need to be labeled with **Q** and **L** on either end.

2.2.1 Labeling the cables

Fig. 3: Labeling the cables



(1) - Reference cables
(2) - Motor cables

(3) - Kit Vertical marking lamp
(4) - Kit Horizontal marking lamp

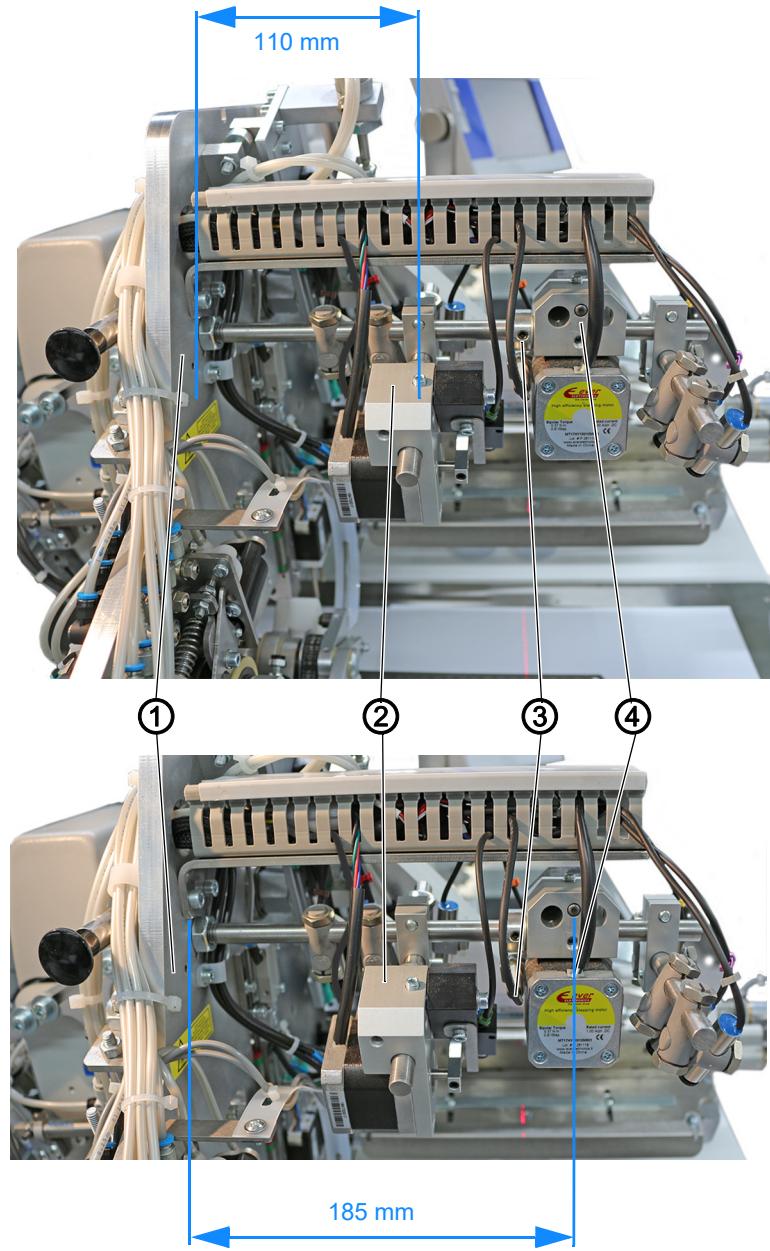


To label the cables:

1. Label the reference cable (1) and the motor cable (2) from the kit Vertical marking lamp (3) with **L** on both ends.
2. Label the reference cable (1) and the motor cable (2) from the kit Horizontal holder marking lamp (4) with **Q** on both ends.

2.2.2 Assembling the programmable marking lamps

Fig. 4: Assembling the programmable marking lamps



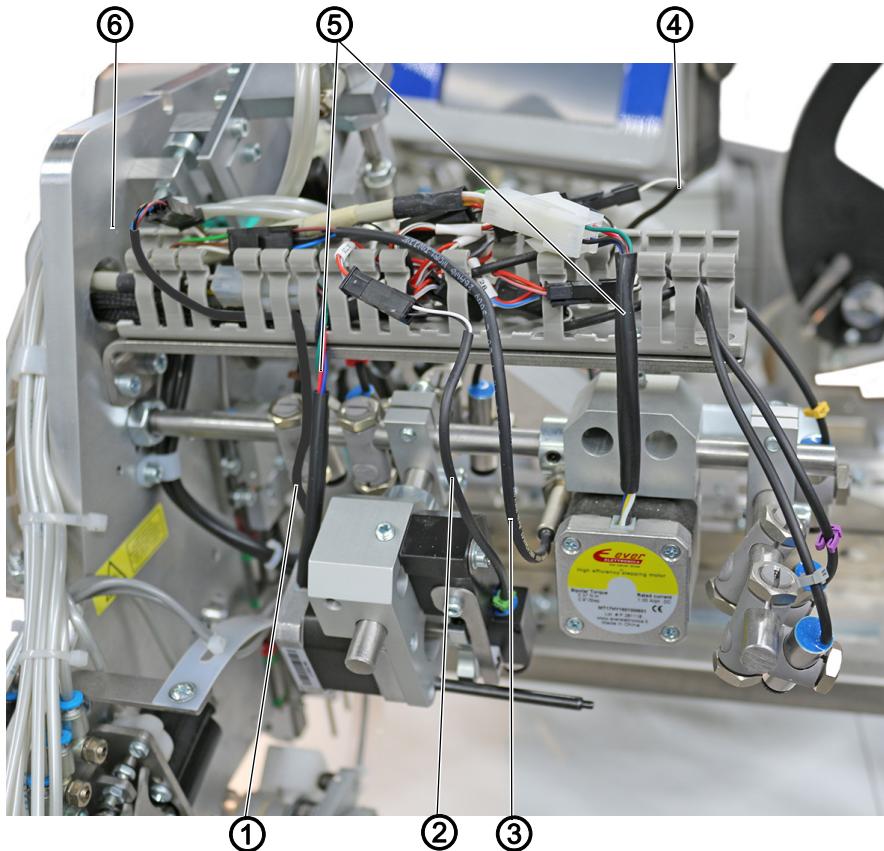


To assemble the programmable marking lamps:

1. Slide the holder horizontal marking lamp (2) onto the bar and assemble it at a distance of 110 mm (from the folder station plate (1) to the middle of the holder horizontal marking lamp (2)).
 2. Slide the set collar (3) onto the bar.
 3. Slide the holder vertical marking lamp (4) onto the bar and assemble it at a distance of 185 mm (from the folder station plate (1) to the middle of the holder vertical marking lamp (4)).

2.2.3 Connecting the programmable marking lamps

Fig. 5: Connecting the programmable marking lamps (1)



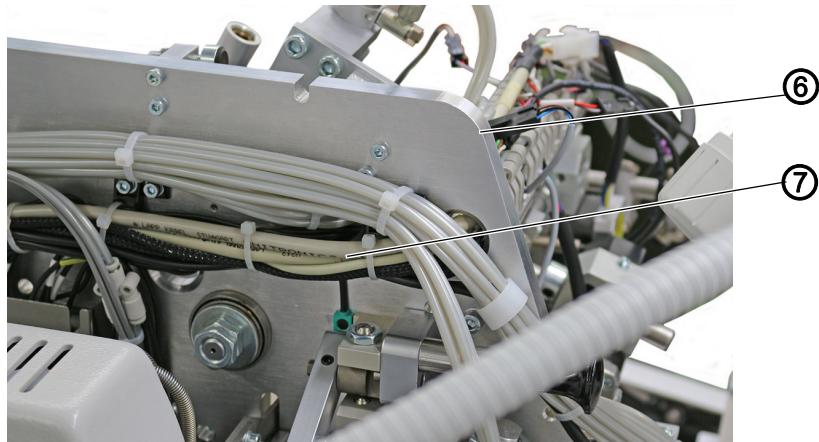
- | | |
|-------------------------------------|-----------------------------------|
| (1) - Horizontal reference cable | (4) - Cable vertical marking lamp |
| (2) - Cable horizontal marking lamp | (5) - Motor cables |
| (3) - Vertical reference cable | (6) - Folder station plate |

To connect the programmable marking lamps:



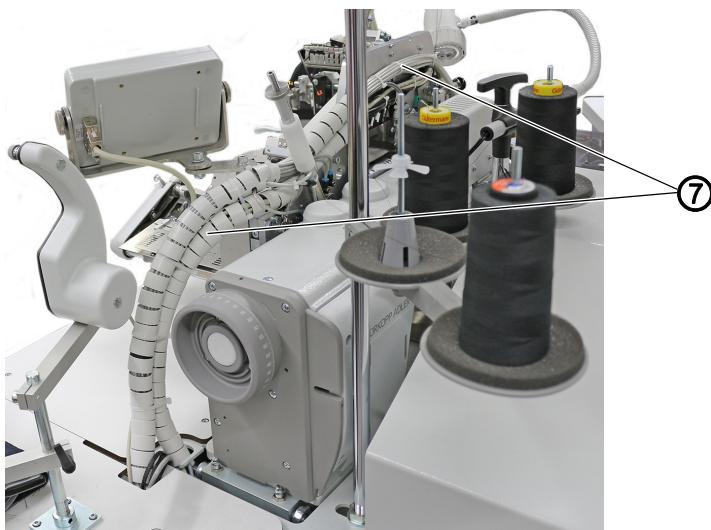
1. Connect the cables (2) and (4) with the plugs of the cables in the cable harness:
 - Horizontal marking lamp (2): X725
 - Vertical marking lamp (4): X715
2. Connect the horizontal reference cable (1) and the vertical reference cable (3) according to the labeling on the reference cables.
3. Connect the motor cables (5) according to the labeling on the motor cables.
4. Feed the reference cables and the motor cables through the folder station plate (6), under the machine, into the cable harness (7), and back up into the mounting bracket.

Fig. 6: Connecting the programmable marking lamps (2)



(4) - Folder station plate (7) - Cable harness

Fig. 7: Connecting the programmable marking lamps (3)



(7) - Cable harness

Fig. 8: Connecting the programmable marking lamps (4)

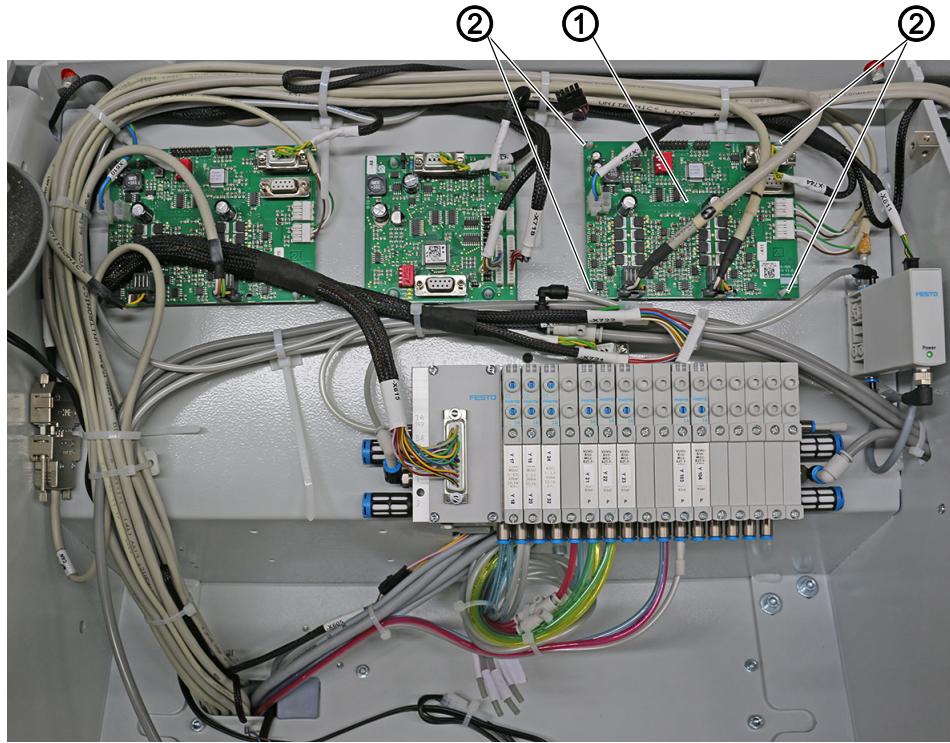


(7) - *Cable harness*

5. Feed the reference and motor cables through the folder station plate (6), under the machine, into the cable harness (7), and back up into the mounting bracket.

2.2.4 Assembling the PCB

Fig. 9: Assembling the PCB



(1) - PCB

(2) - Spacer

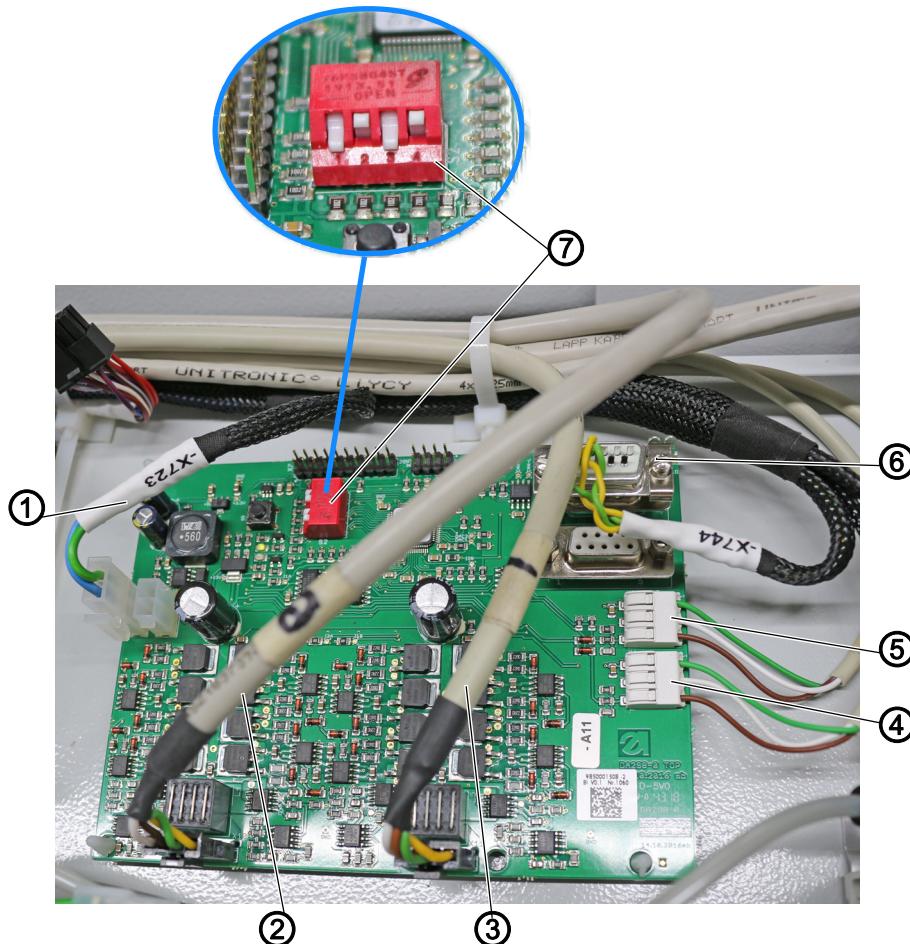


To assemble the PCB:

1. Insert spacers (2) into the holes.
2. Fit the PCB (1).

2.2.5 Connecting the PCB

Fig. 10: Connecting the PCB



- | | |
|--|--|
| (1) - Power supply PCB | (5) - Reference switch horizontal marking lamp |
| (2) - Motor cable horizontal marking lamp | (6) - Plug CAN cable |
| (3) - Motor cable vertical marking lamp | (7) - DIP switch |
| (4) - Reference switch vertical marking lamp | |

To connect the PCB:



1. Connect the cables to the PCB. Pay attention to the labels **Q** and **L**:
 - Power supply PCB (1) (X723): X1
 - Motor cable for horizontal marking lamp (2): X10
 - Motor cable for vertical marking lamp (3): X11
 - Plug CAN cable (X744) (6): X9
2. Connect the reference switch to the PCB. Make sure that the colors match (☞ p. 30):
 - Reference switch vertical marking lamp (4): X4
 - Reference switch horizontal marking lamp (5): X3
3. Set the correct address at the DIP switch (7) (☞ p. 31).

2.2.6 Adjusting the marking lamps

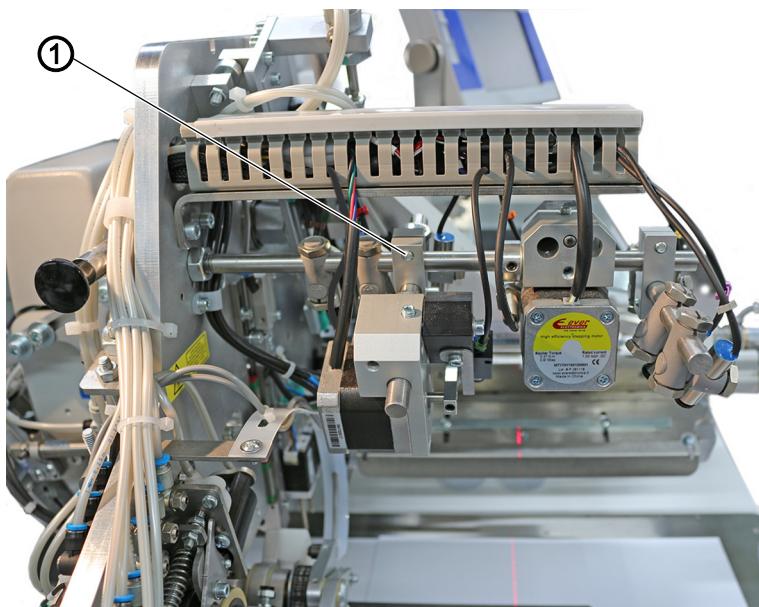


To adjust the marking lamps:

1. Assemble the hood again.
2. Switch on the machine.
3. Open the menu *Service > Machine config.* and select the *Vertical and horizontal programmable marking lamps* option (☞ p. 16).

2.3 Adjusting the horizontal programmable marking lamp

Fig. 11: Adjusting the horizontal programmable marking lamp (1)



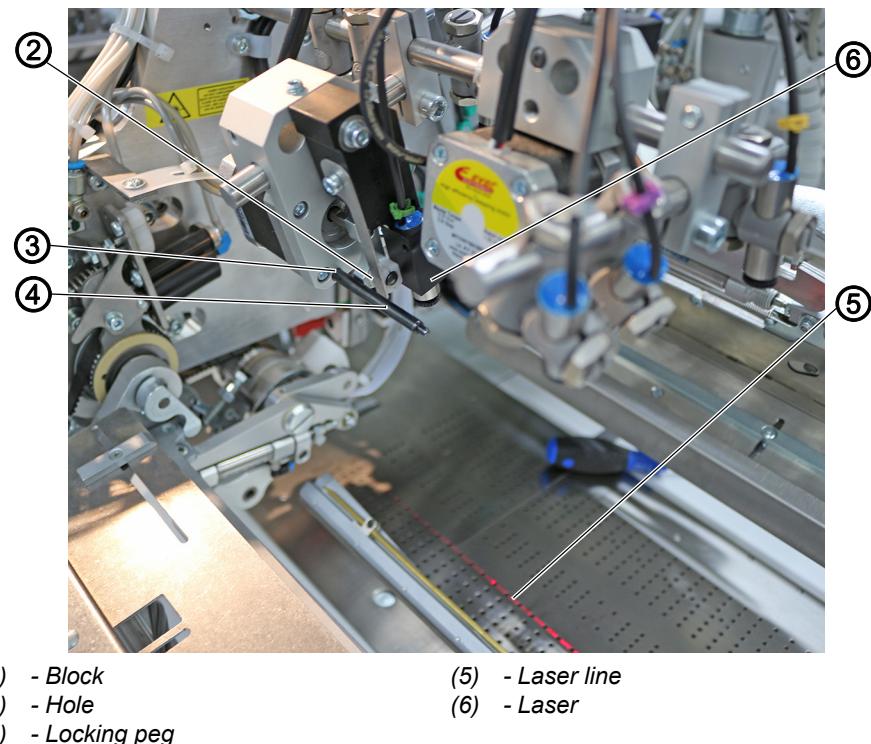
(1) - Screw



To adjust the horizontal marking lamp:

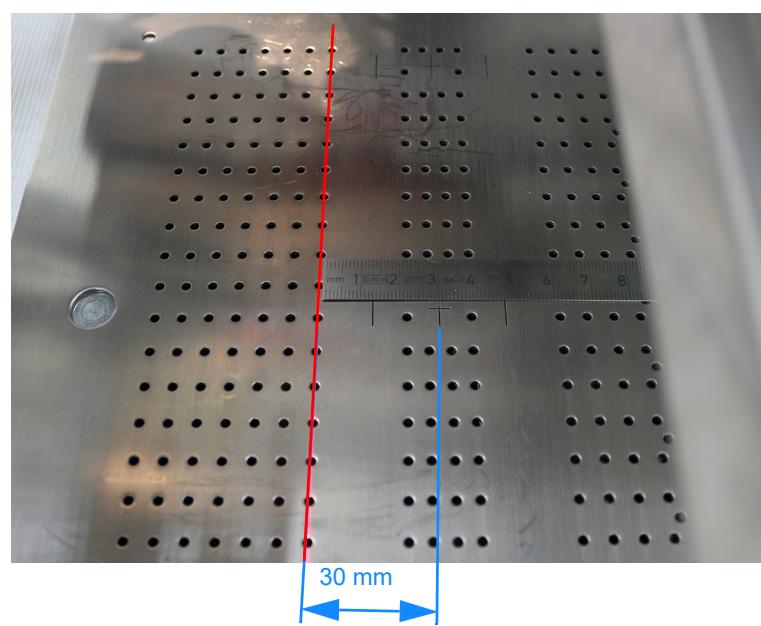
1. Open the menu *Service > Machine test > Horizontal progr. marking lamps test* and execute a reference run (☞ p. 23).
2. When the reference run is complete, the activated marking lamp is lit.
3. Loosen the screw (1).
4. The laser holder is loose.

Fig. 12: Adjusting the horizontal programmable marking lamp (2)



3. Insert the locking peg (4) into the hole (3).
4. Press the block (2) against the locking peg (4).

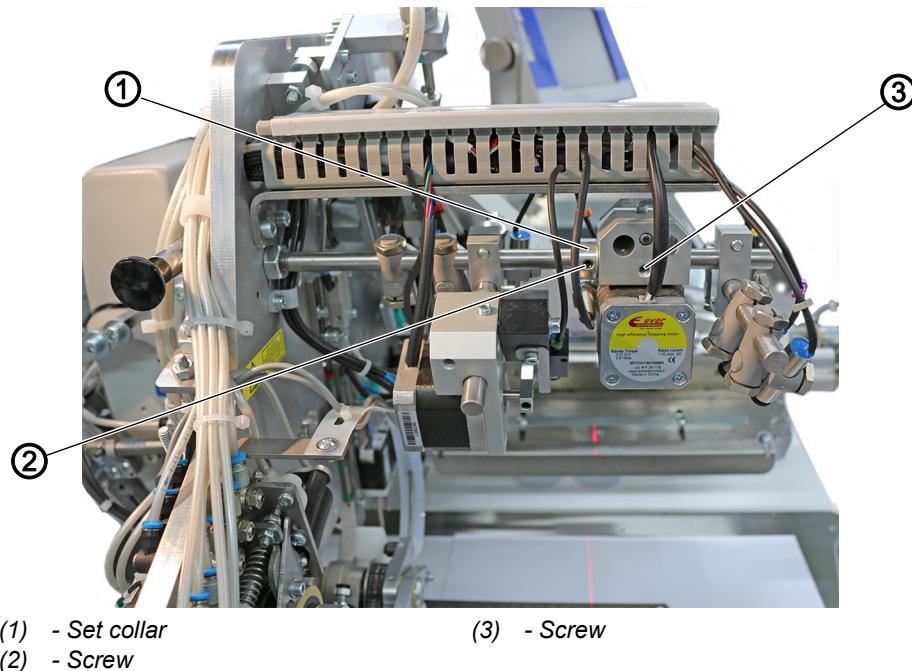
Fig. 13: Adjusting the horizontal programmable marking lamp (3)



5. Set the laser (6) such that the laser line (5) is positioned straight and at a distance of 30 mm from the middle of the pocket opening |+|.
6. Tighten the screw (1).

2.4 Adjusting the vertical programmable marking lamp

Fig. 14: Adjusting the vertical programmable marking lamp (1)



To adjust the vertical marking lamp:

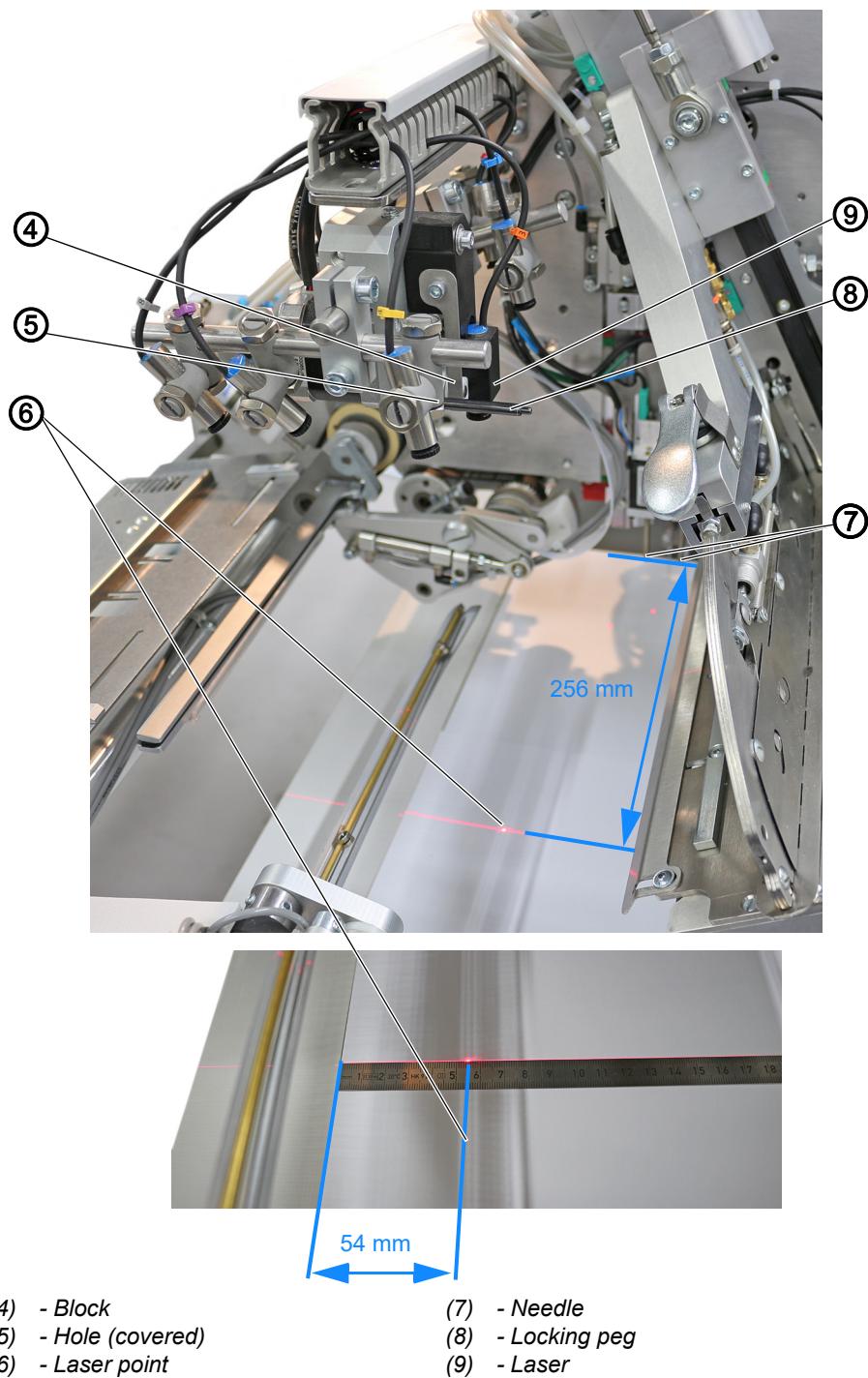


1. Open the menu *Service > Machine test > Vertical progr. marking lamps test* and execute a reference run (☞ p. 23).



- ↳ When the reference run is complete, the activated marking lamp is lit.
- 2. Loosen the screw (2) on the set collar (1).
- 3. Loosen the screw (3).
- ↳ The laser holder is loose.

Fig. 15: Adjusting the vertical programmable marking lamp (2)



4. Insert the locking peg (8) into the hole (5).
5. Press the block (4) against the locking peg (8).
6. Set the laser (9) such that the laser is positioned 256 mm away from the needle (7).
7. Set the laser (9) such that the laser point (6) is positioned 54 mm away from the left sliding plate edge.
8. Tighten the screw (3).
9. Push up the set collar (1) and tighten the screw (2).

3 Software settings

3.1 Activation in the machine configuration



Machine configuration

Main screen -> Service menu -> Machine config.

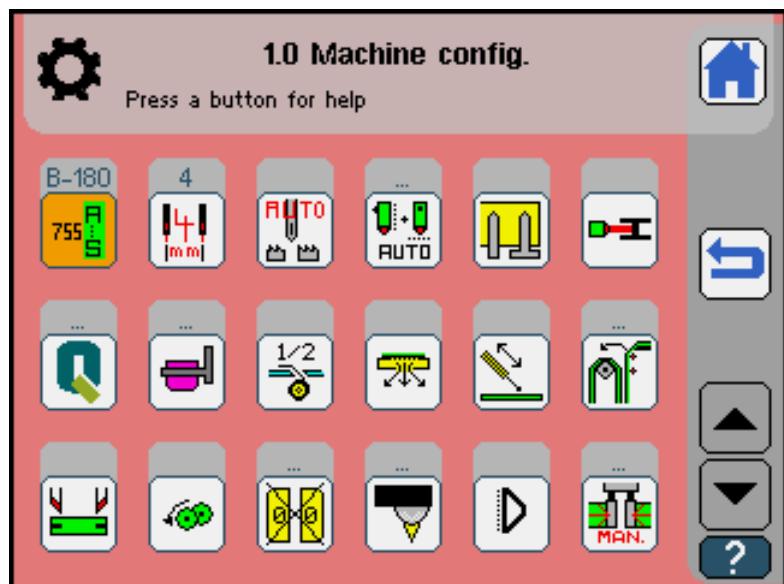


Important

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

- ↳ The display switches to *Machine config.*

Fig. 16: Machine config.



To open the menu *1.5 Programmable marking lamps With/Without*:

1. Press the  button.

- ↳ The menu *1.5 Programmable marking lamps With/Without* opens.

Icon	Setting	Explanation
	<i>Without programmable marking lamps</i>	<ul style="list-style-type: none"> • None of the marking lamps is active
	<i>Vertical progr. marking lamp</i>	<ul style="list-style-type: none"> • Only the vertical marking lamp is active
	<i>Horizontal progr. marking lamp</i>	<ul style="list-style-type: none"> • Only the horizontal marking lamp is active
	<i>Vertical and horizontal programmable marking lamps</i>	<ul style="list-style-type: none"> • Both marking lamps are active (for method F)
	<i>Programmable marking lamp rotated</i>	<ul style="list-style-type: none"> • Vertical marking lamp rotated • Only the vertical marking lamp is active
	<i>Both programmable marking lamps rotated</i>	<ul style="list-style-type: none"> • Vertical marking lamp rotated • Both marking lamps are active

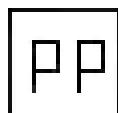


To activate both programmable marking lamps for method F:

1. Press the

↳ Both programmable marking lamps are active.

3.2 Settings in the Program parameters area



Program parameters

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



Information

If an option is not available or grayed out, it must be set up in the *Machine configuration* menu (☞ p. 16). Otherwise, the option will be unavailable in this class.

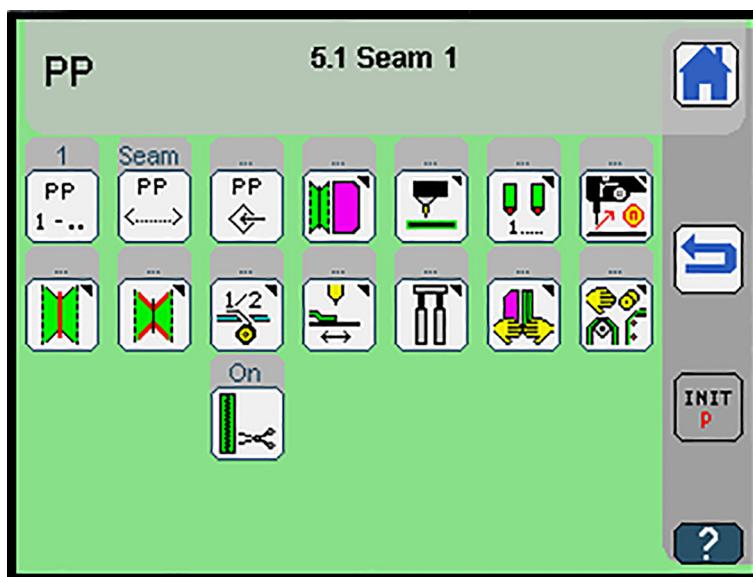


To configure pocket programs:

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

↳ The display switches to *Configure pocket programs*.

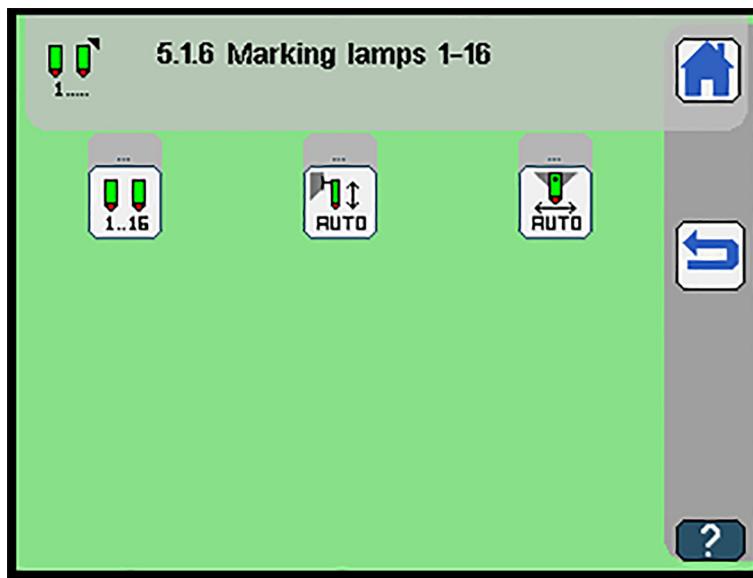
Fig. 17: Program parameters



2. Press the button.

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

Fig. 18: Marking lamps 1-16

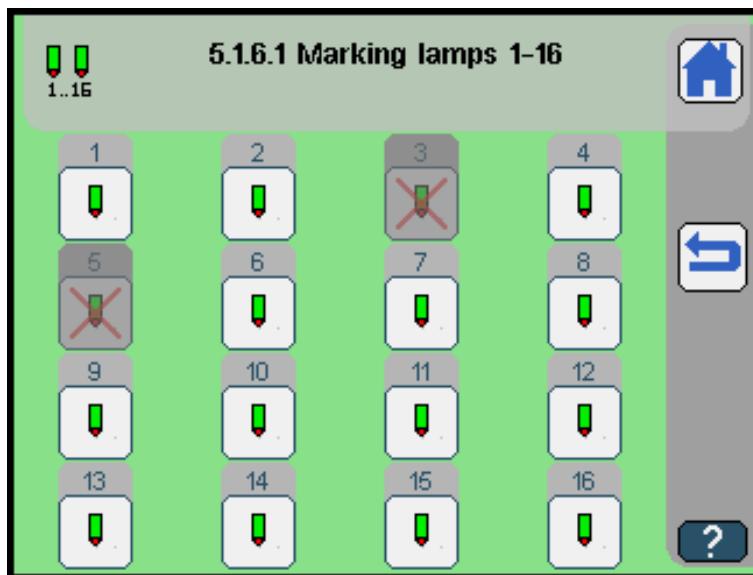


Symbols	Meaning
	Activate marking lamps 1 - 16  p. 20
	Programmable marking lamps in sewing direction  p. 21
	Programmable marking lamps crosswise to the sewing direction  p. 22



Activating marking lamps 1 - 16

Fig. 19: Activate marking lamps 1-16



Symbols	Meaning
	Marking lamp activated
	Marking lamp deactivated



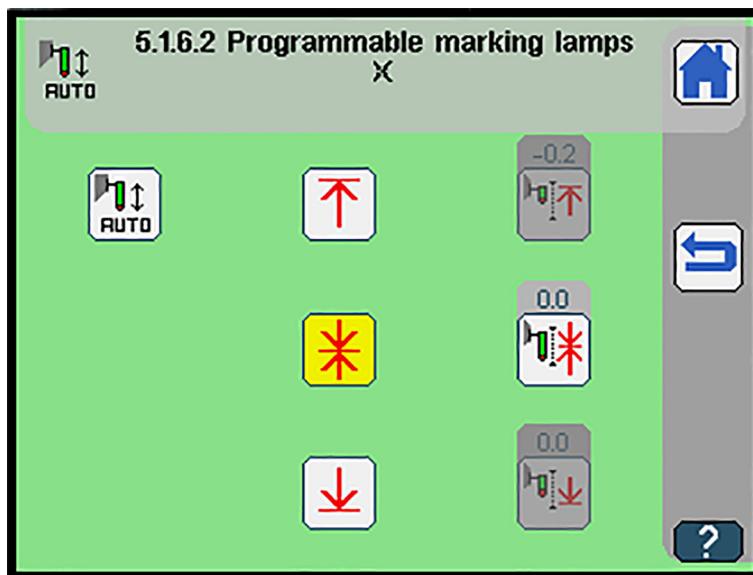
To activate the marking lamps:

1. Press the button of the desired marking lamp.
↳ The marking lamp is (de)activated.



Programmable marking lamps X-axis

Fig. 20: Programmable marking lamps X-axis



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



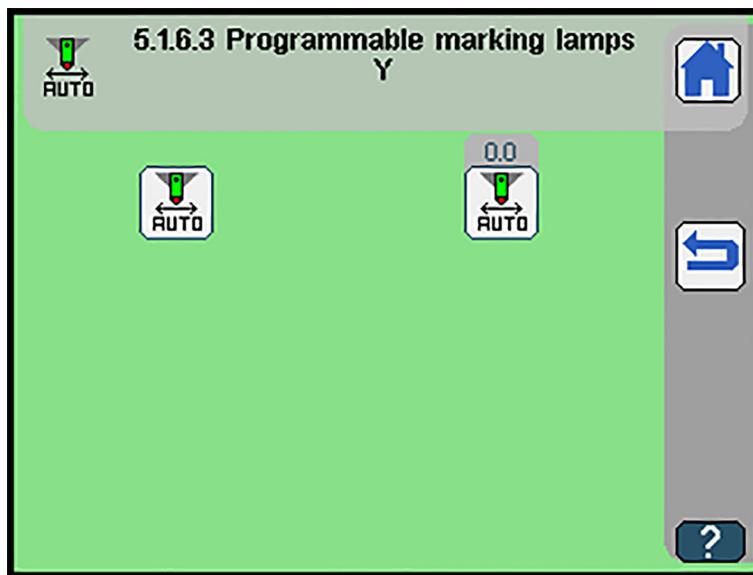
To program the programmable marking lamps for the X-axis:

1. Press the button or .
2. The desired marking lamp moves to the corresponding position.
2. Press the button or .
3. Enter the desired correction value using the numeric keypad.
4. Confirm with **OK**.



Programmable marking lamps Y-axis

Fig. 21: Programmable marking lamps Y-axis



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



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

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

3.3 Settings in the Machine test area

Machine test

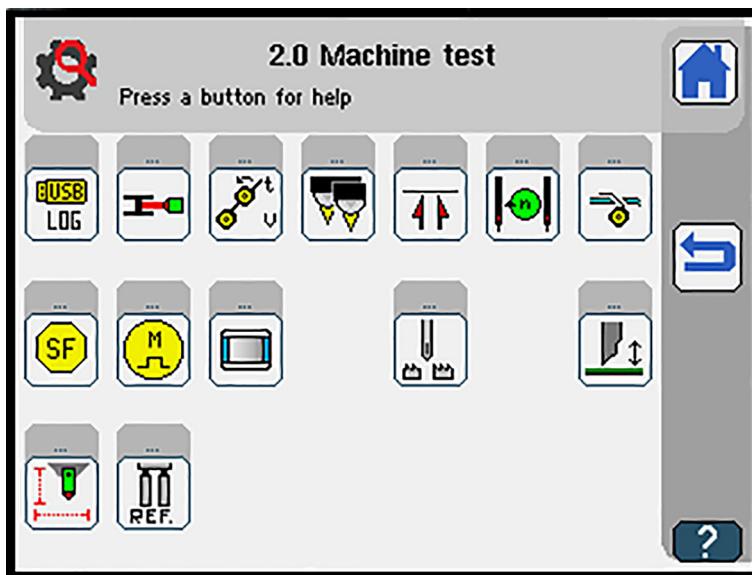


Important

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

- ↳ The display switches to *Machine test*.
The display varies with the machine configuration (☞ p. 16).

Fig. 22: Machine test



To test the programmable marking lamps:



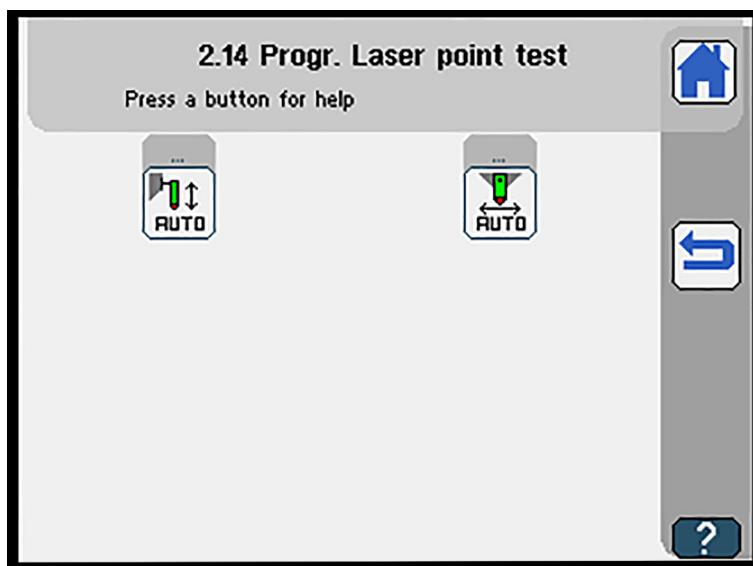
Information

This function is only available if the programmable marking lamps have been activated in the machine configuration.

1. Press the  button.

- ↳ The user interface *Vertical progr. marking lamps test* is displayed.

Fig. 23: Programmable marking lamps test



Icon	Meaning
	Test programmable marking lamps (lengthwise in sewing direction)  p. 25
	Test programmable marking lamps (crosswise to sewing direction)  p. 27



Information

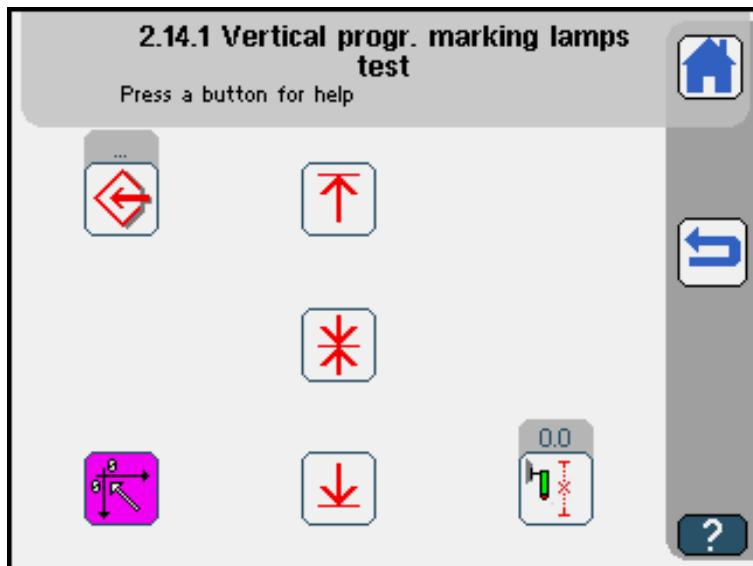
If only one of the programmable marking lamps is active, the menu switches directly to the corresponding submenu.

3.3.1 Programmable marking lamps test (vertical)



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

Fig. 24: Programmable marking lamps test



Icon	Meaning
	Adjust programmable marking lamps p. 26
	Reference
	Select positioning point seam begin.
	Select positioning point seam center
	Select positioning point seam end
	Move to any position • 0 mm - 220 mm



To test the programmable marking lamps:

1. Press the

↳ Reference run is carried out.

2. Press the button , , or .

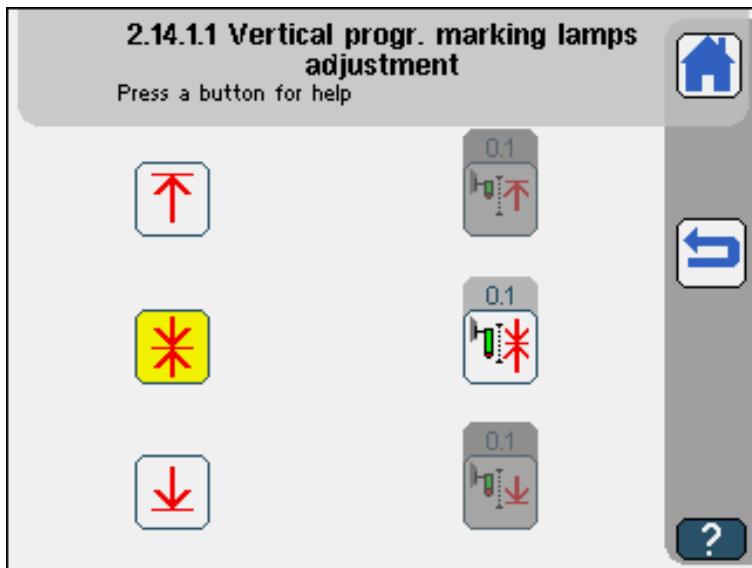
↳ The desired positioning point has been selected.

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

3.3.2 Programmable marking lamps adjustment (vertical)

 The display switches to *progr. marking lamps adjustment*.

Fig. 25: Programmable marking lamps adjustment (vertical)



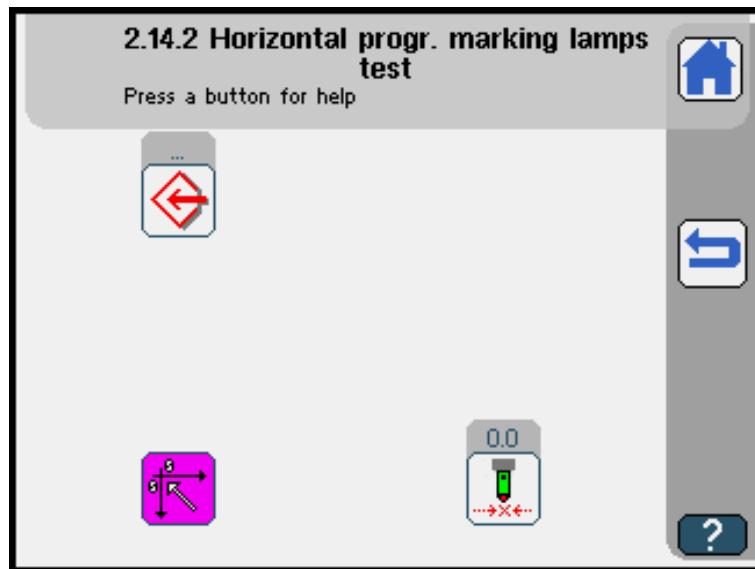
Icon	Meaning
	Select front positioning point
	Select central positioning point
	Select rear positioning point
	Adjust programmable marking lamp position 1 • -100 - 100
	Adjust programmable marking lamp position 2 • -100 - 100
	Adjust programmable marking lamp position 3 • -100 - 100

3.3.3 Programmable marking lamps test (horizontal)



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

Fig. 26: Programmable marking lamps test



Icon	Meaning
	Adjust programmable marking lamps p. 28
	Reference
	Enter position X • 0 mm - 220 mm



To test the programmable marking lamps:

1. Press the

↳ Reference run is carried out.

2. Press the button , , or .

↳ The desired positioning point has been selected.

3. Press the

4. Enter the desired value using the numeric keypad.

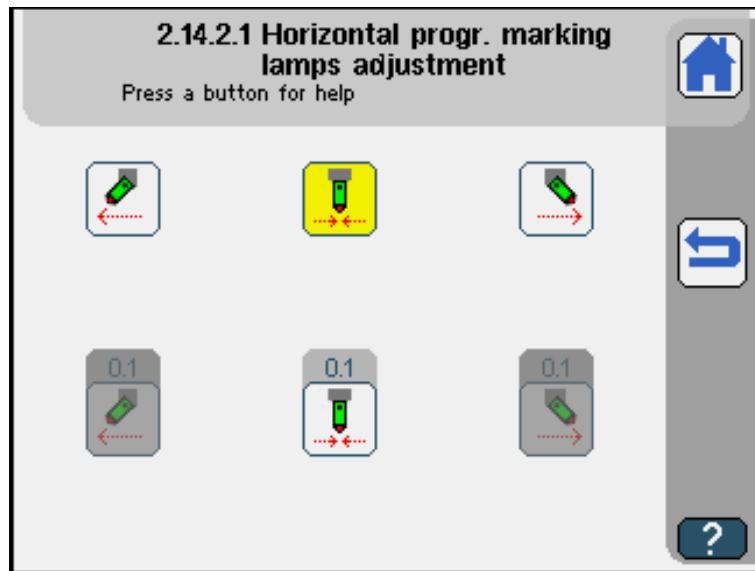
5. Confirm with **OK**.

3.3.4 Programmable marking lamps adjustment (horizontal)



The display switches to *progr. marking lamps adjustment*.

Fig. 27: Programmable marking lamps adjustment (horizontal)



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

4 Appendix

Fig. 28: Wiring diagram (1)

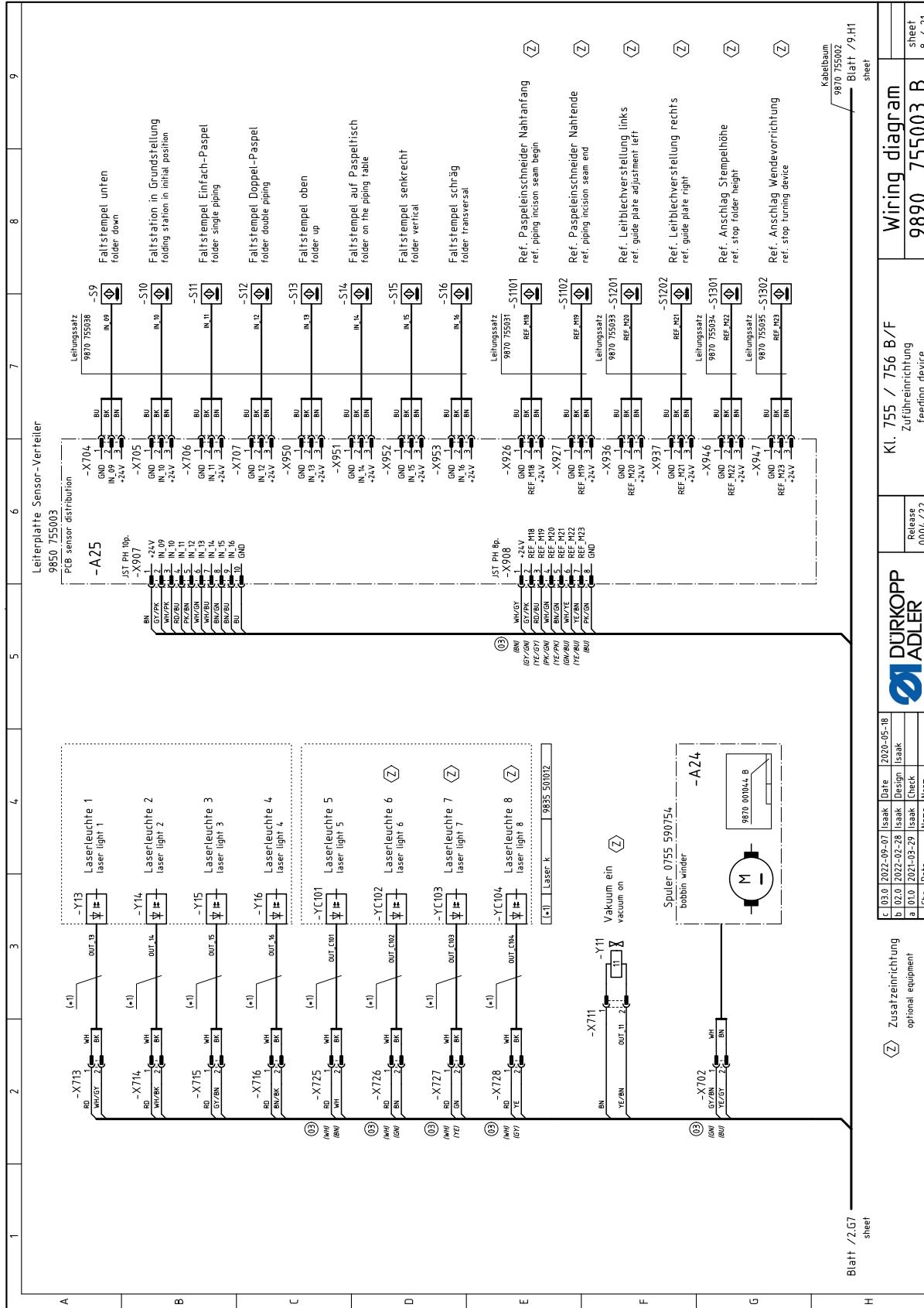


Fig. 29: Wiring diagram (2)

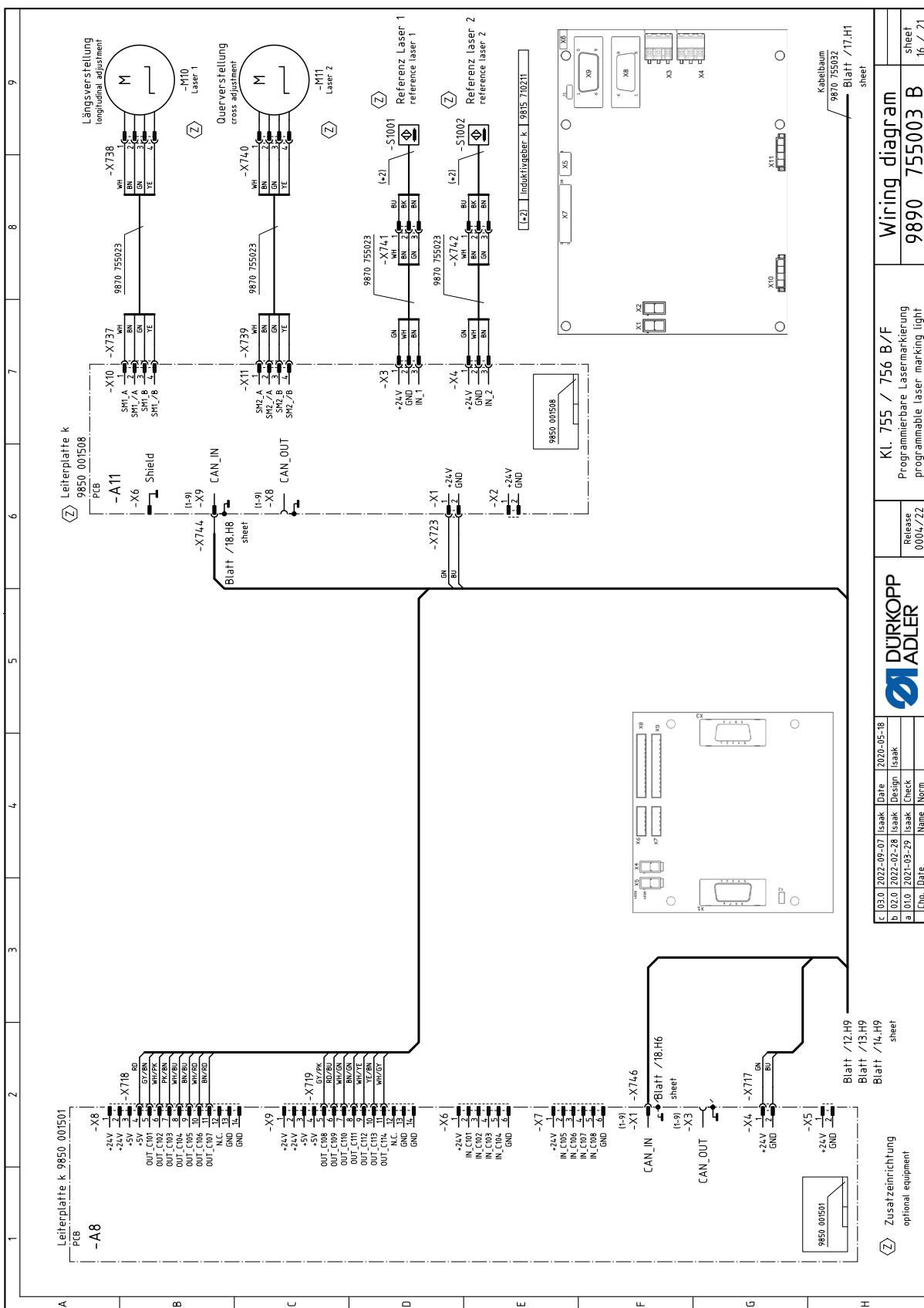
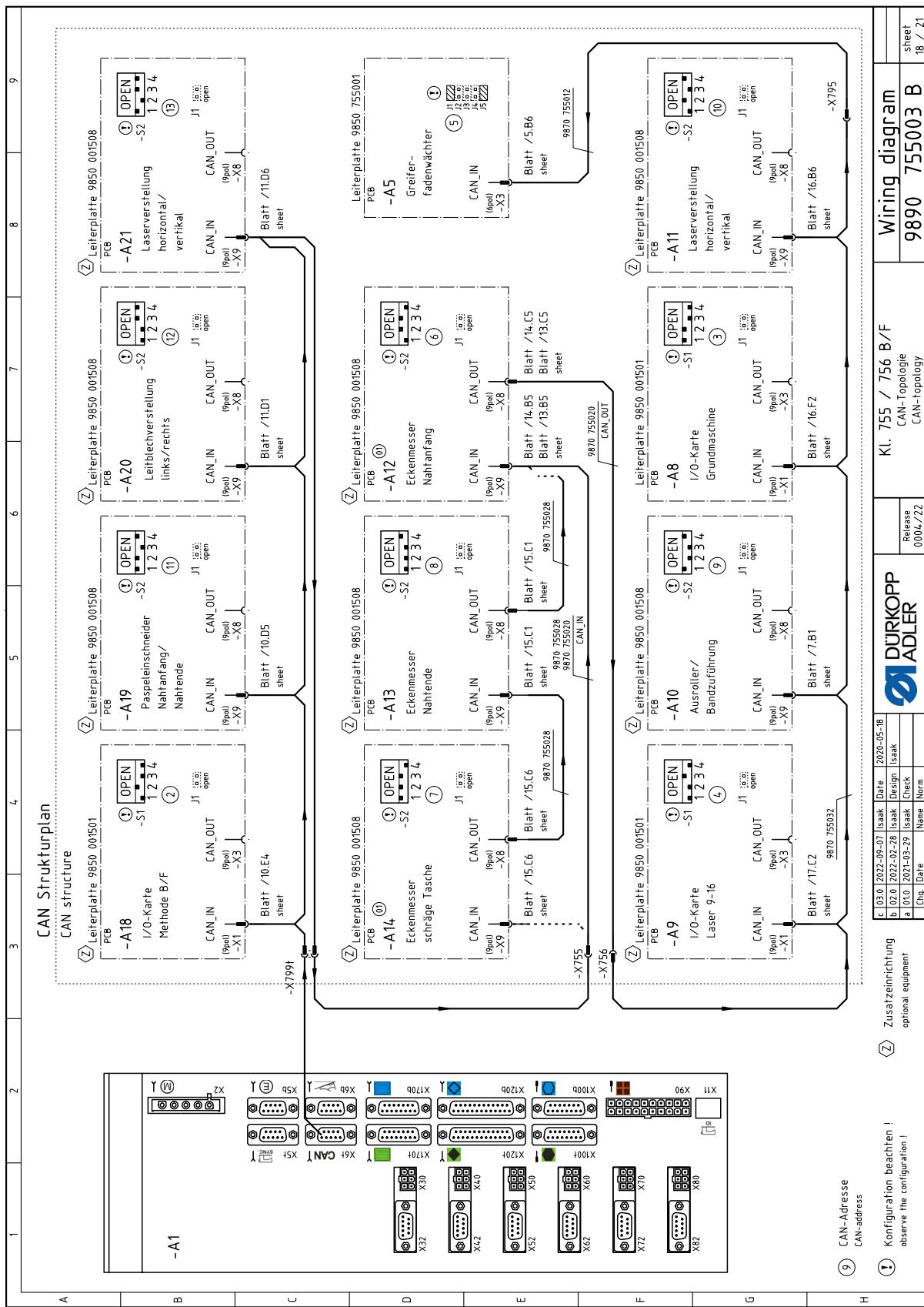


Fig. 30: Wiring diagram (3)





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