beisler
SEWING

1225-6

Operating Instructions

IMPORTANT

READ CAREFULLY BEFORE USE

KEEP FOR FUTURE REFERENCE

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. 87*).

Consider the instructions 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. 19*) is important for the operators.
- Specialists:
  This group has the appropriate technical training for performing maintenance or repairing malfunctions. Specifically, the chapter **Setup** (📖 *p. 71*) is important for specialists.

Service Instructions are supplied separately.

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

1.2 Representation conventions – symbols and characters

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

Proper setting

Specifies proper setting.

Disturbances

Specifies the disturbances that can occur from an incorrect 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 to the machine or on the display/control panel.

Important

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

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

Order

Specifies the work to be performed before or after 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 damage during transport
- 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. Make sure to follow the information included 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 forklift to transport the machine. Raise the machine max. 20 mm and secure it to prevent it from slipping off.

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

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

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

Requirements to be met by the personnel

Only qualified specialists may:

- Set up the machine/put the machine into operation
- Perform maintenance work and repairs
- Perform work on electrical equipment

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

Operation

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

Safety equipment

Safety equipment should not be removed or deactivated. If it is essential to remove 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.

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.

CAUTION

Type and source of danger!

Consequences of non-compliance.

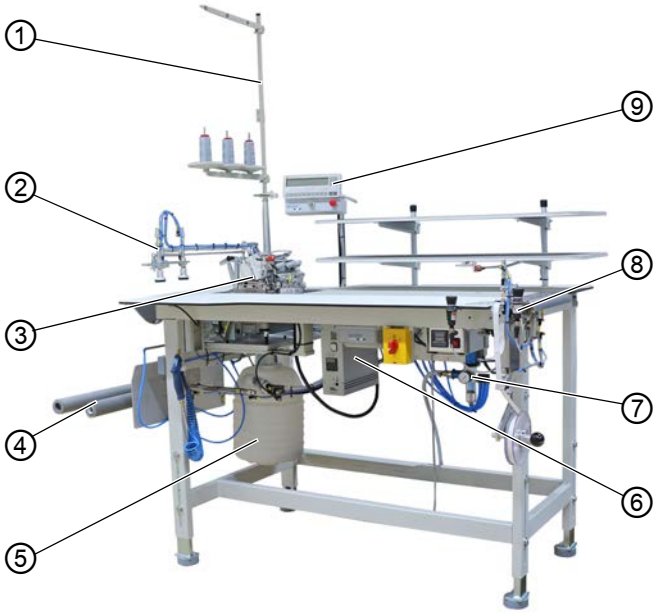
Measures for avoiding the danger.

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

3 Machine description

3.1 Components of the machine

Fig. 1: Components of the machine



(1) - Reel stand
(2) - Swivel device
(3) - Machine head
(4) - Stacker
(5) - Extraction system
(6) - Control
(7) - Compressed air maintenance unit
(8) - Fusing station
(9) - 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. 91*) 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.

CE

4 Operation

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

4.1 Preparing the machine for operation

WARNING

Risk of injury from moving, cutting and sharp parts!

Crushing, cutting and punctures are possible.

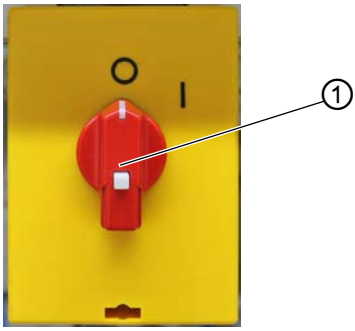
If possible, make preparations only when the machine is switched off.

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

- Inserting/changing the needle
- Threading the needle thread
- Inserting and winding on the hook thread
- Setting the thread tension
- Inserting the fusing tape

4.2 Switching on and off the machine

Fig. 2: Switching on and off the machine



(1) - Main switch

To switch on and off the machine:

1. Set the main switch (1) to position **I**.

↳ The machine switches on.
The control loads the machine program.
The basic display appears in the display of the control panel.

2. Turn the main switch (1) to the **O** position.

↳ The machine switches off.

4.3 Switching on Quick-stop

The Quick-stop switch (1) can be used to immediately stop all working steps on the machine, e.g. after an operating mistake.

Fig. 3: Switching on Quick-stop

(1) - Quick-stop switch

To switch on Quick-stop:

1. Press the Quick-stop switch (1).
   ↳ All working steps on the machine are immediately stopped.
2. Turn the main switch to the **O** position.
   ↳ The machine switches off.

4.4 Resuming operation after a Quick-stop

CAUTION

Risk of injury from sharp and moving parts!
Puncture or crushing possible.

Do not put the machine back into operation until AFTER you corrected the fault.

Fig. 4: Resuming operation after a Quick-stop

(1) - Quick-stop switch

To put the machine back into operation after a Quick-stop:

1. Set the main switch to position **I**.

↳ The machine switches on.

2. Unlock the Quick-stop switch (1).

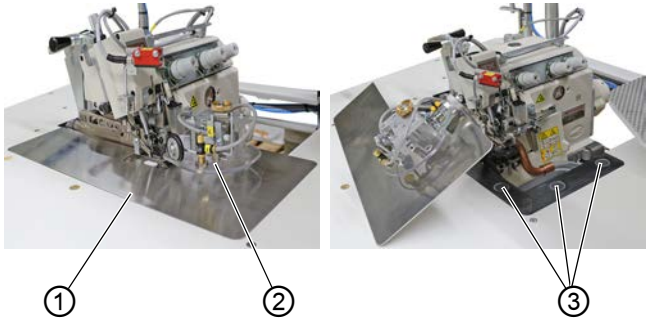
↳ The control loads the machine program.
The basic display appears in the display of the control panel.

4.5 Operating the machine head

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 provided in the machine accessory pack.

4.6 Removing and placing the fabric sliding plate

Fig. 5: Removing and placing the fabric sliding plate



(1) - Fabric sliding plate
(2) - Edge guide
(3) - Magnets

The fabric sliding plate (1) is held in the tabletop cut-out by the magnets (3).
The edge guide (2) is assembled to the fabric sliding plate.

Removing the fabric sliding plate

To remove the fabric sliding plate:

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

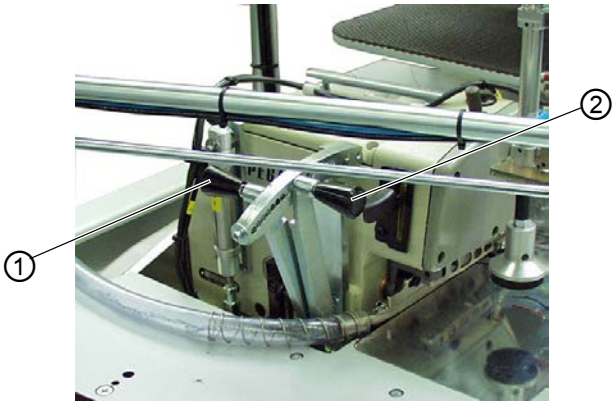
Placing the fabric sliding plate

To place the fabric sliding plate:

1. Insert the fabric sliding plate (1) into the tabletop cut-out.
2. Place the edge guide (2) onto the magnets (3) from the top.

4.7 Setting the differential feed

Fig. 6: Setting the differential feed



(1) - Lever *(2) - Lever*

Setting the permanent differential

The permanent differential is active during the entire sewing process. The adjusting range is between -10 and + 6.

To set the permanent differential:

1. Adjust the lever (1).
   - Greater fullness: Move the lever (1) further into the plus range
   - Less to no fullness: Move the lever (1) further into the minus range

Setting the additional differential

The additional differential can be programmed in the control and is only active in specific seam sections.
The adjusting range is between 0 and +16.

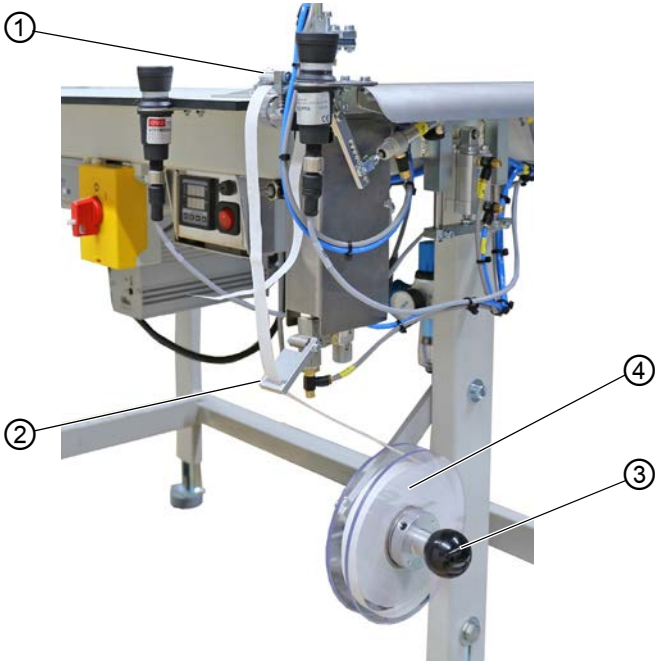
To set the additional differential:

1. Adjust the lever (2).
   - Greater fullness: Move the lever (2) further into the plus range

4.8 Operating the fusing station

4.8.1 Inserting the fusing tape

Fig. 7: Inserting the fusing tape (1)



(1) - Flap
(2) - Guide
(3) - Handle
(4) - Tape

To insert the fusing tape:

1. Strongly pull on the handle (3) and pull off the right supporting disk.
2. Insert a new roll of fusing tape (4).
   Make sure the full roll rotates in counter-clockwise direction while unwinding.
3. Push the right supporting disk back onto the shaft until it catches.
4. Feed the fusing tape (4) through guide (2).
5. Fold up the flap (1).

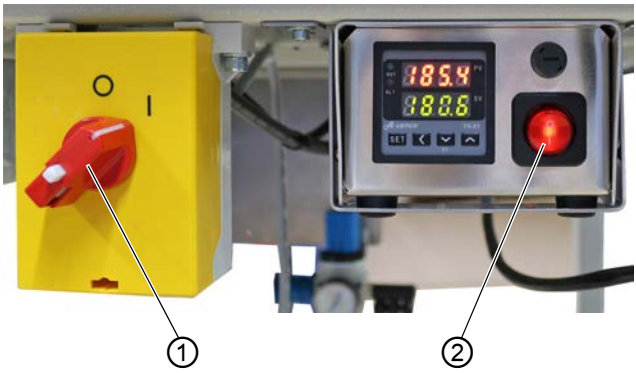
Fig. 8: Inserting the fusing tape (2)

(1) - Flap
(4) - Fusing tape
(5) - Clamp
(6) - Transport roller
(7) - Backing material

6. Separate the fusing tape (4) from the backing material (7).
7. Guide the fusing tape (4) under the flap (1) and draw it under the clamp (5).
8. Guide the backing material (7) downwards behind the transport roller (6).
9. Close the flap (1).

4.8.2 Switching on the fusing station

Fig. 9: Switching on the fusing station



(1) - Main switch *(2) - Toggle switch*

To switch on the fusing station:

1. Set the main switch (1) to position **I**.

   ↳ The machine switches on.

2. Press the toggle switch (2) to the **I** position.

   ↳ The toggle switch is lit.

Information
The lower value (green numbers) indicates the preset heating value.
The upper value (red numbers) indicates the current heating value.

4.8.3 Fusing of knee lining and front trousers

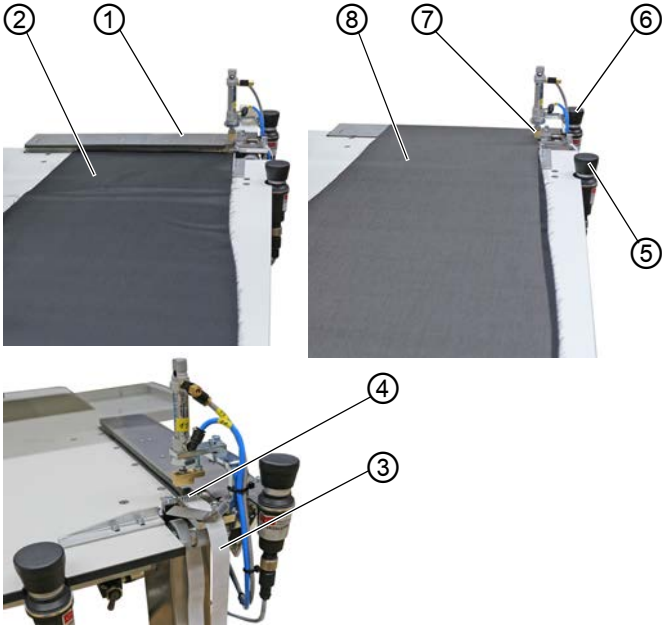
CAUTION

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. 10: Fusing of knee lining and front trousers



(1) - Clamp
(2) - Knee lining
(3) - Tape
(4) - Net-like fusing tape
(5) - Button
(6) - Button
(7) - Upper stamp
(8) - Trousers part

Information

To avoid a displacement of the knee lining during the sewing process, a bonding point has to be set with the fusing station, fusing the lining at the correct position.

To fuse the knee lining with the front trousers:

1. Position the knee lining (2) under the clamp (1).
2. Press the button (5).

↳ The clamp (1) lowers and clamps the knee lining (2). At the same time, the fusing tape (3) is pushed forward, and the net-like fusing tape (4) is separated from the backing material.

3. Position the trousers part (8) and align it relative to the knee lining (2).
4. Press the button (4).

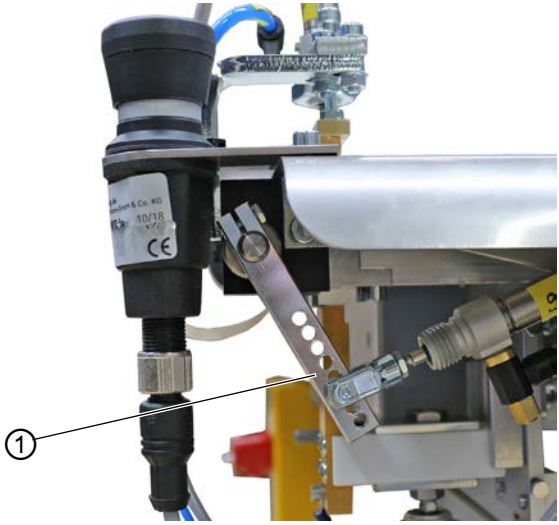
↳ The upper stamp (7) moves downwards, while the lower heated stamp moves upwards. The stamps press trousers part (8) and knee lining (2) together with the fusing tape lying in between.

After the preset fusing time the upper stamp (7) and the clamp (1) are lifted automatically, and the lower stamp is lowered.
Knee lining (2) and trousers part (8) are now fused and can be fed for overlocking.

4.8.4 Setting the fusing tape feed

A lever can be used to set the amount of fusing tape that will be fed.

Fig. 11: Setting the fusing tape feed



(1) - Lever

To set the fusing tape feed:

1. Select the desired hole on the lever (1):
   - more fusing tape: select a higher hole
   - less fusing tape: select a lower hole

4.8.5 Cleaning the stamp

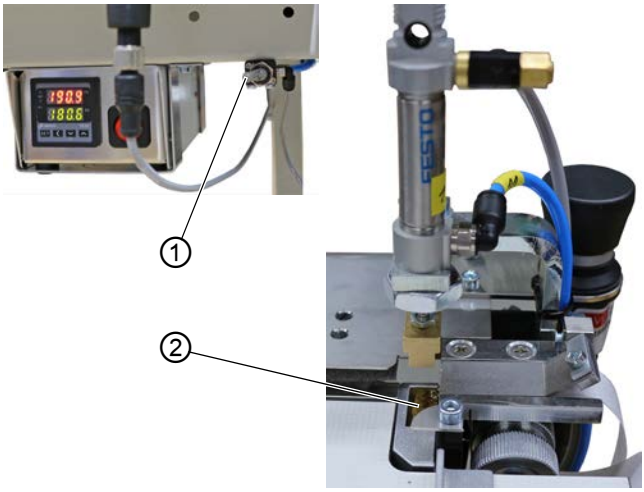
CAUTION

Risk of injury from hot fusing stamp!

Risk of burns.

Allow the stamp to cool off before cleaning it.

Fig. 12: Cleaning the stamp



(1) - Toggle switch *(2) - lower stamp*

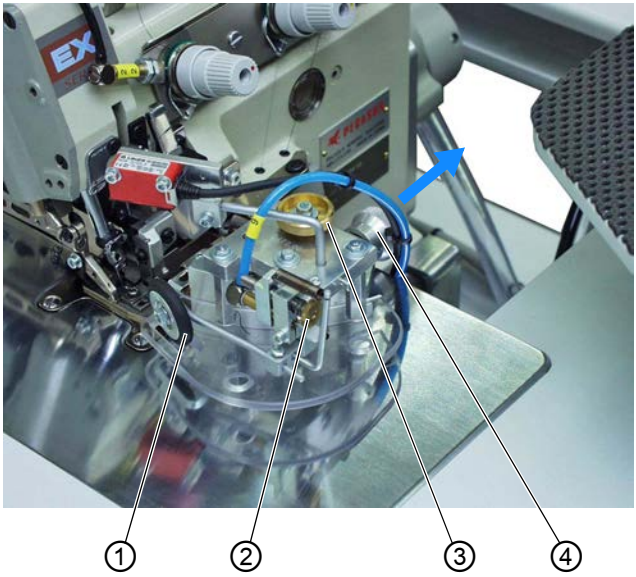
To clean the stamp:

1. Actuate the toggle switch (1).
   ↳ The lower stamp (2) moves up.
2. Clean the stamp.
3. Actuate the toggle switch (1).
   ↳ The lower stamp (2) moves down.

4.9 Setting the edge guide

The height-adjustable edge guide ensures a precise positioning of the trousers part in front of the sewing head. The height of the edge guide can be adjusted depending on the thickness of the sewing material.
The draw roll guarantees that the sewing material is fed precisely under the sewing foot.

Fig. 13: Setting the edge guide



(1) - Draw roll
(2) - Adjusting wheel
(3) - Adjusting wheel
(4) - Adjusting wheel

Setting the height of the edge guide

To set the height of the edge guide:

1. Pull the adjusting wheel (4) in the direction of the arrow.
2. Turn the adjusting wheel (4) to one of the 4 lock-in positions.
   - Position 1: minimum height
   - Position 4: maximum height

Setting the fine adjustment of the edge guide

To set the fine adjustment of the edge guide:

1. Turn the adjusting wheel (3).

Setting the pressure of the draw roll

To set the pressure of the draw roll:

1. Turn the adjusting wheel (2).
   - Increase the pressure of the draw roll (1): turn clockwise
   - Decrease the pressure of the draw roll (1): turn counterclockwise

4.10 Throw-over stacker

CAUTION

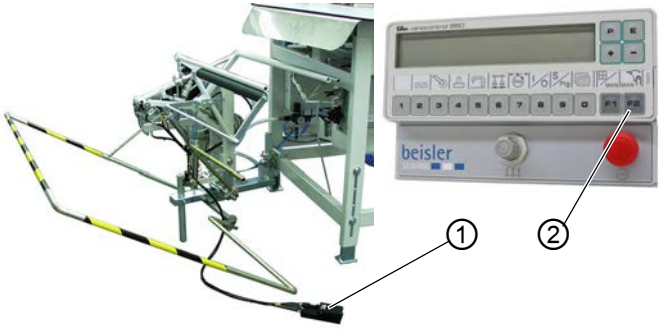
Risk of injury from moving parts!

Crushing possible.

Do NOT reach into the working area of the throw-over stacker during stacking.

4.10.1 Operating the throw-over stacker

Fig. 14: Operating the throw-over stacker



(1) - Pedal *(2) - Button F2*

The finished workpieces are stacked on the throw-over stacker.

Stacking the sewing material manually

To stack the sewing material manually:

1. Press the F2 button (2).

↳ A stacking process is carried out.

Removing stacked parts

To remove stacked parts:

1. Press the pedal (1) and hold it down.

   ↳ The throw-over stacker opens.

2. Remove the stacked parts.

4.10.2 Setting the air nozzles in the tabletop

Fig. 15: Setting the air nozzles in the tabletop

(1) - Air nozzles *(2) - Adjusting wheel*

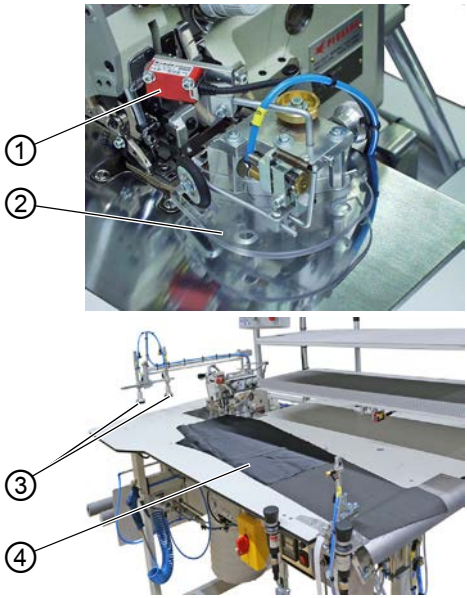
The air nozzles (1) embedded in the tabletop support the precise stacking of the sewing material.

To set the air nozzles in the tabletop:

1. Turn the adjusting wheel (2).
   - Increased intensity of the air blast: turn clockwise
   - Reduced intensity of the air blast: turn counterclockwise

4.11 Sewing

Fig. 16: Sewing



(1) - Light barrier
(2) - Edge guide
(3) - Punch
(4) - Sewing material

To sew:

1. Call up the desired seam program (📖 *p. 40*).
2. Fuse knee lining and front trousers (📖 *p. 28*).
3. Place the sewing material (4) on the tabletop.
   Make sure the sewing material is positioned straight under the edge guide (2).

Important

The edge guide (2) lowers when the sewing material (4) is moved under the light barrier (1). The sewing process starts automatically.

4. Slide the sewing material (4) under the light barrier (1).

↳ The sewing process starts.

When the sewing process ends, the stamps (3) are lowered, and the sewing material (4) is stacked.

5 Programming

5.1 Control panel

Fig. 17: Control panel

(1) - Display
(2) - Buttons 1-0
(3) - Quick-stop switch
(4) - Function buttons
(5) - Input buttons

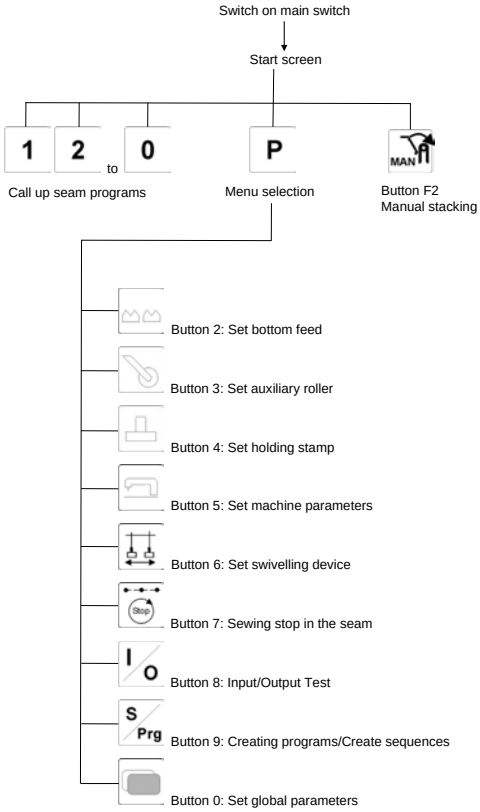
Button	Function
1 ... 0	Seam program 1 to seam program 20
F2	Stack manually
P	Save menu/data selection
P 2	Function bottom feed
P 3	Set function auxiliary roller
P 4	Set function holding stamp

Button	Function
P 5	Set machine parameters
P 6	Set function swivel device
P 7	Sewing stop in the seam
P 8	Input/output test
P 9	Program sequence (S) Create programs (Prg)
P 0	Set global parameters
E	Enter
F1 F2	Select parameters/scroll
+ −	Change parameter values

5.2 User interface

5.2.1 Menu structure of seam and setting programs

Fig. 18: Menu structure of seam and setting programs



5.2.2 Calling up seam programs

To call up a seam program:

1. Switch on the main switch.

↳ The machine starts up.
The control initializes.
The seam program previously used is loaded.

2. Press one of the buttons 1 to 0 .

↳ The selected seam program is loaded.

5.2.3 Calling up the parameter menu

To call up the parameter menu:

1. Switch on the main switch.

↳ The machine starts up.
The control initializes.
The seam program previously used is loaded.

2. Press the P button.

↳ The selection menu is loaded.

3. Press one of the buttons 1 to 0 .

↳ The display changes over to the corresponding function.

5.2.4 Manual stacking

To stack manually:

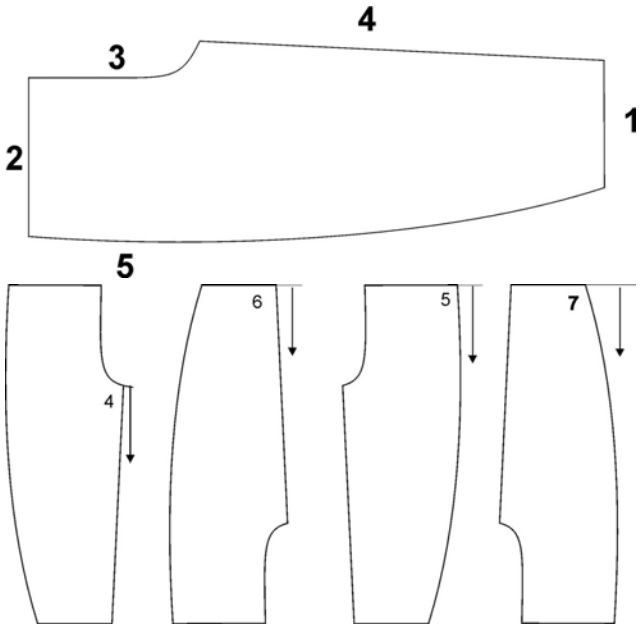
1. Select the seam program.

2. Press the F2 button.

↳ The throw-over stacker completes a stacking movement.

5.3 Seam programs

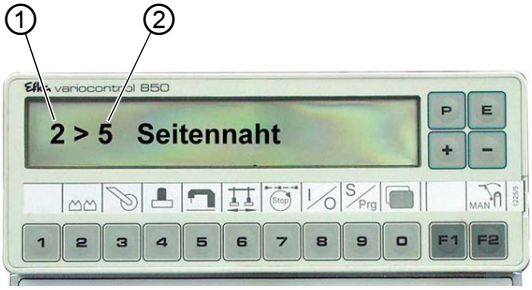
Fig. 19: Seam programs



Designation of the individual seams
1 = hem
2 = waistband
3 = fly seam or seat seam
4 = crotch seam
5 = side seam
6 = crotch seam from the hem
7 = side seam from the hem

A seam program as shown on the display of the control panel

Fig. 20: A seam program as shown on the display of the control panel



(1) - Seam program number *(2) - Seam number*

Standard seam programs

The machine ships standard with 8 seam programs.

Seam program	Description
001	Crotch seam from the waistband
002	Side seam from the waistband
003	Crotch seam from the hem
004	Side seam from the hem
005	Side seam with prefabricated pocket from the waistband • Manual start
006	Side seam with prefabricated pocket from the hem • Automatic start up to the pocket • Finish seam manually
007	Crotch seam and side seam alternately
008	Crotch seam and side seam alternately

5.4 Setting the parameters

The parameter values are altered in the individual parameter menus.

To set the parameter values:

1. Press the P button.
2. Select the desired menu item.
3. Select the desired parameter using the buttons F1 and F2.
4. Press the E button.
5. Use the buttons + and - to change the parameter value.
6. Press the P button.

↳ The setting is saved.

7. Press the P button.

↳ The display returns to the selection menu.

8. Press the P button.

↳ The display returns to the seam program.

5.5 Seam-specific parameters

5.5.1 Setting the bottom feed

	Parameter	Setting range
	**07**: Length of path 1	0 - 00
	09: Length of path 2	0 - 00
	11: Length of path 3	0 - 00
	73: Fullness of path 1	ON/OFF
	74: Fullness of path 2	ON/OFF
	75: Fullness of path 3	ON/OFF

5.5.2 Setting the auxiliary roller

	Parameter	Setting range
	**13**: Number of stitches after which the auxiliary roller will be lowered	0 - 400
	14: Number of stitches specifying for how long the auxiliary roller will remain lowered	0 - 300

5.5.3 Setting the holding stamp

	Parameter	Setting range
	**15**: Time when the holding stamp is lowered	2 - 20
	16: Duration for which the warp separator will remain switched on	0 - 100
	17: Switch the throw-over stacker on/off	0/1
	47: Time of the stacker movement	0 - 2000
	57: Duration for which the holding stamp will remain lowered	0 - 2000

5.5.4 Setting machine parameters

	Parameter	Setting range
	**30**: Set sewing speed	0 - 8500
	31: switch manual sewing on/off	0/1
	32: Number of stitches specifying for how long table blowing will remain switched on	0 - 400
	44: Number of stitches until the edge guide is lowered	0 - 200
	60: Soft start speed	500 - 5000
	61: Switch soft start on/off	0/1
	76: Switch start via light barrier on/off	0/1
	77: Switch auto start on/off	0/1
	78: Number of stitches after which auto start will start	0 - 400
	98: Switch the lining clamp on/off	0/1

5.5.5 Setting the swivel device

	Parameter	Setting range
	**62**: Number of stitches after which the blade will extend	0 - 00
	63: Number of stitches specifying for how long the blade will remain retracted	0 - 00
	64: Switch the swiveling of the stacker on/off	0/1
	69: Light barrier start	0/1

5.5.6 Changing seam paths

	Parameter	Setting range
	**81**: Length of seam path 1	0 - 00
	82: Switch the speed reduction in seam path 1 on/off	0/1
	83: Speed reduction in seam path 1	0 - 7000
	84: Switch stop in seam on/off	0/1
	85: Switch the sewing foot lift in the seam on/off	0/1
	86: Length of seam path 2	0 - 00
	87: Switch the speed reduction in seam path 2 on/off	0/1
	88: Speed reduction in seam path 2	0 - 7000
	89: Switch stop in seam on/off	0/1
	90: Switch the sewing foot lift in the seam on/off	0/1
	86: Length of seam path 3	0 - 00
	87: Switch the speed reduction in seam path 3 on/off	0/1
	88: Speed reduction in seam path 3	0 - 7000
	89: Switch stop in seam on/off	0/1
	90: Switch the sewing foot lift in the seam on/off	0/1

5.6 Changing global parameters

	Parameter	Setting range
	**45**: Number of stitches until table blowing will be switched on	0 - 200
	46: Duration of the throw-over stacker pulse	0 - 2000
	47: Time of the throw-over stacker movement	
	48: Speed limit	max. 8500
	49: Speed at warp separation	0 - 5000
	50: Number of stitches until the thread tensioner will be opened (seam end)	0 - 50
	56: Seam programming ON/OFF • ON: Define the seam sequences in the current program • OFF: create the next free program with seams	0/1
	57: Duration for which the holding stamp will remain down	0 - 2000
	58: Display of the software version	
	59: Number of stitches specifying for how long the seam chain will be sucked (seam beginning)	0 - 150
	65: Thread tension lift at seam beginning	
	66: Fusing time	
	67: Time of the swiveling movement towards the stacker	
	68: Time when the swivel device swivels back	
	80: Reset daily piece counter	

5.7 Input/output test

The input - output test can be used to check the different input and output elements.

5.7.1 Input test

Input elements

Switch	Description
01	Light barrier 01
03	Light barrier 03, sewing start of hem
05	Switch *Program stop*
08	Lining clamp
09	Fusing stamp

To test the input elements:

1. Press the P button.
2. Press the 8 button.
3. Activate the corresponding input.
   Example: Cover the light barrier.
4. Press the button.

↳ The program is quit.

5.7.2 Output test

Output elements

Switch	Description
Y01	Sewing foot up/down
Y02	Thread tension lift open/closed
Y03	Edge guide up/down
Y04	Stacker pulse on
Y05	Holding stamp up/down
Y06	Auxiliary roller up/down
Y07	Swivel device on/off
Y08	Blade swiveling on/off
Y09	Tape feed on/off
Y10	Differential on/off
Y11	Fusing stamp up/down
Y12	Warp separator on/off
Y13	Table blowing on/off
Y14	Dirt suction on/off

To test the output elements:

1. Press the P button.
2. Press the 8 button.
3. Press the + button.
4. Use the buttons + and − to select the desired output element.

5. Press the F2 button.

↳ The output element is switched on or off.

6. Press the button.

↳ The program is quit.

5.8 Creating seam programs

Order

Before you can create a new seam program or delete an existing seam program, you must set the global parameter **56** to the value *0* (📖 *p. 47*).
Doing so switches off seam programming, preventing existing programs from being altered inadvertently.

To create a seam program:

1. Press the P button.
2. Press the 9 button (Prg = programs).
3. Briefly press the F1 button 2x.
4. Use one of the buttons 1 to 9 select a seam.
5. Press the E button.

↳ The selected seam is stored.

6. Use one of the buttons 1 to 9 select another seam.

OR

7. Press the P button.

↳ The new setting is saved.
The display returns to the selection menu.

Order

After creating a new seam program, you must reset the global parameter **56** to the value *1* (📖 *p. 47*).

5.9 Changing a seam program or sequence

Order

Before you can create a new seam program or delete an existing seam program, you must set the global parameter **56** to the value *0* (📖 *p. 47*).
Doing so switches off seam programming, preventing existing programs from being altered inadvertently.

To change a seam program or sequence:

1. Use one of the buttons 1 to 9 select the desired seam program.
2. Press the P button.
3. Press the 9 button (S 0 sequence).
4. Use the buttons + or − to select an available location.
5. Use one of the buttons 1 to 9 select a seam number.
6. Use the buttons + or − to select another available location.

OR

7. Press the P button.

↳ The seam program is stored, and the display returns to the selection menu.

5.10 Deleting a seam program

To delete a seam program:

1. Press the P button.
2. Press the 9 button.
3. Press the F2 button.

↳ The display shows *DELETE?*.

4. Press the F2 button.

↳ The seam program has been deleted.

5. Press the P button.

↳ The display returns to the selection menu.

5.11 USB key

Fig. 21: USB key

(1) - USB key

The USB key (1) is used to transfer and store the machine software.
The USB key (1) makes it possible to transfer program and parameter data to other machines.

5.11.1 Formatting the USB key

To format the USB key

1. Use your PC to format the USB key with the **FAT 16** file system.

5.11.2 Initializing the USB key

Fig. 22: Initializing the USB key

(1) - USB key

To initialize the USB key:

1. Switch off the main switch.
2. Plug the USB key (1) into the control.
3. Press and hold the **P** button.
4. Switch on the main switch.

   ↳ The display shows the message *USB. DEV. DETECT:.*
5. Press and hold the **P** button until the display shows the message *SERVICE - CODE*.
6. Enter code 3112.
7. Press the **E** button.

5.11.3 USB functions

Parameter	Function
Store and load global parameters File extension: *.PAR	
F-510	save from the control to the USB key
F-511	load from the USB key to the control
F-512	Compare USB key and control data
F-513	Delete data on the USB key
Storing and loading programs and seam parameters File extension: *.PAY	
F-514	save from the control to the USB key
F-515	load from the USB key to the control
F-516	Compare USB key and control data
F-517	Delete data on the USB key
Loading a new software version File extension: *.PRG	
F-523	load a new software version from the USB key to the control

Information

Since using the **FAT 16** system, the control assigns names with a maximum of 8 characters.

If the stored data comprises various program or parameter data, the control will assign a new name to each set of data.
You can rename the files as needed on your PC.

As a general rule, the control can only read data that is stored on the main level of the USB key. Data stored in subdirectories cannot be processed.

5.11.4 Writing data to the USB key

To write data to the USB key:

1. Enter the desired parameter.
2. Press the E button.
   ↳ The cursor flashes.
3. Press the F2 button.
   ↳ The file name assigned by the control appears.
4. Press the E button.
   ↳ The data is written to the USB key.

5.11.5 Loading data from the USB key

To load data from the USB key:

1. Enter the desired parameter.
2. Press the E button.
   ↳ The cursor flashes.
3. Press the F2 button.
   ↳ The name of the first file stored on the USB key appears.
4. Select the desired file using the buttons + or −.
5. Press the E button.
   ↳ The message *READ DATA YES = E* appears.
6. Press the E button.
   ↳ The data is loaded from the USB key.

5.11.6 Comparing data stored on the USB key with the data of the control

To compare data stored on the USB key with the data of the control:

1. Enter the desired parameter.
2. Press the E button.

↳ The file name assigned by the control appears.

3. Press the E button.

↳ The message *READ DATA YES = E* appears.

4. Press the E button.

↳ The data stored on the USB key is compared with the data of the control.
The message *READ DATA* appears.
The result of the comparison is displayed.

- ***DATA OK***: The data stored on the USB key is identical to the data of the control
- ***DATA DIFFERENT***: The data stored on the USB key is not identical to the data of the control

5.11.7 Deleting data from the USB key

To delete data from the USB key:

1. Enter the desired parameter:
2. Press the **E** button.

↳ The cursor flashes.

3. Press the **F2** button.

↳ The name of the first file stored on the USB key appears.

4. Select the desired file using the buttons **+** or **-**.
5. Press the **E** button.

↳ The data is deleted from the USB key.
The message *READY* appears.

5.11.8 Loading the software version from the USB key

To load the software version from the USB key:

1. Enter parameter 523.
2. Press the **E** button.

↳ The cursor flashes.

3. Press the **F2** button.

↳ The name of the first file stored on the USB key appears.

4. Select the desired parameter file using the buttons **+** or **-**.

5. Press the E button.

↳ The message *READ DATA YES = E* appears.

6. Press the E button.

↳ The data is read from the USB key.

7. Press the P button.

↳ The message *SAVE DATA* appears.

8. Wait for approx. 3 seconds until the message disappears.

9. Press the button E 2x.

↳ The cursor flashes.

10. Press the F2 button.

↳ The name of the first file stored on the USB key appears.

11. Select the desired program file using the buttons + or -.

12. Press the E button.

↳ The message *READ DATA YES = E* appears.

13. Press the E button.

↳ The data is read from the USB key.

14. Switch off and on the machine again.

↳ The new software version has been loaded.

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 (🕮 *Service Instructions)*.

Maintenance intervals

Work to be carried out	Operating hours			
	8	40	160	500
Remove lint and thread remnants	●			
Empty the suction container	●			
Check the water level		●		
Top off the oil reservoir	●			
Check the pneumatic 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!

Lint and thread remnants can impair the operation of the machine.

Clean the machine as described.

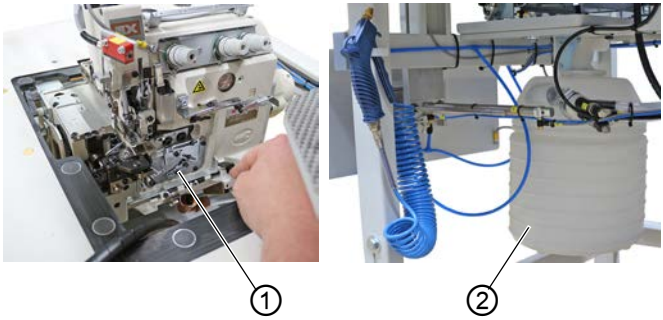
NOTICE

Property damage from solvent-based cleaners!

Solvent-based cleaners will damage paintwork.

Use only solvent-free substances for cleaning.

Fig. 23: Cleaning



(1) - Thread guides

(2) - Suction container

To clean the machine:

1. Blow out the area around the thread guides (1) using the compressed air gun.
2. Remove and empty the suction container (2).

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 oil-wick lubrication system. The bearings are supplied from the oil reservoir.

For topping off the oil reservoir, use only lubricating oil **DA 10** or oil of equivalent quality with the following specifications:

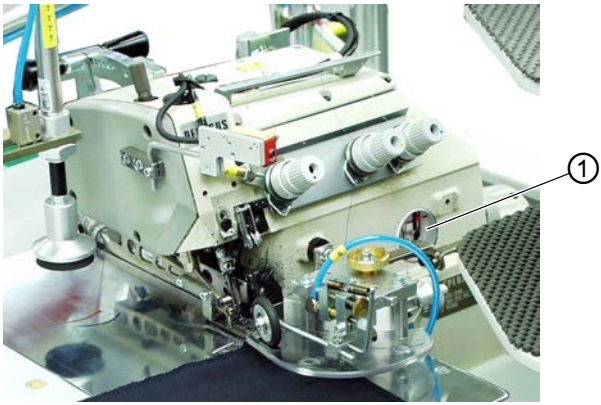
- Viscosity at 40 °C:10 mm^2/s
- Flash point: 150 °C

You can order the lubricating oil from our sales offices using the following part numbers.

Container	Part no.
250 ml	9047 000011
1 l	9047 000012
2 l	9047 000013
5 l	9047 000014

Checking the lubrication of the machine head

Fig. 24: Checking the lubrication of the machine head



(1) - Inspection glass

To check the lubrication of the machine head:

1. Check the oil level in the inspection window (1).
2. If necessary, top off the oil (📖 *Operating Instructions Machine head*).

6.3 Servicing the pneumatic system

6.3.1 Setting the operating pressure

NOTICE

Property damage from incorrect setting!

Incorrect operating pressure can result in damage to the machine.

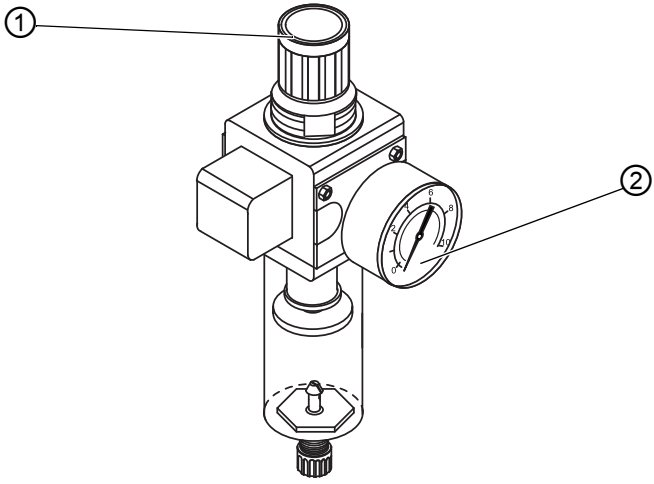
Ensure that the machine is only used when the operating pressure is set correctly.

Proper setting

Refer to the **Technical data** (📖 *p. 91*) 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. 25: Setting the operating pressure



(1) - Pressure controller *(2) - Pressure gage*

To set the operating pressure:

1. Pull the pressure controller (1) up.

2. Turn the pressure controller until the pressure gage (2) indicates the proper setting:
   - Increase pressure = turn clockwise
   - Reduce pressure = turn counterclockwise
3. Push the pressure controller (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.

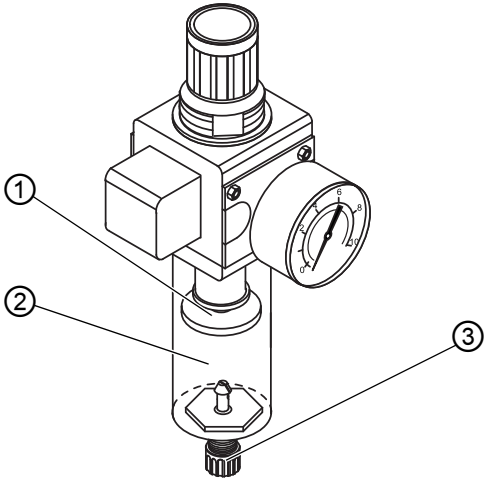
Water condensation accumulates in the water separator (2) of the pressure controller.

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. 26: 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

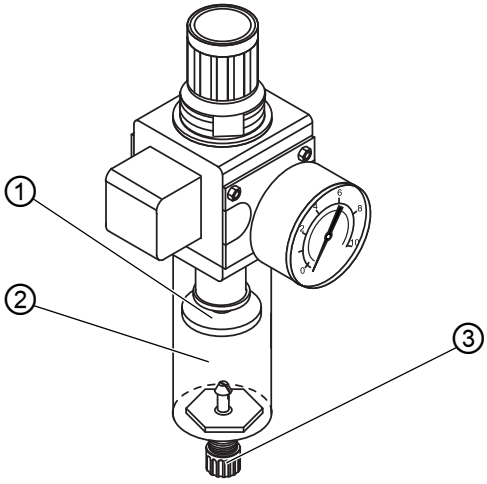
NOTICE

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. 27: 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. 67*).
3. Loosen the water separator (2).
4. Loosen 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 foils
- Lashing straps at reel stand and stand
- Lashing strap at throw-over stacker

7.3 Setting 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.

The working height is adjustable between 850 and 1200 mm (clearance between the floor and upper edge of the tabletop).

Fig. 28: Setting the working height

(1) - Screws

To set the working height:

1. Loosen the screws (1) on the stand bars.
2. Set 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 (1).

7.4 Assembling the reel stand

Fig. 29: Assembling the reel stand

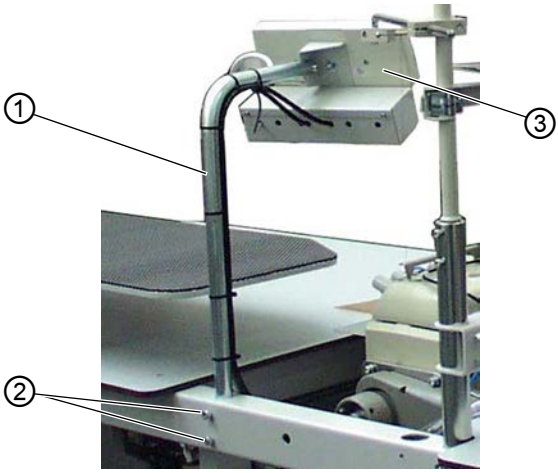
(1) - Reel stand tube
(2) - Screws
(3) - Bracket

To assemble the reel stand:

1. Insert the real stand tube (1) into the bracket (3).
2. Tighten the screws (2).

7.5 Assembling the control panel

Fig. 30: Assembling the control panel



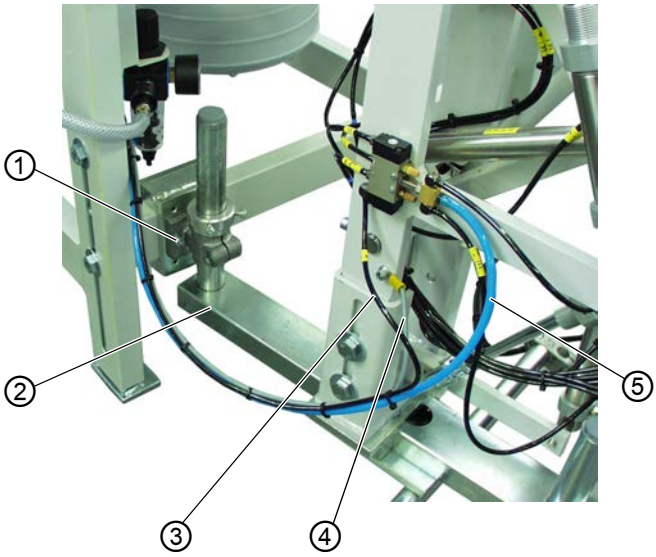
(1) - Supporting tube
(2) - Screws
(3) - Control panel

To assemble the control panel:

1. Loosen the screws (2).
2. Pull up the supporting tube (1) along with the control panel (3) as far as it will go.
3. Tighten the screws (2).

7.6 Assembling the throw-over stacker

Fig. 31: Assembling the throw-over stacker (1)

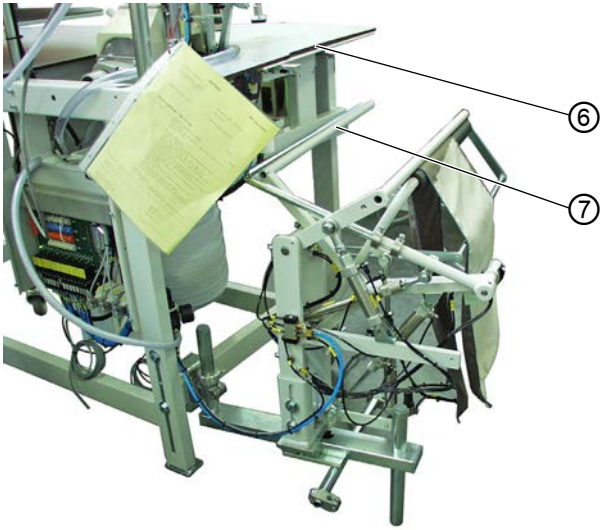


(1) - Screws
(2) - Bracket
(3) - Compressed air line
(4) - Grounding wire
(5) - Compressed air line

To assemble the throw-over stacker:

1. Move the throw-over stacker with bracket (2) up to the machine.
2. Tighten the bracket (2) to the machine using the screws (1). Do not yet tighten the screws (1) all the way.

Fig. 32: Assembling the throw-over stacker (2)

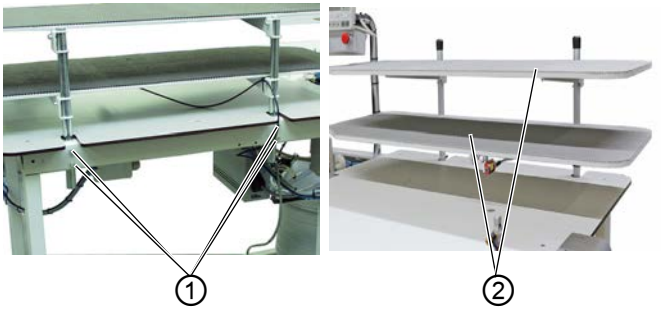


(6) - Edge of the tabletop *(7) - Smoother*

3. Align the throw-over stacker such that the smoother (7) is parallel to the edge of the tabletop (6).
4. Tighten the screws (1).
5. Tighten the grounding wire (4) at the throw-over stacker.
6. Slip the compressed air lines (3) and (5) onto the junction.

7.7 Aligning the sewing material surfaces

Fig. 33: Aligning the sewing material surfaces



(1) - Screws

(2) - Sewing material surfaces

To align the sewing material surfaces:

1. Loosen the screws (1).
2. Set the sewing material surfaces (2) to the desired height.
3. Tighten the screws (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 mains 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 setting!

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 Setting the operating pressure

7.9.3 Setting the operating pressure

NOTICE

Property damage from incorrect setting!

Incorrect operating pressure can result in damage to the machine.

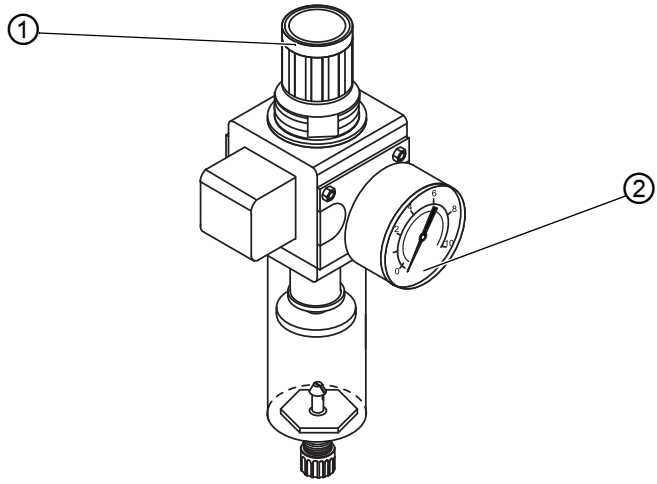
Ensure that the machine is only used when the operating pressure is set correctly.

Proper setting

Refer to the **Technical data** (📖 *p. 91*) 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. 34: Setting the operating pressure



(1) - Pressure controller *(2) - Pressure gage*

To set the operating pressure:

1. Pull the pressure controller (1) up.
2. Turn the pressure controller until the pressure gage (2) indicates the proper setting:
   - Increase pressure = turn clockwise
   - Reduce pressure = turn counterclockwise
3. Push the pressure controller (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. Remove residual oil from the oil pan using a cloth.
5. Cover the control panel to protect it from soiling.
6. Cover the control to protect it from soiling.
7. Cover the entire machine if possible to protect it from contamination and damage.

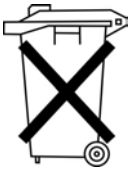
9 Disposal

CAUTION

Risk of environmental damage from improper disposal!

Improper disposal of the machine can result in serious environmental damage.

ALWAYS comply with the national regulations regarding disposal.



The machine must not be disposed of in the normal household waste.

The machine must be disposed of in a suitable manner in accordance with all applicable national regulations.

When disposing of the machine, be aware that it consists of a range of different materials (steel, plastic, electronic components, etc.). Follow the national regulations when disposing these materials.

10 Troubleshooting

10.1 Customer Service

Contact for repairs and issues with the machine:

Dürkopp Adler GmbH

Potsdamer Str. 190
33719 Bielefeld, Germany

Tel. +49 (0) 180 5 383 756
Fax +49 (0) 521 925 2594
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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.

Code	Meaning
Error 3	You should delete the last existing seam in the program currently used
Info B1	Switch on the control in boot mode and press the **F2** button
Info B2	programmed segment number
Info B3	Flash programming failed
Info B4	Flash programming OK

Code	Meaning
Info U1	FP custom code incorrect, e. g. describing a parameter that does not exist
Info U2	wrong system function
Info U3	wrong In/Out number
Info U4	too many user variables
Info U5	too many system variables
Info U6	User program does not fit in memory
Info U7	wrong or non-defined button on control panel
Info U8	unknown device address
Info U9	fatal exception error

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

Error	Possible causes	Remedial action
Missing 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
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

Data and characteristic values

Technical data	Unit	1225-6
Machine type		One-button sewing unit
Type of stitches		503/504
Hook type		Overlock hook
Number of needles		1
Needle system		B27
Needle strength	[Nm]	80 - 110
Thread strength	[Nm]	Bulked thread/120
Stitch length	[mm]	1.0 mm - 5.0 mm
Speed maximum	[min^{-1}]	7500
Speed on delivery	[min^{-1}]	7000
Seam clearance	[mm]	6 mm, 5 mm, 4 mm
Mains voltage	[V]	1x230 V
Mains frequency	[Hz]	50/60
Operating pressure	[bar]	6
Length	[mm]	1500
Width	[mm]	900
Height	[mm]	1400
Weight	[kg]	120
Power input	[kVA]	0.9

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