

Additional Instructions

Attaching and cutting the chest pieces

IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE

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1 General information

Components of the kit

Check whether the scope of delivery for kit 0272 590034 is correct prior to installation.

Part number	Quantity	Designation
0999 240392	1	WI-E coupling
9731 006004	1	Hose, 3 m
B1100161.30	1	Pneumatic valve
0272 360030	1	Bracket
9203 003177	2	Cylinder-head bolt M3x40
9207 170227	2	Chipboard screw 3.5x16
0797 002017	2	Hose connector
9731 005004	1	Hose, 2 m
9710 920018	1	Throttle valve
9790 000220	1	Plug nipple
0699 979265	1	Hose, 1 m
0272 360010	1	Blow tube
0272 360020	1	Holder
9202 002487	1	Cylinder-head bolt M5x12
9880 002005	1	Knee button
9870 272007	1	Cable
0999 240402	1	T-R coupling
9840 120003	7	Nail clamp
9840 123003	7	Steel nail
0791 272700 EN	1	Additional Instructions

2 Assembly

2.1 Assembling the blow tube

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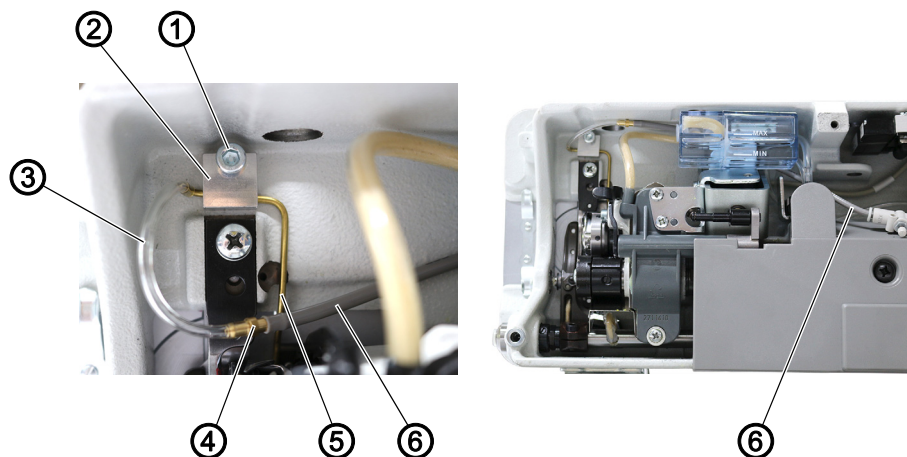


Risk of death from live components!

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

Only qualified specialists may perform work on electrical equipment.

Fig. 1: Assembling the blow tube (1)



- (1) - Screw
- (2) - Plate
- (3) - Hose

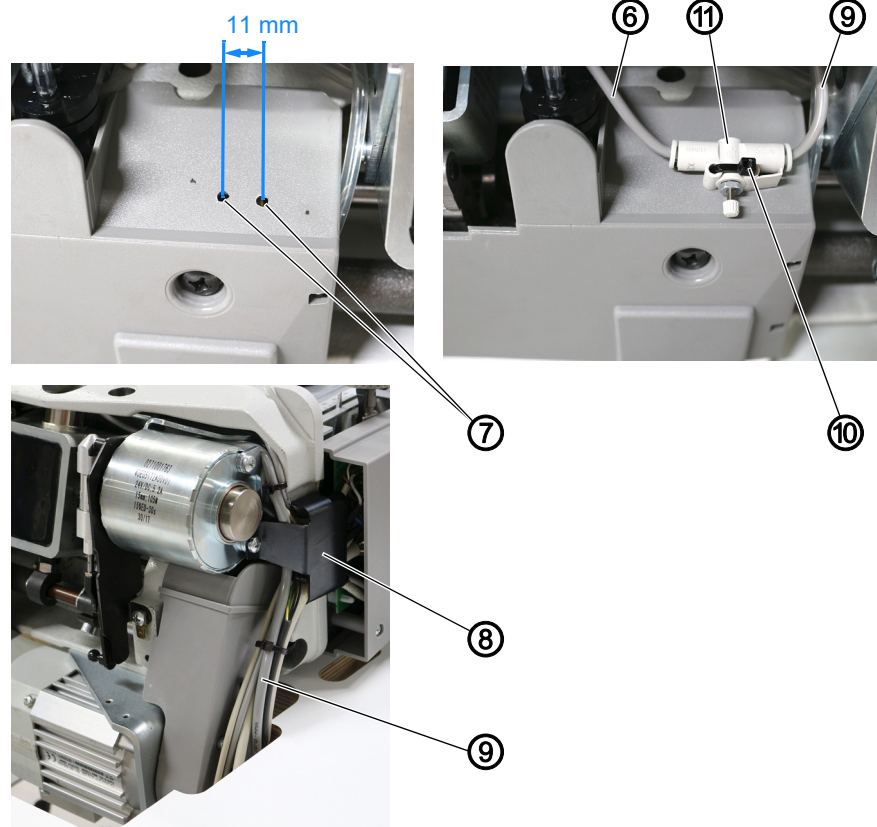
- (4) - Plug nipple
- (5) - Blow tube
- (6) - Hose



To assemble the blow tube:

1. Switch off the machine.
2. Disconnect the compressed air supply.
3. Tilt the machine head.
4. Connect the blow tube (5) with the transparent hose (3).
5. Use the screw (1) and the plate (2) to attach the blow tube in the machine head on the left close to the hook.
Make sure the blow tube does not come into contact with the hook.
6. Connect the transparent hose (3) and the hose (6) to one another using the plug nipple (4).

Fig. 2: Assembling the blow tube (2)



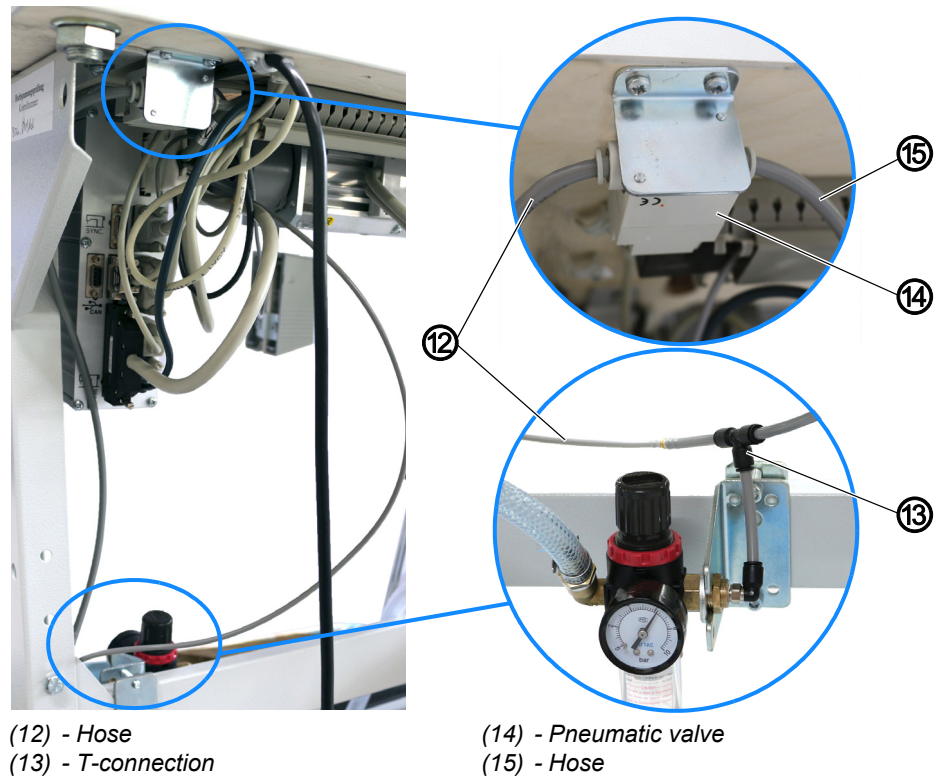
- (6) - Hose
- (7) - Holes
- (8) - Guide

- (9) - Hose
- (10) - Cable tie
- (11) - Throttle valve



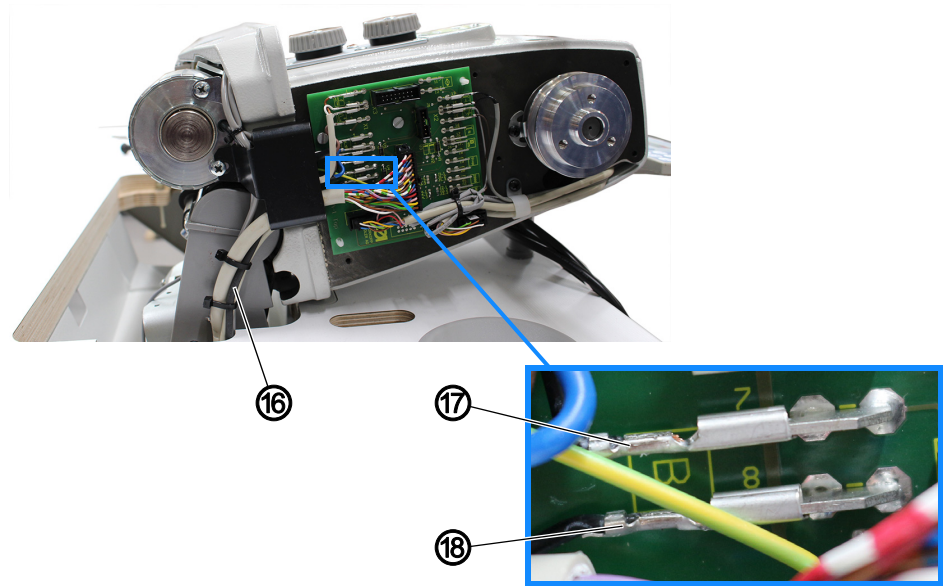
7. Drill 2 holes (7) with \varnothing 5 mm into the center of the oil pan at a distance of approx. 11 mm.
8. Attach the throttle valve (11) with the cable tie (10) at the holes (7) in the oil pan.
9. Insert hoses (6) and (9) into the throttle valve (11).
10. Lay the hose (9) inside the machine.
11. Feed the hose (9) through the guide (8) and the slot in the tabletop.

Fig. 3: Assembling the blow tube (3)



12. Connect hose (9) with hose (15) using the plug nipple.
13. Attach the pneumatic valve (14) at the bracket and tighten it on the tabletop.
14. Follow the labellings to connect hoses (12) and (15) with the pneumatic valve (14).
 - Hose (15) for the exhaust air: Connection **2**
 - Hose (12) for the supply air: Connection **1**
15. Connect the hose (12) to the T-connection (13) of the compressed air maintenance unit.
16. Erect the machine head.

Fig. 4: Assembling the blow tube (4)



(16) - Cable

(17) - Cable

(18) - Cable



17. Disassemble the belt cover.

18. Tilt the machine head.

19. Connect the cable (16) of the pneumatic valve (14) to the PCB.

- Cable (18) labeled 1: Slot 7
- Cable (17) labeled 2: Slot 8

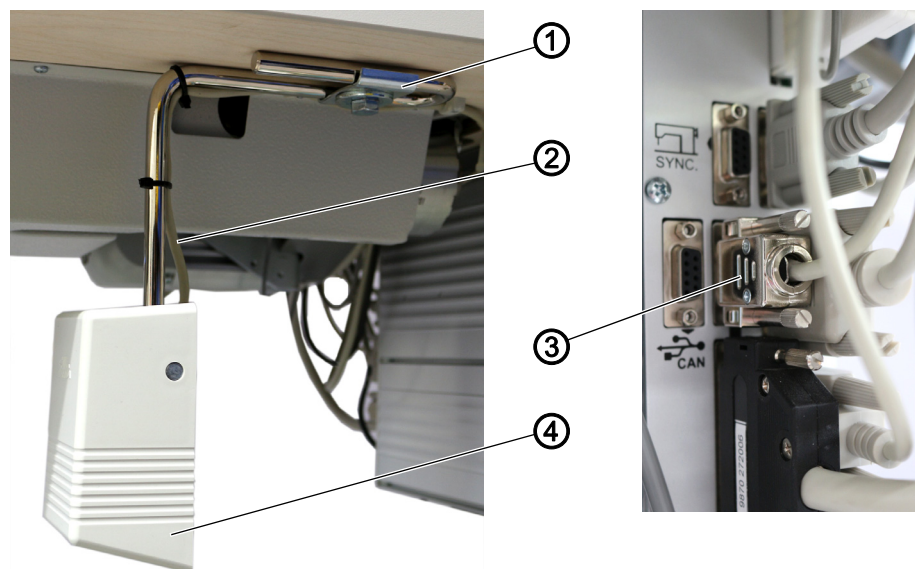
20. Erect the machine head.

21. Assemble the belt cover.

22. Restore the compressed air supply.

2.2 Assembling the knee button

Fig. 5: Assembling the knee button



(1) - Clip
(2) - Cable

(3) - Plug
(4) - Knee button



To assemble the knee button:



1. Position the knee button (4) such that it can be easily operated with the knee.
2. Tighten the knee button (4) with the clip (1) on the tabletop.
3. Use cable ties to attach the cable (2) to the knee button (4) and guide it along below the tabletop.
4. Connect the plug (3) with the control.

3 Software settings

3.1 Activating the blow tube



To activate the blow tube in the software:

1. Press buttons  and  at the same time.
2. Switch on the machine.
- ↳ You are on the Technician level.
3. Use the buttons below the display to call up and set the desired parameter.

Parameter	Value	Description
t 11 00	14	Function of function module 1 (X1.30)
t 11 09	2	Condition of function module 1 (X1.30) prior to thread cutting
t 31 01	1	Stitch shortening during thread cutting
t 51 28	8	Toggle switch at knee button down
t 51 29	8	Toggle switch at knee button up

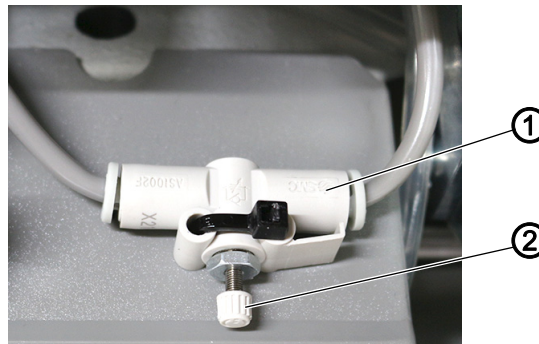
3.2 Checking the function of the blow tube



Proper setting

The hook must not pick up the needle thread loop.
Stitch formation is prevented.

Fig. 6: Checking the function of the blow tube



(1) - Throttle valve

(2) - Screw



To check the function of the blow tube:

1. Press the knee button and check if air is blown through the blow tube.
2. Perform a sewing test and check if the needle thread loop is reliably blown away from the hook tip.

3. If the needle thread loop is not blown away far enough from the hook:
 - Turn the screw (2) on the throttle valve (1) and lock it with the nut when the position is correct.

AND/OR

- Position the blow tube closer to the hook.



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