



513

Additional Instructions

Contraction clamp

**IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE**

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1 General information

The contraction clamp is required for bartacking buttonholes.

Components of the kit

Check whether the scope of delivery for kit 0513 590014 is correct prior to installation.

Part number	Quantity	Description
0512 220224	1	Contraction clamp
0532 10023934	1	Retaining bracket
0532 10010074	2	Screw
0512 10037834	1	Lever
0512 10037835	1	Roller
0512 10011707	1	Screw
9202 002907	1	Screw
0791 513700 EN	1	Instructions

2 Conversion

The conversion sequence consists of several different work steps. The fault-free execution of these steps is necessary for achieving a good result.

2.1 Preparing the machine for the conversion

WARNING



Risk of injury from moving, cutting and sharp parts!

Crushing, cutting and punctures are possible.

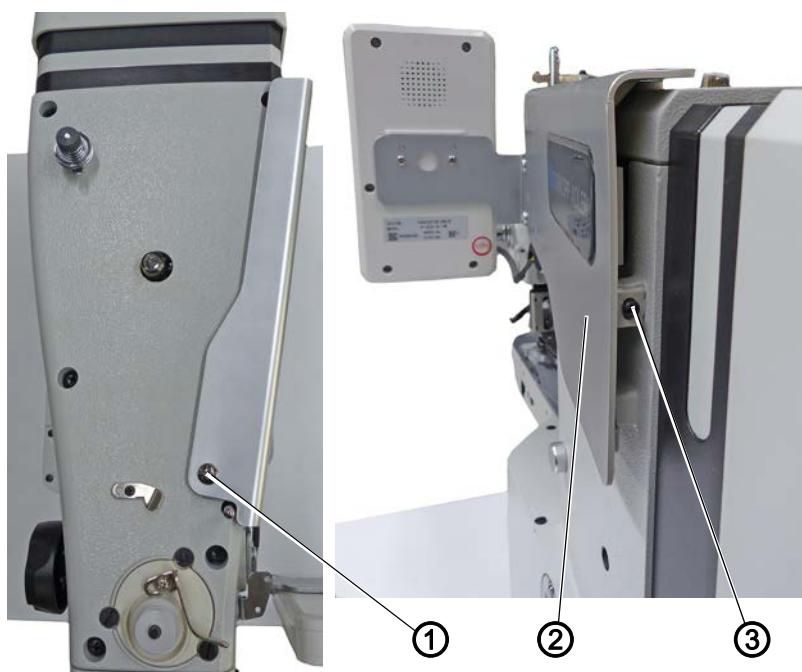
If possible, make preparations only when the machine is switched off.

Complete the following steps in preparation of converting the machine:

- Switch off the machine and disconnect it from the power supply
- Remove the needle

2.2 Disassembling the clamp lifting parts

Fig. 1: Disassembling the clamp lifting parts (1)



(1) - Screw
(2) - Design faceplate

(3) - Screw

1. Loosen screw (1).

2. Loosen screw (3).
3. Slide the design faceplate (2) back and remove it carefully, making sure not to damage any cables.

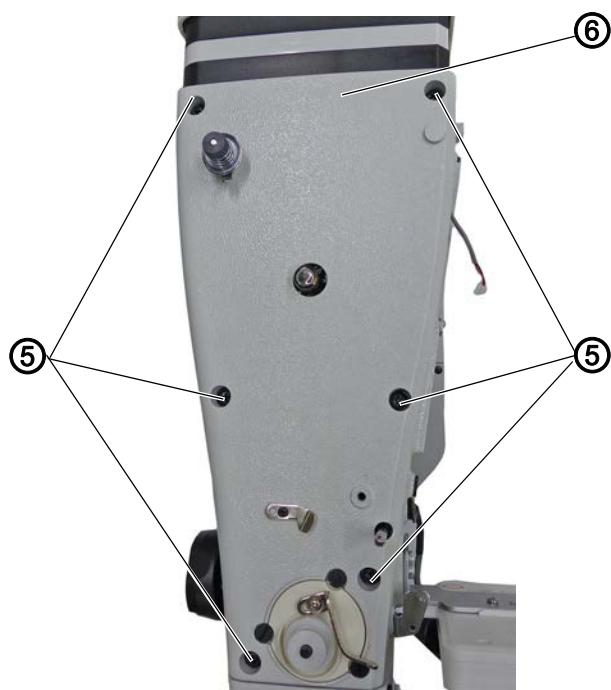
Fig. 2: Disassembling the clamp lifting parts (2)



(4) - Plug connection

4. Disconnect the plug connection (4).

Fig. 3: Disassembling the clamp lifting parts (3)



(5) - Screws

(6) - Arm cover

5. Loosen the 6 screws (5).
6. Disassemble the arm cover (6).

Fig. 4: Disassembling the clamp lifting parts (4)



(7) - Screw

7. Loosen screw (7).

Fig. 5: Disassembling the clamp lifting parts (5)



(8) - Springs

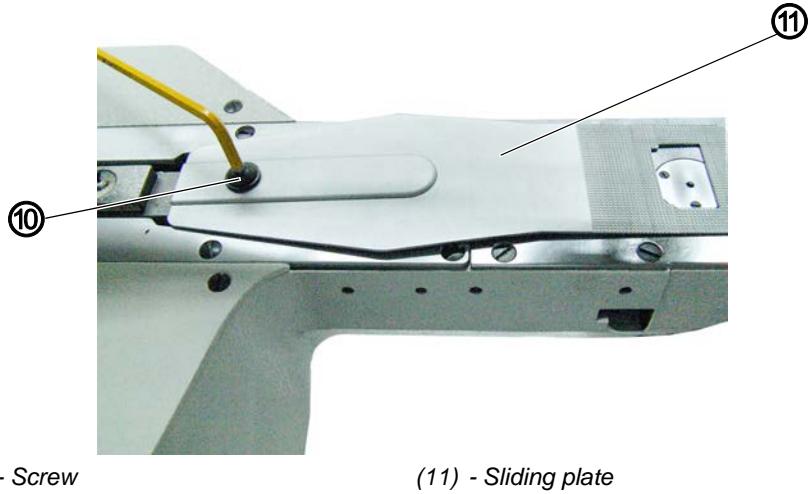
(9)



(9) - Balls

8. Relieve the springs (8) and remove the clamp, making sure not to lose the balls (9).

Fig. 6: Disassembling the clamp lifting parts (6)

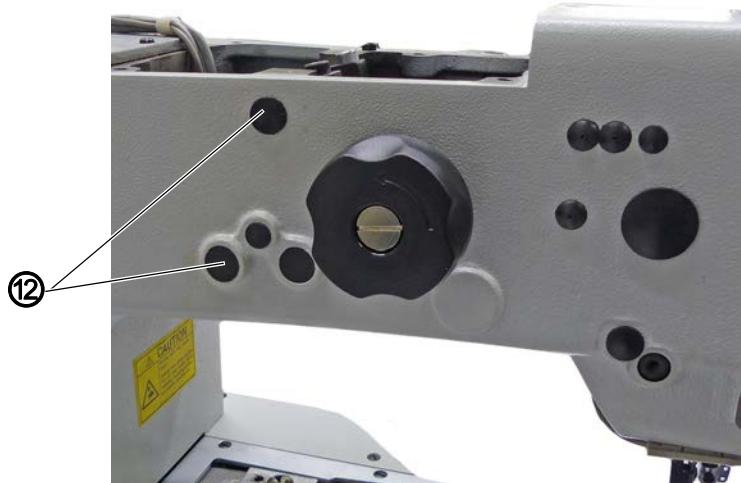


(10) - Screw

(11) - Sliding plate

9. Loosen screw (10).
10. Remove the sliding plate (11).

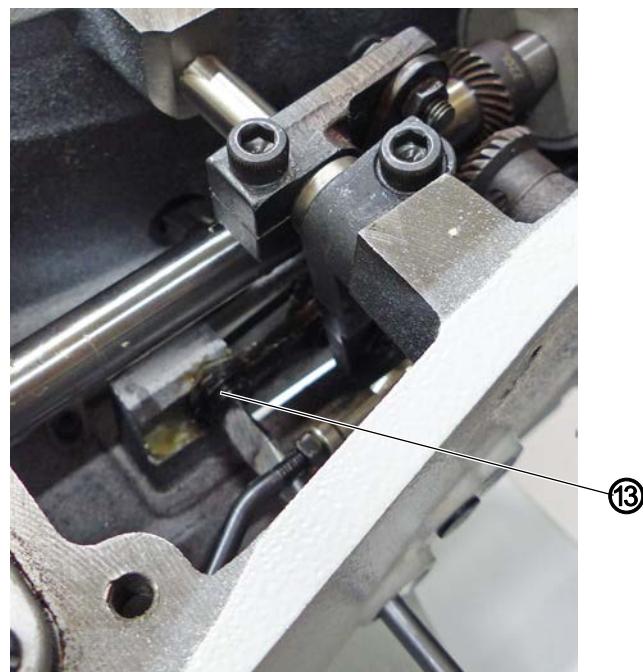
Fig. 7: Disassembling the clamp lifting parts (7)



(12) - Plug

11. Remove the plug (12).

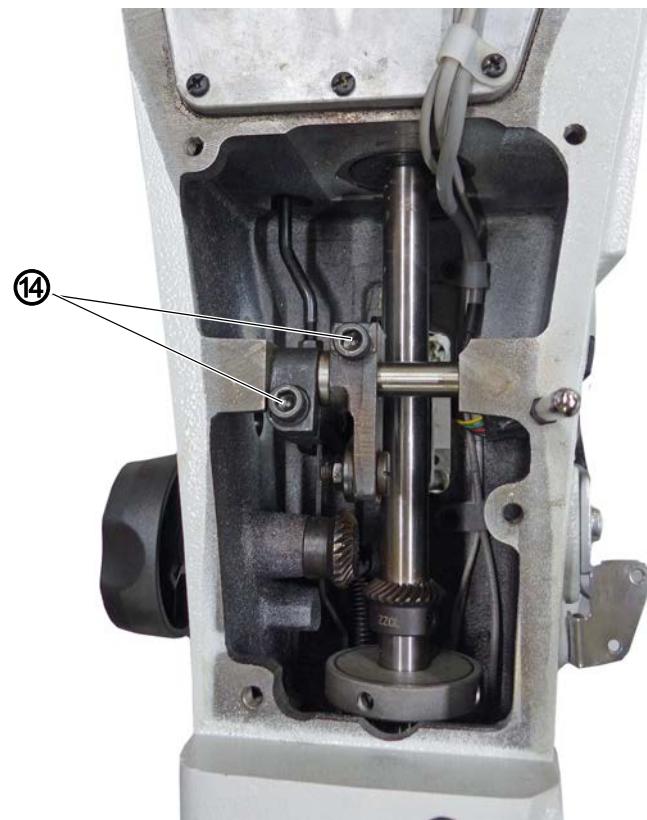
Fig. 8: Disassembling the clamp lifting parts (8)



(13) - Screw

12. Loosen and remove the screw (13).

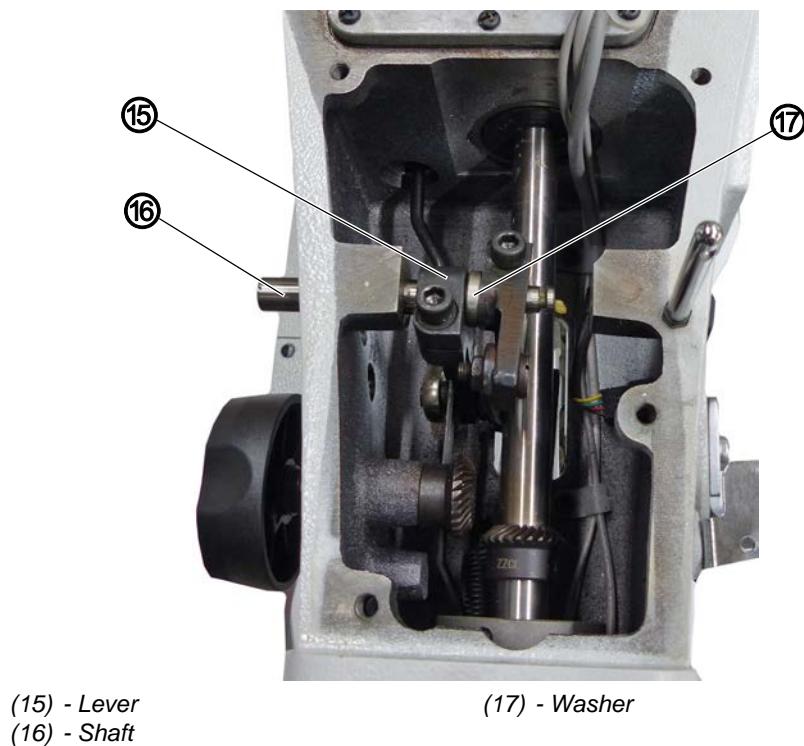
Fig. 9: Disassembling the clamp lifting parts (9)



(14) - Screws

13. Loosen the screws (14).

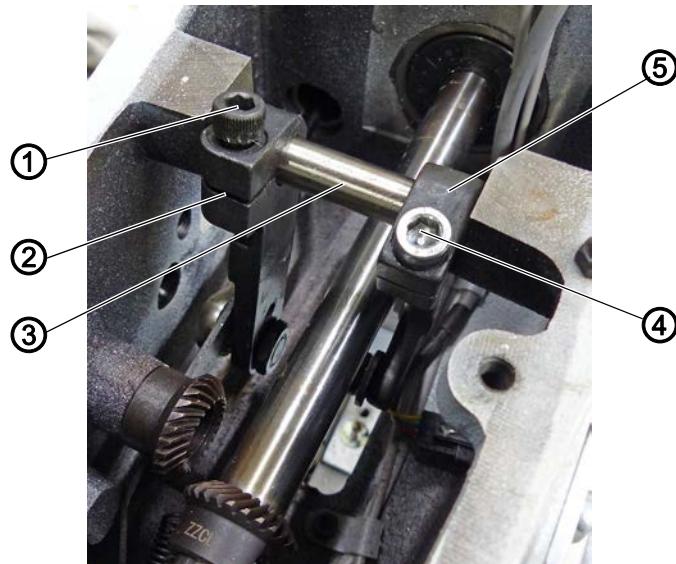
Fig. 10: Disassembling the clamp lifting parts (10)



14. Loosen and pull out the shaft (16).
15. Remove lever (15) and washer (17).

2.3 Assembling the contraction clamp parts

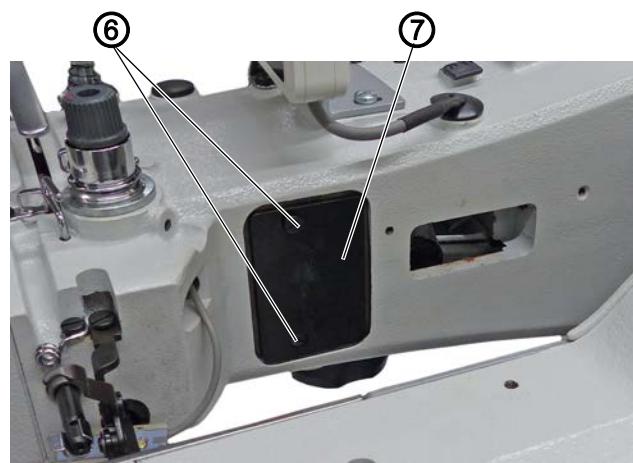
Fig. 11: Assembling the contraction clamp parts (1)



- | | |
|-------------|-------------|
| (1) - Screw | (4) - Screw |
| (2) - Lever | (5) - Lever |
| (3) - Shaft | |

1. Insert the new lever (5).
2. Push in the shaft (3) as far as it will go.
3. Attach the lever (2) using the screw (1).
4. Preset the new lever (5) to a position similar to the one on the left using the screw (4).

Fig. 12: Assembling the contraction clamp parts (2)



- | | |
|--------------|-------------|
| (6) - Screws | (7) - Plate |
|--------------|-------------|

5. Tilt the machine.
6. Loosen 2 screws (6) of the plate (7).
7. Remove the plate (7).

Fig. 13: Assembling the contraction clamp parts (3)



(8) - Holder

(9) - Screws

8. Assemble the holder (8) using the screws (9).

Fig. 14: Assembling the contraction clamp parts (4)

(10) - Clamp
(11) - Hole

(12) - Pins

9. Use the pins (12) to position the clamp (10) on the underside and at the hole (11).

Fig. 15: Assembling the contraction clamp parts (5)

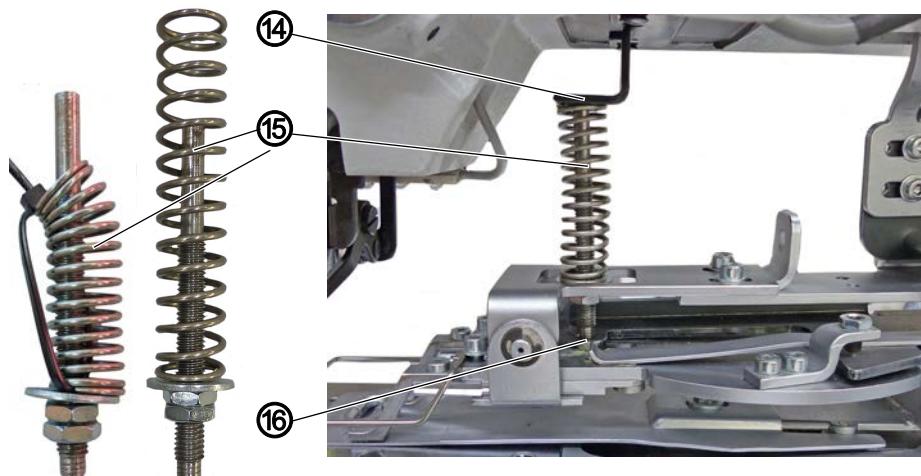


(10) - Clamp

(13) - Screw

10. Attach the clamp (10) using the screw (13).

Fig. 16: Assembling the contraction clamp parts (6)

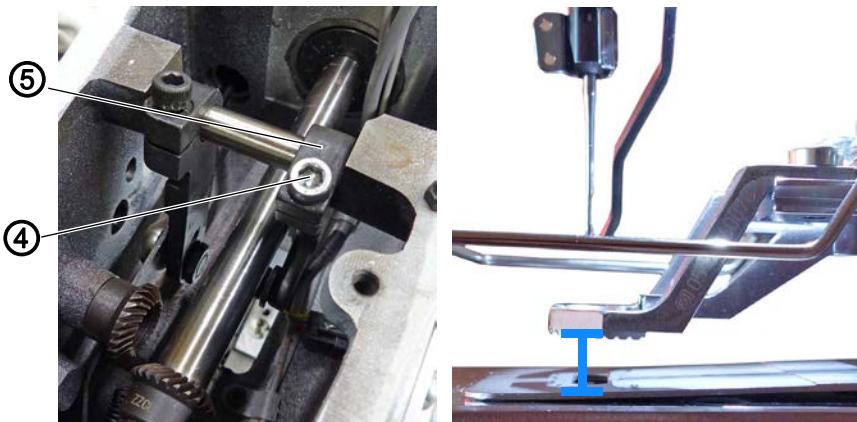


(14) - Retaining bracket
 (15) - Spring

(16) - Fixture

11. Contract the spring (15) using a cable tie.
12. Grab the spring (15) by the thread and insert the other end into the retaining bracket (14) first before inserting the end with the thread into the lower fixture (16).
13. Insert the plug again.

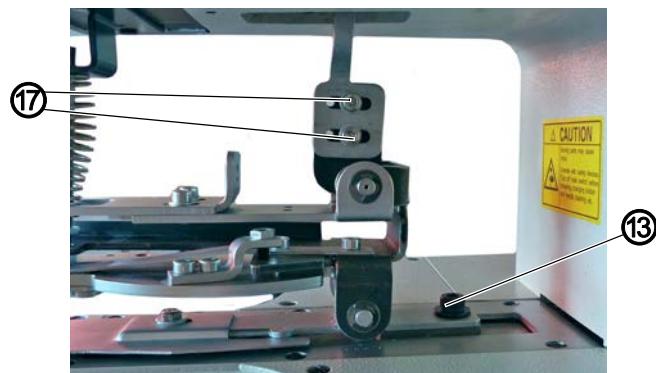
Fig. 17: Assembling the contraction clamp parts (7)



(5) - Lever
 (4) - Screw

14. Loosen the screw (4) and use the lever (5) to adjust the lifting height (marked blue) of the contraction clamp to approximately 8 to 10 mm.
15. Move the lever (5) and tighten the screw (4) again

Fig. 18: Assembling the contraction clamp parts (7)



(17) - Screws

(13) - Screw

16. If you cannot reach the desired lifting height by adjusting the lever:
Loosen the 2 screws (17), slide the clamp to the front/rear, and tighten
the screws (17) again.

Fig. 19: Assembling the contraction clamp parts (8)



(18) - Needle hole

17. Check the position of the contraction clamp relative to the needle hole (18) and adjust it if necessary.
 18. To make the adjustment, loosen the screw (13), align the contraction clamp and tighten the screw (13) again.
 19. Assemble the arm cover and design faceplate in reverse order.

3 Settings in the software

3.1 Adjusting the parameters

3.1.1 Parameter U135

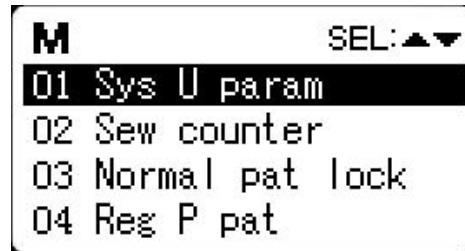
This parameter is used to ensure that the contraction clamp is positioned in the center when sewing begins.



To set the U135 parameter:

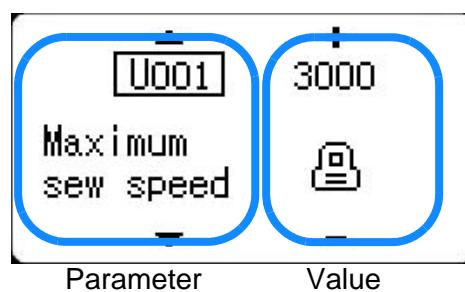
1. Press the **M** button.
- ↳ The system menu appears:

Fig. 20: Parameter U135 (1)



2. Use the arrow buttons **◀ ▶** to select the *01 Sys U param* menu item.
 3. Press the **✎** button to confirm.
- ↳ The submenu for setting the parameters appears:

Fig. 21: Parameter U135 (2)



4. Use the **◀ ▶** buttons to select parameter U135.
 5. Use the **+[−]** buttons to set value 1.
 6. To save your setting, press the **✎** button.
- ↳ The settings have been saved, and you have been returned to the system menu.

7. Press the  button again.
- ↳ The machine is ready to sew again.

3.1.2 Parameter K027

NOTICE

Property damage may occur!

The technician level allows you to adjust settings that may cause the machine to stop working properly.

ALWAYS check if the setting is correct. ALWAYS check if a setting erases data.

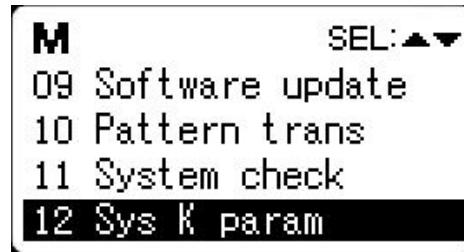
This parameter can be used to adjust the speed of the clamp.



To set the K027 parameter:

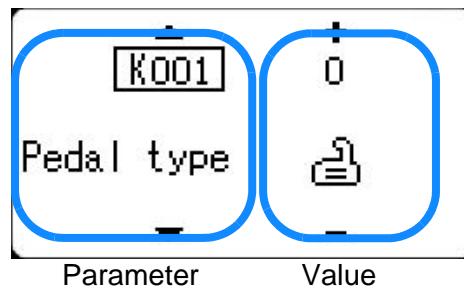
1. Press and hold the  button until a signal tone sounds.
- ↳ The system menu appears:

Fig. 22: Parameter K027 (1)



2. Use the arrow buttons   to select the 12 Sys K param menu item.
 3. Press the  button to confirm.
- ↳ The submenu for setting the parameters appears:

Fig. 23: Parameter K027 (2)



4. Use the  buttons to select parameter K027.
5. Press the  button.
- ↳ The display shows a prompt to enter the password.
6. Enter the password 496378829 using the 
7. Press the  button to confirm.
8. Use the  buttons to set value 1500.
9. To save your setting, press the .
- ↳ The settings have been saved, and you have been returned to the system menu.
10. Press the  button again.
- ↳ The machine is ready to sew again.

3.2 Activating/deactivating a seam program

NOTICE

Property damage may occur!

The built-in clamp may become damaged, making it impossible to continue sewing.

ALWAYS check if the built-in clamp and the seam program match.
Lock unsuitable seam programs!

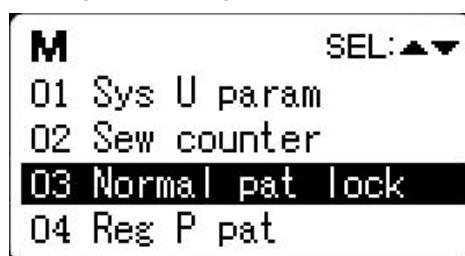
If a seam program cannot be selected, the lock may still be active (default setting for seam programs 101 through 200).



To unlock seam programs:

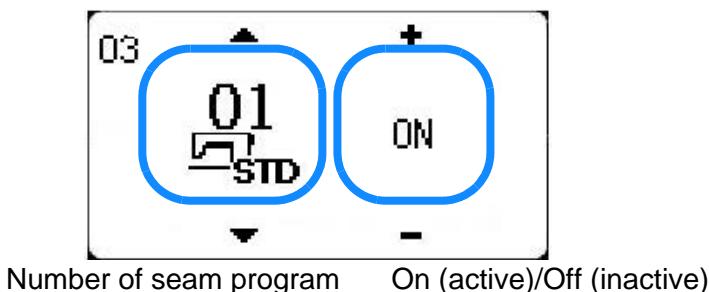
1. Press the .
- ↳ The system menu appears:

Fig. 24: Activating/deactivating a seam program (1)



2. Use the arrow buttons  to select the *03 Normal pat lock* menu item.
3. Press the  button to confirm.
 ↵ The display shows the submenu for activating/deactivating the seam programs:

Fig. 25: Activating/deactivating a seam program (2)



4. Use the  buttons to select the seam program number.
5. Use the  buttons to active or deactivate the seam program.
6. To save the settings, press the  button.
 ↵ The settings have been saved, and you have been returned to the system menu.
7. Press the  button again.
 ↵ The machine is ready to sew again.

3.3 Performing a manual test run

To check if the selected seam program matches the installed clamp, you can perform a manual test run.



To perform a manual test run:

1. Press the  button.
2. Use the arrow buttons  to select the desired seam program.
3. Press the  button.
4. Press the  button.
 ↵ The machine enters the manual test run mode.

5. You can use the  buttons to check stitch by stitch if the seam program will cause collisions with the clamp.
6. Press the  button.
☞ The machine is ready to sew now.



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