

**Part 2: Installation Instructions Cl. 550-12-12**

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## 1. Scope of Delivery

Basic equipment consists of:

- Complete sewing machine for advance crimping
- Frame MG53-3 with pallet table top 1530 x 951 mm
- Multi-program controls 200-3
- Direct current positioning drive
- Compressed Air Maintenance Unit
- Sewing light
- Thread stand
- Tools and small parts in the accessories pack

Optional equipment Bordering (special order)

## 2. Installing the Sewing Unit



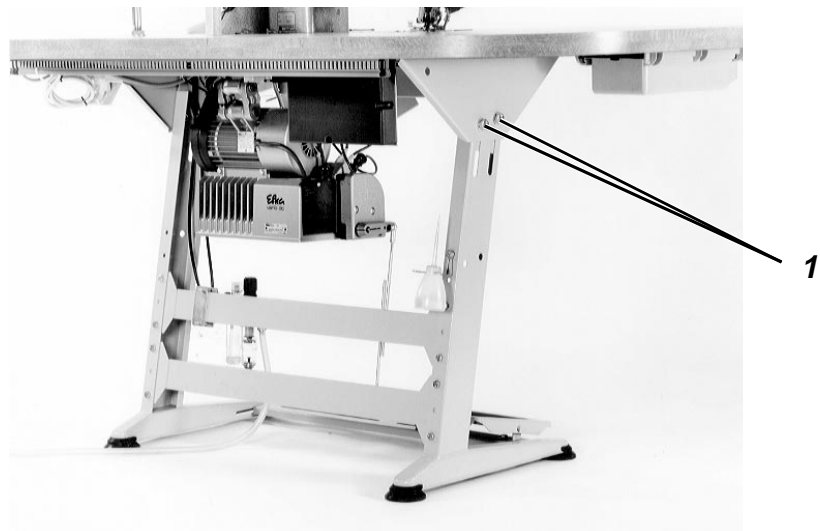
### ATTENTION !

The sewing unit may only be set up by trained skilled personnel.

Before installing the sewing unit it is essential that all transport security be removed !

### 2.1 Setting the Work Height

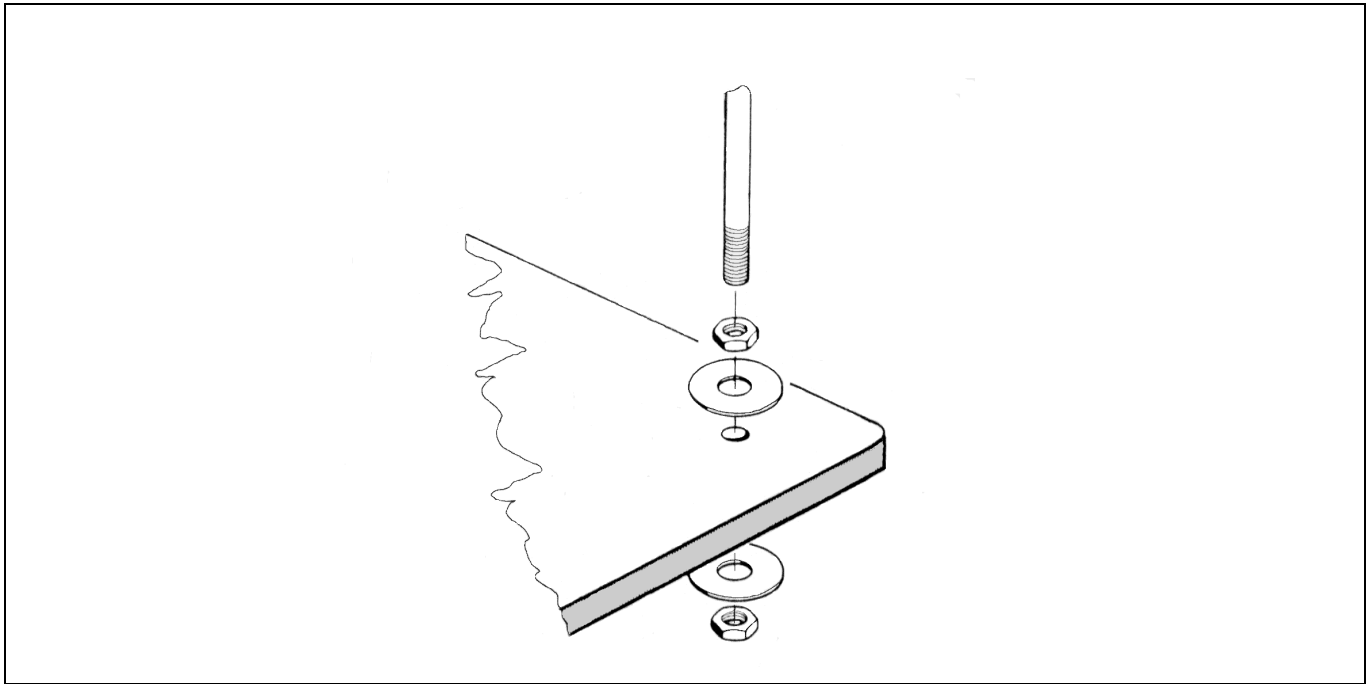
The work height is adjustable between 75 cm and 85 cm (measured to the top of the table).



- Loosen the set screws 1 on both sides of the frame.
- Horizontally set the work plate to the desired height.  
In order to avoid tilting pull out or push in the work plate equally on both sides.
- Tighten the set screws 1 again.



## 2.2 Mounting the Thread Stand



Mount the thread stand on the table top as shown in the sketch above.

## 2.3 Checking the V-belt Tension

After transport the V-belt tension set at the factory is to be checked. The V-belt 1 must be so tensioned that it can be pressed in at the center by about 10 mm under finger pressure.



Correcting V-belt tension:

- Loosen the nuts 2.
- Swing the sewing drive 3 until the desired V-belt tension is reached.
- Tighten the nuts 2 again.



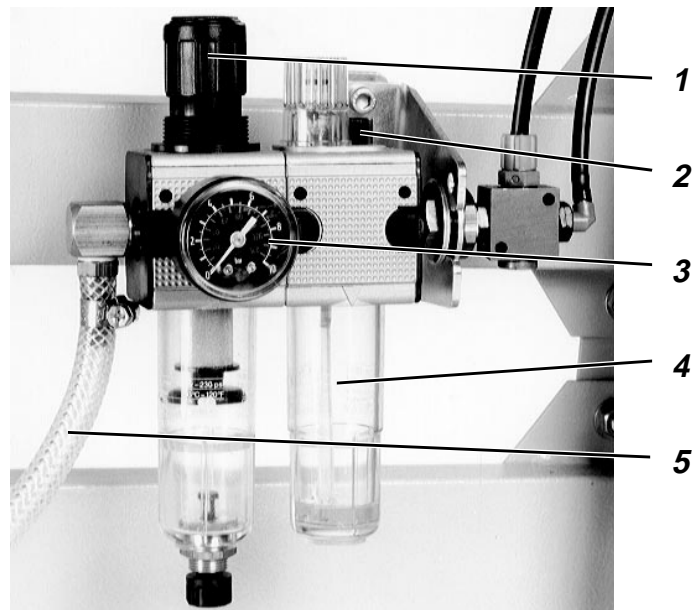
## 2.4 Filling Oil

For filling the oil reservoir use only **ESSO SP-NK 10** lubrication oil. SP-NK 10 is available from the **DÜRKOPP ADLER AG** sales offices.

- Fill the hook drive housing and the reservoir for the central oil wick lubrication up to the top line marking with oil (see chapter 3.2 of the Operating Instructions).

## 2.5 Connecting the Compressed Air Maintenance Unit

For the operation of the sewing foot stroke, stitch condensation, thread trimmer as well as the optional equipment for bordering the sewing unit must be supplied with water-free, lightly oiled compressed air.



### Connecting the compressed air maintenance unit

- Connect the connection hose 5 for the maintenance unit to the compressed air supply with the enclosed coupling.

### Filling the oil reservoir

- Completely shut off the compressed air by turning the knob 1 counter-clockwise.
- Screw out the oil fill screw 2.
- Fill the oil reservoir 4 up to the groove marking with **ESSO SP-NK 10** lubrication oil.
- After filling the oil release the compressed air again by pulling up the knob 1 and turning it clockwise.

### Setting the operating pressure

- The operating pressure is 6 bar. It can be read on the pressure gauge 3.
- To set the operating pressure pull up and turn the knob 1.
  - Turn clockwise = Increase pressure
  - Turn counter-clockwise = Decrease pressure



### 3. Electrical Connection



#### **ATTENTION !**

All work on the electrical components of the sewing unit may only be conducted by electricians or appropriately trained personnel.  
The mains plug must be pulled out.

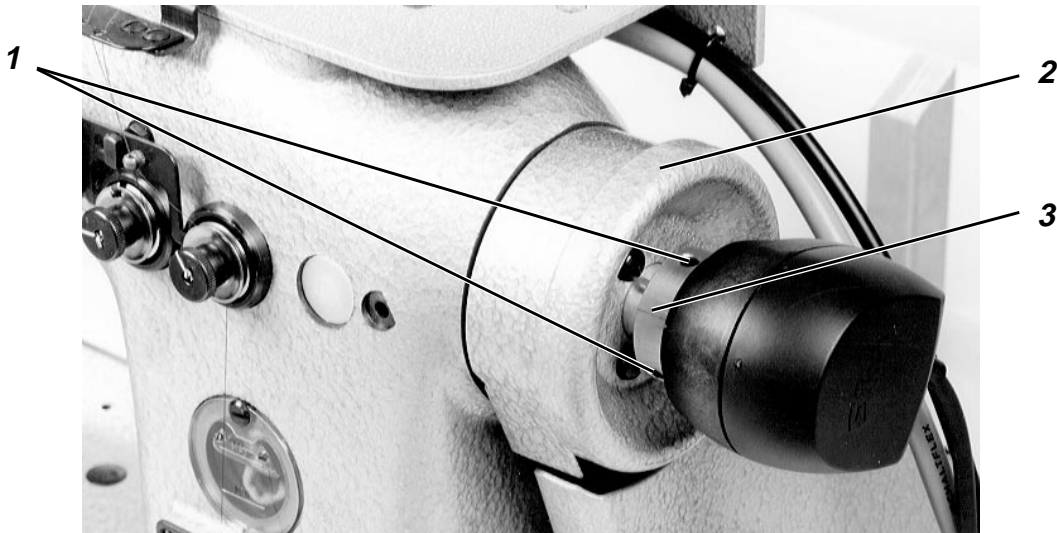
#### 3.1 Checking the Nominal Voltage

The nominal voltage listed on the motor rating plate of the sewing drive and the mains voltage must be the same !

#### 3.2 Checking Positioning

The machine should position when the thread pulling lever is at its upper dead center.

The setting of the positioning is usually made at the factory.



#### **Checking positioning**

- Turn off the main switch.
- Bring the thread pulling lever into a central position by turning the handwheel 2.
- Turn on the main switch. The machine positions.  
If the thread pulling lever is not in its upper dead center then the position must be reset.

#### **Setting the position**

- Loosen the threaded pins 1 of the synchronizer ring 3.
- Firmly hold the synchronizer ring 3.
- Move the thread pulling lever into its upper dead center by turning the handwheel 2.
- Tighten the threaded pins 1 again.
- Check the positioning again.