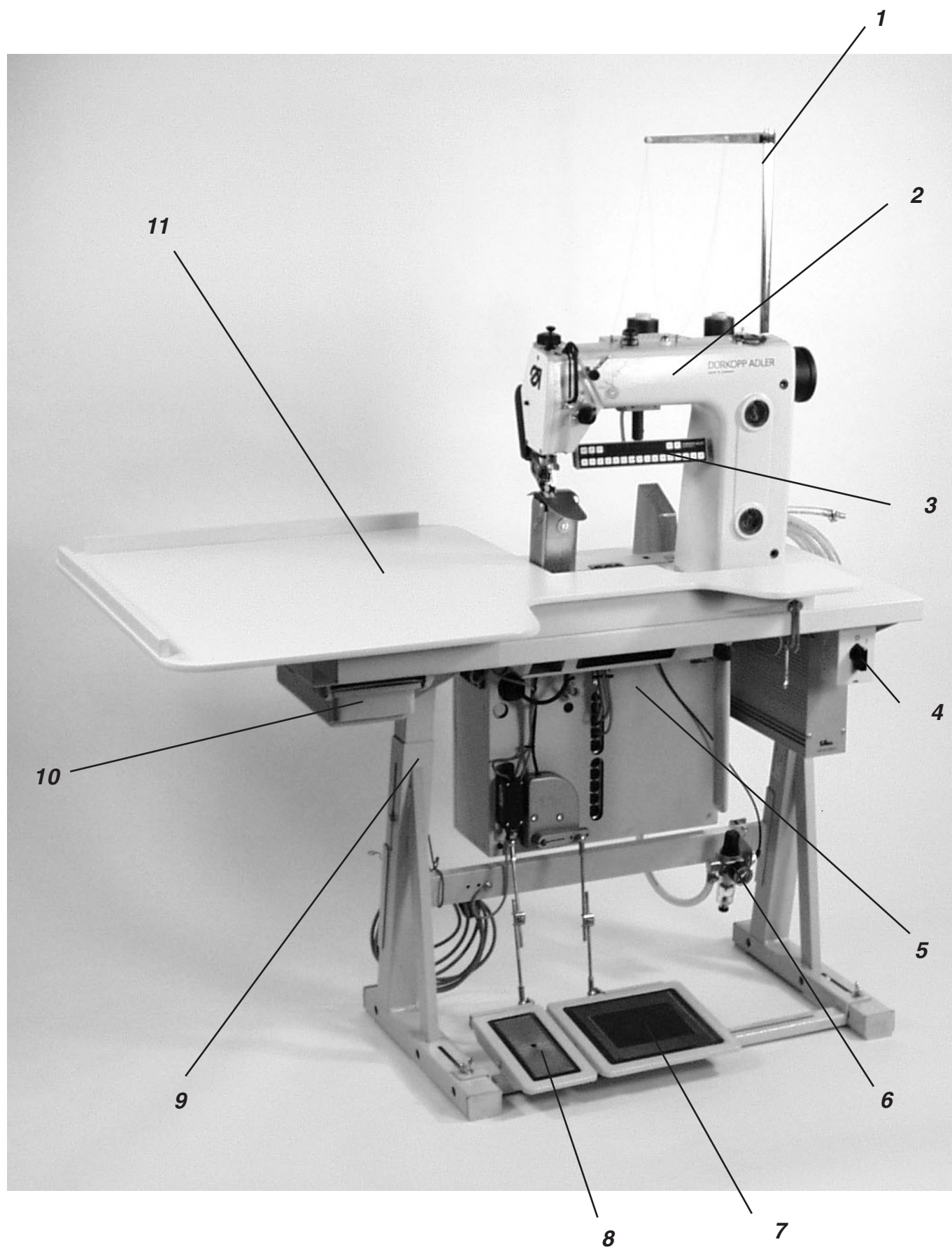




Part 2: Installation Instructions

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1. Scope of Delivery

The scope of delivery **depends on your order**.

Before proceeding to the installation, check whether all the necessary parts are available.

Equipment (as per subclass):

- 1 Machine head
- 2 Sewing light
- 3 Table top
- 4 Drawer
- 5 Stand
- 6 Reel stand
- 7 Control panel
- 8 Main switch
- 9 Knee lever
- 10 Conditioning unit
- 11 Sewing motor
- 12 Pedal rods
- 13 Pedal
- 14 Left pedal
- Small parts in the accessories

2

2. General and Transportation Safety



ATTENTION !

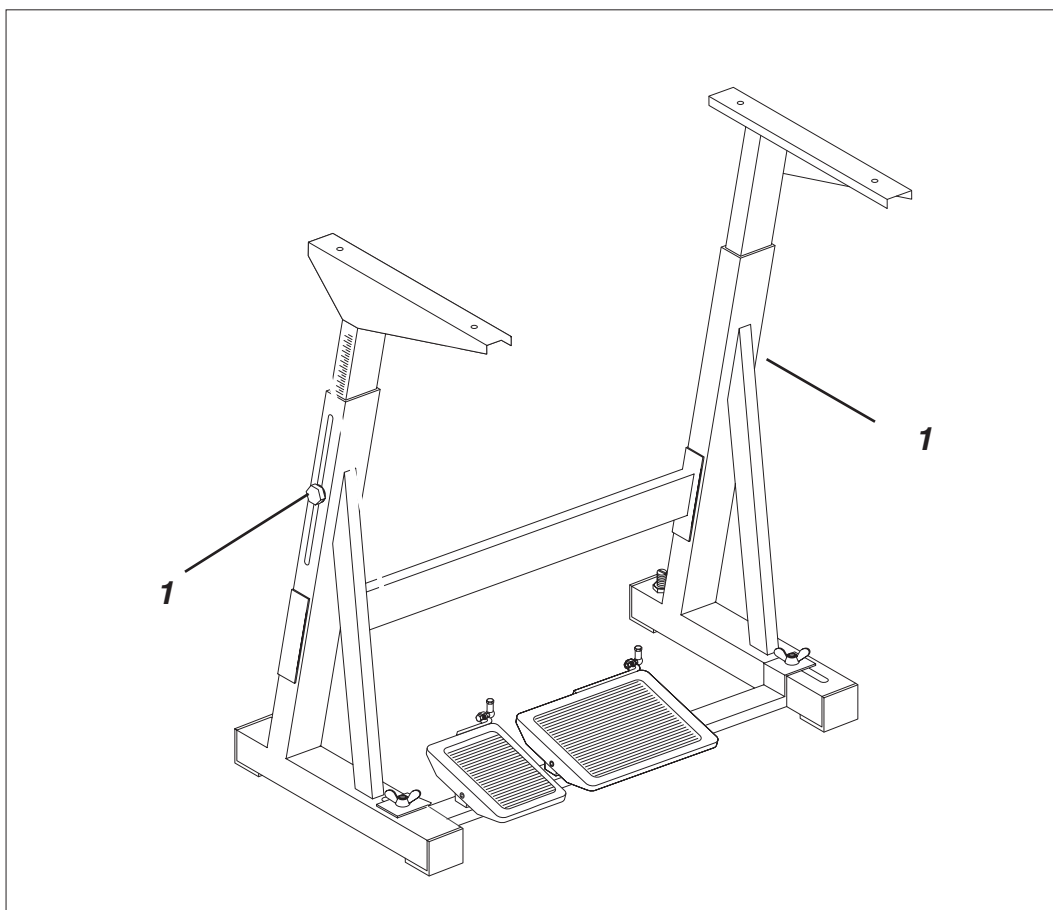
The special sewing machine should be installed exclusively by a properly qualified staff.

If you have bought a placed special sewing machine, the following transportation safeties have to be removed :

- Safety bands and the wood borders on the machine head and table and stand.
- Safety block and bands on the sewing motor.



3 Setting the Working Level



- The working level can be set between 750 and 900 mm (Measured up to the table top).
- Loosen the screws 1 on the sleepers of the stand.
- Set the table top so that it is at the desired level and in horizontal position.
In order to avoid a jamming, push the table top in and out equally on both sides.
- Tighten both screws 1.



4. Electrical Connection



ATTENTION !

Any work on the electrical equipment of the sewing unit should be carried out exclusively by the properly qualified electricians or by the properly qualified staff!.
The mains plug must be pulled out.

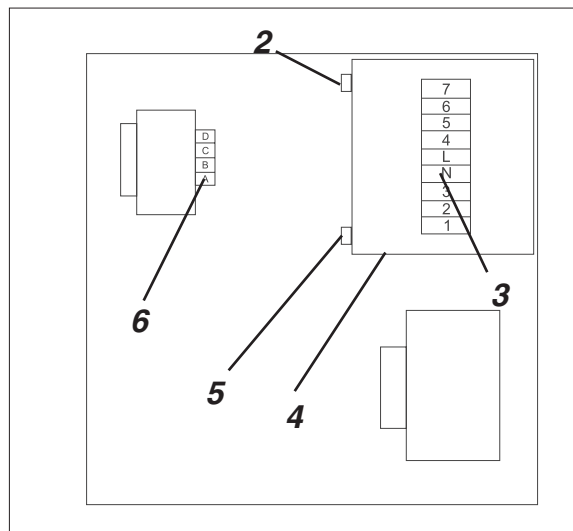
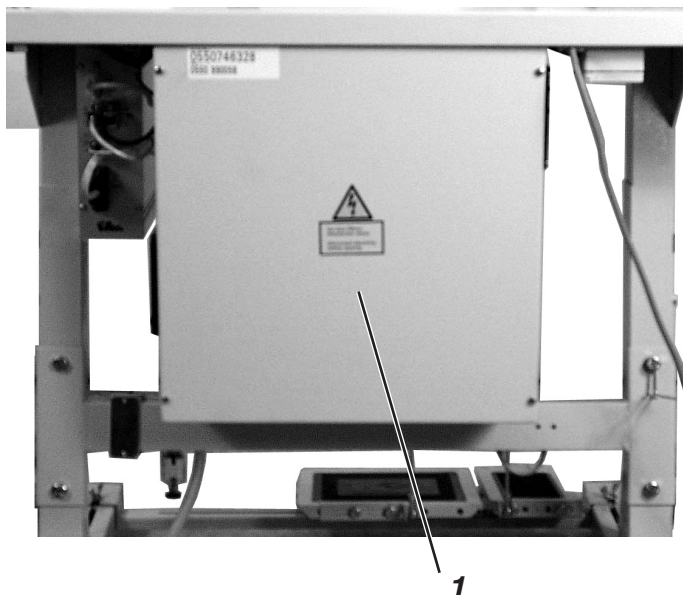
It is absolutely necessary to respect the enclosed manufacturer's instructions for the step motor.

4.1 Checking the Nominal Voltage

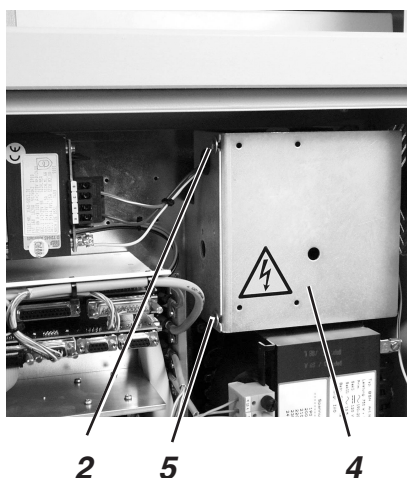


ATTENTION !

The nominal voltage, stated on the type plate, should agree with the local voltage!



2

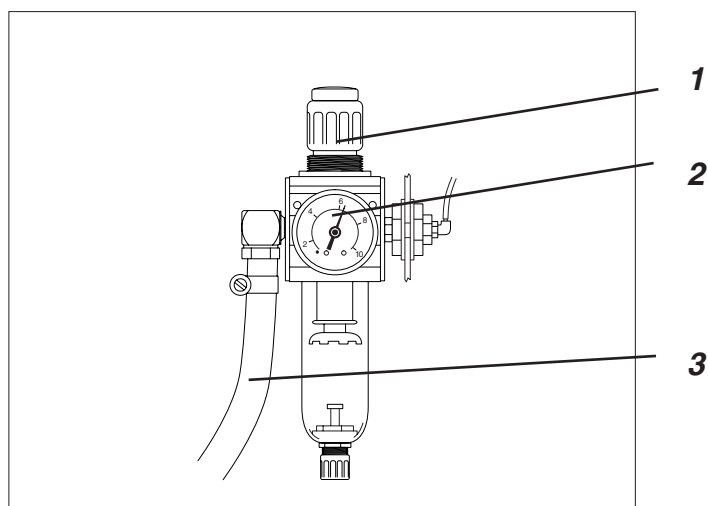


Use the terminal bar 3 and the transformer 6 in the control cabinet for adapting to the local voltage.

- Screw off the cover 1 at the switch cabinet.
- Loosen the screws 2 and 5 and remove the guard 4.
- Check the arrangement of the connections on the terminal bar 3 and on the transformer 6.
(See circuit diagrams 9870 550033 B sheet 1 to 3)
- If necessary, change the connections according to the local voltage.
- Re-assemble the guard 4 and screw on with the screws 2 and 5.
- Re-assemble the cover 1 on the switch cabinet and screw on.



5. Pneumatic Connection



ATTENTION !

A perfect function of the pneumatic elements will only be ensured if the line pressure ranges between 8 and 10 bar.

The service pressure of the special sewing machine amounts to 6 bar.

Pneumatic connection kit

Under the reference number 0797 003031 it is possible to obtain a pneumatic connection kit for stands with conditioning unit for compressed air.

It includes the following components:

- Connection hose, 5 m long, ($\varnothing = 9$ mm)
- Hose nozzles and hose binders
- Coupling socket and coupling plug

Connecting the conditioning unit for compressed air

- Connect the conditioning unit for compressed air by the connection hose 3 ($\varnothing = 9$ mm) and the hose coupling R1/4" to the compressed air line.

Adjusting the service pressure

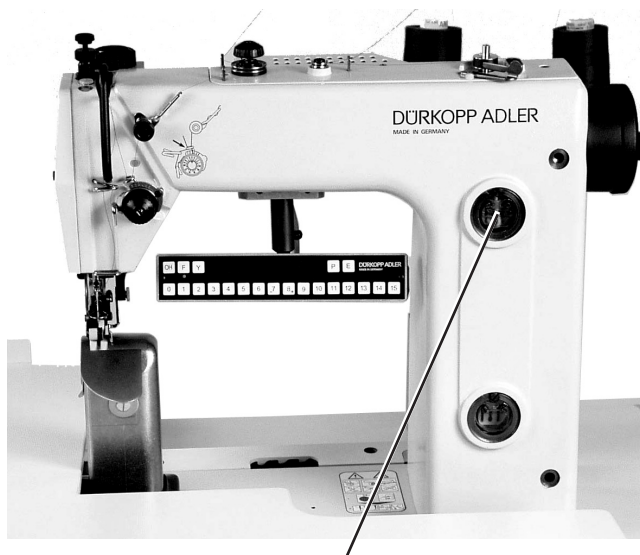
The service pressure amounts to 6 bar.

The service pressure is shown by the manometer 2.

- For adjusting the service pressure, lift the rotary handle 1 and turn it.
 - For increasing the pressure = Turn the rotary handle 1 clockwise
 - For reducing the pressure = Turn the rotary handle 1 counter-clockwise



6. Lubrication



1



Caution Risk of Injury!

Oil can cause skin rashes.
Avoid longer skin contact.
After contact wash yourself thoroughly.



ATTENTION !

The handling and disposal of mineral oils is subject to legal regulations.
Deliver used oil to an authorized reception point.
Protect your environment.
Take care not to spill any oil.

2

For lubrication of the special sewing machine, use exclusively the lubrication oil **ESSO-SP-NK 10** or an equivalent oil with the following specification:

- Viscosity at 40° C: 10 mm²/s
- Flash point: 150° C

ESSO SP-NK 10 can be obtained from the sales offices of **DÜRKOPP ADLER AG** under the following parts numbers:

- 2 liter container: 9047 000013
- 5 liter container: 9047 000014

Lubrication of the machine head

- Fill the oil reservoir 1 up to the mark “**max.**”.



7. Sewing Test

After the installation work, carry out a sewing test.

- Insert the mains plug.



Caution Risk of Injury!

Switch off the main switch.
Switch off the sewing machine before threading the needle and the hook thread.

- Thread the reel thread (See Operating Instructions).
- Switch on the main switch.
- Arrest the sewing feet in raised position (See Operating Instructions).
- Fill up the reel at low speed.
- Switch on the main switch .
- Threading the needle and hook thread (See Operating Instructions).
- Select the material to be sewn.
- Start the sewing test at low speed and increase the speed continuously.
- Check whether the seam meets the expectations.
If the expectations are not fulfilled change the thread tensions (See Operating instructions).
If necessary, check and correct the settings specified in the Service Instructions.