

550-16-26

**Engineered sewing station
for setting sleeves**

- [Operating Instructions](#)
- Installation Instructions
- Service Instructions
- Instructions for programming

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Foreword

This instruction manual is intended to help the user to become familiar with the machine and take advantage of its application possibilities in accordance with the recommendations.

The instruction manual contains important information on how to operate the machine securely, properly and economically. Observation of the instructions eliminates danger, reduces costs for repair and down-times, and increases the reliability and life of the machine.

The instruction manual is intended to complement existing national accident prevention and environment protection regulations.

The instruction manual must always be available at the machine/sewing unit.

The instruction manual must be read and applied by any person that is authorized to work on the machine/sewing unit. This means:

- Operation, including equipping, troubleshooting during the work cycle, removing of fabric waste,
- Service (maintenance, inspection, repair) and/or
- Transport.

The user also has to assure that only authorized personnel work on the machine.

The user is obliged to check the machine at least once per shift for apparent damages and to immediately report any changes (including the performance in service), which impair the safety.

The user company must ensure that the machine is only operated in perfect working order.

Never remove or disable any safety devices.

If safety devices need to be removed for equipping, repairing or maintaining, the safety devices must be remounted directly after completion of the maintenance and repair work.

Unauthorized modification of the machine rules out liability of the manufacturer for damage resulting from this.

Observe all safety and danger recommendations on the machine/unit! The yellow-and-black striped surfaces designate permanent danger areas, eg danger of squashing, cutting, shearing or collision.

Besides the recommendations in this instruction manual also observe the general safety and accident prevention regulations!

General safety instructions

The non-observance of the following safety instructions can cause bodily injuries or damages to the machine.

1. The machine must only be commissioned in full knowledge of the instruction book and operated by persons with appropriate training.
2. Before putting into service also read the safety rules and instructions of the motor supplier.
3. The machine must be used only for the purpose intended. Use of the machine without the safety devices is not permitted. Observe all the relevant safety regulations.
4. When gauge parts are exchanged (e.g. needle, presser foot, needle plate, feed dog and bobbin) when threading, when the workplace is left, and during service work, the machine must be disconnected from the mains by switching off the master switch or disconnecting the mains plug.
5. Daily servicing work must be carried out only by appropriately trained persons.
6. Repairs, conversion and special maintenance work must only be carried out by technicians or persons with appropriate training.
7. For service or repair work on pneumatic systems, disconnect the machine from the compressed air supply system (max. 7-10 bar). Before disconnecting, reduce the pressure of the maintenance unit. Exceptions to this are only adjustments and functions checks made by appropriately trained technicians.
8. Work on the electrical equipment must be carried out only by electricians or appropriately trained persons.
9. Work on parts and systems under electric current is not permitted, except as specified in regulations DIN VDE 0105.
10. Conversion or changes to the machine must be authorized by us and made only in adherence to all safety regulations.
11. For repairs, only replacement parts approved by us must be used.
12. Commissioning of the sewing head is prohibited until such time as the entire sewing unit is found to comply with EC directives.
13. The line cord should be equipped with a country-specific mains plug. This work must be carried out by appropriately trained technicians (see paragraph 8).



It is absolutely necessary to respect the safety instructions marked by these signs.

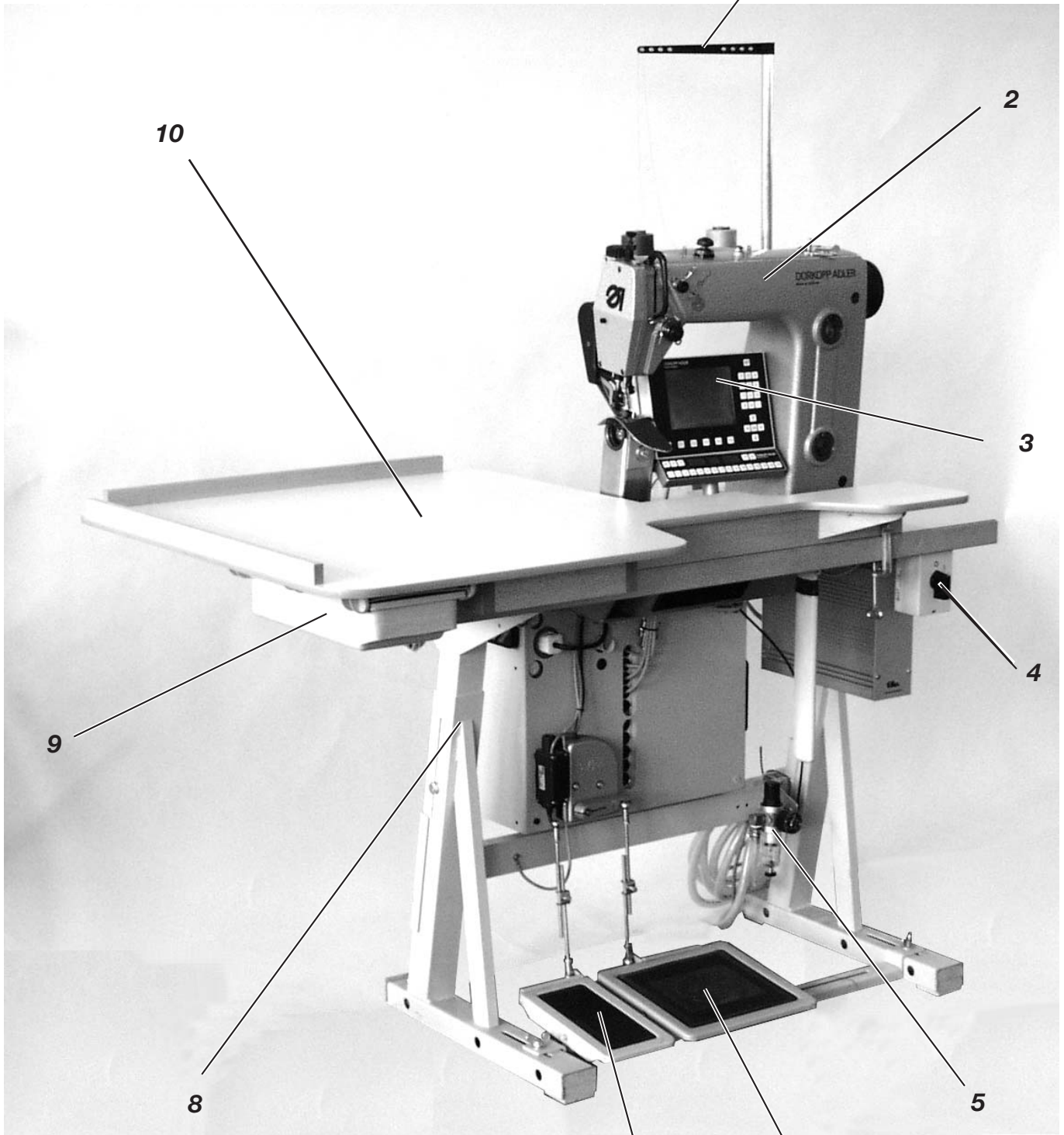
Danger of bodily injuries !

Please note also the general safety instructions.



Part 2: Installation Instructions class 550-16-26 – Original 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

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2. General and Transportation Safety



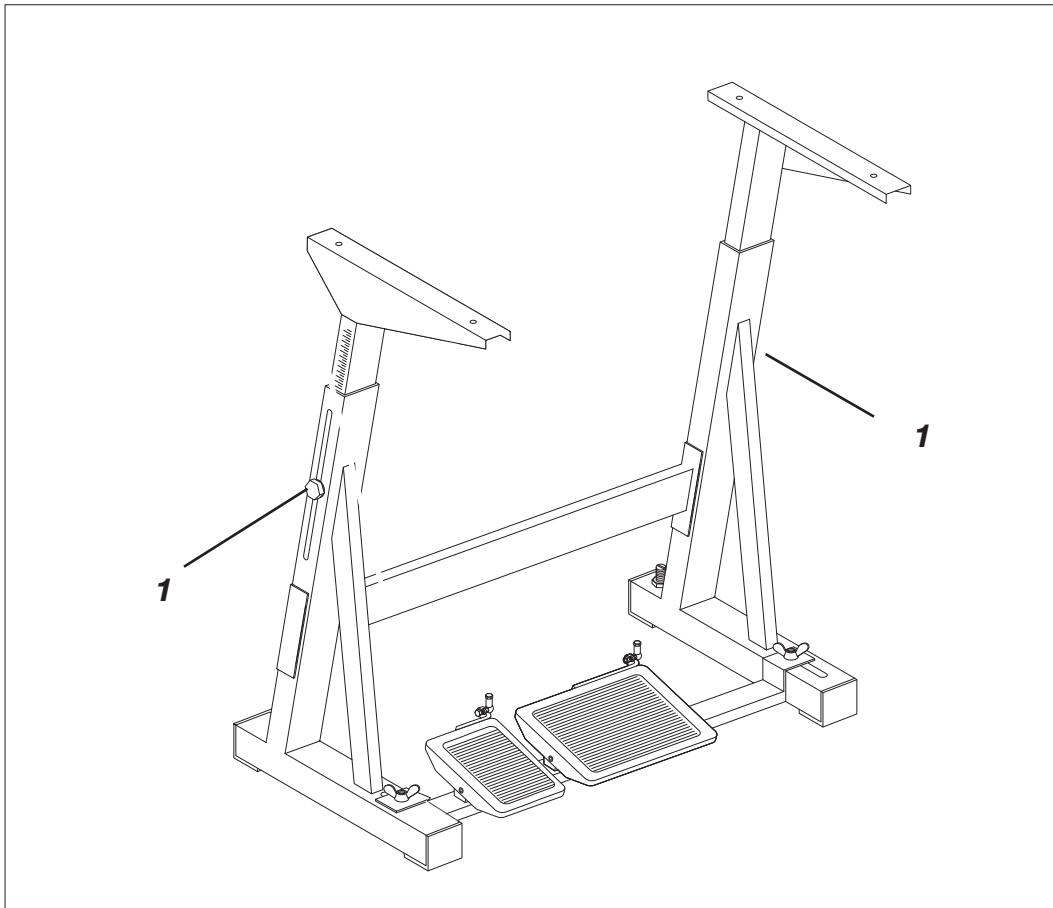
ATTENTION !

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.

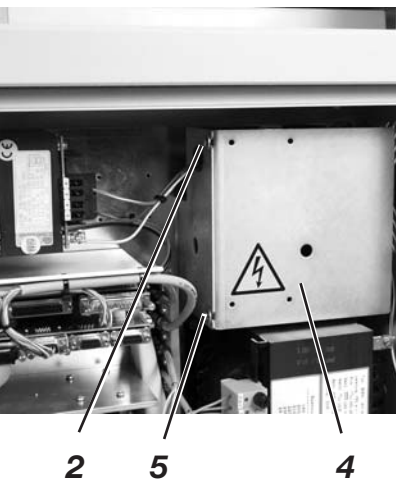
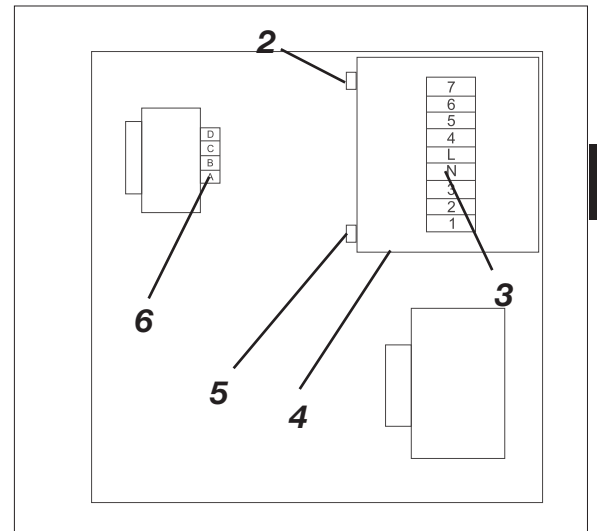
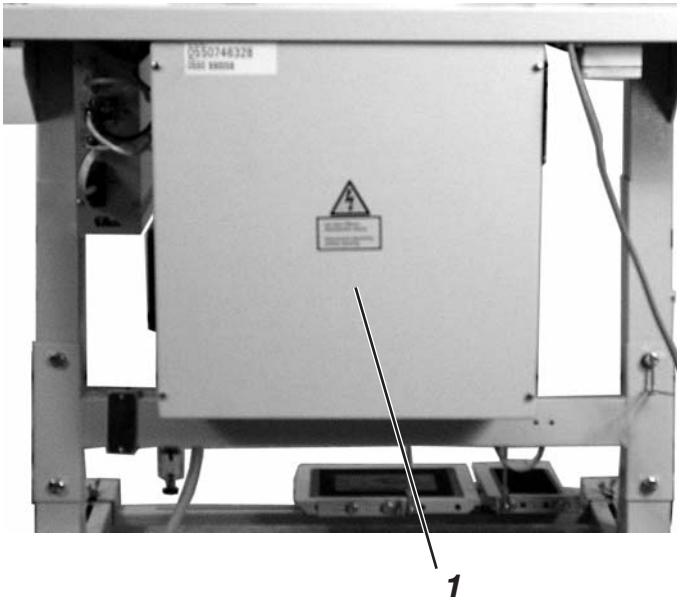
It is absolutely necessary to respect the enclosed manufacturer's instructions for the step motor.

4.1 Checking the Nominal Voltage



ATTENTION !

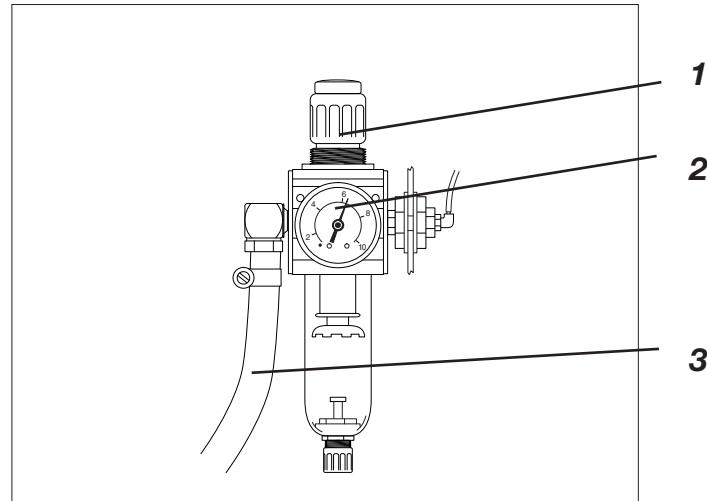
The nominal voltage, stated on the type plate, should agree with the local voltage!



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)
- 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



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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.

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

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

DA 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

Following 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.