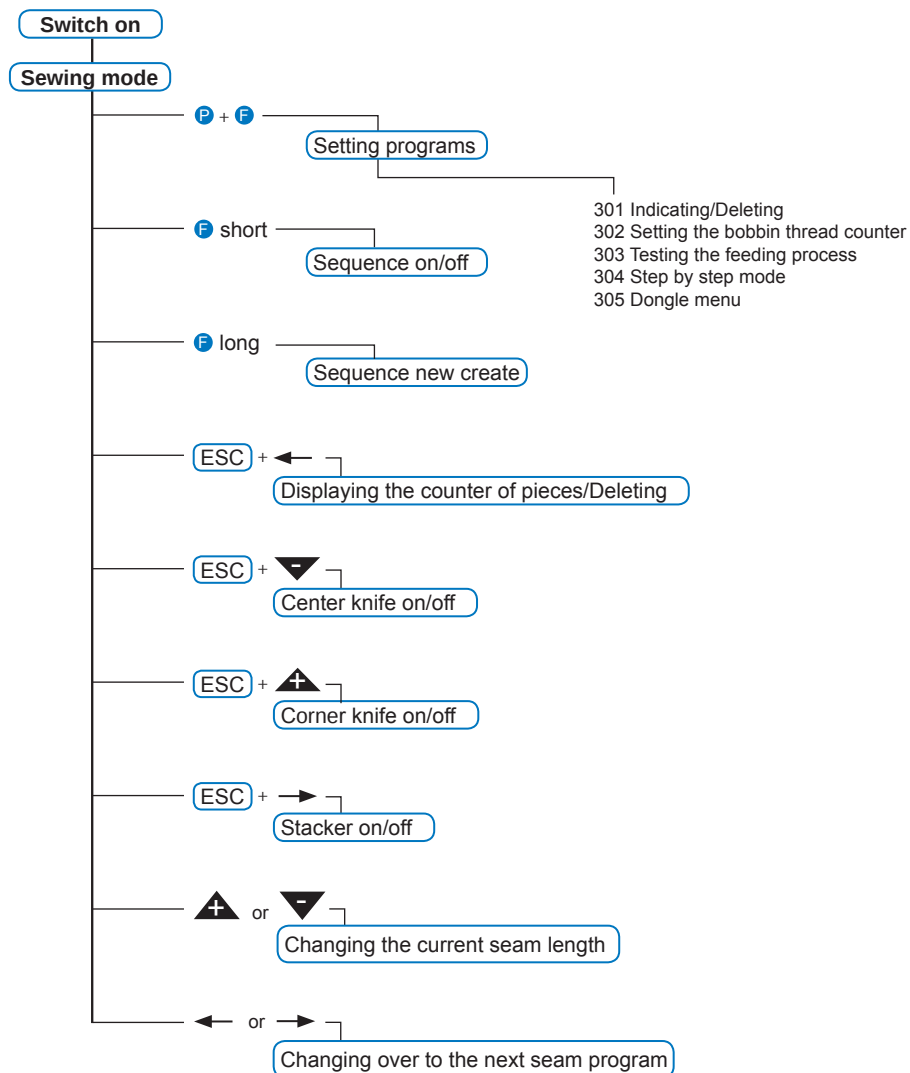




Error/Info	Description	Remedy
3210	Thread breakage	Thread in the thread again
3215	Empty bobbin (Bobin thread counter)	Insert a full bobbin
3220	Empty bobbin (Remaining thread-monitor)	
9601	Pedal has been stepped back during the sewing process	For cancelling the pedal has be actuated once again. Afterwards the feeding clamp runs in 1st rear position.
9604	Folder not in top position Light-barrier (S4) for fabric removal inactive	Adjust light-barrier (S4) for fabric removal
9700	Folder not in top position	Correct folder adjustment (mechanical collision; check switch S8)
9701	Folder not in low position	Correct folder adjustment (mechanical collision; check switch S8)
9720	Error when scanning the flap by light-barrier	Check the reflecting foil; check alignment of the light-barrier
9721	Flap has been pos. in front of the front positioning point	Position the flap correctly
9722	Flap protrudes from the max. sewing area (behind the rear positioning point)	Check the flap size; position the flap correctly
9723	Fluff at the flap beginning	Feed flaps with smooth edges; check the reflecting foil
9726	Flap too large or reflecting foil soiled or defective	Check flap size and reflecting foil
9730	Corner knife at the seam beginning cannot be driven to	Alter L1 (adjust corner knife distance) or change positioning point of the current seam
9001	Corner knife station is swung out Folding station is swung out during the sewing process Step back on the pedal; afterwards the transport carriage runs to the back; start the process.	Swing in corner knife station Check/adjust fastening of the corner knife station
9002	Folding station is swung out Folding station is swung out during the sewing process Step back on the pedal; afterwards the transport carriage runs to the back; start the process	Sewing folding station in Check/adjust fastening of the folding station
9003	Wrong needle position before sewing start	Turn manually the hand wheel in lever up position
ref	Request to carry out the reference run after switching the machine on.	Step back on the pedal
Current seam length flashes	Corner knife at the seam beginning cannot be reached	Change the present seam length, or change the loading position, or change L1 (adjust distance counter knife).

Switch on

Sewing mode

P

Editing the current seam parameters

- 100 Seam length mm
- 101 Stacker on/off
- 102 Center knife on/off
- 103 Center knife correction seam beginning 1/10 mm
- 104 Center knife correction seam end 1/10 mm
- 105 Corner knife on/off
- 106 Corner knife correction seam beginning 1/10 mm
- 107 Corner knife correction seam end 1/10mm
- 108 Stitch length 1/10 mm
- 109 Sewing motor speed
- 110 Sewing motor soft start on/off
- 111 Sewing motor number of soft start stitches
- 112 Sewing motor soft start speed
- 113 Clamping mode
 - 0 = Lower left and right feeding clamp simultaneously
 - 1 = Lower left feeding clamp first
 - 2 = Lower right feeding clamp first
- 114 Positioning point
 - 0 = front
 - 1 = center
 - 2 = rear
- 115 Positioning point offset mm
- 116 Type seam tightening seam beginning
 - 0 = Bartack
 - 1 = Condensed stitches
- 117 Number of condensed stitches seam beginning
- 118 Stitch length condensed stitches/Bartack Seam beginning 1/10 mm
- 119 Number of bartacks seam beginning
- 120 Type seam tightening seam end
 - 0 = Bartack
 - 1 = Condensed stitches
- 121 Number of condensed stitches seam end
- 122 Stitch length condensed stitches/Bartack Seam end 1/10 mm
- 123 Number of bartacks seam end
- 124 Material feed type,
 - 0 = Material runs to the loading position
 - 1 = Material runs to the stacking position
 - 2 = no run, in stacking position,
- 125 Type of waiting position
 - 0 = Feeding clamp runs to the waiting position
 - 1 = Feeding clamp remains in stacking position
- 126 Material feed to the stacking position

Switch on

Sewing mode

P

Editing the current seam parameters

- 127 Loading speed
- 128 Return speed
- 129 Downholder on/off
- 130 Sewing mode
 - 0 = Constant sewing length
 - 1 = Light-barrier for flap scanning
- 131 Light-barrier correction seam beginning 1/10 mm
- 132 Light-barrier correction seam end 1/10 mm
- 133 Material feed to the waiting position
- 134 Max. Flap length
- 135 Flap clamp on/off
- 136 Pedal mode
 - 0 = normal
 - 1 = Pedal has to be in basic position before the next step
 - 2 = Pedal actuation for moving in sewing position (flap clamp)
- 137 Second light barrier active
 - 0 = 1st light barrier active
 - 1 = 2nd light barrier active