DÜRKOPP ADLER

M-TYPE PREMIUM

Quick reference

IMPORTANT

READ CAREFULLY BEFORE USE

KEEP FOR FUTURE REFERENCE

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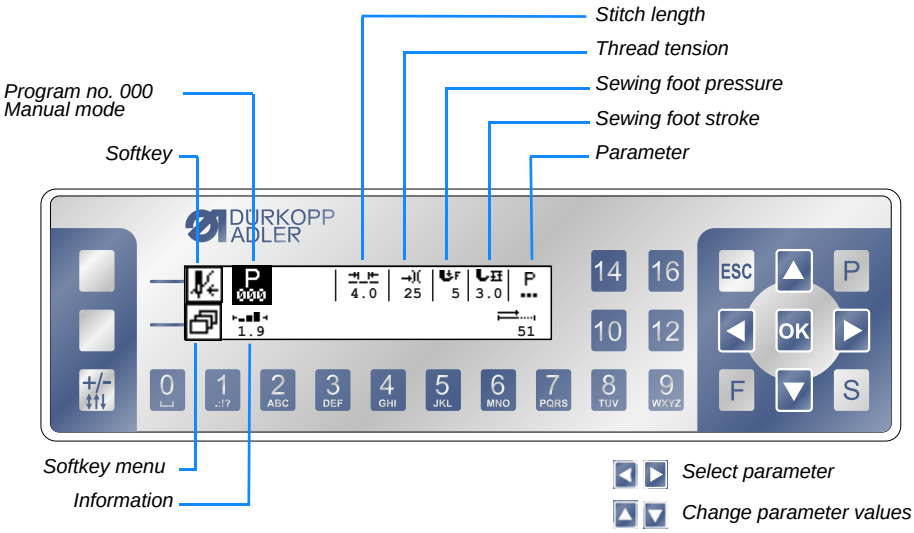
1 Manual mode



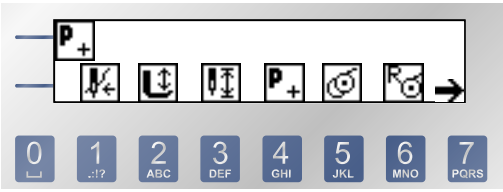
Program structure in manual mode

Symbol	Menu item	Setting/reference
max	`Max. speed`	Value range 0050 - 3800 [rpm]
	`ThreadTrim`	ON/OFF
TC	`ThreadClamp`	ON/OFF
	`PointPos.`	Value range 000 - 359 [°]
	`Start Tack`	1.2 Parameters `Start Tack`, p. 5
	`End Tack`	1.3 Parameters `End Tack`, p. 7

Symbol	Menu item	Setting/reference
	Foot	🕮 *1.4 Parameters* `Foot`, p. 9
	Bobbin	🕮 *1.5 Parameters* `Bobbin`, p. 9
	InfoScreen	🕮 *1.6 Parameters* `InfoScreen`, p. 9
	Puller	🕮 *1.7 Parameters* `Puller`, p. 10
	EdgeGuide	🕮 *1.8 Parameters* `EdgeGuide`, p. 10
cor.	*Speed Corr.*	🕮 *1.9 Parameters* `Speed Corr.`, p. 10
	FabricThickness	🕮 *1.10 Parameters* `FabricThickness`, p. 11
	LightBarrier	🕮 *1.11 Parameters* `LightBarrier`, p. 12
	Output	customer-specific

1.1 Softkey menu

Assignment of the **Softkey** button:
Press the numeric button under the function and the **Softkey** button at the same time.



1 - Threading mode
2 - Sewing foot position
3 - Needle position
4 - Create new seam program
5 - Winder mode
6 - Reset bobbin stitch counter
7 - Other functions

1.2 Parameters *Start Tack*

Symbol	Menu item	Setting 1	Setting 2
	On	ON/OFF	
	Stitches (↑)	Value range 01 – 50	
	Stitches (↓)	Value range 01 – 50	
	Repetitions	Value range 01 – 10	
	t Change	Value range 0000 – 1000 [ms]	

Symbol	Menu item	Setting 1	Setting 2
	St.Len.Def.	ON/OFF	
		St.Len. (↑)	Value range 01.0 – 12.0 [mm]
		St.Len. (↓)	Value range 01.0 – 12.0 [mm]
	Speed	Value range 0000 - 2000 [rpm]	
	Pedal Stop	ON/OFF	
][←F	*Thr.Tens.Def.*	ON/OFF	
	Catch Backtack	ON/OFF	
		Stitches (↑)	Value range 01 – 50
		Stitches (↓)	Value range 01 – 50
	First Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50

Symbol	Menu item	Setting 1	Setting 2
	Last Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50
	Invert Dir.	ON/OFF	

1.3 Parameters *End Tack*

Symbol	Menu item	Setting 1	Setting 2
	On	ON/OFF	
	Stitches (↑)	Value range 01 – 50	
	Stitches (↓)	Value range 01 – 50	
	Repetitions	Value range 01 – 10	
	t Change	Value range 0000 – 1000 [ms]	
	St.Len.Def.	ON/OFF	
		St.Len. (↑)	Value range 01.0 – 12.0 [mm]
		St.Len. (↓)	Value range 01.0 – 12.0 [mm]

Symbol	Menu item	Setting 1	Setting 2
	Speed	Value range 0000 - 2000 [rpm]	
	Pedal Stop	ON/OFF	
	Thr.Tens.Def.	ON/OFF	
	Catch Backtack	ON/OFF	
		Stitches (↑)	Value range 01 – 50
		Stitches (↓)	Value range 01 – 50
	First Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50
	Last Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50
	Invert Dir.	ON/OFF	

1.4 Parameters *Foot*

Symbol	Menu item	Setting
	FL AtStop,	ON/OFF
	FL AfterTrim,	ON/OFF
	FL ht.AtStop	Value range 00 – 20 [mm]
	FL ht.A.Trim	Value range 00 – 20 [mm]

1.5 Parameters *Bobbin*

Symbol	Menu item	Setting 1	Setting 2
	Off		
	Monitor	*t Clean*	Value range 0000 – 5000 [ms]
		Motor Stop	ON/OFF
	Softw.	*CounterType*	A/B/C/D
		Counter	Value range 00000 – 99999
		MotorStop	ON/OFF
		ResetNeces	ON/OFF

1.6 Parameters *InfoScreen*

Symbol				POS		
Menu item	*Off*	*Pedal*	*Thickness*	*Position*	*Speed*	*Bobbin Cnt*

1.7 Parameters *Puller*

Symbol	Menu item	Setting
	Top Cor.	Value range -100 - 100 [%]
	Bottom Cor.	Value range -100 - 100 [%]

1.8 Parameters *EdgeGuide*

Symbol	Menu item	Setting
	Gap	Value range 01.0 – 45.0 [mm]
	Gap (+)	Value range 01.0 – 45.0 [mm]

1.9 Parameters *Speed Corr.*

Symbol	Menu item	Setting 1	Setting 2	Setting 3
	ON/OFF			
	Stitchlen.	*Off*		
		linear	*Stitchlen.*	Value range -50 – 50 [%]
			Min. speed	Value range 0000 - 4000 [rpm]
			Max. speed	Value range 0000 - 4000 [rpm]
		2.OnOff	*Min. speed*	Value range 0000 - 4000 [rpm]
		2.On	*Min. speed*	Value range 0000 - 4000 [rpm]

Symbol	Menu item	Setting 1	Setting 2	Setting 3
	Thr.Tens.	*Off*		
		linear	*Thr.Tens.*	Value range 00 – 99 [%]
			Min. speed	Value range 0000 - 4000 [rpm]
			Max. speed	Value range 0000 - 4000 [rpm]
		2.OnOff	*Min. speed*	Value range 0000 - 4000 [rpm]
		2.On	*Min. speed*	Value range 0000 - 4000 [rpm]
	FootPress.	*Off*		
		linear	*FootPress.*	Value range 00 – 20
			Min. speed	Value range 0000 - 4000 [rpm]
			Max. speed	Value range 0000 - 4000 [rpm]

1.10 Parameters *FabricThickness*

Symbol	Menu item	Setting 1	Setting 2	Setting 3
	ON/OFF			
	Stroke	*Off*		
		linear	*Stroke*	Value range 00.0 – 09.0 [mm]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]
		2.OnOff	*ThickMin*	Value range 00.0 – 10.0 [mm]
		2.On	*ThickMin*	Value range 00.0 – 10.0 [mm]
	Stitchlen.	*Off*		
		linear	*Stitchlen.*	Value range -50 – 50 [%]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]
		2.OnOff	*ThickMin*	Value range 00.0 – 10.0 [mm]
		2.On	*ThickMin*	Value range 00.0 – 10.0 [mm]

Symbol	Menu item	Setting 1	Setting 2	Setting 3
	Thr.Tens.	*Off*		
		linear	*Thr.Tens.*	Value range 00 – 99 [%]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]
		2.OnOff	*ThickMin*	Value range 00.0 – 10.0 [mm]
		2.On	*ThickMin*	Value range 00.0 – 10.0 [mm]
	FootPress.	*Off*		
		linear	*FootPress.*	Value range 00 – 20
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]
max	*Max.Speed*	*Off*		
		linear	*Max.Speed*	Value range 0000 - 4000 [rpm]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]

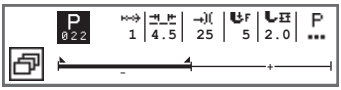
1.11 Parameters *LightBarrier*

Symbol	Menu item	Setting
	LightBarrier	ON/OFF
	Start	ON/OFF
	End	ON/OFF

Symbol	Menu item	Setting
	Distance	Value range 0 – 255 [mm]
	Seams	Value range 1 – 255
	Filter	Value range 0 – 255 [mm]

2 Programming/edit mode

2.1 Editing a program



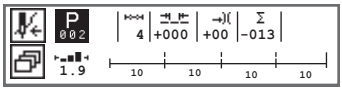
Select parameter

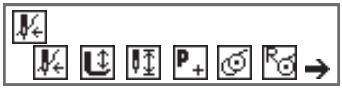
Change parameter values

Save changes

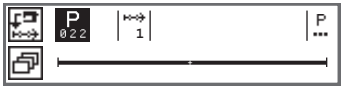
2.2 Creating a new program

Switch to programming mode.



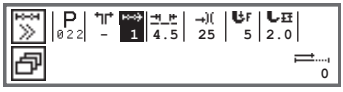


If desired, use the arrow buttons and the numeric buttons to, respectively, change and enter the program number. Press the **OK** button to confirm the program number.



There are two ways to set up a program:

Teach-In



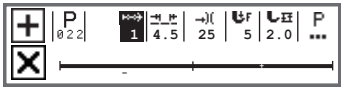
Select parameter

Change parameter values

Sew desired number of stitches per pedal. Press the button to start a new seam section.

One level back/save program. Exit teach-in mode by pressing back the pedal.

Manual



Select parameter

Change parameter values

Add seam section

One level back/save program.

2.3 Parameters for seam section

Symbol	Menu item	Setting/reference
	StitchCount	Value range 0000 – 9999
	Max. speed	Value range 0050 - 3800 [rpm]
	Seg.End Modes	🕮 *2.3.1 Parameters* `Seg.End Modes`, p. 16
	Start Tack	🕮 *2.3.2 Parameters* `Start Tack`, p. 16
	End Tack	🕮 *2.3.3 Parameters* `End Tack`, p. 18
	Needle Up	ON/OFF
	Foot lifted	ON/OFF
	FL height	Value range 00 -20 [mm]
	Backwards	ON/OFF
	Puller	🕮 *2.3.4 Parameters* `Puller`, p. 20
	Center Guide	ON/OFF
	Edge Guide	🕮 *2.3.5 Parameters* `Edge Guide`, p. 20

Symbol	Menu item	Setting/reference
	LightBarrier	📖 *2.3.6 Parameters* `LightBarrier`, p. 20
	Output	customer-specific

2.3.1 Parameters *Seg.End Modes*

Symbol	Menu item	Setting
	Stop	ON/OFF
	Thread Trim	ON/OFF
	Needle Up	ON/OFF
	Foot lifted	ON/OFF
	FL height	Value range 00 – 20 [mm]

2.3.2 Parameters *Start Tack*

Symbol	Menu item	Setting 1	Setting 2
	On	ON/OFF	
	Stitches (↑)	Value range 01 – 50	
	Stitches (↓)	Value range 01 – 50	

Symbol	Menu item	Setting 1	Setting 2
	Repetitions	Value range 01 – 10	
	t Change	Value range 0000 – 1000 [ms]	
	St.Len.Def.	ON/OFF	
		St.Len. (↑)	Value range 01.0 – 12.0 [mm]
		St.Len. (↓)	Value range 01.0 – 12.0 [mm]
	Speed	Value range 0000 – 2000 [rpm]	
	Pedal Stop	ON/OFF	
	Thr.Tens.Def.	ON/OFF	
	Catch Backtack	ON/OFF	
		Stitches (↑)	Value range 01 – 50
		Stitches (↓)	Value range 01 – 50
	First Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50

Symbol	Menu item	Setting 1	Setting 2
	Last Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50
	Invert Dir.	ON/OFF	

2.3.3 Parameters *End Tack*

Symbol	Menu item	Setting 1	Setting 2
	On	ON/OFF	
	Stitches (↑)	Value range 01 – 50	
	Stitches (↓)	Value range 01 – 50	
	Repetitions	Value range 01 – 10	
	t Change	Value range 0000 – 1000 [ms]	
	St.Len.Def.	ON/OFF	
		St.Len. (↑)	Value range 01.0 – 12.0 [mm]
		St.Len. (↓)	Value range 01.0 – 12.0 [mm]

Symbol	Menu item	Setting 1	Setting 2
	Speed	Value range 0000 – 2000 [rpm]	
	Pedal Stop	ON/OFF	
	Thr.Tens.Def.	ON/OFF	
	Catch Backtack	ON/OFF	
		Stitches (↑)	Value range 01 – 50
		Stitches (↓)	Value range 01 – 50
	First Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50
	Last Repet	ON/OFF	
		Stitches (↑/↓)	Value range 01 – 50
	Invert Dir.	ON/OFF	

2.3.4 Parameters *Puller*

Symbol	Menu item	Setting
	Top Cor.	Value range -100 - 100 [%]
	Bottom Cor.	Value range -100 - 100 [%]

2.3.5 Parameters *Edge Guide*

Symbol	Menu item	Setting
	Gap	Value range 01.0 – 45.0 [mm]

2.3.6 Parameters *LightBarrier*

Symbol	Menu item	Setting
	LightBarrier	ON/OFF
	Start	ON/OFF
	End	ON/OFF
	Distance	Value range 0 – 255 [mm]
	Seams	Value range 1 – 255
	Filter	Value range 0 – 255 [mm]

2.4 Parameters for program

Symbol	Menu item	Setting/reference
P 001-999	*Prog. Name*	Custom
	Add Values(+)	🕮 *2.4.1 Parameters* `Add Values (+)`, p. 22
P 001-999	*Next Prog.*	Value range 000 – 999
	Loop Prog.	ON/OFF
TC	*Thread Clamp*	ON/OFF
	Bobbin	🕮 *2.4.2 Parameters* `Bobbin`, p. 22
P 001-999	*InfoScreen*	🕮 *2.4.3 Parameters* `InfoScreen`, p. 22
000 Σ 14	*DailyPieces*	🕮 *2.4.4 Parameters* `Daily Pieces`, p. 23
	PointPos.°	Value range 000 - 359 [°]
n cor.	*Speed Corr*	🕮 *2.4.5 Parameters* `Speed Corr`, p. 23
	FabricThickness	🕮 *2.4.6 Parameters* `FabricThickness`, p. 24

2.4.1 Parameters *Add Values (+)*

Symbol	Menu item	Setting
	St.Len.(+)	Value range 00.0 – 12.0 [mm]
	F.Stroke(+)	Value range 00.5 – 09.0 [mm]
	Thr.Tens.(+)	Value range 00 – 99 [%]
	Gap (+)	Value range 01.0 – 45.0 [mm]

2.4.2 Parameters *Bobbin*

Symbol	Menu items	Setting 1	Setting 2
	Off		
	Monitor	*t Clean*	Value range 0000 – 5000 [ms]
		Motor Stop	ON/OFF
	Softw.	*CounterType*	A/B/C/D
		Counter	Value range 00000 – 99999
		MotorStop	ON/OFF
		ResetNeces	ON/OFF

2.4.3 Parameters *InfoScreen*

Symbol				POS		
Menu item	*Off*	*Pedal*	*Thickness*	*Position*	*Speed*	*Bobbin Cnt*

2.4.4 Parameters *Daily Pieces*

Symbol	Menu item	Setting
	CntMode	UP/DOWN/OFF
	Reset	Value range -999 – 999

2.4.5 Parameters *Speed Corr*

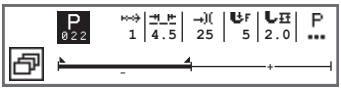
Symbol	Menu item	Setting 1	Setting 2	Setting 3
	ON/OFF			
	Stitchlen.	*Off*		
		linear	*Stitchlen.*	Value range -50 – 50 [%]
			Min. speed	Value range 0000 - 4000 [rpm]
			Max. speed	Value range 0000 - 4000 [rpm]
		2.OnOff	*Min. speed*	Value range 0000 - 4000 [rpm]
		2.On	*Min. speed*	Value range 0000 - 4000 [rpm]
	Thr.Tens.	*Off*		
		linear	*Thr.Tens.*	Value range 00 – 99 [%]
			Min. speed	Value range 0000 - 4000 [rpm]
			Max. speed	Value range 0000 - 4000 [rpm]
		2.OnOff	*Min. speed*	Value range 0000 - 4000 [rpm]
		2.On	*Min. speed*	Value range 0000 - 4000 [rpm]
	FootPress.	*Off*		
		linear	*FootPress.*	Value range 00 – 20
			Min. speed	Value range 0000 - 4000 [rpm]
			Max. speed	Value range 0000 - 4000 [rpm]

2.4.6 Parameters *FabricThickness*

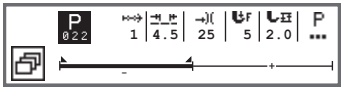
Symbol	Menu item	Setting 1	Setting 2	Setting 3
	ON/OFF			
	Stroke	*Off*		
		linear	*Stroke*	Value range 00.0 – 09.0 [mm]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]
		2.OnOff	*ThickMin*	Value range 00.0 – 10.0 [mm]
		2.On	*ThickMin*	Value range 00.0 – 10.0 [mm]
	Stitchlen.	*Off*		
		linear	*Stitchlen.*	Value range -50 – 50 [%]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]
		2.OnOff	*ThickMin*	Value range 00.0 – 10.0 [mm]
		2.On	*ThickMin*	Value range 00.0 – 10.0 [mm]
	Thr.Tens.	*Off*		
		linear	*Thr.Tens.*	Value range 00 – 99 [%]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]
		2.OnOff	*ThickMin*	Value range 00.0 – 10.0 [mm]
		2.On	*ThickMin*	Value range 00.0 – 10.0 [mm]
	FootPress.	*Off*		
		linear	*FootPress.*	Value range 00 – 20
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]

Symbol	Menu item	Setting 1	Setting 2	Setting 3
max	*Max.Speed*	*Off*		
		linear	*Max.Speed*	Value range 0000 - 4000 [rpm]
			ThickMin	Value range 00.0 – 10.0 [mm]
			ThickMax	Value range 00.0 – 10.0 [mm]

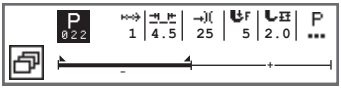
2.5 Copying the program



If desired, use the arrow buttons and the numeric buttons to, respectively, change and enter the program number. Press the **OK** button to confirm the program number.



2.6 Deleting the program



The selected program is deleted.

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Subject to design changes - Part of the machines shown with additional equipment - Printed in Germany
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