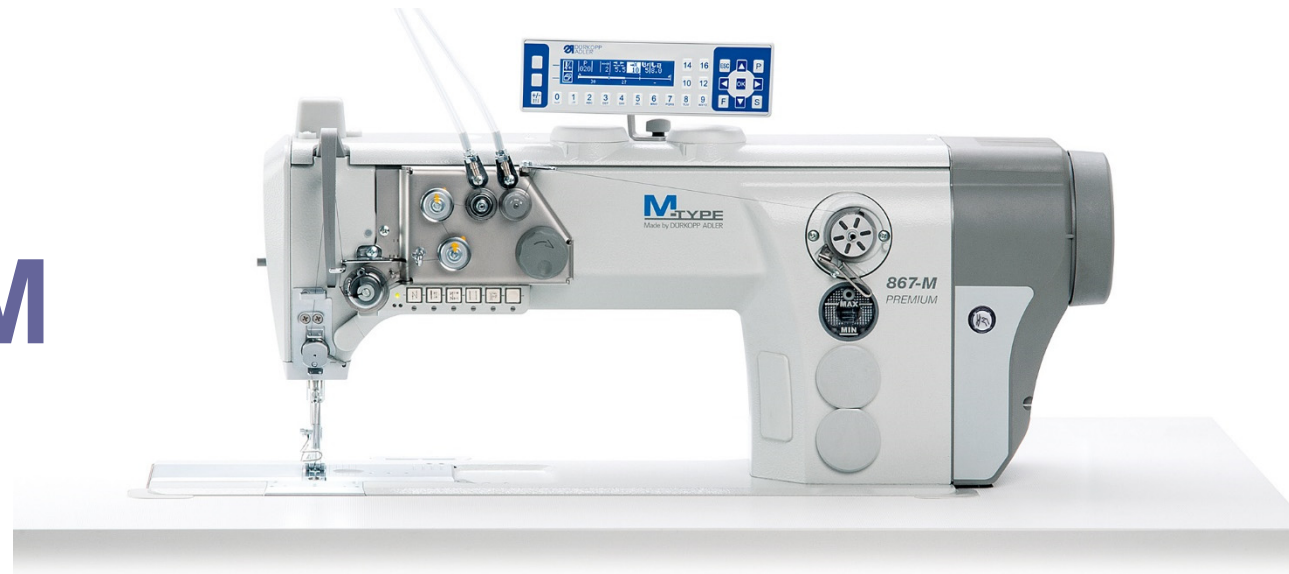


M-TYPE PREMIUM



TECHNICIAN COURSE

Agenda Technician Training - 1 day

09:00 - 09:15	Introduction, Training Overview
09:15 - 09:30	Access to Technician Level <ul style="list-style-type: none">• Access password• Introduction of settings
09:30 - 10:30	Definition of default program parameters <ul style="list-style-type: none">• Explication of parameters• Exercises: test the settings in operator mode
10:30 - 10:45	Break
10:45 - 12:15	Machine Configuration <ul style="list-style-type: none">• Explication of parameters• Emphasize importance of settings when replacing equipment: maximum speed, maximum stitch length, foot lift, edge guide• Exercises: test the settings in operator mode
12:15 - 13:15	Lunch

Agenda Technician Training - 1 day

13:15 - 14:45

User Configuration

- Explication ParameterView
Exercise: Use of parameter codes in technician and operator level
- Input/Output Configuration
Exercise: configure function button no. 6, etc.
- Configuration of program parameters:
Segment Switch, abort, Forward Sound, etc.
- Lock: block/restrict functions for operator
- Screen settings: contrast, brightness

14:45 - 15:00

Break

15:00 - 16:30

Service Routines

- Test equipment, adjustments of equipment, calibration
- Exercises: Multi-test, calibration of stitch length, guide, pedal

Configuration Counter

Reset data

Agenda Technician Training - 1 day

15:00 - 16:30

Data transfer

- Explications of transfer modes
- Exercises: save/upload parameters, calibration data and programs

Perform Software Update

Mechanical

- Setting the stroke movement for the feeding foot
- Setting the sewing foot pressure and sewing foot lift
- Setting the mechanical stitch adjustment

16:30 - 16:45

Conclusion, Questions

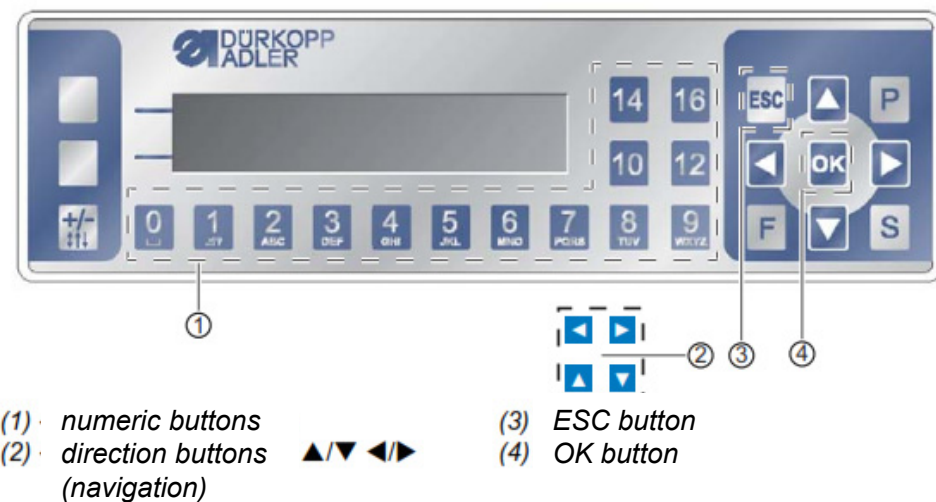
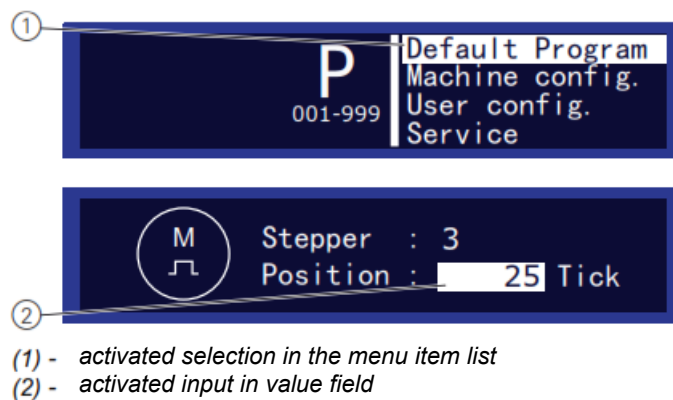
M-Type PREMIUM

Programmable sewing machine

- Installation of stepper motors to provide the following adjustments:
 - programmable setting of the stitch length
 - programmable adjustment of the alternating sewing feet
 - sewing foot lift controlled by stepper motor
 - programmable needle thread tension (electromagnetically) with speed compensation
 - programmable sewing foot pressure
- Creation of Programs
 - reuse and reproduce parameter settings
 - automatize the seam sections
 - sequential mode for a maximum of 9 interlinked seam programs
- Control DAC comfort with OP3000 control panel, software production done by Dürkopp Adler
- Distribution of programs and update of software via USB stick

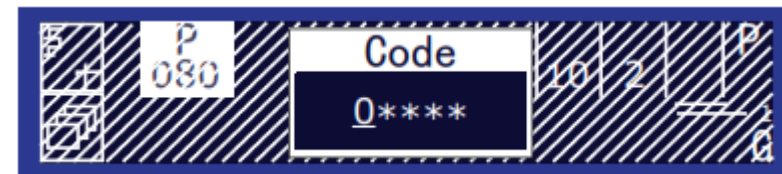
Overview Technician Level

- Service adjustments via software settings
 - general machine configuration
 - test functions for machine elements
 - calibration functions
 - pre-setting of default parameter values in programs
- Control Panel OP3000












Calling up the Technician Level

- Login
 - Press P and S simultaneously
 - Enter the code: **25483**
- Technician menu items:
 - Default Program (program presets)
 - Machine config.
 - User config.
 - Service
 - Counter
 - Reset (Reset data)
 - Data Transfer



P
001-999

Default Program

	Stitchlen.	Stitch length	0.0 – 12.0 mm
	Foot Press.	Sewing foot pressure	01 - 20
	Thr.Tens.	Needle thread tension	01 – 99 %
	Foot Stroke	Sewing foot stroke	0.5 – 9.0 mm
	Start Tack	Start bartack	ON/OFF
	End Tack	End bartack	ON/OFF
	Thread Trim	Thread cutter	ON/OFF
	 DailyPieces	Daily piece counter	Mode OFF/Incr./Decr.

Attention! Priority Technician Mode



The settings of the technician level have the **priority**



Define parameters and default values with care



Machine config.





	Thread Trim	Settings for the thread cutter tool	ON/OFF, Speed--> ...
	Thread Clamp	Adjustments for Thread Clamp	Angles, Options, PWM, NSB
	Speed	Speed settings for particular conditions	Max/Min., Pos.Speed, SoftStart
	Stop Positions	Needle positions	at Stop, Threading, at Cutting
	Foot	maximum height and speed of foot lift	
	Thr.Tens.	Behaviour of thread tension during intermediate foot lift and after trim (cutting)	
	Stroke	Couple the 2 nd thread tension with the 2 nd foot stroke	
	Stitchlen.	limit the maximum stitch length.	
	Holding Fore	Motor holding force	
	Puller		
	Pedal	Settings for pedal behaviour, response times	
	NeedleCooling	Needle cooling settings	speed, lag time/delay, ...
	EdgeGuide	Edge Guide	travel speed, Min. gap mm
	FabricThickness	Material thickness detection	
	SpeedCorr	Correction effects of high speed	Hysterese
	LightBarrier	Light Barrier settings	
	Mode Seg.Size	Counting method of seam sections: no. of stitches or the length in mm	
	Threading	Position of the sewing foot if threading mode is active/during threading mode	

Machine config. (Notes)

Machine config. (Notes)



User config.

 Language	Select the software menu language	FR, CZ, EN, DE, SL
ParameterView	Activate display of the parameter numbers	
Input Config	Configuration and allocation of inputs: function buttons, pedal	
Output Config	Configuration & allocation of outputs: opt.equipment, NeedleCooling	
StitchFunctions	Configuration of individual stitch counting (half stitches)	
Scanner	Configuration of a connected Scanner	
Interface	Definition of interface at the DAC to which scanner is connected	
 Programs	Behaviour of programs: Abort, segment switch, Forward Sound	
Jog-Dial	Activate the handwheel (Jog-Dial) to be used as input instrument	
 Lock	Setting access right for operators, block functions and modes	
M2M	Configure Machine to Machine	
Contrast	Predefinition control panel contrast	
 Brightness	Predefinition of brightness of control panel OP3000	

User config. (Notes)

Input Signals of the machine

Input Signal	Input	Input functions
S1 Sew backwards	X120T.3	3
S2 Needle position	X120T.16	4
S3 Bartack	X120T.4	2
S4 2 nd stitch length	X120T.17	12
S5 2 nd thread tension	X120T.5	11
S6 Change to next seam section	X120T.18	23
Knee button S1	X120T.15	21
Knee button S2	X120T.2	21
Jog-Dial (handwheel)	X100B.15	6

Output Signals of the machine

Output Signal	Output
ML (X22)	X120B.9
NK (X22)	X120B.10
RA (X16)	X120B.12
STL (X17)	X120B.22
STL (FA) (X18)	X120B.23
FL (X15) (X22)	X90.12
FF3 OUT (X22)	X90.15

Output functions
0
1 = Needle Cooling
3 = Pos 1
4 = Pos 2
5 = Motor Running signal
6 = Central Guide
7 = Signal Foot Lift

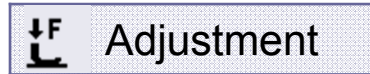


Service



Multitest

Verification if equipment is functioning correctly (e.g. pedal)



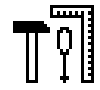
Adjustment

Service routines with the machine under tension



Calibration

Calibration of stitch length, pedal, edge guide, thickness



Service (Notes)

Counter

P.C.	Piece Counter
P.C.D.	Piece Counter Daily
S.C.	Stitch Counter
B.C.	Bobbin Counter



Res

Reset (data)

Reset data	All parameters are reset to the factory settings
Reset programs	All created programs are erased.
Reset Calibr.	All calibration values are reset to the factory settings.
Reset all	All parameters, programs and calibration values are reset



Data Transfer



All Data

Transfer of parameter settings, programs and calibration values



Only Data

Transfer of parameter settings and calibration values



Programs

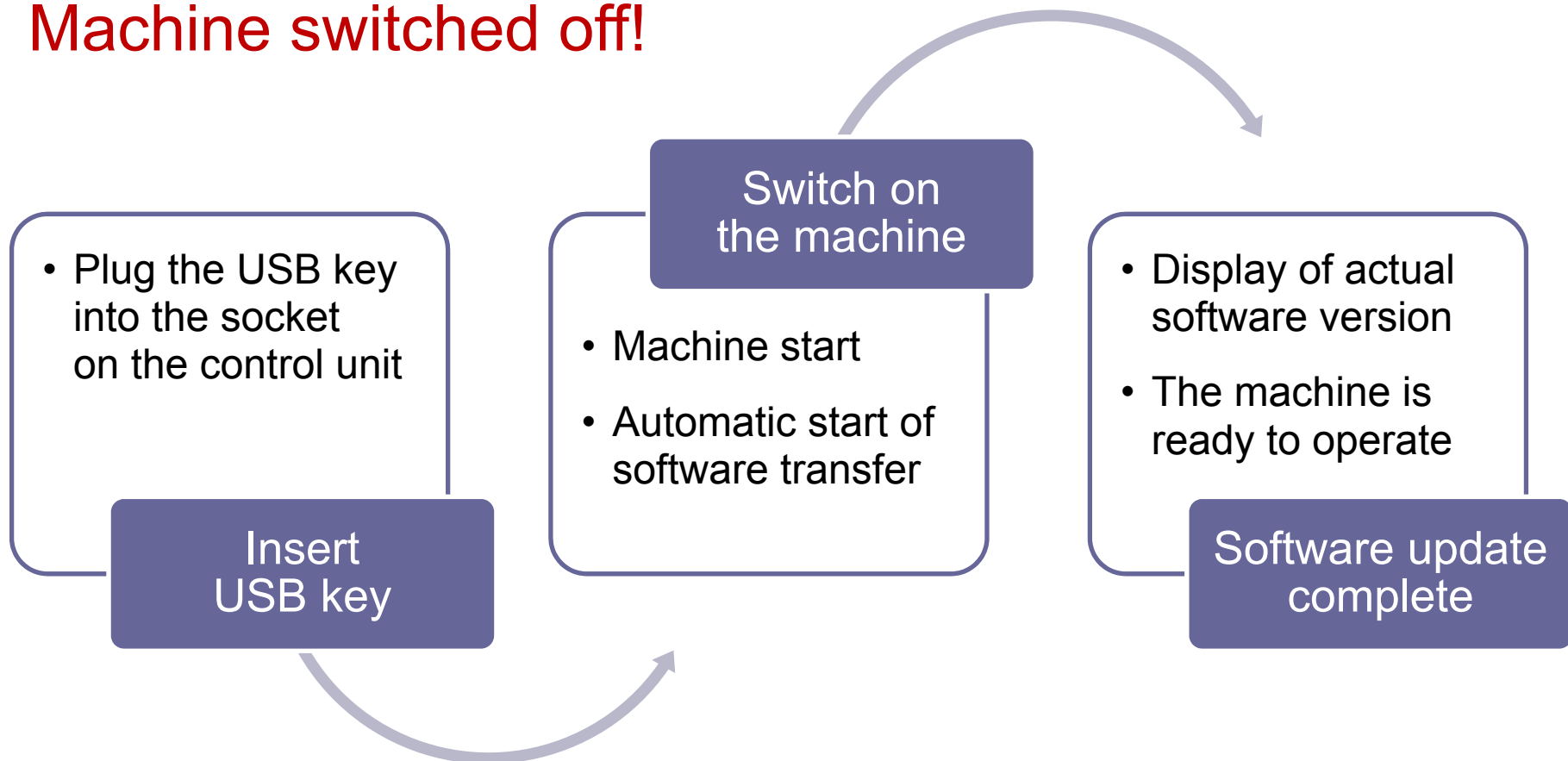
Transfer of all or just specific programs

1 Software Update

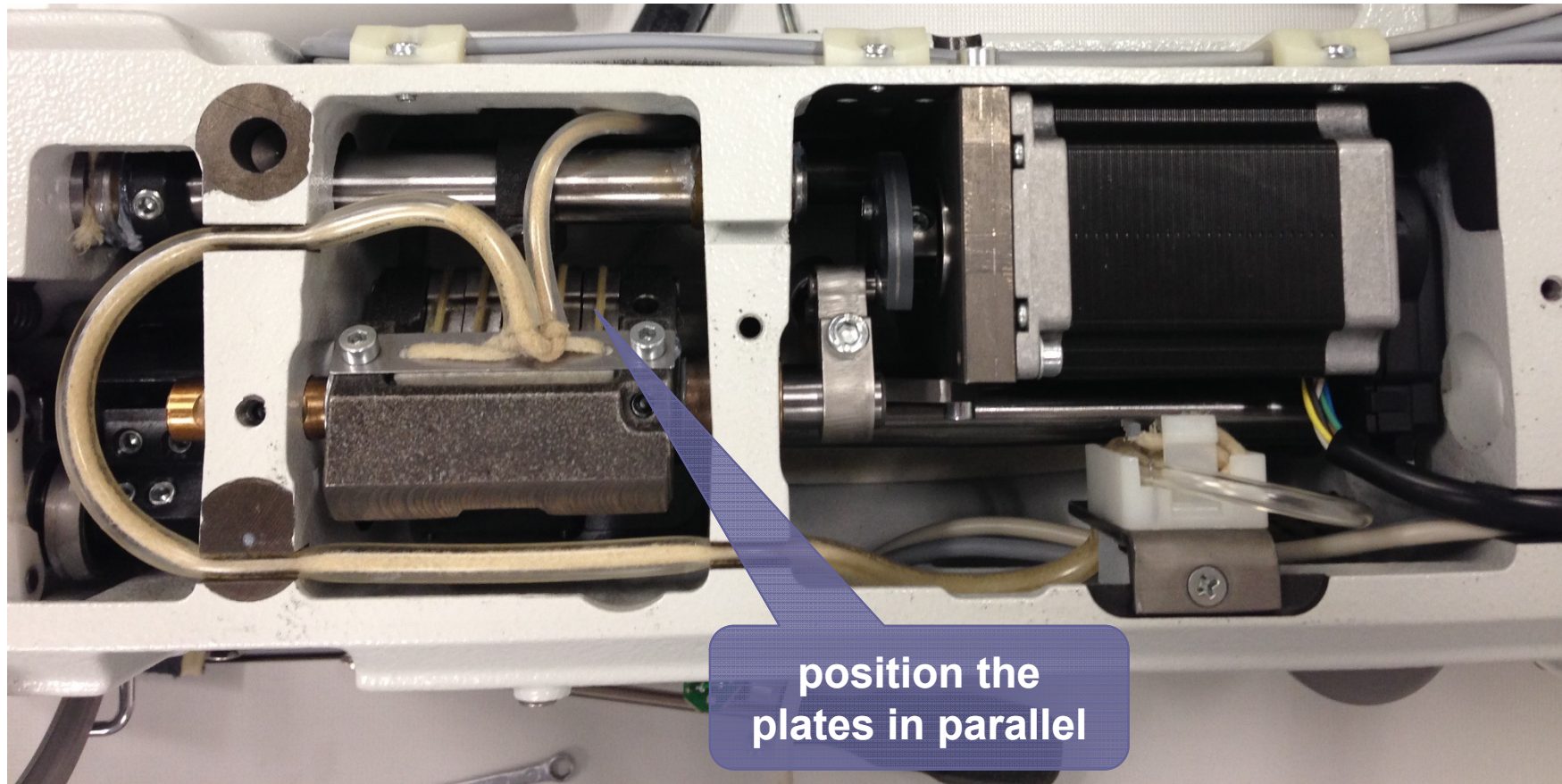
- The file of the actual software version (*.dacing) can be downloaded from the Dürkopp-Adler website
- Save software version file to the root directory of USB key (no subfolder)
- Make sure you just have **ONE** software version file stored on USB !!!
- Update the software of the machine

2 Software Update

Machine switched off!



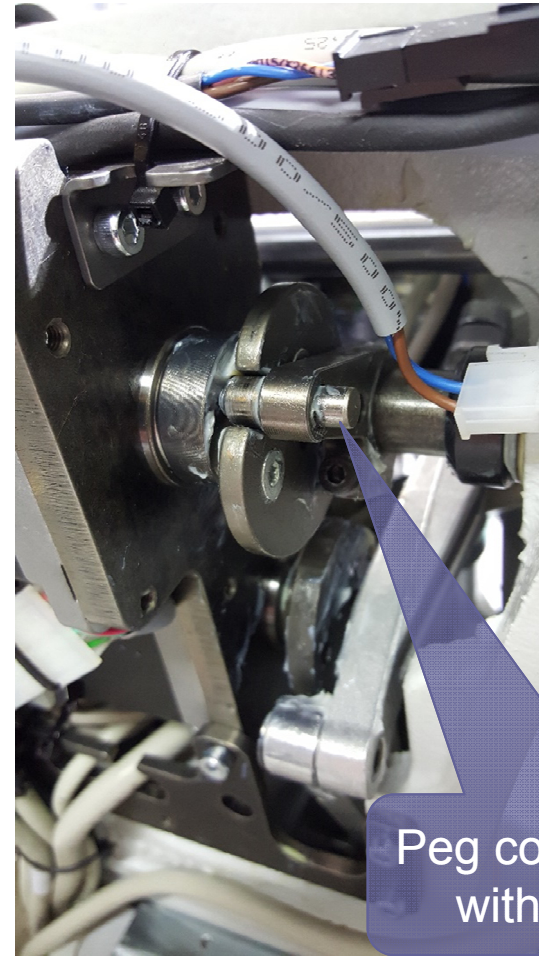
Specific Mechanical Adjustments PREMIUM: Setting the sewing foot lifting gear



Specific Mechanical Adjustments PREMIUM: Setting the sewing foot pressure and sewing foot lift

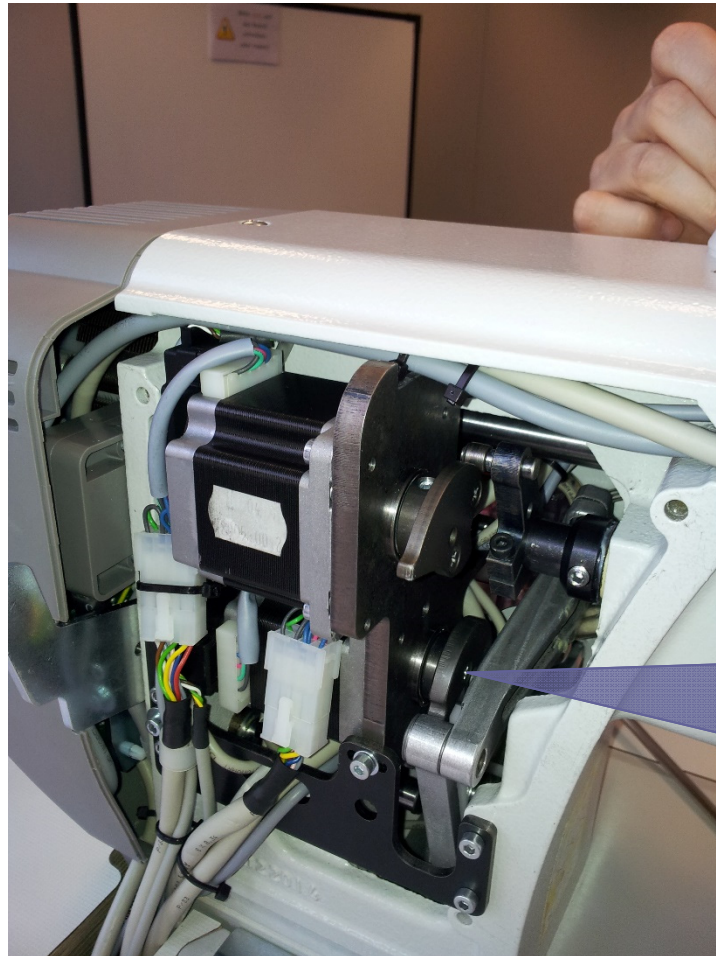


Place a 5 mm pin
between the presser
foot and throat plate.



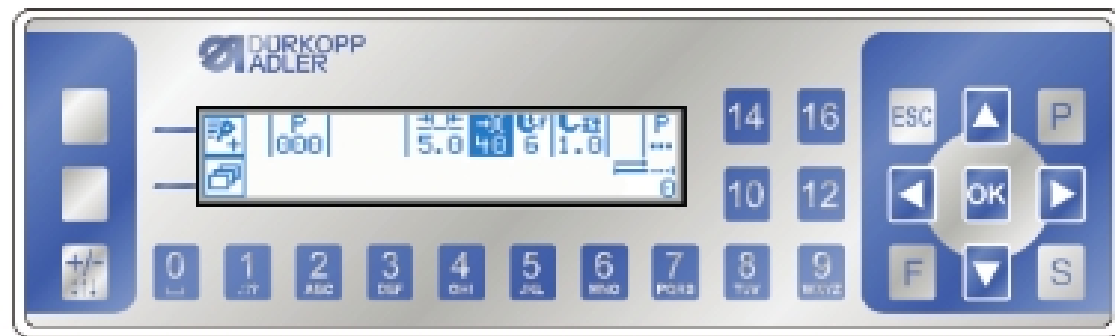
Peg control cam in place
with the locking pin

Specific Mechanical Adjustments PREMIUM: Setting the mechanical stitch adjustment



- Insert the locking pin into the hole on the bearing bracket and into the recess in the control cam.
- Manually position the plates so that they are parallel.
- Press the white plastic bar against the control cam without play.

QUESTIONS?



**THANK YOU
FOR YOUR ATTENTION**



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