DÜRKOPP ADLER

M-Type
M-Type PREMIUM

Additional Instructions

Seam middle guide

IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE

1 General information

The seam middle guide is used as an aid to guide the material during top stitching.
The seam middle guide is supposed to indicate the midway point between 2 seams so that the distance is the same from the middle to the left and right needle.

These kits can be assembled on all 2-needle machines of class 867.

The seam middle guide is available in several versions:

- Mechanical seam middle guide (N800 005655)
- External pneumatic seam middle guide (N800 005650)
- Pneumatic seam middle guide integrated into the presser foot (sewing equipment E24/.../... mm stitch length)

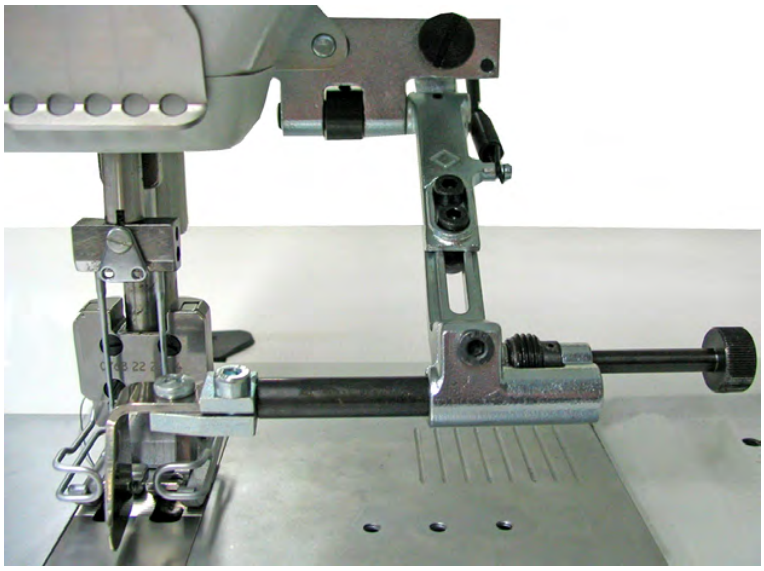
All versions function in the same manner.

1.1 Components of the kit N800 005655

Check whether the scope of delivery for the kit is correct prior to installation.

Part number	Quantity	Description
0667 245004	1	Stop
9202 002077	2	Cheese-head screw (M4x10)
9202 002877	2	Cheese-head screw (M6x10)
9330 000087	2	Washer (A4, 3)
N800 075013	1	Ruler
N800 080003	1	Holder

Fig. 1: General information: Mechanical seam middle guide (3)



1.2 Components of the kit N800 005650

Check whether the scope of delivery for the kit is correct prior to installation.

Part number	Quantity	Description
0667 105164	1	Head cover
0667 595050	1	Holder
1001 009243	2	Washer
9202 002107	2	Cheese-head screw (M4x20)
9204 211997	1	Flat-head screw (M5x16)
9205 102778	1	Threaded pin (M8x8)
9217 000157	1	Wing screw (M4x16)
9231 110127	1	Hex nut (M6)
9330 000087	3	Washer (A4, 3)
9700 100040	1	Cylinder, single
9710 920013	1	Throttle valve
N800 005614	1	Stop
N800 005615	1	Pressure piece
9840 120026	1	Mounting clip
9204 201667	1	Pan-head screw (M4x10)
0867 590064	1	Pneum. connection cpl.
9870 867005	-	Cable K, for magnet valve
9815 301082	-	Button
0797 000317	-	Magnet valve **Important**: Magnet valve open without current

Fig. 2: General information: Pneumatic seam middle guide (2)

Important

There is a 2nd version of the pneumatic seam middle guide:
For class 867, there is also the seam middle guide integrated into the presser foot for sewing equipment E24/.../... mm stitch length.

Fig. 3: General information: Integrated seam middle guide in the presser foot (3)

Both variants of the pneumatic seam middle guide are set in the same manner in the software. The only difference is the assembly.

1.3 Kits for M-TYPE PREMIUM

Important

Machines of the M-TYPE PREMIUM class are not equipped with compressed air. If you want to connect the pneumatic seam middle guide to a PREMIUM machine, you will need the following additional kits (see 🕮 *Parts List*):

- **9780 000108**: Compressed air maintenance unit
- **0867 593534**: pneumatic connection PREMIUM
- **0797 003031**: Pressure line K

2 Assembly

2.1 Assembling the seam middle guide

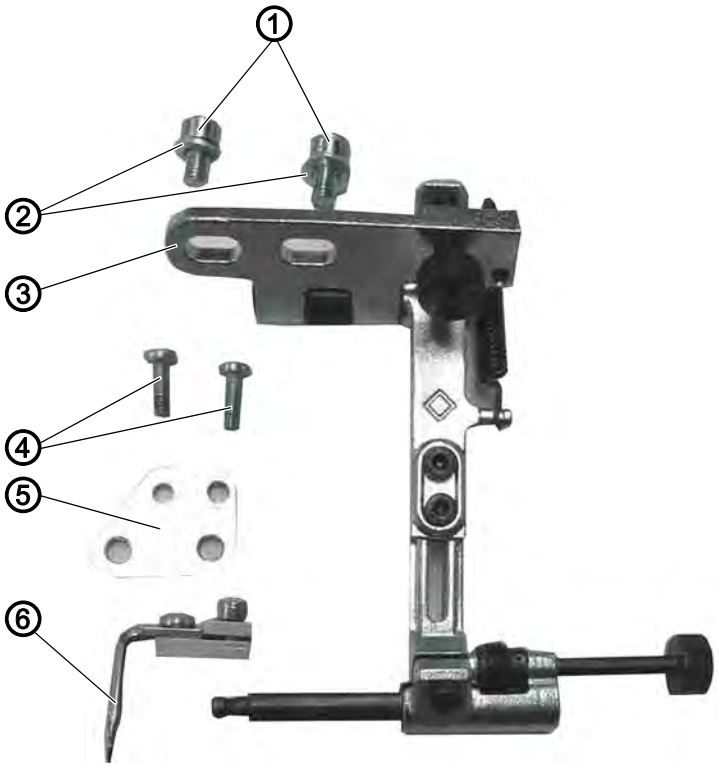
There are 2 versions of the seam middle guide:

- Mechanical seam middle guide
- Pneumatic seam middle guide

There are 2 versions of the pneumatic seam middle guide.

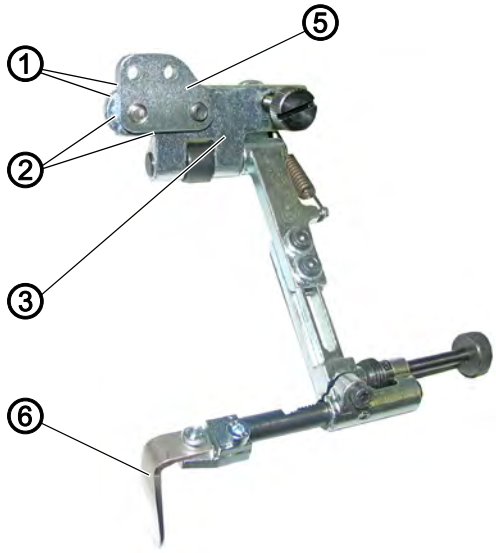
2.1.1 Assembling the mechanical seam middle guide

Fig. 4: Assembling the mechanical seam middle guide (1)



(1) - Screw
(2) - Washer
(3) - Bracket (pre-assembled)
(4) - Screw
(5) - Fixing plate
(6) - Seam middle guide

Fig. 5: Assembling the mechanical seam middle guide (2)

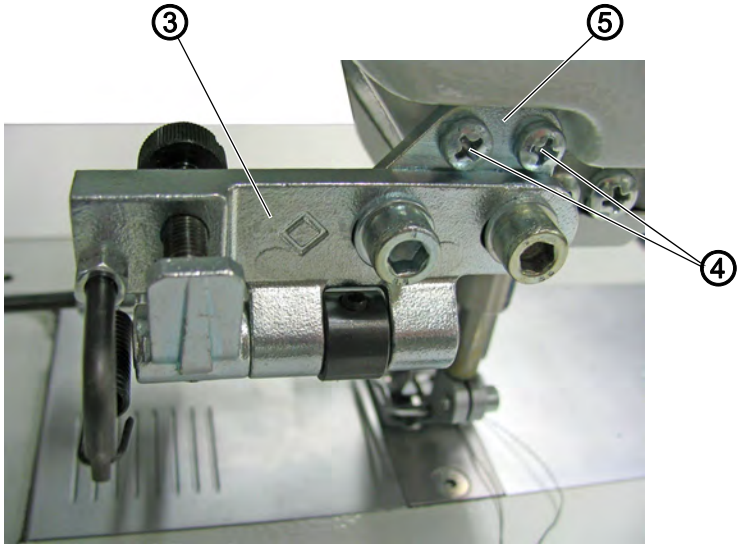


(1) - Screw (not visible)
(2) - Washer
(3) - Bracket
(5) - Fixing plate
(6) - Seam middle guide

To assemble mechanical seam middle guide:

1. Use the screws (1) and the washers (2) to screw the fixing plate (5) to the bracket (3).
2. Screw the seam middle guide (6) to the bracket (3).
3. Use the screws (4) to screw the fixing plate (5) from the rear to the sewing head.

Fig. 6: Assembling the mechanical seam middle guide (3)

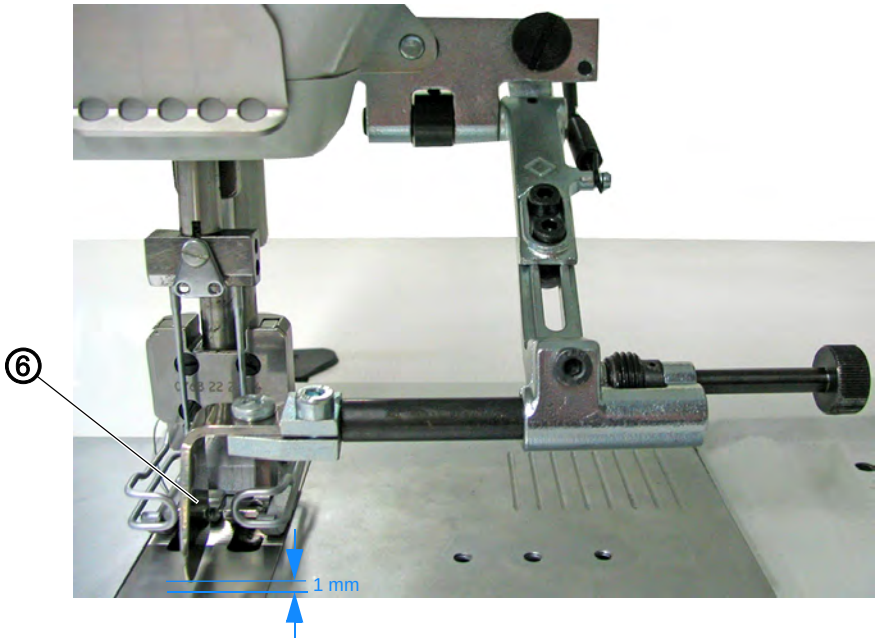


(3) - Bracket
(4) - Screw
(5) - Fixing plate

4. Align the bracket (3) horizontally to the tabletop.

Make sure that the distance to the left and right needle is the same. There should be a distance of 1 mm between the seam middle guide (6) and the throat plate.

Fig. 7: Assembling the mechanical seam middle guide (4)



(6) - Seam middle guide

2.1.2 Assembling the pneumatic seam middle guide

DANGER

Risk of death from live components!

Unprotected contact with electricity can result in serious injuries or death.

Only qualified specialists may perform work on electrical equipment.

Switch off the machine and disconnect the power plug before assembling the pneumatic seam middle guide.

NOTICE

Property damage may occur!

Damage to the sewing material or individual parts of the seam middle guide.

Set a maximum of 3 bar for the seam middle guide on the pressure gage of the compressed air unit.

NOTICE

Property damage may occur!

The pneumatic hose can be damaged by kinking or crushing.

Do NOT kink or crush the pneumatic hose.

Order

The assembly of the pneumatic seam middle guide involves 3 steps:

1. Assemble the seam middle guide.
2. Complete the compressed air unit.
3. Establish the electrical connection.

Assembling the seam middle guide

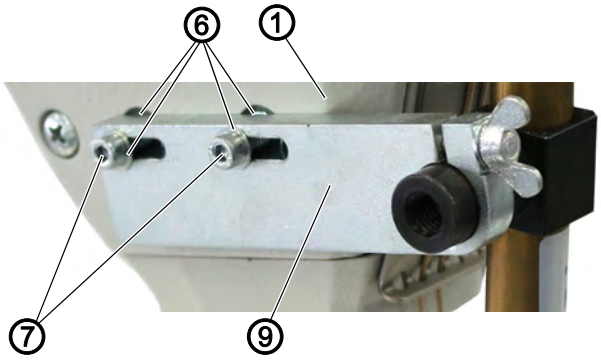
Fig. 8: Assembling the pneumatic seam middle guide (1)

(1) - Head cover
(2) - Screw
(3) - Washer
(4) - Hole
(5) - Mounting clip
(6) - Washer
(7) - Screw
(8) - Seam middle guide
(9) - Bracket
(10) - Connection

To assemble the pneumatic seam middle guide:

1. Disassemble the old head cover (NOT at M-Type PREMIUM).
2. Assemble the new head cover (1) (NOT at M-Type PREMIUM).

Fig. 9: Assembling the pneumatic seam middle guide (2)



(1) - Head cover
(6) - Washer
(7) - Screw
(9) - Bracket

3. Use the 2 screws (7) and the 4 washers (6) to screw the bracket (9) to the new head cover (1).

Fig. 10: Assembling the pneumatic seam middle guide (3)

(1) - Head cover
(2) - Screw
(3) - Washer
(5) - Mounting clip
(10) - Connection
(11) - Pneumatic hose

4. Connect the pneumatic hose (11) to the mounting clip (5).
5. Use the screw (2) and the washer (3) to screw the mounting clip (5) into the hole (4).
6. Assemble the pneumatic hose (11) to the connection (10).
7. Route the pneumatic hose (11) to the rear.

Information

The black pneumatic hose (11) with kit N800 005650 has a slightly larger diameter than the transparent pneumatic hose which is connected to the presser foot.

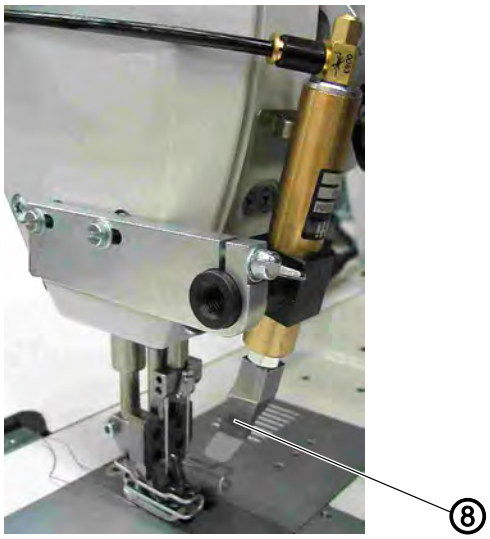
Fig. 11: Assembling the pneumatic seam middle guide (4)

Kit N800 005650 contains an adapter that is used to connect the black pneumatic hose (11).

8. Connect the pneumatic hose (11) to the rear of the machine arm using the adapter.
9. Assemble the pneumatic hose (11), for example, with cable ties, to the existing cable harness and lay it under the tabletop to the compressed air unit.

   In doing so, do not kink or crush the pneumatic hose.

Fig. 12: Assembling the pneumatic seam middle guide (4)



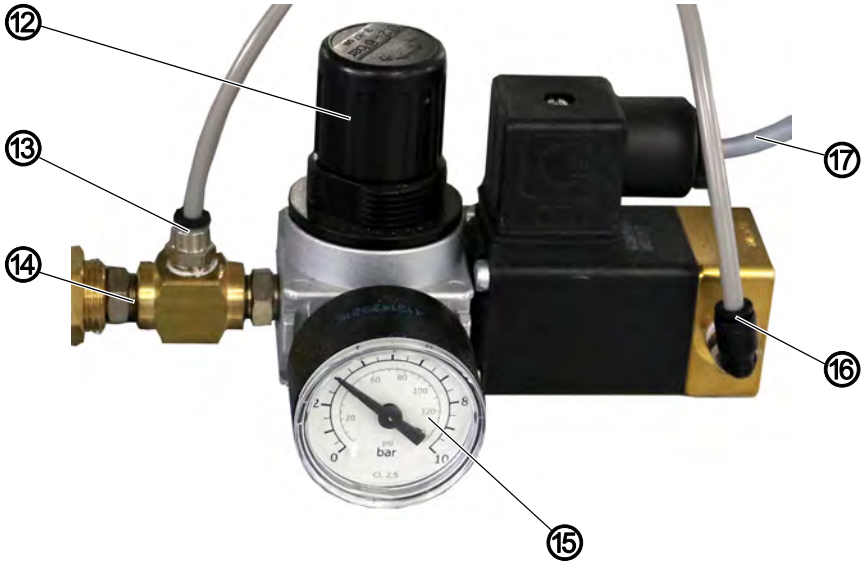
(8) - Seam middle guide

10. Align the seam middle guide (8).

    Make sure that the distance to the left and right needle is the same. There should be a distance of 1 mm between the seam middle guide (8) and the throat plate when the seam middle guide is in the lower position.

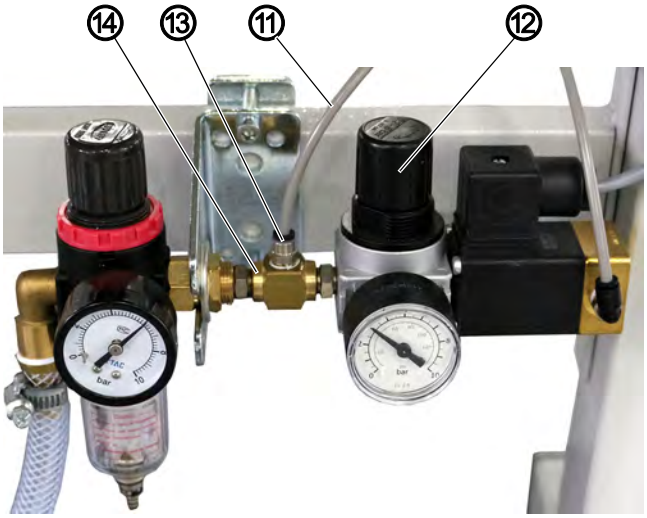
Completing the compressed air unit

Fig. 13: Assembling the pneumatic seam middle guide (5)



(12) - Rotary switch
(13) - Connection
(14) - Connection
(15) - Pressure gage
(16) - Connection
(17) - Cable (from the magnet valve)

Fig. 14: Assembling the pneumatic seam middle guide (6)



(11) - Pneumatic hose
(12) - Rotary switch
(13) - Connection
(14) - Connection

To complete the compressed air unit:

11. Use the connection (14) to connect the pre-assembled compressed air unit to the existing compressed air unit.
12. Connect the pneumatic hose (11) to the connection (13).

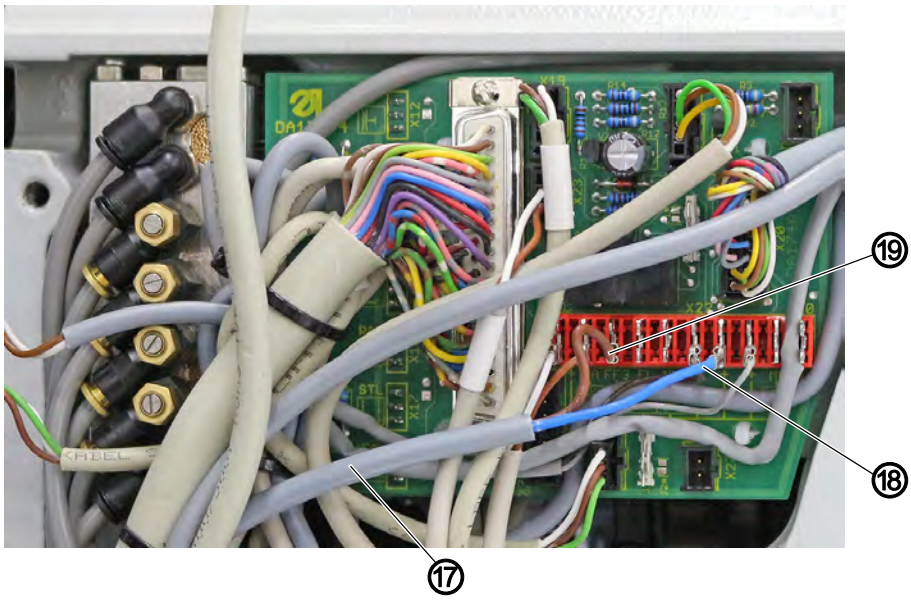
13. Set the rotary switch (12) to a maximum of 3 bar.

Establishing electrical connection

To establish the electrical connection:

14. Lay the cable from the magnet valve (17) upwards into the junction.

Fig. 15: Assembling the pneumatic seam middle guide (7)



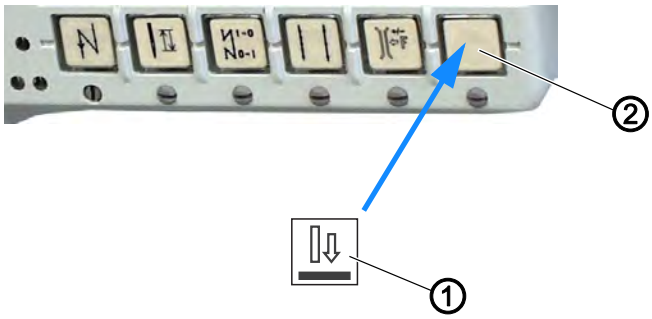
(17) - Cable (from the magnet valve)
*(18) - Neutral conductor (**+** 24 V)*
*(19) - Phase (**FF3** OUT)*

15. Connect both connections from the magnet valve (17) to the connector strip **7**, X22, PIN3 (**FF3** OUT) and PIN 1, 7 or 8 (**+**24 V) of the circuit board.

↳ The seam middle guide is now fully assembled.

2.2 Setting the seam middle guide in the software

Fig. 16: Setting the seam middle guide in the software



(1) - Seam middle guide sticker *(2) - Free button*

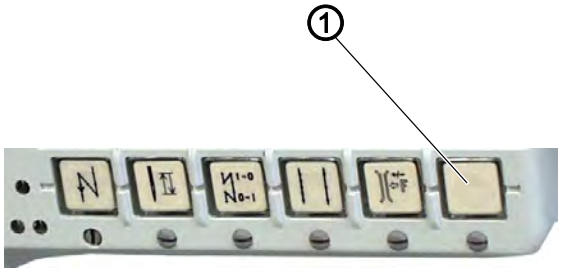
Regardless of the control which is connected to the machine, there is usually a free button on the push button panel on the machine arm.

In fact, all buttons on the push button panel are always fully customizable, but only the 6th button is set as a free button at the factory. This is why we recommend that you assign the seam middle guide function to this free button (2). This kit has a sticker (1) with the symbol of the seam middle guide in order to indicate the free button (2) accordingly.

For the different controls that may be connected to class 867, correspondingly different parameters must be adjusted for the seam middle guide.

2.2.1 For DAC basic control

Fig. 17: For DAC basic control (1)



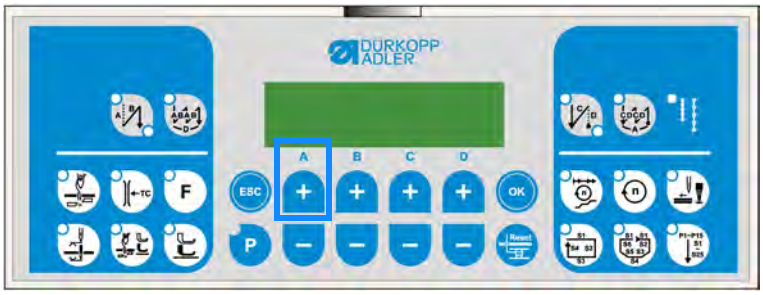
(1) - Button

To set the seam middle guide function in the software of a DAC basic control:

1. Select the desired button (1) which is to be assigned the seam middle guide function.
2. On the OP1000 control panel, keep the buttons **P** and **Reset** pressed down while switching on the machine.

↳ The display switches to `o 06 00`.

Fig. 18: For DAC basic control (2)



3. To switch to service level, press the **A+** button.

↳ The display switches to `t 00 00`.

4. Keep the desired button (1), which is to be assigned the seam middle guide function, pressed down.

↳ The display shows the parameter for setting the pressed button (1). If the button (1) was not previously assigned, the display shows `0`.

5. Set parameter to `10` (input function for function module 3).

6. Confirm with **OK**.

↳ The display briefly shows the parameter `t 11 61` and switches to `0` or `1`.

- `0` = set at the factory
- `1` = function module inverted

7. Set parameter to `5` (carrier roller/seam middle guide).

↳ The seam middle guide function is set in the software.
The seam middle guide is now successfully assembled and ready for use.

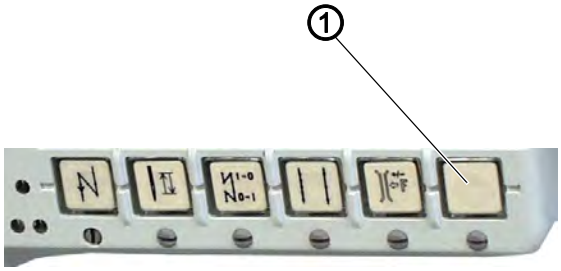
Information

In the parameter group `t 14 XX`, all parameters for the carrier roller can be adjusted (raising seam middle guide when locking/lifting the sewing feet, delaying lowering the seam middle guide, etc.).

See also the 🕮 *Parameter list 867 DAC basic/classic*.

2.2.2 For DAC comfort control

Fig. 19: For DAC comfort control (1)



(1) - Button

To set the seam middle guide function in the software of a DAC comfort control:

1. Press the **P** and **S** buttons at the same time to access the Technician level.
2. Enter the password (25483).
3. Select the desired button (1) which is to be assigned the seam middle guide function.

Fig. 20: For DAC comfort control (2)

4. In the menu `User config > Output config` select the desired output and assign the mode `6` (Puller/seam center guide).

Machine output signal	Output
FF3 OUT (X22)	X90.15

5. In the menu `User config > Input config` select the input for the desired key and assign the mode `15` (Seam center guide/puller).

Machine input signal		Input
Buttons on the button bar	S1	X120T.3
	S2	X120T.16
	S3	X120T.4
	S4	X120T.17
	S5	X120T.5
	S6	X120T.18

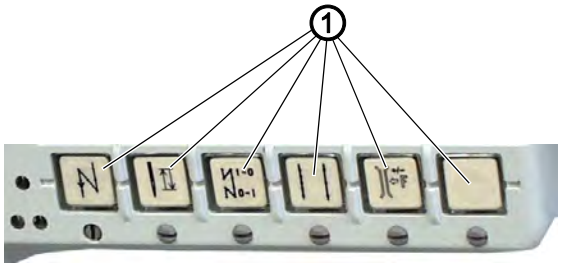
6. In the menu *Machine config > Center Guide* choose the mode *on* to activate the seam center guide.
   If neccessary, restart the machine if there do not appear new submenus in this menu.
7. In the menu *Machine config > Center guide* insert the desired parameter.

Menu item	Setting options
Auto	Mode for automatic raising of the seam center guide.
	Off Raising of the seam center guide is deactivated; it is not raised automatically.
	OnTack Raising of the seam center guide when sewing the bartack.
	OnLift Raising of the seam center guide when lifting the sewing foot.
	Tack+Lift Raising of the seam center guide when sewing the bartack and lifting the sewing foot.
RaiseOnHP	When the second stroke height is activated, the seam center guide is automatically raised. (Value range: On/Off)

2.2.3 For Efka control

When the machine is switched off, the seam middle guide is in the lower position (magnet valve is electronically off). After switching on the machine, the seam middle guide is always up (magnet valve is electronically on).

Fig. 21: For Efka control (1)



(1) - Button

The seam middle guide can be switched on and off using any button (1) on the push button panel. The most suitable button in this case is the free button on the far right.

To set the seam middle guide function in the software of an Efka control:

1. Keep the **P** button pressed down.
2. Switch on the machine.
3. Enter the password for the service level: **3112**.
4. You can now set the desired parameters:

Required parameter settings

Sewing motor/control	Parameter
DC 1550/DA 321G	**F-275** to value **5**
DC 1600/DA 82GA	**F-149** to value **3**

For the seam middle guide, there are other possible parameter settings:

Other parameters

Parameter		Value	Seam middle guide function...
DA 321G	DA 82GA		
F-278 F-278	F-186 F-186	0 >0	• ...switch on and off with the desired button (1) • ...is switched on automatically after the stitch count
F-260	F-260	0 = off 1 = on	• ...lower after sewing foot lift with stitch count is off • ...lower after sewing foot lift after specified stitch count DA 321GPAR F-186 DA 82GA: PAR F278
F-261	F-261 F-261 F-261 F-261	0 1 2 3	• ...is always switched on for bartack and sewing foot lift if it was previously switched on • ...is only switched off during bartack and sewing foot lift if it was previously switched on • ...is only switched off during the sewing foot lift if it was previously switched on • ...is only switched off when sewing a bartack if it was previously switched on
F-262	F-262 F-262	0 1	• ...is always switched on for the quick stroke function (HP) by the knee button if it is switched on • ...is off during the quick stroke function (HP) by the knee button if it was previously switched on

Information

If the seam middle guide is switched off (up), the condition remains unchanged, regardless of how parameters F-261 and F-262 are set and which functions are effective.

DÜRKOPP ADLER AG
Potsdamer Str. 190
33719 Bielefeld
Germany
Phone: +49 (0) 521 925 00
Email: service@duerkopp-adler.com
www.duerkopp-adler.com