

867

Additional Instructions

Conversion control DA321G to
DAC classic

IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE

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1 General information

Components of the kit

Check whether the scope of delivery for kit 9880 867061 is correct prior to installation.

Part number	Quantity	Designation
9800 21001 R	1	Control DAC classic
9850 001309	1	Machine ID
9800 170040	1	Motor
9202 002477	4	Screw M5x10
9204 201827	3	Screw M4x7-H
9207 170227	2	Screw 3,5x16
9330 000087	3	Washer A4,3
9840 121002	6	Cable tie
9850 767019	1	Dongle with program
0791 867734 EN	1	Additional Instructions

2 Conversion DA321G to DAC classic

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.

2.1 Disassembling components

Before you can install the DAC classic control, the components that are no longer required must first be disassembled.



Important

Put the disassembled housing parts and screws aside, these will be needed again for later assembly.

2.1.1 Disassembling sewing drive DC1550



To disassemble the sewing drive DC1550:

1. Switch off the machine.
2. Loosen the 2 screws of the toothed belt cover.
3. Disassemble the toothed belt cover.
If necessary, loosen the oil pan.
4. Remove the circlip on the toothed belt pulley of the sewing drive.
5. Pull off the toothed belt.
6. Loosen the 4 screws of the motor mounting.
7. Disassemble the motor.
8. Loosen the toothed belt pulley from the drive shaft of the motor.

2.1.2 Disassemble the Efka control DA321G



To disassemble the Efka control DA321G:

1. Disassemble all cables at the rear of the control.
2. Loosen the 4 screws that fasten the control to the table top.
3. Remove the control from the table top.

2.1.3 Disassembling the Efka setpoint device



To disassemble the Efka setpoint device:

1. Loosen the 4 screws that fasten the set point device to the angle bracket.
2. Disassemble the setpoint device
3. Loosen the 4 screws that fasten the angle bracket to the table top.
4. Disassemble the angle bracket.

2.1.4 Disassembling the Efka control panel



To disassemble the Efka control panel:

1. Loosen the cover on the back of the machine head through which the control panel wire passes.
2. Loosen the screw on the back of the control panel.
3. Disassemble the control panel.

2.2 Assembling components

2.2.1 Assembling the new sewing drive



To assemble the new sewing drive:

1. Press the toothed belt pulley of the Efka DC1550 sewing drive onto the drive shaft of the new 750 W sewing drive.
2. Mount the sewing drive with 4 screws.
3. Put on the toothed belt.
4. Mount the circlip on the toothed belt pulley of the sewing drive.
5. Mount the toothed belt cover.
If the oil pan has been loosened, tighten the oil pan again

2.2.2 Assembling the DAC classic control



To assemble the DAC classic control:

1. Screw the control to the table top with 4 screws.
Use the screws previously used to mount the Efka control to the table top.



Important

The strain relief of the mains cable must be secured to the table top. Make sure that the cable between the control unit and the strain relief is not tensioned.

2. Connect all cables to the control (p. 8).

2.2.3 Assembling the OP1000 control panel



To assemble the OP1000 control panel:

1. Fasten the OP1000 control panel to the same bracket where the Efka control panel was previously mounted.
Use the screw previously used to tighten the Efka control panel.
2. Lead the OP1000 cable under the plastic cover on the rear of the machine head.
3. Fasten the plastic cover.
4. Connect the OP1000 cable to the control (p. 8).

2.2.4 Assembling the DAC setpoint device



To assemble the DAC setpoint device:

1. Screw the DAC setpoint device to the table top.
Use the screws previously used to secure the Efka setpoint device to the angle bracket.



Important

Make sure that the setpoint device is positioned correctly.
The pedal linkage runs vertically from the setpoint device to the pedal.
Secure the setpoint device cable under the guide of the angle and with the 2 nail clamps provided.

2. Connect the cable of the DAC setpoint device to the control ( p. 8).

2.2.5 Assembling the machine ID



To assemble the machine ID:

1. Screw the machine ID under the table top using the screws provided.
2. Connect the machine ID cable to the control ( p. 8).

2.2.6 Connecting the cables to the DAC classic

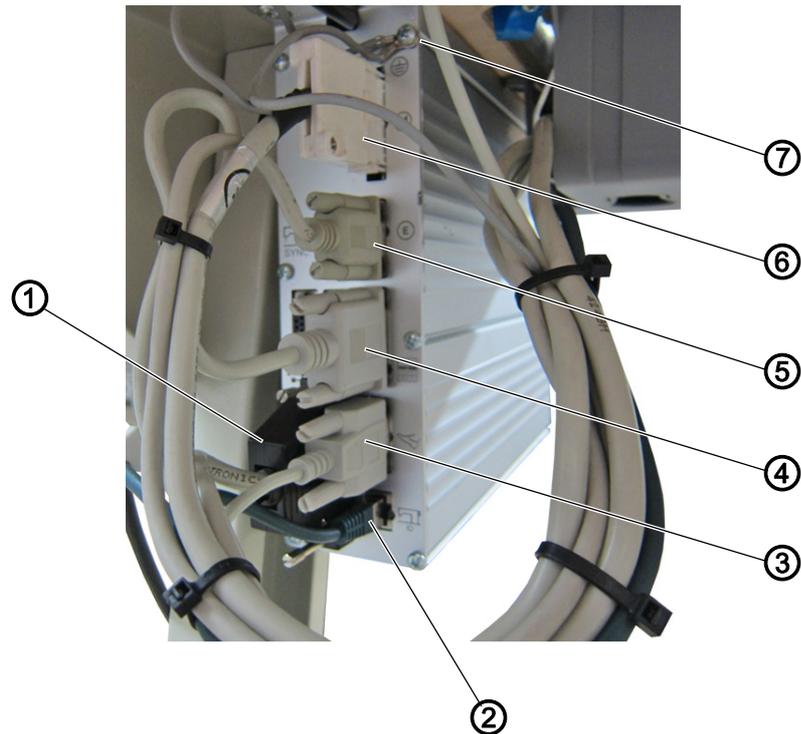
NOTICE

Property damage possible!

Functional impairment of the control system due to missing equipotential bonding.

Make sure that the equipotential bonding is properly connected.

Fig. 1: Connecting the cables to the DAC classic



- (1) - Input/output connector
- (2) - Machine ID
- (3) - Setpoint device
- (4) - OP1000 control panel

- (5) - Encoder
- (6) - Motor
- (7) - equipotential bondings

2.3 Software settings



To set the software settings for the DAC classic:

1. Connect the dongle to the control.
2. Switch on the machine.
- ↳ The software update to the current machine software starts.
3. Remove the dongle at the end of the software update.
4. Restart the machine.
5. Connect the dongle to the control unit again.
6. Press the keys  and  simultaneously.
7. Press **A+** to call up the technician level.
8. Select the parameter *t 51 04* with the keys **B+** and **D+**.
- ↳ Machine class and subclass are set in parameter *t 51 04*.
9. Select machine class 867-2 with keys **A+** and **A-** and confirm with key .
- ↳ Various subclasses are displayed.
10. Select the subclass 190x45 with the keys **A+** and **A-**.
11. Set the following reference positions:

Parameter	Reference position
<i>t 08 10</i>	Reference position: needle tip on throat plate and key 
<i>t 08 12</i>	lower needle position: 250
<i>t 08 13</i>	upper needle position: 155
<i>t 51 28</i>	Input function IN_EXT1: 0
<i>t 51 29</i>	Input function IN_EXT2: 0



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