

DAC comfort

Parameter list

M-TYPE PREMIUM 0791 867980 EN

IMPORTANT READ CAREFULLY BEFORE USE KEEP FOR FUTURE REFERENCE

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1 Software version

This parameter list applies to the following software versions of the control panel:

Control panel	Version
OP3000	A04.58
Commander Basic/Pro	A01.13



2 Categories

O/T	00	00-29	Start bartack
O/T	00	30-59	End bartack
O/T	00	60-99	Bartack
O/T	01	00-29	Thread clamp
O/T	01	30-49	NSB
O/T	01	50-54	PWM thread clamp
O/T	02		Thread cutter
O/T	03		Sewing foot lift
O/T	04		-
O/T	05		Soft start
O/T	06		Bobbin stitch counter/bobbin monitor
O/T	07		Seam programs
O/T	08		Motor
O/T	09		Thread tension
O/T	10		Stroke adjustment
O/T	11		-
O/T	12		Turn Back
O/T	13		Needle cooling
O/T	14		Puller/center guide
O/T	15		Edge cutter
O/T	16		Light barrier
O/T	17		Jog-Dial
O/T	18		Stacker
O/T	19		Zigzag
O/T	20		Thread wiper
O/T	21		Contour guide
O/T	22		Outfeed roller
O/T	23		Hook lubrication
O/T	24		-
O/T	25		Stitch loosening
O/T	26		Differential feed
O/T	27		Material thickness adjustment
O/T	28		Speed effect
O/T	29		Fullness support
O/T	30		Stitch length
O/T	31		Short Stitch
O/T	32		Edge guide
O/T	50		Operation lock
O/T	51		Control, other



O/T	52	OP
O/T	53-55	Input configuration
O/T	56	Output configuration
O/T	60	Multitest
O/T	61	Assemble
O/T	62	Calibration



3 Parameter

3.1 Operator level

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Bartack at seam begin	1					Setting the bartack at seam begin
O 00 01	Bartack at seam begin	1	0	1	0	-	Bartack at seam begin On/Off 0 = On; 1 = Off
O 00 02	Number of stitches backwards	n	1	50	3	Stitches	Number of backward stitches in bartack at seam begin
O 00 03	Number of stitches forward	n	1	50	3	Stitches	Number of forward stitches in bartack at seam begin
O 00 04	Number of bartack sections	n n	1	99	2	-	Total section number (forward and backwards) of bartack formation at seam begin
O 00 05	Stop-Time for direction change	2	0	1000	100	ms	Stop time for the direction change of the individual bartack sections in order to reach the specified stitch lengths (forwards/backwards). Stop time < 100 ms => Normal bartack Stop time > 100 ms => Ornamental-stitch bartack

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 00 06	Stitch length default		0	1	1	-	If this function is active, the same stitch length is used for the bartack as the one set in Manual mode. If this function is deactivated, a custom input can be entered.
O 00 07	Stitch length of backwards stitches		1.0	12.0	5.0	mm	Stitch length of backward stitches in bartack at seam begin
O 00 08	Stitch length of stitches forward		1.0	12.0	5.0	mm	Stitch length of forward stitches in bartack at seam begin
O 00 09	Speed in bartack	1	50	2000	1000	rpm	Speed in bartack at seam begin
O 00 10	Single stitches per pedal	₩¥	0	1	0	-	If this function is activated, each stitch in the bartack can be sewn individually by pressing the pedal. This function can only be used meaningfully if the speed is set very low for the bartack. 0 = Off 1 = Single stitch with bartack speed 2 = Single stitch with pedal-related speed
O 00 11	Needle thread tension Default value	Ì(←F DEFAULT	0	1	1	-	If this function is active, the same needle thread tension is used for the bartack as the one set in Manual mode. If this function is deactivated, a custom input can be entered.
O 00 12	Needle thread tension (right)) [←F	1	99	10	%	Deviant needle thread tension value in bartack (in 2-needle machines: right needle tension).

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 00 13	Needle thread tension left	F+)()(+F	1	99	10	%	Deviant needle thread tension value in bartack for the left needle thread (in 2-needle machines).
	Catch bartack	24		•			Setting the catch bartack
O 00 14	Catch bartack	24	0	1	0	-	Catch bartack at seam begin On/Off 0 = Off; 1 = On
O 00 15	Number of stitches backwards	E V	1	50	1	Stitches	Number of backward stitches in catch bartack at seam begin
O 00 16	Number of stitches forward	≣2 ↓	1	50	1	Stitches	Number of forward stitches in catch bartack at seam begin
	First bartack section	1		•		•	Setting the first bartack section at seam begin
O 00 17	First bartack section	1	0	1	0	-	The first section of the bartack can be programmed with a different number of stitches. All subsequent sections have the preset number of stitches from the settings for the start bartack. 0 = Off; 1 = On
O 00 18	Number of stitches	n	1	50	3	Stitches	Number of stitches in first bartack section at seam begin

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 00 19	Invert bartack direction		0	1	0	-	Normally, a bartack starts either with the sewing direction (forwards – even number of sections) or against the sewing direction (backwards – odd number of sections), depending on the number of sections. Setting this parameter inverts the sewing direction of the bartack.
O 00 20	Number of bartack sections	U n	1	10	2	-	Total section number (forward and backwards) of bartack formation at seam begin
	Last bartack section	4					Setting the last bartack section
O 00 21	Last bartack section	1	0	1	0	-	The last section of the bartack can be programmed with a different number of stitches. All subsequent sections have the preset number of stitches from the settings for the start bartack. 0 = Off; 1 = On
O 00 22	Number of stitches	i Ann	1	50	3	Stitches	Number of stitches in last bartack section at seam end
	Bartack at seam end	1			1	1	Settings of the bartack at seam end
O 00 51	Bartack at seam end	1	0	1	0	-	Bartack at seam end 0 = Off 1 = On

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 00 52	Number of stitches backwards	n	1	50	3	Stitches	Number of backward stitches in bartack at seam end
O 00 53	Number of stitches forward	n	1	50	3	Stitches	Number of forward stitches in bartack at seam end
O 00 54	Number of bartack sections	n U	1	99	2	-	Total section number (forward and backwards) of bartack formation at seam end
O 00 55	Stop-Time for direction change	<u>с</u> 5	0	1000	100	ms	Stop time for the direction change of the individual bartack sections in order to reach the specified stitch lengths (forwards / backwards). Stop time < 100 ms => Normal bartack Stop time > 100 ms => Ornamental-stitch bartack
O 00 56	Stitch length default		0	1	1	-	If this function is active, the same stitch length is used for the bartack as the one set in Manual mode. If this function is deactivated, a custom input can be entered.
O 00 57	Stitch length of backwards stitches		1.0	12.0	5.0	mm	Stitch length of backward stitches in bartack at seam end
O 00 58	Stitch length of stitches forward		1.0	12.0	5.0	mm	Stitch length of forward stitches in bartack at seam end
O 00 59	Speed in bartack		50	2000	1000	rpm	Speed in bartack at seam end

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 00 60	Single stitches per pedal	₩.	0	1	0	-	If this function is activated, each stitch in the bartack can be sewn individually by pressing the pedal. This function can only be used meaningfully if the speed is set very low for the bartack. 0 = Off 1 = Single stitch with bartack speed 2 = Single stitch with pedal-related speed
O 00 61	Needle thread tension Default value	Ì(←F DEFAULT	0	1	1	-	If this function is active, the same needle thread tension is used for the bartack as the one set in Manual mode. If this function is deactivated, a custom input can be entered.
O 00 62	Needle thread tension)(← F	1	99	1000	%	Deviant needle thread tension value in bartack
O 00 63	Needle thread tension left	F+)()(+F	1	99	1000	%	Needle thread tension of left needle thread (2-needle machines)
	Catch bartack	in.		•	•		Setting the catch bartack
O 00 64	Catch bartack	1	0	1	0	-	Catch bartack at seam end On/Off
O 00 65	Number of stitches backwards	ţ,	1	50	1	Stitches	Number of backward stitches in catch bartack at seam end
O 00 66	Number of stitches forward		1	50	1	Stitches	Number of forward stitches in catch bartack at seam end

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No.	Parameter	Icon	Min	Max	Preset value	Unit	Description
	Last bartack section	1					Setting the last bartack section
O 00 67	Last bartack section	1	0	1	0	-	The last section of the bartack can be programmed with a different number of stitches. All subsequent sections have the preset number of stitches from the settings for the start bartack.
O 00 68	Number of stitches	<u>n</u>	1	50	3	Stitches	Number of stitches in last bartack section at seam end
O 00 69	Invert bartack direction		0	1	0	-	Normally, a bartack starts either with the sewing direction (forwards – even number of sections) or against the sewing direction (backwards – odd number of sections), depending on the number of sections. Setting this parameter inverts the sewing direction of the bartack.
O 00 70	Number of bartack sections	Ŋ n	1	10	2	-	Total section number (forward and backwards) of bartack formation at seam end.
	First bartack section	1			•		Setting the first bartack section at seam begin
O 00 71	First bartack section	1	0	1	0	-	The first section of the bartack can be programmed with a different number of stitches. All subsequent sections have the preset number of stitches from the settings for the start bartack. 0 = Off; 1 = On

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 00 72	Number of stitches	n	1	50	3	Stitches	Number of stitches in first bartack section at seam begin
O 01 00	Needle thread clamp)[←	0	1	0	-	Needle thread clamp 1 = On 0 = Off
O 02 00	Thread trimmer	<u> </u>	0	1	1	-	Thread cutter 1 = On 0 = Off
	Sewing foot lift						Setting the sewing foot lift
O 03 00	Sewing foot lift at sewing stop		0	1	0	-	Automatic sewing foot lift during stop in sewing operations
O 03 01	Sewing foot lift after trim/at segment end		0	1	0	-	Automatic lifting of the sewing feet after thread cutting/at the end of the segment. The sewing feet will remain in their lifted position until a new sewing process begins.
O 03 10	Height of sewing foot lift at stop		0	20	18	mm	Adjust parameter of sewing foot lift at sewing stop. The lifting height can be adjusted to the material thickness.

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 03 11	Height of sewing foot lift after trim/at segment end		0	20	18	mm	Setting of the sewing foot lifting height after thread cutting/at the end of the segment. The lifting height can be adjusted to the material thickness.
	Remaining thread monitor						Settings of the remaining thread monitor
O 06 00	Bobbin monitor mode		Off	Moni- tor	Off	List	Selection modes for hook thread monitor Off = No monitoring of the remaining thread amount
		Σ:0000					Software = Monitoring of the remaining thread amount by stitch count
		~ <u>=</u> = •					Monitor = Use of the optional photoelectronic remaining thread monitor (RTM)
O 06 01	Counter Type		A	D	A	-	Selection of a stitch counter (A, B, C or D) that can be used, for instance, to factor in the capacity for different thread thicknesses.
O 06 02	Counter value	Σ:0000	0	99999	1000	Stitches	Bobbin supply capacity in stitches. This is a very variable value, which depends on the size of the bobbin and the thickness of the thread.
O 06 03	Stitch count bobbin	Σ:0000	0	1	0	-	Sewing stops and a notice is shown on the display when the bobbin is detected to be nearly empty. If the parameter is not activated, only the LEDs on the machine arm give a warning if the bobbin is empty.

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No.	Parameter	lcon	Min	Мах	Preset value	Unit	Description
O 06 06	Sewing stop	⊘ 	0	1	0	-	Sewing stops and a notice is shown on the display when the bobbin is detected to be nearly empty. If the parameter is not activated, only the LEDs on the machine arm give a warning if the bobbin is empty.
O 06 07	Sewing foot lower position		0	1	0	-	The sewing feet will remain at the bottom position after thread cutting. Sewing foot lift is blocked.
O 06 08	Reset necessary		0	1	0	-	It is only possible to resume sewing after changing the bobbin and confirming the message on the control panel.
O 06 09	t Clean		0	5000	200	ms	Duration for which the lens is blown clear with compressed air. The process takes place as the thread is cut.
	Daily piece counter	Σ↓↑ 0000		·			Daily piece counter for the active seam program
O 06 10	Counter Mode	Σ↓↑ 0000	-	-	-	-	Daily piece counter, can be set to count either up or down. When the daily piece counter is activated, it must be reset once after entering a value to ensure it counts correctly.
O 06 11	Reset daily piece counter	Ο Σ:0000	0	1	0	-	Display of remaining stitches corresponding to the thread capacity of used bobbin
O 07 00	Program name	<pre>PP <></pre>	-	-	-	-	Enter of program name
O 07 01	Next program	P→P×	0	999	0	Prog	Definition of the subsequent seam program

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Program Cycle						Settings of the program cycle
O 07 02	Program Cycle	(P)	0	1	0	-	Definition of segments that will be repeated in cycle to realize ornamental seams with defined stitch formation.
O 07 03	Start Segment	→ →→1	0	30	0	-	Seam segment that will start the program cycle.
O 07 04	End Segment	⊢→→→	0	30	0	-	Seam segment that will end the program cycle.
O 07 05	Repetitions		0	99	0	-	Number of repetitions for defined seam segments 0 = endless 1-99 = Number of repetitions
O 07 10	Seam length in segment	Hint Market	0	9999	0	mm	Length of a seam segment in millimeter
O 07 11	Number of stitches in segment	⊨ → →	0	9999	0	Stitches	Number of stitches in a seam segment
	Seam segment end	→ ↓ 		•	•		Modes for the end of a seam segment

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 07 20	Sewing stop		0	1	1	-	Automatic sewing stop at the end of a seam segment To continue with the seam, the pedal must be set to the neutral position. 0 = Off 1 = On
O 07 21	Needle up position		0	1	1	-	Upper needle position at the end of the seam segment 0 = Off 1 = On
O 07 30	Backwards	T T	0	1	0	-	Stitches in segment will be sewn backwards
O 08 00	Max. Speed	n max	50	3000	3000	rpm	Maximum speed by pressing the pedal to the end position.
O 08 01	Needle position	ZŽĮZ	0	1	0	-	Position of the needle when sewing stops. The needle is either in the material or at the upper needle position.
O 08 14	Pointing Position		0	359	90	0	The distance of the needle from the material can be adjusted to allow precise positioning of the sewing material when starting sewing. The value entered here corresponds to the degree number on the handwheel. Move to the position using the press function on the jog dial.
O 08 30	Sewing speed	n	0	1	0	-	Display of current speed
O 08 31	Needle position		0	1	0	-	Display the current needle position (degree number on the handwheel)

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 08 32	Pedal position	-20+24	0	1	0	-	Display of the current pedal position
O 09 02	Additional value needle thread tension (+))(-F ⊕	1	99	20	%	Second value for the needle thread tension This value can be activated with a button/switch
O 09 12	Additional value needle thread tension left (+)	F+)()(+F (+)	1	99	20	%	Second value for the needle thread tension (left) This value can be activated with a button/switch
O 10 02	Additional value sewing foot stroke (+)		0.5	9.0	2.0	mm	Second value for the sewing foot stroke. This value can be activated with a button/switch
O 14 00	Seam Center Guide		0	1	0	-	Seam Center Guide 0 = Off 1 = On
O 14 01	Puller	0 0	0	1	0	-	Puller 0 = Off 1 = On
	Puller (upper + lower roller)	0 0					Adjust parameter of puller feeding
O 14 20	Correction top roller	⊙ +/- V	-100	100	0	%	The puller supports the transport of the sewing material. The feed of the two rollers is calculated automatically based on the stitch length of the machine. An adjustment may be necessary depending on the application. The rollers of the puller can be adjusted separately. The input is in percent: a positive value increases the roller feed while a negative value reduces the feed.

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 14 30	Correction bottom roller	⊙ ↓ /-	-100	100	0	%	The puller supports the transport of the sewing material. The feed of the two rollers is calculated automatically based on the stitch length of the machine. An adjustment may be necessary depending on the application. The rollers of the puller can be adjusted separately. The input is in percent: a positive value increases the roller feed while a negative value reduces the feed.
O 15 00	Edge trimmer	: 1	0	1	0	-	Edge cutter 0 = Off 1 = On
	Light barrier						The light barrier detects the beginning and the end of the material. After a signal was detected, sewing can continue automatically with the specifically set parameters.
O 16 00	Light barrier		0	1	0	-	Light barrier 0 = Off 1 = On
O 16 01	Distance		0	255	50	mm	Here, you can set the distance from the detection of the signal to the end of the material. This distance signifies the path from the needle to the light barrier. The path is specified in millimeters and used by the machine to independently calculate the number of stitches.
O 16 02	Signal detection at seam begin		0	1	1	-	The signal scan of the light barrier is performed at the beginning of the seam. If the function is activated, the light barrier must detect a signal to allow the machine to sew. If the function is inactive, sewing can take place without signal detection.
O 16 03	Signal detection at seam end		0	1	0	-	The signal scan of the light barrier is performed at the end of the seam. If the function is active, the machine will continue to sew with the specifically set parameters following the signal detection. If the function is inactive, nothing will happen.

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 16 10	Number of signal detections		1	255	1	Seams	Input of the number of signal detections after which the machine is supposed to continue with the specifically set parameters.
O 16 20	Filter stitches		0	255	50	mm	Loosely woven fabric with stitches may cause the light barrier to wrongly detect a signal. To prevent this from happening, you enter the number of filter stitches. This number represents the minimum number of stitches with signal detection following the 1 st detection of the signal.
	Material thickness detection						To achieve consistently good sewing results for different material thicknesses, some parameters can be adjusted specifically to the material thickness.
O 27 00	Material thickness detection		0	1	0	-	Material thickness detection 0 = Off 1 = On
O 27 02	Material thickness		0	1	0	-	Display of measured material thickness below sewing feet
	Sewing foot stroke regulated by material thickness			•			Setting the adjustment in sewing foot stroke depending on material thickness
O 27 10	Mode sewing foot stroke regulated by material thickness	Ĺ,	Off	2. On	Off	-	The material thickness can be identified in various modes and responded to depending on the setting. The following modes can be selected for the sewing foot stroke: - Off - Linear - 2 nd value On/Of - 2 nd value On

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 27 11	Max. Sewing foot stroke		0.0	9.0	7.0	mm	Maximum sewing foot stroke reached at the upper material thickness limit.
O 27 12	Min. Material thickness	D min I	0.0	10.0	3.0	mm	Material thickness at which the increase in sewing foot stroke should start.
O 27 13	Max. Material thickness		0.0	10.0	6.0	mm	Material thickness up to which the increase in sewing foot stroke should occur.
	Stitch length regulated by material thickness	$\frac{\frac{1}{2}}{\frac{1}{2}}$					Setting the adjustment in stitch length depending on material thickness
O 27 20	Mode stitch length regulated by material thickness	ĹĹ,	Off	2. On	Off	-	The material thickness can be identified in various modes and responded to depending on the setting. The following modes can be selected for the stitch length: - Off - Linear - 2 nd value On/Of - 2 nd value On
O 27 21	Stitch length correction factor (%)	± +/- ↑ %	-50	50	-10	%	Maximum stitch length variation reached at the upper material thickness limit.
O 27 22	Min. Material thickness		0.0	10.0	3.0	mm	Material thickness at which the adaption in stitch length should start.
O 27 23	Max. Material thickness		0.0	10.0	6.0	mm	Material thickness up to which the adaption in stitch length should occur.

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Needle thread tension regulated by material thickness)(← F +/- √					Setting the adjustment in needle thread tension depending on material thickness
O 27 30	Mode needle thread tension regulated by material thickness	Ľ,	Off	2. On	Off	-	The material thickness can be identified in various modes and responded to depending on the setting. The following modes can be selected for the needle thread tension: - Off - Linear - 2 nd value On/Of - 2 nd value On
O 27 31	Max. needle thread tension)(←F max	0	99	50	%	Maximum needle thread tension reached at the upper material thickness limit.
O 27 32	Min. Material thickness	D min	00.0	10.0	3.0	mm	Material thickness at which the adaption in needle thread tension should start.
O 27 33	Max. Material thickness	Max	00.0	10.0	6.0	mm	Material thickness up to which the adaption in needle thread tension should occur.
	Needle thread tension regulated by material thickness (left)	F+)[)[+F +/- ✔					Setting the adjustment in needle thread tension depending on material thickness (left)
O 27 40	Mode needle thread tension regulated by material thickness (left)	Ľ,	Off	2. On	Off	-	The material thickness can be identified in various modes and responded to depending on the setting. The following modes can be selected for the needle thread tension (L): - Off - Linear - 2 nd value On/Of - 2 nd value On

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 27 41	Max. needle thread tension (left)	F+)()(+F max	0	99	50	%	Maximum needle thread tension (left) reached at the upper material thickness limit.
O 27 42	Min. Material thickness	D min ^I	0.0	10.0	3.0	mm	Material thickness at which the adaption in needle thread tension (L) should start.
O 27 43	Max. Material thickness	Max	0.0	10.0	6.0	mm	Material thickness up to which the adaption in needle thread tension (L) should occur.
	Sewing foot pressure regulated by material thickness	↓ F L					Setting the adjustment in sewing foot pressure depending on material thickness
O 27 50	Mode sewing foot pressure regulated by material thickness		Off	Linear	Off	-	The material thickness can be identified in various modes and responded to depending on the setting. The following modes can be selected for the sewing foot pressure: - Off - Linear
O 27 51	Max. sewing foot pressure	L F max	0	20	15	-	Maximum sewing foot pressure reached at the upper material thickness limit.
O 27 52	Min. Material thickness	D min	0.0	10.0	3.0	mm	Material thickness at which the adaption in sewing foot pressure should start.
O 27 53	Max. Material thickness		0.0	10.0	6.0	mm	Max. Material thickness up to which the adaption in sewing foot pressure should occur.

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Speed regulated by material thickness	€D +/- ✓					Setting the adjustment in speed depending on material thickness
O 27 60	Mode speed regulated by material thickness		Off	Linear	Off	-	The material thickness can be identified in various modes and responded to depending on the setting. The following modes can be selected for the speed: - Off - Linear
O 27 61	Max. Speed	€D +/- ↓ max	0	4000	1500	-	Maximum speed reached at the upper material thickness limit.
O 27 62	Min. Material thickness	D min	0.0	10.0	3.0	mm	Material thickness at which the adaption in speed should start.
O 27 63	Max. Material thickness	max	0.0	10.0	6.0	mm	Material thickness up to which the adaption in speed should occur.
	Speed correction	€ +/- ✓					Some parameters are affected by high speeds because of the resulting physical effects. To counteract these effects and to achieve consistent results, even at high speeds, adjustment factors can be set depending on the speed.
O 28 00	Speed regulated correction	€ +/- ✓	0	1	0	-	Speed regulated correction 0 = Off 1 = On
	Speed regulated stitch length correction	$\frac{\frac{1}{1+\frac{1}{2}}}{\frac{1}{2}}$					Setting the speed regulated stitch length correction

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 28 20	Mode speed regulated stitch length correction	ĹŹ,	Off	2. On	Off	-	The correction of the effects of high speeds can be identified in various modes and responded to depending on the setting. The following modes can be selected for the stitch length correction: - Off - Linear - 2 nd value On/Of - 2 nd value On
O 28 21	Stitch length correction factor (%)	± +/- ↑ %	-50	50	-10	%	Maximum stitch length variation (%) reached at the upper speed limit.
O 28 22	Min. Speed	min	0	4000	1000	rpm	Speed at which the increase/reduction of stitch length should start.
O 28 23	Max. Speed	n ax	0	4000	3000	rpm	Speed up to which the increase/reduction of stitch length should occur.
	Speed regulated thread tension correction)(←F +/- √				·	Setting the speed regulated thread tension correction
O 28 30	Mode speed regulated thread tension correction	ĬŹ,	Off	2. On	Off	-	The correction of the effects of high speeds can be identified in various modes and responded to depending on the setting. The following modes can be selected for the needle thread tension correction: - Off - Linear - 2 nd value On/Of - 2 nd value On
O 28 31	Max. needle thread tension)(←F max	0	99	50	%	Maximum needle thread tension reached at the upper speed limit.

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No.	Parameter	Icon	Min	Max	Preset value	Unit	Description
O 28 32	Min. Speed	min	0	4000	1000	rpm	Speed at which the increase in needle thread tension should start.
O 28 33	Max. Speed	max	0	4000	3000	rpm	Speed up to which the increase in needle thread tension should occur.
	Speed regulated thread tension correction (left)	F+)()(+F					Setting the speed regulated thread tension correction for the left needle thread
O 28 40	Mode speed regulated thread tension correction	ĹŹ,	Off	2. On	Off	-	The correction of the effects of high speeds can be identified in various modes and responded to depending on the setting. The following modes can be selected for the needle thread tension correction (L): - Off - Linear - 2 nd value On/Of - 2 nd value On
O 28 41	Max. needle thread tension (left)	F+)()(+F max	0	99	50	%	Maximum needle thread tension left reached at the upper speed limit.
O 28 42	Min. Speed	min	0	4000	1000	rpm	Speed at which the increase in left needle thread tension should start.
O 28 43	Max. Speed	max	0	4000	3000	rpm	Speed up to which the increase in left needle thread tension should occur.
	Speed regulated correction of the sewing foot pressure	↓ F ⑦ /- ✓					Setting the speed regulated correction of the sewing foot pressure

No.	Parameter	lcon	Min	Мах	Preset value	Unit	Description
O 28 50	Mode Speed regulated correction of the sewing foot pressure		Off	Linear	Off	-	The correction of the effects of high speeds can be identified in various modes and responded to depending on the setting. The following modes can be selected for the sewing foot pressure: - Off - Linear
O 28 51	Max. sewing foot pressure	F max	0	20	15	-	Maximum sewing foot pressure reached at the upper speed limit.
O 28 52	Min. Speed	min	0	4000	1000	rpm	Speed at which the adaption in sewing foot pressure should start.
O 28 53	Max. Speed	max max	0	4000	1000	rpm	Speed up to which the adaption in sewing foot pressure should occur.
	Additional values (+)	$ \int \left(- F \right)^{\frac{1}{2}} \left$		·			Setting the additional values (second value) for stitch length, sewing foot stroke and needle thread tension
O 30 02	Additional value stitch length (+)		0.0	6.0	4.5	mm	Second value for the stitch length. This value can be activated with a button/switch
	Motor-driven edge guide					•	Setting the motor-driven edge guide
O 32 01	Gap		8.0	45.0	10.0	mm	Gap of the motor-driven edge guide to the needle considering to the defined safety clearance to the sewing feet

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 32 02	Gap (2 nd value)		8.0	45.0	10.0	mm	Gap (second value) of the motor-driven edge guide to the needle considering to the defined safety clearance to the sewing feet
O 32 11	Edge Guide Height		0.1	12.0	12.0	mm	Height of the motor-driven edge guide in relation to the throat plate
O 32 12	Edge Guide Height (2 nd value)		0.1	12.0	12.0	mm	Height (2 nd value) of the motor-driven edge guide in relation to the throat plate
	Outputs						This parameter provides virtual outputs that can be assigned customer-specific functions. They can be used when customer-specific applications require a signal from the control of the machine. These parameters cannot be used unless the virtual outputs have been assigned to a physical output at the Technician level.
O 59 01	O 01		0	1	0	-	Output 1 0 = Off 1 = On
O 59 02	O 02		0	1	0	-	Output 2 0 = Off 1 = On
O 59 03	O 03		0	1	0	-	Output 3 0 = Off 1 = On
O 59 04	O 04		0	1	0	-	Output 4 0 = Off 1 = On
O 59 05	O 05		0	1	0	-	Output 5 0 = Off 1 = On
O 59 06	O 06		0	1	0	-	Output 6 0 = Off 1 = On

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
O 59 07	O 07		0	1	0	-	Output 7 0 = Off 1 = On
O 59 08	O 08		0	1	0	-	Output 8 0 = Off 1 = On
O 59 09	O 09		0	1	0	-	Output 9 0 = Off 1 = On
O 59 10	O 10		0	1	0	-	Output 10 0 = Off 1 = On
O 59 11	O 11		0	1	0	-	Output 11 0 = Off 1 = On
O 59 12	0 12		0	1	0	-	Output 12 0 = Off 1 = On
O 59 13	O 13		0	1	0	-	Output 13 0 = Off 1 = On
O 59 14	O 14		0	1	0	-	Output 14 0 = Off 1 = On
O 59 15	O 15		0	1	0	-	Output 15 0 = Off 1 = On
O 59 16	O 16		0	1	0	-	Output 16 0 = Off 1 = On

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3.2 Technician level

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Machine configuration	¢¢					Settings of the machine configuration
T 01 00	Thread Clamp Mode	MODE 0-10	0	10	6	-	Mode of thread clamp
		MODE 0					0 = TC switch-on angle = T 01 01, TC switch-off angle = T 01 02, Without FL;
		MODE 1					1 = TC switch-on angle = 213°, TC switch-off angle = 13°, Without FL;
		MODE 2					2 = TC switch-on angle = 154°, TC switch-off angle = 225°, Without FL;
		MODE 3					3 = TC switch-on angle = 154°, TC switch-off angle = 295°, Without FL;
		MODE 4					4 = TC switch-on angle = 213°, TC switch-off angle = 13°, FL switch-on angle = 213°, FL switch-off angle = 259°;

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
		MODE 5					5 = TC switch-on angle = 213°, TC switch-off angle = 13°, FL switch-on angle = 149°, FL switch-off angle = 259°;
		MODE 6					6 = TC switch-on angle = 180°, TC switch-off angle = 320°, FL switch-on angle = 165°, FL switch-off angle = 225°, FL switch-off angle, additionally stroke-dependent;
		MODE 7					7 = Without TC, FL switch-on angle = T 01 11, FL switch-off angle = T 01 12,
		MODE 8					8 = TC switch-on angle = T 01 01, TC switch-off angle = T 01 02, FL switch-on angle = T 01 11, FL switch-off angle = T 01 12;
		MODE 9					9 = Without TC, FL switch-on angle = T 01 11, FL switch-off angle = 5.2.2.3.2, FL switch-off angle, additionally stroke-dependent;
		MODE 10					10 = TC switch-on angle = T 01 01, TC switch-off angle = T 01 02, FL switch-on angle = T 01 11, FL switch-off angle = T 01 12, FL switch-off angle, additionally stroke-dependent

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 00 47	Max. Speed	max	0	4000	0	rpm	Speed limit in manual bartack 0 = Off
	Thread clamp angle						Position for activating and deactivating the thread clamp.
T 01 01	On		0	359	180	0	Position for activating the thread clamp.
T 01 02	Off		0	359	320	0	Position for deactivating the thread clamp.
	Needle thread clamp)[←					Settings of the needle thread clamp
T 01 03	Needle thread clamp)[←	0	1	1	-	Needle thread clamp 0 = Off; 1 = On
T 01 04	Material thickness compensation		0	1	1	-	Compensation of the material thickness 0 = Off; 1 = On
	Sewing foot angle						Position for lifting/lowering the sewing feet in order to release a thread jammed underneath.
T 01 11	On		0	359	165	0	Position for lifting the sewing feet in order to release a thread jammed underneath.

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 01 12	Off		0	359	260	0	Position for lowering the sewing feet in order to release a thread jammed underneath.
T 01 13	Height		1.0	12.0	10.0	-	Lifting height of the sewing feet
T 01 14	PrePressure	↓ F L	0	20	1	-	Reduced value for the sewing foot pressure during the clamping cycle (0 = off)
T 01 15	PreStroke	L ^{II}	0	9.0	1	-	Reduced value for the sewing foot stroke during the clamping cycle (0 = off)
T 01 20	Option		0	3	0	-	Mode of thread clamp 0 – at seam begin only 1 – at seam begin and during reversal 2 – at seam begin and during sewing foot lift 3 – at seam begin and during reversal and sewing foot lift
T 01 30	On		0	1	0	-	Thread clamp On/Off for NSB 0 = Off; 1 = On
T 01 31	Time delay		0	1000	40	ms	Delay for switch on the NSB after thread trimming.
T 01 32	Off		0	359	49	o	Position to switch off the knife in first stitch.
No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
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T 01 34	Off		0	359	52	o	Position for switching off the knife clamp during the second stitch.
	Exhaust	¶→M					Exhaust removal of the cut-off remaining threads
T 01 35	On		0	359	167	o	Position for the start of exhaust removal
T 01 36	Off	€ ↓	0	99999	500	ms	Duration of exhaust removal
	PWM configuration thread clamp						Pulse width modulation Power supply to the magnet for the thread clamp
T 01 50	Time (t1)		0	1000	200	ms	t1 [ms] Activation duration of thread clamp in time period t1.
T 01 51	Duty cycle (t1 %)		0	100	100	%	Duty cycle t1 [%] Duty cycle in time period t1
T 01 52	Time (t2)	€t2	0	600	60	ms	t2 [s] Activation duration of the thread cutter in time period t2.
T 01 53	Duty cycle (t2)	€t2	0	100	30	%	Duty cycle t2 [%] Duty cycle in time period t2

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 01 54	Boost		0	1	0	-	Voltage overshoot when the thread cutter is activated 0= No 1= Yes
T 02 00	Speed		50	250	150	rpm	Speed of the machine during thread cutting.
	Thread cutter						Setting the thread cutter
T 02 03	Thread trimmer		0	1	1	-	Thread cutting 0 = Off; 1 = On
T 02 04	Thread cutting Backward stitch		0	1	2	-	Thread cutting during backward stitch. 0 = Off; 1 = On
T 02 10	Start thread trim		0	359	125	0	Position when the magnet of the thread cutter is activated.
T 02 11	Stop thread trim		0	359	20	o	Position when the magnet of the thread cutter is deactivated.
	Change of stitch length						Change of the stitch length during the thread cutting process. A shorter stitch length will reduce the distance from the feed dog to the counter blade, resulting in a shorter thread. A greater stitch length will lead to a longer thread.

Parameter

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 02 20	Change of stitch length		0	1		-	Adjustments for stitch length 0 = Off; 1 = On
T 02 21	Stitch length value		1	10	1	-	Optimization of the remaining thread length for the cutting systems (Short thread cutter, KFA = 1, extra short; Long thread cutter, LFA = 10, extra long)
T 02 22	On	ON ON	0	359	180	0	Position when the change of stitch length is activated.
T 02 23	Off	OFF	0	359	60	0	Position when the change of stitch length is deactivated.
	PWM Configuration thread trimmer						Pulse width modulation Power supply to the magnet for the thread cutter.
T 02 50	Time (t1)		0	1000	500	ms	t1 [ms] Activation duration of the thread cutter in time period t1.
T 02 51	Duty cycle (t1)		0	100	100	%	Duty cycle t1 [%] Duty cycle in time period t1
T 02 52	Time (t2)	€t2	0	600	20	ms	t2 [s] Activation duration of the thread cutter in time period t2.
T 02 53	Duty cycle (t2)		0	100	40	%	Duty cycle t2 [%] Duty cycle in time period t2

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 02 54	Boost		0	1	0	-	Voltage overshoot when the thread cutter is activated 0 = Off; 1 = On
	Sewing foot lift						Settings of the sewing foot lift
T 03 01	Max. sewing foot lift	L max	1.0	20.0	20.0	mm	Maximum lift height that the system may lift the sewing feet. (Value range with standard thread cutter 01.0 - 20.0 [mm]) (Value range for short thread cutter 01.0 - 18.0 [mm] due to raised throat plate)
T 03 02	Step motor speed	M 🕕	1	60	20	-	Speed at which the sewing feet will be lifted.
	Threading mode			1		1	Adjust parameter of the threading mode
T 03 03	Position sewing foot	が <u>し</u> が少し	Down	Pedal	Down	-	Down = The sewing foot is lowered in threading mode. Up = The sewing foot is lifted in threading mode. Pedal = The sewing foot can be lifted or lowered with the pedal in threading mode.
T 05 00	Soft start speed	→→→	10	1000	500	rpm	Speed for the soft start.
T 05 01	Number of soft start stitches		0	10	1	Stitches	Number of stitches to be made during a soft start.

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	RTM / BRM / EC						Settings for remaining thread monitor, bobbin rotation monitor and enlacement check
T 06 00	Remaining thread monitor	∽≖∷∎	0	1	0	-	Activation of the bobbin rotation monitor 0 = PCB 9850 867003 1 = CAN version (right bobbin)
T 06 05	Repeat Message after trim						The error message displayed in the seam is repeated after thread cutting. 0 = Off; 1 = On
T 06 06	Acknowledge error during sewing stop		0	1	0	-	The sewing process cannot be resumed until the error is acknowledged on the control panel during the sewing stop. 0 = Off; 1 = On
T 06 10	Enlacement check		0	1	0	-	Enlacement check 0 = Off; 1 = On
	Bobbin Rotation Monitor						Adjust parameter of the Bobbin Rotation Monitor
T 06 11	Bobbin Rotation Monitor	€ ~⊒∷∎~	0	1	0	-	Bobbin Rotation Monitor 0 = Off; 1 = On
T 06 12	Number of stitches		0	255	11	Stitches	Delayed stitches before the bobbin rotation monitor starts. The machine calculates the number of stitches automatically depending on the value entered.

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 07 00	Pedal Abort		0	1	1	-	Abort a program by pressing the pedal in Position -2 twice. 0 = Off; 1 = On
T 07 02	Forward Sound		0	1	1	-	Acoustic signal at segment switch 0 = Off; 1 = On
T 07 04	Thread trimmer	×	0	1	1	-	The thread cutter becomes active or remains inactive when a seam section is canceled. 0 = Off; 1 = On
	Program abort	×		•			Settings for a program abort
T 07 05	Mode at program abort		0	1	1	-	Mode at program abort Position = After the cancellation, the needle is merely brought to its end position and the thread is cut (if activated). Seg.End = Ending of the program with all configurations that are set for this seam section.
T 07 06	Segment switch by pedal	-2	0	1	1	-	A switch between two seam sections is usually carried out with the ► button. This function can also be assigned to Position -2 on the pedal. 0 = Off; 1 = On
	Stitch function	<u>+n</u>			1	•	The machine counts the stitches when a program is processed with the pedal. If the user sews half stitches or full stitches manually, they can also be counted, if required. To do so, this function must be active. The electronic handwheel is not affected by this setting.

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 07 07	Count stitches	<u>+n</u>	0	1	1	-	Count stitches 0 = Off; 1 = On
T 07 08	Correction of backward stitches	<i>11</i> +/- √	0	1	1	-	Backward stitches carried out manually are corrected with regard to the necessary forward stitches during the stitch count 0 = Off; 1 = On
	Mode segment size	⊨∔ ⊶∔ mm/e⊸n					Settings of the seam segment mode
T 07 10	Segment length	<mark>⊨ → ↓</mark> mm/e → n	Length	Number of stitches	Number of stitches	-	Length = Seam sections are measured via the length specification (in mm) Number of stitches = Seam sections are measured via the stitch count.
	Program default values	P					Customer-specific settings can be made here, which are automatically used as preset values for the first seam section during the creation of a new program.
T 07 20	Stitch length default		0.0	6.0	4.5	mm	Stitch length used as default value in programming mode
T 07 22	Sewing foot pressure default	DEFAULT	1	20	5	-	Sewing foot pressure used as default value in programming mode
T 07 23	Needle thread tension default)(← F DEFAULT	1	99	20	%	Needle thread tension used as default value in programming mode

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 07 24	Needle thread tension (left)	F+)()(+F DEFAULT	1	99	20	%	Needle thread tension (left) used as default value in programming mode
T 07 28	Sewing foot stroke		0.5	9.0	2.0	-	Sewing foot stroke used as default value in programming mode
T 07 30	Bartack at seam begin	1	0	1	0	-	Setting as to whether the bartack at seam begin is automatically activated in a new program. The values for the bartack at seam begin are taken from the Manual mode. 0 = Off; 1 = On
T 07 31	Bartack at seam end	1	0	1	0	-	Setting as to whether the bartack at seam end is automatically activated in a new program. The values for the bartack at seam end are taken from the Manual mode. 0 = Off; 1 = On
T 07 32	Thread trimmer	M.	0	1	1	-	Setting as to whether the thread cutter is automatically activated in a new program. 0 = Off; 1 = On
T 07 40	Counter Mode	Σ↓↑ 0000	Off	High	Off	-	Daily piece counter, can be set to count either up or down. When the daily piece counter is activated, it must be reset once after entering a value to ensure it counts correctly.
T 07 41	Reset	Σ:0000	-999	999	0	-	Value to which the daily piece counter is set when a reset is performed.

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Sewing speed						Adjustment parameter of the sewing speed
T 08 00	Max. Speed	max	500	3800	3000	rpm	Maximum permissible speed; it can no longer be exceeded on the operator level. (Value range varies depending on the subclass)
T 08 01	Min. Speed	min	50	400	150	rpm	Minimum speed at which an individual stitch is made; a lower speed is no longer possible at operator level.
T 08 02	Position speed		10	700	150	rpm	Position speed; the last stitch is made slower during stopping of the sewing procedure.
T 08 03	Acceleration	@ 	1	40	30	rpm/ms	Slope of the acceleration ramp
T 08 04	Deceleration	ا	1	40	30	rpm/ms	Slope of the deceleration ramp
	Holding Force	F					Setting the holding force of the motor
T 08 06	Holding Force Mode	F (E)	Off	Hold Pos	On	-	Off = Holding force inactive On = Holding force active Hold Pos. = Position control; position is checked and resets itself
T 08 07	Max. Current	F	0	50	25	-	Holding current of the motor

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 08 08	Response	له ۲	0	100	30	-	Response time for the continuous current
T 08 12	Lower needle position	zŲ ZZZ	0	359	120	o	Lower needle position at a sewing stop during the seam.
T 08 13	Needle position after trim		0	359	120	0	Needle position after thread cutting before reversal.
T 08 15	Threading position		0	359	60	0	Needle position for the proper function of the threader, e.g. with thread lever at top dead center.
T 08 16	Needle up position		0	359	30	0	Holding position of the needle outside of the material.
T 08 20	Pedal		-	-	-	-	Calibration of the pedal
T 08 21	Pedal steps		0	64	24	-	Number of speed steps processed by the pedal.
T 08 22	Speed curve pedal		0	7	0	-	Speed curve of the pedal. Number of speed levels from 0 to 7.
T 08 23	t Position -1	-10	0	255	50	ms	Debouncing of position -1

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 08 24	t Position -2	-2 (b)	0	255	15	ms	Debouncing of position -2
T 08 25	Pedal Type		DA Analog	Digital	DA Analog	-	DA Analog/Digital Choice between an analog and digital pedal.
T 08 26	Inverted		0	1	1	-	Inversion of the signals given by the pedal (possibly necessary for digital setpoint devices). 0 = Off; 1 = On
T 08 40	DB3000		150	9999	3000	rpm	Speed limit
T 08 41	DB2000		150	9999	2000	rpm	Speed limit
T 08 44	t Position 0	0 ()	0	255	10	ms	Debouncing of position 0
	Needle thread tension)(• F					Adjust parameter of the needle thread tension during active sewing foot lift.
T 09 00	Mode needle thread tension at sewing foot lift	HODE	0	3	0	-	Mode for lifting the needle thread tension during active sewing foot lift. 0 = Needle thread tension is not lifted 1 = The needle thread tension is lifted as the sewing feet are lifted during sewing 2 = The needle thread tension is lifted after thread cutting 3 = The needle thread tension is lifted as the sewing feet are lifted during sewing and after thread cutting

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 09 01	Pre-tension)(+F%	0	99	0	%	Setting of the pretension during thread cutting. A value of 0 is recommended as the pretension is generated by a mechanical tension.
T 09 02	Delay time	•)[• <mark>)</mark> [•	0.1	7.5	5.0	S	The needle thread tension remains closed for a defined period of time after thread cutting and prevents the needle thread from being pulled further when the sewing material is removed. Without a thread cutter, this menu item should be set to a very low value.
	Sewing foot stroke						Adjust parameter of the sewing foot stroke during active 2 nd thread tension
T 09 03	Additional thread tension	۶+)(⊕)(+۶ Lੂ <u>स</u> ⊕	0	1	0	-	If the second sewing foot stroke is switched on, the second needle thread tension is automatically activated (except in the case of material thickness detection). 0 = Off; 1 = On
T 09 10	Open thread tension		0	359	340	o	Needle position at which the needle thread tension switches to the value for thread cutting.
T 09 11	Close thread tension	÷÷ ∲∕)(←F	0	359	71	o	Position at which the standard needle thread tension is used again after thread cutting.
T 09 12	Needle thread tension thread trim	_\)(←F	0	50	0	%	Needle thread tension during thread cutting.
T 09 13	Needle thread tension thread trim (left)	F+)()(+F	0	5	0	%	Needle thread tension during thread cutting (left)

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 09 21	t needle thread tension thread trim)(←F DEFAULT	0	200	20	ms	Delay, showing how long it takes until the standard needle thread tension is used again.
	Speed limitation sewing foot stroke						Adjust parameter of the speed limitation in relation to the sewing foot stroke
T 10 01	Speed		0	4000	1800	rpm	As from the set value of the sewing foot stroke (Min. Stroke), the speed is reduced down to the desired value of the sewing foot stroke (Max. Stroke). (Value range, depending on subclass)
T 10 02	Min. Sewing foot stroke		0	9.0	3.0	Stroke	Sewing foot stroke at which the speed reduction is initiated.
T 10 03	Max. Sewing foot stroke		0	9.0	7.0	Stroke	Sewing foot stroke at which the reduced speed is reached.
T 10 08	Number of stitches 2. stroke off		0	255	0	Stitches	Number of stitches after which the second sewing foot stroke is automatically deactivated.
	Automatic stroke shift						Automatic stroke shift in relation to the sewing speed
T 10 10	Speed level,		0	4000	0	rpm	Speed at which the second sewing foot stroke height is automatically activated. (Value range, depending on subclass)

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 10 11	Quick stroke adjustment in tack		0	1	0	-	 2. sewing foot stroke height is automatically activated, even in bartack. 0 = Off; 1 = On
T 12 00	Turn back		0	1	1	-	Reversal after cutting the thread is active or inactive. 0 = Off; 1 = On
T 12 01	Needle position after turn back		0	359	30	0	Position of the needle after thread cutting (reversal position); the needle is set upward to reach the full lifting height, and the thread lever is then no longer at top dead center.
	Needle cooling	¢≋⊑					Adjust parameter of the needle cooling
T 13 00	Mode needle cooling	¢≋⊏	On	Edge cutter	Off	-	Off = Needle cooling is deactivated. On = Needle cooling is activated. At speed = Activation of the needle cooling starting at a specific speed Edge cutter = Needle cooling is activated when the edge cutter is also activated.
T 13 01	Needle cooling t Delay	U≋⊑	0.0	10.0	2.5	ms	Lag time, after which the needle cooling is deactivated.
T 13 02	Cool Speed	U≋⊑	0	6000	2000	rpm	Speed at which the needle cooling is activated.
	Seam Center Guide						Adjust parameter of the seam center guide

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 14 00	Auto modes for seam center guide		Off	Tack + Lift	Off	-	Mode for automatic raising of the seam center guide. Off = Raising of the seam center guide is deactivated; it is not raised automatically. During bartacking = Raising of the seam center guide when sewing the bartack. During lifting = 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.
T 14 01	Raise seam center guide on quick stroke adjustment		0	1	0	-	When the second stroke height is activated, the seam center guide is automatically raised. 0 = Off; 1 = On
	Puller	0 0					Adjust parameter of puller feeding
T 14 02	Puller	0 0	0	1	0	-	Puller
T 14 03	Auto modes for the upper puller		Off	Tack + Lift	Off	-	Mode for raising the puller automatically. Off = Raising of the puller is deactivated; it is not raised automatically. During lifting = Raising of the puller when lifting the sewing foot. During bartacking = Raising of the puller when sewing the bartack. Tack + Lift = Raising of the puller when sewing the bartack and lifting the sewing foot.
T 14 04	Raise on quick stroke adjustment		0	1	0	-	When the second stroke height is activated, the puller is automatically raised. 0 = Off; 1 = On

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 14 05	Delay	⊙ ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	0	999.9	115.0	mm	Lowering of the roller after seam begin; depends on stitch length and application.
T 14 06	Seam Center Guide		0	1	0	-	Seam Center Guide 0 = Off; 1 = On
T 14 10	Mode Rollers	0	Mecha nic	Top+Bot	Top+Bot	-	Setting defining which puller roller is supposed to run. Mechanic = Both rollers freewheel passively; mechanical coupling only Top+Bot = Both wheels run actively under power Top = The upper roller runs actively under power
T 14 11	Feeding method	© ⊙	0	1	0	-	Transport mode of the rollers continuous = even transport intermittent = transport adapted to the rhythm of the machine's feed dog
T 14 12	Start	01-0 01	0	359	135	0	Setting of the start and stop angle for the intermittent puller. Start/Stop has been adapted to the machine. The values should not be changed.
T 14 13	Stop	0)= 0 777777 07	0	359	155	•	Setting of the start and stop angle for the intermittent puller. Start/Stop has been adapted to the machine. The values should not be changed.
T 14 14	Pressure	o €	Yes	No	Yes	-	Set the puller pressure Yes = Pressure is supplied constantly and regulated via the gage at the puller. HPNo = Pressure is generated actively except for the 2^{nd} stroke height. No = No active pressure from puller.

No.	Parameter	Icon	Min	Max	Preset value	Unit	Description
T 14 15	Switch off		0	1	0	-	Puller is not active when the sewing motor is stopped. Holding force of the roller is off; sewing material can be pulled out from between the rollers. 0 = Off; 1 = On
T 14 16	Always on		0	1	0	-	Puller is always on even when raised. 0 = Off; 1 = On
	Upper puller roller					•	Settings of the upper puller roller
T 14 20	Transmission, upper puller roller	<u>0:0</u>	0	65.0	1.0	-	Transmission, puller
T 14 22	Current feed (active)		0	5.0	3.5	A	Motor current, puller
T 14 23	Current feed (passive)		0	5.0	1.0	A	No-damage current, puller
T 14 24	Diameter, upper roller	⊘ mm ↓ 2777772 ⊘	0	9999	50	mm	Diameter, roller
T 14 25	Direction		0	1	0	-	Rotational direction, roller 0 = right 1 = left

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 14 26	Closed Loop	0 0	0	1	1	-	0 = non-regulated (controlled operation) 1 = regulated
	Lower puller roller						Settings of the lower puller roller
T 14 30	Transmission, lower roller	⊘ :⊙	0	65.0	1.0	-	Transmission, puller
T 14 32	Current feed (active)		0	5.0	3.5	A	Motor current, puller
T 14 33	Current feed (passive)		0	5.0	1.0	A	No-damage current, puller
T 14 34	Diameter, lower roller	0 mm 7777777 0	0	9999	49	mm	Diameter, roller
T 14 35	Direction	0 ///// 0	0	1	1	-	Rotational direction, roller 0 = right 1 = left
T 14 36	Closed Loop	0 0	0	1	1	-	0 = non-regulated (controlled operation) 1 = regulated
	Light barrier			•	•	1	Adjust parameter of the light barrier

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 16 00	Speed		10	2000	1000	rpm	The last stitches after the detection of the end of the material (approx. 50 mm) can be sewn at a defined speed.
T 16 01	Light barrier		0	1	0	-	Light barrier 0 = Off; 1 = On
T 16 02	Pedal start		0	1	0	-	Free = Pedal start On = Pedal can be pressed and the machine sews as soon as the material breaks the light barrier Off = Pedal is pressed but the machine does not start sewing; must be started from neutral position
T 16 04	Sense		0	1	0	-	Dark = The signal is given when the light barrier is broken. Bright = The signal is given when the light barrier is complete.
T 16 05	Automatic		0	1	0	-	This setting is relevant only if the material end detection is activated on the Operator level. On = The pedal starts a program, which runs automatically. Off = The pedal starts a program; the user determines the speed through the end of the program.
T 17 00	Jog-Dial		0	1	1	-	Jog-Dial 0 = Off; 1 = On
	Material thickness detection				•		Settings of the material thickness detection
T 27 00	Material thickness detection		0	1	1	-	Material thickness detection 0 = Off; 1 = On

Parameter

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 27 01	Hysterese	↓ +/- √ 	0.0	2.0	0.2	mm	Tolerance at which the material thickness detection based on the second stitch length, the second needle thread tension and/or the second sewing foot stroke switches back. This tolerance is designed to ensure that there is no constant alternating between activation and deactivation in the boundary range.
T 27 02	Pressure compensation	Ì F %	0	1	0	-	With extremely thick material, the foot pressure increases above the standard set value due to the material thickness. To a certain extent, the machine can compensate itself for the influence of thick material. 0 = Off; 1 = On
T 28 01	Hysterese	€1 +/- √	0	2000	100	rpm	Tolerance at which the correction of the effects of high speed based on the second stitch length, the second needle thread tension and/or the second sewing foot stroke switches back. This tolerance is designed to ensure that there is no constant alternating between activation and deactivation in the boundary range.
	Stitch length						Adjust parameter of the stitch length
T 30 10	Max. stitch length		2.0	12.0	6.0	mm	Maximum stitch length possible during sewing; this will vary depending on the sewing equipment and MUST be adjusted when changing the sewing equipment. When the value is changed, the machine requests a reset, i.e. switching off and on again. (Value range depending on subclass)
T 30 11	Manual stitch length adjust- ment	AL .	0	1	1	-	Stitch adjustment lever for manual adjustment of the stitch length active or inactive; optional equipment. 0 = Off; 1 = On



No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Speed limitation stitch length						Adjust parameter of the speed limitation in relation to the stitch length
T 30 12	Speed in relation to stitch length		0	4000	3000	rpm	Value for limiting the speed as from a defined, adjustable stitch length. (Value range depending on subclass)
T 30 13	Speed limitation stitch length		2.0	12.0	6.0	mm	The speed is limited during sewing as from the set stitch length value. (Value range depending on subclass)
	Short stitches	ł					Adjust parameters of short stitches
T 31 00	Number of short stitches at seam begin	ł	0	99	0	Stitches	Number of short stitches at seam begin; advisable for neat starts to sewing.
T 31 01	Number of short stitches at seam end	ł	0	99	0	Stitches	Number of short stitches at seam end to ensure that the length difference between the needle thread and the hook thread is (visually) as small as possible.
T 31 10	Stitch length of short stitches		-12.0	12.0	1.5	-	Stitch length of the short stitches (generally between 1.0 - 1.5 mm)
	Edge guide						Adjust Parameter of the edge guide
T 32 00	Edge Guide		0	1	0	-	Edge guide 0 = Off; 1 = On

Parameter

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 32 01	Edge Guide Speed		5000	60000	25000	Hz	Travel speed of the edge guide.
T 32 02	Min. Edge Guide Position	Umin 1	1.0	36.0	8.0	mm	Smallest possible gap between the sewing foot and the edge guide. This will vary depending on the sewing equipment and MUST be adjusted when changing the sewing equipment. CAUTION The entered value is the gap measured between the NEEDLE and the edge guide.
T 32 03	Edge Guide Motor		0	1	1	-	0 = pneumatic 1 = step motor
T 32 11	Speed (height)		5000	60000	2500	Hz	Travel speed of the edge guide for the height
T 32 12	Min. height		0.1	12.0	1.0	mm	Smallest possible distance between throat plate and edge ruler / roller.
T 32 20	Mode		0	2	0	-	Mode edge guide 0 = 1-Axis Int (Internal Card) 1 = 1-Axis Ext (External Card) 2 = 2-Axes Ext (External Card)
	Operation lock	₩¥					Settings associated with the Service Stop button
T 50 03	Operation lock mode (Service Stop)		0	1	0	-	Sewing foot position during the operation lock 0 = Sewing feet remain fixed in position 1 = Sewing feet can be moved depending on the pedal position

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 50 04	Function button Manual bartack		0	1	1	-	Function button active during the operation lock 0 = On 1 = Off
T 50 05	All inputs		0	1	0	-	All inputs active during machine blockage 0 = Off 1 = On
T 51 02	Language		-	-	EN	-	Language selection
	QONDAC	Q					Machines can be interlinked to allow for networked operation. Various settings can be made for the networking of the machines.
T 51 08	QONDAC	Q	0	1	1	-	QONDAC 0 = On 1 = Off
T 51 09	Customer ID	Ø₽	-	-	-	-	Editor that lets you set the customer ID
T 51 10	QONDAC		-	-	-	-	Adjustment of the Ethernet configuration
T 51 12	Language	$\mathbf{\mathbf{S}}$	-	-	EN	-	Language selection

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Lock	•					The access to certain functions and areas can be restricted for the user.
T 51 17	Password		0	99999	0	-	Set your own access password for the Technician level. 00000 corresponds to the password preset by Dürkopp Adler. Do not lose the new password!
T 51 18	Кеу		0	2	0	-	Mode for accessing the Technician level Code = Access via defined password only USB = Access via USB key with access file only USB + code = Access via defined password or USB key with access file.
T 51 19	Security Key		-	-	-	-	The defined password is saved as a file to a USB key. The USB key provides access with this password on all machines. The file stored on the USB key cannot be copied.
	Reset						Use this submenu to reset the data of the machine. Various settings can be made for resetting the data.
T 51 20	Reset Parameter		0	1	0	-	All parameters are reset to the factory settings; this does not apply to the programs and the calibration values.
T 51 21	Reset Programs		0	1	0	-	All created programs are erased.
T 51 22	Reset calibration		0	1	0	-	All calibration values are reset to the factory settings.
T 51 23	Reset all		0	1	0	-	All parameters, programs, and calibration values are reset to the factory settings.
	Data transfer			•	•	•	Adjust parameter of the Data Transfer

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Parameter

No.	Parameter	lcon	Min	Мах	Preset value	Unit	Description
	All data						All data – i.e. parameter settings, programs, and calibration values – are transfered to the USB key or the control.
T 51 30	Load from USB		0	1	0	-	Data transfer from USB key to the control box
T 51 31	Store to USB		0	1	0	-	Data Transfer from the control box to the USB key
	Only Parameter						Only the data for parameter settings and calibration values are transfered to the USB key or the control.
T 51 32	Load from USB		0	1	0	-	Data transfer from USB key to the control box
T 51 33	Store to USB		0	1	0	-	Data Transfer from the control box to the USB key
	Programs						Only the programs are transfered to the USB key or the control.
T 51 34	Load from USB		-	-	-	-	Data transfer from USB key to the control box
T 51 35	Store to USB		-	-	-	-	Data Transfer from the control box to the USB key
T 51 36	List of messages		-	-	-	-	The list of messages can be saved to a USB key.
T 51 40	Light Machine		1	10	6	-	Brightness of the machine arm
T 51 41	Sewing lamp		1	10	6	-	Brightness sewing lamp
T 52 00	Contrast		10	255	32	-	Set the contrast of the control panel to the user's needs here.
T 52 01	Brightness		0	255	224	-	Set the brightness of the control panel to the user's needs here.

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No.	Parameter	lcon	Min	Мах	Preset value	Unit	Description
T 52 40	Program Switch		0	1	0	-	The last active program is fixed on the Operator level. It is not possible to change to a different program. 0 = Off 1 = On
	Manual mode						Selective restriction of areas in Manual mode R/W = Read/Write Off = Area is hidden R/O = Read Only
T 52 41	Sewing parameters		0	1	0	-	Restriction of access to additional sewing parameters 0 = R/W 1 = Off
T 52 42	Stitch length		0	2	0	-	Restriction of access to the stitch length 0 = R/W 1 = R/O 2 = Off
T 52 43	Needle thread tension		0	2	0	-	Restriction of access to the needle thread tension 0 = R/W 1 = R/O 2 = Off
T 52 44	Sewing foot pressure		0	2	0	-	Restriction of access to the sewing foot pressure 0 = R/W 1 = R/O 2 = Off
T 52 45	Sewing foot stroke		0	2	0	-	Restriction of access to the sewing foot stroke 0 = R/W 1 = R/O 2 = Off
	Program						Selective restriction of access to existing programs and their parameters R/W = Read/Write Off = Area is hidden R/O = Read Only

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 52 60	Programming	Û	0	1	0	-	It is not possible to create new programs, it is not possible to edit existing programs 0 = Off 1 = On
T 52 61	Stitch length correction	+/-	0	2	0	-	Restriction of access to the correction factor for the stitch length 0 = R/W 1 = R/O 2 = Off
T 52 62	Needle thread tension Correction)[←F +/- √	0	2	0	-	Restriction of access to the correction factor for the needle tension 0 = R/W 1 = R/O 2 = Off
	Inputs/outputs Configuration						Configure and allocate the inputs and outputs here.

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 53 00	Mode Input X120B.2		0	58	20		A mode can be allocated to every input: 0 = No function 1 = Threading position 2 = Bartack active/inactive 3 = Manual bartack 4 = Half stitch 5 = Full stitch 6 = Point position 7 = No function 8 = Needle height 9 = No function 11 = 2 nd needle thread tension 12 = Change of stitch length 13 = No function 14 = No function 15 = Seam center guide/puller 16 = No function 17 = No function 18 = Light barrier 19 = No function 20 = Operation lock when contact is opened normally (NO) 21 = Quick stroke height adjustment 22 = No function 23 = Change to next seam section 24 = No function 25 = 2 nd position of edge guide 26 = Sewing feet lift position (shoe machines) 27 = Additional fullness 28 = Tension tape 29 = Puller 31 = Operation lock when contact is closed (N.C.) 32 = Charger program selection

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
Τ 53 00	Mode Input X120B.2		0	58	20	-	34 = Program selection bit 0 35 = Program selection bit 1 36 = Program selection bit 2 37 = Program selection bit 3 38 = Program selection bit 4 39 = Program selection bit 5 40 = Program selection bit 6 41 = Program selection bit 7 42 = Program selection bit 8 43 = Program selection bit 9 44 = Short stitch length 45 = 2 nd position of edge guide (height) 46 = 2 nd position of edge guide (gap and height) 47 = DB3000 48 = DB2000 49 = Function module 1 50 = Function module 2 51 = Function module 3 52 = Function module 4 53 = Function module 5 54 = Function module 7 56 = Function module 7 56 = Function module 8 57 = Sewing lamp 58 = Light Machine
T 53 04	Stored (for X120B.2)		0	1	0	-	On = stored Off = not stored
T 53 10	Mode Input X120B.3		0	32	0	-	Select the mode as in T 53 00
T 53 14	Stored (for X120B.3)		0	1	0	-	On = stored Off = not stored
T 53 20	Mode Input X120B.4		0	32	0	-	Select the mode as in T 53 00
T 53 24	Stored (for X120B.4)		0	1	0	-	On = stored Off = not stored
T 53 30	Mode Input X120B.5		0	32	0	-	Select the mode as in T 53 00

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 53 34	Stored (for X120B.5)		0	1	0	-	On = stored Off = not stored
T 53 40	Mode Input X120B.15		0	32	0	-	Select the mode as in T 53 00
T 53 44	Stored (for X120B.15)		0	1	0	-	On = stored Off = not stored
T 53 50	Mode Input X120B.16		0	32	0	-	Select the mode as in T 53 00
T 53 54	Stored (for X120B.16)		0	1	0	-	On = stored Off = not stored
T 53 60	Mode Input X120B.17		0	32	0	-	Select the mode as in T 53 00
T 53 64	Stored (for X120B.17)		0	1	0	-	On = stored Off = not stored
T 53 70	Mode Input X120B.18		0	32	0	-	Select the mode as in T 53 00
T 53 74	Stored (for X120B.18)		0	1	0	-	On = stored Off = not stored
T 54 00	Mode Input X120T.2		0	32	0	-	Select the mode as in T 53 00
T 54 04	Stored (for X120T.2)		0	1	0	-	On = stored Off = not stored
T 54 10	Mode Input X120T.3		0	32	0	-	Select the mode as in T 53 00
T 53 14	Stored (for X120T.3)		0	1	0	-	On = stored Off = not stored
T 54 20	Mode Input X120T.4		0	32	0	-	Select the mode as in T 53 00
T 54 24	Stored (for X120T.4)		0	1	0	-	On = stored Off = not stored
T 54 30	Mode Input X120T.5		0	32	0	-	Select the mode as in T 53 00
T 54 34	Stored (for X120T.5)		0	1	0	-	On = stored Off = not stored
T 54 40	Mode Input X120T.15		0	32	0	-	Select the mode as in T 53 00

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 54 44	Stored (for X120T.15)		0	1	0	-	On = stored Off = not stored
T 54 50	Mode Input X120T.16		0	32	0	-	Select the mode as in T 53 00
T 54 54	Stored (for X120T.16)		0	1	0	-	On = stored Off = not stored
T 54 60	Mode Input X120T.17		0	32	0	-	Select the mode as in T 53 00
T 54 64	Stored (for X120T.17)		0	1	0	-	On = stored Off = not stored
T 54 70	Mode Input X120T.18		0	32	0	-	Select the mode as in T 53 00
T 54 74	Stored (for X120T.18)		0	1	0	-	On = stored Off = not stored
T 55 00	Mode Input X100B.4		0	32	0	-	Select the mode as in T 53 00
T 55 04	Stored (for X100B.4)		0	1	0	-	On = stored Off = not stored
T 55 10	Mode Input X100B.7		0	32	0	-	Select the mode as in T 53 00
T 55 14	Stored (for X100B.7)		0	1	0	-	On = stored Off = not stored
T 55 20	Mode Input X100B.11		0	32	0	-	Select the mode as in T 53 00
T 55 24	Stored (for X100B.11)		0	1	0	-	On = stored Off = not stored
T 55 30	Mode Input X100B.15		0	32	0	-	Select the mode as in T 53 00
T 55 34	Stored (for X100B.15)		0	1	0	-	On = stored Off = not stored
T 55 40	Mode Input X100T.4		0	32	0	-	Select the mode as in T 53 00
T 55 44	Stored (for X100T.4)		0	1	0	-	On = stored Off = not stored
T 55 50	Mode Input X100T.7		0	32	0	-	Select the mode as in T 53 00

Parameter

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 55 54	Stored (for X100T.7)		0	1	0	-	On = stored Off = not stored
T 55 60	Mode Input X100T.11		0	32	0	-	Select the mode as in T 53 00
T 55 64	Stored (for X100T.11)		0	1	0	-	On = stored Off = not stored
T 55 70	Mode Input X100T.15		0	32	0	-	Select the mode as in T 53 00
T 55 74	Stored (for X100T.15)		0	1	0	-	On = stored Off = not stored

No.	Parameter	lcon	Min	Мах	Preset value	Unit	Description
T 56 00	Mode Output X120B.9		0	51	3	-	A mode can be allocated to every output: 0 = No function 1 = Needle cooling 2 = Cleaning signal for remaining thread monitor 3 = Pos 1 4 = Pos 2 5 = Motor operation 6 = Puller seam center guide 7 = Signal sewing foot lift 8 = Puller 9 = Puller pressure 10 = Bartack 11 = Bartack process 12 = Thread Trim 13 = In the seam 14 = Segment Output 1 15 = Segment Output 2 16 = Segment Output 3 17 = Segment Output 4 18 = Segment Output 5 19 = Segment Output 7 21 = Segment Output 8 22 = Segment Output 1 23 = Segment Output 10 24 = Segment Output 11 25 = Segment Output 13 27 = Segment Output 13 27 = Segment Output 14 28 = Segment Output 15 29 = Segment Output 15 29 = Segment Output 16 30 = Needle thread tension 31 = Manual bartack active

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 56 00	Mode Output X120B.9		0	51	3		32 = LED Manual bartack 33 = LED 2^{nd} stitch length 34 = LED Additional thread tension 35 = LED Quick stroke adjustment 36 = LED Seam center guide 37 = LED Puller feeding/puller 38 = LED 2^{nd} gap 39 = LED Stitch function (half stitch, full stitch) 40 = LED Operation lock 41 = Edge Guide On/Off 42 = 2^{nd} edge Guide Height 43 = Function module Out 1 44 = Function module Out 2 45 = Function module Out 3 46 = Function module Out 4 47 = Function module Out 4 47 = Function module Out 6 49 = Function module Out 7 50 = Function module Out 8 51 = Light Machine Arm
T 56 10	Mode Output X120B.10		0	21	1	-	Select the mode as in T 56 00
T 56 20	Mode Output X120B.12		0	21	2	-	Select the mode as in T 56 00
T 56 30	Mode Output X120B.22		0	21	0	-	Select the mode as in T 56 00
T 56 40	Mode Output X120B.23		0	21	0	-	Select the mode as in T 56 00
T 56 50	Mode Output X90.12		0	21	0	-	Select the mode as in T 56 00
T 56 60	Mode Output X90.15		0	21	6	-	Select the mode as in T 56 00
T 57 00	Mode Input X83B.2		0	32	0	-	Select the mode as in T 53 00
T 57 04	Stored (for X83B.2)		0	1	0	-	On = stored Off = not stored
T 57 10	Mode Input X83B.3		0	32	0	-	Select the mode as in T 53 00



No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 57 14	Stored (for X83B.3)		0	1	0	-	On = stored Off = not stored
T 57 20	Mode Input X83B.4		0	32	0	-	Select the mode as in T 53 00
T 57 24	Stored (for X83B.4)		0	1	0	-	On = stored Off = not stored
T 57 30	Mode Input X83B.5		0	32	0	-	Select the mode as in T 53 00
T 57 34	Stored (for X83B.5)		0	1	0	-	On = stored Off = not stored
T 57 40	Mode Input X83B.15		0	32	0	-	Select the mode as in T 53 00
T 57 44	Stored (for X83B.15)		0	1	0	-	On = stored Off = not stored
T 57 50	Mode Input X83B.16		0	32	0	-	Select the mode as in T 53 00
T 57 54	Stored (for X83B.16)		0	1	0	-	On = stored Off = not stored
T 57 60	Mode Input X83B.17		0	32	0	-	Select the mode as in T 53 00
T 57 64	Stored (for X83B.17)		0	1	0	-	On = stored Off = not stored
T 57 70	Mode Input X83B.18		0	32	0	-	Select the mode as in T 53 00
T 57 74	Stored (for X83B.18)		0	1	0	-	On = stored Off = not stored
T 58 00	Mode Input X83T.2		0	32	0	-	Select the mode as in T 53 00
T 58 04	Stored (for X83T.2)		0	1	0	-	On = stored Off = not stored
T 58 10	Mode Input X83T.3		0	32	0	-	Select the mode as in T 53 00
T 58 14	Stored (for X83T.3)		0	1	0	-	On = stored Off = not stored
T 58 20	Mode Input X83T.4		0	32	0	-	Select the mode as in T 53 00

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 58 24	Stored (for X83T.4)		0	1	0	-	On = stored Off = not stored
T 58 30	Mode Input X83T.5		0	32	0	-	Select the mode as in T 53 00
T 58 34	Stored (for X83T.5)		0	1	0	-	On = stored Off = not stored
T 58 40	Mode Input X83T.15		0	32	0	-	Select the mode as in T 53 00
T 58 44	Stored (for X83T.15)		0	1	0	-	On = stored Off = not stored
T 58 50	Mode Input X83T.16		0	32	0	-	Select the mode as in T 53 00
T 58 54	Stored (for X83T.16)		0	1	0	-	On = stored Off = not stored
T 58 60	Mode Input X83T.17		0	32	0	-	Select the mode as in T 53 00
T 58 64	Stored (for X83T.17)		0	1	0	-	On = stored Off = not stored
T 58 70	Mode Input X83T.18		0	32	0	-	Select the mode as in T 53 00
T 58 74	Stored (for X83T.18)		0	1	0	-	On = stored Off = not stored
T 59 00	Mode Output X83B.9		0	21	1	-	Select the mode as in T 56 00
T 59 10	Mode Output X83B.10		0	21	1	-	Select the mode as in T 56 00
T 59 20	Mode Output X83B.11		0	21	2	-	Select the mode as in T 56 00
T 59 30	Mode Output X83B.12		0	21	2	-	Select the mode as in T 56 00
T 59 40	Mode Output X83B.22		0	21	0	-	Select the mode as in T 56 00
T 59 50	Mode Output X83B.23		0	21	0	-	Select the mode as in T 56 00
T 59 60	Mode Output X83B.24		0	21	0	-	Select the mode as in T 56 00
T 59 70	Mode Output X83B.25		0	21	0	-	Select the mode as in T 56 00


No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Multitest						This parameter makes it possible to test whether, for example, magnets, drives, and inputs or outputs are functioning correctly.
T 60 00	Test Output		-	-	-	-	Test of the outputs 1 = $x120B.9$; 2 = $x120B.22$ 3 = $x120B.10$; 4 = $x120B.23$ 5 = $x120B.11$; 6 = $x120B.24$ 7 = $x120B.12$; 8 = $x120B.25$ 9 = $x120T.9$; 10 = $x120T.22$ 11 = $x120T.10$; 12 = $x120T.23$ 13 = $x120T.11$; 14 = $x120T.25$ 17 = $x100B.2$; 18 = $x100B.3$ 19 = $x100B.5$; 20 = $x100B.6$ 21 = $x100B.13$; 24 = $x100B.14$ 25 = $x100T.2$; 26 = $x100T.14$ 97 = $x83B.10$; 100 = $x83B.23$ 101 = $x83B.12$; 104 = $x83B.24$ 103 = $x83B.12$; 104 = $x83B.25$ 105 = $x106$ = $x83T.22$ 107 = $x106$ = $x83T.24$ 101 = $x110T = x83T.24$ 101 = $x110T = x83T.24$ 111 = $x112 = x83T.25$



No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 60 01	Test PWM		-	-	-	-	Test of the pulse width modulation 1 = X90.12 2 = X90.13 3 = X90.14 4 = X90.15 5 = X90.16 6 = X90.18 7 = X83T.9 8 = X83T.10 9 = X83T.11 10 = X83T.12
T 60 02	Test Input		-	-	-	-	Test of the inputs 1 = X120B.2; 2 = X120B.15 3 = X120B.3; 4 = X120B.16 5 = X120B.4; 6 = X120B.17 7 = X120B.5; 8 = X120B.18 9 = X120T.2; 10 = X120T.15 11 = X120T.3; 12 = X120T.16 13 = X120T.4; 14 = X120T.17 15 = X120T.5; 16 = X120T.18 17 = X100B.11; 18 = X100B.7 19 = X100T.11; 20 = X100T.7 21 = ; 22 = - 23 = ; 24 = - 33 = ; 34 = - 35 = ; 36 = - 37 = ; 38 = - 39 = ; 85 = X90.8 97 = X83B.2; 98 = X83B.15 99 = X83B.3; 100 = X83B.16 101 = X83B.4; 102 = X83B.17 103 = X83B.5; 104 = X83T.16 109 = X83T.4; 110 = X83T.17 111 = X83T.5; 112 = X83T.18

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 60 03	Test analog Input		-	-	-	-	Test of the analog inputs 1 = X120B.7 2 = X120T.7 3 = X120B.20 4 = X120T.20 5 = X90.17 6 = X90.19
T 60 04	Test automatic Input		-	-	-	-	Test of the inputs 1 = X120B.2; 2 = X120B.15 3 = X120B.3; 4 = X120B.16 5 = X120B.4; 6 = X120B.17 7 = X120B.5; 8 = X120B.18 9 = X120T.2; 10 = X120T.15 11 = X120T.3; 12 = X120T.16 13 = X120T.4; 14 = X120T.17 15 = X120T.5; 16 = X120T.18 17 = X100B.11; 18 = X100B.7 19 = X100T.11; 20 = X100T.7 21 = -; 22 = - 23 = -; 24 = - 33 = -; 34 = - 35 = -; 36 = - 37 = -; 38 = - 39 = -; 85 = X90.8 97 = X83B.2; 98 = X83B.15 99 = X83B.3; 100 = X83B.16 101 = X83B.4; 102 = X83B.17 103 = X83B.5; 104 = X83B.18 105 = X83T.2; 106 = X83T.16 109 = X83T.4; 110 = X83T.17 111 = X83T.5; 112 = X83T.18
T 60 05	Test Sewing Motor		-	-	-	-	Use this subitem to test the functionality of the sewing motor.

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description	
T 60 06	Test Step Motor		-	-			You use this subitem to test step motors for stitch length adjustment, sewing foot lift/sewing foot pressure and stroke adjustment. The machine can move to defined positions (steps), where 2000 steps = 360°	
T 60 07	Test Pedal		-	-	-	-	This subitem is used to check the various pedal positions of the analog pedal (X6b). The positions are indicated by measured and automatically calculated calibration values.	
T 60 08	Test Material Thickness Sensor		-	-	-	-	Use this subitem to test the functionality of the material thickness sensor.	
T 60 09	Test SSD		-	-	-	-	Use this subitem to test the functionality of the SSD sensor.	
	Settings	¢.					Call up the corresponding service routine to be able to make settings on the machine without any risk.	
	Feed dog	***					Adjustment of the feed dog	
T 61 00	Assemble feed dog		-	-	-	-	Disassembling and assembling the feed dog	
T 61 01	Position to needle		-	-	-	-	Setting the feed dog position to the needle	
T 61 02	Feed dog movement	ţÇ t	-	-	-	-	Setting the feed dog feed movement	

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Hook - Needle	₿₽					Adjustment of Needle-Hook
T 61 10	Timing		-	-	-	-	Setting the loop stroke position
T 61 11	Needle bar stroke		-	-	-	-	Setting the needle bar height
	Sewing foot stroke						Adjustment of alternating sewing feet
T 61 20	Even sewing foot stroke		-	-	-	-	Setting an even sewing foot stroke of feeding and presser foot
T 61 21	Feed Move		-	-	-	-	Setting the feeding foot movement
T 61 30	Needle thread tension) [← F	-	-	-	-	Settings of the needle thread tension
	Calibration					•	Setting the Calibration parameter
T 62 00	Stitch length calibration		-	-	-	-	Calibration of the stitch length and/or the feed

No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
T 62 01	Material thickness detection		-	-	-	-	Calibration of the material thickness detection
T 62 02	Manual stitch length adjust- ment		-	-	-	-	Calibration of the stitch adjustment lever (optional equipment)
T 62 03	Calibrate motor-driven edge guide		-	-	-	-	Calibration of the motor-driven edge guide (optional equipment)
T 62 04	Edge Guide Height		-	-	-	-	Height calibration of the motor-driven edge guide (additional equipment)
T 62 30	Thread tension		-	-	-	-	Window for setting the thread tension
T 62 31	Thread tension (left)		-	-	-	-	Window for setting the thread tension (left)
	Hand scanner	الع م					Adjust parameter of the scanner
T 63 00	Hand scanner		0	1	0	-	Hand scanner 0 = Off 1 = On
	BDE						Configuration of the BDE interface
T 63 10	Mode BDE		0	1	0	-	Configuration of the BDE interface 0 = Off 1 = hand scanner

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No.	Parameter	lcon	Min	Max	Preset value	Unit	Description
	Х170Т						Configuration for the X170T interface
T 63 11	Mode X170T		0	1	0	-	Configuration for the X170T interface 0 = Off 1 = hand scanner
T 63 12	Baudrate		19400	250000	115200	-	Transfer rate of the scanner
T 63 13	Baudrate		19400	250000	115200	-	Transfer rate of the scanner
	Output Configuration			-			Configure and allocate the outputs here.
T 64 00	Mode Output X83T.9		0	21	1	-	Select the mode as in T 56 00
T 64 10	Mode Output X83T.10		0	21	1	-	Select the mode as in T 56 00
T 64 20	Mode Output X83T.11		0	21	2	-	Select the mode as in T 56 00
T 64 30	Mode Output X83T.12		0	21	2	-	Select the mode as in T 56 00
T 64 40	Mode Output X83T.22		0	21	0	-	Select the mode as in T 56 00
T 64 50	Mode Output X83T.23		0	21	0	-	Select the mode as in T 56 00
T 64 60	Mode Output X83T.24		0	21	0	-	Select the mode as in T 56 00
T 64 70	Mode Output X83T.25		0	21	0	-	Select the mode as in T 56 00

Parameter

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Comparison of different classes 4

No.	Parameter	867 – 190922-M	867 - 190929-M	867 – 190942-M	867 – 190945-M	867 – 290922-M	867 – 290942-M	867 – 290945-M	667	669
T 08 00	Max. Speed (Preset value)	3000	3000	3000	3000	3000	3000	3000	3000	3000
T 08 02	PosSpeed	150	150	150	150	150	150	150	150	150
O 01 00	Thread clamp (Preset value)	0	0	0	1	0	0	1	0	0
O 03 10	FL ht.AtStop (Max.)	20	20	20	18	20	20	18	20	20
O 03 11	FL ht.A.Trim (Max)	20	20	20	18	20	20	18	20	20
T 02 10	Start Trim° (Preset value)	125	225	125	125	125	125	125	160	125
T 08 13	After Trim° (Preset value)	71	71	71	85	71	71	85	71	71
T 09 11	Tens.Close° (Preset value)	71	71	71	85	71	71	85	71	71
T 31 01	End St. (Preset value) (Short Stitch)	0	0	0	1	0	0	1	0	0
T 08 00	Max. Speed (Max)	3800	3800	3400	3400	3500	3200	3200	3000	3000
T 08 12	StopBottom° (Preset value)	120	220	120	120	120	120	120	120	120

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No.	Parameter	867 – 190922-M	867 – 190929-M	867 – 190942-M	867 – 190945-M	867 – 290922-M	867 – 290942-M	867 – 290945-M	667	669
T 12 01	StopIdle° (Preset value)	30	30	30	30	30	30	30	30	30
	FL Height Max (Preset value) (Max)	20	20	20	18	20	20	18	20	20
T 30 10	Max.St.Len. (Max)	12.0	12.0	12.0	12.0	12.0	12.0	12.0	9.0	6.0

5 Warnings, error and information messages

Code	Туре	Possible cause	Remedial action
1000	Error	Sewing motor encoder plug (Sub-D, 9pol) not connected	Connect encoder cable to the control, use the correct interface
1001	Error	Sewing motor error Sewing motor plug (AMP) not connected	 Check connection and plug in Test sewing motor phases (R = 2.8Ω, high impedance to PE) Replace encoder Replace sewing motor Replace control
1002	Error	Sewing motor insulation error	 Check motor phase and PE for low-impedance connection Replace encoder Replace sewing motor
1004	Error	Incorrect sewing motor direction of rotation	 Replace encoder Check motor plug assignment and change it if necessary Check wiring in machine distributor and change it, if necessary Test motor phases and check for correct value
1005	Error	Motor blocked	 Eliminate stiff movement in the sewing machine Replace encoder Replace sewing motor
1006	Error	Maximum speed exceeded	 Replace encoder Perform reset Check class (t 51 04)
1007	Error	Error in the reference run	 Replace encoder Eliminate stiff movement in the sewing machine
1008	Error	Sewing motor encoder error	Replace encoder

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Code	Туре	Possible cause	Remedial action
1010	Error	External synchronizer plug (Sub-D, 9-pin) not connected	 Connect cable of external synchronizer to control, make sure that interface (Sync) is correct Only recommended for machines with transmission!
1011	Error	Encoder Z pulse missing	 Switch off the control, use handwheel to turn, and switch on the control again If error is not corrected, check encoder
1012	Error	Synchronizer fault	Replace synchronizer
1054	Error	Internal short circuit	Replace control
1055	Error	Sewing motor overload	 Eliminate stiff movement in the sewing machine Replace encoder Replace sewing motor
1060	Error	Sewing motor overload/excess current/excess voltage	Check selection of class Replace control Replace motor Replace encoder
1061	Error	Sewing motor overload/excess current/excess voltage	Check selection of class Replace control Replace motor Replace encoder
1120	Error	Sewing motor Init fault	Perform software updateCheck selection of class
1121	Error	Sewing motor watchdog	Perform software updateCheck selection of class
1203	Error	Position not reached (during thread cutting, reversal, etc.)	 Check the controller settings and change them if necessary (e.g. thread cutter setting, belt tension, etc.) Check position thread lever at top dead center

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Code	Туре	Possible cause	Remedial action
1302	Error	Sewing motor current error	 Check Service Stop Eliminate stiff movement in the sewing machine Replace encoder Replace motor
1330	Error	No answer from sewing motor	Perform software updateReplace control
2101	Error	Step motor card X30 reference run timeout	Check reference sensor
2105	Error	Step motor card X30 blockage	Eliminate stiff movement in the sewing machine
2121	Error	Step motor card X30 encoder plug (Sub-D, 9-pin) not connected	Connect encoder cable to the control, use the correct interface
2122	Error	Step motor card X30 flywheel position not found	Check step motor 1 for stiff movement
2130	Error	Step motor card X30 not responding	Perform software updateReplace control
2131	Error	Step motor card X30 init error	Perform software update Check selection of class
2152	Error	Step motor card X30 overcurrent	Eliminate stiff movement in the sewing machine
2171	Error	Step motor card X30 Watchdog (Stitch length)	Perform software update Check selection of class
2172	Error	Step motor card X30 motor overload / overvoltage / overcurrent (Stitch length)	Check selection of class Replace control Replace encoder Replace the step motor
2173	Error	Step motor card X30 Sewing motor encoder not connected (Stitch length)	Replace control

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Code	Туре	Possible cause	Remedial action
2174	Error	Step motor card X30 Sewing motor encoder not init (Stitch length)	Perform software updateCheck selection of class
2175	Error	Step motor card X30 Init Position not found (Stitch length)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2176	Error	Step motor card X30 not Enabled (Stitch length)	Replace control
2177	Error	Step motor card X30 Overload (Stitch length)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2178	Error	Step motor card X30 Encoder failure (Stitch length)	Replace encoder
2179	Error	Step motor card X30 Current sensor failure (Stitch length)	Replace control
2180	Error	Step motor card X30 Incorrect step motor direction of rotation (Stitch length)	 Replace encoder Check if plugs have been mixed up Check wiring in machine distributor and change it, if necessary
2181	Error	Step motor card X30 Reference drive failure (Stitch length)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2183	Error	Step motor card X30 overcurrent (Stitch length)	Replace control
2184	Error	Step motor card X30 parameter init (Stitch length)	Perform software updateCheck selection of class
2185	Error	Step motor card X30 insulation error (Stitch length)	 Check motor phase and PE for low-impedance connection Replace encoder Replace sewing motor

Code	Туре	Possible cause	Remedial action
2187	Error	Step motor card X30 transport interval failure (Stitch length)	Perform software update Check selection of class
2188	Error	Step motor card X30 Reference drive failure (Stitch length)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2201	Error	Step motor card X40 reference run timeout	Check reference sensor
2205	Error	Step motor card X40 step motor blockage	Eliminate stiff movement in the sewing machine
2221	Error	Step motor card X40 encoder plug (Sub-D, 9-pin) not connected	Connect encoder cable to the control, use the correct interface
2222	Error	Step motor card X40 flywheel position not found	Check step motor 1 for stiff movement
2230	Error	Step motor card X40 not responding	Perform software update Replace control
2231	Error	Step motor card X40 init error	Perform software update Check selection of class
2252	Error	Step motor card X40 overcurrent	Eliminate stiff movement in the sewing machine
2271	Error	Step motor card X40 watchdog (sewing foot lift)	Perform software updateCheck selection of class
2272	Error	Step motor card X40 motor overload / overvoltage / overcurrent (Foot lifting)	Check selection of class Replace control Replace encoder Replace the step motor
2273	Error	Step motor card X40 Sewing motor encoder not connected (Foot lifting)	Replace control

Code	Туре	Possible cause	Remedial action
2274	Error	Step motor card X40 Sewing motor encoder not init (Foot lifting)	Perform software updateCheck selection of class
2275	Error	Step motor card X40 Init Position not found (Foot lifting)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2276	Error	Step motor card X40 not Enabled (Foot lifting)	Replace control
2277	Error	Step motor card X40 I ² t (Foot lifting)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2278	Error	Step motor card X40 Encoder failure (Foot lifting)	Replace encoder
2279	Error	Step motor card X40 Current sensor failure (Foot lifting)	Replace control
2280	Error	Step motor card X40 Incorrect step motor direction of rotation (Foot lifting)	 Replace encoder Check if plugs have been mixed up Check wiring in machine distributor and change it, if necessary
2281	Error	Step motor card X40 Reference drive failure (Foot lifting)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2283	Error	Step motor card X40 overcurrent (Foot lifting)	Replace control
2284	Error	Step motor card X40 parameter init (Foot lifting)	Perform software updateCheck selection of class
2285	Error	Step motor card X40 insulation error (Foot lifting)	 Check motor phase and PE for low-impedance connection Replace encoder Replace sewing motor
2287	Error	Step motor card X40 transport interval failure (Foot lifting)	Perform software updateCheck selection of class



Code	Туре	Possible cause	Remedial action
2288	Error	Step motor card X40 Reference drive failure (Foot lifting)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2301	Error	Step motor card X50 Reference drive failure (Stitch length)	Check reference sensor
2305	Error	Step motor card X50 step motor blockage	Eliminate stiff movement in the sewing machine
2321	Error	Step motor card X50 encoder plug (Sub-D, 9-pin) not connected	Connect encoder cable to the control, use the correct interface
2322	Error	Step motor card X50 flywheel position not found	Check step motor 1 for stiff movement
2330	Error	Step motor card X50 not responding	Perform software update Replace control
2331	Error	Step motor card X50 init error	Perform software update Check selection of class
2352	Error	Step motor card X50 overcurrent	Eliminate stiff movement in the sewing machine
2371	Error	Step motor card X50 watchdog (sewing foot lift)	Perform software update Check selection of class
2372	Error	Step motor card X50 motor overload / overvoltage / overcurrent (Foot stroke)	Check selection of class Replace control Replace encoder Replace the step motor
2373	Error	Step motor card X50 Sewing motor encoder not connected(Foot stroke)	Replace control
2374	Error	Step motor card X50 Sewing motor encoder not init (Foot stroke)	Perform software updateCheck selection of class

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Code	Туре	Possible cause	Remedial action
2375	Error	Step motor card X50 Init Position not found (Foot stroke)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2376	Error	Step motor card X50 not Enabled (Foot stroke)	Replace control
2377	Error	Step motor card X50 Overload (Foot stroke)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2378	Error	Step motor card X50 Encoder failure (Foot stroke)	Replace encoder
2379	Error	Step motor card X50 Current sensor failure (Foot stroke)	Replace control
2380	Error	Step motor card X50 Incorrect step motor direction of rotation (Foot stroke)	 Replace encoder Check if plugs have been mixed up Check wiring in machine distributor and change it, if necessary
2381	Error	Step motor card X50 Reference drive failure(Foot stroke)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2383	Error	Step motor card X50 overcurrent (Foot stroke)	Replace control
2384	Error	Step motor card X50 parameter init (Foot stroke)	Perform software updateCheck selection of class
2385	Error	Step motor card X50 insulation error (Foot stroke)	 Check motor phase and PE for low-impedance connection Replace encoder Replace sewing motor
2387	Error	Step motor card X50 transport interval failure (Foot stroke)	Perform software update Check selection of class

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Code	Туре	Possible cause	Remedial action
2388	Error	Step motor card X50 Reference drive failure (Foot stroke)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2401	Error	Step motor card X60 reference run timeout (Edge guide)	Check reference sensor
2405	Error	Step motor card X60 step motor blockage (Edge guide)	Eliminate stiff movement in the sewing machine
2421	Error	Step motor card X60 encoder plug (Sub-D, 9-pin) not connected	Connect encoder cable to the control, use the correct interface
2422	Error	Step motor card X60 flywheel position not found	Check step motor 1 for stiff movement
2430	Error	Step motor card X60 not responding	Perform software updateReplace control
2431	Error	Step motor card X60 init error	Perform software updateCheck selection of class
2471	Error	Step motor card X60 Watchdog (Edge guide)	Perform software updateCheck selection of class
2472	Error	Step motor card X60 motor overload / overvoltage / overcurrent (Edge guide)	Check selection of class Replace control Replace encoder Replace the step motor
2473	Error	Step motor card X60 Sewing motor encoder not connected(Edge guide)	Replace control
2474	Error	Step motor card X60 Sewing motor encoder not init (Edge guide)	Perform software updateCheck selection of class

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Code	Туре	Possible cause	Remedial action
2475	Error	Step motor card X60 Init Position not found (Edge guide)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2476	Error	Step motor card X60 not Enabled (Edge guide)	Replace control
2477	Error	Step motor card X60 Overload (Edge guide)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2478	Error	Step motor card X60 Encoder failure (Edge guide)	Replace encoder
2479	Error	Step motor card X60 Current sensor failure (Edge guide)	Replace control
2480	Error	Step motor card X60 Incorrect step motor direction of rotation (Edge guide)	 Replace encoder Check if plugs have been mixed up Check wiring in machine distributor and change it, if necessary
2481	Error	Step motor card X60 Reference drive failure (Edge guide)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2483	Error	Step motor card X60 overcurrent (Edge guide)	Replace control
2484	Error	Step motor card X60 parameter init (Edge guide)	Perform software updateCheck selection of class
2485	Error	Step motor card X60 insulation error (Edge guide)	 Check motor phase and PE for low-impedance connection Replace encoder Replace sewing motor
2487	Error	Step motor card X60 transport interval failure(Edge guide)	Perform software updateCheck selection of class

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Code	Туре	Possible cause	Remedial action
2488	Error	Step motor card X60 Reference drive failure (Edge guide)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2501	Error	Step motor card X70 reference run timeout (upper Puller)	Check reference sensor
2505	Error	Step motor card X70 step motor blockage (upper Puller)	Eliminate stiff movement in the sewing machine
2521	Error	Step motor card X70 encoder plug (Sub-D, 9-pin) not connected	Connect encoder cable to the control, use the correct interface
2522	Error	Step motor card X70 flywheel position not found	Check step motor 1 for stiff movement
2530	Error	Step motor card X70 not responding	Perform software updateReplace control
2531	Error	Step motor card X70 init error	Perform software updateCheck selection of class
2571	Error	Step motor card X70 Watchdog (upper Puller)	Perform software updateCheck selection of class
2572	Error	Step motor card X70 motor overload / overvoltage / overcurrent (upper Puller)	Check selection of class Replace control Replace encoder Replace the step motor
2573	Error	Step motor card X70 Sewing motor encoder not connected(upper Puller)	Replace control
2574	Error	Step motor card X70 Sewing motor encoder not init (upper Puller)	Perform software updateCheck selection of class

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Code	Туре	Possible cause	Remedial action
2575	Error	Step motor card X70 Init Position not found (upper Puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2576	Error	Step motor card X70 not Enabled (upper Puller)	Replace control
2577	Error	Step motor card X70 Overload (upper Puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2578	Error	Step motor card X70 Encoder failure (upper Puller)	Replace encoder
2579	Error	Step motor card X70 Current sensor failure (upper Puller)	Replace control
2580	Error	Step motor card X70 Incorrect step motor direction of rotation (upper Puller)	 Replace encoder Check if plugs have been mixed up Check wiring in machine distributor and change it, if necessary
2581	Error	Step motor card X70 Reference drive failure (upper Puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2583	Error	Step motor card X70 overcurrent (upper Puller)	Replace control
2584	Error	Step motor card X70 parameter init (upper Puller)	Perform software updateCheck selection of class
2585	Error	Step motor card X70 insulation error (upper Puller)	 Check motor phase and PE for low-impedance connection Replace encoder Replace sewing motor
2587	Error	Step motor card X70 transport interval failure (upper Puller)	Perform software updateCheck selection of class

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Code	Туре	Possible cause	Remedial action
2588	Error	Step motor card X70 Reference drive failure (upper Puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2601	Error	Step motor X80 reference run timeout (bottom puller)	Check reference sensor
2605	Error	Step motor card X80 step motor blockage (bottom puller)	Eliminate stiff movement in the sewing machine
2621	Error	Step motor card X82 encoder plug (Sub-D, 9-pin) not connected (bottom puller)	Connect encoder cable to the control, use the correct interface
2622	Error	Step motor card X80 flywheel position not found (bottom puller)	Check step motor 6 for stiff movement
2630	Error	Step motor card X80 not responding (bottom puller)	Perform software update Replace control
2631	Error	Step motor card X80 init failure (bottom puller)	Perform software updateCheck selection of class
2671	Error	Step motor card X80 Watchdog (bottom puller)	Perform software updateCheck selection of class
2672	Error	Step motor card X80 motor overload / overvoltage / overcurrent (bottom puller)	Check selection of class Replace control Replace encoder Replace the step motor
2673	Error	Step motor card X80 Sewing motor encoder not connected (bottom puller)	Replace control
2674	Error	Step motor card X80 Sewing motor encoder not init (bottom puller)	Perform software updateCheck selection of class

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Code	Туре	Possible cause	Remedial action
2675	Error	Step motor card X80 Init Position not found (bottom puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2676	Error	Step motor card X80 not Enabled (bottom puller)	Replace control
2677	Error	Step motor card X80 Overload (bottom puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2678	Error	Step motor card X80 Encoder failure (bottom puller)	Replace encoder
2679	Error	Step motor card X80 Current sensor failure (bottom puller)	Replace control
2680	Error	Step motor card X80 Incorrect step motor direction of rotation (bottom puller)	 Replace encoder Check if plugs have been mixed up Check wiring in machine distributor and change it, if necessary
2681	Error	Step motor card X80 Reference drive failure (bottom puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2683	Error	Step motor card X80 overcurrent (bottom puller)	Replace control
2684	Error	Step motor card X80 parameter init (bottom puller)	Perform software updateCheck selection of class
2685	Error	Step motor card X80 insulation error (bottom puller)	 Check motor phase and PE for low-impedance connection Replace encoder Replace sewing motor
2687	Error	Step motor card X80 transport interval failure (bottom puller)	Perform software update Check selection of class

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Code	Туре	Possible cause	Remedial action
2688	Error	Step motor card X80 Reference drive failure (bottom puller)	 Eliminate stiff movement in the sewing machine Replace encoder Replace motor
2901	Error	General Reference Timeout of the step motors	Check the reference sensors
3010	Error	U100 V start-up error	Disconnect the step motor plugs; if error persists, replace control
3011	Error	U100 V short circuit	Disconnect the step motor plugs; if error persists: Replace control
3012	Error	U100 V (I²T) overload	one or more step motors defective
3020	Error	U24 V start-up error	Disconnect magnet plug; if error persists: Replace control
3021	Error	U24 V short circuit	Disconnect magnet plug; if error persists: Replace control
3022	Error	U24 V (I²T) overload	one or more magnets defective
3030	Error	Motor phase failure	Replace control
3104	Warning	Pedal is not in position 0	When switching the control on, take your foot off the pedal
3109	Warning	Operation lock	Check tilt sensor on machine
3110	Information	Magnet for thread tension on the right is not connected	Check connection of magnet for thread tension on the right
3111	Information	Magnet for thread tension on the left is not connected	Check connection of magnet for thread tension on the left
3150	Information	Maintenance necessary	 for information on lubricating the machine, see the service instructions for the machine
3217	Information	RTM right	Bobbin is emptyinsert a new bobbin
3223	Information	Skip stitch detection	-

Code	Туре	Possible cause	Remedial action
3224	Information	Bobbin rotation monitor	 the bobbin is not rotating Check the bobbin, advance the initial thread
3225	Information	SSD sensor is soiled	Clean the sensor using compressed air or a soft cotton cloth
3354	Information	Error during thread cutting	Perform software update
3383	Information	Error during reference run of the motor	Check motor Perform software update
4201	Warning	SD card error	Insert SD card Replace control
4430	Warning	OP3000: Connection lost	 Check connection to OP3000 Replace OP3000 Replace control
4440	Error	OP3000: DAC receive buffer exceeded	 Check connection to OP3000 Replace OP3000 Replace control
4441	Warning	OP3000: DAC receiver timeout	 Check connection to OP3000 Replace OP3000 Replace control
4442	Warning	OP3000: DAC unknown message	 Check connection to OP3000 Replace OP3000 Replace control
4443	Warning	OP3000: DAC invalid checksum	 Check connection to OP3000 Replace OP3000 Replace control
4445	Error	OP3000: DAC send buffer exceeded	Check connection to OP3000 Replace OP3000 Replace control

Code	Туре	Possible cause	Remedial action
4446	Warning	OP3000: DAC no response	Check connection to OP3000 Replace OP3000 Replace control
4447	Warning	OP3000: DAC invalid response	Check connection to OP3000Replace OP3000Replace control
4450	Error	OP3000: DAC OP Receive buffer exceeded	Check connection to OP3000Replace OP3000Replace control
4451	Warning	OP3000: DAC OP receiver Timeout	Check connection to OP3000Replace OP3000Replace control
4452	Warning	OP3000: DAC OP unknown message	Check connection to OP3000Replace OP3000Replace control
4456	Warning	OP3000: DAC no response	Check connection to OP3000Replace OP3000Replace control
4460	Warning	OP7000 connection lost	Check connection to OP7000Replace OP7000Replace control
4906	Information		Check machine ID connection socketReset or machine class change necessary
4907	Information		Reset or machine class change necessary
4908	Information		Reset necessary
4911	Information		Reset necessary

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Code	Туре	Possible cause	Remedial action
4918	Warning	Invalid update file	Contact DA Service
4919	Warning	Reset failed	Contact DA Service
4920	Warning	Error in update log	Contact DA Service
4921	Warning	Update was interrupted	Contact DA Service
4922	Error	Unable to find user database	Contact DA Service
4923	Error	Synchronization failed	Contact DA Service
4930	Information	Control switched	Data transfer from control panel to control
4931	Information	Control checksum error	Data transfer from control panel to control
6353	Error	EEprom Timeout	 Switch off the control, wait until the LEDs are off, check connection for machine ID, and switch on control again
5001	Information	Incorrect class	Change class Perform reset
5002	Information	Incorrect class or machine ID connection error	Change class Perform reset
5003	Information	Data version is too old	Perform reset
5004	Information	Checksum is incorrect	Perform reset
6360	Information	No valid data on external EEprom (internal data structures are not compatible with the external data storage device)	Software update
6361	Information	No external EEprom connected	Connect machine ID

Code	Туре	Possible cause	Remedial action
6362	Information	No valid data on internal EEprom (internal data structures are not compatible with the external data storage device)	 Check machine ID connection Switch off the control, wait until the LEDs have gone out, and then switch on the control again Software update
6363	Information	No valid data on internal and external EEprom (Software version is not compatible with the internal data storage device, emergency operating features only)	 Check machine ID connection Switch off the control, wait until the LEDs have gone out, and then switch on the control again Software update
6364	Information	No valid data on internal EEprom and external EEprom not connected (the internal data structures are not compatible with the external data storage device)	 Check machine ID connection Switch off the control, wait until the LEDs have gone out, and then switch on the control again Software update
6365	Information	Internal EEprom defective	Replace control
6366	Information	Internal EEprom defective and external data not valid (only emergency operating features)	Replace control
6367	Information	Internal EEprom defective and external data not valid (only emergency operating features)	Replace control
7270	Information	External CAN	 Check connection cables Perform software update Replace CAN slaves
9310	Error	Tape feeder not connected	 Check connection cables Perform software update Replace the control of the tape feeder
9320	Error	Tape feeder in lowered position	
9330	Information	Material thickness sensor not connected	 Check connection cables Perform software update Replace material thickness sensor

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Code	Туре	Possible cause	Remedial action
9340	Error	Remaining thread monitor not connected	 Check connection cables Perform software update Replace remaining thread monitor
9910	Warning	Sewing stop	 Check tilt sensor on machine Check 24V Replace control
9911	Warning	Power down	The control is switched off
9912	Warning	Restart necessary	Switch off the control
9913	Warning	Empty bobbin	Please insert a full bobbin
9914	Warning	Reset	Remove USB key!
9915	Warning	Please Wait!	Please wait and do not remove the USB key
9916	Warning	Erase internal Memory	Delete SD card. Continue with OK; cancel with ESC
9917	Warning	Erase USB key	Delete the USB key. Continue with OK; cancel with ESC
9918	Warning	No USB key present	Please insert USB key
9919	Warning	Sewing stop	Machine in stop mode for threading the thread
9920	Warning	Referencing	Please wait for motor referencing
9921	Warning	Display Message from QONDAC	Show Message
9922	Warning	Service Stop	Check the Service Stop button Check 24V Replace control
9923	Warning	Update required	Press OK for Restart or ESC for cancel

Code	Туре	Possible cause	Remedial action
9924	Warning	Generate Security Key	Generate a security key on the USB key
9925	Warning	Security Key changed!	Overwrite Key?
9926	Warning	Please Confirm Reset	Really reset?
9927	Warning	Reset	Reset successfully
9928	Warning	Referencing?	Press pedal backwards (pedal position-2)
9929	Warning	Not enough thread available	Please insert a full bobbin
9930	Warning	Empty bobbin	Please insert a full bobbin
9931	Information	Bobbin mode	Press pedal backwards to exit bobbin wind mode
9932	Information	No program available	Automatic mode is not available without a seam program. Please use programming mode to create a new seam program.





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