DÜRKOPP ADLER

906
911-210

Additional Instructions

Stitch position optimization

IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE

1 General information

Multi-directional stitching paths lead to difficulties with unreeling directions. This may result in the hook thread forming a festoon stitch i.e. double plaiting of the needle thread.

To prevent this festoon stitch occurring, stitch position optimization can be activated so the hook thread is guided to the left of the stitch hole. This will result in the needle always making the stitch to the right of the hook thread, thereby avoiding a festoon stitch.

Components of the kit

Check whether the scope of delivery for kit 0911 597774 is correct prior to installation.

Part number	Quantity	Description
0911 597764	1	Stich position optimization, fitted
9710 063000	1	Magnet valve
9731 005004	1	Hose (3,6 m)
9840 121001	5	Cable tie
0791 911862 EN	1	Additional Instructions

2 Assembling the stitch position optimization

2.1 Assembling the magnet valve

NOTICE

Property damage may occur!

The hoses can be damaged by contact with rotating shafts or moving parts.

Fix the hoses with cable ties. Cut off protruding cable ties.

Fig. 1: Assembling the magnet valve (1)

(1) - Magnet valve

To assemble the magnet valve:

1. Remove the blanking plates from the valve block.
2. Assemble the magnet valve (1).
   - **Class 906:** output **7**
   - **Class 911-210:** output **8**

Fig. 2: Assembling the magnet valve (2)

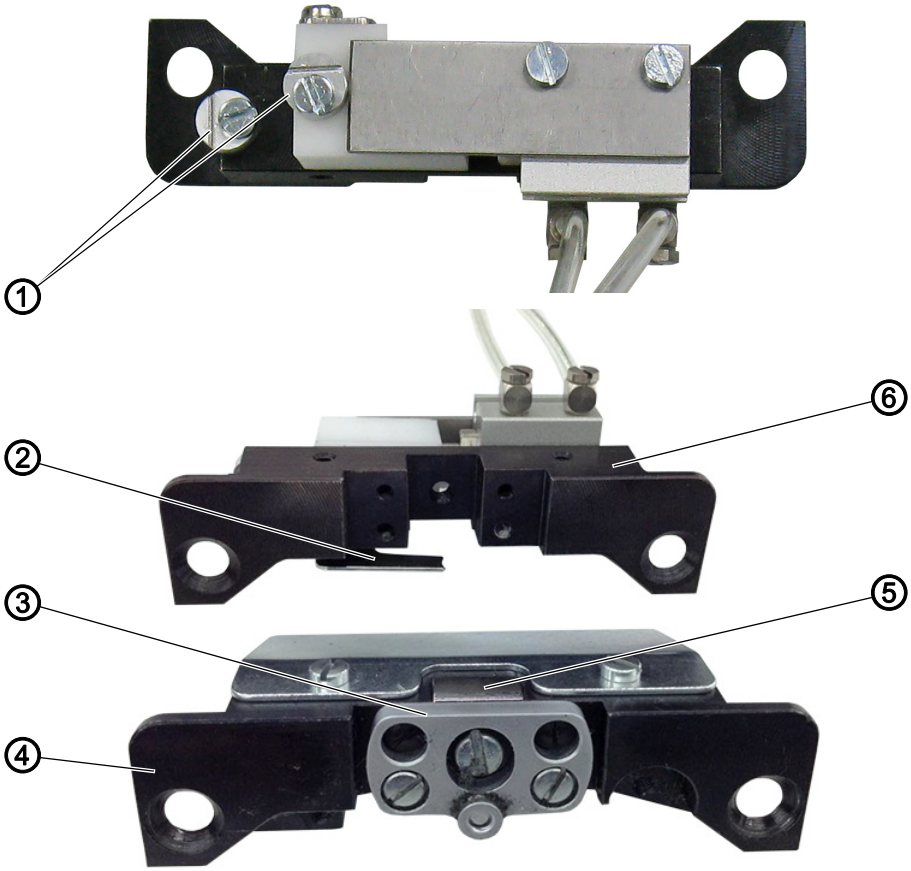
(2) - Hoses

3. Guide hoses (2) downwards between the rear hood of the machine head and the carrier of the transport system.
4. Secure hoses (2) with the cables ties to the existing cables and hoses and guide them forwards to the hook.

2.2 Assembling the stitch position optimization

The path of the hook thread slider (2) is limited by two eccentrics (1). The eccentrics (1) can be adjusted when installed.

Fig. 3: Assembling the stitch position optimization



(1) - Eccentric
(2) - Hook thread pusher
(3) - Throat plate
(4) - Throat plate holder
(5) - Needle guide
(6) - Stitch position optimization

To assemble the stitch position optimization:

1. Disassemble the throat plate holder (4).
2. Disassemble the throat plate (3) and needle guide (5).
3. Screw throat plate (3) and needle guide (5) to stitch position optimization (6).
4. Assemble the stitch position optimization (6) in the machine.

Important

Check the setting of the needle guide (📖 *Service Instructions*).

↳ The hook thread pusher (2) should have the smallest possible distance to the throat plate underside, but should NOT touch the throat plate underside.

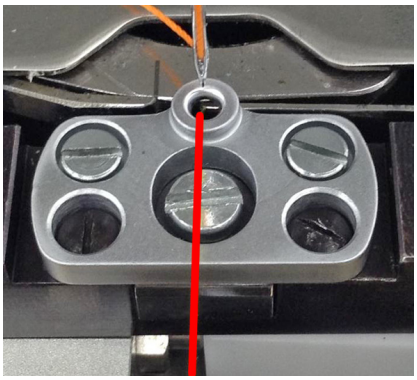
5. Tighten the stitch plate optimization

Important

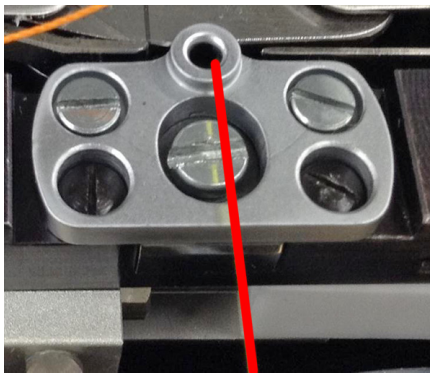
When folding down the machine head, make sure that the stitch position optimization does NOT hit the oil pan.
If necessary, bend the oil pan slightly forward.

2.3 Checking the stitch position optimization

Fig. 4: Checking the stitch position optimization



Stitch position optimization active



Stitch position optimization inactive

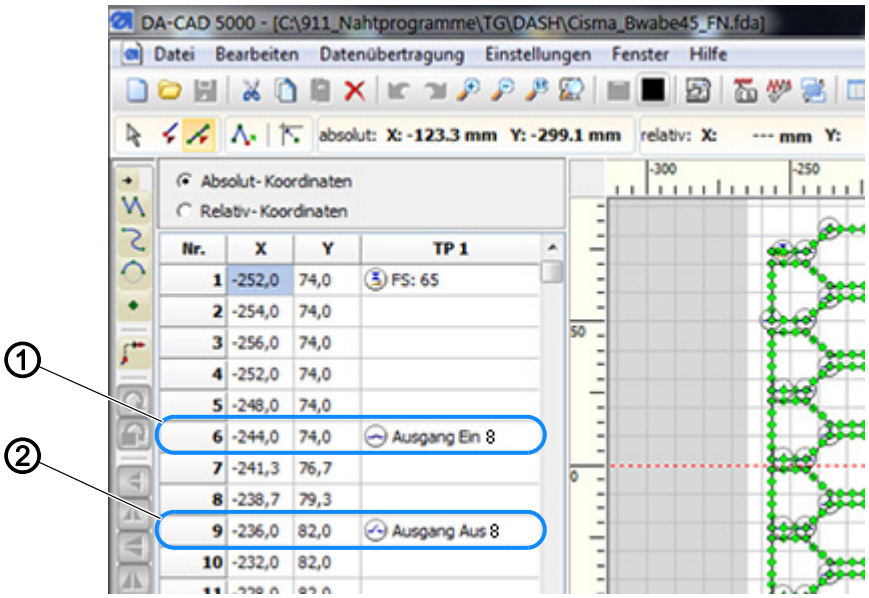
To check the stitch position optimization:

1. In the menu *Service > Multitest > Test outputs* activate the magnet valve.
   - **Class 906:** activate output **7**
   - **Class 911-210:** activate output **8**

↳ The path of the hook thread pusher to the center of the stitch hole is limited by the two eccentrics so that the hook thread is diverted to the left via the center of the stitch hole.

2.4 Programming the stitch position optimization

Fig. 5: Programming the stitch position optimization



(1) - Stitch position optimization active *(2) - Stitch position optimization inactive*

To program the stitch position optimization:

1. Control stitch direction optimization via technology points in the sewing program (e.g. DA-CAD).

- **Class 906:**
  - Output **7** ON: Stitch position optimization active
  - Output **7** OFF: Stitch position optimization inactive
- **Class 911-210:**
  - Output **8** ON: Stitch position optimization active
  - Output **8** OFF: Stitch position optimization inactive

OR

1. Switch stitch direction optimization on or off via the contour adjustment on the control panel.

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

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