

PicoDrive P40 PD2

P41 PD2

P41 PD2-L

INSTRUCTION MANUAL

P44 PD2

P44 PD2-L

This Instruction Manual is valid for drives
from the following software version on:

P40 PD2 # 4_040_14 →

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**PFAFF Industriesysteme
und Maschinen AG**

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	Contents	Page
1	Safety	5
1.01	Directives	5
1.02	General notes on safety	5
1.03	Safety and work symbols	6
1.04	Important notes for the user	6
1.05	Operating and technical staff	7
1.05.01	Operating staff	7
1.05.02	Technical staff	7
1.06	Notes on danger	8
2	Proper use.....	9
3	Specifications	10
3.01	P40PD2 and P41PD2	10
3.02	P41PD2-L and P44PD2-L	11
3.03	Installation dimensions	12
4	Disposal	13
5	Transportation packing and storage.....	13
5.01	Transportation to the customer's premises	13
5.02	Transportation inside the customer's premises	13
5.03	Disposal of packing materials	13
5.04	Storage	13
6	Control elements.....	14
6.01	Main switch	14
6.02	Control panel.....	15
6.02.01	Selection keys	16
6.02.02	Function keys	17
7	Installation and commissioning	19
8	Sewing	20
8.01	Manual sewing.....	20
8.01.01	Switching the sewing functions on / off.....	21
8.01.02	Altering the number of bartacks	21
8.01.03	Selecting the parameter input	22
8.01.04	Selecting the maximum speed	22
8.02	Programmed sewing.....	23
8.02.01	Switching the sewing functions on / off.....	24
8.02.02	Selecting seam program, seam segment or number of seam segment stitches.....	24
8.02.03	Selecting the speed, next program and number of seam segments.....	25
8.02.04	Altering the number of bartacks	26
8.02.05	Special functions.....	27

	Contents	Page
8.03	Error messages.....	28
8.03.01	Description of the error messages	28
9	Input	29
9.01	Seam programming	29
9.01.01	Selecting the seam program number and seam segment	30
9.01.02	Entering the speed, next program and number of seam segments	31
9.01.03	Entering bartack stitches.....	32
9.01.04	Entering special functions.....	33
9.01.05	Entering the seam segment stitches	35
9.02	Example of how to enter a seam program	36
9.03	Parameter input	42
9.03.01	Example of how to enter the parameters	42
9.03.02	Selecting the user level.....	43
9.03.03	Functional overview of parameters.....	44
9.03.04	List of parameters.....	45
10	Service functions.....	54
10.01	Resetting the control unit.....	54
10.01.01	Calling up the reset function.....	54
10.01.02	Resetting the set parameter values	55
10.01.03	Deleting all seam programs	56
10.01.04	Cold start	57
10.02	Display of software version and current machine class for	58
10.03	Hardware test	59
11	Pin assignment of plug X5	62
11.01	Inputs	62
11.04	Switching example	63
11.02	Outputs.....	63
11.03	Power supply	63

1 Safety

1.01 Directives

This sewing machine drive was built in accordance with the European regulations stated in the Conformity and Manufacturer's Declaration.

In addition to this Instruction Manual, please also observe all generally accepted, statutory and other regulations and legal requirements – also those of the country of operation – and all valid environmental protection regulations! The applicable local regulations of the social insurance society for occupational accidents or other supervisory organisations must also be strictly adhered to!

1.02 General notes on safety

- Before unpacking and commissioning the sewing machine drive this Instruction Manual must be read carefully. Please become familiar with the safety, assembly, operating and maintenance regulations before you set the sewing machine drive, its accessories and attachments into operation for the first time.
- All work on an with the sewing machine drive may only be carried out in compliance with the following general and special safety notes in this Instruction Manual!
- All persons concerned must be aware of these safety notes and must comply with them. Non-compliance with the safety notes can lead to personal injury, damage to objects or to defects and damage to the sewing machine drive.
- The danger and safety warnings attached to the sewing machine drive must be observed!
- The sewing machine drive may only be operated with a protective earth conductor which is connected to a functioning protective system in accordance with all local provisions and regulations.
- The installation and commissioning of the sewing machine drive must be carried out carefully by properly trained personnel. The accident prevention regulations valid in the respective user country and the rules for safe and professional work must be observed.
- To reduce the risk of burns, fire, electric shock or injuries, the alteration or rebuilding of the sewing machine drive are not permitted under any circumstances.
- If additional equipment or appliances are attached to the control unit of the sewing machine drive, these may only be operated with low voltage produced by a safety transformer!
- The sewing machine drive may only be used for the purpose for which it is intended and must not be operated without its safety devices. All applicable safety regulations must be observed.
- Before the removal of covers, the fitting of additional attachments or accessories, such as speed control unit, light barrier etc., the sewing machine drive must be switched off and disconnected from the mains, and the sewing machine drive must have come to a standstill. The case of the control unit may only be opened after **10 minutes!**
- Before leaving the workplace, the machine must be switched off at the main switch. If the machine will be out of operation for a longer period, the mains switch should be disconnected, to protect the sewing machine drive from being switched on accidentally.

- Work is not permitted on parts and equipment which are connected to the power supply! Exceptions to this are contained in the regulations EN 50110.
- Repair work and special maintenance work must only be carried out by specialists or appropriately trained personnel!
- Only spare parts which have been approved by us are to be used for repairs! We expressly point out that any replacement parts or accessories not supplied by us have not been tested and approved by us. The installation and /or use of such products may result in negative changes to the constructional characteristics of the machine. We are not liable for any damage caused by non-original parts.

1.03 Safety and work symbols



Danger!
Points for particular attention



Danger of injury to operating or technical staff!



Dangerous voltage!
Danger of death for operating and technical staff!



Note, information

1.04 Important notes for the user

- This instruction manual belongs to the equipment of the sewing machine drive and must be available to the operating staff at all times. The instruction manual must be read before the equipment is operated for the first time.
- Both operating and technical staff must be instructed on the safety devices of the sewing machine drive and on safe working methods.
- It is the duty of the user to operate the sewing machine drive in perfect running order only.
- The user must ensure that none of the safety devices are removed or put out of working order.
- The user must ensure that only authorized persons work on the sewing machine drive.

For further information please contact your PFAFF agency.

1.05 Operating and technical staff

1.05.01 Operating staff

Operating staff are the persons responsible for setting up, operating and cleaning the machine and for eliminating any malfunctions in the sewing area.

The operating staff is obliged to observe the following points:

- For all work the notes on safety in this Instruction Manual must always be observed!
- Any working methods, which adversely affect the safety of the machine, must be avoided!
- Any changes occurring on the sewing machine drive, which may affect its safety, must be reported to the user immediately!

1.05.02 Technical staff

Technical staff are persons who have been trained in electrical engineering/electronics and mechanical engineering. They are responsible for servicing, repairing and adjusting the machine.

The operating staff is obliged to observe the following points:

- For all work the notes on safety in this Instruction Manual must always be observed!
- Before carry out any repair work, the main switch must be switched off and measures taken to prevent it from being switched on again!
- Never work on parts or equipment still connected to the power supply! Exceptions are only permissible in accordance with the regulations EN 50110.
- All safety covers must be replaced after the completion of maintenance and repair work!

1.06

Notes on danger



Only operate the sewing machine drive with a protective earth conductor connected to a functioning protective system in accordance with all local regulations and directives! Danger of electric shocks!



Do not disconnect the protective earth conductor!

Do not neutralize the protection by using extension lines without a protective earth conductor!

Danger of electric shocks!



Never operate the sewing machine drive if the air vents are clogged!

Danger of damage to the sewing motor!

Remove threads, fluff, dust etc. from the air vents.



Do not stick or drop any objects, e.g. needles, in the openings!

Danger of damage to the sewing machine drive!



Do not place fingers near moving parts! Danger of injury!



Do not operate the sewing machine drive if aerosols (sprays) or oxygen have been used! Danger of explosions!

2

Proper use

The sewing machine drives **P40 PD2**, **P41PD2** and **P44PD2** are not machines which are ready for use. They are intended for installation in machines for the sewing thread processing industry, which are operated in clean, dry rooms.



Any and all uses of this machine, e.g. use outdoors or in a wet environment, or where there is a risk of explosion, which have not been approved by the manufacturer, are considered to be inappropriate! The manufacturer cannot be held liable for any damage caused by inappropriate use! The appropriate use includes the observance of all operational, adjustment, maintenance and repair measures specified by the manufacturer!

3 Specifications▲

3.01 P40PD2 and P41PD2

Rated values

Voltage:	230 V, single-phase
Frequency:	50/60 Hz
Current for drive:	3,5 A
Current for control unit:	0.6 A
Power output:	375 W
Speed:	6000 min ⁻¹
Torque:	0.63 Nm
Moment of inertia of motor (without belt pulley):	0.5 kgcm ²
Operating mode:	S5 (40% rel. on-time for 2.5 s runtime)
Protection system:	IP40
Insulation class:	E

Limit values

Rated voltage range:	180 - 260 V, single-phase
Max. motor speed:	9000 min ⁻¹
Max. torque (short time):	3.0 Nm
Max. power output (short-time):	1000 W
Moment of inertia of machine (reduced to motor shaft):	4.5 kg cm ²



Before connecting the sewing machine drive make sure that the mains voltage is in the specified rated voltage range.

Operating requirements

Ambient temperature:	+5 to +45° C
Average ambient temperature (over 24 hours):	<35° C
Relative humidity:	85% at 30° C

External control elements

Voltage with engine idling:	25 V
Voltage under load:	24 V at 4A / 20 V at 10 A (short-time)
Output:	96W / 200 W (short-time)
Load current:	4 A
Max. load current (short-time):	10 A



The sum of the load currents of all simultaneously activated control elements must not continuously exceed 4 A .

Weights

Net weight (drive complete with all accessories):	approx. 8 kg
Gross weight:	approx. 10 kg

▲ Subject to alteration

3.02 P41PD2-L and P44PD2-L

Rated values

Voltage:	230 V, single-phase
Frequency:	50/60 Hz
Current for drive:	5.0 A
Current for control unit:	0.6 A
Power output:	550 W
Speed:	4000 min ⁻¹
Torque:	1.2 Nm
Moment of inertia of motor (without belt pulley):	1.0 kgcm ²
Operating mode:	S5 (40% rel. on-time for 2.5 s runtime)
Protection system:	IP40
Insulation class:	E

Limit values

Rated voltage range:	180 – 260 V, single-phase
Max. motor speed:	4500 min ⁻¹
Max. torque (short time):	7.0 Nm
Max. power output (short-time):	1500 W
Moment of inertia of machine (reduced to motor shaft):	9.0 kg cm ²



Before connecting the sewing machine drive make sure that the mains voltage is in the specified rated voltage range.

Operating requirements

Ambient temperature:	+5 to +45° C
Average ambient temperature (over 24 hours):	<35° C
Relative humidity:	85% at 30° C

External control elements

Voltage with engine idling:	25 V
Voltage under load:	24 V at 4A / 20 V at 10 A (short-time)
Output:	96W / 200 W (short-time)
Load current:	4 A
Max. load current (short-time):	10 A



The sum of the load currents of all simultaneously activated control elements must not continuously exceed 4 A .

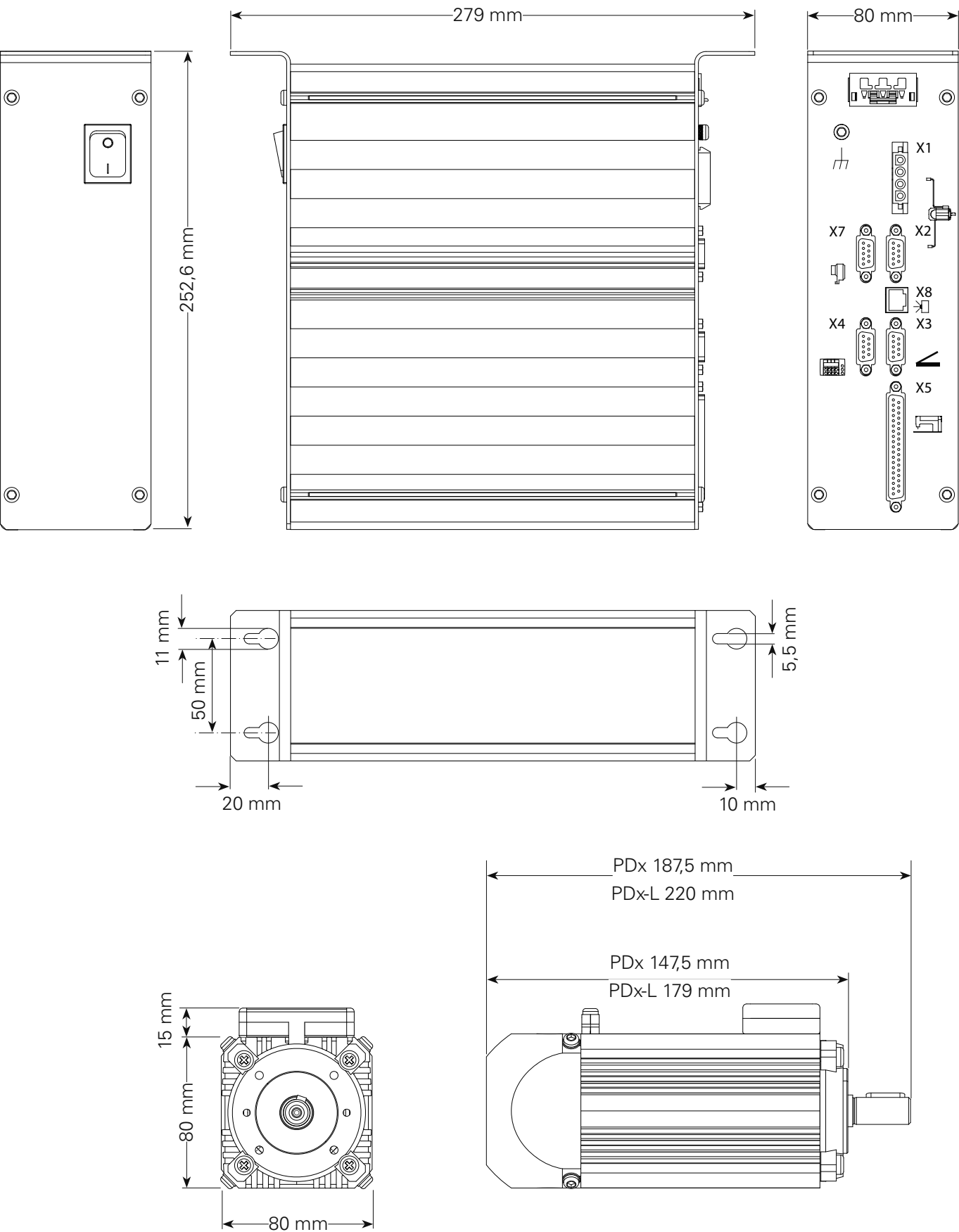
Weights

Net weight (drive complete with all accessories):	approx. 9 kg
Gross weight:	approx. 11 kg

▲ Subject to alteration

Specifications

3.03 Installation dimensions



4 Disposal

- Proper disposal of the sewing machine drive is the responsibility of the customer.
- The materials used for the sewing machine drive are steel, aluminium, brass and various plastic materials. The electrical equipment comprises plastic materials and copper.
- The sewing machine drive must be disposed of according to the locally valid pollution regulations. If necessary, a specialised company should be commissioned.



Care must be taken to see that parts soiled with lubricants are disposed of separately in accordance with the locally valid pollution control regulations!

Transportation packing and storage

5 Transportation packing and storage

The sewing machine drive can be transported and stored at temperatures in the range from **-25** to **+55 ° C**. For a period of less than 24 hours temperatures up to **+70° C** are permitted.

5.01 Transportation to the customer's premises

The sewing machine drives are delivered completely packed.

5.02 Transportation inside the customer's premises

The manufacturer cannot be made liable for transportation inside the customer's premises or to the other operating locations.

5.03 Disposal of packing materials

The packing materials for this sewing machine drive comprise PVC, cardboard and styrofoam. Proper disposal of the packing material is the responsibility of the customer.

5.04 Storage

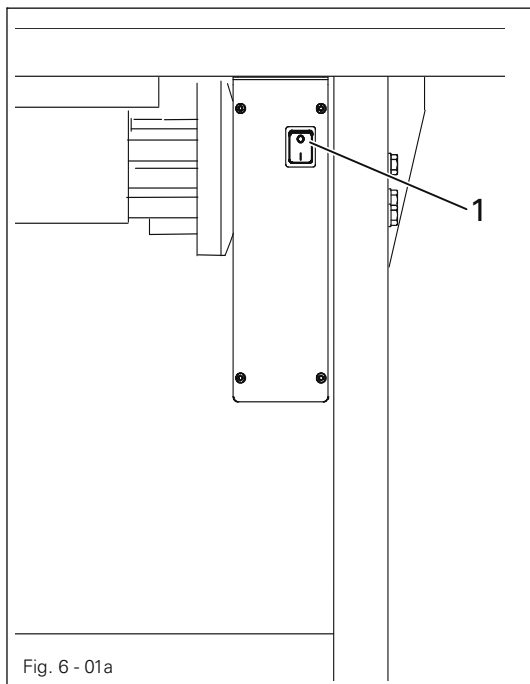
When the machine is not in use, it can be stored in its packing in a dry environment. If the sewing machine drive is stored for longer periods, the individual parts, in particular the surfaces of moving parts, must be protected against corrosion, e.g. with a film of oil.

6 Control elements

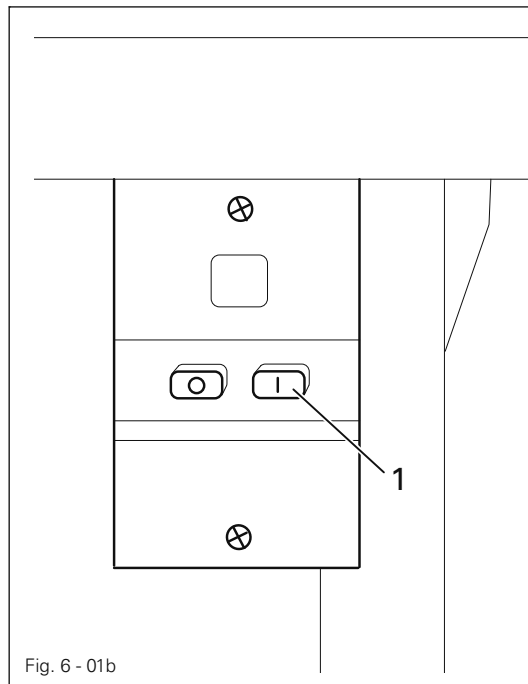
6.01 Main switch

Depending on customer specifications, the drive can optionally be fitted with one of the following main switches.

Standard

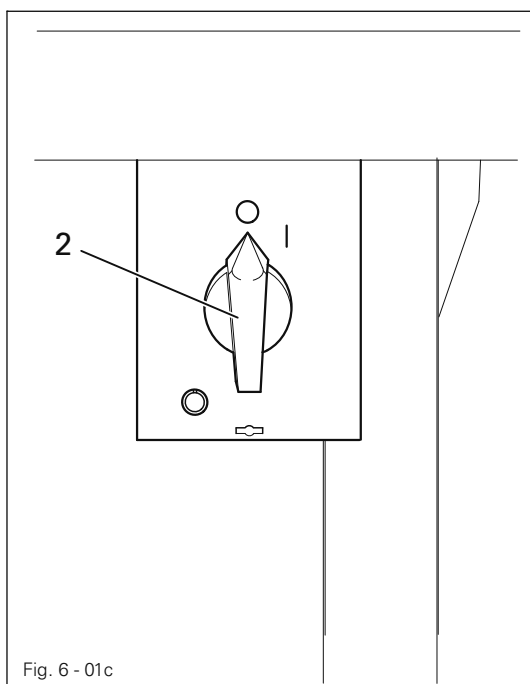


Option 1



Standard and Option 1

- The power supply for the sewing machine drive is switched on/off via main switch 1 .



Option 2

- Turn main switch 2 to switch the power supply of the sewing machine drive on or off.

6.02 Control panel

The control panel is used to display and call up the machine functions for setting up and for sewing operation, for entering parameter values and for reading error messages and service settings.

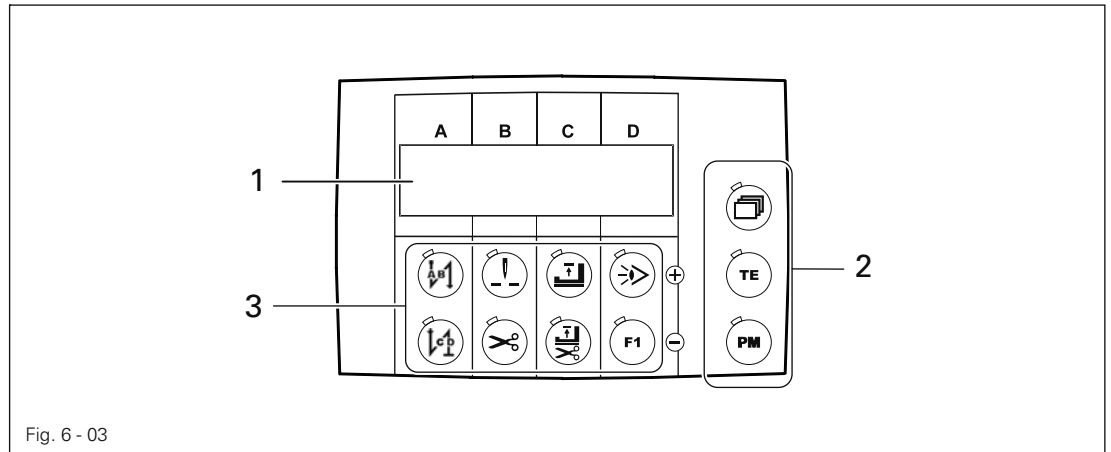


Fig. 6 - 03

The control panel has the following operating and display elements:

- The display **1** consists of a one-line display with an **8-figure** LCD-matrix and is used to show appropriate information and selection parameter.
- The selection keys **2** are used to change the screen display, to switch the function keys and to select the operating mode (**manual / programmed sewing**).
- The function keys **3** below the display are used to switch the appropriate functions on or off, depending which key is selected, or to change the values of the appropriate setting range (**A, B, C or D**).

6.02.01 Selection keys

The functions of the selections keys **2** are described in detail below:



Scrolling

- This selection key is used to change between the different menus shown on the display. The selection of the menu and the setting values shown depend on the selection of the operating mode, also see Chapter 9.01 **Manual sewing** or Chapter 9.02 **Programmed sewing**.
- Press this selection key to acknowledge the correction of an error, see Chapter 8.03 **Error messages**.



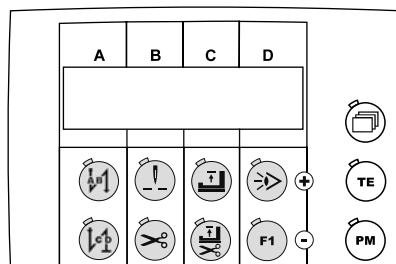
TE / input

- This selection key is used to switch the function keys **3**, also see Chapter 6.02.02 **Function keys**:

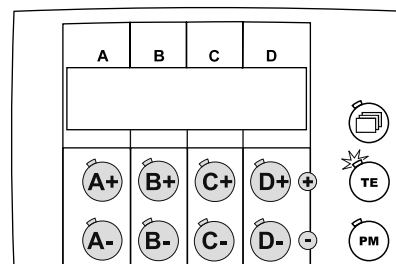
When this function is switched off (**LED off**), the appropriate sewing function can be switched on or off with the function keys **3**.

When this function is switched on (**LED on**), the set values of the appropriate setting ranges (**A**, **B**, **C** and **D**) can be altered.

TE / input off



TE / input on



PM / operating mode

- Press this selection key to switch between manual sewing and programmed sewing. When the LED is illuminated, the programmed sewing mode is activated.

6.02.02 Function keys

The function keys **3** described below generally have two basic functions:

- To switch the sewing function on or off (**LED** in the "TE/Input" key is **off**)
An activated function is always shown by the corresponding illuminated LED.
- To alter the set values shown on the display (**LED** in the "TE/Input" key is **on**)
Press and hold the appropriate function key to slowly change the set value shown above it. If the function key is pressed longer, the set value changes more quickly.

Description of the individual functions:

**Start bartack / A+**

- If the "TE / Input" key is switched off, the bartacks at the beginning of the seam (start bartacks) are switched on or off, see Chapter **9.01.03 Entering bartack stitches**.
- If the "TE / Input key" is switched on, this function key serves as a plus function for the setting range (A).

**End bartack / A-**

- If the "TE / Input" key is switched off, the bartacks at the end of the seam (end bartacks) are switched on or off, see Chapter **9.01.03 Entering bartack stitches**.
- If the "TE / Input key" is switched on, this function key serves as a minus function for the setting range (A).

**Raised needle position after sewing stop / B+**

- If the "TE / Input" key is switched off, the "raised needle position after sewing stop" function is switched on or off. If the function is switched on, the needle positions in t.d.c. take-up lever after sewing stops
- If the "TE / Input key" is switched on, this function key serves as a plus function for the setting range (B).

**Thread trimming / B-**

- If the "TE / Input key" is switched off, the thread trimmer is switched on or off.
- If the "TE / Input key" is switched on, this function key serves as a minus function for the setting range (B).

**Raised foot position after sewing stop / C+**

- If the "TE / Input key" is switched off, the "raised foot position after sewing stop" function is switched on or off. If the function is switched on, the sewing foot is raised after sewing stops.
- If the "TE / Input key" is switched on, this function key serves as a plus function for the setting range (C).

**Raised foot position at end of seam sector / C-**

- If the "TE / Input key" is switched off, the "raised foot position at end of seam sector" function is switched on or off. If the function is switched on, the sewing foot is raised at the end of the seam sector.
- If the "TE / Input key" is switched on, this function key serves as a minus function for the setting range (C).



Sewing with light barrier / D+

- If the "TE / Input key" is switched off, the sewing with light barrier functions is switched on or off. When sewing with light barrier, the number of stitches entered corresponds to the light barrier compensation stitches.
- If the "TE / Input key" is switched on, this function key serves as a plus function for the setting range (D).



F1 / D-

- If the "TE / Input key" is switched on, this function key serves as a minus function for the setting range (D-).
- Under Parameter **488** other functions can be assigned to this key (see **chapter 9.03.04 List of parameters**).

Installation and commissioning



Only operate the sewing machine drive with a protective earth conductor connected to a functioning protective system in accordance with all local regulations and directives! Danger of electric shocks!



Do not disconnect the protective earth conductor!
Protection is neutralized by the use of extension lines without a protective earth conductor! Danger of electric shocks!



Before connecting the sewing drive make sure that the mains voltage is within the specified rated voltage range, see Chapter **3 Specifications**.



If the sewing machine drive was stored at temperatures below **+5° C**, it must reach ambient temperature before being operated.



The sewing machine drive may only be operated after establishing that the machine in which this sewing machine drive is to be installed, complies with the regulations of the EC-machine directives.



Never operate the sewing machine drive if the air vents are clogged!
Danger of damage to the sewing motor!
Remove threads, fluff, dust etc. from the air vents.

During installation and commissioning the appropriate Instruction or Set-up Manual for the sewing machine must be observed!

8

Sewing

In the sewing mode all settings, which are relevant for the sewing operation, are shown on the display. Functions can be switched on or off by pressing a key, set values for the most important parameters can be altered directly.



The "PM" selection key is used to choose between manual sewing (**LED** in the selection key is **off**) and programmed sewing (**LED** in the selection key is **on**).

8.01

Manual sewing

- Switch on the machine.

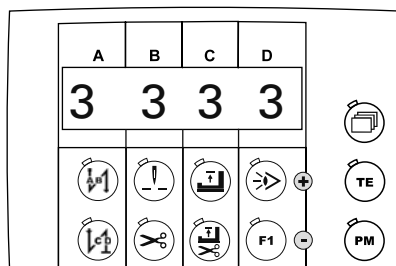


- Select manual sewing (**LED** in the selection key is **off**) by pressing the "PM" key.

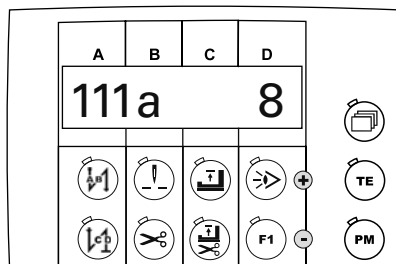


- By pressing the "scroll" key it is possible to choose one of the following display diagrams:

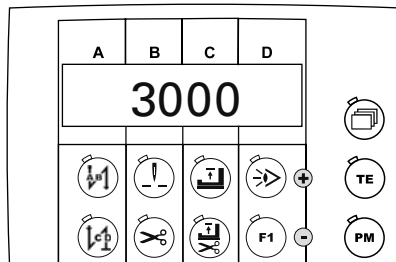
Start and end tacks



Parameters



Speed



When the machine is switched on, the display diagram, which was activated before the machine was switched off, always appears.

8.01.01 Switching the sewing functions on / off

- When the "TE / input" selection key is switched off, the sewing functions for manual sewing can be switched on or off. If a function is activated, the LED in the corresponding key is illuminated:



Start tacks on/off



Foot position raised after sewing stops on/off



End tacks on/off



Foot position raised at end of seam sector on/off



Needle position raised on/off



Light barrier on/off



Thread trimming on/off



Function on/off

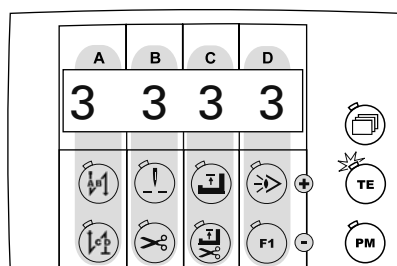
8.01.02 Altering the number of bartacks



- Call up the display diagram for the start and end bartacks (if necessary, press key several times).



- Switch on the "TE / input" function (LED is illuminated).



The number of bartack stitches are shown on the display, which can be altered as follows when the machine has stopped:



Increase the number of forwards stitches for start bartack (A+)



Increase the number of reverse stitches for the end bartack (C+)



Reduce the number of forwards stitches for start bartack (A-)



Reduce the number of reverse stitches for the end bartack (C-)



Increase the number of reverse stitches for start bartack (B+)



Increase the number of forward stitches for the end bartack (D+)



Reduce the number of reverse stitches for start bartack (B-)



Reduce the number of forward stitches for the end bartack (D-)

- Enter the set values for the start and end bartacks.

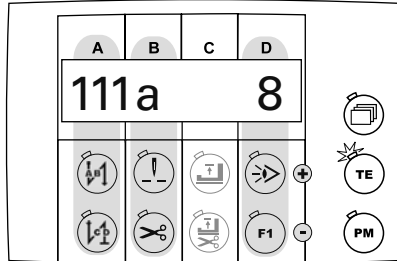
8.01.03 Selecting the parameter input



- Call up the display diagram for the parameters (if necessary, press the key several times).



- Switch on the "TE / input" function (**LED is illuminated**).



The first parameter with the corresponding set value is shown on the display.

The parameter selection and the alteration of the value can be carried out as follows:



Selecting the hundred figure of the parameter (A+)



Selecting the ten and unit figure of the parameter (B-)



Selecting the hundred figure of the parameter (A-)



Increase the set value of the parameter (D+)



Selecting the ten and unit figure of the parameter (B+)



Reduce the set figure of the parameter (D-)

- Select the parameter and alter the set value, see chapter 9.03.04 List of parameters.

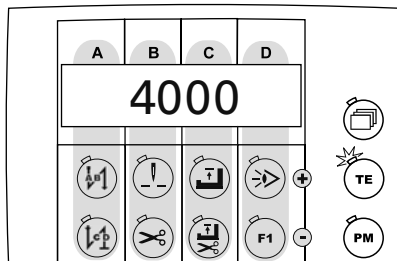
8.01.04 Selecting the maximum speed



- Call up the display diagram for the speed (if necessary, press the key several times).



- Switch on the "TE / input" function (**LED is illuminated**).



When the machine stops, the maximum speed is displayed and can be altered with the function keys in hundred steps.



When the value for parameter "605" is set at "1", the actual machine speed appears on the display after sewing starts.

8.02 Programmed sewing

- Switch on the machine.

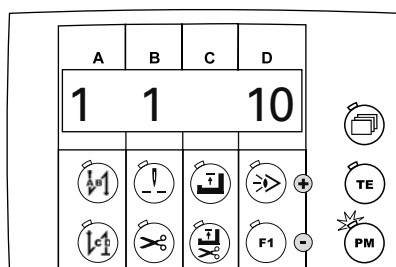


- Select programmed sewing (**LED** in the selection key is illuminated) by pressing the "PM" key.

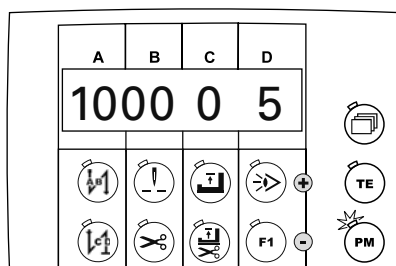


- By pressing the "scroll" key it is possible to choose one of the following display diagrams:

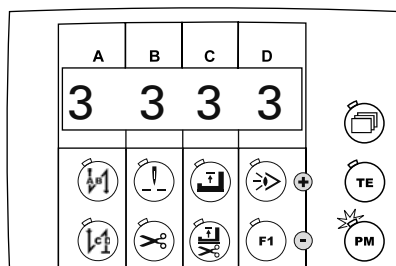
Seam program number, seam segment number and number of seam segment stitches



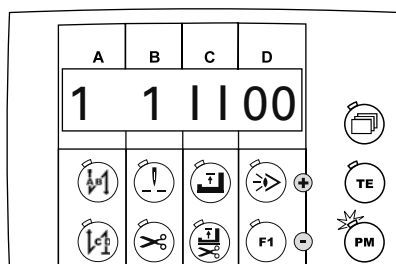
Seam program speed, seam program number of next program and number of seam segments



Start and end tacks



Seam program number, seam segment and special function



8.02.01 Switching the sewing functions on / off

When the "TE / input" selection key is **switched off**, the sewing functions for the current seam sector can be switched on or off. If a function is activated, the LED in the corresponding key is illuminated:



Start tacks on/off



Foot position raised after sewing stops on/off



End tacks on/off



Foot position raised at end of seam sector on/off



Needle position raised on/off



Light barrier on/off



Thread trimming on/off



Function on/off

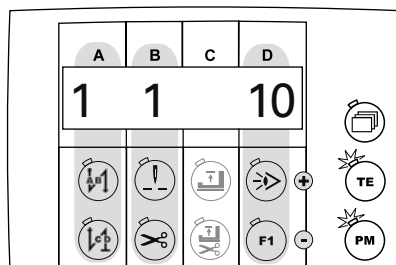
8.02.02 Selecting seam program, seam segment or number of seam segment stitches



- Call up the display diagram for the seam program number, seam segment number and the number of the seam segment stitches (if necessary, press key several times).



- Switch on the "TE / input" function (**LED is illuminated**).



The corresponding set values are shown on the display and can be altered as follows:



Select the seam program (A+)



Select the seam segment (B-)



Select the seam program (A-)



Increase the number of seam segment stitches (D+)



Select the seam segment (B+)



Reduce the number of seam segment stitches (D-)

- Enter the set values accordingly.

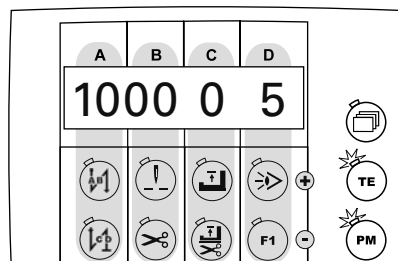
8.02.03 Selecting the speed, next program and number of seam segments



- Call up the display diagram for the speed, the next program and the number of seam segments (if necessary, press key several times).



- Switch on the "TE / input" function (**LED is illuminated**).



The corresponding set values are shown on the display and can be altered as follows:



Alter the speed (A+)



Select the next program (C+)



Alter the speed (A-)



Select the next program (C-)



Alter the speed (B+)



Alter the number of seam segments (D+)



Alter the speed (B-)

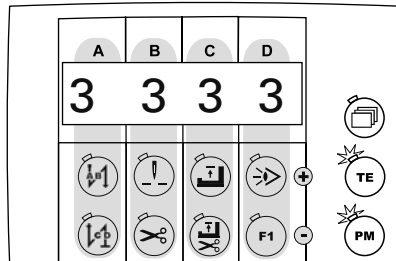


Alter the number of seam segments (D-)









- Enter the set values for the start and end bartacks..

8.02.04 Altering the number of bartacks

- Call up the display diagram for the start and end bartacks (if necessary, press key several times).
- Switch on the "TE / input" function (**LED is illuminated**).



The number of bartack stitches are shown on the display, which can be altered as follows when the machine has stopped:

- | | |
|--|--|
|  <p>Increase the number of forwards stitches for start bartack (A+)</p> |  <p>Increase the number of reverse stitches for the end bartack (C+)</p> |
|  <p>Reduce the number of forwards stitches for start bartack (A-)</p> |  <p>Reduce the number of reverse stitches for the end bartack (C-)</p> |
|  <p>Increase the number of reverse stitches for start bartack (B+)</p> |  <p>Increase the number of forward stitches for the end bartack (D+)</p> |
|  <p>Reduce the number of reverse stitches for start bartack (B-)</p> |  <p>Reduce the number of forward stitches for the end bartack (D-)</p> |

- Enter the set values for the start and end bartacks.

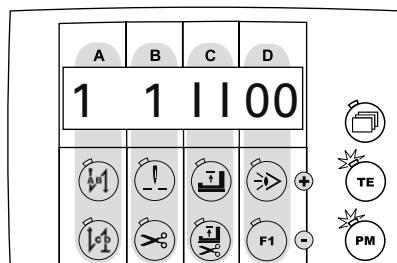
8.02.05 Special functions



- Call up the display diagram for the special functions (if necessary, press key several times).



- Switch on the "TE / input" function (LED is illuminated).



The special functions together with the corresponding seam program and seam segment are shown on the display:



Select the seam program (A+)



Stop at seam end on/off (C+)



Select the seam program (A-)



Constant speed on/off (C-)



Select the seam segment (B+)



Feed changeover on/off (D+)



Select the seam segment (B-)

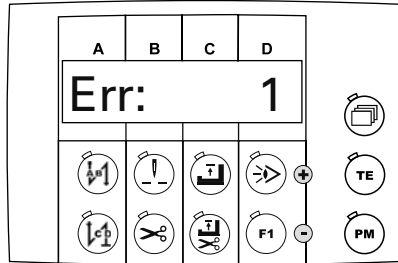


Manual seam segment on/off (D-)

- Enter the set values, see Chapter 9.01.04 **Entering the special functions**.

8.03 Error messages

When an error occurs, the text "Err:" appears on the display together with an error code, as shown in the example below. An error message can be caused by incorrect settings, defective elements or overload conditions.



- Eliminate error.



- If necessary, acknowledge error elimination.

8.03.01 Description of the error messages

Errorcode	Cause	Remedy
Err: 1	Pedal not in rest position	Check pedal
Err: 9	Start inhibitor at standstill	Bring sewing head to its basic position (Check parameter "665")
Err: 10	Machine class altered	Switch control unit off, then on again.
Err: 14	Bobbin cover open	Close bobbin cover
Err: 62	Voltage of power supply unit (24 V) too low	Check connected consumers
Err: 63	Power supply unit (24 V) overloaded	Check connected consumers
Err: 64	"Mains off" signal when machine is switched on	Contact service
Err: 65	IGBT error when machine is switched on	Contact service
Err: 66	IGBT test with error recognition	Contact service
Err: 68	Overcurrent motor during operation	Contact service
Err: 70	Motor blocking	Check machine for binding
Err: 71	Incremental transmitter of motor not connected	Check plug of incremental transmitter
Err: 73	Faulty running of motor (set rotation speed not reached)	Check machine for binding
Err: 74	No synchronisation impulse from sewing head	Check transmitter
Err: 92	Start inhibitor running during drive	Check end switch
Err: 173	Motor not connected	Check motor connection

9 Input

9.01 Seam programming



The display diagrams shown below serve as an example for the corresponding input possibilities. The set values described on the machine may differ from these.

- Switch on the machine.

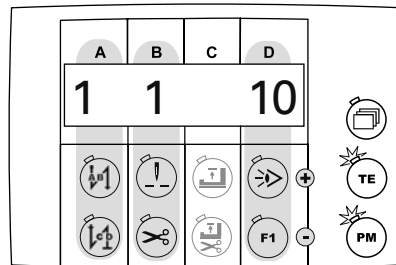


- Select programmed sewing function by pressing the "PM" key (LED on the selection key is illuminated).

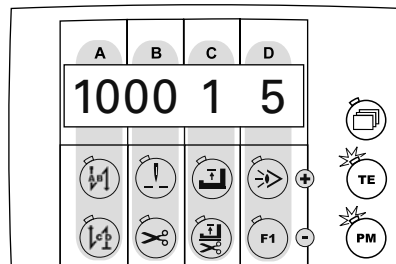


- Switch on the "TE / input" function (LED is illuminated).

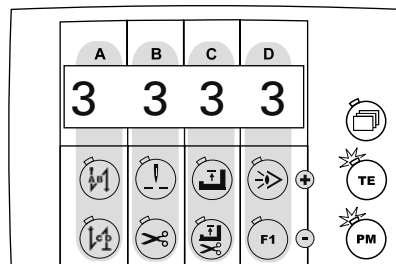
The set values for seam program number, seam segment number and number of seam segment stitches appear on the display.



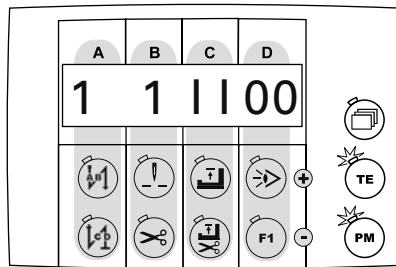
- Further set values can be called up as follows by pressing the selection key "scroll":
 - Seam program speed, seam program number of next program and number of seam segments



Start and end bartacks



Seam program number, seam segment and special function



- The set values can be adjusted in each case by pressing the corresponding function keys.

9.01.01 Selecting the seam program number and seam segment

- Switch on the machine.



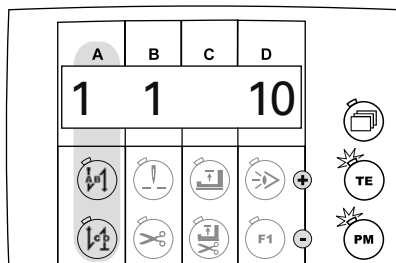
- Select programmed sewing function by pressing the "PM" key (LED on the selection key is illuminated).



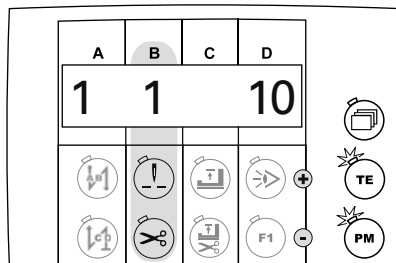
- Switch on the "TE / input" function (LED is illuminated).



- Press the selection key until the seam program number appears on the display together with the seam segment number and the number of seam segment stitches.



- Select the seam program number with the corresponding function keys. Up to 5 different seam programs can be selected.



- Select the seam segment with the corresponding function keys.



- If necessary select further set values

or



- "Switch off the "TE / input" function (LED is off).

9.01.02 Entering the speed, next program and number of seam segments

- Switch on the machine.



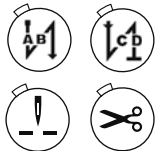
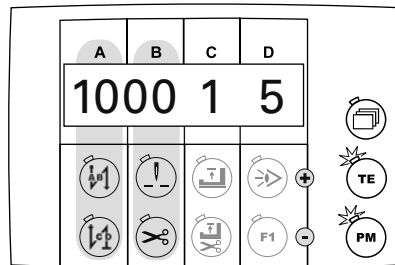
- Select programmed sewing function by pressing the "PM" key (LED on the selection key is illuminated).



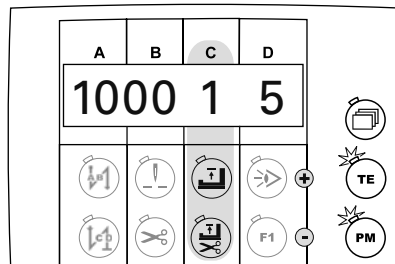
- Switch on the "TE / input" function (LED is illuminated).



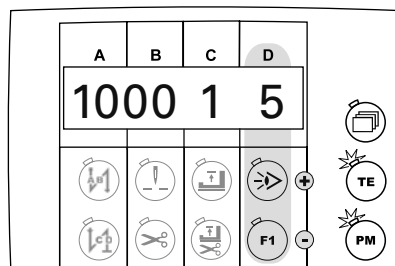
- Press the selection key until the display for entering the speed, the next program and the number of seam segments appears on the screen.



- Select the desired speed for the current seam program with the corresponding function keys.



- Select the seam program number for the desired next program with the corresponding function keys. The next program is called up automatically after the current seam program has been completed.



- Specify the number of seam segments in the current seam program with the corresponding function keys. Up to 9 seam segments can be defined for each seam program.



- If necessary select further set values

or



- "Switch off the "TE / input" function (LED is off).

9.01.03 Entering bartack stitches

- Switch on the machine.



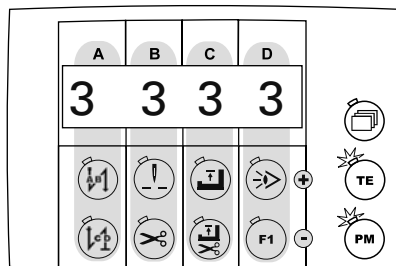
- Select programmed sewing function by pressing the "PM" key (LED on the selection key is illuminated).



- Switch on the "TE / input" function (LED is illuminated).



- Press the selection key until the display for entering the bartack stitches appears on the screen.



- Select the desired number of stitches for each case with the corresponding function keys.



Number of forward stitches for the start bartack (setting range A)



Number of reverse stitches for the start bartack (setting range B)



Number of reverse stitches for the end bartack (setting range C)



Number of forward stitches for the end bartack (setting range D)






- If necessary select further set values

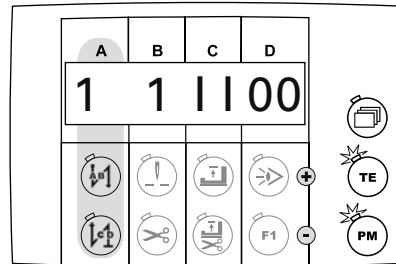
or





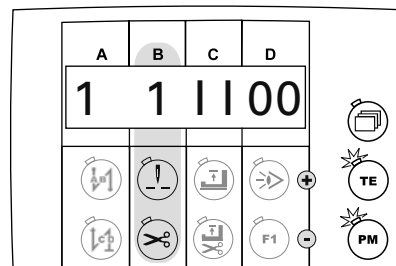
- "Switch off the "TE / input" function (LED is off).



9.01.04 Entering special functions

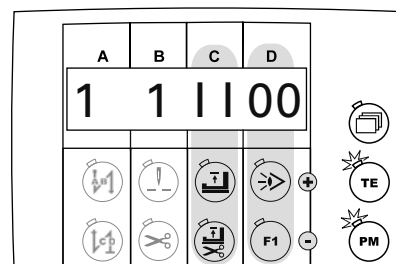
- Switch on the machine.
-  ● Select programmed sewing function by pressing the "PM" key (LED on the selection key is illuminated).
-  ● Switch on the "TE / input" function (LED is illuminated).
-  ● Press the selection key until the display for entering special functions appears on the screen.



-   ● If necessary, select the desired seam program with the corresponding function keys (setting range A).



-   ● If necessary, select the desired seam segment with the corresponding function keys (setting range B).



- Allocate the desired special functions with the following function keys for the selected seam segment (setting range C + D).



Switching the "stop at end of seam" function on/off (1 = on; 0 = off)

If the function is switched on, the machine stops automatically at the end of the selected seam segment.



Switching the "constant speed" function on/off (1 = on; 0 = off)

If the function is switched on, the selected seam segment is sewn constantly at the selected speed. If the function is switched off, the appropriate pedal setting is used for the adjustment until the set speed is reached.



Switching the feed changeover function on/off (1 = on; 0 = off)

If the function is switched on, the feed unit is switched at the end of the selected seam segment.



Switching the manual seam segment on/off (1 = on; 0 = off)

If the function is switched on, the selected seam segment is sewn without stitch counting. The end of the seam segment is called up with the pedal function.



- Select further set values

or



- "Switch off the "TE / input" function (**LED is off**).

9.01.05 Entering the seam segment stitches

- Switch on the machine.



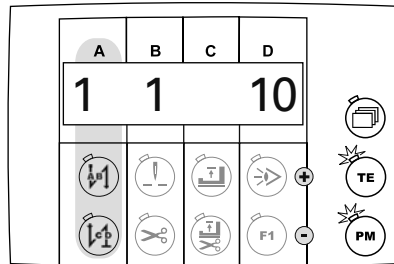
- Select programmed sewing function by pressing the "PM" key (LED on the selection key is illuminated).



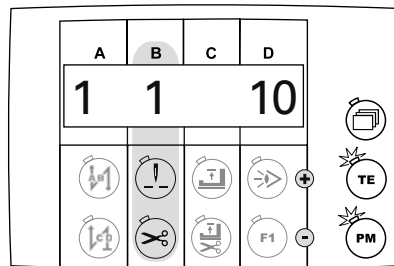
- Switch on the "TE / input" function (LED is illuminated).



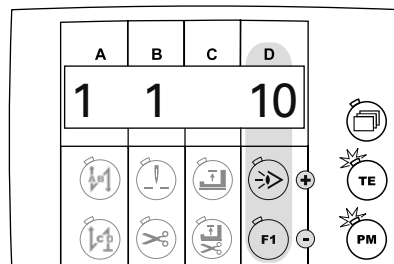
- Press the selection key until the seam program number appears on the display together with the seam segment number and the number of seam segment stitches.



- If necessary, select the seam program number with the corresponding function keys.



- Select the desired seam segment with the corresponding function keys.



- Enter the desired number of seam segment stitches for the selected seam segment with the corresponding function keys. A maximum of 250 stitches can be entered.



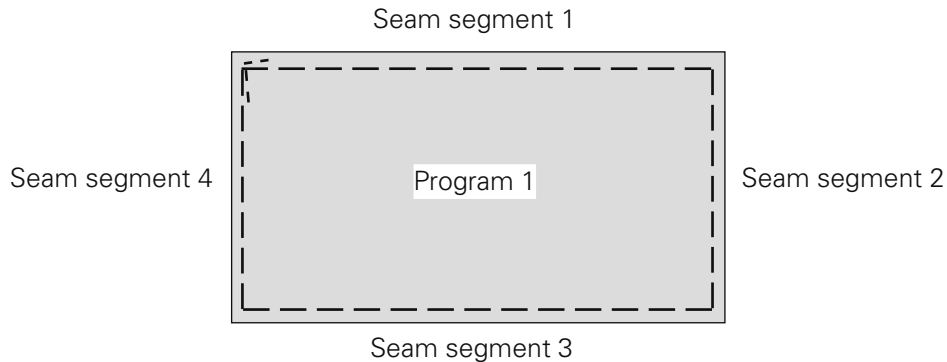
- Select further set values

or



- "Switch off the "TE / input" function (LED is off).

9.02 Example of how to enter a seam program



Example: Attaching a label

- Program number: 1
- Speed: 1500 min-1
- Seam segment 1
with 20 stitches, start bartack, programmed stop and raise sewing foot at end of seam
- Seam segment 2
with 10 stitches, programmed stop and raise sewing foot at end of seam
- Seam segment 3
with 20 stitches, programmed stop and raise sewing foot at end of seam
- Seam segment 4
with 10 stitches, end bartack, programmed stop and raise sewing foot at end of seam and thread trimming

- Switch on the machine.



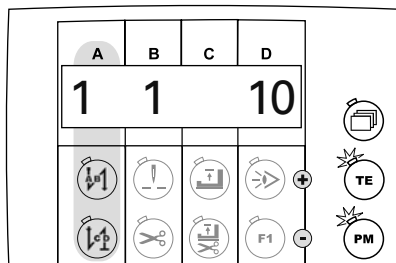
- Select programmed sewing function by pressing the "PM" key (LED on the selection key is illuminated).



- Switch on the "TE / input" function (LED is illuminated).



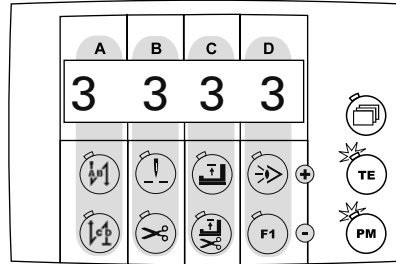
- Press the selection key until the seam program number appears on the display together with the seam segment number and the number of seam segment stitches.



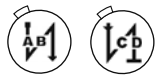
- Select the seam program number "1" with the corresponding function keys.



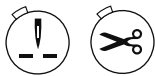
- Press the selection key until the display for entering the bartack stitches appears on the screen.



- Select the desired number of stitches for each case with the corresponding function keys.



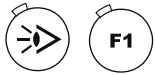
Number of forward stitches for the start bartack (setting range A)



Number of reverse stitches for the start bartack (setting range B)



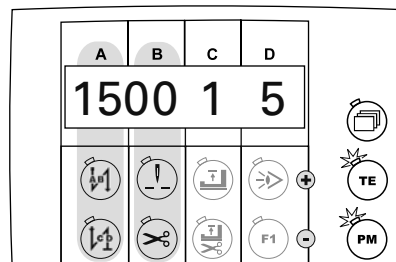
Number of reverse stitches for the end bartack (setting range C)



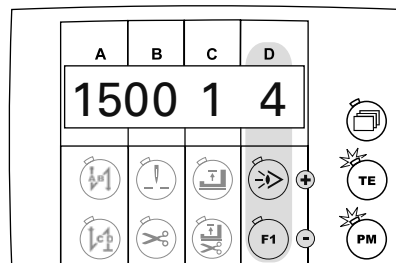
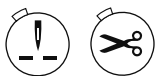
Number of forward stitches for the end bartack (setting range D)



- Press the selection key until the display for entering the speed, the next program and the number of seam segments appears on the screen.



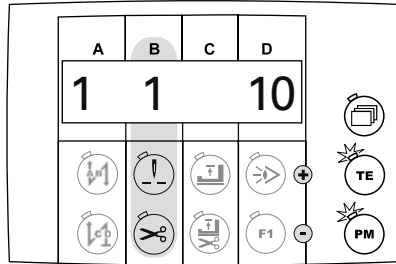
- Using the corresponding function keys, select the speed "1500" for the current seam program.



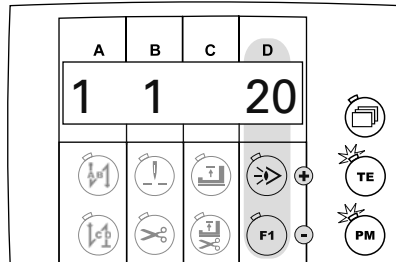
- Using the corresponding function keys, specify the number of seam segments ("4") in the current seam program.



- Press the selection key until the display for the seam program number appears on the screen together with the seam segment number and the number of seam segment stitches.



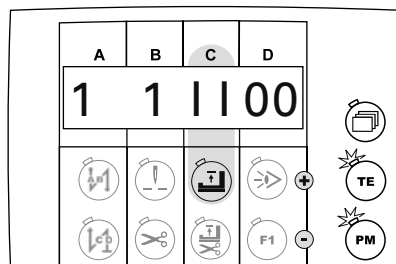
- Using the corresponding function keys, call up seam segment "1".



- Enter the number of seam segment stitches ("20") for seam segment "1" with the corresponding function keys.



- Press the selection key until the display for entering the special functions appears on the screen.



- Using the corresponding function key, switch on the "stop at end of seam" function (I = on; 0 = off).



- "Switch off the "TE / input" function (LED is off).

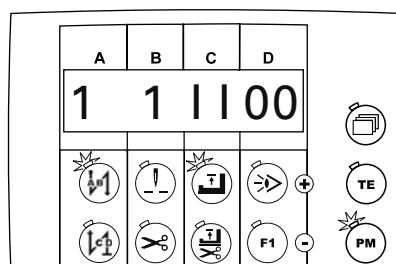
- Enter the sewing functions for the seam sector "1":



Switch on start bartack (LED is illuminated).



Switch on the "foot position raised after sewing stops" function (LED is illuminated).

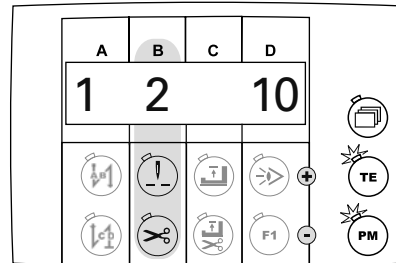




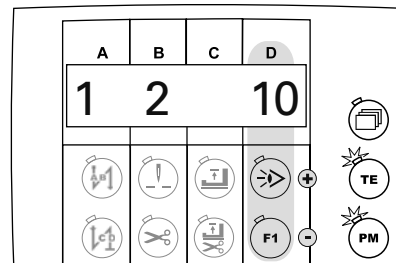
- Switch the "TE / input" function on again (LED is illuminated).



- Press the selection key until the display for the seam program number appears on the screen together with the seam segment number and the number of seam segment stitches.



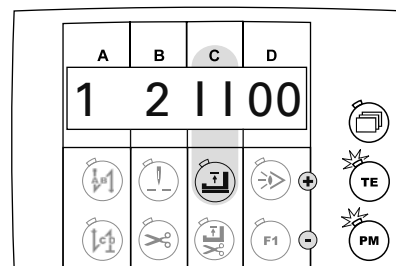
- Using the corresponding function keys, call up seam segment "2".



- Enter the number of seam segment stitches ("10") for seam segment "2" with the corresponding function keys.



- Press the selection key until the display for entering the special functions appears on the screen.



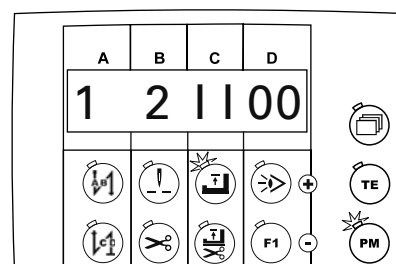
- Using the corresponding function key, switch on the "stop at end of seam" function (1 = on; 0 = off).



- "Switch off the "TE / input" function (LED is off).



- Switch on the "foot position raised after sewing stops" function (LED is illuminated).

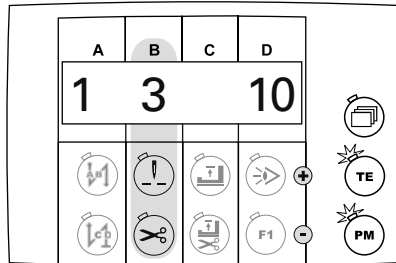




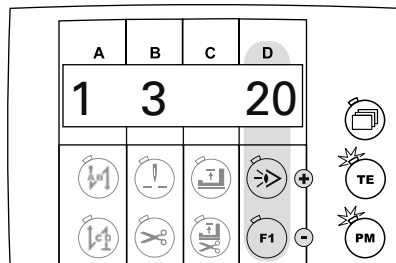
- Switch the "TE / input" function on again ((LED is illuminated)



- Press the selection key until the display for the seam program number appears on the screen together with the seam segment number and the number of seam segment stitches.



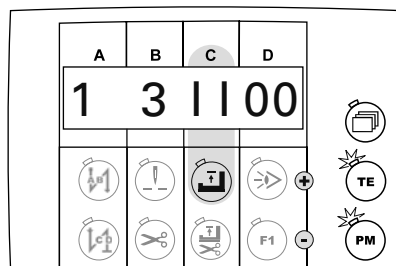
- Using the corresponding function keys, call up seam segment "3".



- Enter the number of seam segment stitches ("20") for seam segment "3" with the corresponding function keys.



- Press the selection key until the display for entering the special functions appears on the screen.



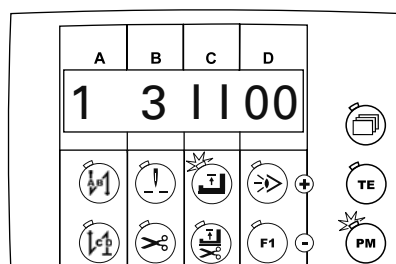
- Using the corresponding function key, switch on the "stop at end of seam" function (I = on; 0 = off).



- "Switch off the "TE / input" function (LED is off).



- Switch on the "foot position raised after sewing stops" function (LED is illuminated).

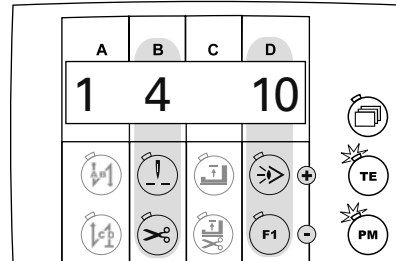




- Switch the "TE / input" function on again ((LED is illuminated).



- Press the selection key until the display for the seam program number appears on the screen together with the seam segment number and the number of seam segment stitches.



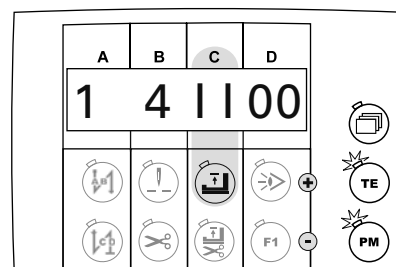
- Using the corresponding function keys, call up seam segment "4".



- Enter the number of seam segment stitches ("10") for seam segment "4" with the corresponding function keys.



- Press the selection key until the display for entering the special functions appears on the screen.



- Using the corresponding function key, switch on the "stop at end of seam" function (I = on; 0 = off).



- "Switch off the "TE / input" function (LED is off).

- Enter the sewing functions for the seam sector "4":



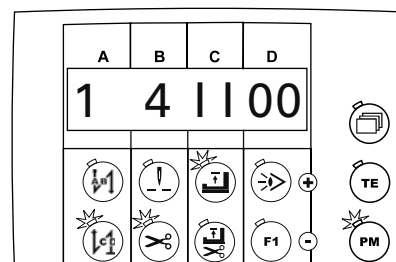
Switch on end bartack (LED is illuminated)



Switch on the "foot position raised after sewing stops" function (LED is illuminated)



Switch on the thread trimming function ((LED is illuminated)



9.03 Parameter input

9.03.01 Example of how to enter the parameters

- Switch on the machine.



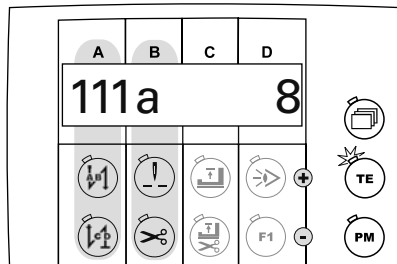
- Select the manual sewing mode by pressing the "PM" key (LED in the selection key is off).



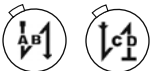
- Switch on the "TE / input" function (LED is illuminated).



- Press the selection key until the following display appears on the screen.



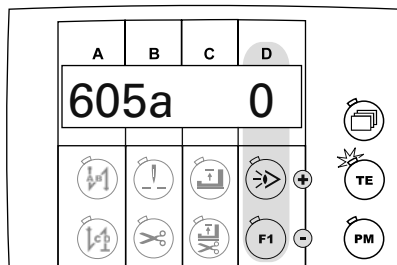
- Select the desired parameter, e.g. "605" Speed display on/off, by pressing the corresponding function keys.



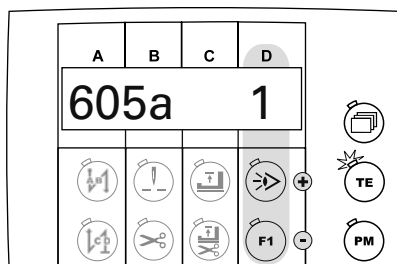
Function keys for selecting the hundred figure of the parameter



Function keys for selecting the ten and unit figures of the parameter



- Press the corresponding function keys to alter the set value as desired, e.g. "1" for speed display or "0" for no speed display.



- "Switch off the "TE / input" function (LED is off).

9.03.02 Selecting the user level

- Switch on the machine.



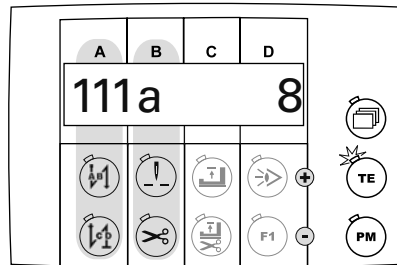
- Select the manual sewing mode by pressing the "PM" key (LED in the selection key is off).



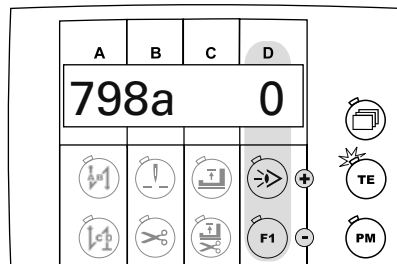
- Switch on the "TE / input" function (LED is illuminated)..



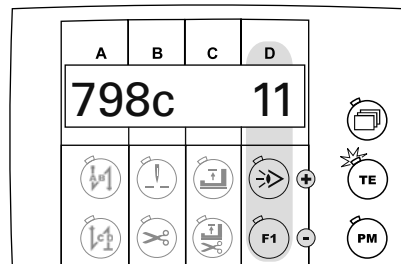
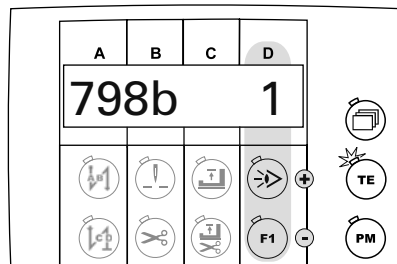
- Press the selection key until the following display appears on the screen.



- Select parameter "798" by pressing the corresponding function keys.



- The standard set value is set at "0" (= operator level "A"). Press the corresponding function keys to select the desired user level.



Set value "0"	=	User level "A"
Set value "1"	=	Mechanic level "B"
Set value "11"	=	Service level "C"

The selected user level is shown next to the parameter number.



- "Switch off the "TE / input" function (LED is off).



If the main switch is switched off and on again, the machine changes back automatically to user lever "A".

9.03.03 Functional overview of parameters



All available functions are shown in column "**Function**". The column "**Parameter**" contains the parameters required for the activation of the respective function.

Function	Parameter
Acceleration	722
Backtack	105, 110, 364, 523, 584, 585
Bearing position	653, 789
Brake	723
Catcher	707
Control	881, 884, 885, 886, 887, 889, 890, 900
Darning program	313
Direction of rotation	800
Display	605, 933
End backtack	110, 939, 968
Hardware-test	797
Knife	105, 110, 427
Machine class	799
Machine run	422, 438
Motor	897
Motor start lock-out	665
Needle position	522, 700, 702, 703, 446, 488, 748
Needle position change-over	446, 488, 748
Needle up without trimming	446, 488, 710, 748
Number of stitches	111, 112, 445, 499
Ornamental tack	522, 523, 530, 775
Photocell	111, 112, 113, 199, 615
Presser foot	427, 636, 642, 651, 688, 719, 729, 730, 770
Program	206, 313
Programming level	798
Puller	422, 427, 445, 499

Function	Parameter
Reverse rotation	618, 623, 801
Seam end	110, 206
Seam start	105, 989
Single stitch	446, 488, 748
Soft start	116, 117
Speed	105, 110, 117, 199, 530, 585, 586, 605, 606, 607, 608, 609
Speed limitation	117, 199, 585, 586
Standstill brake	718
Start	113
Start delay	729, 189, 190, 623, 642, 643, 730, 761, 770, 939, 968, 969
Start tack	105, 939, 968
Stitch condensation	105, 110, 364
Stop	206, 427, 665
Stop time	775
Switch-on time	189, 190, 715, 889
Tack inversion	446, 748
Tack suppression	446, 748
Tacting output	538, 642, 643, 705, 719, 721, 734
Thread clamp	422, 969, 985, 986, 989
Thread tension release	538, 636, 688, 707, 761
Thread trimming	438, 609, 705, 706, 734, 795
Thread wiper	422, 668, 715
Transport change	364, 643, 721, 939, 968, 969
Troubleshooting	797

9.03.04 List of parameters



Only appropriately trained personnel is authorized to alter the set values in the parameters of user level "B" and "C".

Group	Parameter	Description	User level	Setting range	Set value
1	105	Speed at seam start	B	300 - 2000	
		571, 574, 591			700
		1180			1600
		1525S			1000
		580			1400
	110	Speed at seam end	B	300 - 2000	
		571, 574, 591			700
		1180			1600
		1525S			1000
		580			1400
	111	Light barrier compensating stitches	A	1 - 30	8
	112	No. of stitches for blocking out light barrier for knitted fabrics	B	0 - 100	0
	113	Start with light barrier 1 = only if light barrier dark 0 = also when light barrier bright	B	0 - 1	0
	116	Soft starting stitches (soft start)	A	0 - 30	
		571, 574, 591, 1525S			0
		580, 1180			1
	117	Speed for soft starting stitches (soft start)	B	120 - 1000	
		571, 574, 591, 1525S			400
		580, 1180			1000
	180	Number of pieces	A	0 - 1	0
	189	Drive runtime in life test in 0.1sec	C	10 - 600	50
	190	Drive stop time in life test in 0.1sec	C	10 - 600	50
	199	Speed for light barrier compensating stitches	B	300 - 2000	1200
2	206	Interrupt /stop seam section at fixed speed 1 = with pedal -2, 0 = with pedal 0	B	0 - 1	0
3	313	Programs are backtack programs 1 = yes, 0 = no	A	0 - 1	0
	364	Transport change-over means for 1 = Back-tack 0 = Stitch condensation	A	0 - 1	1

Group	Parameter	Description	User level	Setting range	Set value
4	422	Output Ax is 1 = wiper, 2 = thread clamp 3 = motor runs, 4 = lifting puller	B	1 - 4	
		571, 574, 591, 1180, 1525S			1
		580			2
	427	Operating mode of the input E4 1 = presser foot 2 = stroke adjustment 3 = control of puller 4 = stop	B	1 - 3	1
	438	Output Ax is 1 = motor run, 0 = trimming	B	0 - 1	0
	445	Stitches for puller delay	B	0 - 100	0
	446	Input E2 is 1 = needle raised without trimming 2 = needle position change 3 = single stitch 5 = tack inversion 6 = tack suppression 11 = Speed reduction	B	1 - 11	
		580, 1180, 1525S			1
		571, 574, 591			11
	488	Function of F1 key on control panel 1 = needle up without trimming 2 = needle position change 3 = single stitch 4 = single stitch with shortened stitch length 5 = tack inversion 6 = tack suppression	B	1 - 6	1
	499	Number of stitches for slowed down lowering of puller after operating knee switch	B	0 - 100	0
5	523	Tack 1 = ornamental tack (stitch-in-stitch) 0 = standard tack	A	0 - 1	
		580, 1180, 1525S			0
		571, 574, 591			1
	530	Maximum speed for ornamental tack	B	300 - 2000	
		571, 574, 591			700
		580, 1180, 1525S			1000

Group	Parameter	Description	User level	Setting range	Set value
5	538	Timing of output (thread tension release) (0 = 100 % starting	B	10 - 100	50
	584	Tack 1 = quadruple, 0 = double	B	0 - 1	0
	585	Speed limitation with tack	B	300 - 4800	1000
	586	Speed limitation	B	180 - 1500	600
6	605	Actual speed value in display 1 = on, 0 = off	A	0 - 1	0
	606	Minimum speed	B	120 - 800	180
	607	Maximum speed	B		
		580, 1180		300 - 6000	5000
		571, 574, 591, 1525S		300 - 3200	3000
	608	Speed stage curve (pedal characteristic) 0 = 12 stages non-linear 1 = 12 stages linear 2 = 24 stages non-linear 3 = 24 stages linear 4 = stages 1..8 minimum speed, stages 9...24 linear	B	0 - 4	
		580, 1180, 1525S			1
		571, 574, 591			0
	609	Trimming speed 1	B	100 - 700	
		574, 591, 1525S			180
		1180			210
		580			220
	615	End recognition with light barrier 1 = from bright to dark 0 = from dark to bright	B	0 - 1	0
	618	Return after seam end 1 = yes, 0 = no	B	0 - 1	0
	623	Switch-on delay for return in [ms]	B	50 - 9000	100
	636	Thread tension release in conjunction with presser foot lift 1 = yes, 0 = no	B	0 - 1	0
	642	Presser foot lift time from switch-on to ten- sion reduction	B		
		571, 574, 591		10 - 200	100
		580, 1180, 1525S		10 - 150	100

Group	Parameter	Description	User level	Setting range	Set value
6	643	Feed adjustment time from switch on to tension reduction	B		
		571, 574, 591		10 - 200	100
		580, 1180, 1525S		10 - 150	100
	651	Presser foot with automatic descent on machine stop. 1 = yes, 0 = no	B	0 - 1	1
	653	Bearing position before sewing 1 = yes, 0 = no	B	0 - 1	0
	665	Lock/stop when 1 = contact closed, 0 = contact open	B	0 - 1	
		1525S			1
		571, 574, 580, 591, 1180			0
	668	Thread wiper 1 = yes, 0 = no	B	0 - 1	0
	688	Thread tension release in conjunction with presser foot lift during intermediate stop, if parameter 636 is at ON 1 = on, 0 = off	B	0 - 1	1
7	700*	Needle position 0 Needle reference position	B	0 - 255	0
	702	1 st needle position (lowered)	B	0 - 255	
		571, 574, 591			15
		580			79
		1180			90
		1525S			70
	703	Thread take-up lever position raised	B	0 - 255	
		574			230
		580			222
		571, 591			224
		1180			236
		1525S			234

* = These parameters remain unchanged when the set parameter values are reset, see Chapter 10.01.02 Resetting the set parameter values.

Group	Parameter	Description	User level	Setting range	Set value
7	705	End of cutting signal	B	0 - 255	
		571, 574, 591			100
		580			175
		1180			200
		1525S			186
	706	Start of cutting signal	B	0 - 255	
		571, 574, 591			17
		580			135
		1180			136
		1525S			85
	707	Start thread tension release	B	0 - 255	
		571, 574, 591			180
		580			190
		1180			164
		1525S			192
	710	Needle position raised	B	0 - 255	184
	715	Switch-on time [ms] for thread wiper	B	0 - 9000	60
	718	Stop brake tacting (0 = brake off)	B	0 - 50	
		571, 574, 591, 580, 1180			0
		1525S			20
	719	Tacting output (presser foot) starting in [%]	B		
		571, 574, 591, 580, 1180		10 - 60	40
		1525S		10 - 100	100
	721	Tacting output (feed adjustment) starting in [%]	B		
		571, 574, 591		10 - 90	70
		580, 1180		10 - 90	40
		1525S		10 - 100	100
	722	Acceleration ramp for sewing motor, 1 = flat	B		
		571, 574, 591		1 - 30	20
		580		1 - 40	40
		1180		1 - 30	22
		1525S		1 - 30	18
	723	Brake ramp for sewing motor, 1 = flat	B		
		574		1 - 30	17
		580		1 - 40	25
		571, 591, 1180		1 - 30	22
		1525S		1 - 30	18

Group	Parameter	Description	User level	Setting range	Set value
7	729	Start delay after lowering presser foot [ms]	B	10 - 9000	
		571, 574, 591, 1525S			120
		580			70
		1180			20
	730	Lift delay for presser foot at end of seam	B	0 - 9000	
		580, 1180			0
		571, 574, 591, 1525S			50
	734	Tacting output(cutting magnetic)	B	0 - 100	10
	748	Input E3 is 1 = needle up without trimming 2 = needle position change-over 3 = single stitch 5 = backtack inversion 6 = backtack suppression 11 = Speed reduction	B	1 - 11	1
	757	Stop position for ornamental tack	B	0 - 255	
		1180			90
		571, 574 , 591			45
		1525S			70
		580			79
	761	Extension thread tension release / thread pulling [ms]	B	0 - 80	0
	770	Lifting delay for presser foot when pedal position is "-1" [ms]	B	10 - 250	110
	775	Stop time for ornamental tack [ms]	B	10 - 1000	
		571, 574, 591			120
		580, 1180, 1525S			150
	789	Needle position 10 (bearing position)	B	0 - 255	
		571, 574, 591,580, 1180			248
		1525S			240
	795	Output A5 1 = Output is LED keypad 0 = Output is trimming pneumatic	B	0 - 1	
		571, 574, 591			1
		580, 1180, 1525S			0
	797	Hardware test, 0 = off, 1 = on	C	0 - 1	0

Group	Parameter	Description	User level	Setting range	Set value
7	798	User level 0 = user level A, 1 = mechanic level B 11 = service level C	A	0 - 20	0
	799*	Selected machine class	C	1 - 7	
		1180			2
		571, 591			4
		1525S			5
		574			6
		580			7
8	800*	Motor rotating direction when looking at V-belt pulley 1 = anti-clockwise, 0 = clockwise	C	0 - 1	
		1180			0
		571, 574, 580, 591, 1525S			1
	801	Reversing angle at end of seam	B	10 - 212	
		571, 574, 580, 591, 1180			32
		1525S			40
	802*	Speed reduction main drive 1 = variable, 0 = 1:1	C	0 - 1	
		571, 580, 591, 1180			0
		574, 1525S			1
	881	Adaptation of positioning behaviour of motor to the machine to avoid vibrations	C	10 - 200	100
	884	Proportional amplification of speed control of sewing motor	B	5 - 40	
		574			22
		571, 591			35
		580, 1180, 1525S			20
	885	Integral amplification of speed control of sewing motor	C	10 - 100	
		574,			45
		571, 591			48
		580, 1180, 1525S			55

* = These parameters remain unchanged when the set parameter values are reset, see Chapter 10.01.02 Resetting the set parameter values.

Group	Parameter	Description	User level	Setting range	Set value
8	886	Proportional amplification of positioning controller (sewing motor)	C	1 - 100	
		574, 1180			8
		571, 591			2
		580			12
		1525S			27
	887	Differential amplification of positioning controller (sewing motor)	C	10 - 100	
		580			55
		574			40
		571, 591			47
		1180			60
		1525S			20
	889	Time for positioning control in [ms], 0 = always	C	0 - 2500	
		571, 574, 580, 591, 1180			300
		1525S			120
	890	Proportional amplification of stop brake	C	1 - 200	
		574, 580, 591, 1180			25
		1525S			100
	897*	MINI-motor variant 1 = long, 0 = short	C	0 - 1	
		580, 1180			0
		571, 574, 591, 1525S			1
9	900	Proportional amplification of speed controller during trimming	B	5 - 50	25
	933	Switchover of display on screen (diagnosis display)	C	0 - 4	0
	939	Hold-back time (premature electrical switchover) for feed adjustment when switching on [ms]	B	10 - 200	
		571, 574, 591			20
		580			34
		1180			30
		1525S			60

* = These parameters remain unchanged when the set parameter values are reset, see Chapter 10.01.02 Resetting the set parameter values.

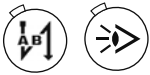
Group	Parameter	Description	User level	Setting range	Set value
9	968	Hold-back time (premature electrical switchover) for feed adjustment when switching off [ms]	B	10 - 200	
		580			40
		571, 574, 591			11
		1180			30
		1525S			50
	969	Switch off position for presser foot when thread is clamped at beginning of seam	B	0 - 255	100
	985	Switch on position for thread clamp	B	0 - 255	67
	986	Switch off position for thread clamp	B	0 - 255	206
	989	Thread clamp at beginning of seam 0 = Thread clamp off 1 = Thread clamp without presser foot lift 2 = Thread clamp with presser foot lift	B	0 - 2	0

10 Service functions

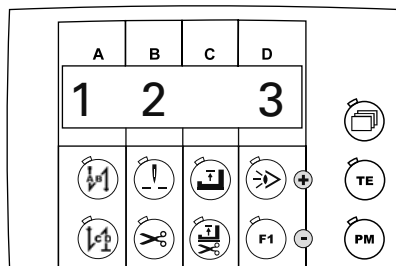
10.01 Resetting the control unit

10.01.01 Calling up the reset function

- Switch off the machine.



- Press and hold the "start bartack" and "sewing with light barrier" function keys simultaneously and switch on the machine. Continue pressing the function keys until the following display appears on the screen.



The reset function offers three different reset possibilities:

- Parameter Reset, see Chapter 10.01.02 Resetting the set parameter values
- Seam Program Reset, see Chapter 10.01.03 Deleting all seam programs
- Cold start, see Chapter 10.01.04 Cold start



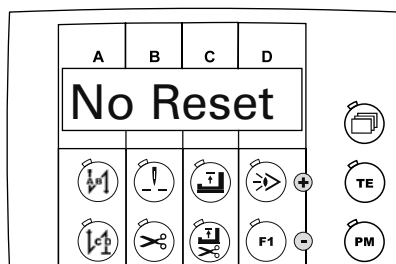
Danger of unintentional data loss!

After operating the corresponding function key, the selected reset is carried out without further check.



- If the "TE / input" selection key is pressed, the machine switches back to its previous status, without carrying out a reset.

The following display appears on the screen for a short time.



10.01.02 Resetting the set parameter values

With this function all set values, with the exception of the specially marked parameters, are set back to their default value (status at time of delivery), see Chapter 9.03.04 List of parameters.

- Call up the reset function, see Chapter 10.01.01 Calling up the reset function.

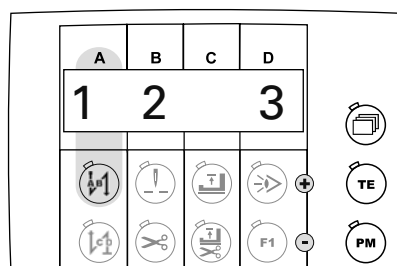


Danger of unintentional data loss!

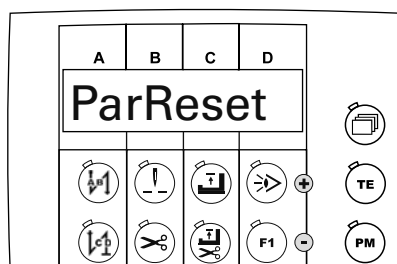
After operating the corresponding function key, the selected reset is carried out without further check.



- Reset the set parameter values by pressing the corresponding function key.



The set parameter values are reset. The following display appears on the screen for a short time.



After the operation is completed, the previous machine status is called up again automatically.

10.01.03 Deleting all seam programs

With this function all seam program inputs are deleted.

- Call up the reset function, see Chapter 10.01.01 Calling up the reset function.

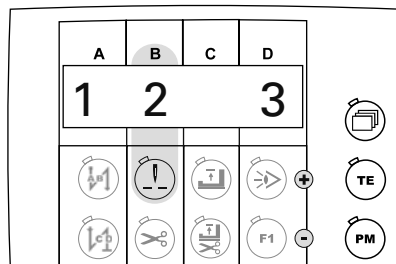


Danger of unintentional data loss!

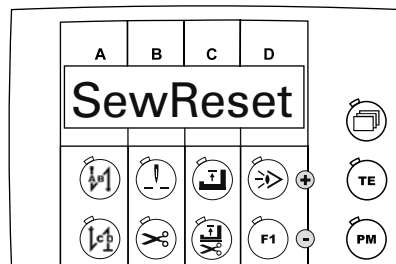
After operating the corresponding function key, the selected reset is carried out without further check.



- Delete the seam program inputs by pressing the corresponding function key.



The seam program inputs are deleted. The following display appears on the screen for a short time.



After the operation is completed, the previous machine status is called up again automatically.

10.01.04 Cold start

With this function a cold start is carried out. All inputs are deleted and all set parameter values are set back to their default value (status at time of delivery), see Chapter 9.03.04 **List of parameters**.

- Call up the reset function, see Chapter 10.01.01 **Calling up the reset function**.

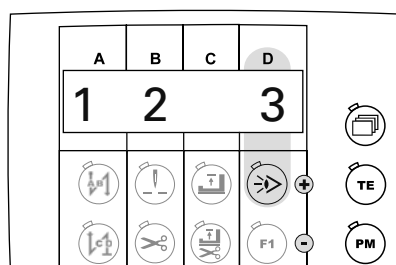


Danger of unintentional data loss!

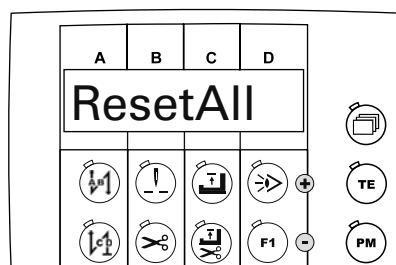
After operating the corresponding function key, the selected reset is carried out without further check.



- Reset the set parameter values by pressing the corresponding function key.



The cold start is carried out. The following display appears on the screen for a short time.



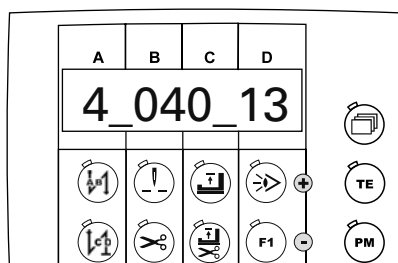
After the operation is completed, the previous machine status is called up again automatically.

10.02 Display of software version and current machine class for

- Switch off the machine.

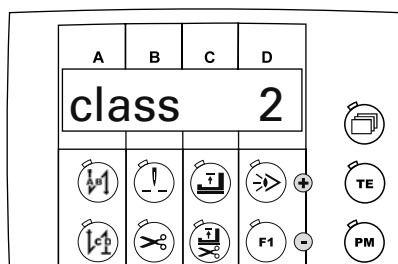


- Hold the "scroll" key pressed down and switch on the machine.
The current software version is displayed, until any key is pressed.



- Press any key.

The current machine class is shown for about 3 seconds.



10.03 Hardware test

- Switch on the machine.



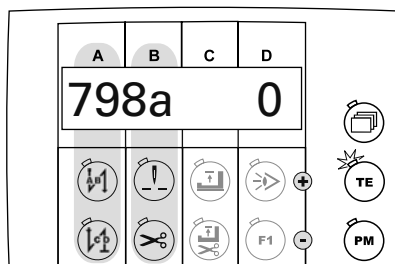
- Select the manual sewing mode by pressing the "PM" key (LED in the selection key is off).



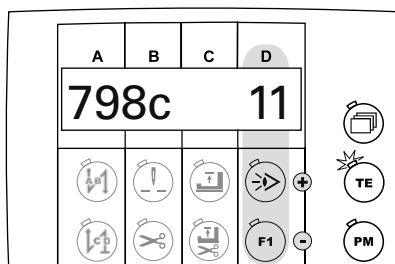
- Switch on the "TE / input" function (LED is illuminated).



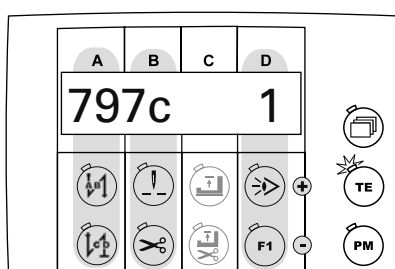
- Press the selection key until the parameter input function appears on the screen.



- Select parameter "798" by pressing the corresponding function keys.



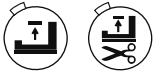
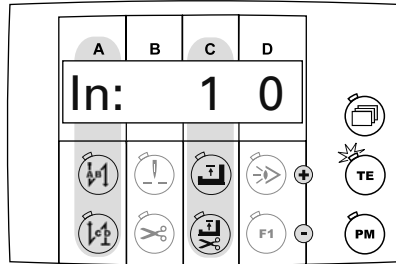
- Select service level "C" by pressing the corresponding function keys.



- Select parameter "797" by pressing the corresponding function keys.



- Set the set value at "1" by pressing the corresponding function keys.
The first test block showing the inputs appears on the display.



- Select the desired input with the corresponding function keys (setting range C).

The switch status of the current input is shown in setting range D.

Following inputs can be shown:

In 1: E1 / TUM manual

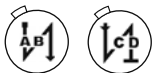
In 2: E2 / various functions, selection with parameter "446"

In 3: E3 / various functions, selection with parameter "748"

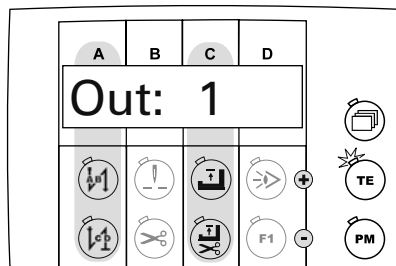
In 4: E4 / tilt lock

In 5: E5 / knee switch presser foot

In LB: Light barrier



- Call up the display of the outputs with the corresponding function keys.



- Select the desired output with the corresponding function keys (setting range C).

Out 1: Presser foot tacted

Out 2: Feed changeover tacted

Out 3: Magnetic cutting tacted

Out 4: Thread tension release (tacted in hardware test with fixed 50%)

Out 5: Pneumatic cutting

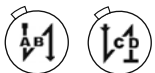
Out 6: Wiper



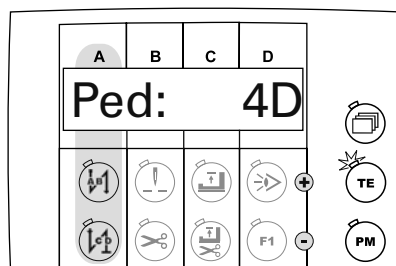
- Switch on selected output.



- Switch off selected output.



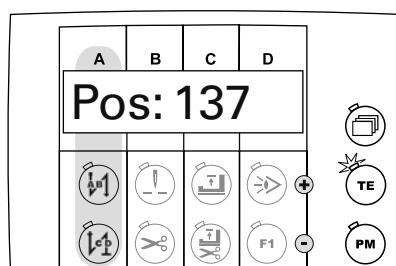
- Select the test mode for the pedal with the corresponding function keys.



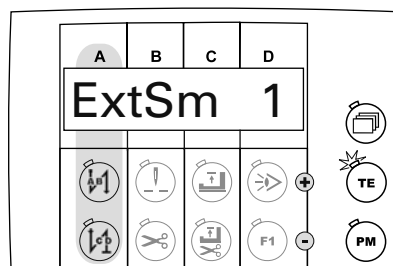
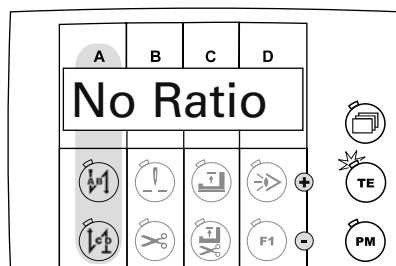
- Operate the pedal.
The activated pedal stages are shown in setting range D.



- Call up the test for the synchronizer in the motor with the corresponding function keys.



- Turn the balance wheel and check the needle bar reference position (parameter "700").
- With the corresponding function keys, call up the speed reduction test.
The speed reduction or increase ratio status of the motor is displayed. The adjustment is carried out with parameter "802".

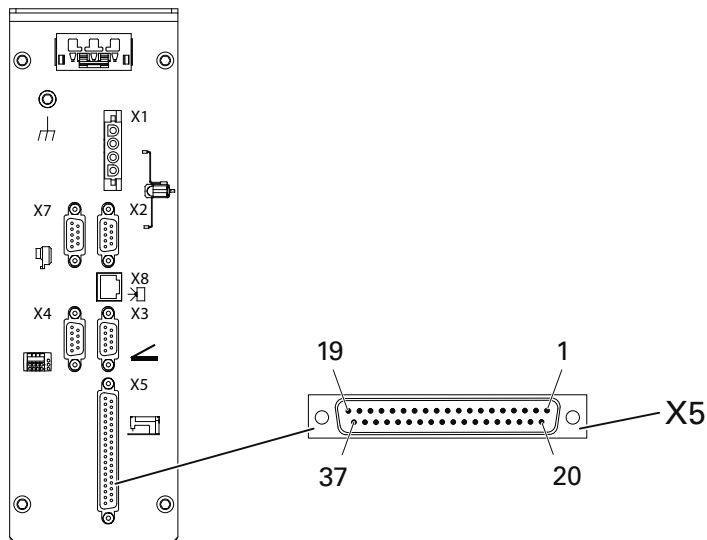


- Conclude the hardware test (LED in the selection key is off).



If the main switch is switched off and on again, the machine changes back automatically to user lever "A".

11 Pin assignment of plug X5



11.01 Inputs

Input No.	Name	Pin-No.
1	Feed reverse	5
2	Functions under parameter 446 1 = needle raised without trimming 2 = needle position change 3 = single stitch 5 = tack inversion 6 = tack suppression 11 = Speed reduction	6
3	Functions under parameter 748 1 = needle up without trimming 2 = needle position change-over 3 = single stitch 5 = backtack inversion 6 = backtack suppression 11 = Speed reduction	14
4	Functions under parameter 427 1 = presser foot 2 = stroke adjustment 3 = control of puller 4 = stop 5 - 9 no function	10
5	Stop, safety device (not included in all machine models)	11
	Photocell	

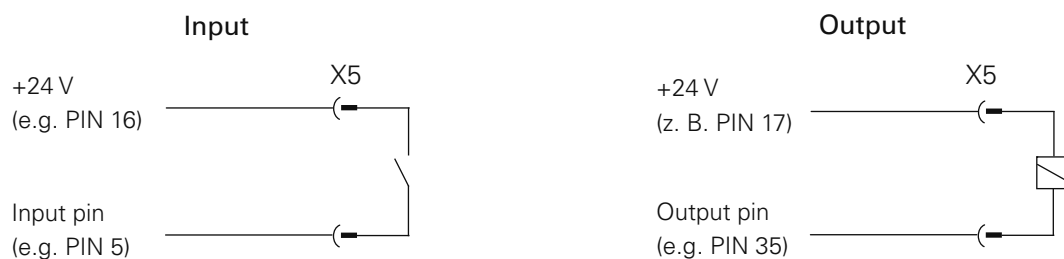
11.02 Outputs

Output No.	Name	Pin-No.
1	Presser foot lifting	35
2	Feed reverse	34
3	Functions under parameter 438 1 = motor run, 0 = trimming	30
4	Thread tension release	36
5	Functions under parameter 795 0 = Output is trimming pneumatic 1 = Output is LED keypad speed limitation over E2 or E3)	37
6	Functions under parameter 422 1 = wiper, 2 = thread clamp 3 = motor runs, 4 = lifting puller	27

11.03 Power supply

Pin-No.	Power supply
16, 17, 18, 26, 33	+24 V
4, 19	0 V

11.04 Switching example





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