PFAFF® Industrial

POWERLine

3721

DOKU-SEAM-SYSTEM

296-12-19 146/002
Betriebsanleitung engl. 04.13

PFAFF Industriesysteme
und Maschinen AG

Hans-Geiger-Str. 12 - IG Nord
D-67661 Kaiserslautern

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1 Safety

1.01 Directives

This machine is constructed in accordance with the European regulations contained in the conformity and manufacturer's declarations.
In addition to this Instruction Manual, also observe all generally accepted, statutory and other regulations and legal requirements and all valid environmental protection regulations! The regionally valid regulations of the social insurance society for occupational accidents or other supervisory organizations are to be strictly adhered to!

1.02 General notes on safety

- This machine may only be operated by adequately trained operators and only after having completely read and understood the Instruction Manual!
- All Notes on Safety and Instruction Manuals of the motor manufacturer are to be read before operating the machine!
- The danger and safety instructions on the machine itself are to be followed!
- This machine may only be used for the purpose for which it is intended and may not be operated without its safety devices. All safety regulations relevant to its operation are to be adhered to.
- When exchanging sewing tools (e.g. needle, roller presser, needle plate and bobbin), when threading the machine, when leaving the machine unattended and during maintenance work, the machine is to be separated from the power supply by switching off the On/Off switch or by removing the plug from the mains!
- Everyday maintenance work is only to be carried out by appropriately trained personnel!
- Repairs and special maintenance work may only be carried out by qualified service staff or appropriately trained personnel!
- Work on electrical equipment may only be carried out by appropriately trained personnel!
- Work is not permitted on parts and equipment which are connected to the power supply! The only exceptions to this rule are found in the regulations EN 50110.
- Modifications and alterations to the machine may only be carried out under observance of all the relevant safety regulations!
- 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 which are not supplied by us have not been tested and approved by us. The installation and/or use of any such products can lead to negative changes in the structural characteristics of the machine. We are not liable for any damage which may be caused by non-original parts.

1.03 Safety symbols

Danger!

Points to be observed..

Danger of injury for operating and specialist personnel!

Caution

Do not operate without finger guard and safety devices.

Before threading, changing bobbin and needle, cleaning etc. **switch off main switch.**

1.04 Important points for the user

- This Instruction Manual is an integral part of the machine and must be available to the operating personnel at all times.
- The Instruction Manual must be read before operating the machine for the first time.
- The operating and specialist personnel is to be instructed as to the safety equipment of the machine and regarding safe work methods.
- It is the duty of the user to only operate the machine in perfect running order.
- It is the obligation of the user to ensure that none of the safety mechanisms are removed or deactivated.
- It is the obligation of the user to ensure that only authorized persons operate and work on the machine.

Further information can be obtained from your PFAFF agent.

1.05 Operating and specialist personnel

1.05.01 Operating personnel

Operating personnel are persons responsible for the equipping, operating and cleaning of the machine as well as for taking care of problems arising in the sewing area.

The operating personnel is required to observe the following points and must:

- always observe the Notes on Safety in the Instruction Manual!
- never use any working methods which could adversely affect the safety of the machine!
- not wear loose-fitting clothing or jewelery such as chains or rings!
- also ensure that only authorized persons have access to the potentially dangerous area around the machine!
- always immediately report to the person responsible any changes in the machine which may limit its safety!

1.05.02 Specialist personnel

Specialist personnel are persons with a specialist education in the fields of electrics, electronics and mechanics. They are responsible for the lubrication, maintenance, repair and adjustment of the machine.

The specialist personnel is obliged to observe the following points and must:

- always observe the Notes on Safety in the Instruction Manual!
- switch off the On/Off switch before carrying out adjustments or repairs, and ensure that it cannot be switched on again unintentionally!
- wait until the luminous diode on the control box is no longer blinking or on before beginning adjustment or repair work.
- never work on parts which are still connected to the power supply! Exceptions are explained in the regulations EN 50110.
- replace the protective coverings and close the electrical control box afer all repairs or maintenance work!

1.06 Danger warnings

A working area of **1 m** must be kept free both in front of and behind the machine, so that easy access is possible at all times.

Never put your hands or fingers in the sewing area during sewing!
Danger of injury by the needle!

While setting or adjusting the machine do not leave any objects on the table nor in the needle plate area! Objects may be trapped or flung out of the machine!

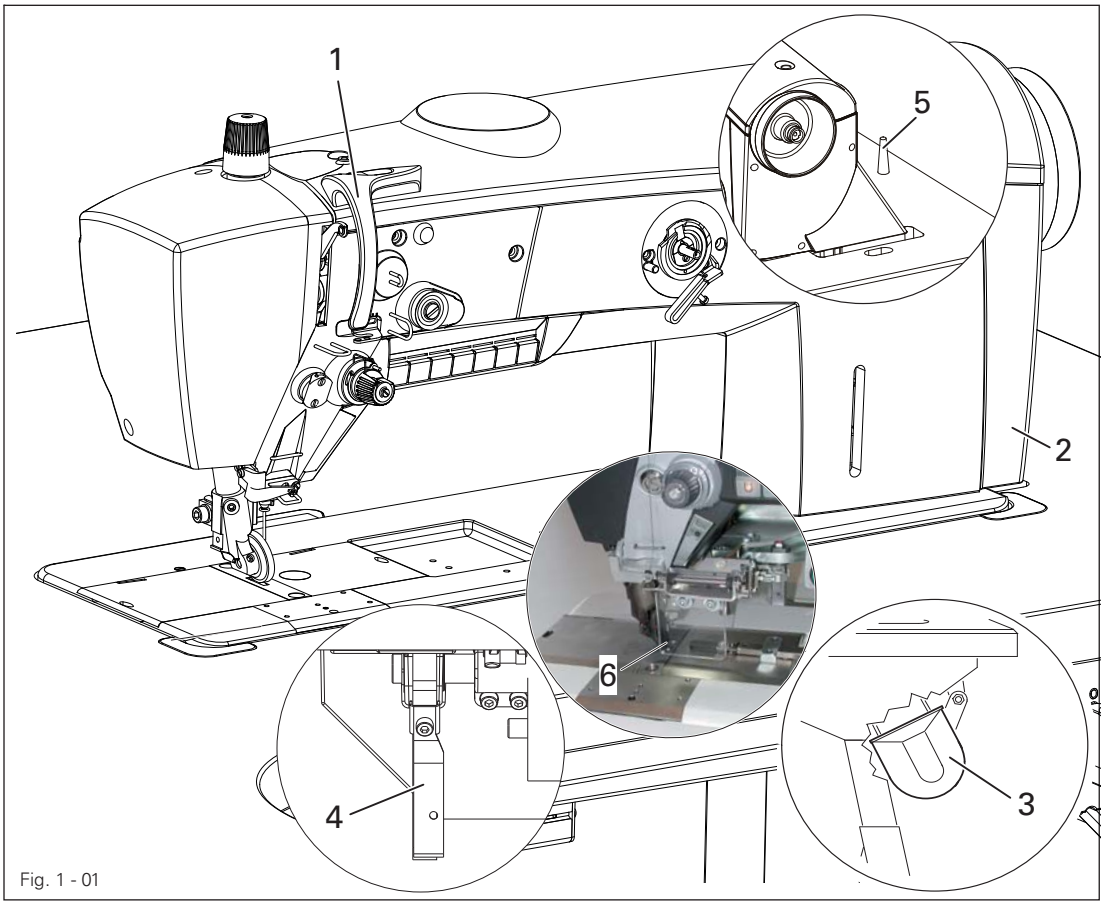


Fig. 1 - 01

Do not run the machine without take-up lever guard **1**!
Danger of injury by moving take-up lever!

Do not run the machine without belt guards **2** and **3**!
Danger of injury by rotating v-belt!

Do not operate the machine without tilt lock **4**!
Danger of crushing between sewing head and table!

Do not operate the machine without support **5**! Danger due to top-heavy sewing head! Machine can tip over backwards when tilted!

Do notuperate machine with edgecutter withoutfinger guard !
Danger of injury by knife!

PFAFF Industrial PFAFF Industriesysteme und Maschinen AG, 67661 Kaiserslautern

Declaration of acknowledgement of the documentation for the PFAFF-DOKU-SEAM-SYSTEM

Customer:.....

Address:.....

Machine: **PFAFF 3721** ..... Serial-Nr.: .....

PC-software: ..... Control software:.....

Each person working on the **PFAFF-DOKU-SEAM-SYSTEM** must be familiar with and understand the contents of these technical documents. The operating and qualified personnel must be appropriately authorised to handle the machine, i.e. qualified and instructed. The operator promises to train his personnel accordingly. Furthermore the user have to take care, to calibrate the machine, when the control-box or the thread-force-sensor was changed.

We hereby confirm that we have read and understood the documentation for the **PFAFF-DOKU-SEAM-SYSTEM**, and that in addition to the advice in the documentation, we will also follow the local safety and accident prevention regulations.

Place:..... Date:.....

Operator:.....

Register 02

PFAFF® Industrial

POWERLine

3721

SHORT INSTRUCTIONS FOR THE INPUT

This instruction manual applies to machines from software version **1.8** and serial number **2 772 129** onwards

Kurzanleitung zur Eingabe engl. 04.13

2 Input

2.01 General information

The effective pull of the needle thread (needle thread tension) is determined during sewing for each stitch by means of a sensor installed in the needle thread path of the sewing machine.
In the process, through a special measuring principle, measuring errors, caused for example by fluctuating temperatures, can be ruled out.
The signals are evaluated on the PC and displayed on the touch-screen monitor on a user interface for Windows ® XP. The analysis of these signals gives information about the machine setting and the quality of each individual stitch sewn.
The seam sector for which the system is to be activated (docu-seam sector) is determined either by a sensor, by knee switch, with a pre-selected seam length or by stitch counting.
The docu-seam system compares the established thread pull with the previously entered limit values and issues an evaluation of the seam on the touch-screen monitor. If the seam is a good seam, an appropriate signal is given to the PC interface and a label can be printed, which can then be attached to indicate the appropriate quality of the seam. The label can be designed individually with an editor.

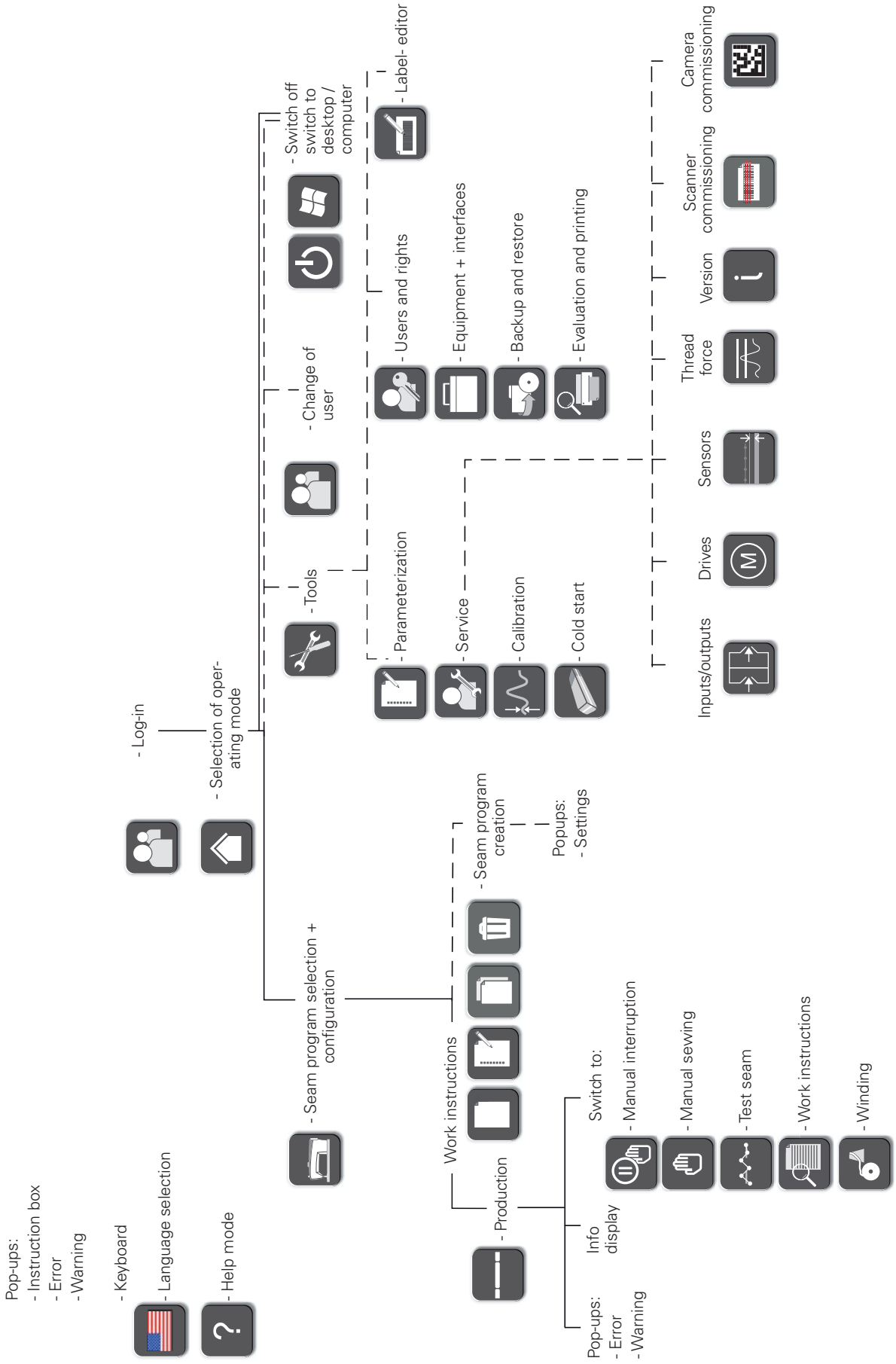
The docu-seam system also activates a missed stitch recognition function and, depending on how it is set, reacts to following types of error:

- missed stitch,
- needle thread breakage, end of needle thread
- bobbin thread breakage, end of bobbin thread
- broken needle
- deviations from edge guide

The use of specified materials can be ensured and documented through the prompt to enter appropriate codes (e.g. scanning of barcodes for thread spindle, material, bobbin).

All inputs, for separate user groups, can be carried out directly over the user interface of the touch screen monitor. Several languages are available for the user interface. All data entered and established can be processed on standard databases and spreadsheets.

2.02 Overview of the functions



2.03 Description of the functions

Each function is selected by tapping the appropriate symbols on the touch-screen monitor.

2.03.01 Overlapping functions

Mode selection
The menu for selecting the operating mode is called up, see Chapter **2.03.02 Operating modes.**

Choice of language
A menu for selecting the language setting is opened, see Chapter **8 Setting up in the Instruction Manual.**

Help mode
After calling up the help mode, the next function selected is described.

Online help
After activation of the help module, the online help can be called up, including language and document selection.

Confirm
The selection is confirmed, entered or altered values are saved.

Stop
The selection process is cancelled, entered or altered values are not saved.

Back
The superordinate level is selected.

Drag and Drop
With this function it is possible to move the window to any position.

Work order
With this function, a previously created work order can be displayed.

2.03.02 Operating modes

Selecting and configuring seam programs
Functions for selecting, processing and creating seam programs are called up, see Chapter **2.04 Creating seam programs.**

Tools
A menu is called up for selecting functions for the sewing head, control unit and printer.

Change of user
The box for entering the user is called up.

Desktop
The application is concluded and the Windows desktop is called up. This function is only displayed for the logged-in administrator or supervisor.

Shut down the computer
The application is concluded and the computer is shut down. This function is only displayed for the logged-in operator or guest.

2.03.03 Tools

Parameterization
A menu is called up for adjusting the parameters, see Adjustment Manual.

Service
The service menu is called up, see Chapter **2.05 Service**.

Calibration
A menu is called up for calibrating the machine, see Calibration Instructions.

Cold start
A cold start is carried out, see Chapter **2.06 Cold Start**.

Users – Rights
A menu is called up for entering users and rights, see Chapter **2.07 Users – Rights**.

Equipment and Interfaces
A menu is opened for allocating work aids to corresponding COM-interfaces, see **Chapter 2.10 Defining options and interfaces.**

Backup and Restore
A menu is called up for carrying out a backup or a restoration, see Chapter **2.08 Back-up – Restore.**

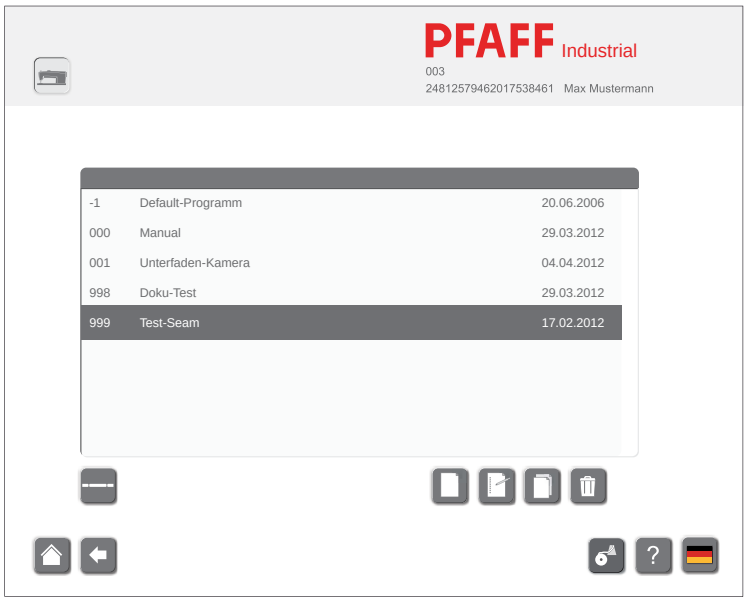
Evaluation and print function
A selected docu-seam with all relevant values is displayed.

Label editor
A menu is called up for editing labels, see Chapter **2.09 Label editor**.

2.04 Creating seam programs

- Log-in as supervisor.

- Call up the seam program selection function.



There are several possibilities of how to create a seam program.

- Select a seam program from the list.

- Edit an existing seam program.

or

- Select a seam program from the list.

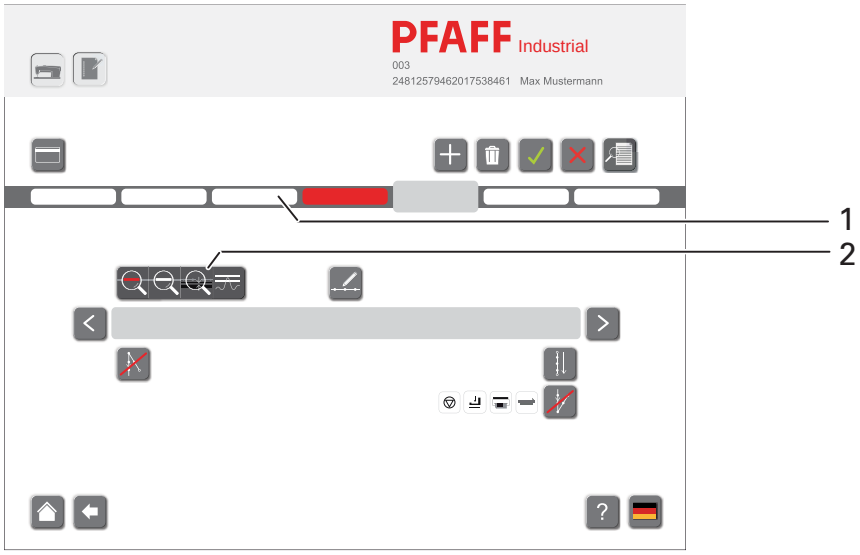
- Copy a seam program to create a new seam program on the basis of an existing one.

or

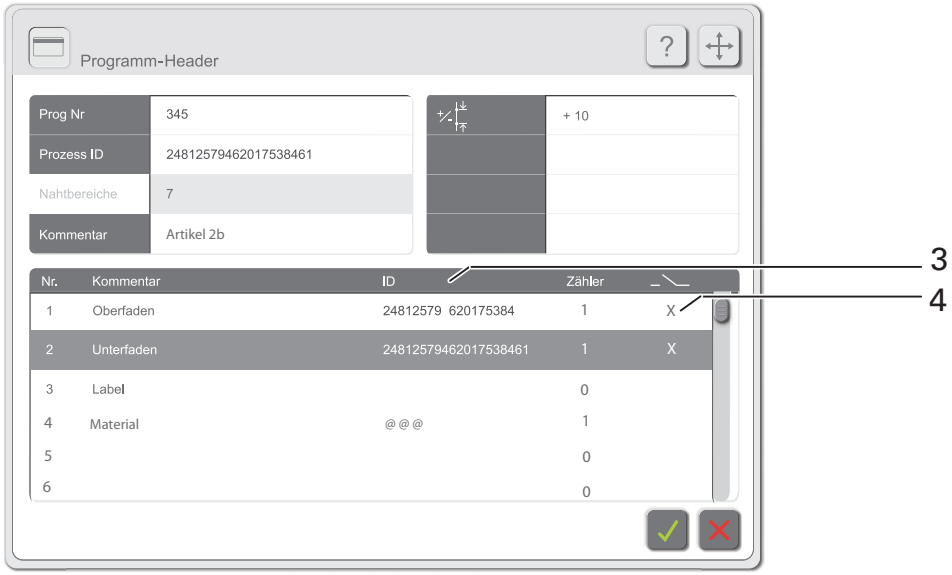
- Create a new seam program.

or

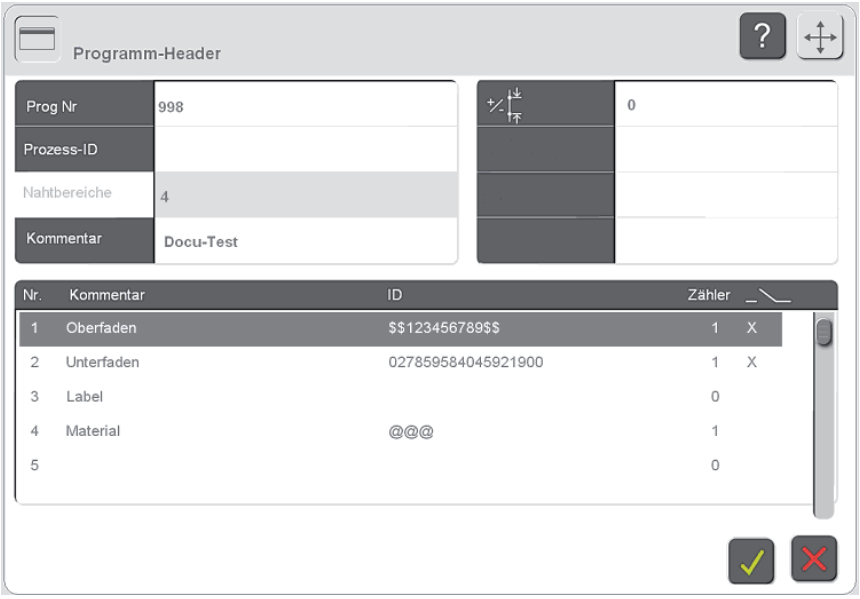
- Deleting a seam programme.



- Call up the Program Header function.



- If necessary, enter/change the program number, process-ID and comment.
- Enter the value for the stitch length correction dependent on the material.
- Enter/change the value for the second stitch length (can be called up with the appropriate key on the machine head).
- Enter/change the value for the second stroke (can be called up with the appropriate key on the machine head).
- Enter top thread and bobbin thread ID in input field **3**, or scan in via hand scanner to activate this function later in input field **4**.
  Control will then only accept sewing material with that ID.



Input Scan Options with wildcard characters in the program-header

1. With input of $$ before a character string or $$ after a character string, only the character string is controlled, true or not true.
   All characters before or after the character string are only documented

Sample:
Header input: $$123456789$$
Bar code : 888881234567895555 OK documented in the protocol
Bar code : 777777123456789333333 OK documented in the protocol
Bar code 888881234567805555 nicht OK, Error not documented in the protocol.

2. Enter @ @ @ in input field **3**.
   The control will not carry out any adjustments, IDs will only be logged.

- Select the data for printing the end label (value "**1**" = print label each time; value "**10**" = print label every tenth time).
- Select seam section from sector **1.**

- If necessary, delete selected seam section.

- If necessary, insert seam section after the selected seam section.
- With function **2** specify the following for the selected seam sector.
  - Activate/deactivate docu-seam sector
  - Activate/deactivate missed stitch recognition function
  - Activate/deactivate edge guide recognition function
  - Specify thread strength, see Chapter **2.04.05 Sensors**

- Call up the menu for entering the sewing parameters and enter the appropriate values, see Chapter **2.04.01 Sewing parameter input**.

- Call up the menu for entering the action at beginning of the seam sector. Depending on the action selected, the symbol may be different. In this example the "double start bartacks" action is selected.

- Select the action and enter/change the appropriate values, see Chapter **2.04.02 Input of action at beginning of seam sector.**

- Call up the menu for the input of the recognition of the end of the seam sector. Depending on the function selected, the symbol may be different. In this example the "recognition of the end of the seam section by knee switch" is selected.

- Select the function for the recognition of the end of the seam sector and, if necessary, enter/change the appropriate values, see Chapter **2.04.03 Input of end of seam sector**.
- Call up the menu for entering the action at the end of the seam sector. Depending on the action selected, the symbol may be different. In this example the "condensed end stitches" action is selected.
- Select the action and, if necessary, enter the label number, see Chapter **2.04.04 Input of action at end of seam sector.**

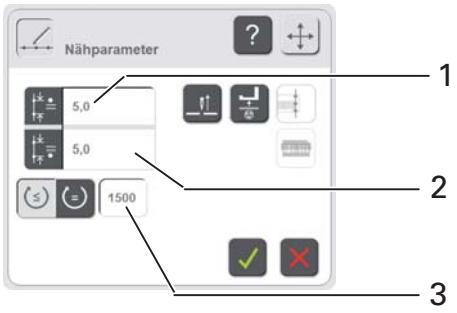
- If necessary, shift the seam sector within the seam.

- After entering/editing the desired seam sectors, save the seam program and quit the seam program function.

- Call up the production function.

2.04.01 Sewing parameter input

- In seam programming call up the menu for sewing parameter input.



Description of the functions

Roller-presser stitch length input
After tapping area **1**, the input menu for the roller-presser stitch length in the current seam sector is called up.

Feed wheel stitch length input
After tapping area **1**, the input menu for the feed wheel stitch length in the current seam sector is called up.

Speed input
After tapping area **3** the input menu for the speed in the current seam sector is called up.

This function is used to select the variable speed. The speed can be adjusted with the pedal position up to the maximum value (This function is activated in the example).

This function is used to select the constant speed. The speed cannot be adjusted with the pedal position.

Needle raised at stop
This function is switched on or off for the current seam sector. If the function is switched on, the needle moves to the top position when sewing stops.

Foot raised at stop
This function is switched on or off for the current seam sector. If the function is switched on, the foot is raised when sewing stops.

Sew in label (only after a docu-seam area)
This function is switched on or off for the current seam sector. If the function is switched on, a label is sewn in after the seam sector has been completed.

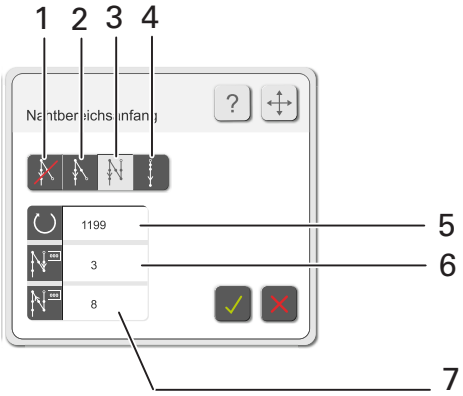
Scan label
This function is switched on or off for the current seam sector. If the function is switched on, the label must be scanned.

Conclude the input
The input is concluded by taking over the selection and the entered values.

Stop the input
The input is concluded without taking over the selection and the entered values.

2.04.02 Input of action at beginning of seam sector

- Call up the menu for the input of the action at the beginning of the seam, see Chapter **2.04 Creating seam programs.**



Description of the functions

Start bartacks and condensed start stitches off
After selecting function **1**, neither a start bartack nor a condensed start stitch is sewn at the beginning of the seam sector.

Start bartack
After the selection of this function and the input of the values for the tack speed in sector **5**, as well as the number of bartacks, the start bartack at the beginning of the seam sector is sewn with the corresponding values.

Double start bartack (currently active)
After the selection of this function and the input of the values for the tack speed in sector **5**, the number of forward stitches in sector **6** and the number of reverse stitches in sector **7**, the double start bartack at the beginning of the seam sector is sewn with the corresponding values.

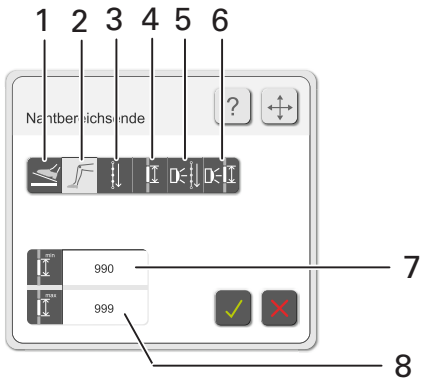
Condensed start stitches
After the selection of this function and the input of the values for the stitch length and the number of stitches, the condensed stitches at the beginning of the seam sector are sewn with the corresponding values.

Conclude the input
The input is concluded by taking over the selection and the entered values.

Stop the input
The input is concluded without taking over the selection and the entered values.

2.04.03 Input of end of seam sector

- Call up the input for the recognition of the end of the seam sector, see Chapter **2.04** Creating seam programs.



Description of the functions

End of seam sector by pedal function
After function **1** has been selected, the end of the seam sector is started with the pedal function.

End of seam sector by knee switch
After function **2** has been selected, the end of the seam sector is started with the pedal function. The minimum number of stitches for the seam sector is defined with sector **7**, the maximum number with sector **8**.

End of seam sector by stitch counting
After function **3** has been selected and following the input of the value for the number of stitches, the end of the seam sector is started after the corresponding number of stitches have been sewn.

End of seam sector by seam length
After function **4** has been selected and following the input of the value for the seam length, the end of the seam sector is started after the corresponding seam length has been sewn.

End of seam sector by sensor with stitch counting
After function **5** has been selected and following the input of the values for the maximum and minimum number of stitches, the end of the seam sector is started by sensor according to the number of stitches entered.

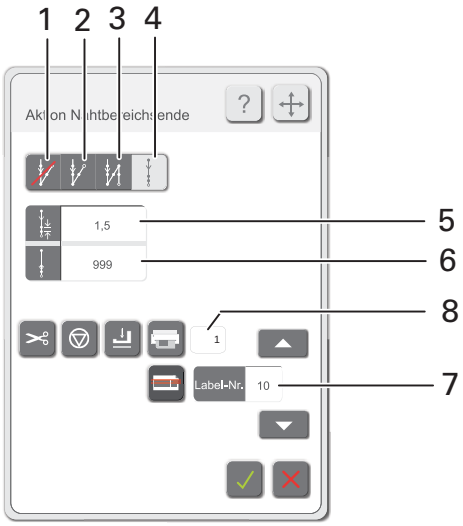
End of seam sector by sensor with seam length
After function **6** has been selected and following the input of the values for the maximum and minimum seam length, the end of the seam sector is started by sensor within the corresponding lengths given.

Conclude the input
The input is concluded by taking over the selection and the entered values.

Stop the input
The input is concluded without taking over the selection and the entered values.

2.04.04 Input of action at end of seam sector

- Call up the menu for the input of the actions at the end of the seam, see Chapter **2.04** Creating seam programs.



Description of the functions

End bartacks and condensed end stitches off

After selecting function **1**, neither an end bartack nor a condensed end stitch is sewn at the end of the seam sector.

End bartack

After the selection of this function **2** and the input of the values for the tack speed, as well as the number of bartacks, the end bartack at the end of the seam sector is sewn with the corresponding values.

Double end bartack

After the selection of this function **3** and the input of the values for the tack speed, the number of forward stitches and the number of reverse stitches, the double end bartack is sewn at the end of the seam sector with the corresponding values.

Condensed end stitches (currently active)

After the selection of this function **4** and the input of the values for the stitch length in sector **5** and the number of stitches in sector **6**, the condensed stitches at the end of the seam sector are sewn with the corresponding values.

Thread trimming on/off

This function is used to switch thread trimming at the end of the seam sector on or off.

Sewing stop

This function is switched on or off. If the function is switched on, the machine stops at the end of the seam sector.

Foot lowered

This function is switched on or off. If the function is switched on, the foot remains down at the end of the seam sector.

Print label on/off

This function is used to switch the label printing function at the end of the seam sector on or off.

Selection of the label

The label, which is to be attached, can be selected in sector 7.

Label payout

The number of labels to be printed can be selected in range 8.

Scan label

This function is switched on or off for the current seam sector. If the function is switched on, the label must be scanned.

Conclude the input

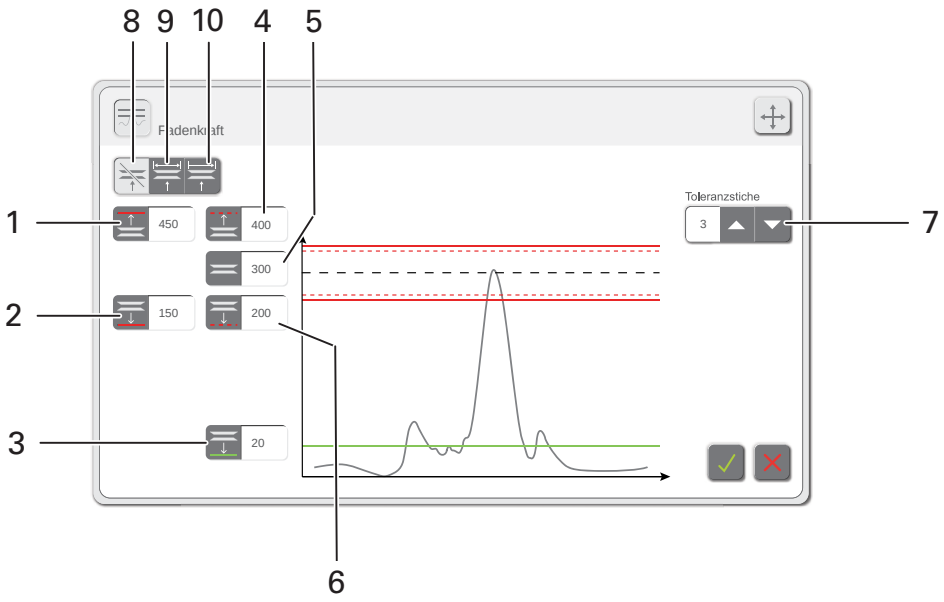
The input is concluded by taking over the selection and the entered values.

Stop the input

The input is concluded without taking over the selection and the entered values.

2.04.05 Thread force

- Call up the menu for entering the parameters for the sensor in the seam programming menu or from the service menu.



Description of the functions

Hard top limit value

The limit value is entered in sector **1**. In the docu-seam area this value must never be exceeded.

Hard bottom limit

The limit value is entered in sector **2**. In the docu-seam area the value must never be lower than this limit.

Bottom limit for missed stitch recognition

The limit value is entered in sector **3**. If the value falls below this limit, a missed stitch is recognised.

Soft top limit

The limit value is entered in sector **4** In the docu-seam area this value may be exceeded a few times. The number of tolerance stitches is entered in sector **7**.

Setpoint (only on the PFAFF 3745 PREMIUM)

The Setpoint is entered in sector **5**.

Soft bottom limit

The limit value is entered in sector **6**. In the docu-seam area it is possible to drop below this level a few times. The number of tolerance stitches is entered in sector **7**.

Tolerance stitches

The number of tolerance stitches is entered in sector **7**. The number of tolerance stitches is used to define how often the thread strength within the docu-seam area may exceed or drop below the soft limits

Thread tension control (only on the PFAFF 3745 PREMIUM)
Pressing the button 8 deactivates the function "Thread tension control" during sewing, button 9 reactivates the function.
Pressing button 10 activates the function "Thread tension control" at the end of the range only.

Conclude the input
The input is concluded by taking over the selection and the entered values.

Stop the input
The input is concluded without taking over the selection and the entered values.

2.05 Service

In the service menu the states of the digital and analogue inputs are displayed. The outputs can be set and reset manually. In addition functions for adjusting the drives, the sensors and the edge guide can be called up, and information about the status of software and firmware displayed.
Only the supervisor and administrator have access to the service menu.

- Log-in as administrator or supervisor.

- Select the "tools" function.

- Call up the service menu.

Descriptions of the functions in the service menu

Inputs/outputs
After this function has been selected, the machine's inputs are displayed. Outputs can set and reset manually. The pedal function can be checked.

Drives
After this function has been selected, the motor functions can be checked and the value for the motor reference position altered.

Edge guide on/off
After this function has been selected, the adjustment function of the edge guide can be switched on or off.

Sensors
After this function has been selected, the current value for the thread strength is displayed. Adjustment to the thread strength and bobbin thread recognition can be made.

Version
After this function has been selected, the current status of the machine's software and firmware is displayed.

Scanner

For scanner commissioning, please see chapter **4.07.02** in the settings manual.

Camera

For camera commissioning, please see chapter **4.07.03** in the settings manual.

2.06 Cold start

When a cold start is carried out, all altered parameter for the sewing head are deleted and set back to default values (status at the time of delivery)!

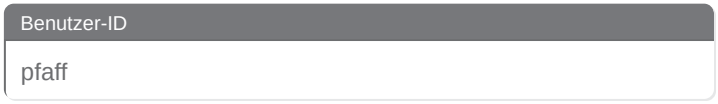
- Log-in as administrator.

- Select the "tools" function.

- Select the "cold start" function.

2.07 Users – rights

A user ID must be entered at initial power up of the machine.
On delivery of the machine, the user ID "pfaff" must be entered.



Any number of users can be added and/or edited. The rights of individual users are defined by allocating the users to relevant user groups.

User groups

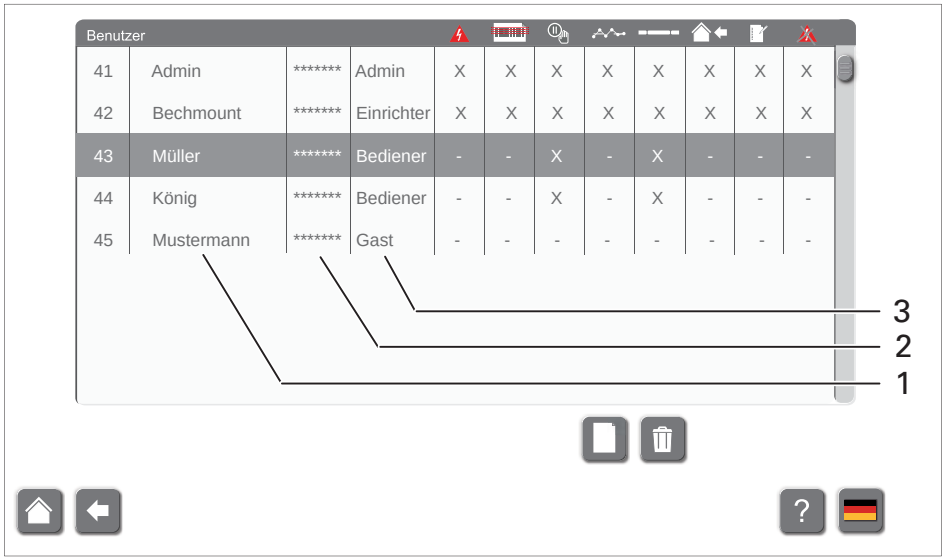
- Administrator
- Supervisor
- Operator
- Guest

Only the administrator can create and edit users, and assign users to specific user groups.

- Log-in as administrator.

- Select the "tools" function.

- Call up the menu for entering the users and their rights.



- In order to change data for a specific user, the relevant entry (name **1**, code **2,** or user group **3**) is selected from the list and edited via the entry field.
- Functions can be activated/deactivated by clicking on relevant columns (**X** = function activated, - function deactivated).

- Create a new user.

- Select a user from the list and delete.

Function descriptions


Docu-seam can be ended


Label copy can be created


Manual seam interruption can be switched on


Test seam mode can be activated


Seam programme can be activated


Production can be interrupted


Seam programme can be created


Docu-seam error can be ignored

2.08 Backup – restore

During a back-up the current database is saved. The backup can be saved on the hard disk of a PC or on an external data carrier (e.g. USB-stick). A backup should be carried out by the supervisor at regular intervals.

- Log-in as administrator.

- Select the "tools" function.

- Call up the menu for making a backup or for starting the restoration function.

- Click on window **1** at first backup.
- Select target directory and start backup of the database.
- Select time, day, and month for backup.
- The day is specified in numbers (**1** = Monday).
- Place a checkmark next to the relevant window in order to allow the backup to proceed at the specified time and date.

The PC associated with the machine must be switched on at the set backup time.

- In order to revert to a previous status, select the function "Restore".
- Select the relevant directory containing backup data, and start the restore process.
- Max. data base size and monitoring mode setting in window **2**

Importing a seam programme

Select the relevant seam programme from the transfer database.

Initialising the database

By selecting this function all previously recorded sewing protocol data will be deleted.

Make sure to create a **backup first**!

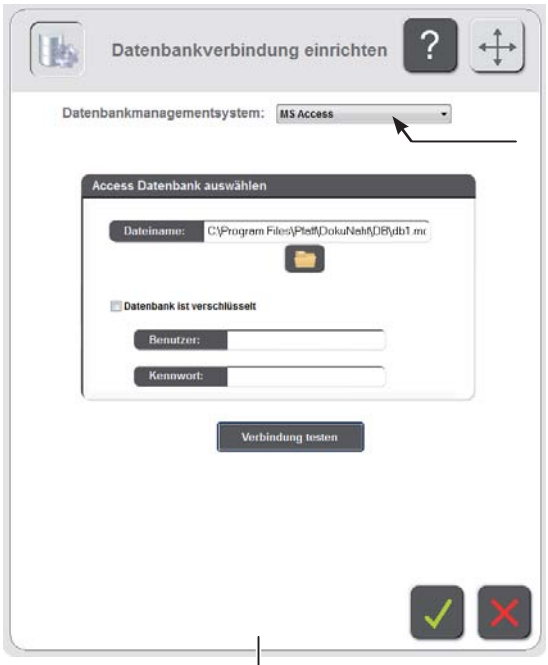
After a restore or a database initialisation, the program will have to be restarted.

Daten base explorer

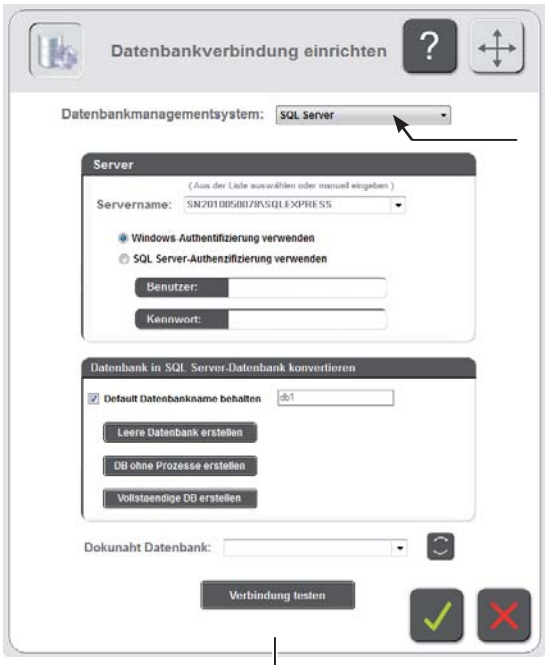
Shows the data base content.

Daten base setting

Select your data base type and the data base connection (see window **3** and **4**).



3



4

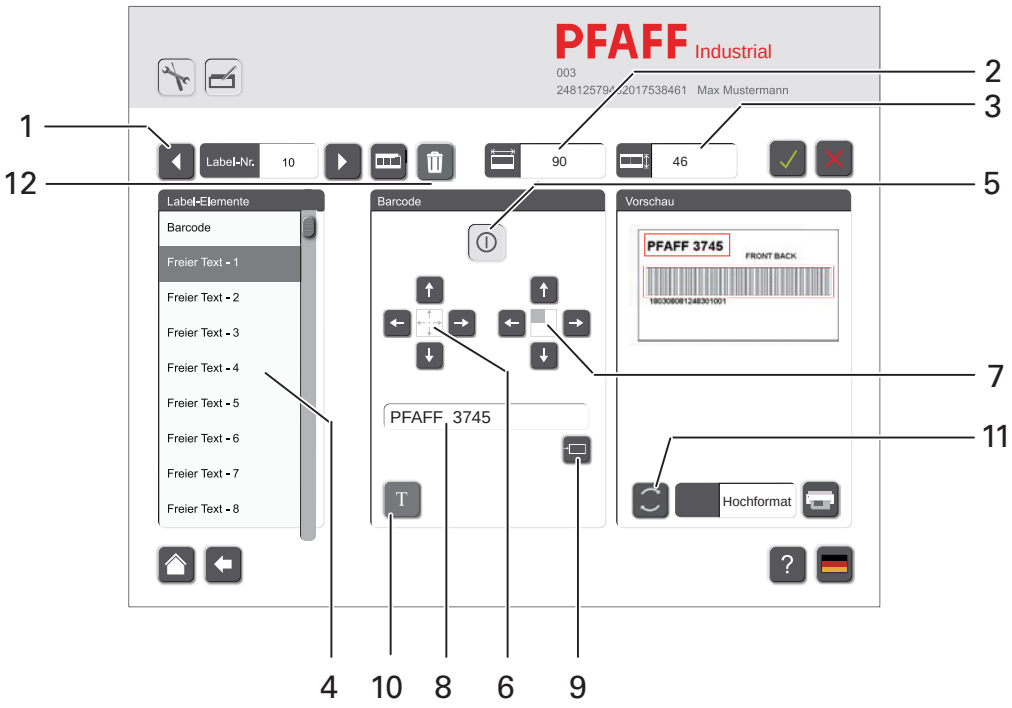
2.09 Label-editor

With the label editor it is possible to create various labels individually and to store them.

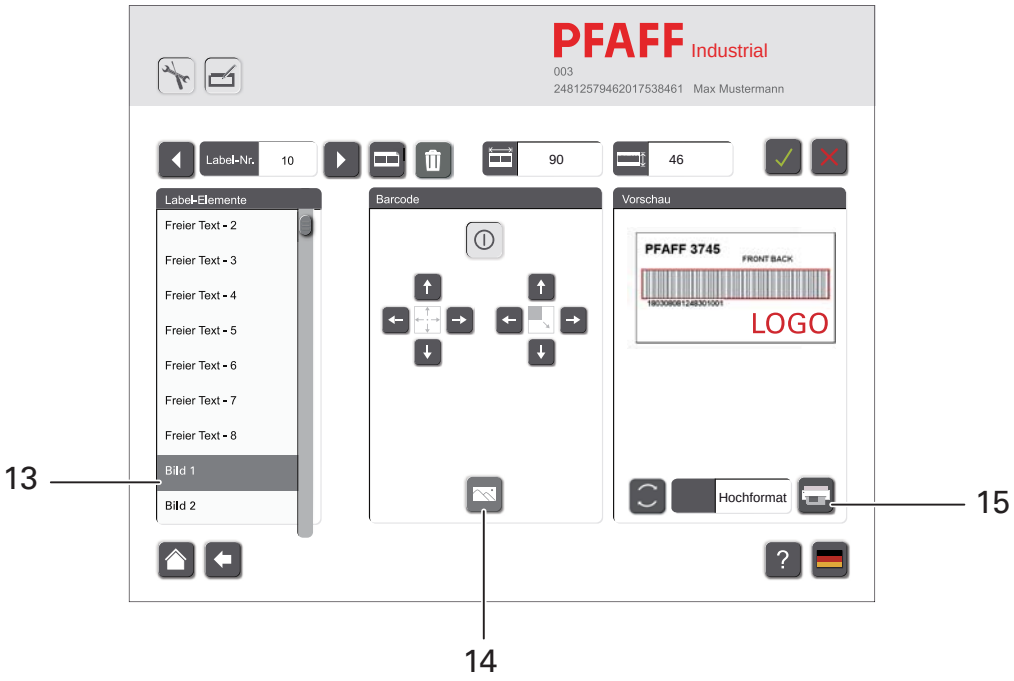
- Log-in as administrator or supervisor

- Select the "tools" function.

- Call up the label editor.



- Select the desired label (label number) by tapping the arrow keys **1**.
- If necessary, change the size of the label by tapping the selection boxes **2** and **3**.
- Select the desired label element by tapping an item from list **4**.
- Activate the selected label element with function **5**. The label element is shown as a preview.
- If necessary edit the selected label element with function **6**.
- If necessary change the size of the selected label element with function **7**.
- After tapping box **8**, enter the text for the selected label element.
- If necessary select variables (time, date, counter etc.) for the selected label element with function **9**.
- If necessary change the font of the selected label element with function **10.**
- If necessary, change format via function **11**.
- If necessary, change element via function **12**.
- If necessary add more label elements, or deactivate existing label elements with function **5**.



If a picture element is selected from list **13**, the symbol **14** appears on the monitor.

- Select an appropriate label element (e.g. "picture **1**) by tapping it on list **13**.
- Select the desired picture file with function **14**. The picture appears as a preview. The picture element can be shifted as described above and the size changed.
- Carry out a test print-out of the label by selecting function **15**.

- Save the changes and quit the label editor function.

- The entry mode deactivated without applying the selection.

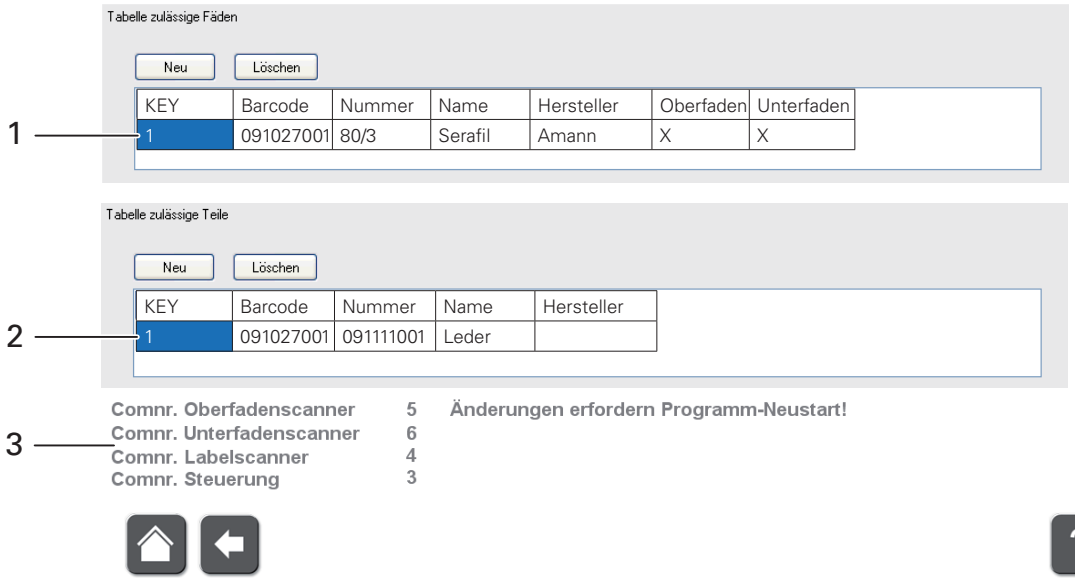
2.10 Defining options and interfaces

In this function, options like label printer, thread type, material type, service, and day counter, as well as control interfaces can be defined.

- Log on as administrator or setter.

- Select function "Tools".

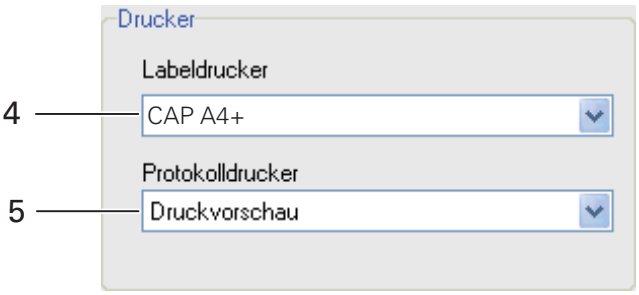
- Call up function "Options and interfaces".



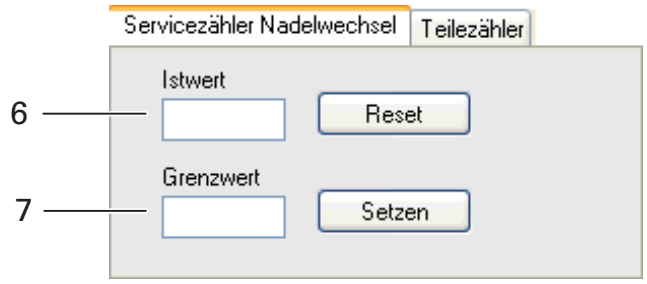
- Define relevant threads by inputting their barcode, thread thickness, thread type, and thread manufacturer in the entry window **1** for top and bobbin threads.
- Input relevant material by entering the barcode, material number, and material type in the entry window **2**.

If no thread and material are selected, any type of thread or material can be used.
If material and thread were selected, only the selected items can be used.

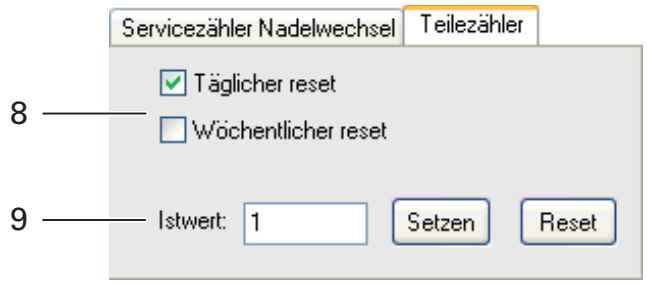
- Input label printer in window **3**.



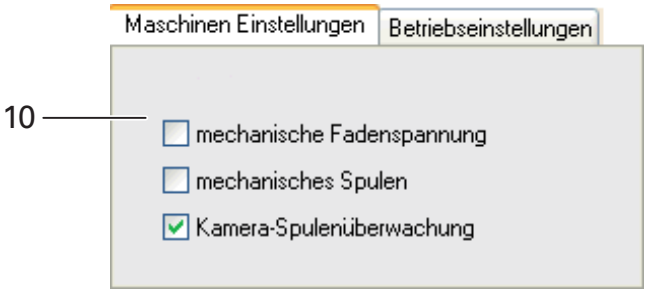
- Input label printer in window **4** .
- Define print process for protocol printing in window **5.**



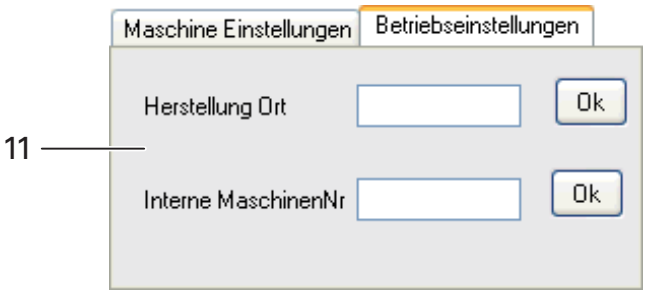
- Input number of stitches until neele change in window **6** (once preset threshold value **7** is reached, the error message "Change needle“ will be displayed; a re-set of the actual value will re-start the count).



- A daily or weekly parts counter can be specified in window **8.**
- The counter start value can be entered in window 'Actual value'.



- Relevant machine equipment must be selected in window 10.



- Operation-specific data is entered in window **11.**

The programme will have to be restarted after any changes!

PFAFF® Industrial

POWERLine

3721

INSTRUCTION MANUAL

This instruction manual applies to machines from software version **1.8** and serial number **2 772 129** onwards

Betriebsanleitung engl. 04.13

3.01 Proper use

The PFAFF 3721 is a workplace with a single-needle, lockstitch, special high-speed sewing machine with forward- and reverse-feeding feed wheel and roller presser, as well as needle feed, electrically controlled tensioning, an electrical bobbin winder and a large sewing hook and docu-seam system.

The machines are used for sewing lockstitch seams in fields requiring safety seams, e.g. in the automotive industry.

Any and all uses of this machine which have not been approved of by the manufacturer are considered to be inappropriate! The manufacturer cannot be held liable for any damage caused by the inappropriate use of the machine! The appropriate use of the machine includes the observance of all operational, adjustment, maintenance and repair measures required by the manufacturer!

3.02 Specifications *

Stitch type: .....301 (lockstitch)
Needle system: 134

Version: BN5

Needle size in 1/100 mm ..... 80 – 100

Max. stitch length: .....5 mm
Max.thread size (synthetic): ..... 30/3▲
Maximum speed: ..... 3500** spm.

Presser foot clearance: .....7 mm
Clearance width: .....350 mm
Clearance height: .....120 mm
Bed plate dimensions: .....640 x 200 mm

Ambient temperature
85% rel. humidity (condensation not permitted): ..... 5 – 40° C

Noise data:
Noise emission level at workplace with a sewing speed of 2400 spm: ..... L_{pA} < 80 dB(A)■
(Noise measurement in accordance with DIN 45 635-48-A-1, ISO 11204, ISO 3744, ISO

Motor data: ..... See name plate on motor
Leakage current:: ..... ≤ 5 mA ◆

Air consumption per switch cycle: .....0.146 Nl

Net weight of sewing head: .....approx. 72 kg
Gross weight of sewing head : .....approx. 82 kg

* Subject to alteration

** Dependent on material, work operation and stitch length

▲ or similar strengths of other types of thread

◆ Due to the use of network filters there is a nominal leakage current of ≤ 5 mA

■ K_{pA} = 2,5 dB

3.03 Disposal of Machine

- Proper disposal of the machine is the responsibility of the customer.
- The materials used for the machine are steel, aluminium, brass and various plastic materials. The electrical equipment comprises plastic materials and copper.
- The machine is to be disposed of according to the locally valid pollution control regula-tions; if necessary, a specialist ist to be commissioned.

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

3.04 Transportation, packing and storage

3.04.01 Transportation to customer's premises

The machines are delivered completely packed.

3.04.02 Transportation inside the customer's premises

The manufacturer cannot be made liable for transportation inside the customer's premises nor to other operating locations. It must be ensured that the machines are only transported in an upright position.

3.04.03 Disposal of packing materials

The packing materials of this machine comprise paper, cardboard and VCE fibre. Proper disposal of the packing material is the responsibility of the customer.

3.04.04 Storage

If the machine is not in use, it can be stored as it is for a period of up to six months, but It should be protected against dust and moisture.
If the machine is stored for longer periods, the individual parts, especially the surfaces of moving parts, must be protected against corrosion, e.g. by a film of oil.

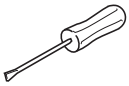
3.05 Explanation of symbols

In this instruction manual, work to be carried out or important information is accentuated by symbols. These symbols have the following meanings:

Note, information

Cleaning, care

Lubrication



Maintenance, repairs, adjustment, service work
(only to be carried out by technical staff)

3.06 Controls

3.06.01 On/off switch / Sewing lamp switch

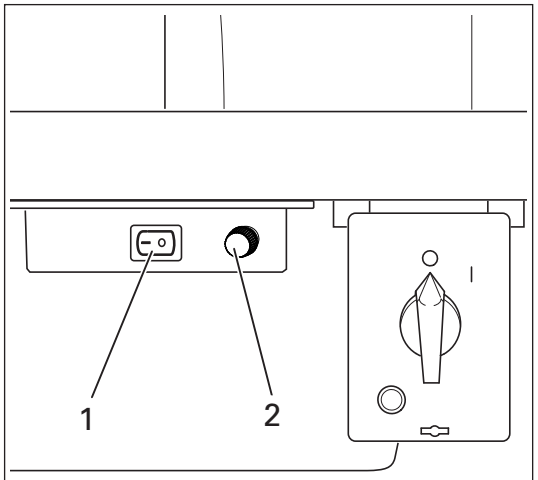


Fig. 6 - 01

- To switch the control system of the machine on or off, turn main switch **1**.

Please note that when activating the machine, the machine must be activated first, and then the power bar.

- Switch the sewing lamp, which is integrated in the machine head, on or off by operating switch **1**.
- Switch 2 regulates the brightness of the sewing lamp.

3.06.02 Power bar

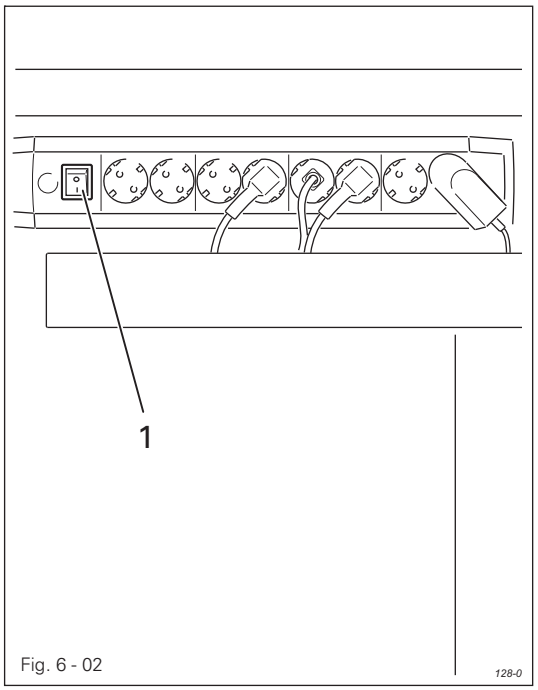


Fig. 6 - 02

- Switch **1** is used to switch the complete power supply of the PC components (PC, touch-screen monitor, hand-held scanner, printer etc.) on or off.

If an individual device is not activated after the power bar has been switched on, please check, if the switches of the individual devices are activated.

3.06.03 Pedal

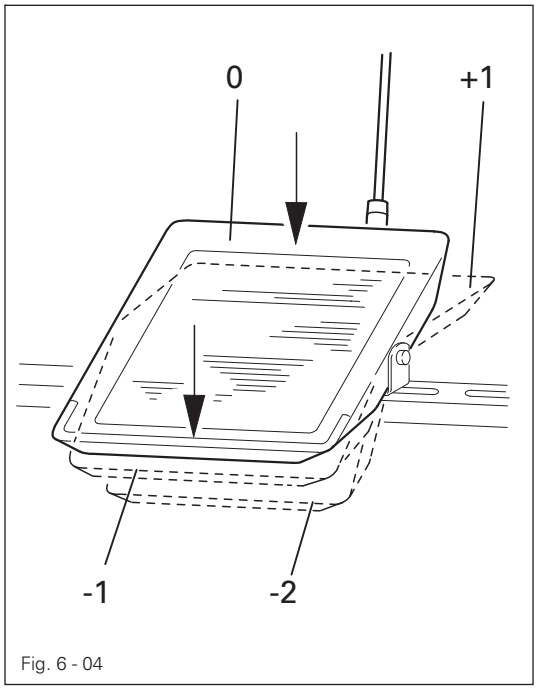


Fig. 6 - 04

- With the on/off switch on
  - 0 = Machine stop
  - +1 = Sew
  - - 1 = Raise roller-presser
  - - 2 = Trim thread (on machines with thread trimmer)

3.06.04 Lever for lifting the roller-presser

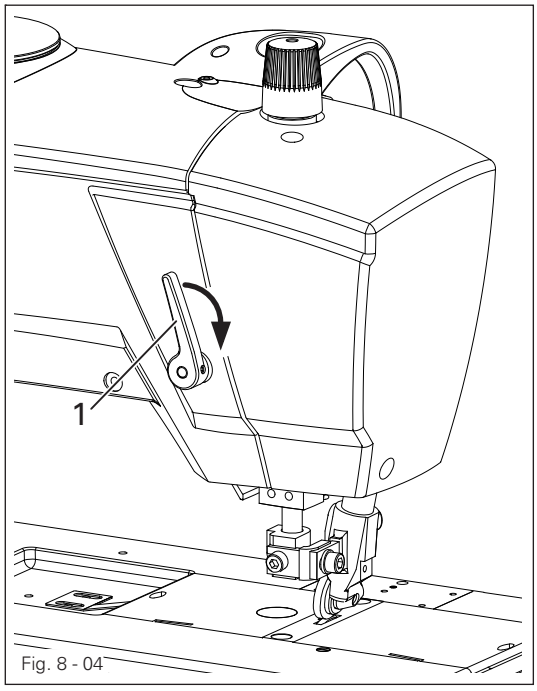


Fig. 8 - 04

- The roller-presser can be lifted by raising lever 1.

3.06.03 Keyboard on machine head

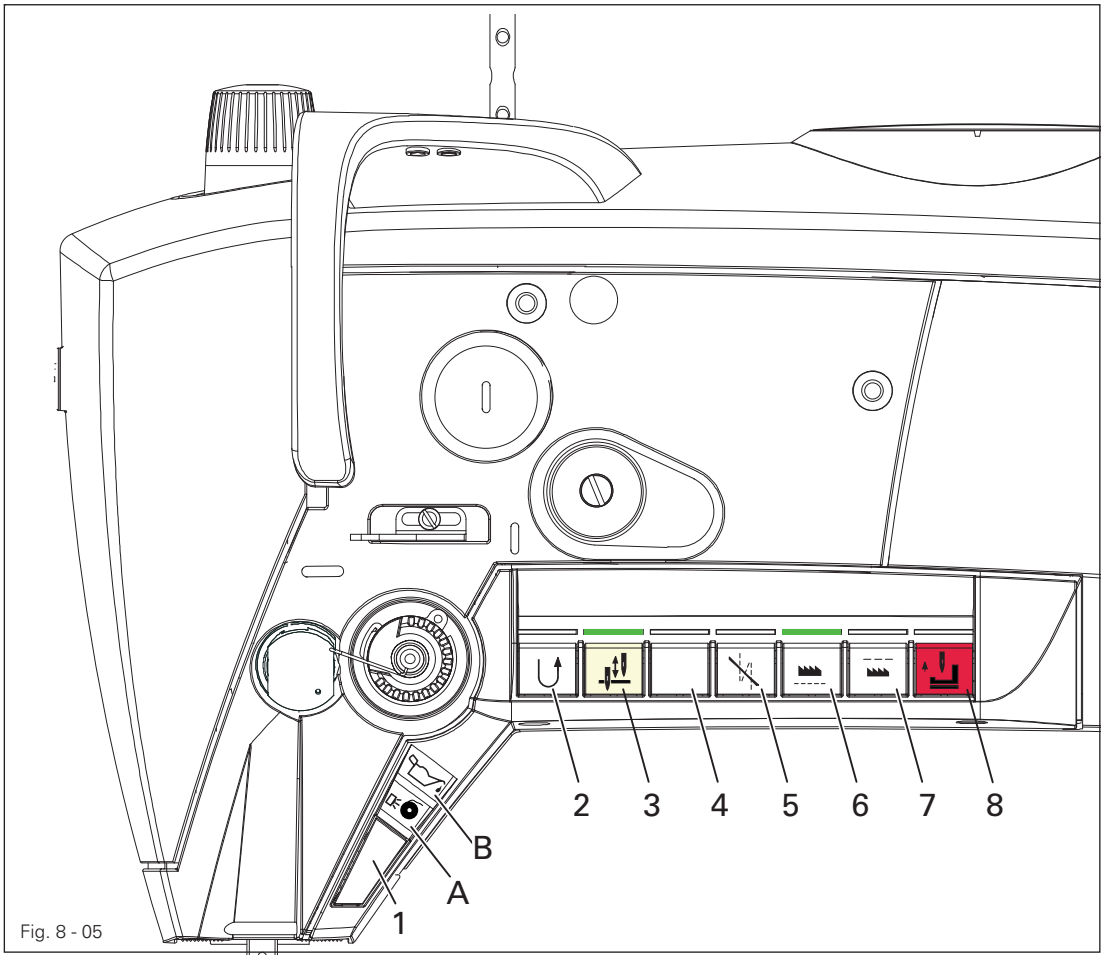


Fig. 8 - 05

- The machine has a keyboard with **8** keys to activate different functions.
- In the keys **2** – **7** there are yellow LEDs. These shine when the respective function has been allocated to key **1**.
- Green LEDs are located above the keys **2** - **7**. These shine when the function has been activated.
- Above key **1** there are two symbol lamps.
  Lamp **A** indicates the status of the bobbin thread control.
  Lamp **B** shines when the minimum level of the oil supply has been reached.
- When the keys **1** – **8** are operated, the functions listed below are carried out.

Key **1**: The functions of the keys **2** - **7** can be allocated to this key.
To program key **1**, simultaneously press one of the keys **2** - **7** and key **1** for approx. **3 seconds**. The function of the selected key is taken over and the yellow LED in this key lights up

Key **2**: Reverse sewing or intermediate backtacks during the seam.

Key **3**: Needle position change
Needle raised without trimming)

Key **4**: This buttom switche into the activating next seam section.

Key **5**: Bartack suppression for one bartack

Key **6**: Half stitch
The machine will carry out one stitch of half the set stitch length when this button is pressed.

Key **7**: Threading aid
Needle rises without thread trimming, thread clamp is opened, thread tension is released and the motor start inhibitor is activated.
If the key is operated again, the motor start inhibitor is deactivated.

Key **8**: EMERGENCY key
Needle rises without thread trimming, thread clamp is opened, thread tension is released, presser foot is raised and the motor start inhibitor is activated. If the key is operated again, the motor start inhibitor is deactivated.

The method for setting parameters is described in the settings manual, and may only be carried out by certified professionals!

3.06.06 Knee switch (optional)

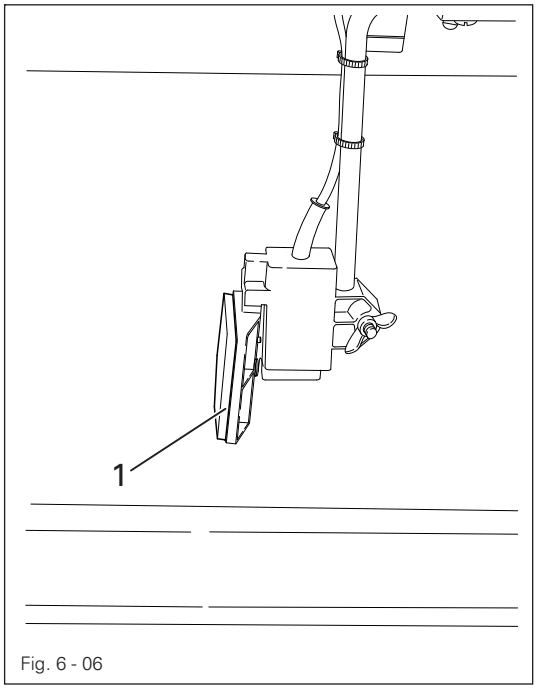


Fig. 6 - 06

- If the knee switch is operated, the docu-seam sector is switched on or off.

3.06.07 Bobbin thread supply monitor

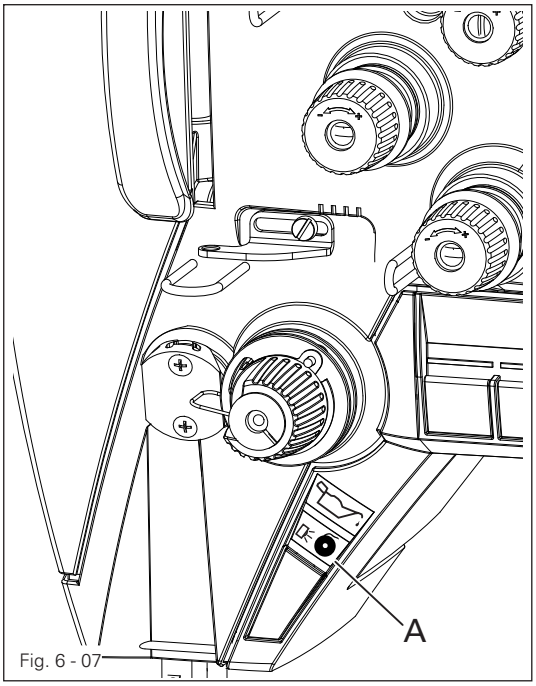


Fig. 6 - 07

- When the residual thread amount is reached, symbol lamp A flashes.
- After the next thread trimming action, a corresponding message is shown on the touch-screen monitor.
- After the bobbin has been changed and the message acknowledged, the operating process can be continued.

3.06.08 Adjustment of the stand height (optional)

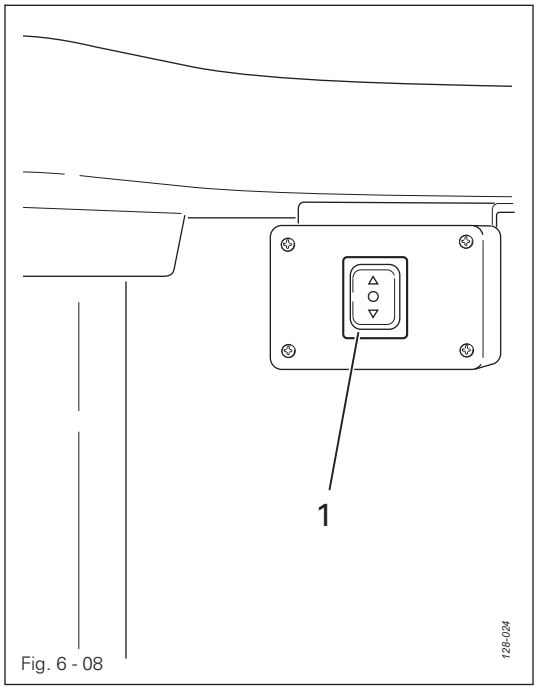


Fig. 6 - 08

- The stand height can be adjusted by operating switch-key **1** accordingly.

3.06.09 Touch-screen monitor

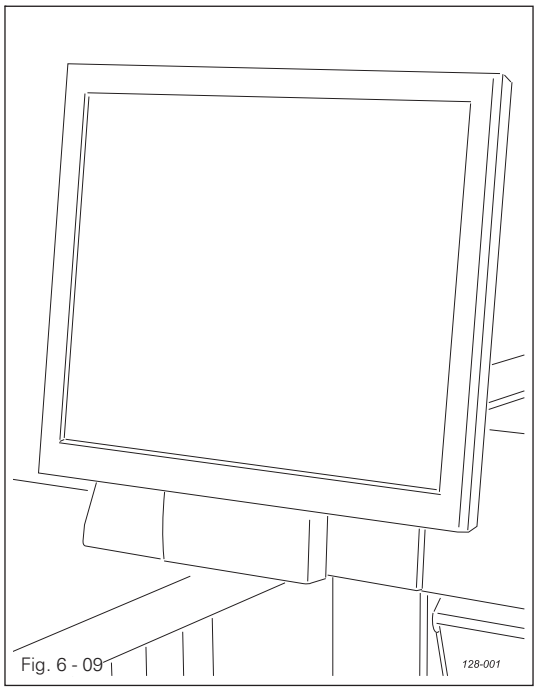


Fig. 6 - 09

- All necessary inputs are carried out on the touch-screen monitor. The appropriate operating mode, messages, parameters etc. are displayed.

3.06.10 Label-printer

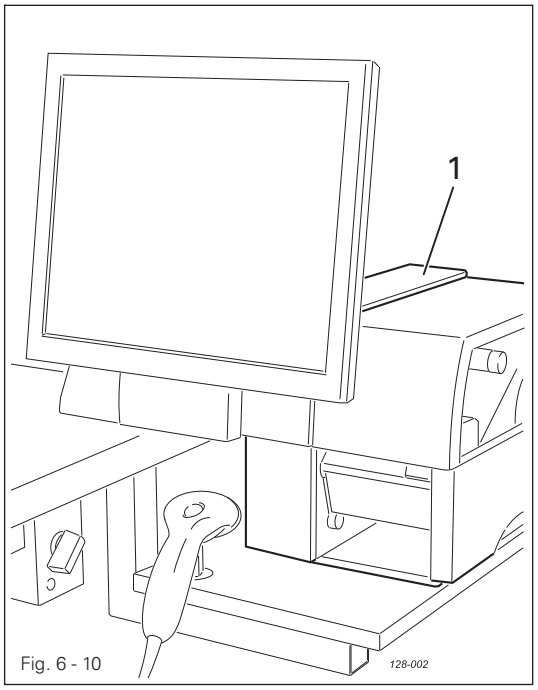


Fig. 6 - 10

- The label printer **1** is used for printing the label.

3.06.11 Hand-held scanner

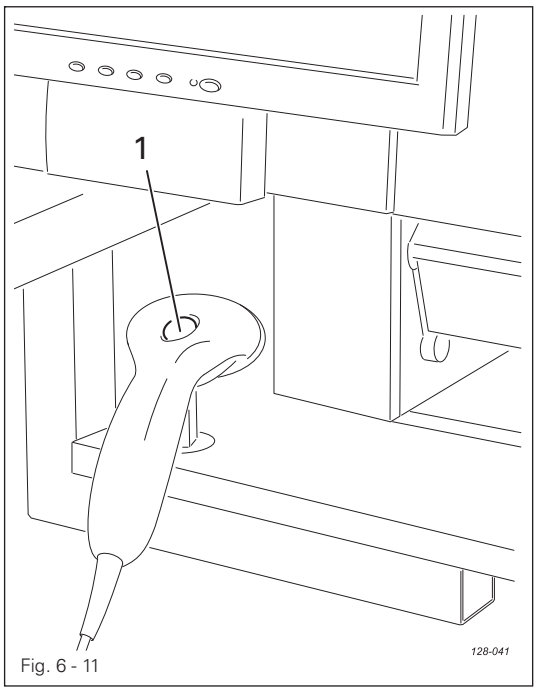


Fig. 6 - 11

- With the aid of the hand-held scanner, after pressing key **1** it is possible to read user and process data. For example, the user log-in, the input of material, needle thread and bobbin thread data can be carried out with the hand-held scanner.

3.06.12 PC

Never switch off the PC, if the PC has not been shut down completely!

Danger of data loss!

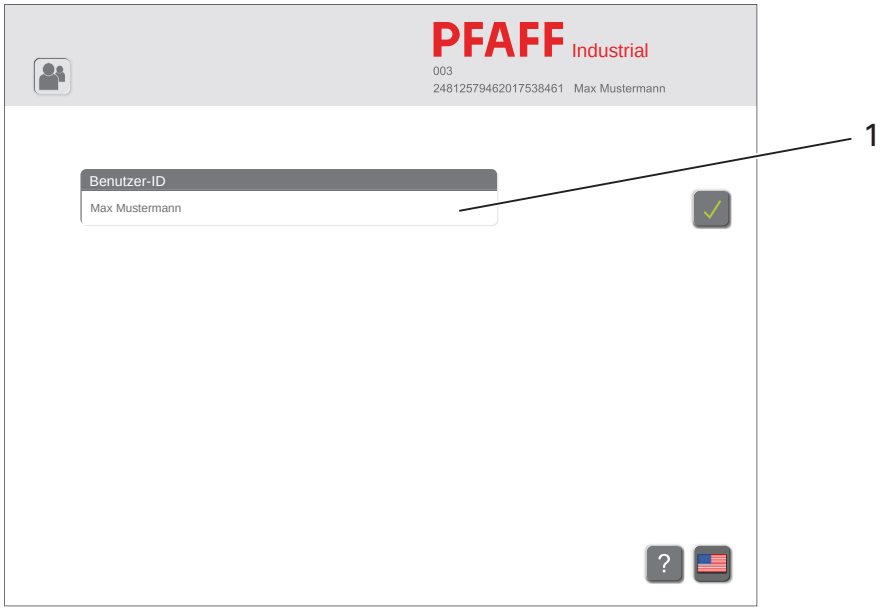
3.07 Setting up

All instructions and regulations in this instruction manual must be observed. Special attention should be given to all safety regulations.

All setting-up work may only be carried out by appropriately trained personnel.

3.07.01 Log-in

- Switch on the machine on the power bar and wait until the PC has started.



- Tap on the input box **1**.
  A box for entering the user appears.
- Enter user.
- Confirm input.

If the user has an ID-card with appropriate barcode, alternatively the user can be entered with the use of the hand-held scanner.

3.07.02 Language selection

- Carry out the log-in.
- Call up the menu for language selection.
- Select the desired language (flag).
  The selected language is immediately taken over for the complete application.

3.07.03 Inserting the needle

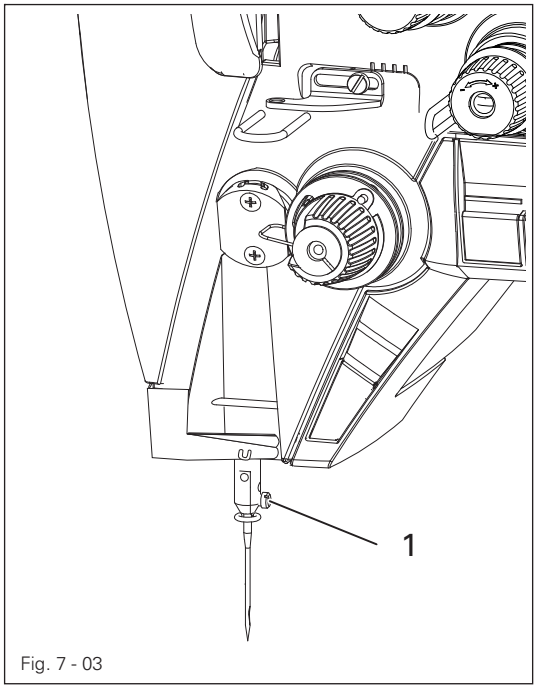


Fig. 7 - 03

Only change the needle when the threading aid is activated! Danger of injury if the machine suddenly starts running!

Only use needles from the system intended for the machine, see Chapter **3.02** Specifications!

- Activate the threading aid on the machine head by pressing the key.
- Loosen screw **1**.
- Insert the needle as far as possible. The long needle groove must be facing left.
- Tighten screw **1**.

- Switch off the threading aid on the machine head again by pressing the key.

3.07.04 Winding the bobbin thread, regulating the winder tension

(PFAFF 3745 PREMIUM)

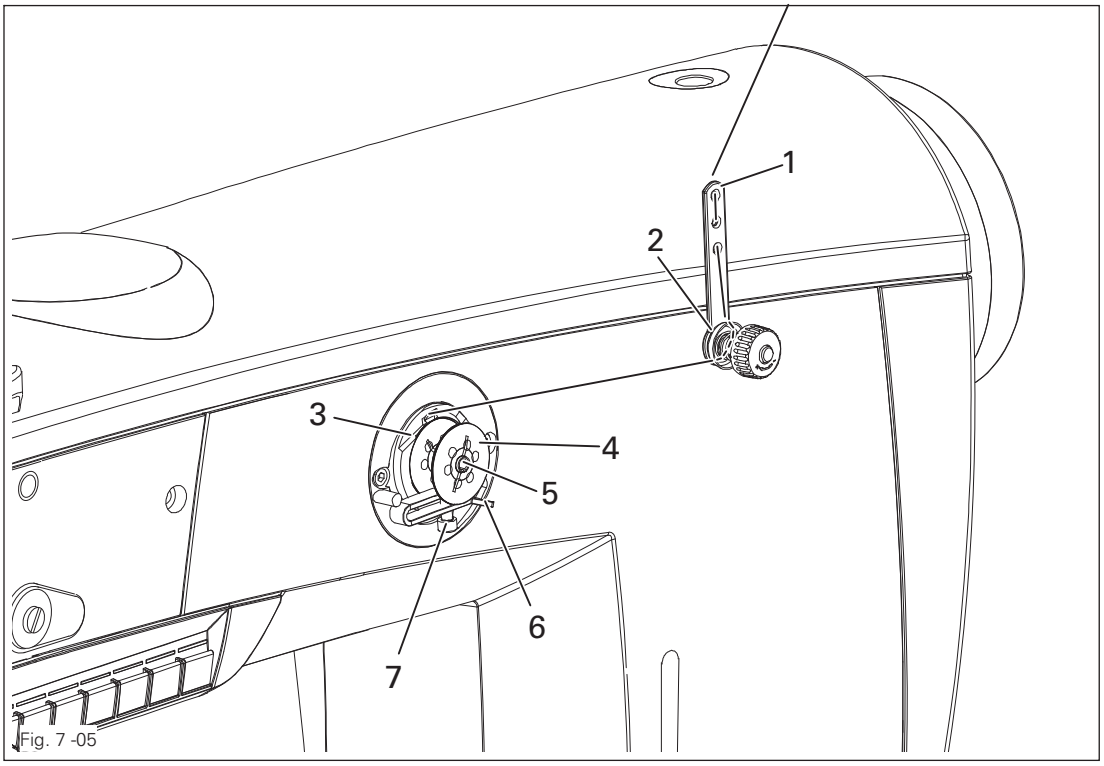


Fig. 7 -05

The requirement for the following steps is that the machine is in the production mode, see Chapter **9 Sewing**.

- Select the "winding" function.
- Pull the thread from the reel stand through guide **1** into bobbin winder tension unit **2** and then behind thread clamp **3**.
- Break off the thread in the thread clamp. The thread is then secured.
- Set the empty bobbin **4** on the bobbin winder spindle **5**.
- Press up lever **6** to switch on the bobbin winder.
- Enter or scan in the bobbin number.
  If no thread classification is required, enter the value "**0**".

After the bobbin number has been entered, the bobbin winder starts automatically and stops again, when bobbin **4** has been filled sufficiently.

- Remove the full bobbin **4** and break off the thread in the thread clamp.
- The tension of the thread on bobbin **4** can be set on the bobbin winder tension unit **2**.
- The thread amount on bobbin **4** can be adjusted with screw **7**.

3.07.05 Bobbin-changing/threading, and regulating the bobbin thread tension

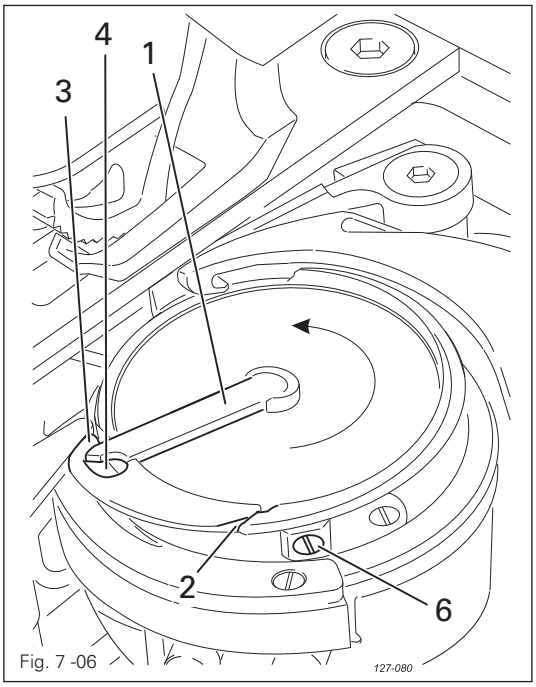


Fig. 7 -06

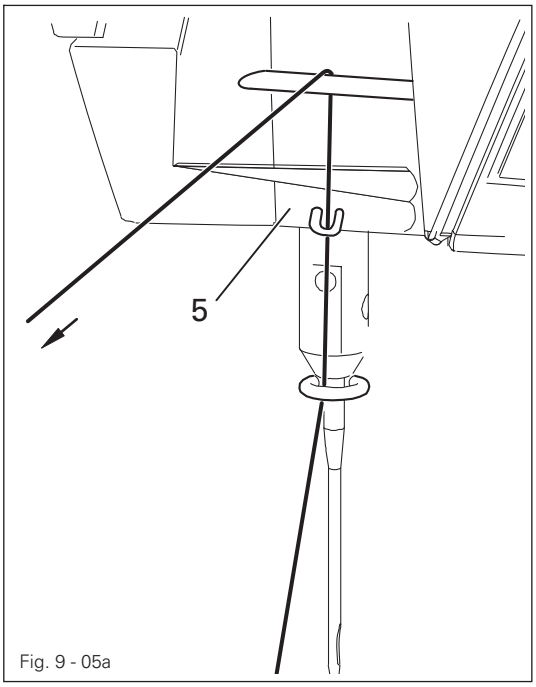
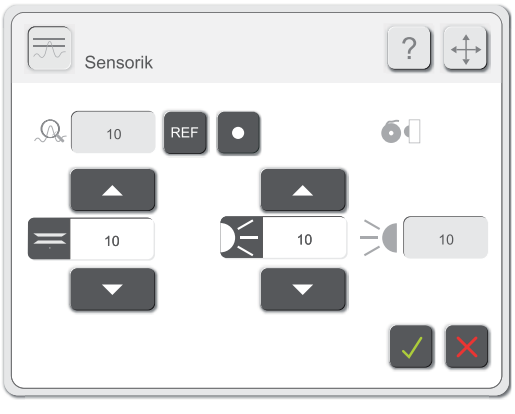


Fig. 9 - 05a

Only change the bobbin when the threading aid is activated!
Danger of injury if the machine suddenly starts running!

- Activate the threading aid on the machine head by pressing the key.
- Press down the spring lock and open the bedplate slide.
- Raise latch **1** and remove the bobbin.
- Place the filled bobbin in the hook so that the bobbin turns in the direction of the arrow when the thread is pulled.
- Turn down latch **1**.
- Pull the thread through slot **2** to pull beak **3** into hole **4**.
- Call up the “tools” function.
- Call up the service menu.
- Select the "Thread force" function.
- Thread the bobbin thread through the sensor as shown in Fig. **7-06**a and pull it through evenly.
- Compare the displayed value with the standard value and, if necessary, adjust the bobbin thread tension accordingly with screw **6**.
- Close the bedplate slide.
- Switch off the threading aid on the machine head again by pressing the key.



3.07.06 Threading the needle thread

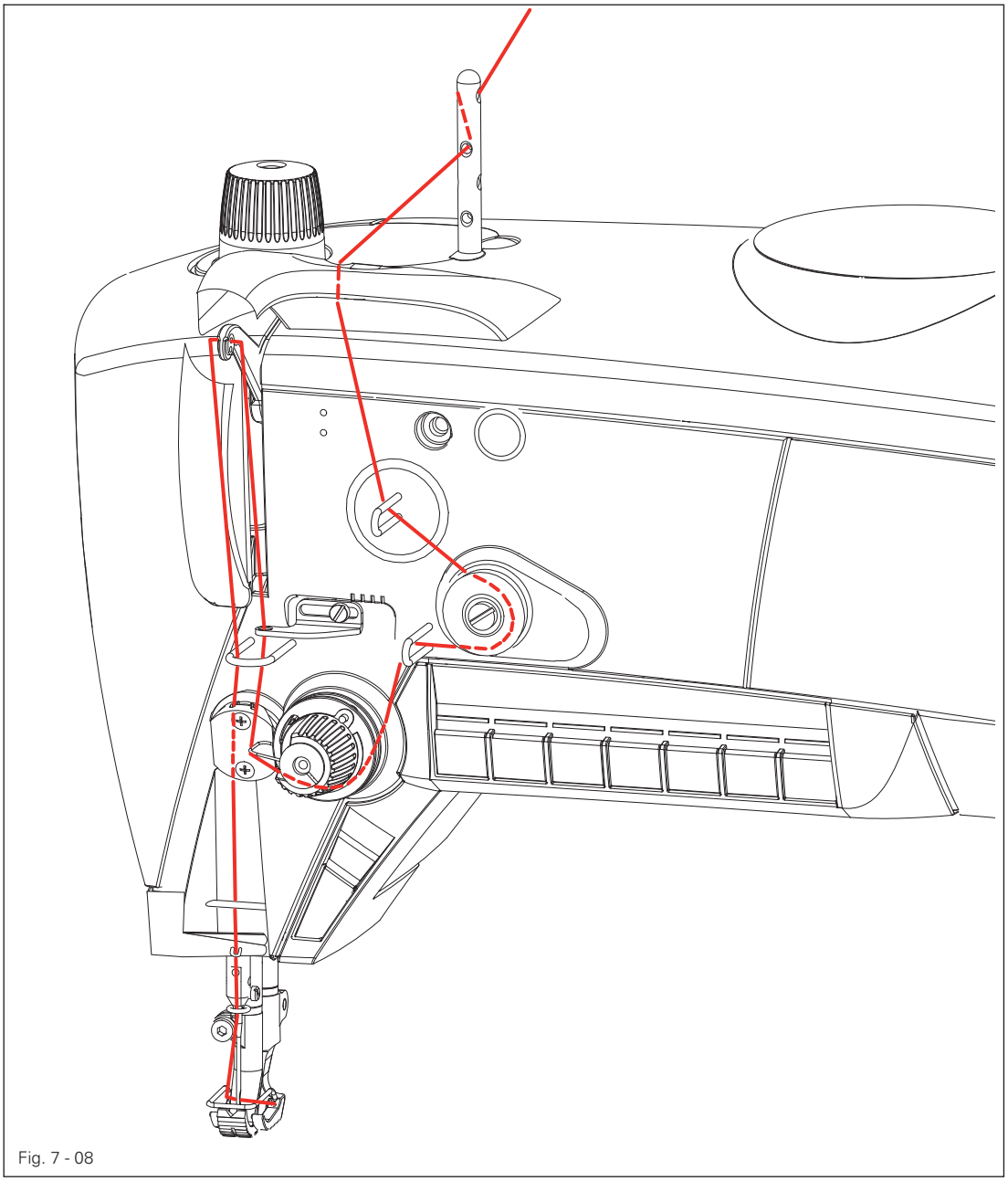


Fig. 7 - 08

Only thread the needle thread when the threading aid is activated!
Danger of injury if the machine suddenly starts running!

- Activate the threading aid on the machine head by pressing the key.
- Thread the needle thread as shown in Fig. **9 - 06**.
- Switch off the threading aid on the machine head again by pressing the key.

3.08 Sewing

The machine may only be operated by appropriately trained personnel! The operating personnel must ensure that only authorised persons are in the danger zone of the machine!

Following conditions must be fulfilled for sewing:

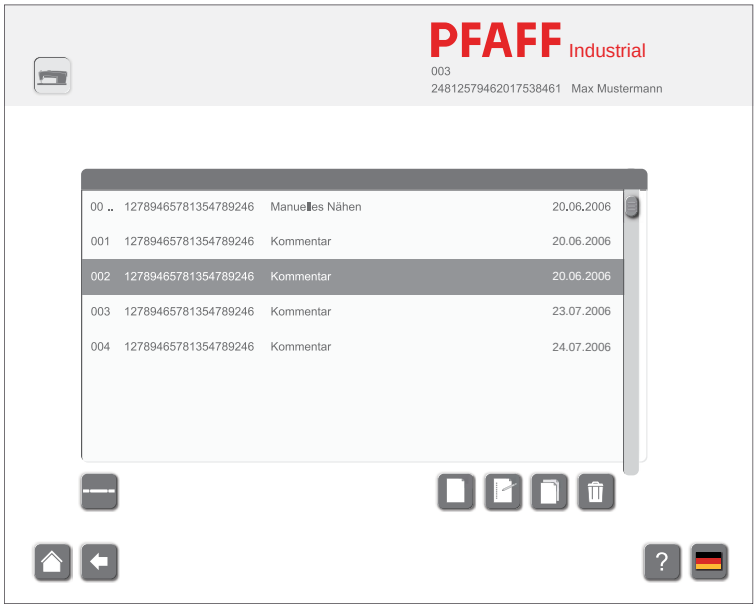
- All safety equipment must be attached, see Chapter **1.06** Danger warnings.
- The machine must be set up and commissioned in accordance with the set-up instructions.
- The setting up work must have been carried out, see Chapter **7** Setting up.

3.08.01 Calling up / carry out the sewing operation

(without camera for bobbin thread monitor)

After the user's log-in, following steps must be carried out:

- Call up the seam program selection function.



- Select the desired program from the list.

As an alternative to the manual seam program selection, the appropriate seam program can also be selected with the hand-held scanner, if a corresponding barcode is available.

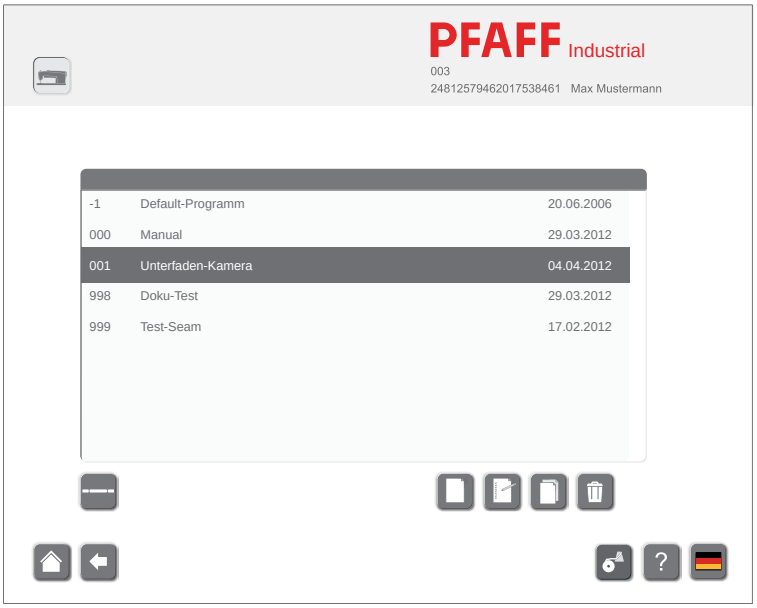
- Call up the production function.
- Insert the material.
- Start the production process by operating the pedal.

3.08.02 Calling up / carry out the sewing operation

(with camera for bobbin thread monitor)

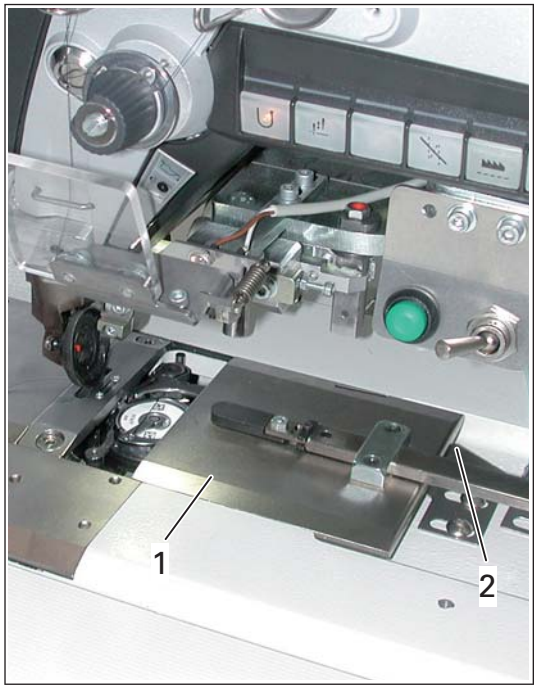
After the user's log-in, following steps must be carried out:

- Call up the seam program selection function.



- Select the desired program from the list.

- The following message will be displayed on the monitor.



- Move bobbin cover 1 into reading position by retracting to spring plate 2).

- Confirm position.

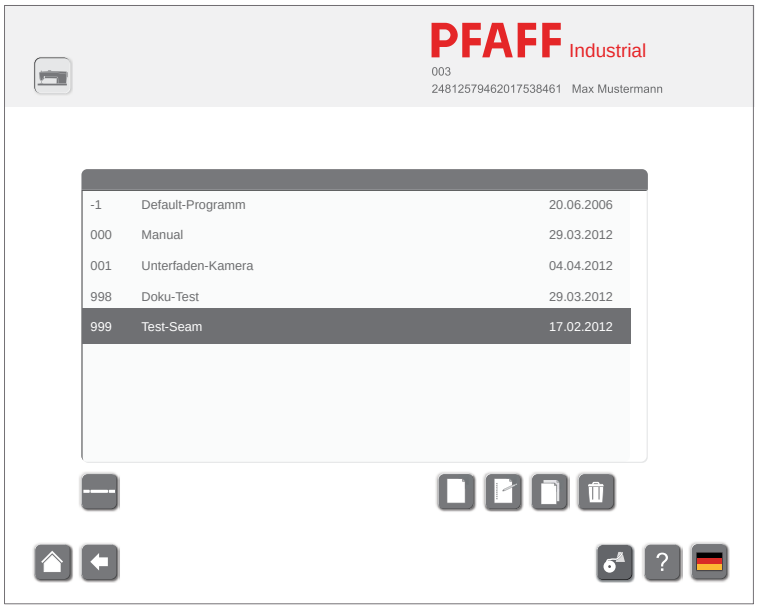
- A green bar above the image means - reading process is under way.
- Turn bobbin as needed to allow reading of DATA Matrix code.
- A red bar above the image means - reading process is not under way (camera error or bobbin cover **1** not in reading position).

- Close bobbin cover **1.**

- Call up the production function.
- Insert the material.
- Start the production process by operating the pedal.

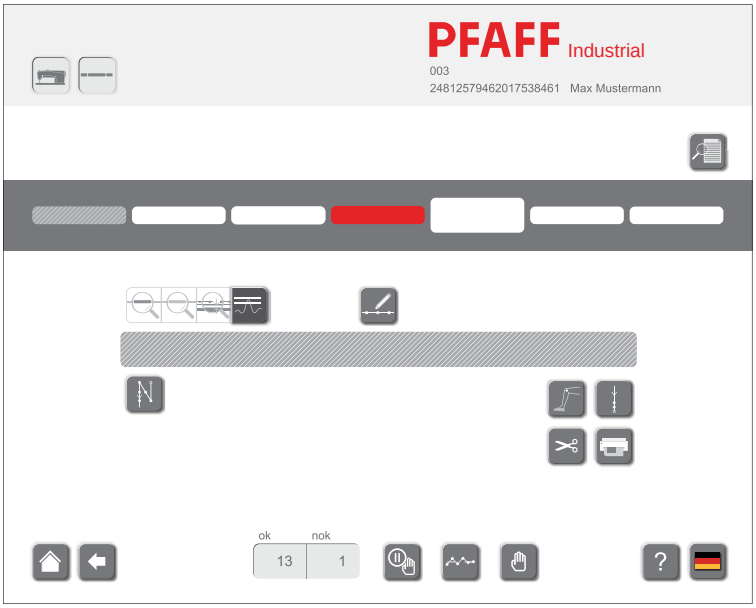
3.08.03 Regulating the needle thread tension

- Call up the seam program selection function.



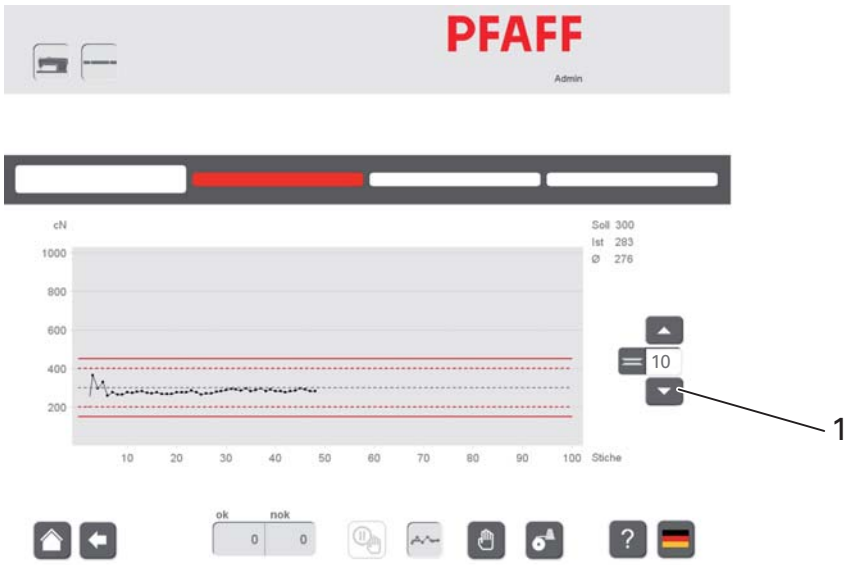
- Select the desired program from the list.

- Call up the production function.



- Call up the function "Trial Seam".
- Insert the material.
- Create a trial seam.

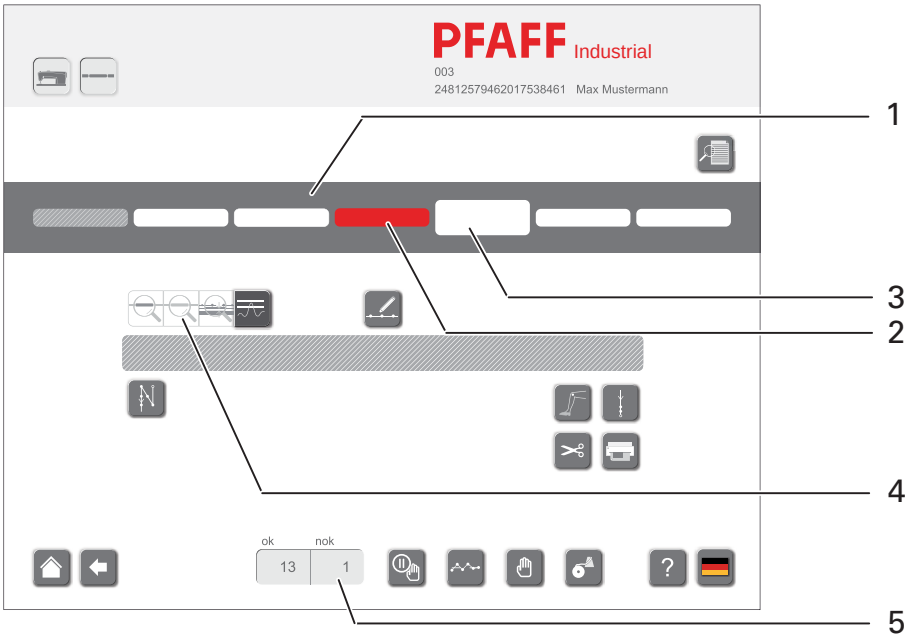
- Set the value for the upper thread tension via the arrow keys **1**, so that the upper thread tension is set to the median value of the monitoring range.



- The new value is stored by pressing the button "Trial Seam" again.

3.08.04 Description of the functions

After the production function has been selected, the following menu appears.



Work instructions

After this function has been selected, the work instructions for the selected seam program are displayed.

Display of the seam sectors

The seam sectors of the seam program are shown in sector **1.**
The docu-seam sector **2** is shown in red.
Seam sector **3** is the seam sector currently being processed.

Display of the monitoring functions

The symbols in sector **4** are used to shown the monitoring functions specified for the seam sector in the seam program. Inactive functions are shown in light grey. The following individual monitoring functions can be activated:

- Docu-seam sector
- Missed stitch detection
- Edge guide recognition (optional)

Thread force

After this function has been selected, the values for the set limit values of the thread strength and the tolerance range for missed stitches are shown.

Sewing parameters

After this function has been selected, the sewing parameters are displayed. The sewing parameters are specified during the seam program input, see Short Instructions for the input.

Action at beginning of the seam sector

The symbol shows the action at the beginning of the seam sector (here, for example, start bartacks). The action for the beginning of the seam sector is specified during the seam program input, see Short Instructions for the input.

End of the seam sector
The symbol shows the type of recognition at the end of the seam sector (here, for example, recognition through knee switch operation). The specification is made during the seam program input, see Short Instructions for the input.

Action at end of the seam sector
The symbol shows the action at the end of the seam sector (here, for example, condensed stitches). The action for the end of the seam sector is specified during the seam program input, see Short Instructions for the input.

Thread trimming on / off
This function is used to switch the thread trimming function at the end of the seam sector on or off.

Print label on / off
This function is used to switch the label printing function at the end of the seam sector on or off.

Selection of the operating mode
This function is used to call up the menu for selecting the operating mode.

Back
This function is used to call up the last level.

Display of the sewing results
In sector 5 both the number of good (“ok”) and bad (“nok”) seams are displayed.

Manual interruption
The seam cycle is interrupted. To continue the seam program, the seam sector can be re-selected.

Manual sewing
Sewing takes place without fixed seam sectors. The characteristics of the thread strength during sewing can be displayed (monitor on/off) and saved (frozen) temporarily as a snapshot.

Test seam
After this function has been selected, a test seam (simulated docu-seam) is sewn to check all specifications. No label is printed and no identification number is recorded in the database.

Bobbin winding (only on the PFAFF 3745 PREMIUM)
The winding operating is carried out, see Chapter 7.04 Winding the bobbin thread…

Help mode
After the help mode has been selected, the next function selected is described.

Choice of language
A menu for selecting the language setting is opened, see Chapter 7 Setting up in the instruction manual.

3.08.05 Concluding the sewing operation

- To end the sewing operation, call up the next level.
- Shut down the PC.
- Switch off the machine on the power bar and at the main switch.

3.09 Care and maintenance

3.09.01 Servicing and maintenance intervals

Clean the hook compartment	Daily, several times if in continuous use
Check the oil level	Daily, before starting the machine
Check/adjust the air pressure	Daily, before starting the machine
Clean the filter of the air filter/lubricator	As required

These maintenance intervals are calculated for the average running time of a single shift operation. If the machine is operated more than this, shorter intervals are recommended.

3.09.02 Cleaning the machine

The cleaning cycle required for the machine depends on following factors:

- Single or several shift operation
- Amount of dust resulting from the workpiece

It is therefore only possible to stipulate the best possible cleaning instructions for each individual case.

For all cleaning work the machine must be disconnected from the mains by switching off the on/off switch or by removing the mains plug!
Danger of injury if the machine suddenly starts up .

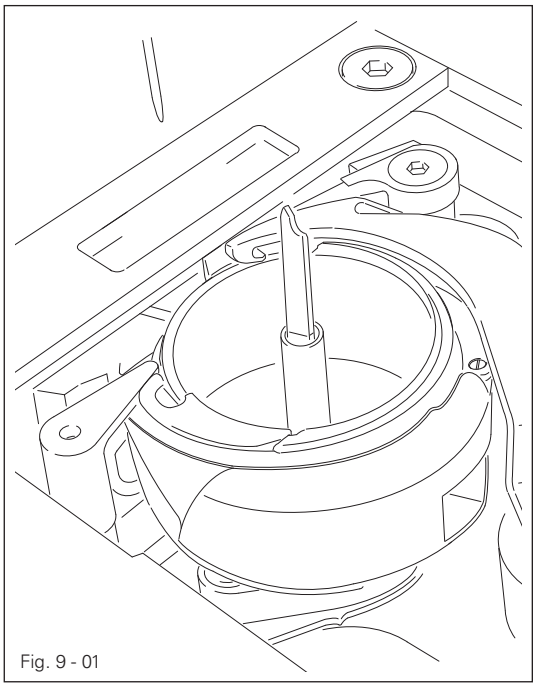


Fig. 9 - 01

To avoid breakdowns, the following cleaning work is recommended for single shift operation:

- Open the bed slide and remove the bobbin.
- Clean the hook and hook compartment daily, several times if in continuous use.
- Set the bobbin in position and close the bed slide.

3.09.03 Lubricating

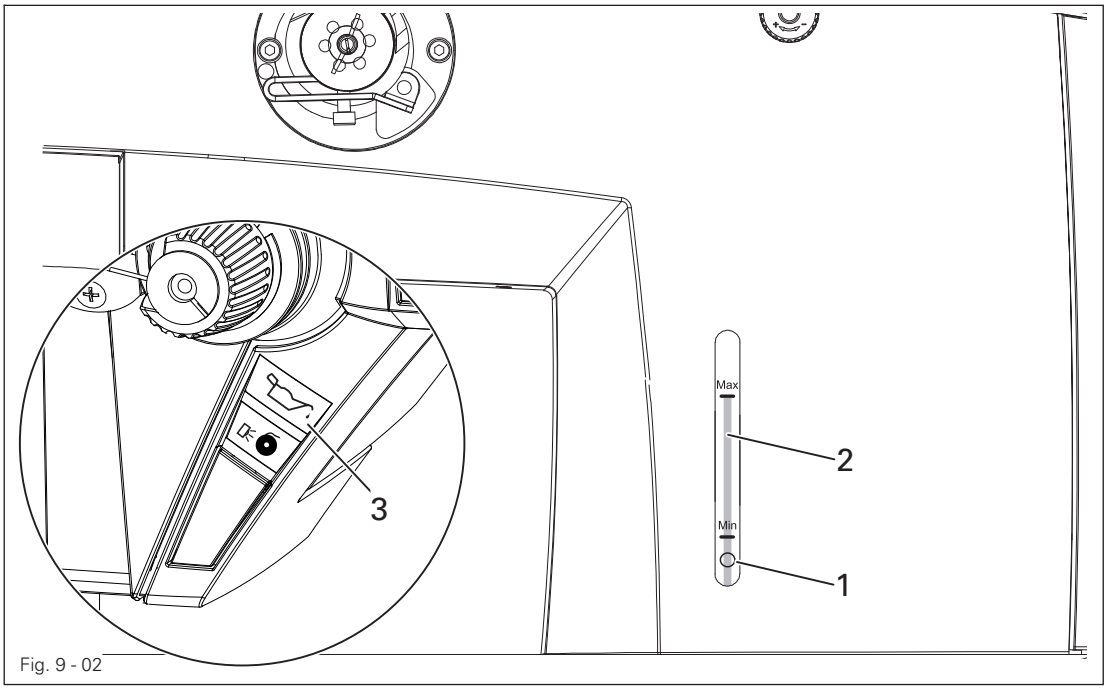
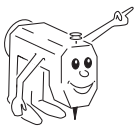


Fig. 9 - 02

Before commissioning the machine, fill in oil through hole **1** until the oil level indicator **2** is at the "MAX" marking.

The oil level is controlled by sensor.
When the minimum oil level is reached, key **3** on the machine head shines red
If required, fill oil into the tank through hole **1**.
Oil level indicator **2** must not exceed the "**MAX**" marking.

Only use oil with a medium viscosity of **22.0 mm²/s** at **40° C** and a density of **0.865 g/cm³** at **15°C**!



We recommend PFAFF sewing-machine oil, part No. **280-1-120 144**.

3.09.04 Checking/regulating the air pressure

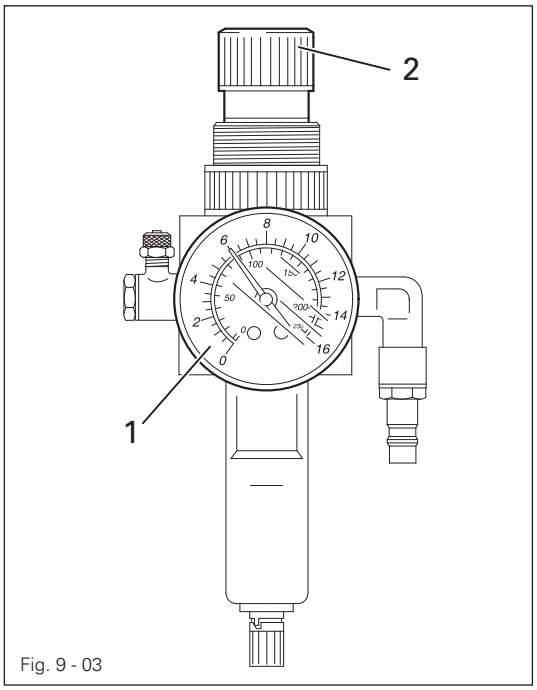


Fig. 9 - 03

- Check the air pressure on gauge **1** every time before operation.
- Gauge **1** must show a pressure of **6** bar.
- Regulate this pressure if required.
- To do so, pull knob **2** up and turn it accordingly.

3.09.05 Emptying/cleaning the water bowl of the air filter/regulator

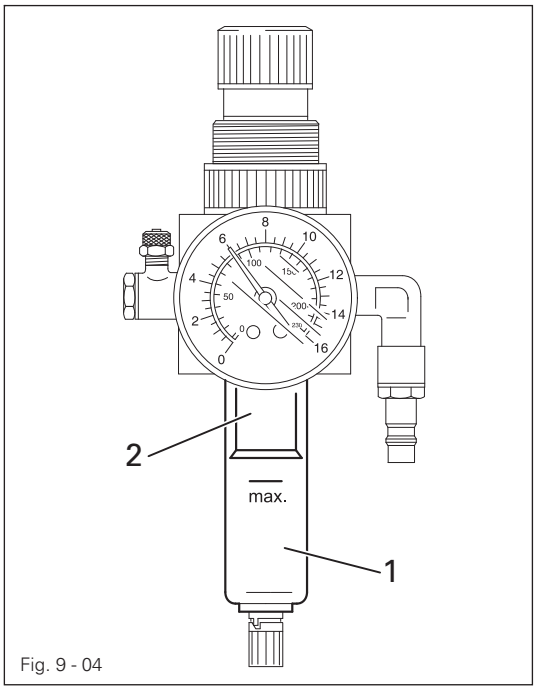


Fig. 9 - 04

Switch off the machine.
Disconnect the air hose at the air filter/regulating unit.

Emptying the water bowl

- Water bowl **1** empties itself automatically when the air hose is disconnected from the air filter/regulator.

Cleaning the filter

- Unscrew water bowl **1** and take out filter **2**.
- Clean the filter with compressed air or with isopropyl-alcohol, part number **95-665735-91**.
- Screw in filter **2** and screw on water bowl **1**.

PFAFF® Industrial

POWERLine

3721

ADJUSTMENT MANUAL

This instruction manual applies to
machines from software version **1.8** and
serial number **2 772 129** onwards

Justieranleitung engl. 04.13

4 Adjustment

Please observe all notes from Chapter **1 Safety** of the instruction manual!
In particular care must be taken to see that all protective devices are refitted properly after adjustment, see Chapter **1.06 Danger warnings** of the instruction manual!

If not otherwise stated, the machine must be disconnected from the electrical power supply. Danger of injury due to unintentional starting of the machine!

4.01 Notes on adjustment

All following adjustments are based on a fully assembled machine and may only be carried out by expert staff trained for this purpose.
Machine covers, which have to be removed and replaced to carry out checks and adjustments, are not mentioned in the text.
The order of the following chapters corresponds to the most logical work sequence for machines which have to be completely adjusted. If only specific individual work steps are carried out, both the preceding and following chapters must be observed.
Screws, nuts indicated in brackets ( ) are fastenings for machine parts, which must be loosened before adjustment and tightened again afterwards.

4.02 Tools, gauges and other accessories for adjusting

- Screwdrivers with blade width from **2** to **10 mm**
- Spanners (wrenches) with jaw width from **7** to **14 mm**
- **1** set Allen keys from **1.5** to **6 mm**
- **1** gauge for the top feed stroke **5.0 mm** (Part No. **61-111 633-60**)
- Metal rule (part No. **08-880 218-00**)
- Sewing thread and test materials

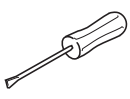
4.03 Abbreviations

t.d.c. = top dead centre
b.d.c. = bottom dead centre

4.04 Explanation of the symbols

In this adjustment manual, symbols emphasize operations to be carried out or important information. The symbols used have the following meaning:

Note, information



Service, repair, adjustment, maintenance
(work to be carried out by qualified staff only)

4.05 Adjusting the basic machine

4.05.01 Basic position of the balance wheel (adjustment aid)

Requirement
When the needle bar is positioned at t.d.c., the marking "**0**" on the scale should be level with the top edge of the belt guard (see arrow).

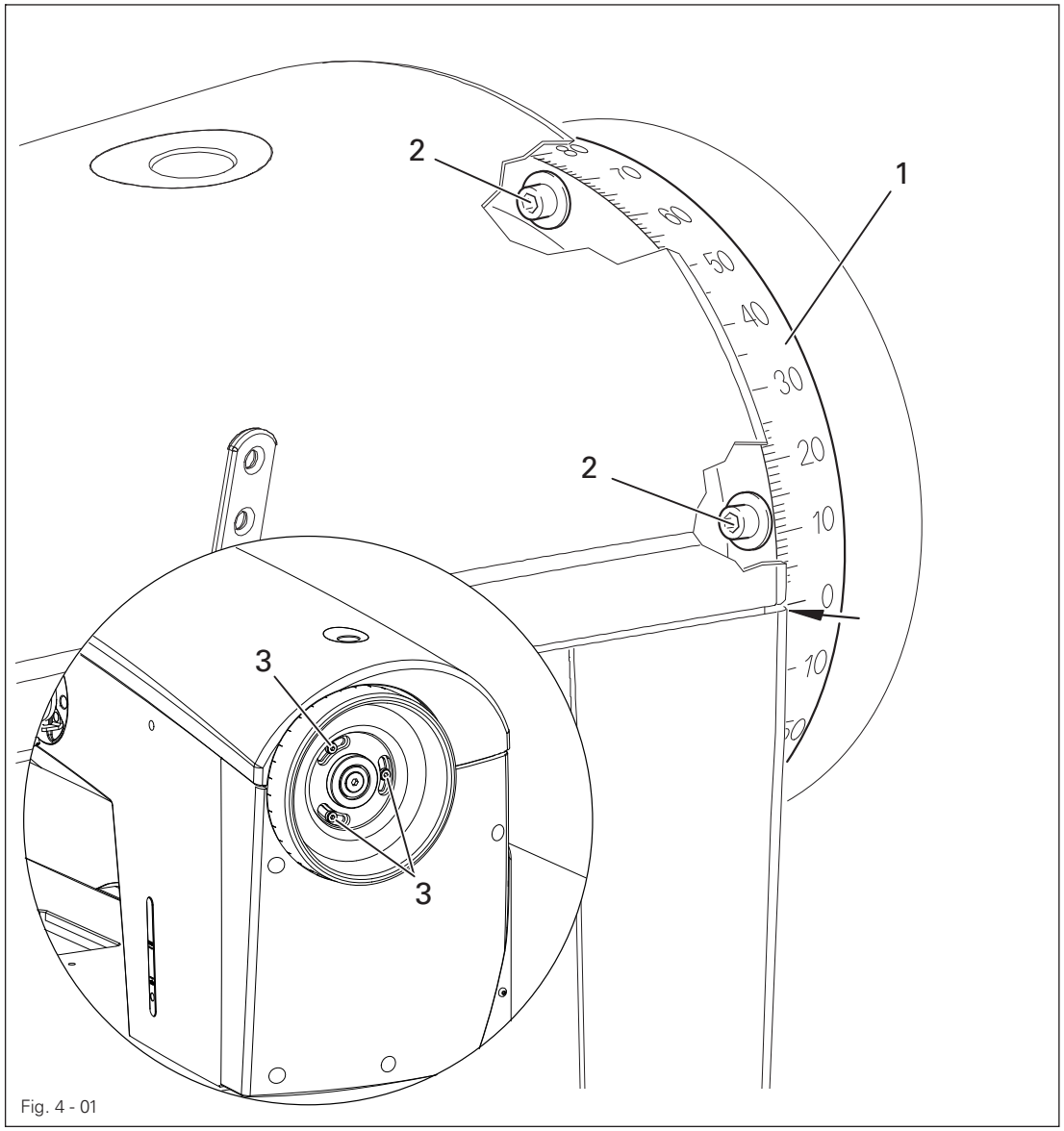


Fig. 4 - 01

- Adjust the scale dial **1** (depending on model screws **2** or **3**) in accordance with the requirement.

4.05.02 Balance weight

Requirement
When the needle bar is positioned at b.d.c. (balance wheel position **180**°) the largest eccentricity of the balance weight **1** should be at the top.

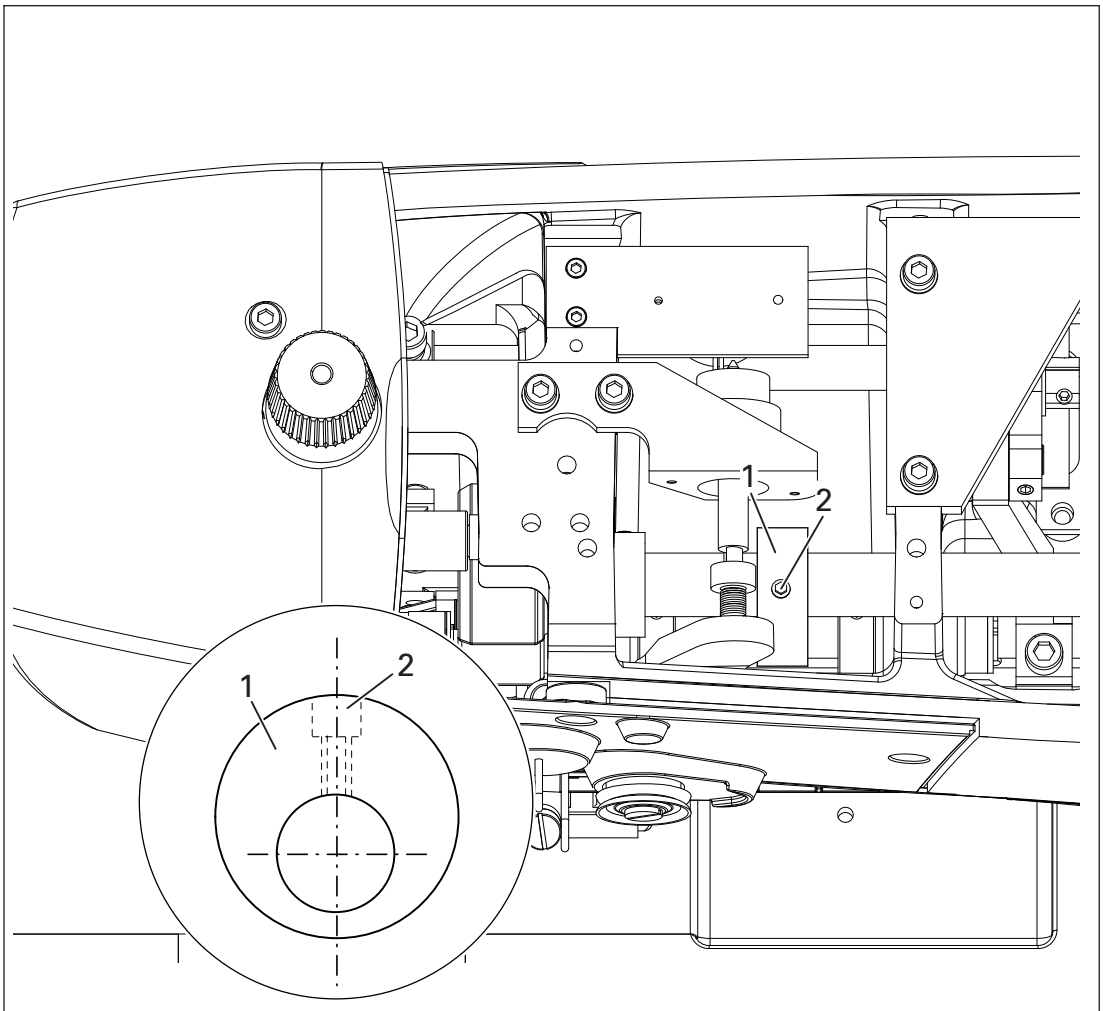


Fig. 4 - 02

- Adjust balance weight **1** (screw **2**) in accordance with the requirement.

4.05.03 Needle position in the direction of sewing

Requirement
With the stitch length set at "**5**", in its front and rear point of reversal the needle should be the same distance from the inside edges of the needle hole.

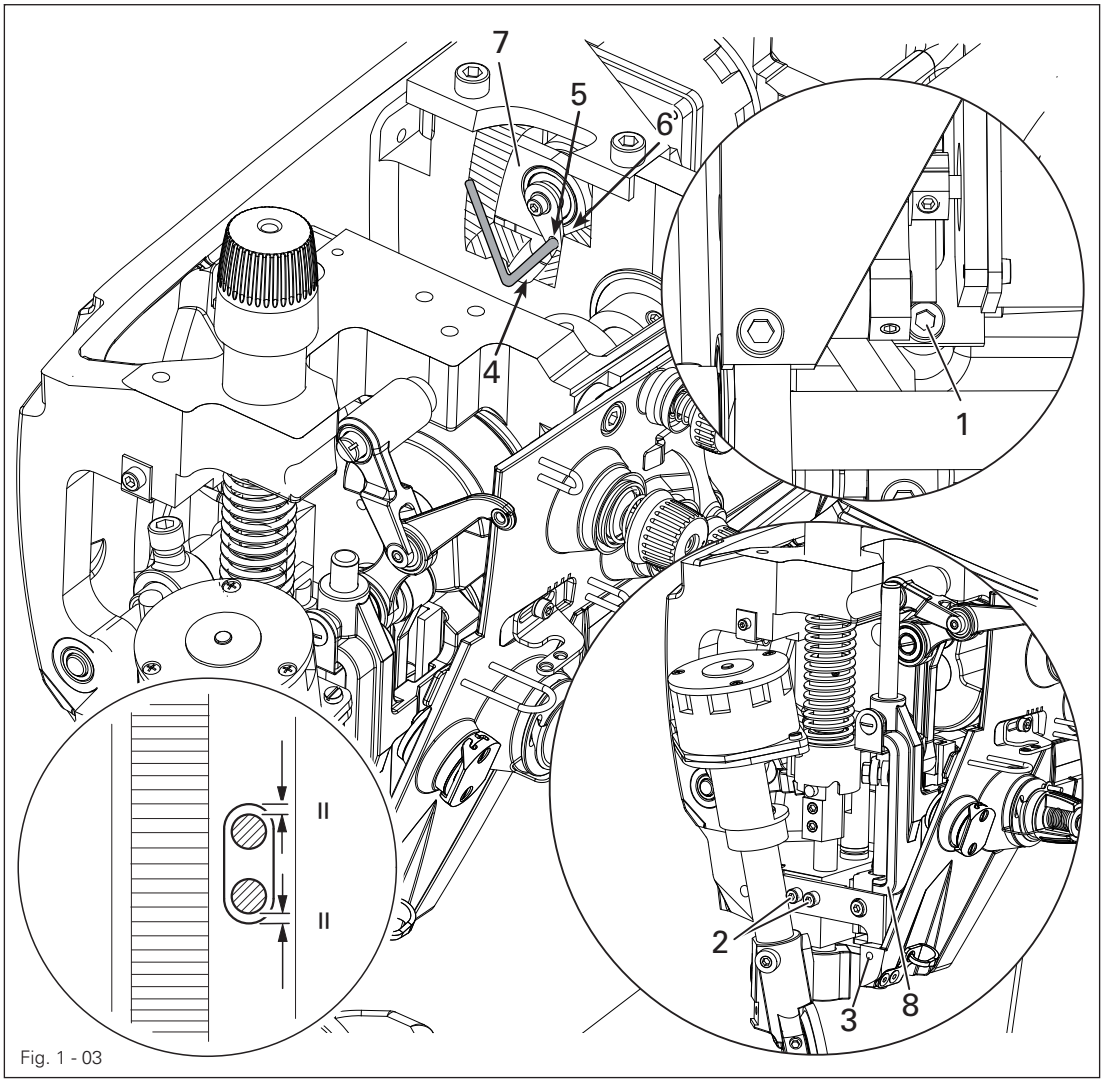
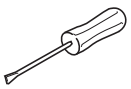


Fig. 1 - 03



- Turn on machine and set stitch length to "**5**".
- Turn machine off and on (synchronise needle bar to stitch length).
- Sew a stitch and check the rear position of the needle according to the requirement.
- Press the stitch control key, sew a stitch and check the forward position of the needle according to the requirement and where necessary make the following adjustments.
- Turn off machine and loosen screws **1**, **2** and **3**.
- Push the adjusting pin's angled part (Order No. **61-111 641-48** through hole **4** and **5** into the hole **6** of the bearing block **7**.
- Move the needle bar frame **8** according to the requirement and tighten screw **1**.
- Check according to the requirement.
- Screws **2** and **3** remain loosened for the subsequent adjustment.

4.05.04 Limiting the needle bar frame

Requirement
With the stitch length set at "**5**", when the needle is in its front and rear point of reversal screw **3** should be the same distance from the inside edge of its hole.

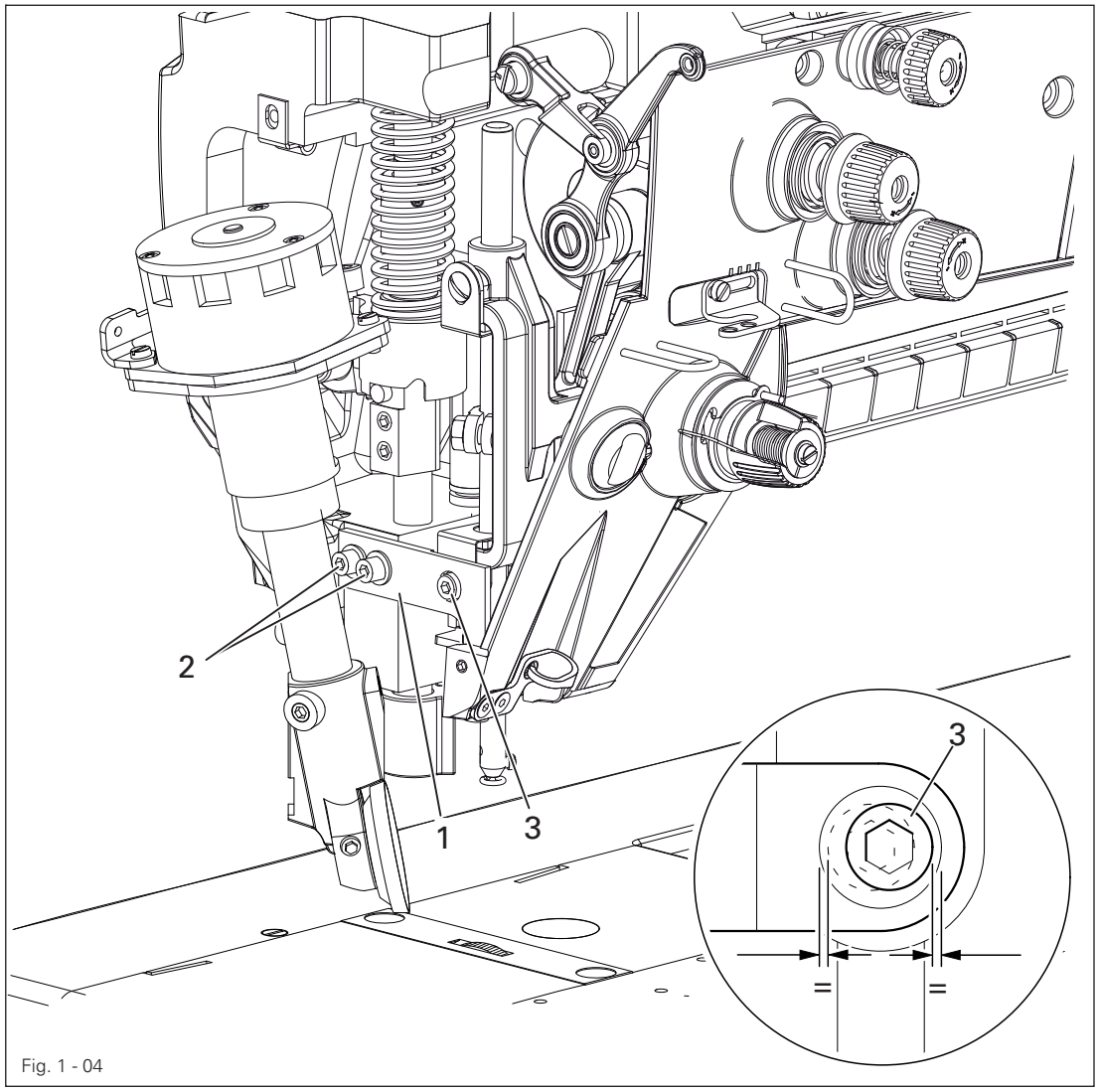


Fig. 1 - 04

- Turn on machine and set stitch length to "**5**".
- Turn machine off and on (synchronise needle bar to stitch length).
- Sew a stitch and check the rear position of the needle according to the requirement..
- Press the stitch control key, sew a stitch and check the forward position of the needle according to the requirement
- If necessary move regulating bow **1** (screw **2** and **3**).

4.05.05 Preliminary adjustment of the needle height

Requirement
When the needle bar is positioned at t.d.c. (handwheel position 0°) there should be a gap between upper edge needle bar and upper edge needle pendulum of about **40 mm.**

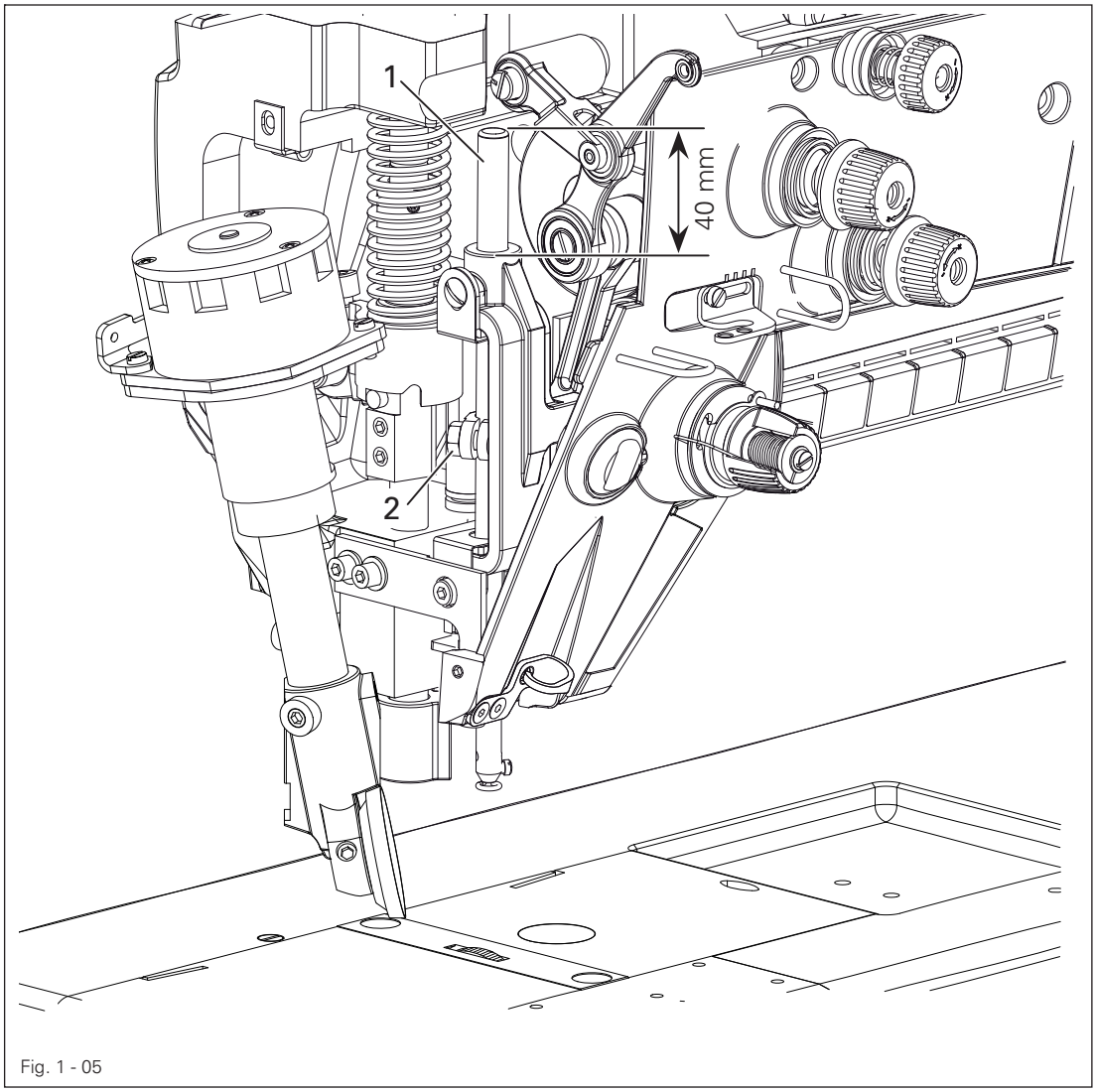
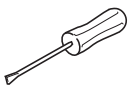


Fig. 1 - 05



- Without turning it, re-position needle bar **1** (screw **2**) in accordance with the **requirement**.

4.05.06 Needle rise, hook clearance, needle height and needle guard

Requirement

With the stitch length set at "**4.0**" and in the needle rise position **2,0 mm** b.d.c. (= Balance wheel position **202°**):

1. the hook point **6** should be positioned at "needle centre" with a hook-to-needle clearance of **0.05 – 0.10 mm**.
2. the top of the needle eye should be positioned **0.8 mm** below hook point **6**
3. and needle guard **7** must touch the needle just lightly.

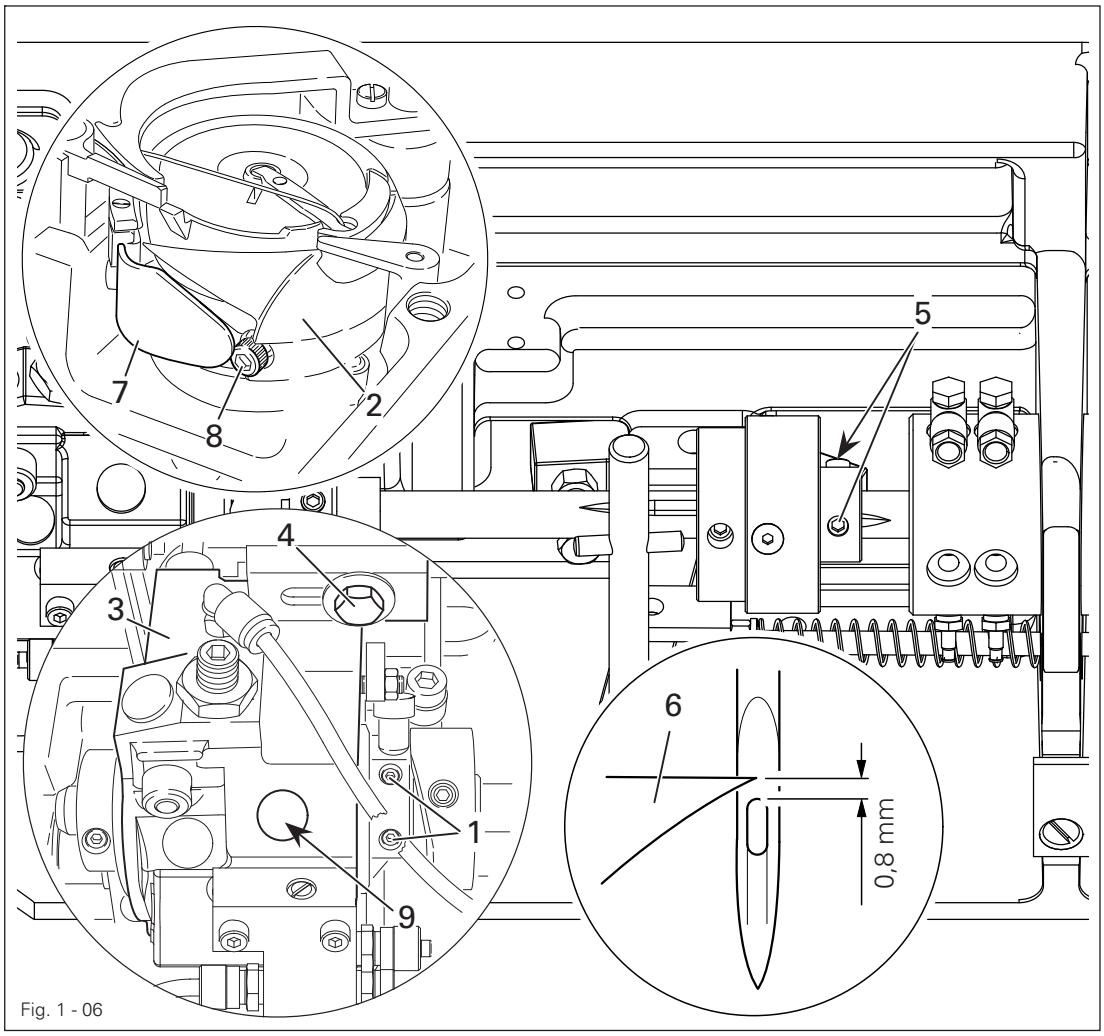
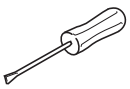


Fig. 1 - 06



- Loosen both screws **1** to the hook **2**.
- Adjust hook **2** and hook bearing **3** (screws **4** and **5**) in accordance with **requirement 1**.
- Without turning it, re-position the needle bar in accordance with the **requirement 2**, also see Chapter **1.05.08 Preliminary adjustment of the needle bar.**
- Adjust needle guard **7** (screw **8**) in accordance with **requirement 3**.
- Set a low cog clearance for screw **9**.

If the needle size is changed, a quick adjustment of hook bearing **3** is possible, after loosening screws **4** and **5**.

4.05.07 Bobbin case opener

Requirement

1. When turning the handwheel, the horn **4** should be lifted off the stitch platen **5** on the right turning point of the bobbin lift **1** by the thread thickness.
2. Bobbin lift upper edge, and lower bobbin upper edge should be at same level.
3. Bobbin lift **1** should be in the right turning point at handwheel position "**300°**".
4. Screw **7** to the return spring of the bobbin lift should be positioned approx. **10** mm above the lock nut **8**.

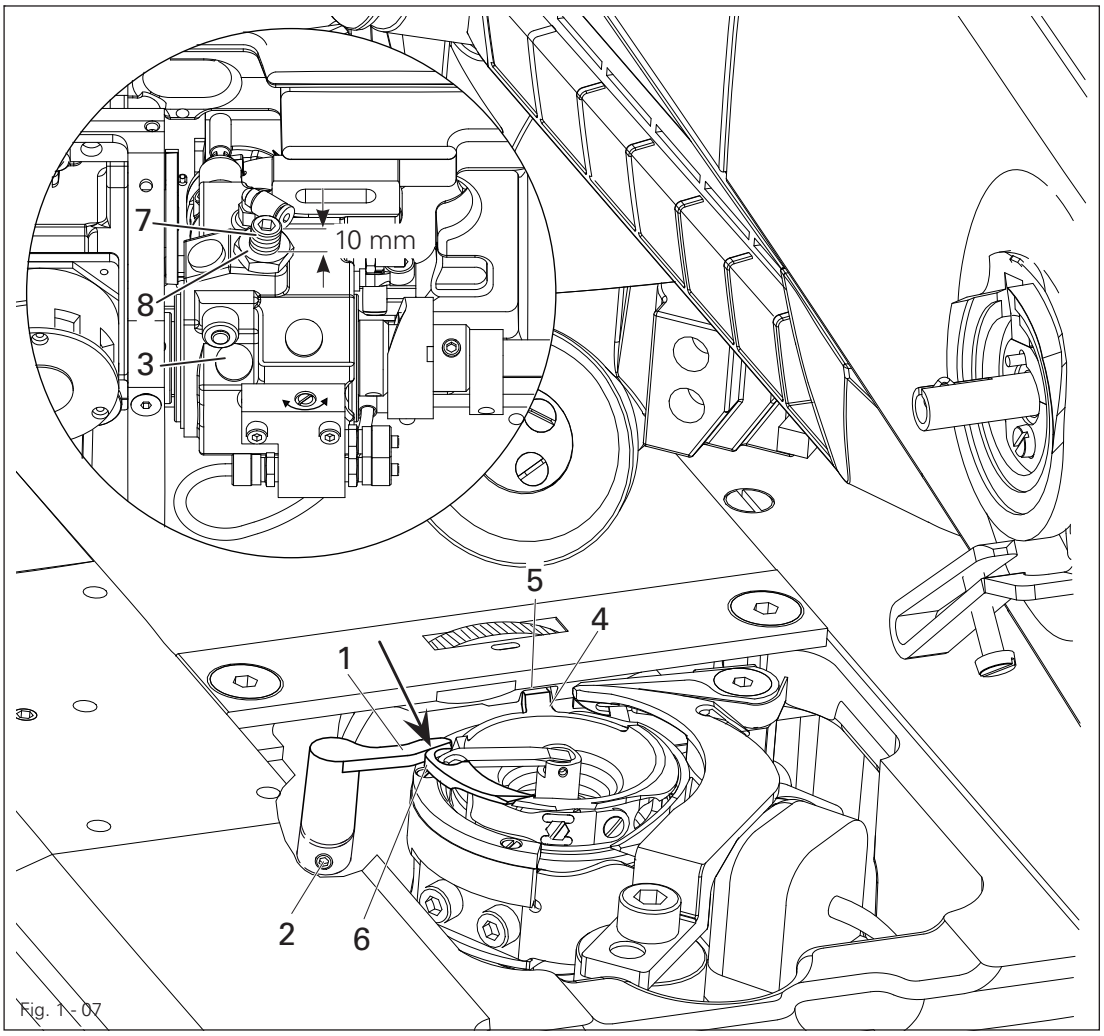


Fig. 1 - 07

- Bobbin lift **1** (screw **2**) must be turned and moved according to requirements **1** and **2**.
- Excenter (screw under cover **3**) must be turned in accordance with requirement **3**.
- Adjust screw **7** (nut **8**) in accordance with requirement **4**.

The thread must pass freely between bobbin lift **1** and bobbin case **6**.

4.05.08 Feed wheel

Requirement

1. The feed wheel should be crossways to the sewing direction in the centre of the needle plate recess.
2. The teeth of the cogwheel should be **0.5** - **0.8** mm above the upper edge of the needle plate, depending on fabric

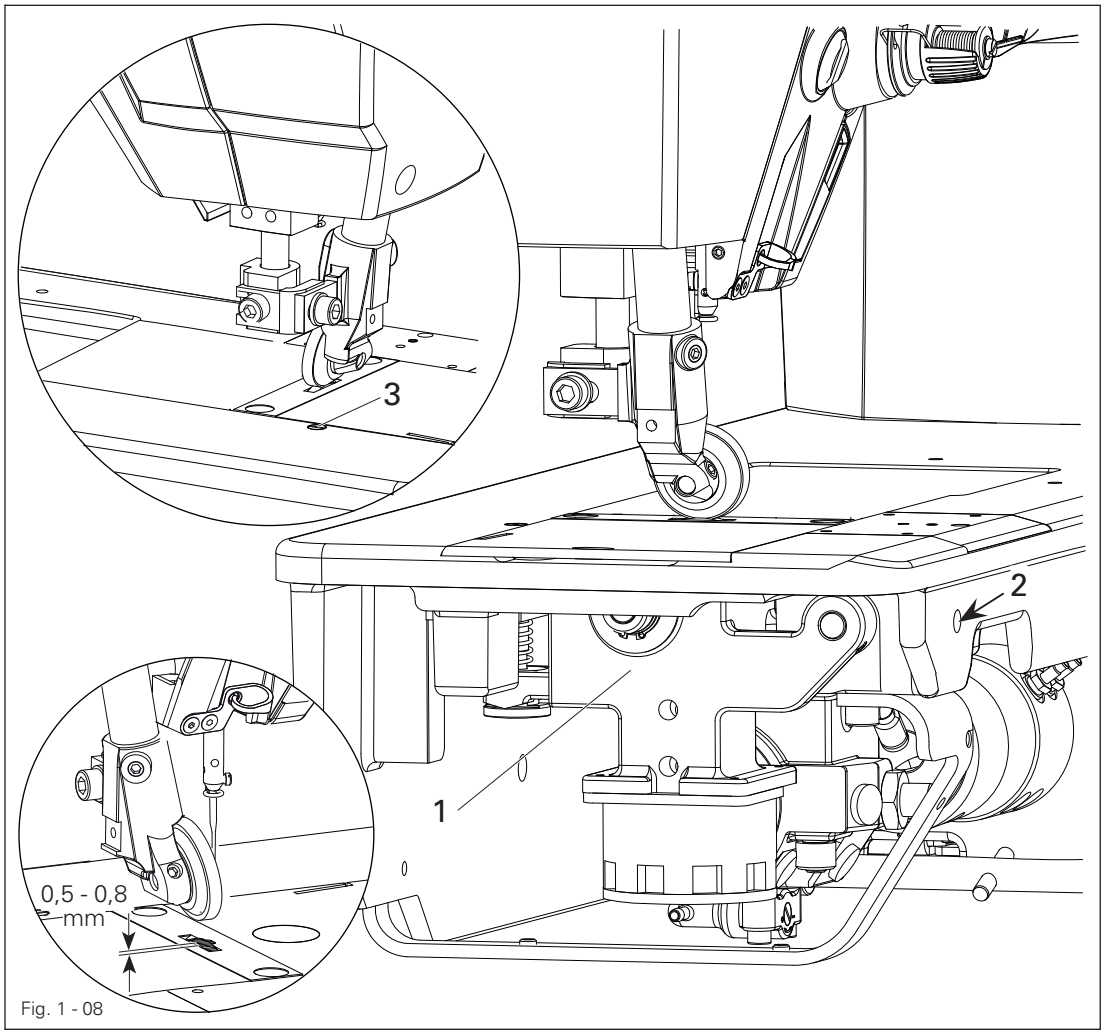


Fig. 1 - 08

- Move feed wheel drive **1** (screw **2**) according to rule **1**.
- Turn screw **3** according to rule **2**

4.05.09 Clearance between roller presser and feed wheel

Requirement

1. With a resting roller-presser there should be a gap between the lift piece **1** and the housing of about **3 mm**.
2. With a raised roller-presser the distance between roller-presser and needle plate should be **8mm**.

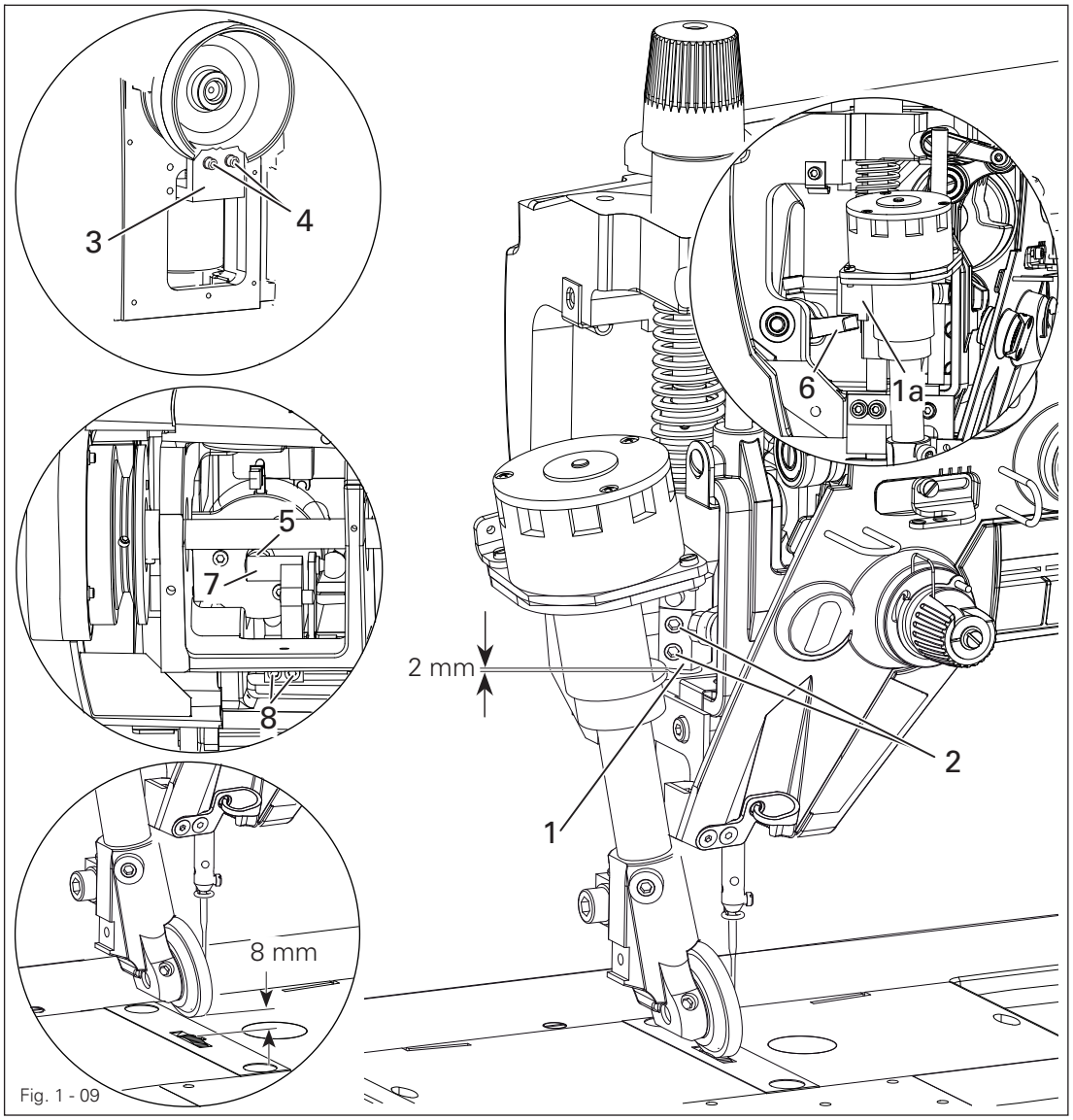
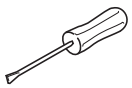


Fig. 1 - 09



- Set the roller-presser down on the needle plate.
- Decrease roller-presser pressure.
- Adjust lift piece **1** (screws **2**) according to the requirement **1**.
- Push magnet bracket **3** (screws **4**) downwards as far as it will go.
- Raise the roller-presser and place an **8mm** gauge under the roller-presser.
- With magnet plunger **5** extended, move lever **6** up against lift piece **1**a and mount lever **7** (screws **8**) on to magnet plunger **5**.
- Check according to the requirement.

4.05.10 Roller-presser

Requirement

When the roller-presser **1** is resting on the feed wheel **6** it must

1. be parallel to the feed wheel **6** when viewed in the direction of sewing,
2. be in the middle of the (needle when viewed in the direction of sewing and
3. be as close as possible to the needle when viewed in transverse direction of sewing.

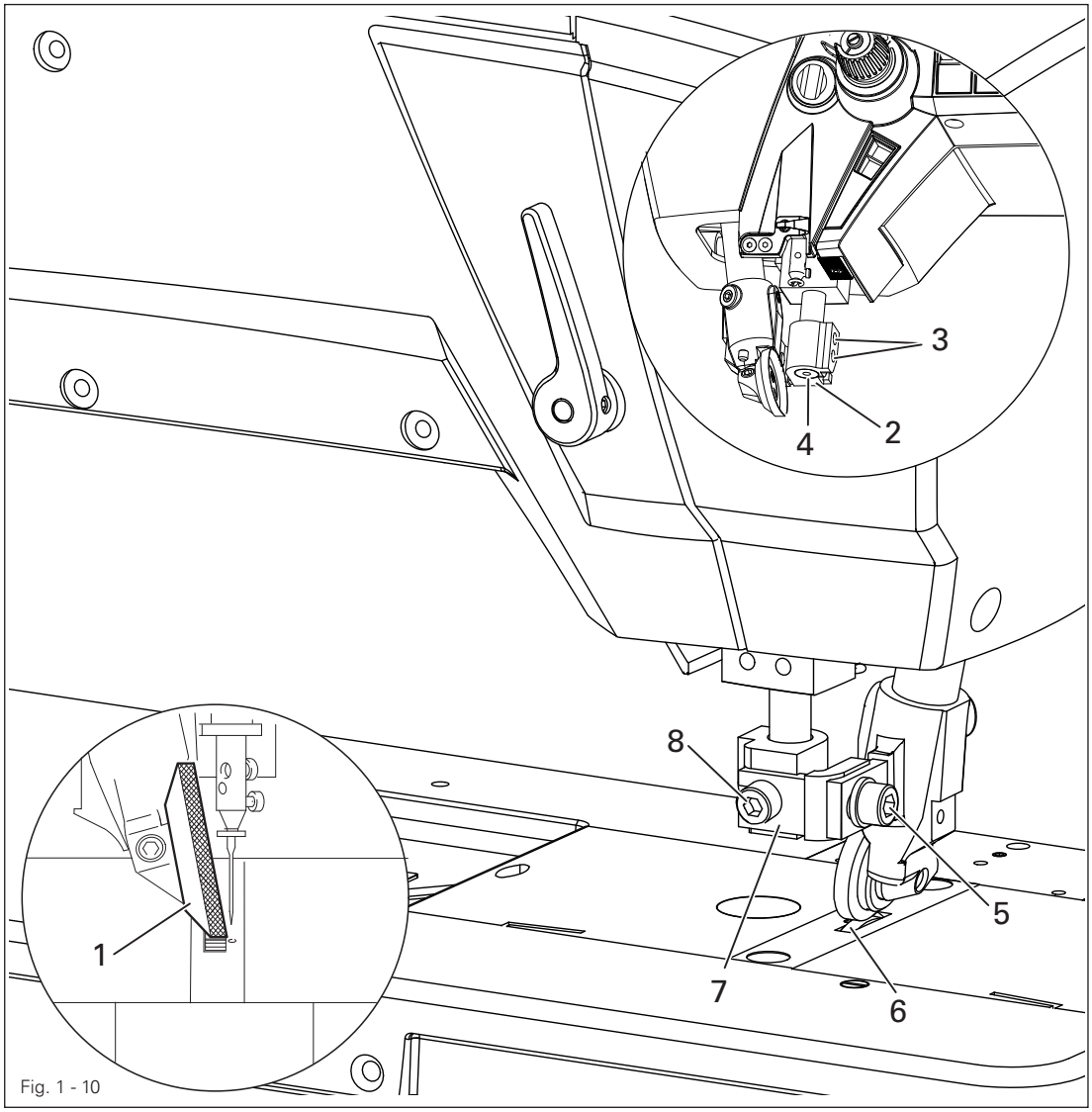
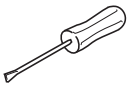


Fig. 1 - 10



- Raise the roller-presser **1**.
- Place roller-presser bracket **2** (screws **3**) flush to the bottom edge of presser bar **4**.
- Always observe **requirement 1** when carrying out the following adjustments.
- Move the roller-presser **1** (screw **5**) in accordance with **requirement 2**.
- Allow the roller-presser **1** to come to rest on the feed wheel **6**.
- Move bracket **7** (screw **8**) according to requirement **3**.

When sewing very tight curves the roller-presser **1** should be moved toward the operator slightly.

4.05.11 Bobbin winder

Requirement

1. After deactivating the winder, the blade should be in **11** o'clock position and microswitch **4** should be pressed.
2. Winder speed must be set to switch off automatically, once the bobbin is full.

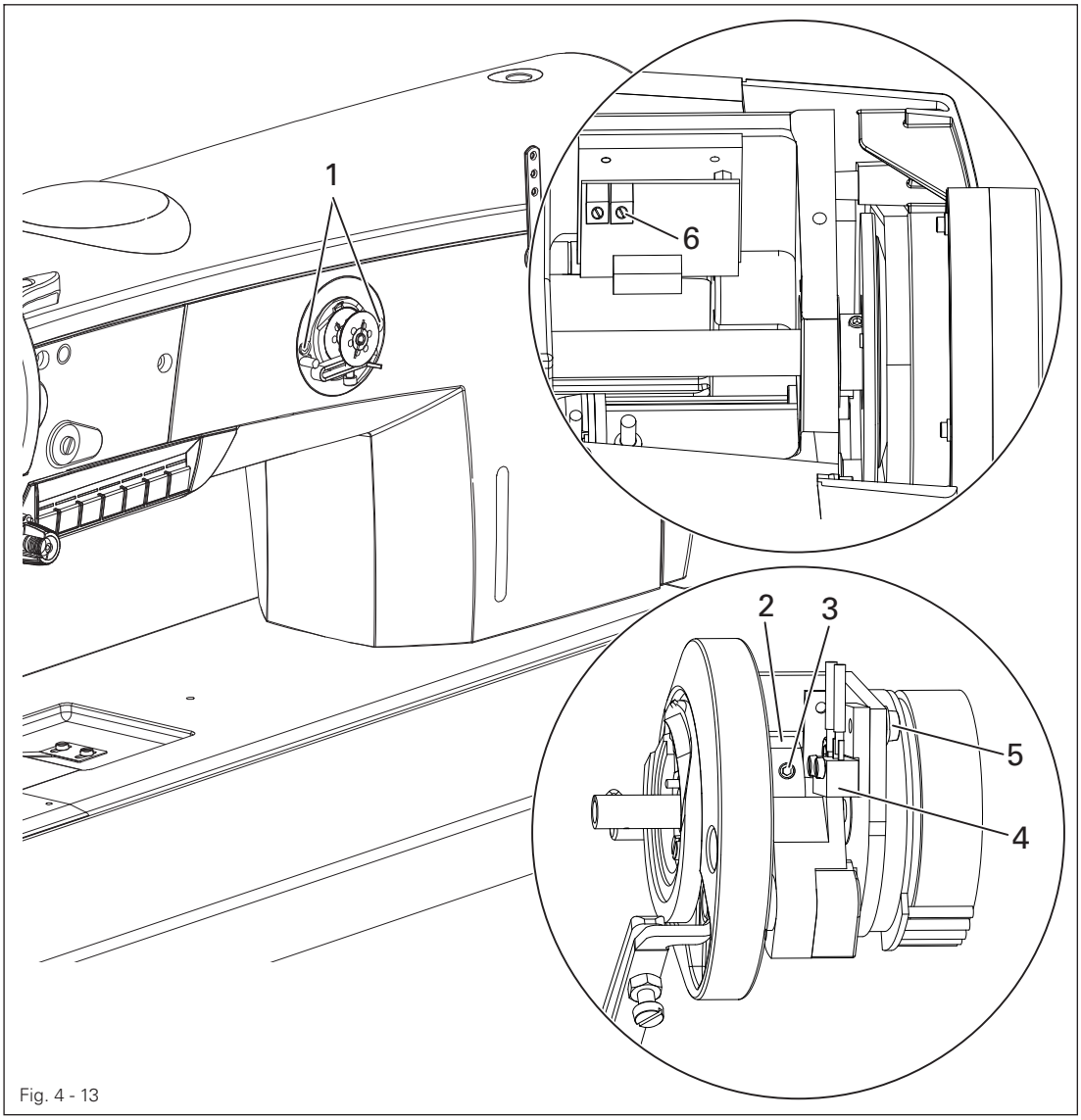


Fig. 4 - 13

- Switch machine off.
- Unscrew screw **1** and remove bobbin
- Adjust spreader **2** (screw **3**) in accordance with **requirement 1**.
- Adjust microswitch **4** (screw **5**) in accordance with **requirement 1**.
- Bobbin speed at Pos **6** must be adjusted in accordance with **requirement 2**.

4.05.12 Thread check spring and thread regulator

Requirement

1. The movement of thread regulator **3** must be completed when the needle point enters the material.
2. When the thread loop is at its largest while being passed around the hook, the check thread spring **3** should rise slightly from the rest **1**.

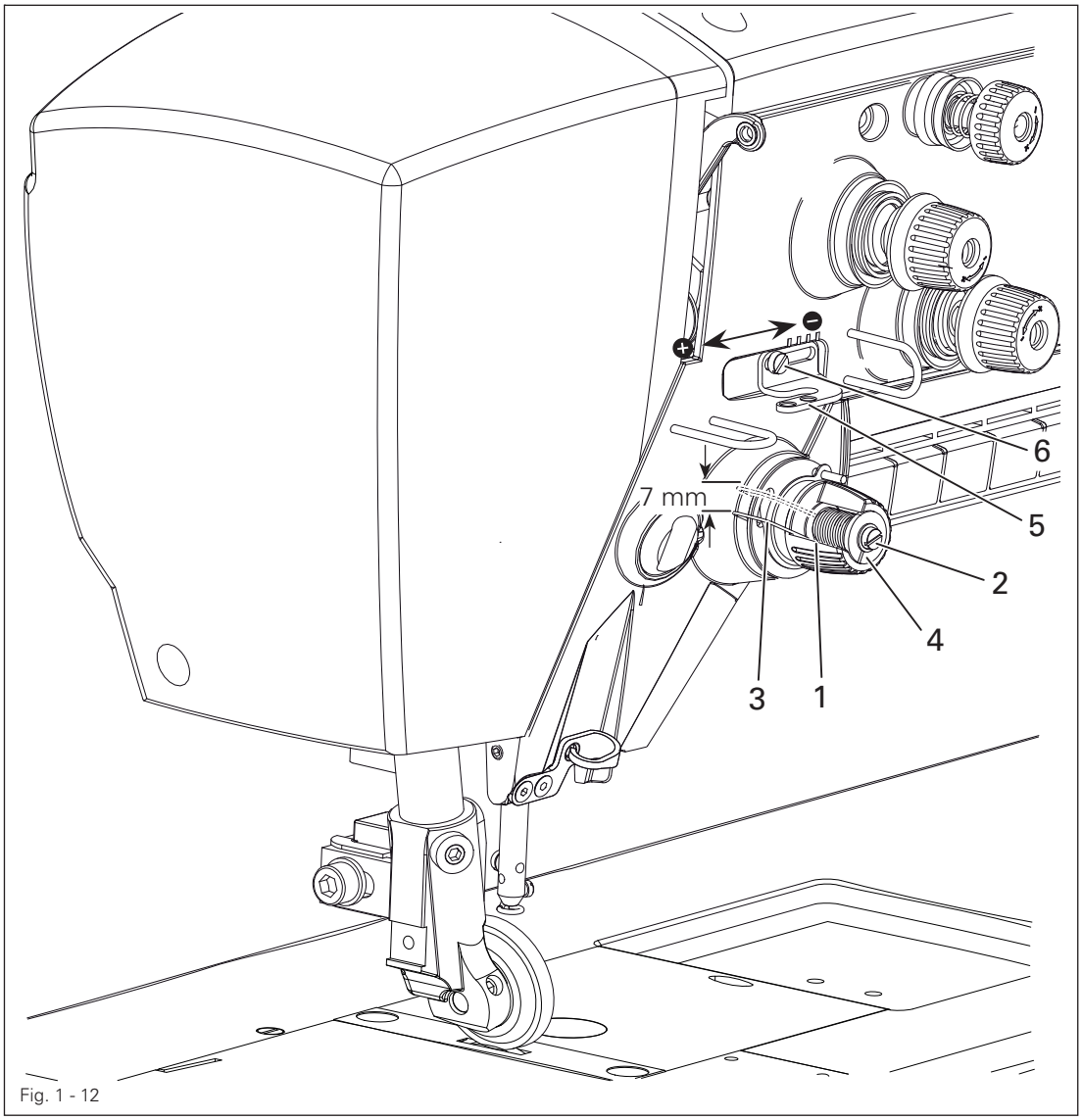
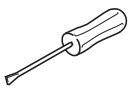


Fig. 1 - 12



- Position rest **1** (screw **2**) in accordance with **requirement 1**.
- Turn sleeve **4** (screw **2**) to adjust the tension of thread check spring **3**.
- Position thread regulator **5** (screw **6**) in accordance with **requirement 2**.

For technical reasons it may be necessary to deviate from the indicated spring stroke or spring tension.
Move thread regulator **5** (screw **6**) towards ("+") (= more thread) or ("-") (= less thread).

4.05.13 Upper thread tension

Requirement
After switching the machine on (reference position), the tension spring **3** should touch motor tappet **4** lightly, with a **1 mm** gauge inserted between the tension shims **5**.

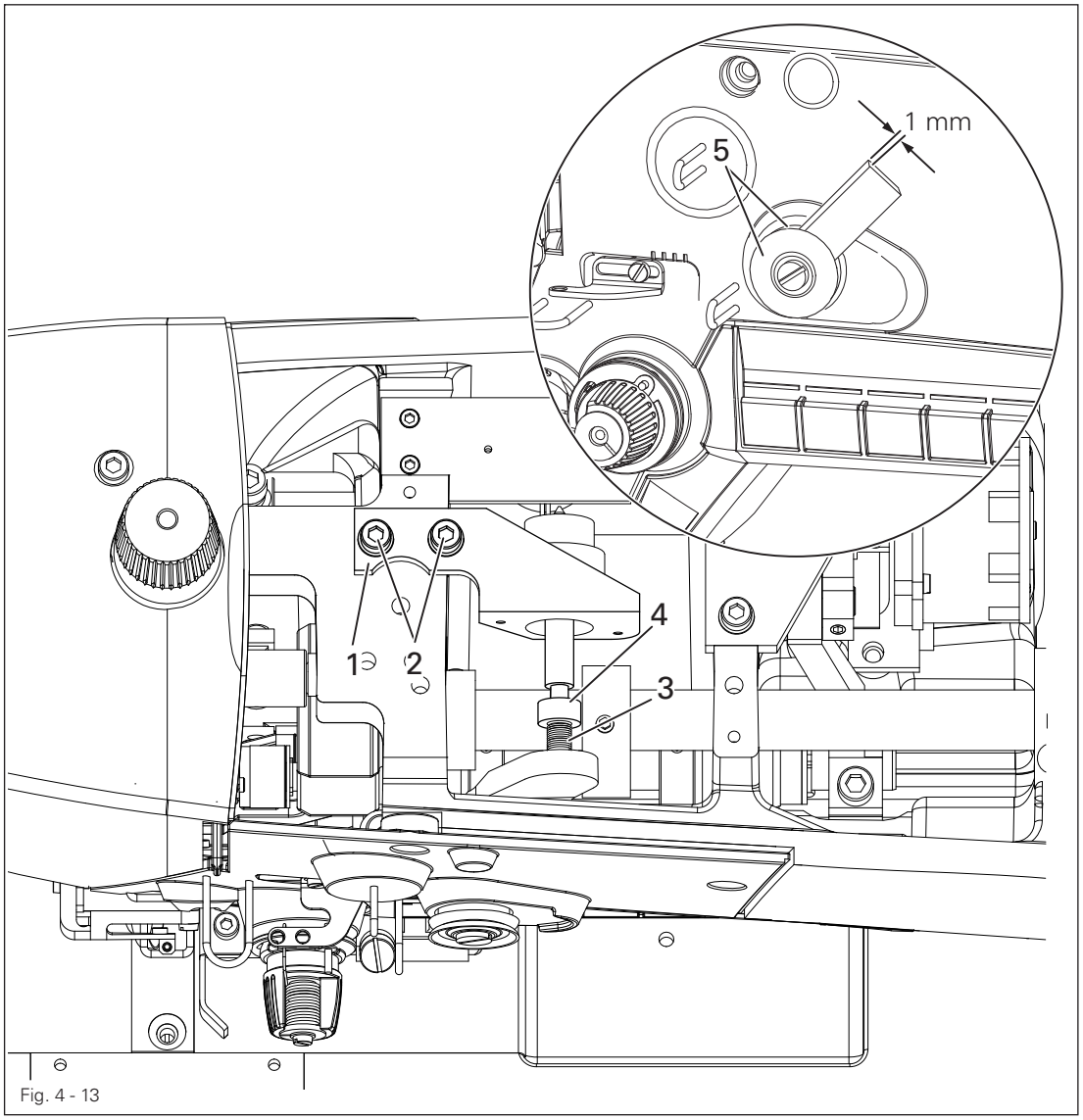


Fig. 4 - 13

- Adjust carrier **1** (screws **2**) in accordance with requirements.

4.05.14 Sewing foot pressure

Requirement
The material should be fed properly even at maximum speed and with the smallest stroke.

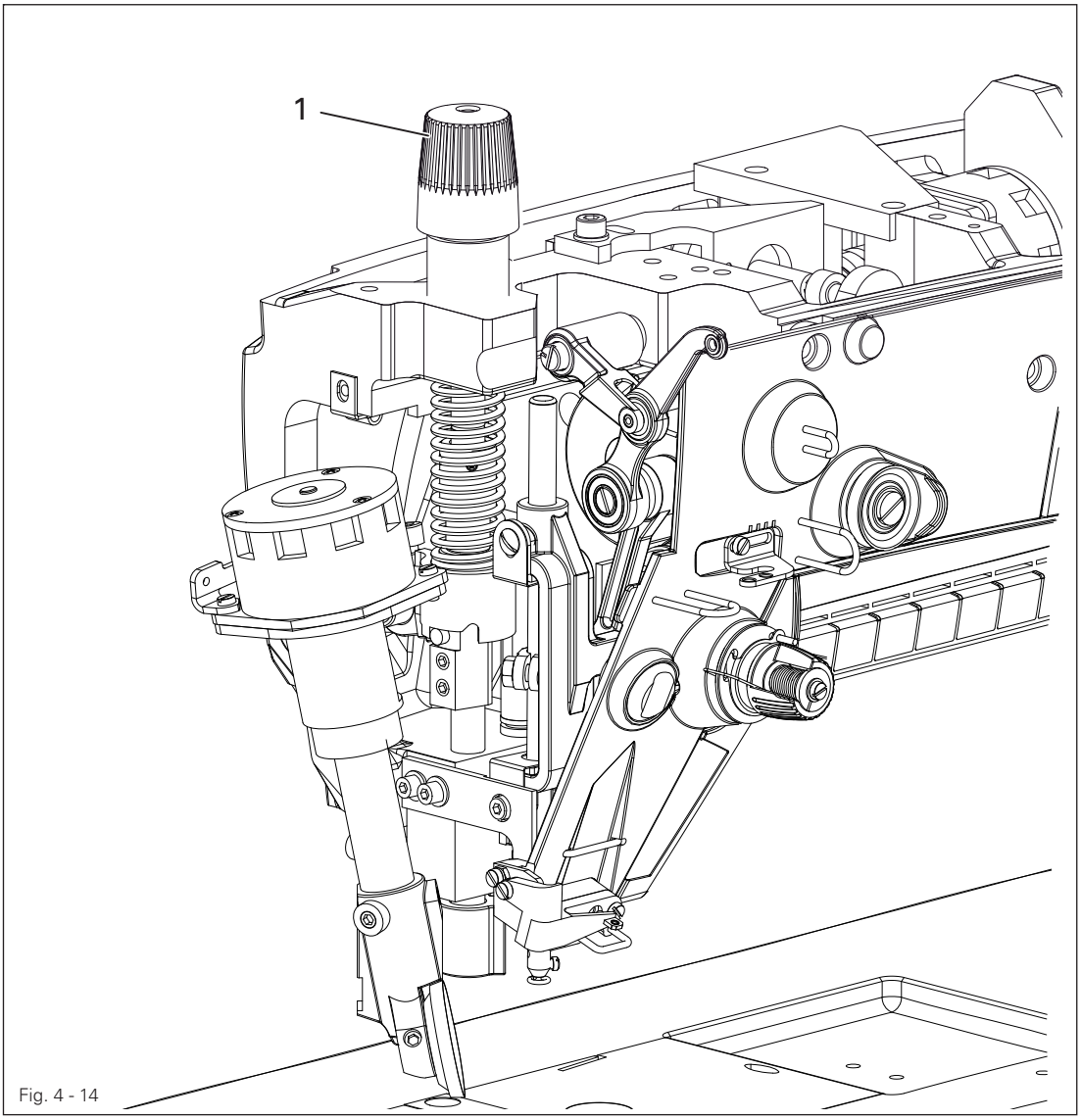


Fig. 4 - 14

- Turn adjustment wheel **1** in accordance with the requirement.

4.05.15 Lubrication

Requirement
After 10 seconds operation at **800** rpm, a light oil strip should appear on a paper strip held to the clamp foot.

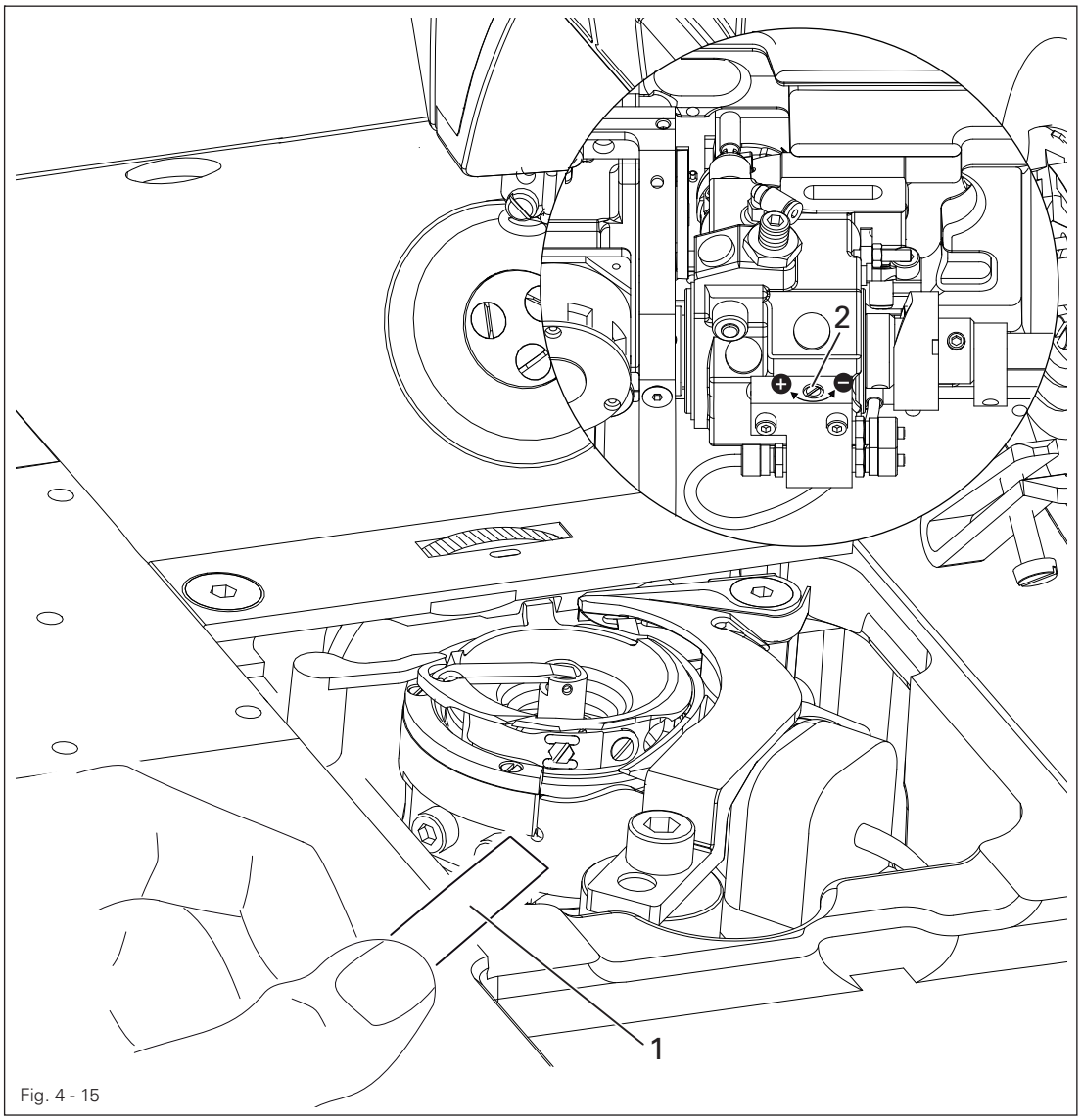
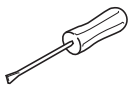


Fig. 4 - 15

- In manuel sewing activate monitor function.



- Check that the machine is filled with oil and that the oil lines are free of air.
- Run the machine for **2** – **3** min.

Do not put your hands into the needle area when the machine is running!
Danger of injury from moving parts!

- With the machine running, hold the paper strip against the hook and check the requirement.
- If necessary, regulate amount of oil with screw **1**

4.05.16 Re-engaging the slip-clutch

Clutch **1** is adjusted at the works. In the case of a thread jamming, clutch **1** will disengage, in order to avoid damage to the hooks.
The following describes how to re-engage clutch **1**.

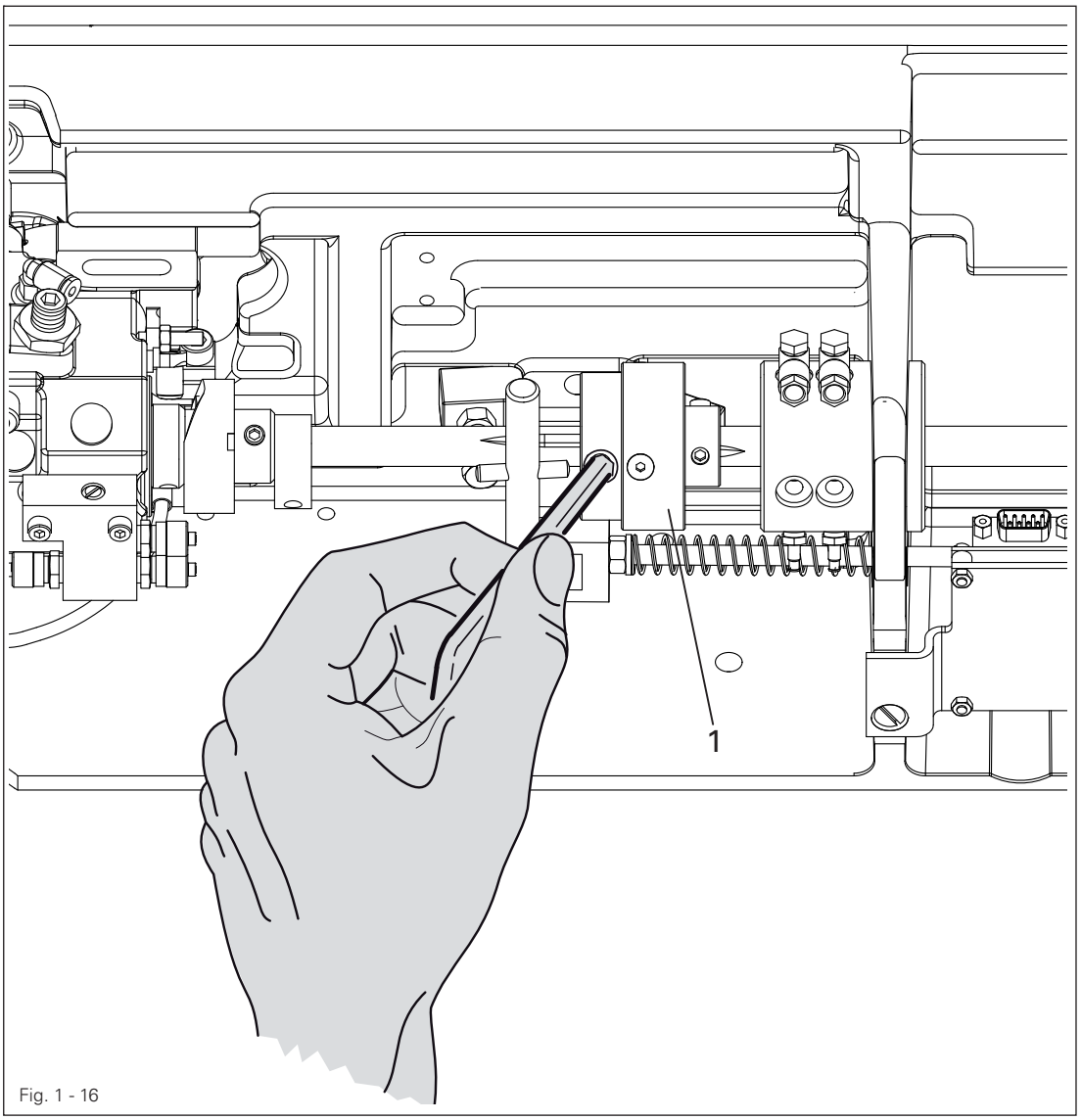


Fig. 1 - 16

- Remedy jammed thread fault.
- Hold clutch **1** firmly, as shown in Fig. **1** - **16**, and turn the balance wheel until clutch **1** re-engages.

4.06 Adjusting the thread trimmer -900/81

4.06.01 Resting position of roller lever/radial position of control cam

Requirement

1. When the take-up lever is at t.d.c. (balance wheel position **60** °), control cam **1** should just have moved roller lever **5** into its basic position.
2. When the thread trimmer is in its resting position, there should be a clearance of **0.1 mm** between roller lever **5** and control cam **1**.

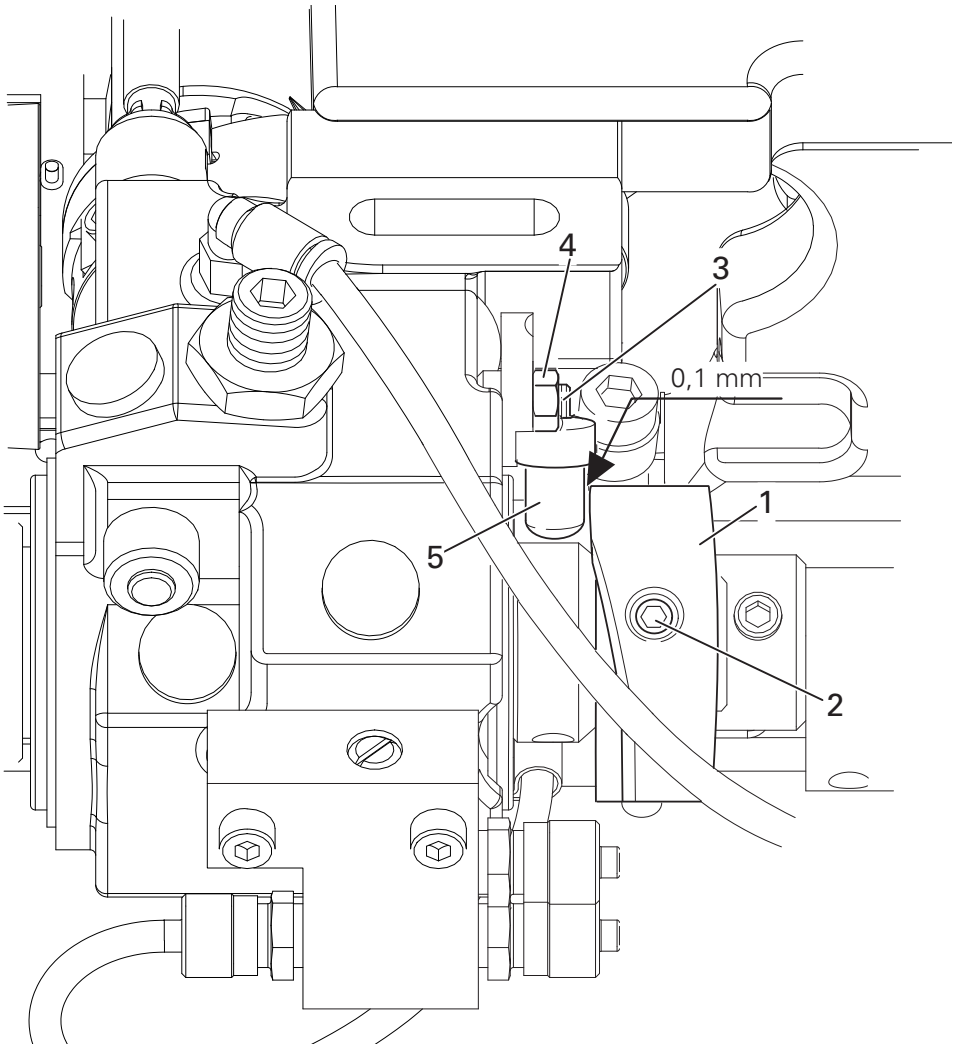


Fig. 1 - 17

- Adjust control cam **1** (screws **2**) in accordance with **requirement 1**.
- Adjust screw **3** (nut **4**) in accordance with **requirement 2**.

4.06.02 Position and height of the thread catcher

Requirement
When the needle bar is positioned at b.d.c. (balance wheel position **180**°) the edges of thread catcher **3** and knife **5** should be flush (see arrow).

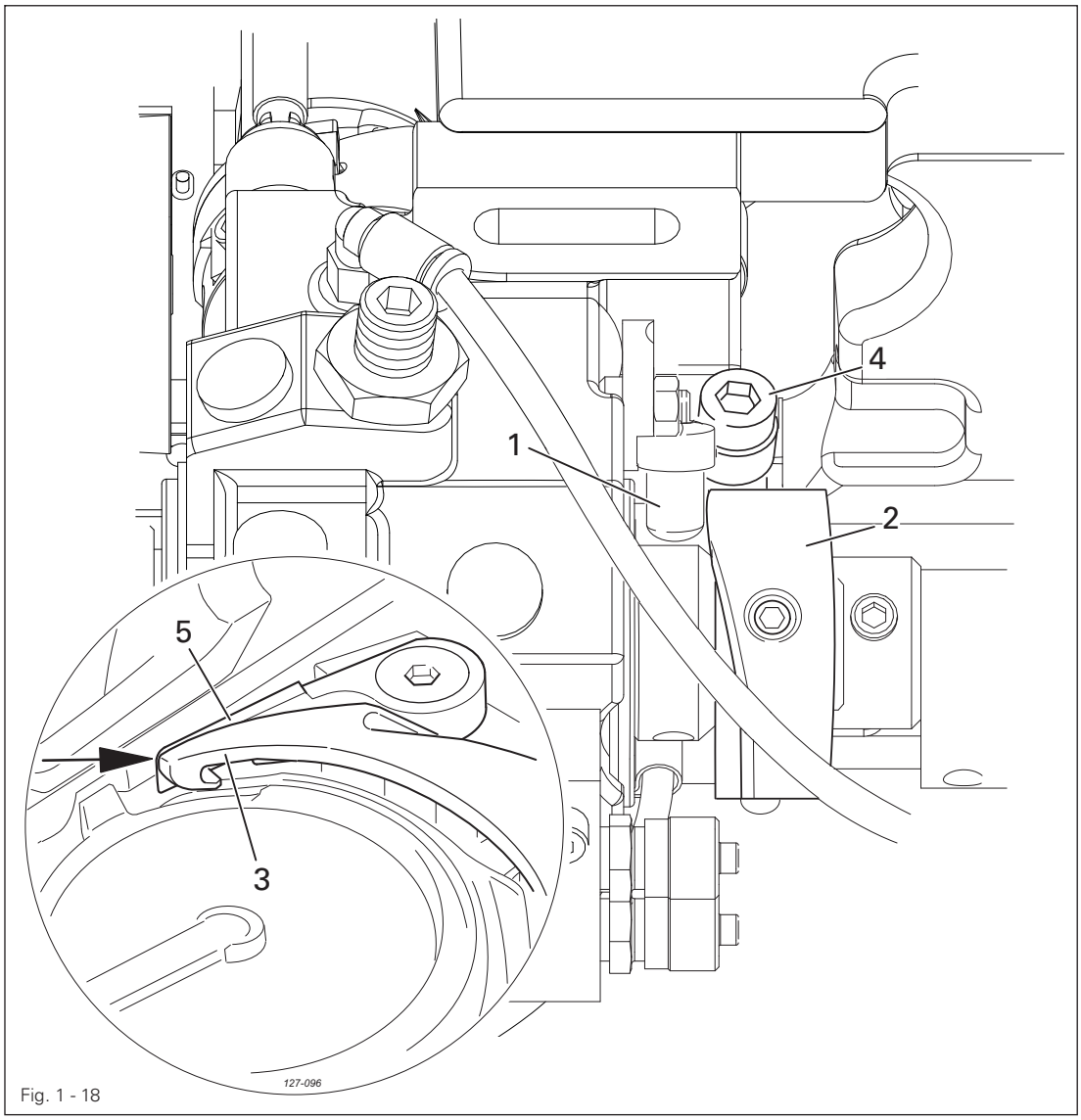


Fig. 1 - 18

- Press roller lever **1** against control cam **2**.
- Adjust thread catcher **3** (screw **4**) in accordance with the **requirement**

The height of thread catcher **3** is pre-set by the manufacturer and, if necessary, it can be adjusted with washers under thread catcher **3** on the base of the hook bearing.

4.06.03 Knife pressure

Requirement
When the front edge of thread catcher **3** is **5 – 6 mm** in front of the knife blade, the knife **4** should be touching the catcher edge with slight pressure.

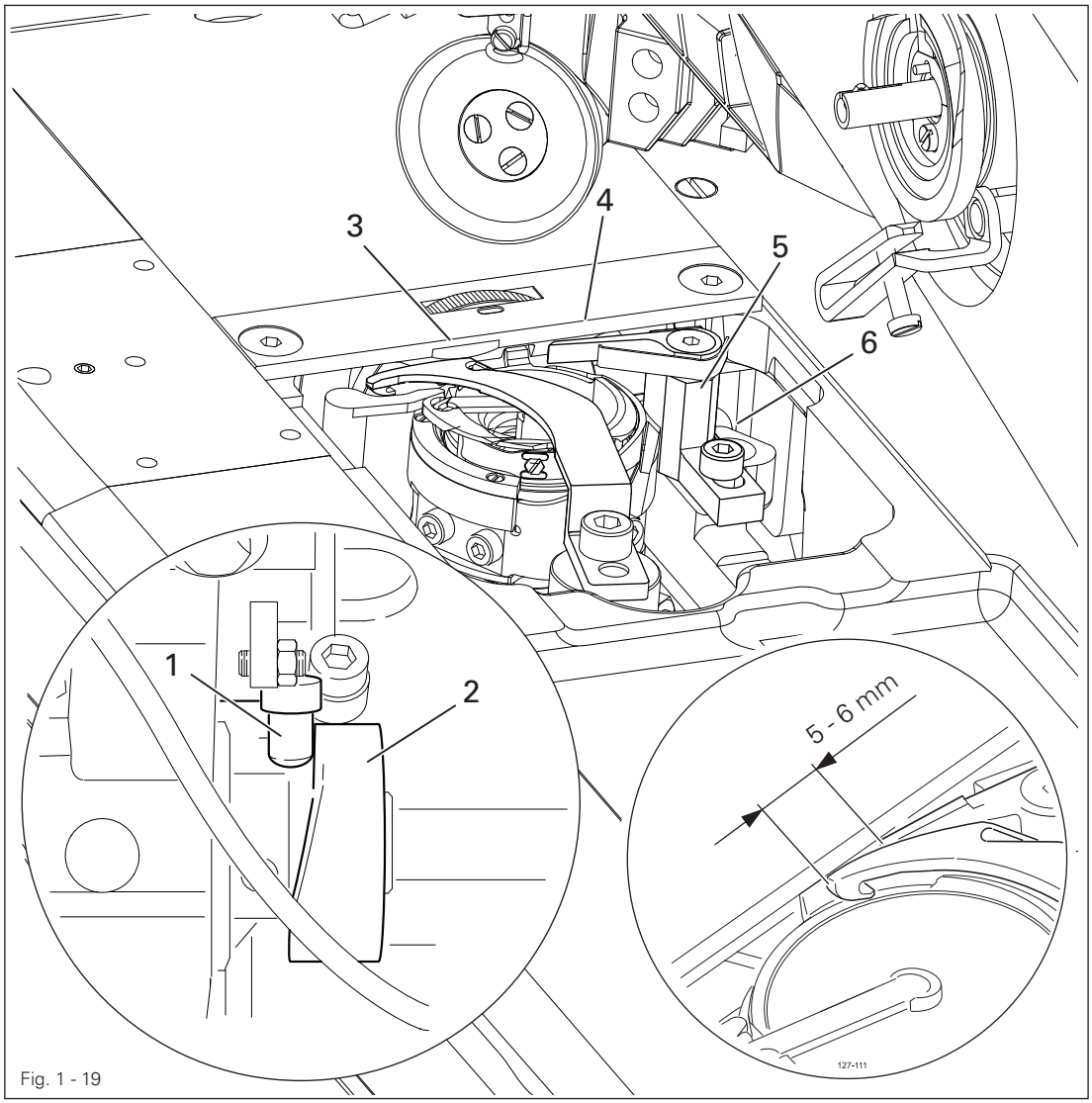


Fig. 1 - 19

- Bring the take-up lever to its b.d.c and press roller lever **1** into the control cam **2**.
- Turn the balance wheel until the front edge of catcher **3** is at a distance of **5 – 6 mm** from the blade of knife **4**.
- Swing knife bearing **5** (screw **6**) in accordance with the **requirement**.

After completing the adjustment, recheck the position of the thread catcher in accordance with Chapter **4.06.02 Position and height of the thread catcher**.

4.06.04 Bobbin thread clamp spring

Requirement
When the thread trimmer is in its cutting position, the clamp spring should slightly touch the thread catcher and hold the thread reliably.

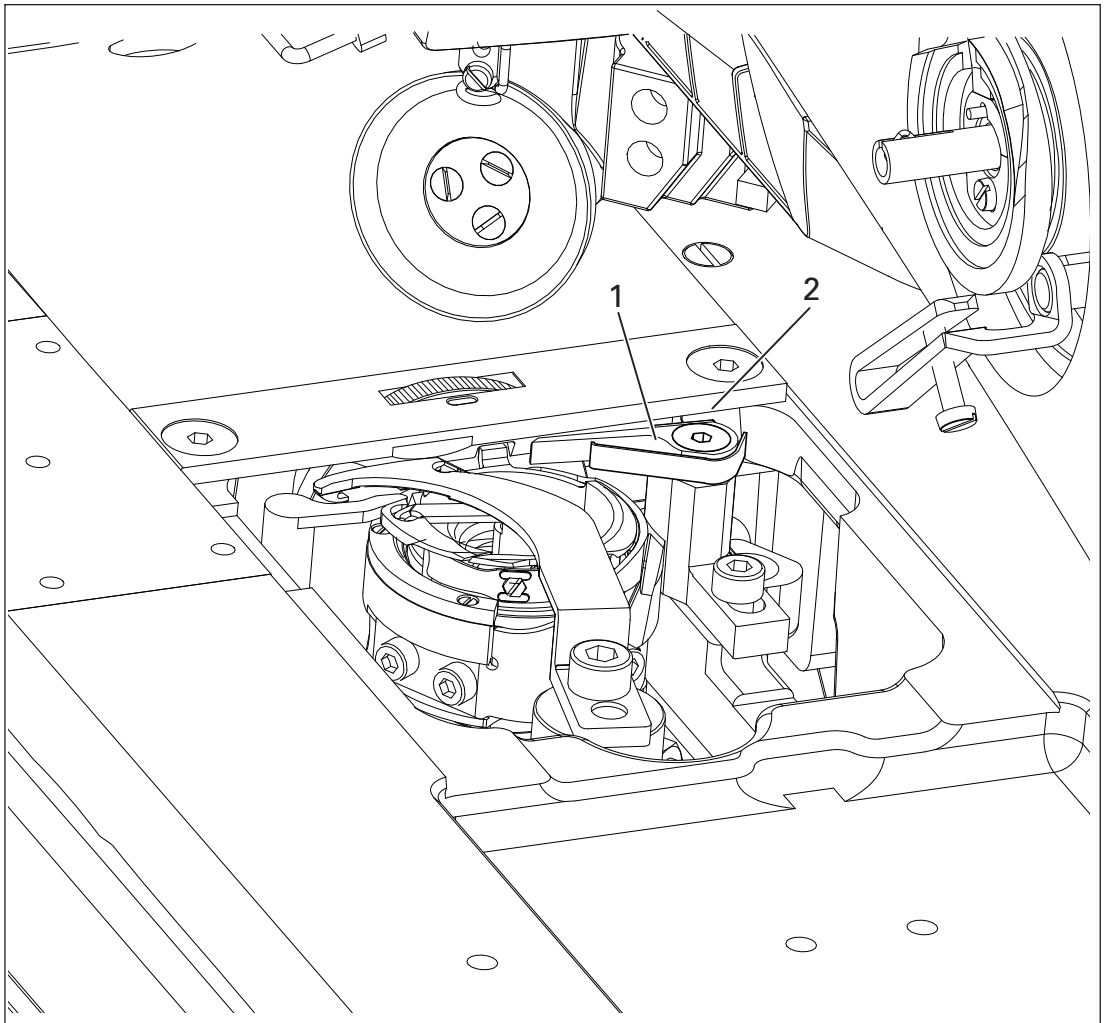
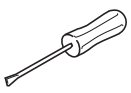


Fig. 1 - 20



- Adjust clamp spring **1** (screw **2**) in accordance with the **requirement**.
- Carry out the cutting operation by hand and check the setting. Readjust if necessary.

4.06.05 Manual cutting test

Requirement

1. **1**. When moving forward, thread catcher **1** must not move bobbin thread **3**
2. When thread catcher **1** is at its front point of reversal, bobbin thread **3** should be in the centre of the marked area (see arrow).
3. After the cutting operation has been completed, needle and bobbin thread should be cut neatly and bobbin thread **3** held.

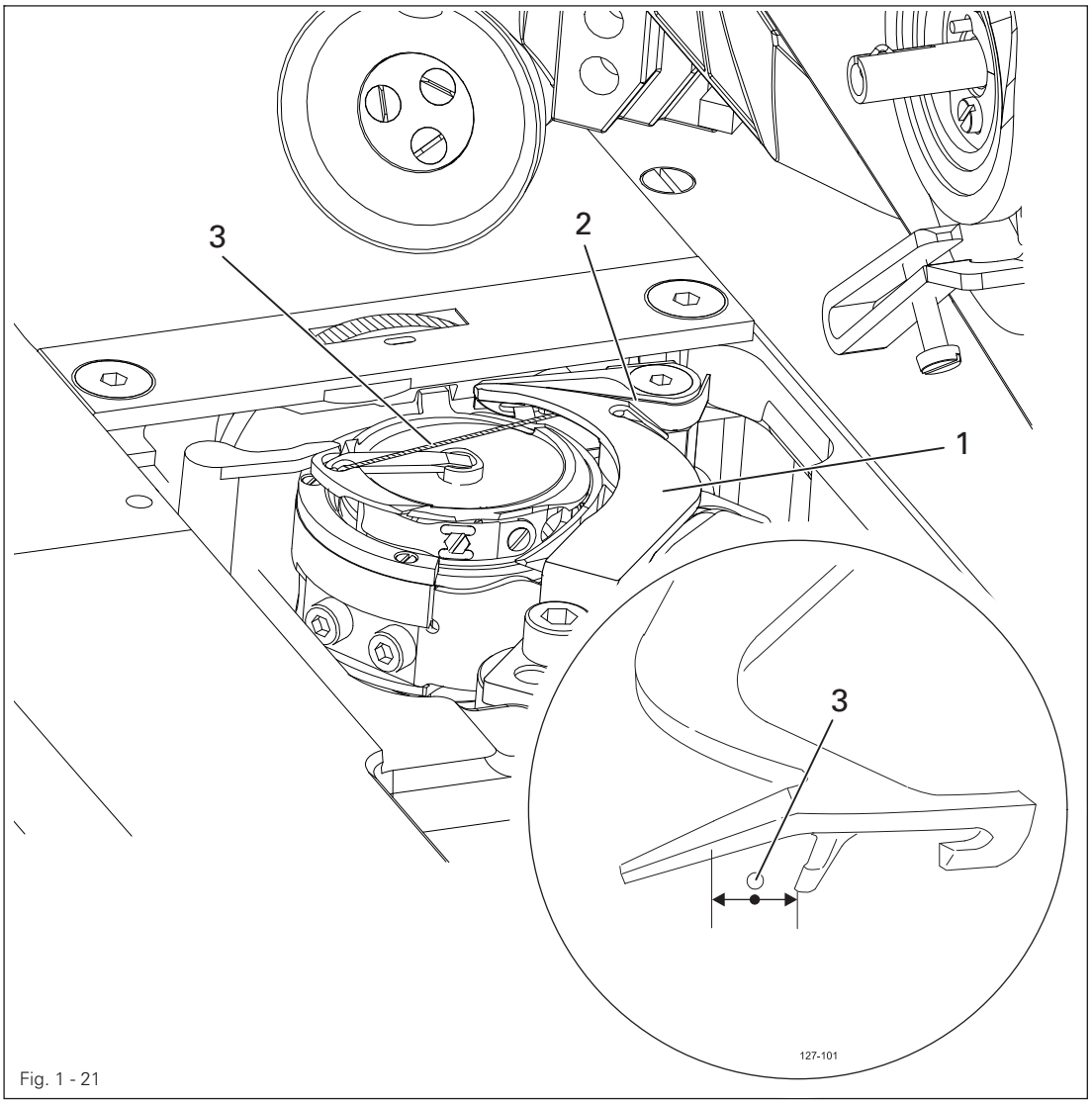
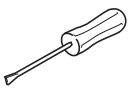


Fig. 1 - 21



- Sew a few stitches.
- Switch off the main switch and the compressed air.
- Carry out a manual cutting test.
- Check **requirement 1**. If necessary, readjust thread catcher **1** in accordance with Chapter **4.06.02 Position and height of the thread catcher**.
- Check **requirement 3**. If necessary, readjust bobbin thread clamp spring **2** in accordance with Chapter **4.06.04 Bobbin thread clamp spring**.

4.07 Setup

4.07.01 Thread tension adjustment

- Select function "Seam Programme".

- Select function "Production".

- Select function "Trial Seam".
- Produce a trial seam and monitor thread tension.
- Adjust offset until current thread tension corresponds to setpoint.

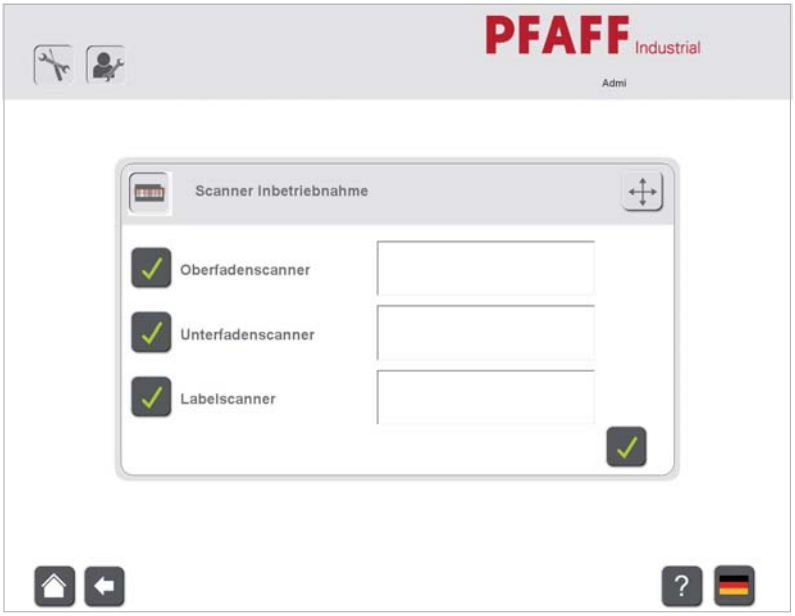
- The calculated offset value must be added or subtracted in parameter **407**.
- Basic setting **407** = **2000**

4.07.02 Commissioning the scanner

- Select function "Tools".

- Select function "Service".

- Select function "Scanner Commissioning".



- Switch the scanner on.
- Position the barcode.
- Set the scanner at the head of the machine in height and directionality, until the barcode is read continuously.

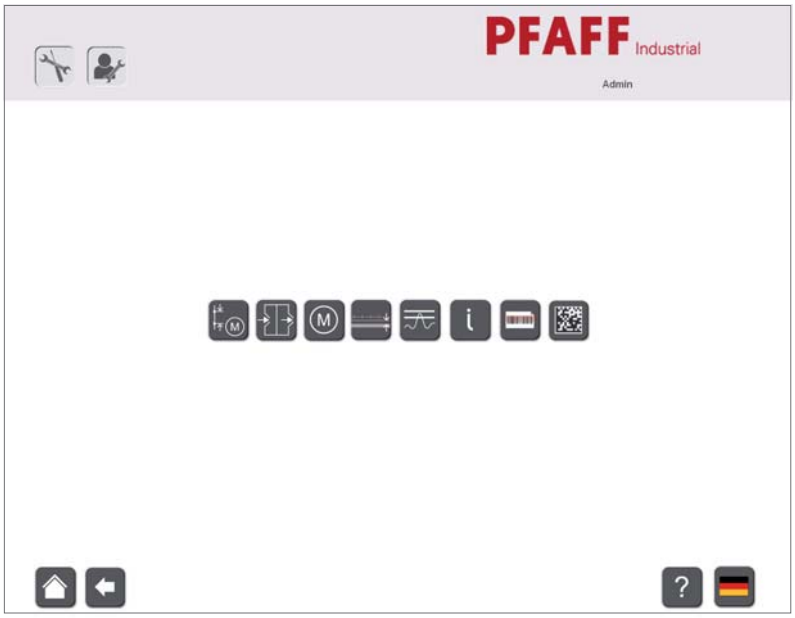
- Finish input.

4.07.03 Commissioning the camera

- Select function "Tools".

- Select function "Service".

- Select function "Camera Commissioning".



Explanation for symbols used in menu "Camera commissioning

Switch on camera

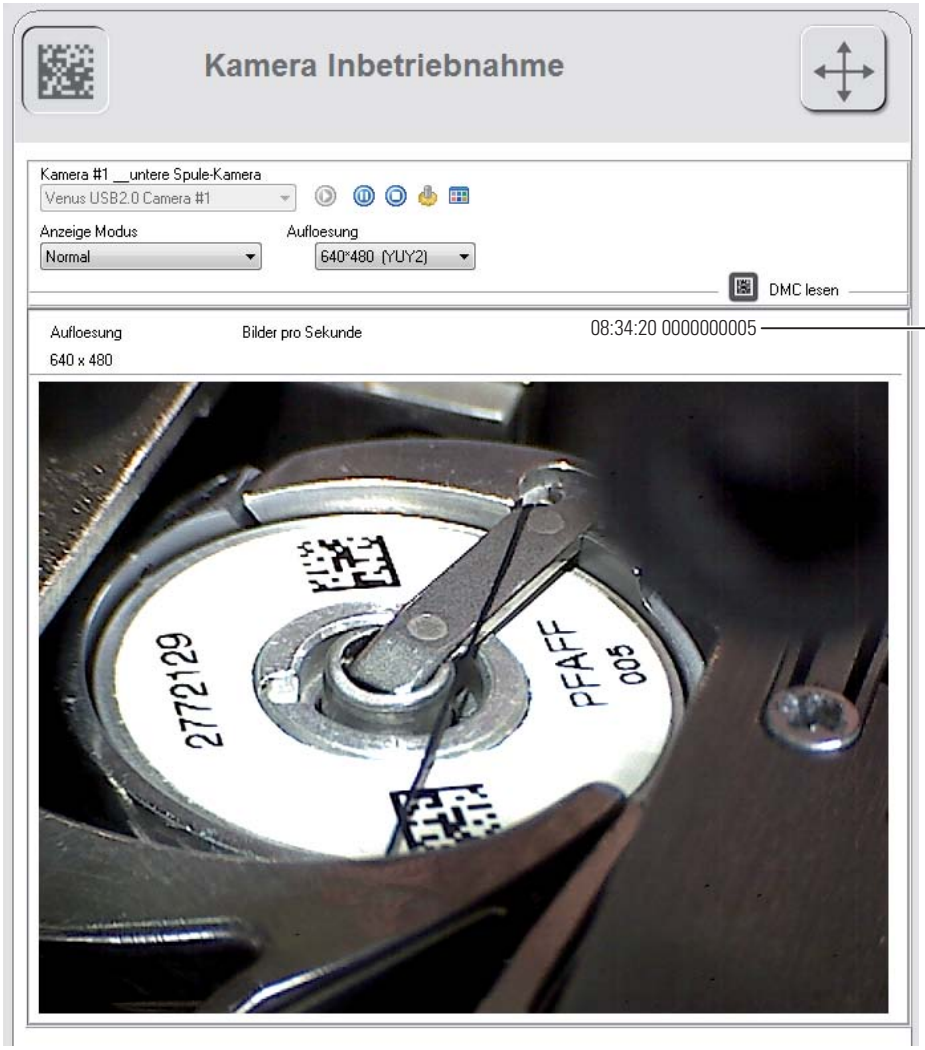
Pause

Stop

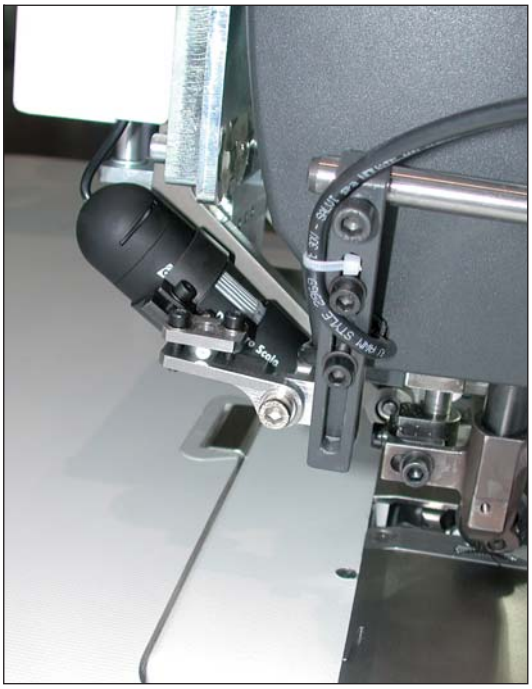
Video properties

Set resolution

Read DMC

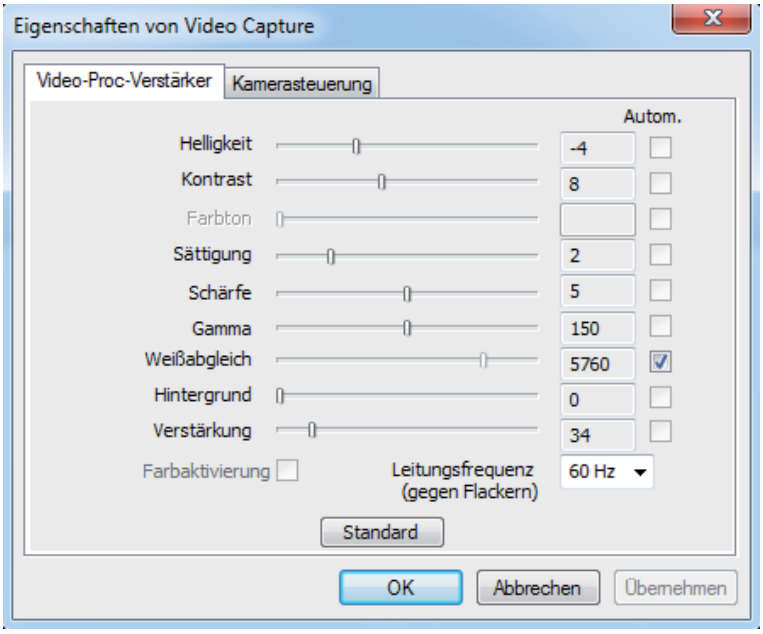


- Switch on camera on
- Select function "Read DMC"

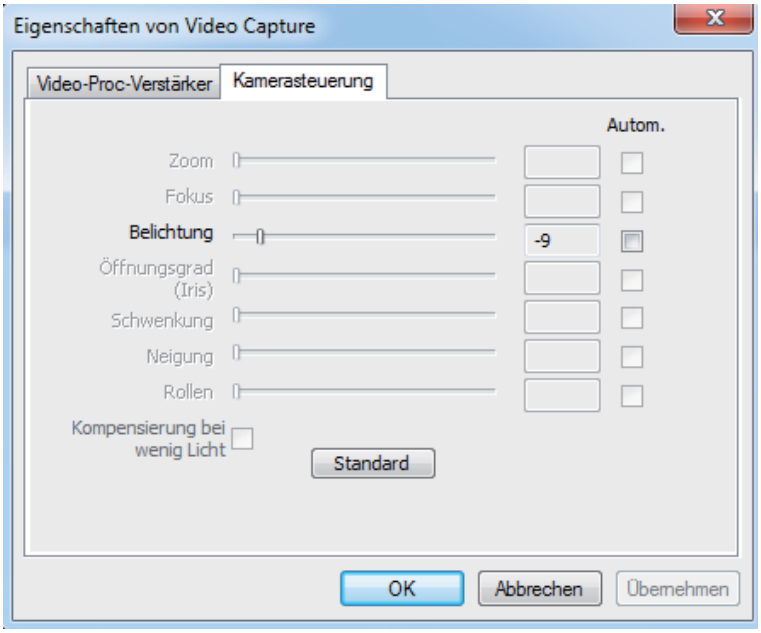


- Select **640** x **480** in the window "Resolution".
- The DATA Matrix code must appear in the window "Code".
- Proceed as follows if "- - - - -" is displayed in the window "Code":
  Switch off camera light on control **1**,
  adjust image focus on Focus **2**,
  turn bobbin to allow reading the DATA Matrix.
- Set exposure (see next page)

- Call up video properties.Adjust settings as needed.
- The following image shows the factory settings.



- Call up the camera control.Adjust settings as needed.
- The following image shows the factory settings.



- Apply the settings.
- Finish input.

4.08 Parameter settings

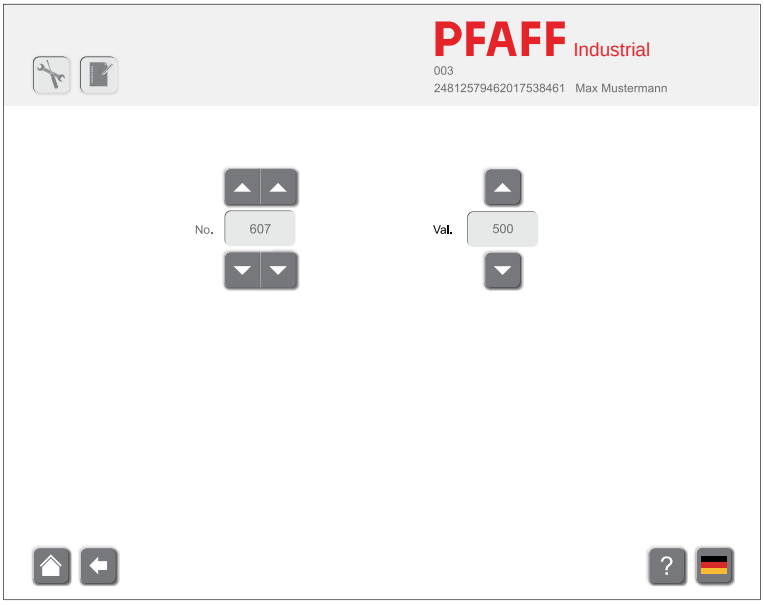
4.08.01 Selecting and altering the parameters

The parameter values can only be altered by the supervisor or the administrator.

- Log in as administrator or supervisor.

- Select the "tools" function.

- Call up the menu for altering parameter values



- By tapping the appropriate arrow symbols select the desired parameter ("No.").
- By tapping the appropriate arrow symbols alter the value ("Val.") of the selected parameter.

4.08.02 List of parameters

Group	Parameter	Description	Setting range	Set value
1	101	Pedal controlled start backtack (I = OFF, II = ON)	0 - 1	1
	102	Reverse rotation (I = OFF, II = ON)	0 - 1	1
	103	Placed stitch (I = OFF, II = ON)	0 - 1	1
	104	Bobbin thread monitoring 0 = Off, 1 = Counter, 2 = Thread monitor	0 - 2	0
	105	Bobbin thread counter	0 - 99999	12000
	106	Bobbin thread remaining counter	0 - 999	100
	113	Control panel key tone when moving from one area to another, (I = OFF, II = ON)	0 - 1	0
	115	Thread clamp (I = OFF, II = ON)	0 - 1	0
2	201	Machine configuration 14 = 3721,	1 - 15	14
	202	Roller-presser field discharge (OFF = I, ON = II) 0 = roller-presser is lowered slowly. Should be set for high foot pressure 1 = roller-presser is lowered quickly. Should be set for low foot pressure	0 - 1	0
3	301	Thread carrier position t.d.c.	0 - 127	125
	302	Needle position under b.d.c.	0 - 127	10
	303	Thread trimmer magnet position on	0 - 127	20
	305	Thread trimmer magnet position off	0 - 127	120
	306	Reverse rotation position	0 - 127	100
	307	Placed stitch position	0 - 127	7
	308	Thread tension ventilation position	0 - 127	30
	309	Thread clamp position on	0 - 127	20
	310	Thread clamp position off	0 - 127	60
	311	Position compensation point for thread strength sensor	0 - 127	40
	312	Position measurement 1 (largest hook loop) in degrees	0 - 127	81
	313	Position measurement 2, t.d.c. take-up lever, in degrees	0 - 127	113

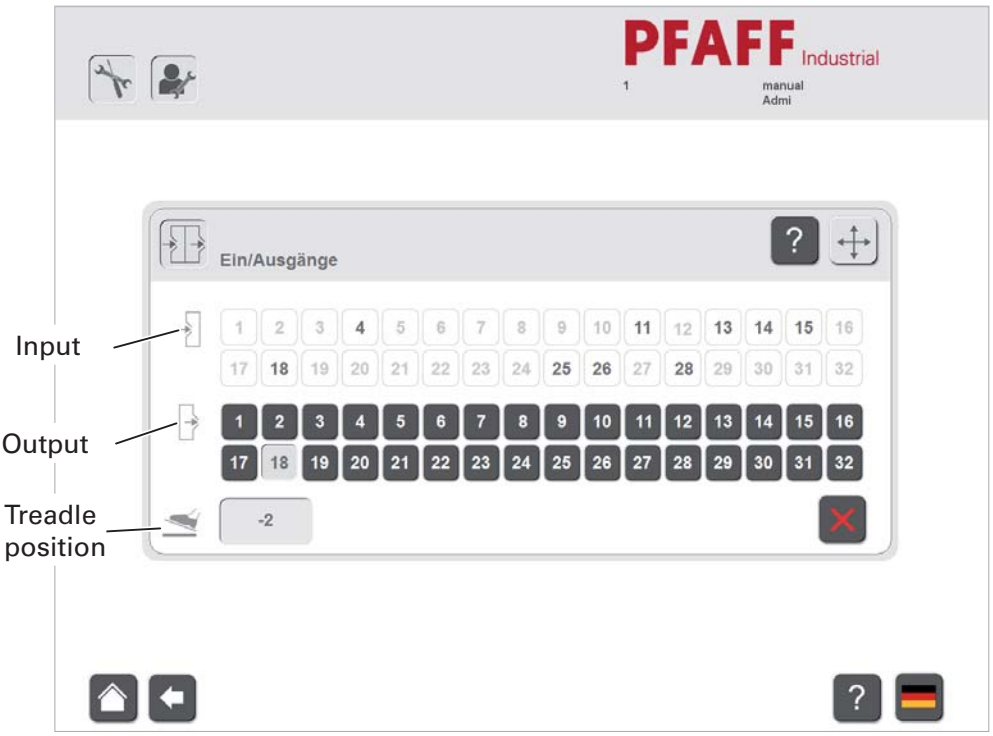
Group	Parameter	Description	Setting range	Set value
3	314	Measurement window measurement 1 in +/-degrees	0 - 20	10
	315	Measurement window measurement 2 in +/-degrees)	0 - 20	10
4	401	Time delay roller-presser lift	0,01s - 1,5s	0,02s
	402	Delayed start after lowering roller-presser	0,01s - 1,5s	0,15s
	403	Set roller-presser lift (must be increased for high foot pressure)	0,01s - 0,2s	0,03s
	404	Thread trimmer magnet pulse	10% -50%	35%
	405	Time to clean the bobbin thread monitor	0,01s - 1,5s	0,25s
	406	Fade-out stitches for missed stitch recognition	0 - 20	8
	407	Zero position step motor thread tension	0 - 1000	81
	408	Acceleration stepping motor thread tension (percentage increase of start stop to roof speed)	0 - 5000	1500
5	501	Maximum speed	100 - 3500	3500
	504	Soft start speed	100 - 3500	1500
	505	Soft start stitch	0 - 15	0
7	701	P-section speed regulator	1 - 50	30
	702	I-section speed regulator	0 - 100	50
	703	P-section position regulator	1 - 50	20
	704	D-section position regulator	1 - 100	30
	705	Time for position regulator	0 - 100	25
	706	P-section position regulator for remainder brake	1 - 50	25
	707	D-section position regulator for remainder brake	1 - 50	15
	708	Maximum torque for remainder brake	0 - 100	0
	709	Minimum machine speed	3 - 64	6
	710	Maximum machine speed	1 - 35	35
	711	Maximum motor speed	1 - 35	35
	712	Positioning speed	3 - 25	18
	713	Acceleration ramp	1 - 50	35
	714	Braking ramp	1 - 50	30
	715	Reference position	0 - 127	10
	716	Dead man time	0 - 255	40

Group	Parameter	Description	Setting range	Set value
7	717	Motor starting current	3 -10	8
	718	Vibration filter	1 -10	6
	719	Assign direction of rotation	0 - 1	0
	720	Move positioner 1 = time opitmised, 2=curse optimised	1 - 2	2
20	2023	Selection mode for soft limit for docu-seam 1 = Docu-seam fields, once tolerance stitches sequentially surpass limit. 2 = Docu-seam fields, once number of tolerance stitches has surpassed soft limit.	1 - 2	2
	2026	Thread tension values 1 = no median values generated	-	1

4.09 Description of the error messages

Display	Description
100	System fault
233	Invalid parameter value
235	Communication error
236	Init not ready
237	Command overrun
264	Mains off during initialisation
265	Excess current directly after mains on
266	Short circuit
268	Excess current during operation
270	Motor blocked
271	No incremental plug
274	Incremental transducer missing for transmission/reduction
373	Motor blocked in 1st stitch
375	Interior starting error
422	Dead man monitoring
300	Seam zone data
400	Seam zone end
500	Pedal or half stitch button or single stitch button (on machine head) activated when machine turned on
600	Communication error with the step motor processor
700	End of ramp
800	Needle drive end point not found
900	Needle drive mid-point not found
1000	Step motor processor error
1100	Step motor step frequency too high
1200	Sewing displacement error
1400	Incorrect program number (larger than 99)
1500	Incorrect section number
1600	Memory full
1700	Incorrect stitch length
1900	External control interface
2000	Incorrect control (no P321ED, no FKM)
2100	Power supply unit overloaded (24V)
2200	Mains voltage
2300	Power supply 24V too low
2400	Error CAN interface

4.10 Inputs / Outputs



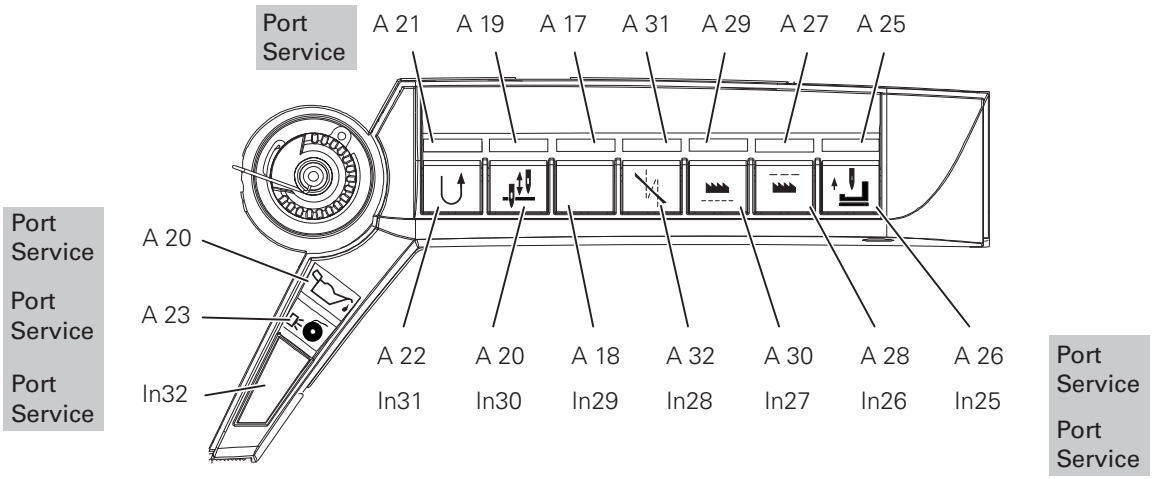
Inputs

Key	Input	Function
4	E4	Starting inhibitor S24
5	E5	Photo cell B15
6	E6	Knee switch S27
7	E7	E-winder S22
10	E10	Bobbin cover in reading position
11	E11	Slide control
12	E12	Bobbin lower thread
13	E13	Bobbin top thread
14	E14	Identification intermittent
15	E15	Needle end position
16	E16	Needle center
25 - 31		Control panel on machine
32		Hotkey

Outputs

Key	Output	Function
1	A1	Roller-presser lift
2	A2	Thread trimming
3	A3	E-winder
5	A5	Thread clamp
6	A6	Bobbin thread monitor clean
15	A15	Audio signal range change
17 - 32		LED on control panel of machine

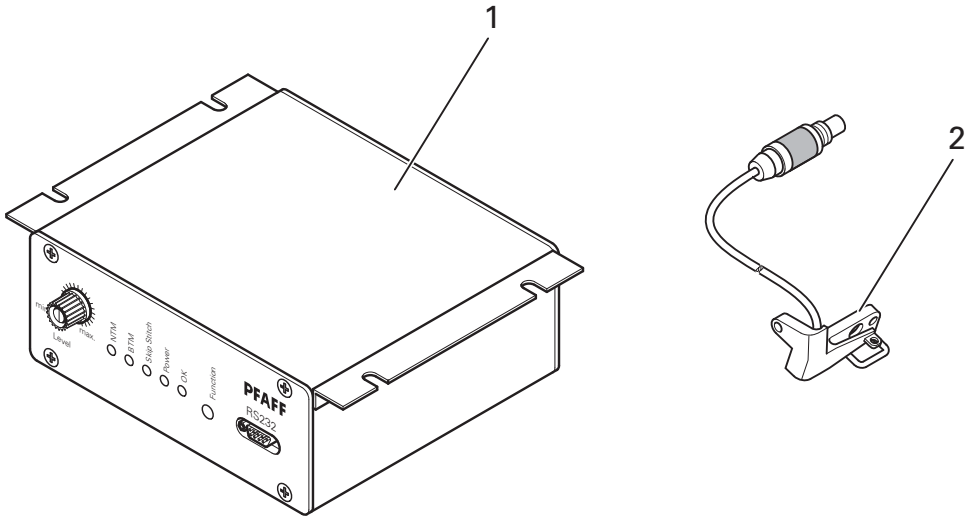
Control panel on machine



4.11 Importend Sevice-information

Attension!!

To avoid wrong monitoring, it is necessary to calibrate the system, after changing the thread-force-sensor 2 or the thread strength module 1..



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CALIBRATION INSTRUCTIONS

Kalibrieranleitung engl. 06.12

5 Calibration

5.01 General information

Due to an increased quality awareness, a calibration service in the context of international competition constantly gains significance. The use of systems for quality assurance is therefore of equal interest both for the manufacturer and the user of testing equipment. This leads to high customer requirements, which result from the DIN standard ISO 9000 for the control of testing equipment.

The control of testing equipment should ensure that all testing equipment relevant for the quality meet up to the specifications. For this reason testing or measuring equipment must be calibrated, and the traceability to national standards must be possible. Physical effects such as ageing and drift make a calibration service necessary, in order to guarantee the significance of the test readings.

5.01.01 Calibration

Calibration is an operation during which measuring equipment with an unidentified error is checked. The check is carried out by comparison with standards, the accuracy of which is confirmed by an official test certificate. If , during the calibration, the readings are outside the permitted tolerance, an adjustment is made, so that the values are within the permitted tolerance, and the calibration is repeated.

Calibration can be carried out by anybody. In contrast to gauging, there is no legal background for calibration.

5.01.02 Traceability

Traceability means that when measuring equipment is tested, it must be possible to trace the documentation of the detailed readings back to a legal standard, i.e. the recorded data is compared with the national standard for the measured quantity.

5.01.03 Standards

Standards are comparative testing means, which refer to one of the seven basic units of the international standard system (SI-System). Standards must themselves be calibrated regularly.
Their traceability is guaranteed by calibration or gauging certificates issued by DKD offices (German Calibration Service) or by the Gauging Office.

The PFAFF calibration system uses a weight of 500 cN = 5 N (cN = centi Newton) as "standard", which results from the product of the weight of a body (SI-unit weight in kg = kilogram) and the gravitational acceleration (g = 9.80992 m/s2). In this way the physical measuring unit of the thread pull in cN is traceable to the standard for weight in kilogram (Calibration certificate no. …., Gauging Office Albstadt).

The weight used here of 0.509765 kg = 509,765 g +/- 7.5 mg corresponds to a weight of 5 N = 500 cN.

5.01.04 Gauging office, German Calibration Office DKD

The standards used here, documented by calibration certificates, represent the unquestionable proof of the traceability in accordance with DIN ISO **9000,** and are internationally recognised through multilateral agreements.

The higher-ranking institution for the entire calibration services in Germany is the PTB (Federal Institute for scientific and technical services).

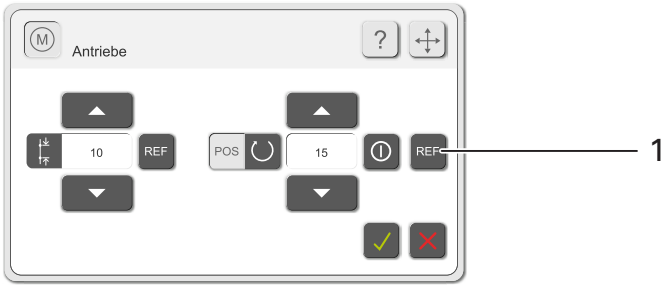
5.02 Calibration procedure

The calibration takes place as described in the calibration certificate at the end of this manual. All calculated or set values must be recorded in the appropriate calibration certificate.

5.02.01 Check / adjust the needle reference position

(Item **1** of the calibration certificate)

- Log-in as administrator.
- Call up the “tools” function.
- Call up the service menu.
- Call up the “drives” function.



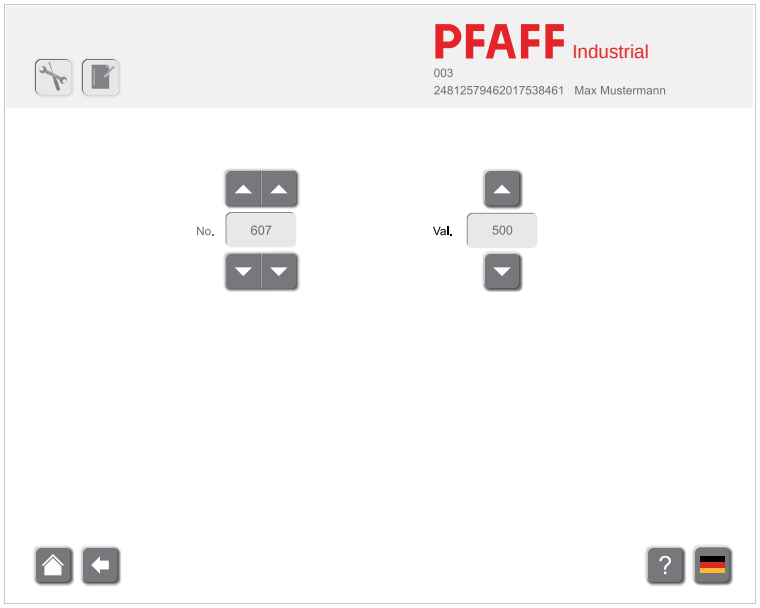
- Select function **1.**
- If necessary move the needle to its t.d.c. using the balance wheel.
- Acknowledge the adjustment.
- Enter the value, which can be found in the parameter list under parameter **700,** in the calibration certificate.
- Conclude the adjustment.
- Call up the mode selection function.

5.02.02 Check / adjust the trigger signals

(Item **2** of the calibration certificate)

- Call up the “tools” function.

- Call up the menu for adjusting the parameter values.

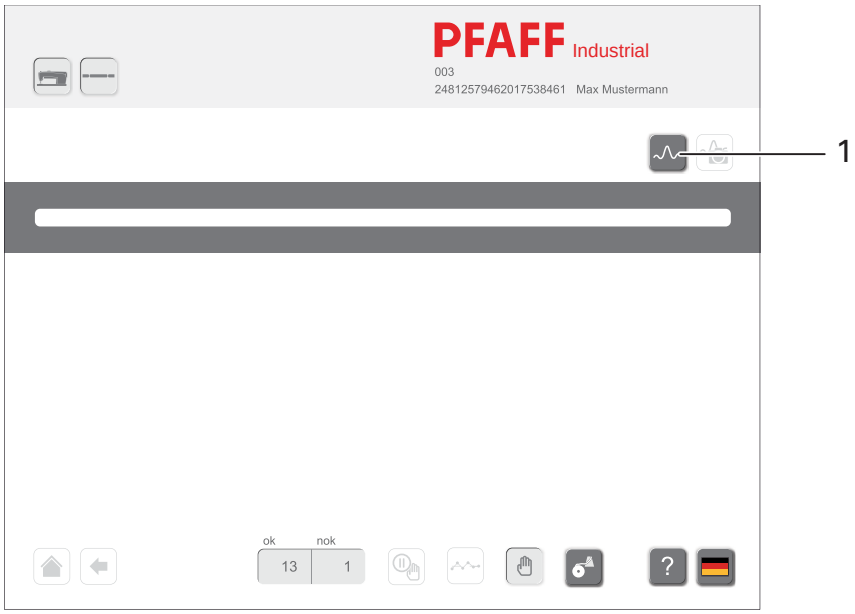


- By tapping the appropriate arrow symbol (“No.”) select parameter **607** for the maximum speed.
- By tapping the appropriate arrow symbol (“Val.”) enter the value “**500**”.

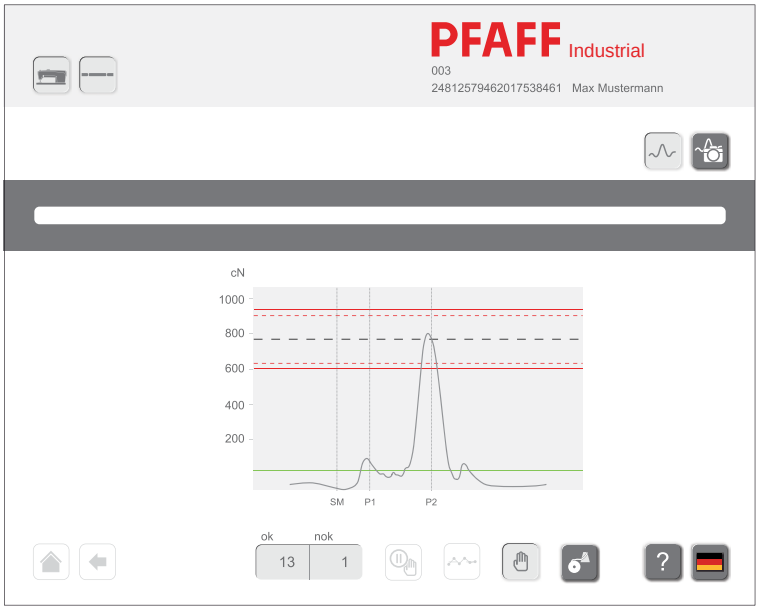
- Call up the mode selection function.

- Call up the seam program selection function and select the “manual” program by tapping on the list of programs.

- Call up the production function.



- Switch on the monitor with function **1.**
- Carry out a test seam.



- Check, whether the trigger signals with the largest hook loop and in t.d.c. take-up lever are both in the maximum range of the thread strength signal.
- If necessary alter the value for parameter **312** (largest hook loop, standard value: "**81**") accordingly.
- If necessary alter the value for parameter **313** (t.d.c. take-up lever, standard value: "**113**") accordingly.
- Carry out another test seam and check the altered value.
- If necessary repeat the procedure until the setting for the trigger signals is correct.
- Enter the values for the speed (**500** min-**1**) and for the parameters **312** and **313** in the calibration certificate.

- Call up the mode selection function.

5.02.03 Check the zero position of the monitor power signal

(Item **3** of the calibration certificate)

- Call up the "tools" function.
- Call up the menu for adjusting the parameter values.
- Call up parameter **311.**
- Check whether the value "**40**" is set. If necessary enter this value.
- Call up the mode selection function.

5.02.04 Checking the setting of the sewing head

(Item **4** of the calibration certificate)

- Check the mechanical setting of the sewing head in accordance with the Adjustment Manual and adjust the sewing head if necessary.

5.02.05 Recording the characteristic thread strength curve

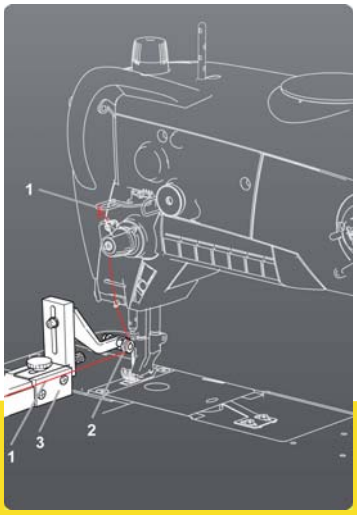
(Item **5** of the calibration certificate)

A synthetic thread size **40** is recommended as calibration thread (to which the calibration weight is attached).

The free movement of the ball bearings of the calibration equipment must be ensured.

- Call up the “tools” function.

- Call up the “calibration” function.

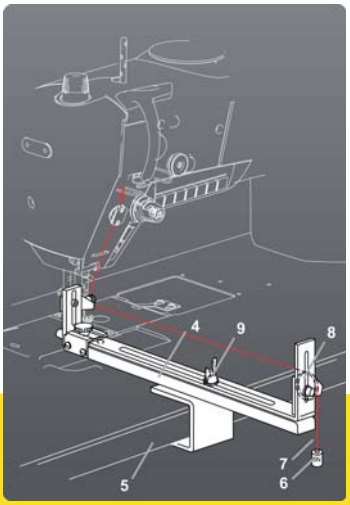


_The calibration thread **1** must be fastend at the thread guide (lose loop).

_Guide the calibration thread **1** through the guides as shown in the service manual, but instead to thread through the needle, guide the thread from the eyelet at the needle bar to the bearing **2** at the calibration device **3**

- Follow the instructions on the touch-screen monitor.

- Scroll on.



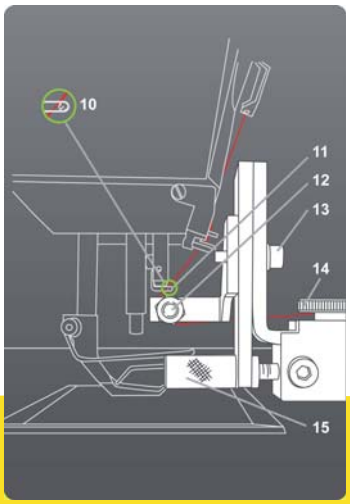
_The calibration device must be fastend at the table top to place the calibration weight according to the picture

_The length of the vertical thread piece after the two turn around the second bearing **8** should be approx. **250** mm

_The rquired length of the calibration device **4** can be adjusted with the wing nut **9.**

- Follow the instructions on the touch-screen monitor.

- Scroll on.



_Take off the needle and the presser foot.

_Turn the balance wheel and pos. the M/C in top dead center take up lever (**66°** balance wheel scale).

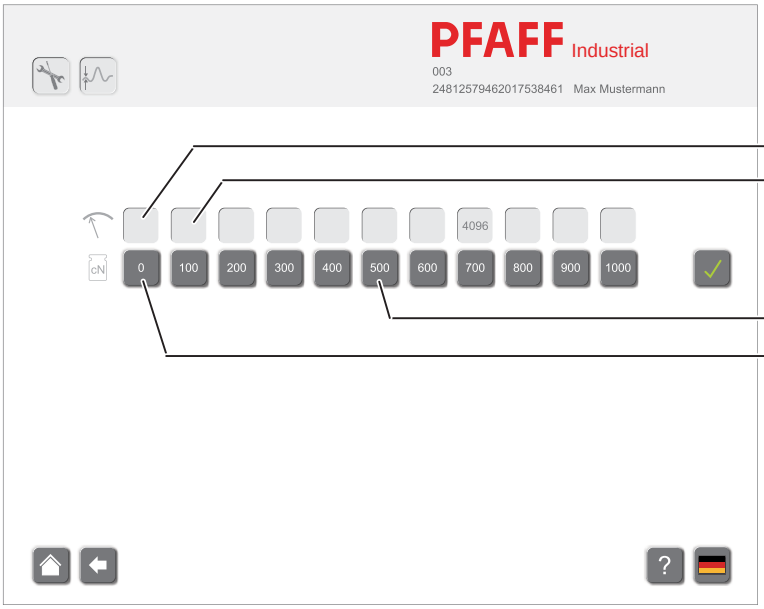
_Turn bearing **12** must be set below the needle bar eyelet by using screw **13.**

_With the knurl screw **15** move the red calibration thread horizontal until it touchs slightly the thread guide at the needle bar **11** (see diagram **10**).

_Fix the correct position with knurl screw **14.**

- Follow the instructions on the touch-screen monitor.

- Conclude the preparation.



- Call up function **1.**
- Do not attach a weight, or remove the weight.

- Acknowledge the measurement.
  The measured value appears in box **2.**

- Record the value from box **2** in the calibration certificate.
- Call up function **3.**
- Attach appropriate weight (**500** cN)

- Acknowledge the measurement.
  The measured value appears in box **4.**

- Record the value from box **4** in the calibration certificate.
- Carry out all measurements from **100** cN to **1000** cN in succession and record the corresponding values in the calibration certificate.

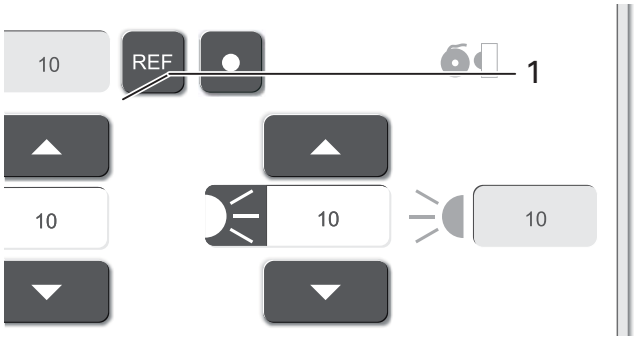
- After completing all measurements, quit the calibration menu.

5.03 Checking the calibration (calibration result)

- Carry out the calibration as described in Chapter **5.02** Calibration procedure.

- Call up the service menu.

- Call up the sensor function.



- Attach the calibration weight (**500** cN) to the thread and wait until the pendulum movements have stopped.
- Record the measured value shown in box **1** in the calibration certificate.
- Repeat the measurements four more times and record each value in the calibration certificate. The measured value must always be within the range of **500** cN +/- **30** cN.
- If there are deviations, the characteristic thread strength curve must be re-recorded in accordance with Chapter **5.02.05 Characteristic thread strength curve**.

- Quit the menu.

- Call up the mode selection function.

PFAFF Industrial PFAFF Industriesysteme und Maschinen AG, 67661 Kaiserslautern

Calibration certificate fort the PFAFF-DOCU-SEAM-SYSTEM

Customer:.....

Address:.....

Machine: **PFAFF 3721**..... Serial-No.: .....

PC-software: ..... Control software:.....

Reference value of weight for standard measuring range: **5 N = 500 cN**

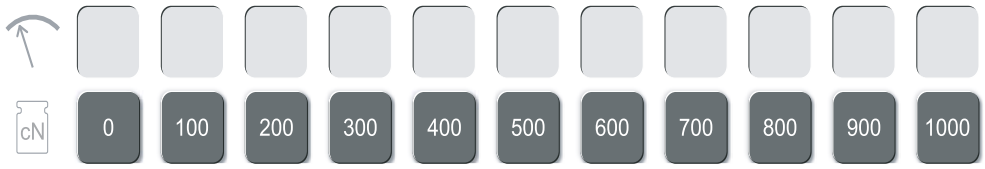
Traceability to national standard, guaranteed iaw DIN ISO 9000
by Gauging Office Albstadt, number of calibration certificate:.....

End value of measuring range: 1500 cN Accuracy: +/- 2%

Calibration procedure:

1. Needle reference position:	(Parameter 700)	.....	O
2. Trigger gnals:si	Speed	.....min^{-1}	O
	Parameter 1 31	.....	O
	Parameter 312	.....	O
3. Zero position of the monitor power signal:	Parameter 313	.....	O
4. Sewing hea tiag set			O

5. Characteristic thread strength curve



Check calibration result with 500cN

Reading	1	2	3	4	5
Measured value [cN]					
Deviation from standard [cN]					

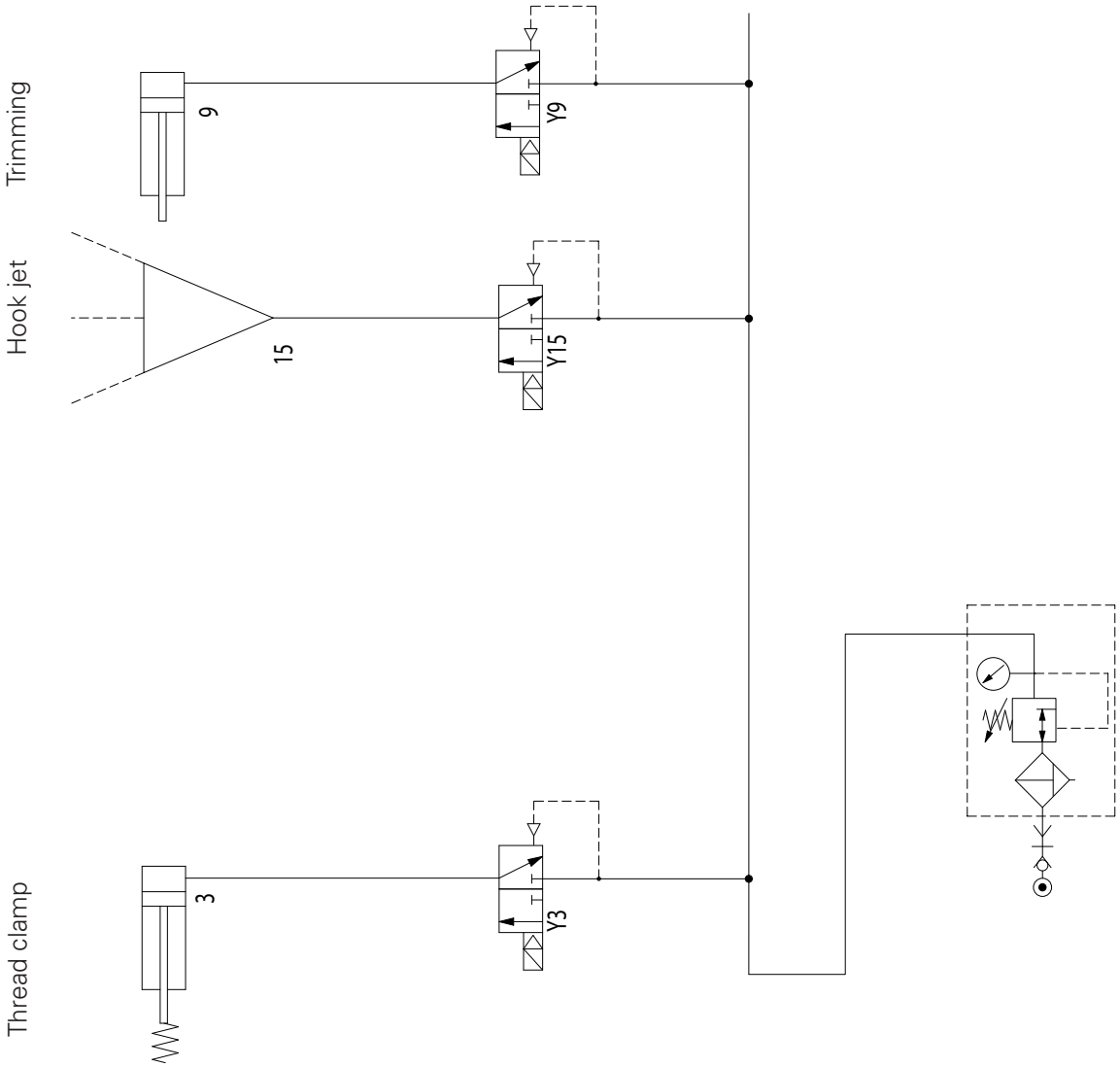
Permissible measuring inaccuracy: +/- **2%** of end value of measuring range = +/- **30** cN.
Evaluation: All measuring values are in the limits for the specific product.

Place:..... Date:..... Testing person:.....

6 Circuit diagrams

6.01 Pneumatics-switch diagram

The control elements and valves are in the machine‘s basic position.Main switch -ON, compressed air -ON



6.02 Circuit diagrams

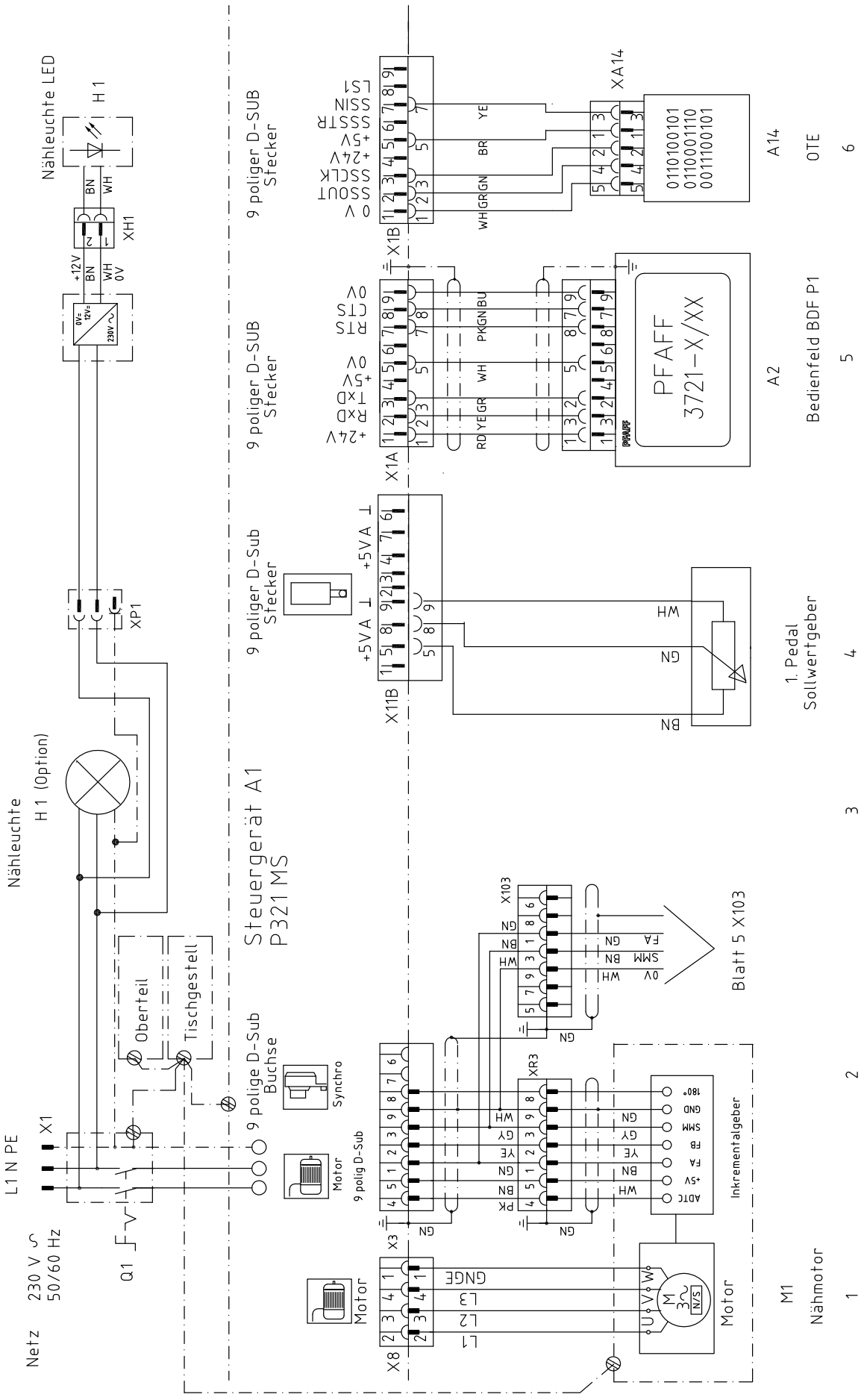
6.02.01 Reference list for the Circuit diagrams 91-191 547-95

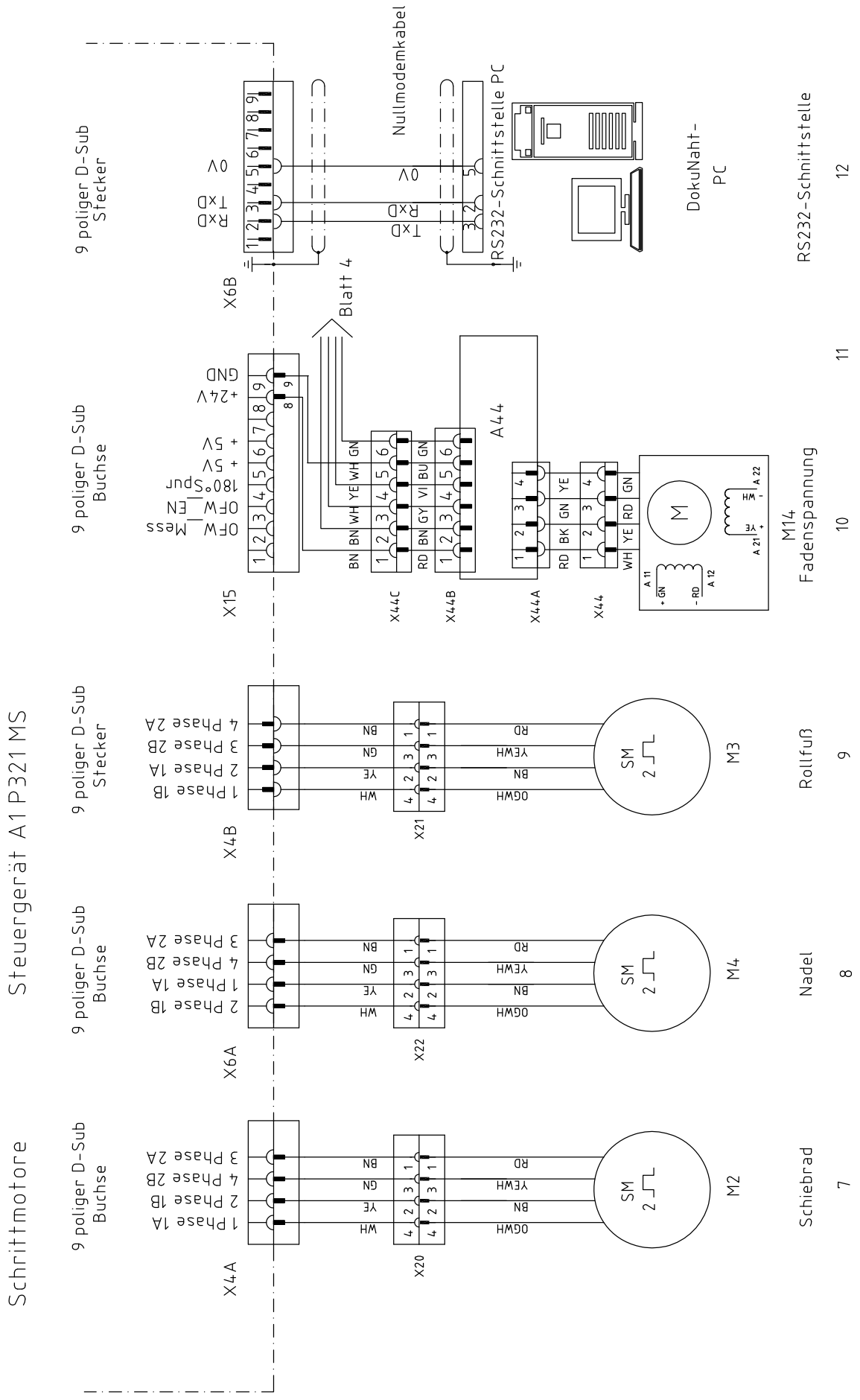
A1	Controller P321 MS
A2	Control panel BDF- P1 (optional)
A14	Sewing head recognition (OTE)
A15	Oil sensor (I2C-Bus)
A16	Keyboard (I2C-Bus)
A20	Bobbin thread monitor
A50	CAN- I²C converter
A100	Thread strength module
B15	Light barrier
B30	Initiator read position
B31	Initiator feed regulator
B33	Initiator slider monitoring
B41	Oil sensor (I2C-Bus)
B100	Thread strength sensor
H1	Sewing lamp
M1	Sewing motor
M2	Step motor feed wheel
M3	Step motor roller-presser
M4	Step motor needle
M11	Motor electrical bobbin winder
M14	Stepping motor thread tension
Q1	Main switch
S1.1	Pedal speed control unit
S1	Key 1 depending on parameter other function
S2	Key 2 depending on parameter other function
S3	Key 3 depending on parameter other function
S4	Key 4 depending on parameter other function
S5	Key 5 depending on parameter other function
S6	Key 6 depending on parameter other function
S7	Key 7 depending on parameter other function
S8	Key 8 depending on parameter other function
S22	Key electrical bobbin winder
S27	Key seam section
S34	Key switchover fuse
S51	Cop switch needle thread
S52	Cop switch bobbin thread

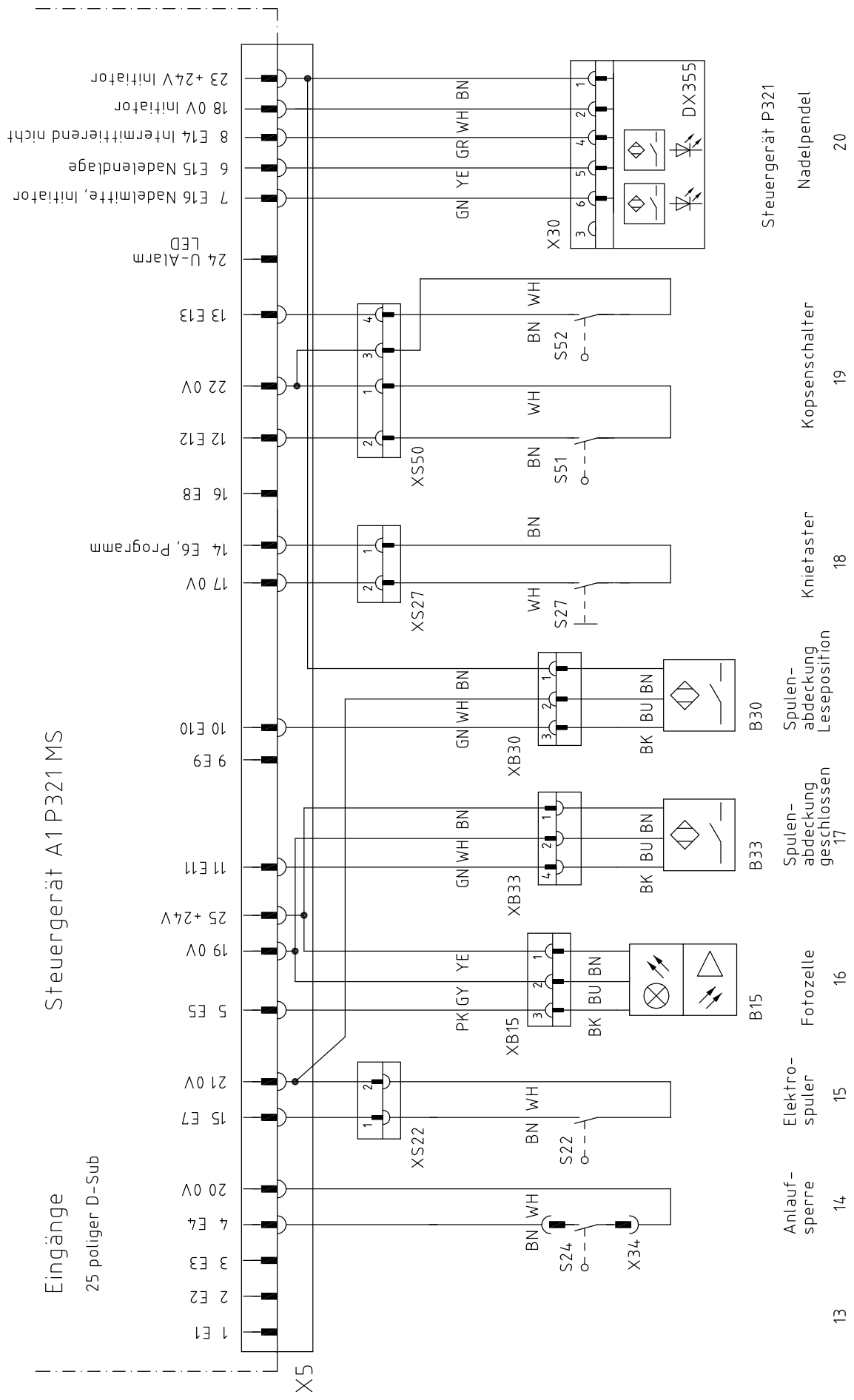
X11A	CAN interface
X6B	RS 232 interface (PC)
X8	Sewing motor
X1A	RS 232/BDF-P1 interface (PC)
X3	Incremental transmitter
X11B	Speed control unit
X1A	BDF- P1 control panel
X15	Stepping motor thread tension
X4A	Feed wheel step motor
X4/B	Roller-presser step motor
X6A	Step motor needle
X5	Input plug
X13	Output plug
XB15	Light barrier plug
X11	not assigned
X20	A20 bobbin thread monitor and B19 thread strength sensor
XS27	Knee switch seam section
X44	Stepping motor thread tension
X1B	A14 Sewing head recognition (OTE)
XA15.1	A15 Oil sensor (I2C-Bus)
XA15.2	A15 Oil sensor (I2C-Bus) > A14 (OTE) (I2C-Bus)
XA16	A16 Keyboard (I2C-Bus)
XB30	B30 Initiator read position
XB33	B33 Initiator bobbin cover closed
X30	DX 355 Needle pendulum
XS22	S22 Key electrical bobbin winder
XS50	Cop switch S51 and S52
XS51	Cop switch S51
XS52	Cop switch S52
X103	Thread strength module
X201	A100 Thread strength module
X202	A100 Thread strength module CAN
X211	B100 Thread strength sensor
X212	A20 Bobbin thread monitor
X45	909/..
X41	910/..
X42	900/..
X46	926/..
Y5	909/..
Y1	910/..
Y2	900/..
Y16	926/..

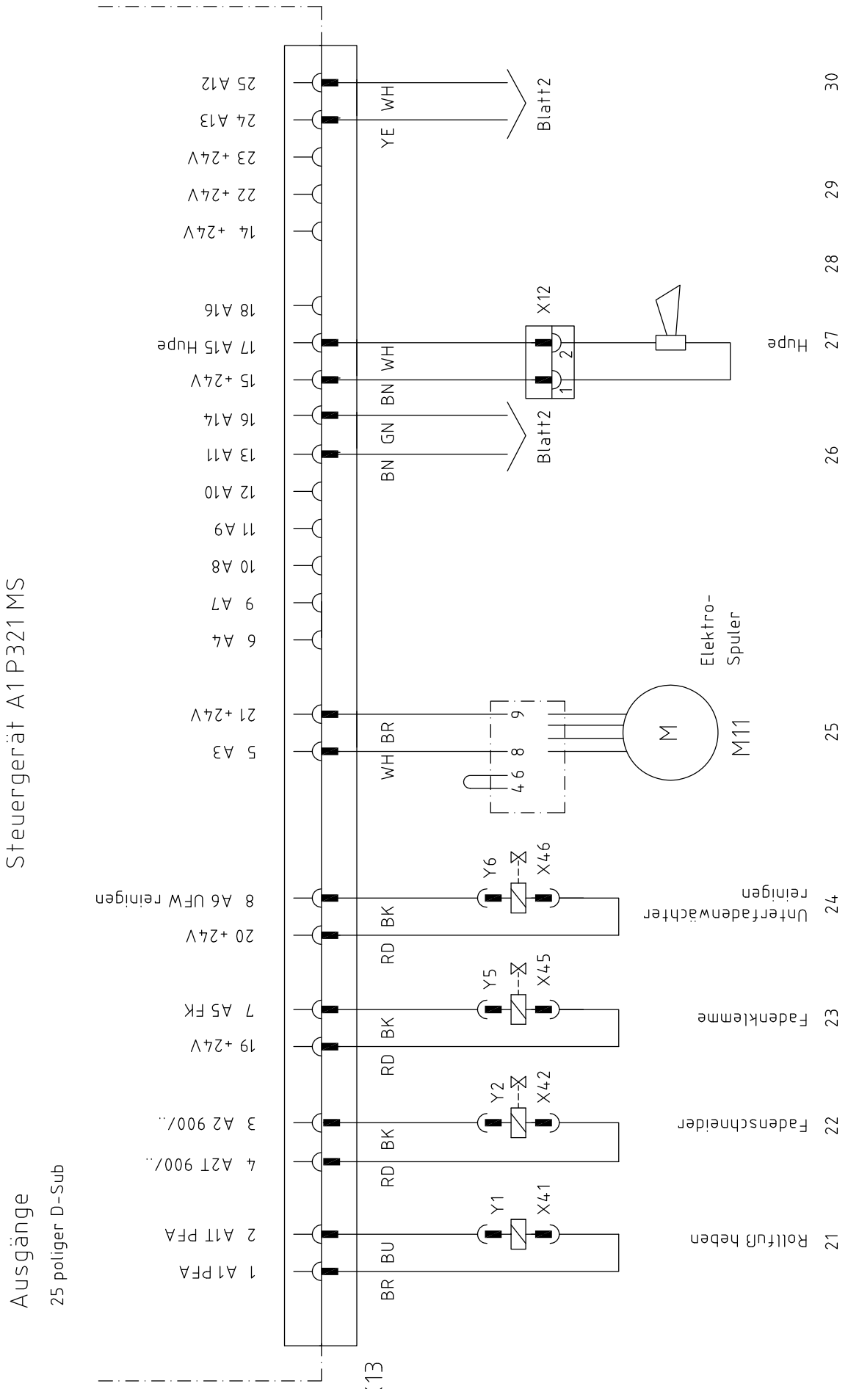
6.03.02 Reference list for the Circuit diagrams 91-191 536-95

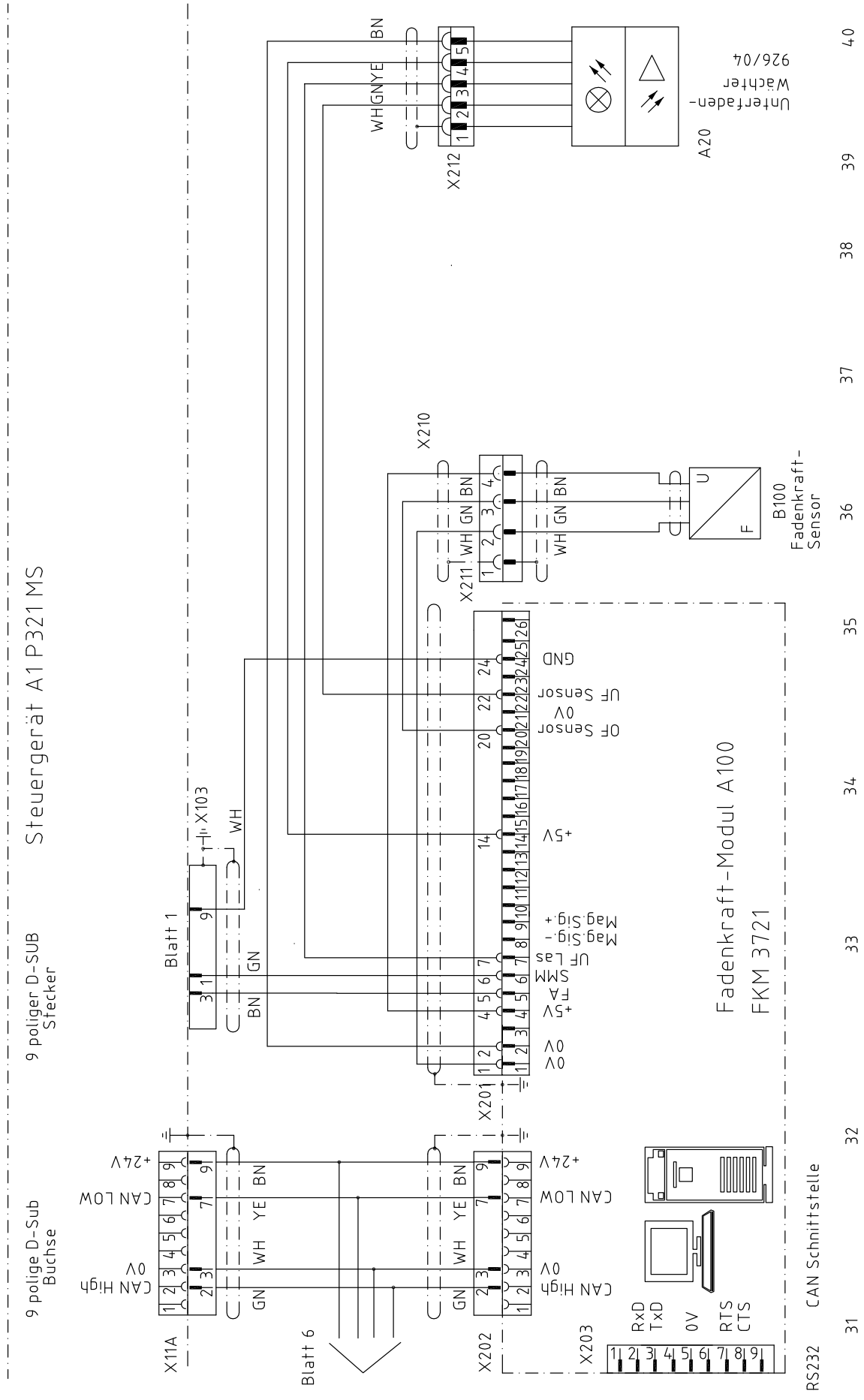
A1	Controller P374 ED-L
A100	PC
A101	Touchscreen monitor
A104	Barcode label printer
B102	Barcode hand-held scanner
B110	Barcode scanner (label)
B111	Barcode scanner (needle thread cop)
B112	Barcode scanner (bobbin thread cop)
A1	Controller P374 ED-L
A100	PC
A101	Touchscreen monitor
A104	Barcode label printer
B102	Barcode hand-held scanner
B110	Barcode scanner (label)
B111	Barcode scanner (needle thread cop)
B112	Barcode scanner (bobbin thread cop)
X0	RS 232 controller interface P374 ED-L
X98	Plug from PCI Seriel RS-232 carde
X99	RS 232 Adapter X98-X0
X100	Mains plug PC
X101	USB- plug PC-A101 touchscreen monitor
X102	USB- plug PC- B102 Barcode hand-held scanner
X103	USB- plug PC-free
X104	USB- plug PC-XUSB7 Barcode label printer
X105	USB plug PC-free
X106	USB plug PC-free
X107	USB plugPC-free
X108	USB plug PC-free
X109	USB plug PC- A101 touchscreen monitor
X110	B110 Barcode scanner (needle thread cop)
X111	B111 Barcode scanner (needle thread cop)
X112	B112 Barcode scanner (label)
X113	Interfaces distributors B110 Barcode scanner (bobbin thread cop)
X114	Interfaces distributors B111 Barcode scanner (needle thread cop)
X115	Interfaces distributors B112 Barcode scanner (label)

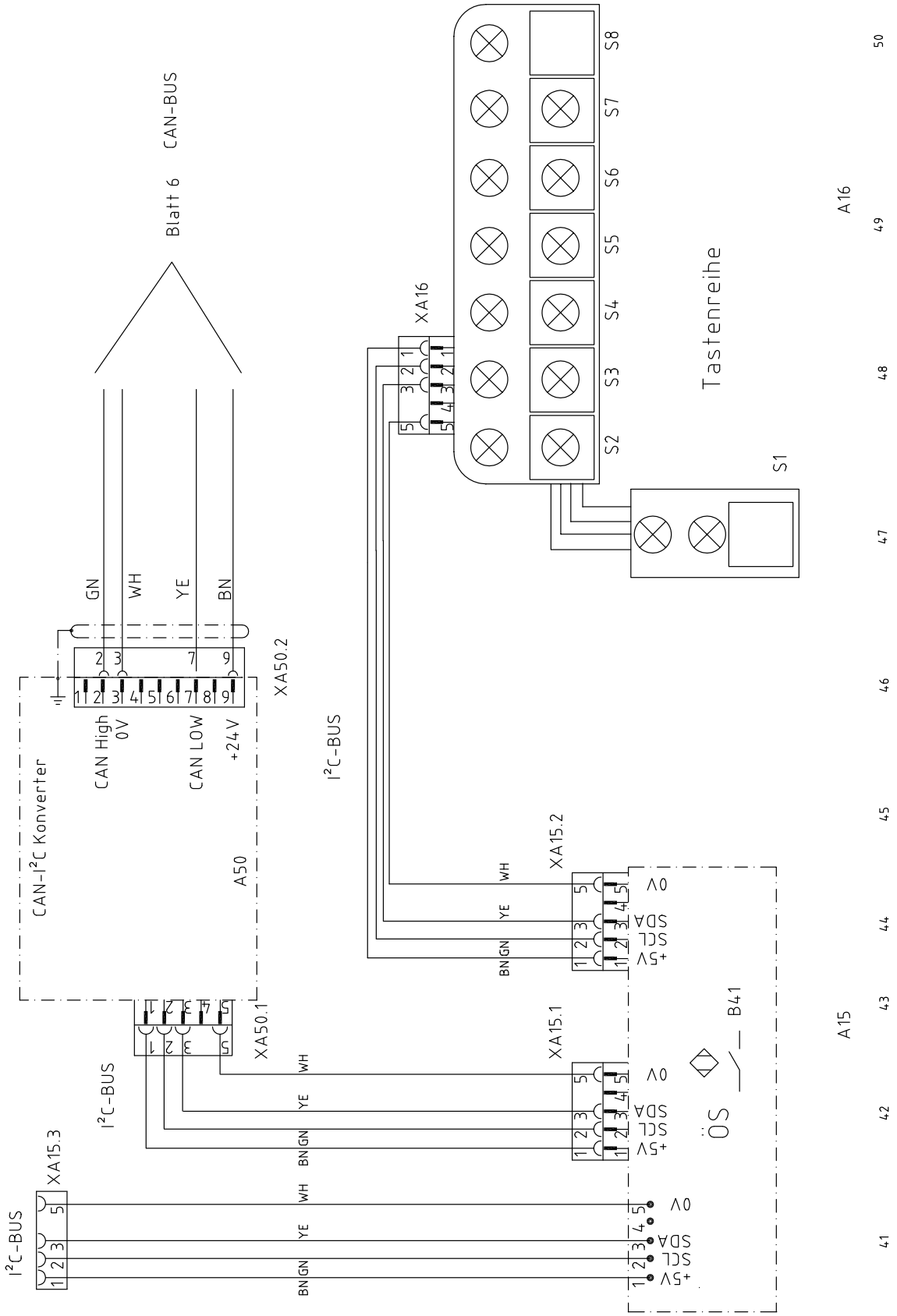

Nähleuchte LED
H 1
BN
WH
XH1
+12V
0V
0V=
12V=
230V~
XP1
Nähleuchte
H 1 (Option)
Steuergerät A1
P321 MS
9 poliger D-SUB
Stecker
9 poliger D-Sub
Stecker
9 polige D-Sub
Buchse
Synchro
Motor
9 polig D-Sub
X1
L1 N PE
Netz 230 V ~
50/60 Hz
Q1
Oberteil
Tischgestell
X1A
X1B
X11B
X3
X8
X103
XR3
XA14
A2
A14
M1
Motor
Inkrementalgeber
PFAFF
3721-X/XX
1. Pedal
Sollwertgeber
Bedienfeld BDF P1
Blatt 5 X103
OTE
Nähmotor
1
2
3
4
5
6

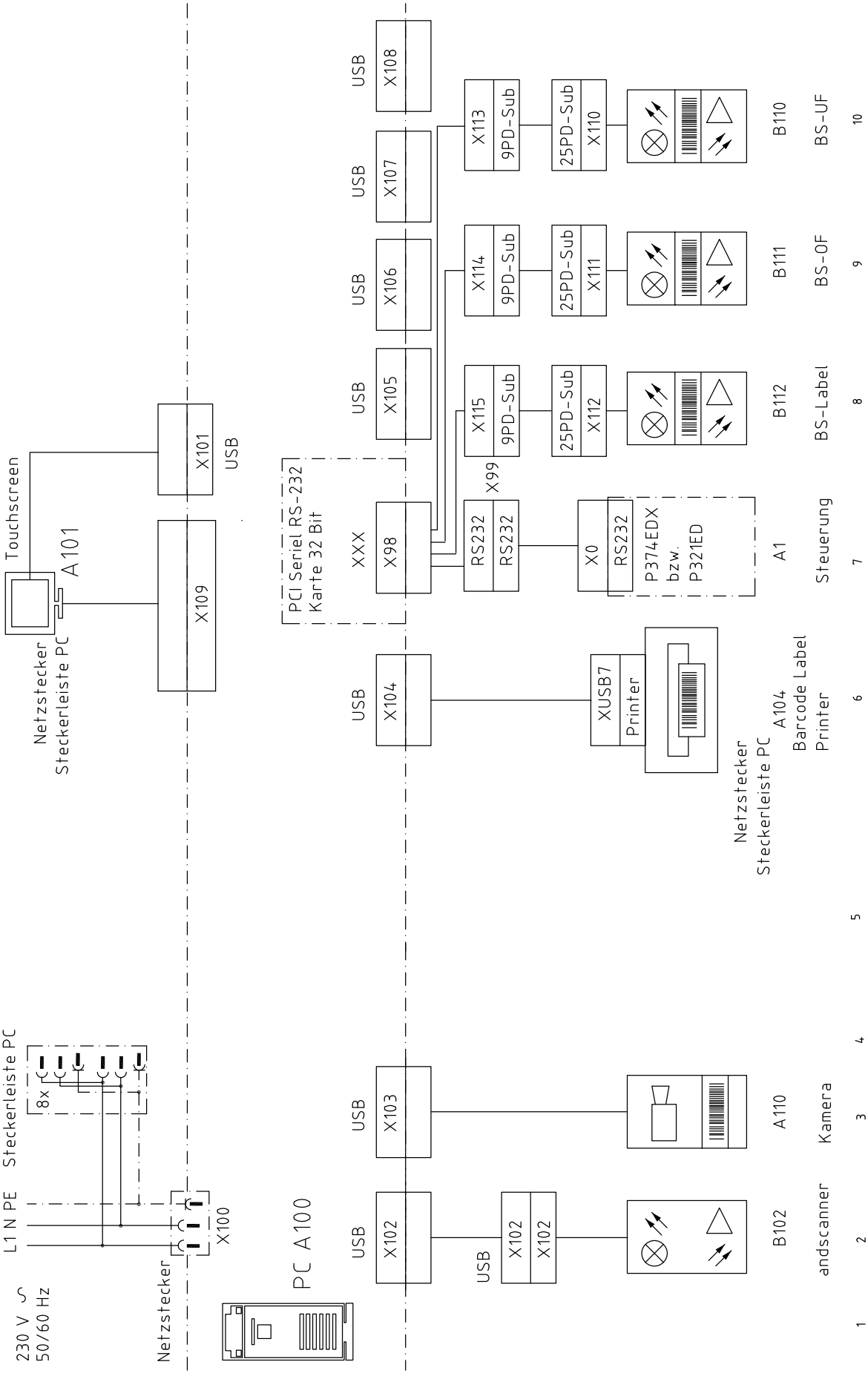

Steuergerät A1 P321 MS
Schrittmotore
9 poliger D-Sub Stecker
9 poliger D-Sub Buchse
X4A
X4B
X6A
X6B
X15
X20
X21
X22
X44
X44A
X44B
X44C
A44
M2
M3
M4
M14
Schiebrad
Rollfuß
Nadel
Fadenspannung
RS232-Schnittstelle
DokuNaht-PC
Nullmodemkabel
RS232-Schnittstelle PC
Blatt 4
1 Phase 1A
2 Phase 1B
3 Phase 2A
4 Phase 2B
OFW_Mess
OFW_EN
180°Spur
+ 5V
+24V
GND
0V
TxD
RxD
SM
2 ⎍⎍
7
8
9
10
11
12


Steuergerät A1 P321 MS
Eingänge
25 poliger D-Sub
X5
1 E1
2 E2
3 E3
4 E4
20 0V
15 E7
21 0V
5 E5
19 0V
25 +24V
11 E11
9 E9
10 E10
17 0V
14 E6, Programm
16 E8
12 E12
22 0V
13 E13
24 U-Alarm LED
7 E16 Nadelmitte, Initiator
8 E14 Intermittierend nicht
6 E15 Nadellendlage
18 0V Initiator
23 +24V Initiator
Steuergerät P321
Nadelpendel
20
DX355
X30
GN YE GR WH BN
Kopsenschalter
19
XS50
S52
S51
BN WH
Knietaster
18
XS27
S27
Spulen-abdeckung Leseposition
B30
XB30
Spulen-abdeckung geschlossen
17
B33
XB33
Fotozelle
16
B15
XB15
PK GY YE
BK BU BN
Elektro-spuler
15
XS22
S22
Anlauf-sperre
14
S24
X34
13


Steuergerät A1 P321 MS
Ausgänge
25 poliger D-Sub
1 A1 PFA
2 A11 PFA
4 A21 900/..
3 A2 900/..
19 +24V
7 A5 FK
20 +24V
8 A6 UFW reinigen
21 +24V
5 A3
6 A4
9 A7
10 A8
11 A9
12 A10
13 A11
16 A14
15 +24V
17 A15 Hupe
18 A16
14 +24V
22 +24V
23 +24V
24 A13
25 A12
BR BU
RD BK
RD BK
RD BK
RD BK
WH BR
BN GN
BN WH
YE WH
Y1
Y2
Y5
Y6
X41
X42
X45
X46
X12
M
M11
Elektro-
Spuler
Blatt2
Blatt2
Hupe
Rollfuß heben
Fadenschneider
Fadenklemme
Unterfadenwächter
reinigen
21
22
23
24
25
26
27
28
29
30


Steuergerät A1 P321 MS
9 poliger D-SUB Stecker
9 polige D-Sub Buchse
X11A
X103
Blatt 1
Blatt 6
X201
X202
X203
X210
X211
X212
A20
Unterfaden-Wächter 926/04
B100 Fadenkraft-Sensor
Fadenkraft-Modul A100
FKM 3721
CAN Schnittstelle
RS232
CAN High
CAN LOW
0V
+24V
+5V
GND
OF Sensor
UF Sensor
Mag.Sig.+
Mag.Sig.-
RxD
TxD
RTS
CTS
WH
GN
YE
BN


CAN-BUS
Blatt 6
A16
Tastenreihe
S1
S2
S3
S4
S5
S6
S7
S8
XA16
XA50.2
XA50.1
XA15.1
XA15.2
XA15.3
A50
A15
CAN-I²C Konverter
CAN High
0V
CAN LOW
+24 V
I²C-BUS
GN
WH
YE
BN
B41
0V
SDA
SCL
+5V


230 V ~
50/60 Hz
L1 N PE
Steckerleiste PC
8x
X100
Netzstecker
PC A100
USB
X102
X102
X102
B102
andscanner
X103
A110
Kamera
X104
XUSB7
Printer
A104
Barcode Label
Printer
Netzstecker
Steckerleiste PC
X105
X106
X107
X108
PCI Seriel RS-232
Karte 32 Bit
XXX
X98
X99
RS232
RS232
X0
RS232
P374EDX
bzw.
P321ED
A1
Steuerung
X115
9PD-Sub
25PD-Sub
X112
B112
BS-Label
X114
9PD-Sub
25PD-Sub
X111
B111
BS-OF
X113
9PD-Sub
25PD-Sub
X110
B110
BS-UF
X101
X109
A101
Touchscreen
Netzstecker
Steckerleiste PC
1
2
3
4
5
6
7
8
9
10

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Gedruckt in der BRD / Printed in Germany / Imprimé en la R.F.A. / Impreso en la R.F.A