

# 5483

## INSTRUCTION MANUAL

This instruction manual applies to machines  
from the following serial numbers onwards:

# 2 492 189 →



This Instruction Manual is valid for all models and subclasses listed in the chapter "Specifications".



The adjustment manual for the machines can be downloaded free of charge from the internet address

**[www.pfaff-industrial.com/pfaff/de/service/downloads](http://www.pfaff-industrial.com/pfaff/de/service/downloads)**

As an alternative to the internet download the adjustment manual can also be ordered in book form under part no. **296-12-18 994/002**.

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**PFAFF Industriesysteme  
und Maschinen AG**

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## **1 Safety**

### **1.01 Regulations**

This machine is constructed in accordance with the European regulations indicated in the conformity and manufacturer's declarations.

In addition to this instruction manual, please also observe all generally accepted, statutory and other legal requirements, including those of the user's country, and the applicable pollution control regulations!

The valid regulations of the regional social insurance society for occupational accidents or other supervisory authorities are to be strictly adhered to!

### **1.02 General notes on safety**

- The machine must only be operated by adequately trained operators and only when the instruction manual has been fully read and understood!
- All notices on safety and the instruction manual of the motor manufacturer are to be read before the machine is put into operation!
- All notes on the machine concerning danger and safety must be observed!
- The machine must be used for the purpose for which it is intended and must not be operated without its safety devices; all regulations relevant to safety must be adhered to.
- When part sets are changed (e.g. needle, presser foot, needle plate, feed dog or bobbin), during threading, when the workplace is left unattended and during maintenance work, the machine must be disconnected from the power supply by turning off the on/off switch or removing the plug from the mains!
- Daily maintenance work must only be carried out by appropriately trained persons!
- Repairs and special maintenance work must only be carried out by qualified technical staff or persons with appropriate training!
- During maintenance or repairs on the pneumatic system the machine must be disconnected from the compressed air supply! The only exception to this is when adjustments or function checks are carried out by appropriately trained technical staff!
- Work on the electrical equipment must only be carried out by technical staff who are qualified to do so!
- Work on parts or equipment connected to the power supply is not permitted! The only exceptions to this are specified in regulations **EN 50110**.
- Conversion or modification of the machine must only be carried out under observation of all relevant safety regulations! Haftung.
- Only spare parts which have been approved by us are to be used for repairs! We draw special attention to the fact that spare parts and accessories not supplied by us have not been subjected to testing nor approval by us. Fitting and/or use of any such parts may cause negative changes to the design characteristics of the machine. We shall not accept any liability for damage caused by the use of non-original parts.

## 1.03

### Safety symbols



Danger!  
Special points to observe.



Danger of injury to operating or technical staff!



### 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 notes for the user

- This instruction manual belongs to the equipment of the machine and must be available to the operating staff at all times.
- This instruction manual must be read before the machine is operated for the first time.
- Both operating and technical staff must be instructed on the safety devices of the machine and on safe working methods.
- It is the duty of the user to operate the machine in perfect running order only.
- The user must ensure that none of the safety devices are removed nor put out of working order.
- The user must ensure that only authorized persons operate and work on the machine.

For further information please refer to your PFAFF agency.

## **1.05 Notes for operating and technical staff**

### **1.05.01 Operating staff**

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

The operating staff are obliged to observe the following points, and must:

- always observe the notes on safety in this instruction manual!
- avoid using any working methods which adversely effect the safety of the machine!
- avoid wearing loose-fitting clothing or jewelry such as necklaces or rings!
- also ensure that only authorized persons are allowed near the danger area of the machine!
- immediately report to the user any changes to the machine that may affect its safety!

### **1.05.02 Technical staff**

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

The technical staff are obliged to observe the following points, and must:

- always observe the notes on safety in this instruction manual!
- switch off the on/off switch before carrying out adjustment and repair work and ensure it cannot be switched on again unintentionally!
- never work on parts or equipment still connected to the power supply! Exceptions to this are only permissible according to regulations **EN 50110**;
- disconnected the machine from the compressed air supply when carrying out maintenance or repair work on pneumatic equipment!
- Exceptions to this are only permissible for function checks;
- replace all safety covers after carrying out maintenance or repair 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 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 slung out of the machine!

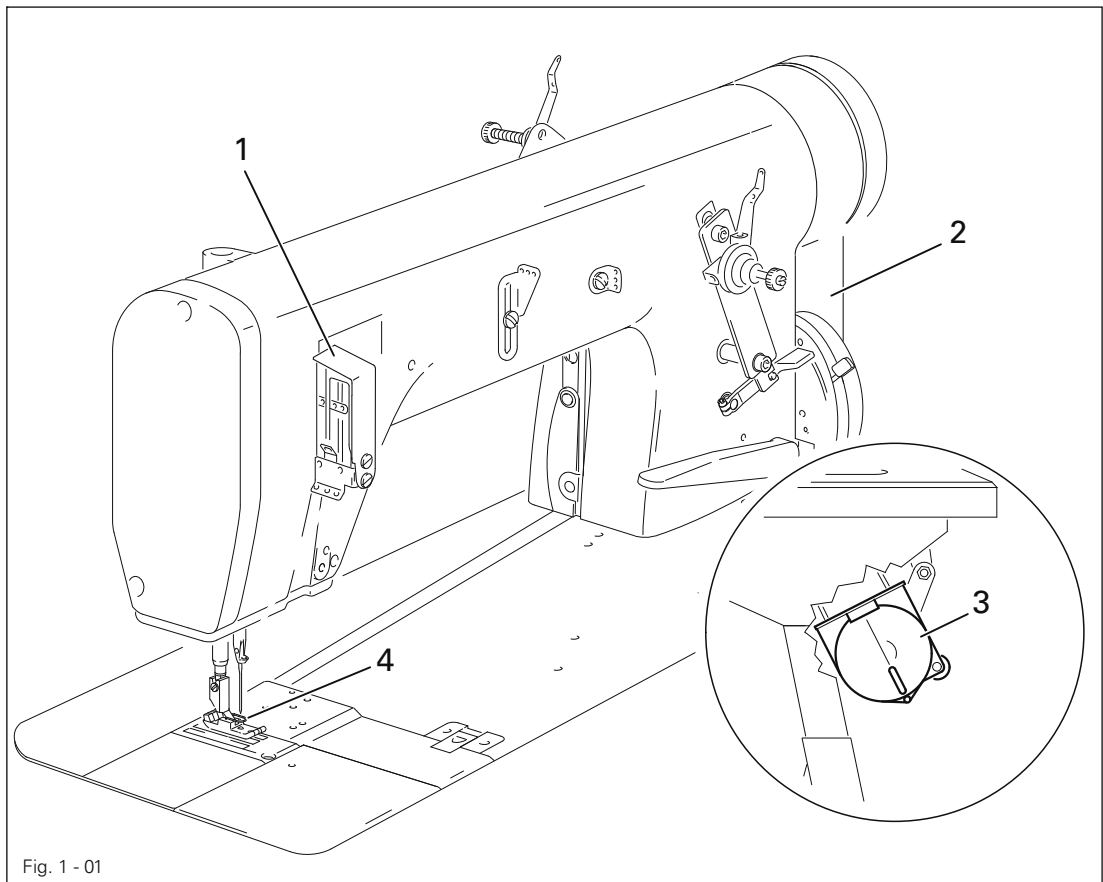


Fig. 1 - 01



Do not operate the machine without take-up lever guard **1!**  
Danger of injury from the movement of the take-up lever!



Do not operate the machine without belt guard **2** and **3!**  
Danger of injury by running drive belts!



Do not operate the machine without finger guard **4!**  
Danger of injury by the needle!



## 2

### Proper use

The **PFAFF 5483** is an ultra-high-speed chainstitch sewing machine with drop feed for production of chainstitch seams.

The machine is intended for commercial (industrial) use.



Any use of these machines which is not approved by the manufacturer shall be considered as improper use! The manufacturer shall not be liable for any damage arising out of improper use! Proper use shall also be considered to include compliance with the operation, adjustment, service and repair measures specified by the manufacturer!

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## Specifications

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### 3 Specifications ♦

#### 3.01 PFAFF 5483-814/01; 5483 H-814/01

Stitch type: ..... 401 (two-thread chainstitch)

Needle system:

5483-814/01 ..... 4463-35

5483 H-814/01 ..... 5463-35

Needle thickness in 1/100 mm:

Model A: ..... 60 to 70

Model B: ..... 80 to 100

Max. stitch length:

Models A and B: ..... 4.5 mm

Version N 3.5: ..... 3.5 mm

Max.thread size (synthetic): ..... 40/3 ▲

Max. sewing speeds:

5483-814/01 in models A and B: ..... 6,000 min<sup>-1</sup>

5483 H-814/01 in models A and B: ..... 4,800 min<sup>-1</sup>

Dimensions of the machine:

Length: ..... approx. 580 mm

Breadth: ..... approx. 177 mm

Height (above table): ..... approx. 265 mm

Clear workspace width: ..... 260 mm

Clear workspace height: ..... 130 mm

Fabric clearance:

5483-814/01 ..... 7 mm

5483 H-814/01 ..... 9 mm

Noise data:

Noise emission level at workplace with a sewing speed of 4800 spm: ..... L<sub>pA</sub> < 83 dB(A)■

(Noise measurement in accordance with DIN 45 635-48-A-1, ISO 11204, ISO 3744, ISO

Net weight (sewing head): ..... approx. 37 kg

Gross weight (sewing head): ..... approx. 45 kg

Motor data: ..... See instruction manual for the motor

Working pressure: ..... 6 bar

Air consumption per switch cycle: ..... ~ 0,146 l

♦ Subject to alterations

▲ synthetic, or other sizes of comparable thread types

■ K<sub>pA</sub> = 2,5 dB

## 3.02 Models and work aids

Model A: ..... For sewing light materials

Model B: ..... For sewing medium materials

Possible work aids:

Subclass -900/71 ..... Thread trimmer

Subclass -910/.. ..... Automatic foot lift

Subclass -911/.. ..... Backtacking system

Subclass -917/.. ..... Stitch condensation system

Subclass -918/14.. ..... Various controls

Subclass -948/26..... Puller feed

Subclass -971/.. ..... Photocell control

### 4 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 regulations; if necessary, a specialist is to be commissioned.



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

### **5            Transportation, packing and storage**

#### **5.01        Transportation to customer's premises**

The machines are delivered completely packed.

#### **5.02        Transportation inside the customer's premises**

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

#### **5.03        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.

#### **5.04        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.

### 6 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:



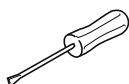
Note, information



Cleaning, care



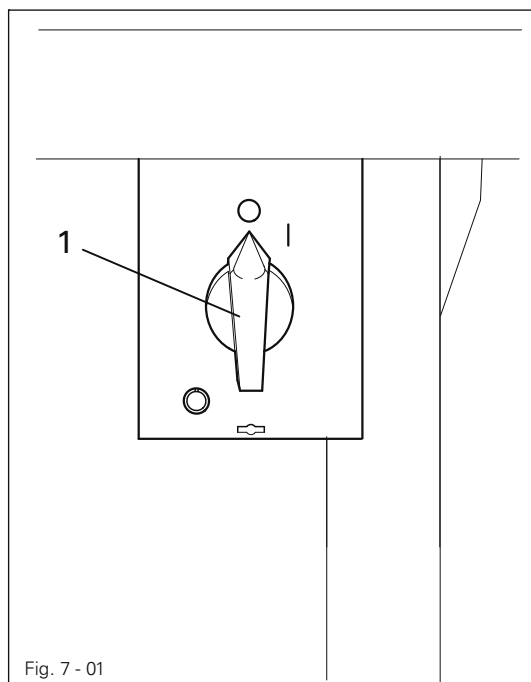
Lubrication



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

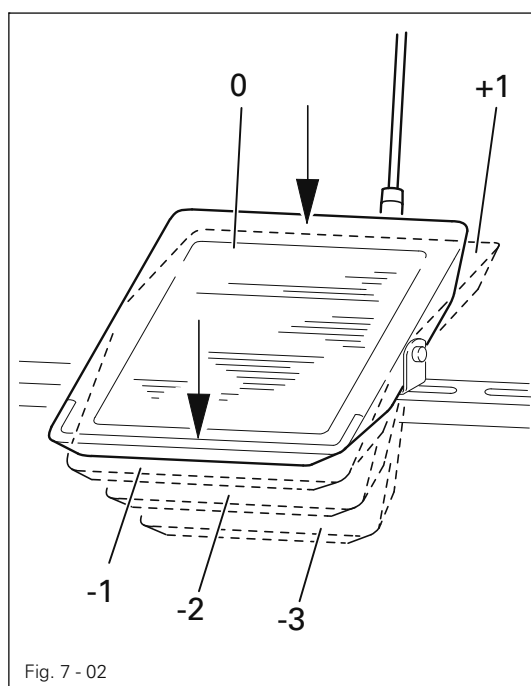
## 7 Controls

### 7.01 Main switch



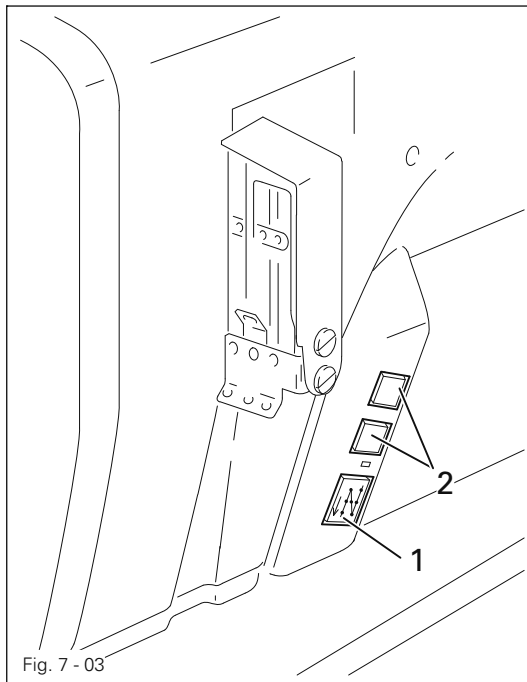
- The machine is switched on or off by turning main switch 1.

### 7.02 Pedal



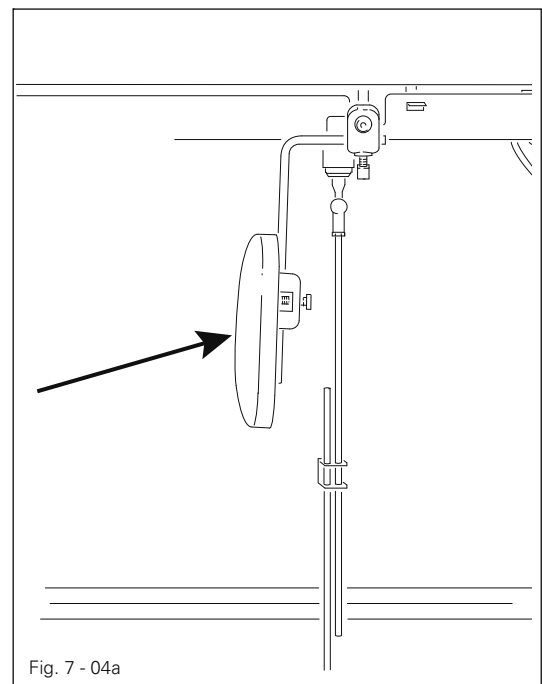
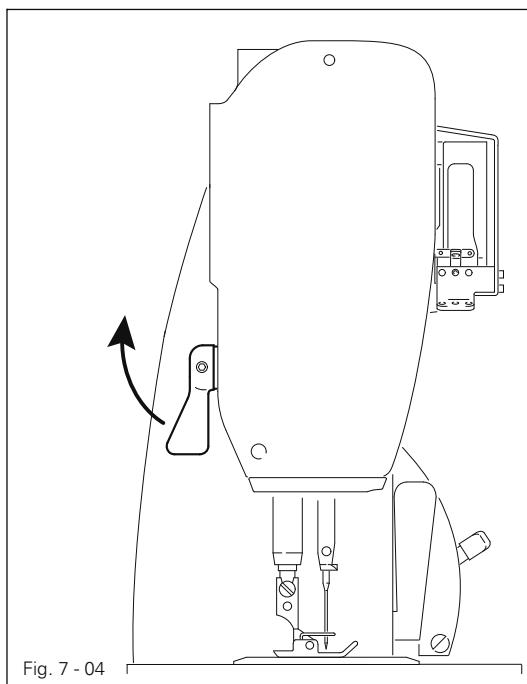
- With the on/off switch on
  - 0 = Machine stop
  - +1 = sewing, up to maximum speed
  - 1 = Raise presser foot
  - 2 = Raise puller roller  
(on machines with -948/26)
  - 3 = Trim thread  
( on machines with -900/..)

## 7.03 Keys on the machine head



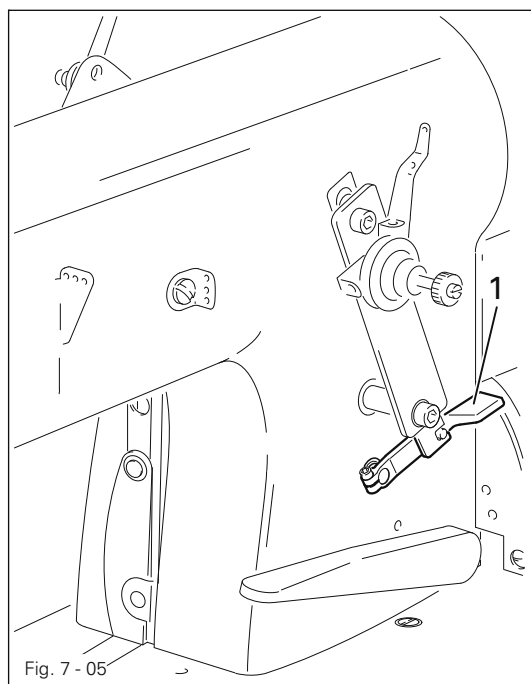
- As long as key 1 is pressed during sewing, the machine sews in reverse.
- Keys 2 can be used for parameter settings (see parameter 748 and 446 in the instruction manual for the motor).

## 7.04 Raising the presser foot



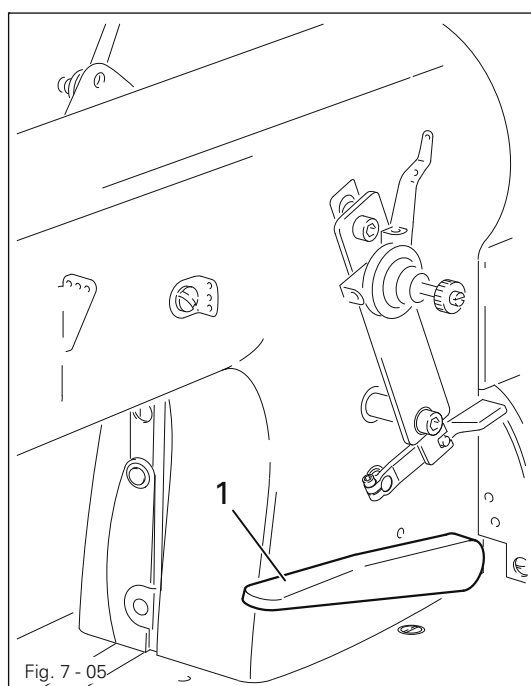


## 7.05 Thread tension release lever



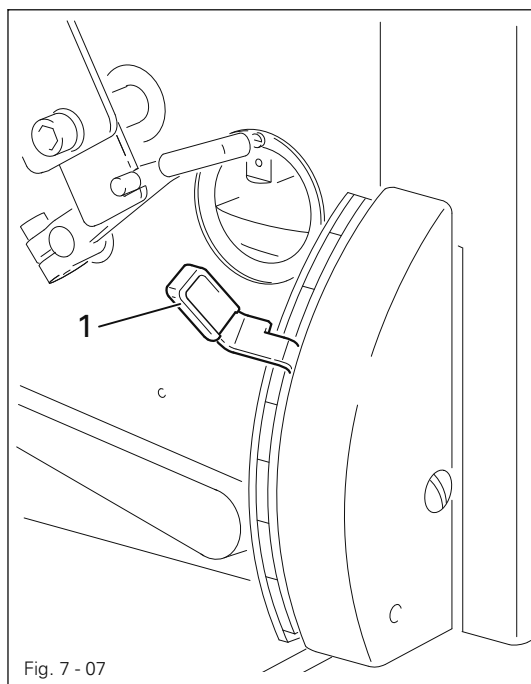
- To release the thread tension push lever 1 downwards.

## 7.06 Reverse feed lever



- To sew condensed stitches, press lever 1 down.

### 7.07 Feed regulator lever



- To set the stitch length, press lever 1 a little to the right and move it to the required stitch length.

### 7.08 Control panel

The description can be found in the separate instruction manual for the motor.

### 7.09 Puller (-948/26)

The description can be found in the separate instruction manual for the Puller.

## 8 Installation and commissioning

The machine must only be mounted and commissioned by qualified personnel!  
All relevant safety regulations are to be observed!



If the machine is delivered without a table, it must be ensured that the frame and the table top which you intend to use can hold the weight of the machine and the motor. It must be ensured that the supporting structure is sufficiently sturdy, including during all sewing operations.

### 8.01 Installation

The site where the machine is installed must be provided with suitable connections for the electric current, see Chapter 3 **Specifications**.

It must also be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided.



The method of packaging used requires that the table top be lowered for transport. The following is a description of how to adjust the height of the table top.

#### 8.01.01 Adjusting the table-top height

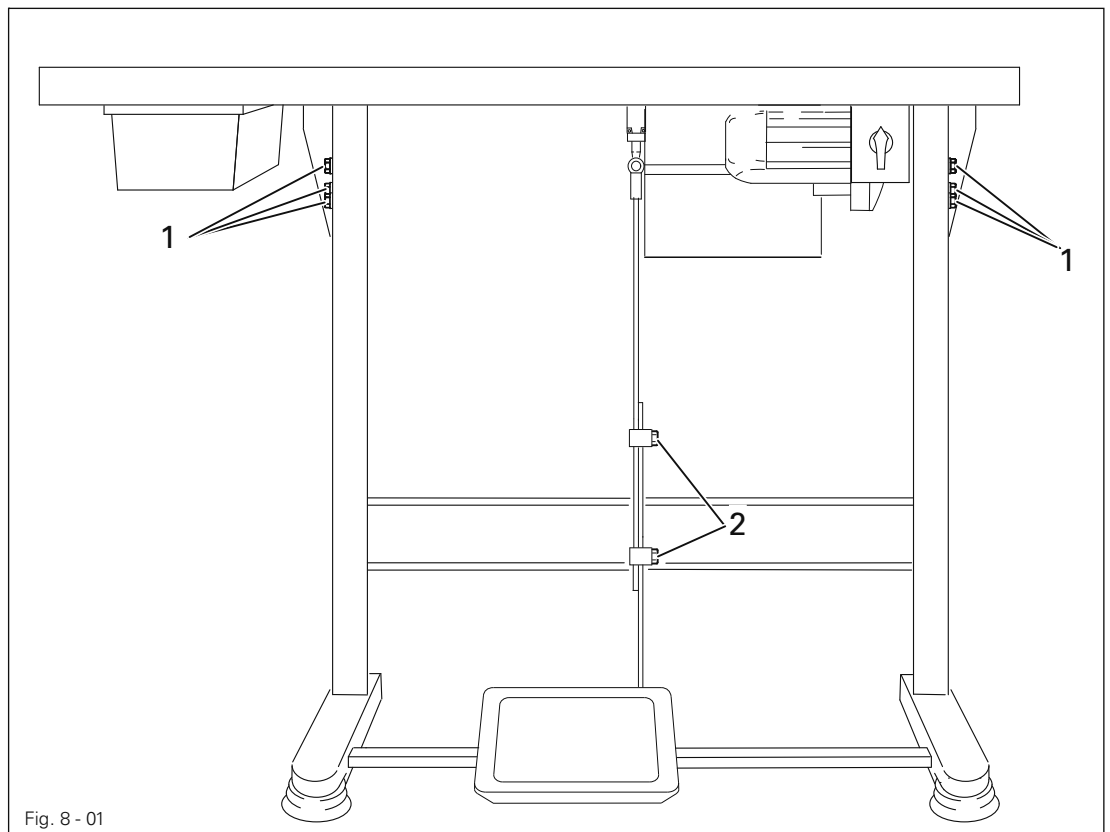
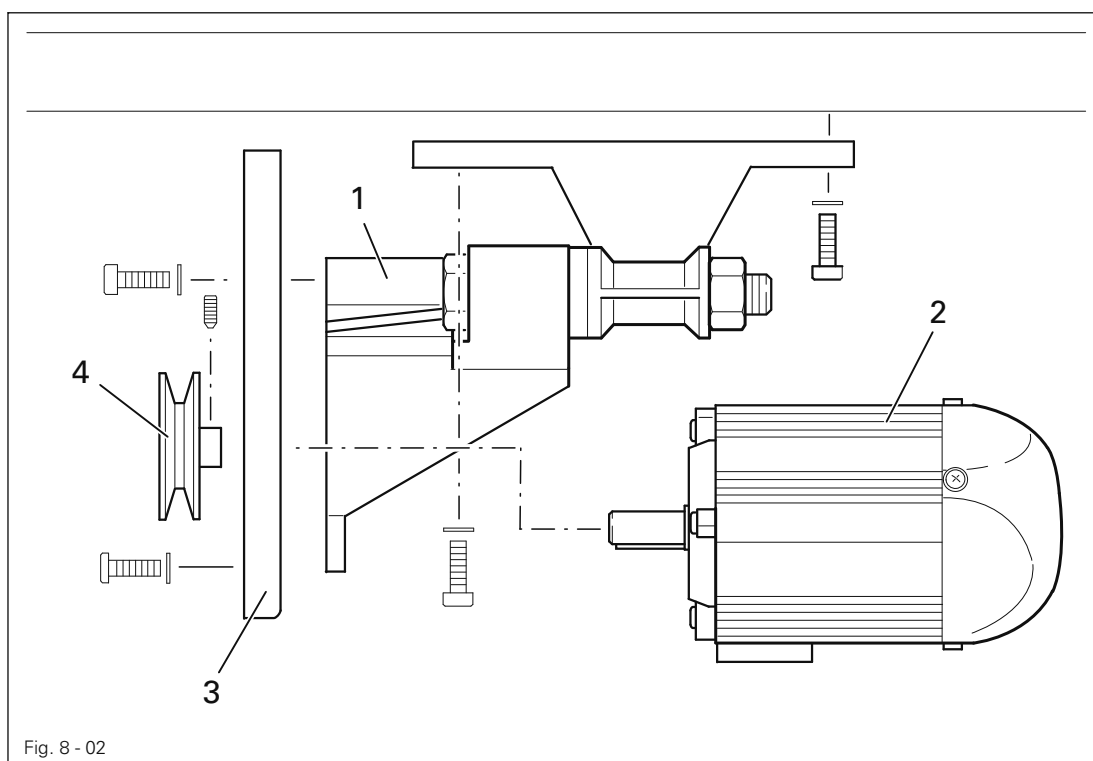


Fig. 8 - 01

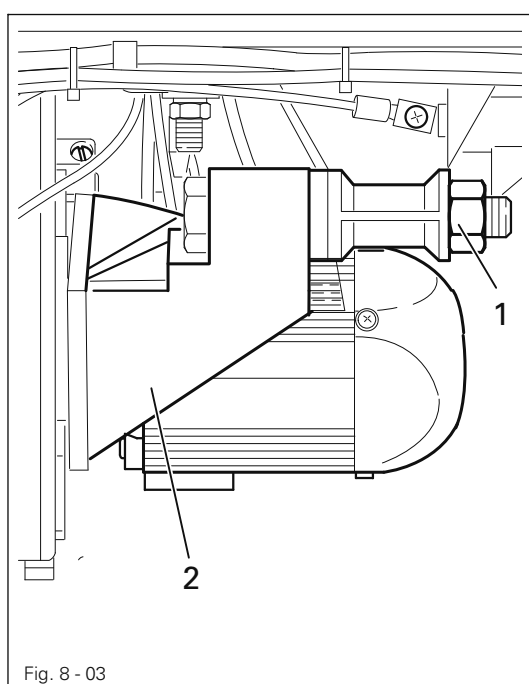
- Loosen screws 1 and 2 and set the desired table-top height
- Tighten screws 1 well.
- Adjust the position of the pedal so that you can operate it comfortably and tighten screw 2.

### 8.01.02 Assembling the motor P40 ED



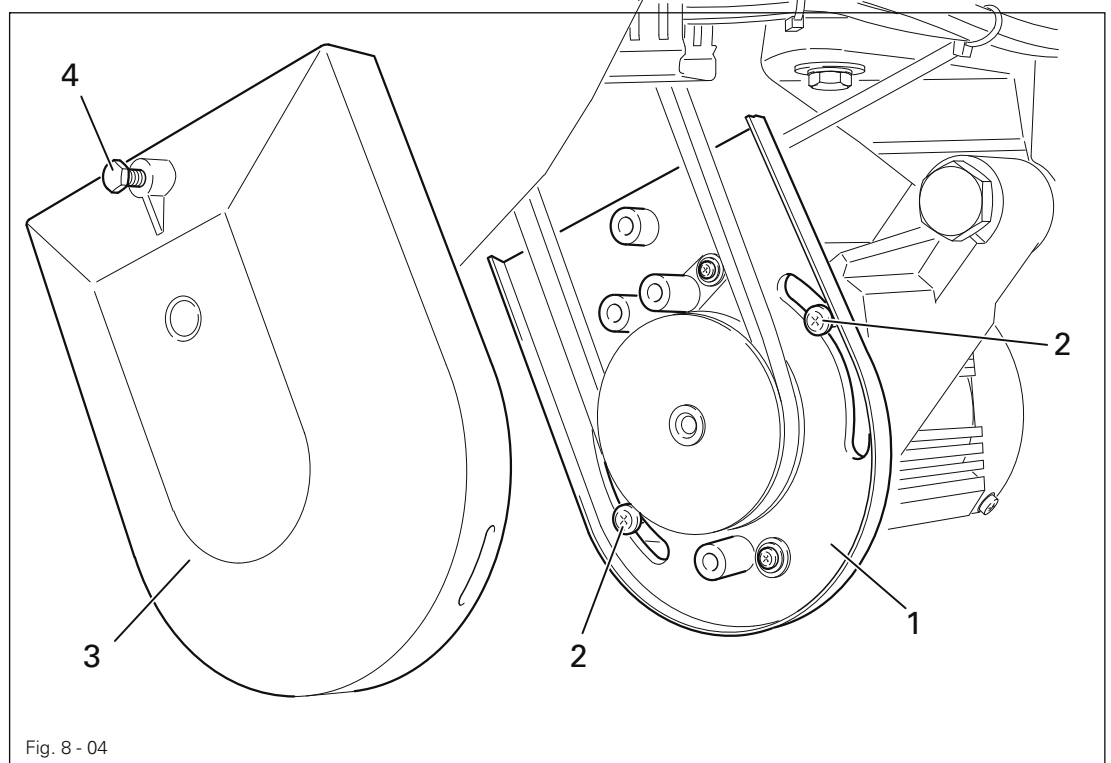
- Assemble motor mounting 1, motor 2, belt guard support 3 and belt pulley 4 as shown in Fig. 8-02.

### 8.01.03 Tightening the V-belt



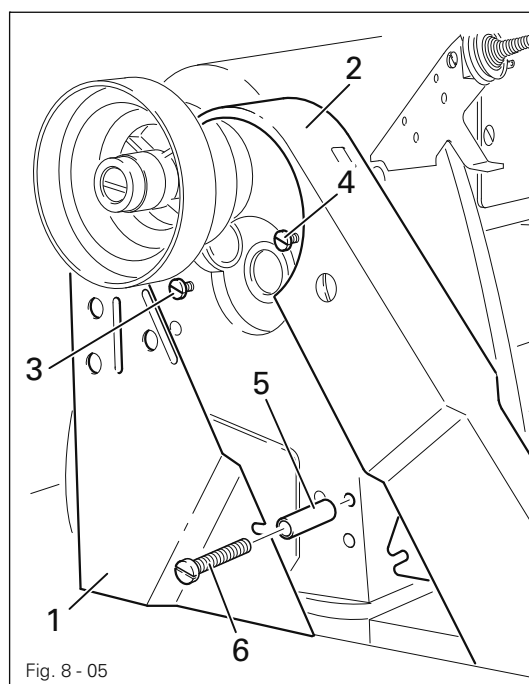
- Fit the V-belt.
- Loosen nut 1 and tighten the V-belt by turning motor mounting 2.
- Tighten nut 1.

### 8.01.04 Mounting the bottom V-belt guard



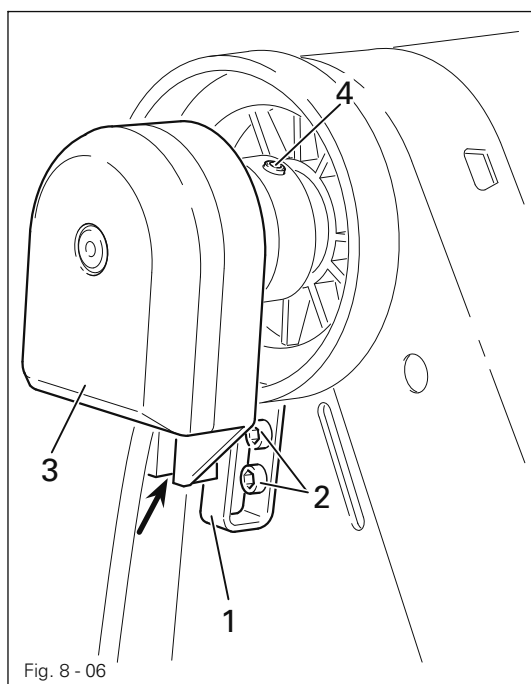
- Loosen screws 2 and adjust belt guard support 1 so that the motor pulley and V-belt run freely.
- Tighten screws 2.
- Fasten belt guard 3 with screw 4.

### 8.01.05 Fitting the upper belt guard



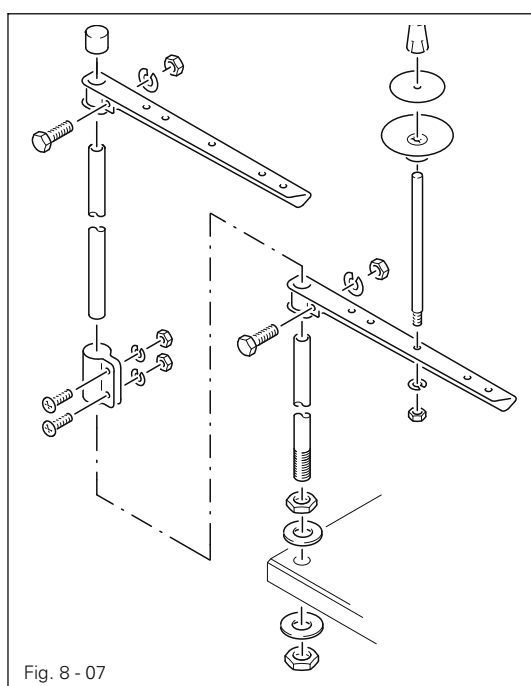
- Push belt guard halves 1 and 2 with their slots behind the heads of screws 3 and 4.
- Fit spacing sleeve 5 on screw 6 and wind screw 6 in a few turns.
- Making sure that the lug on belt guard half 2 is between belt guard half 1 and spacing sleeve 5, position the belt guard and tighten screws 3, 4 and 6.

### 8.01.06 Fitting the synchronizer

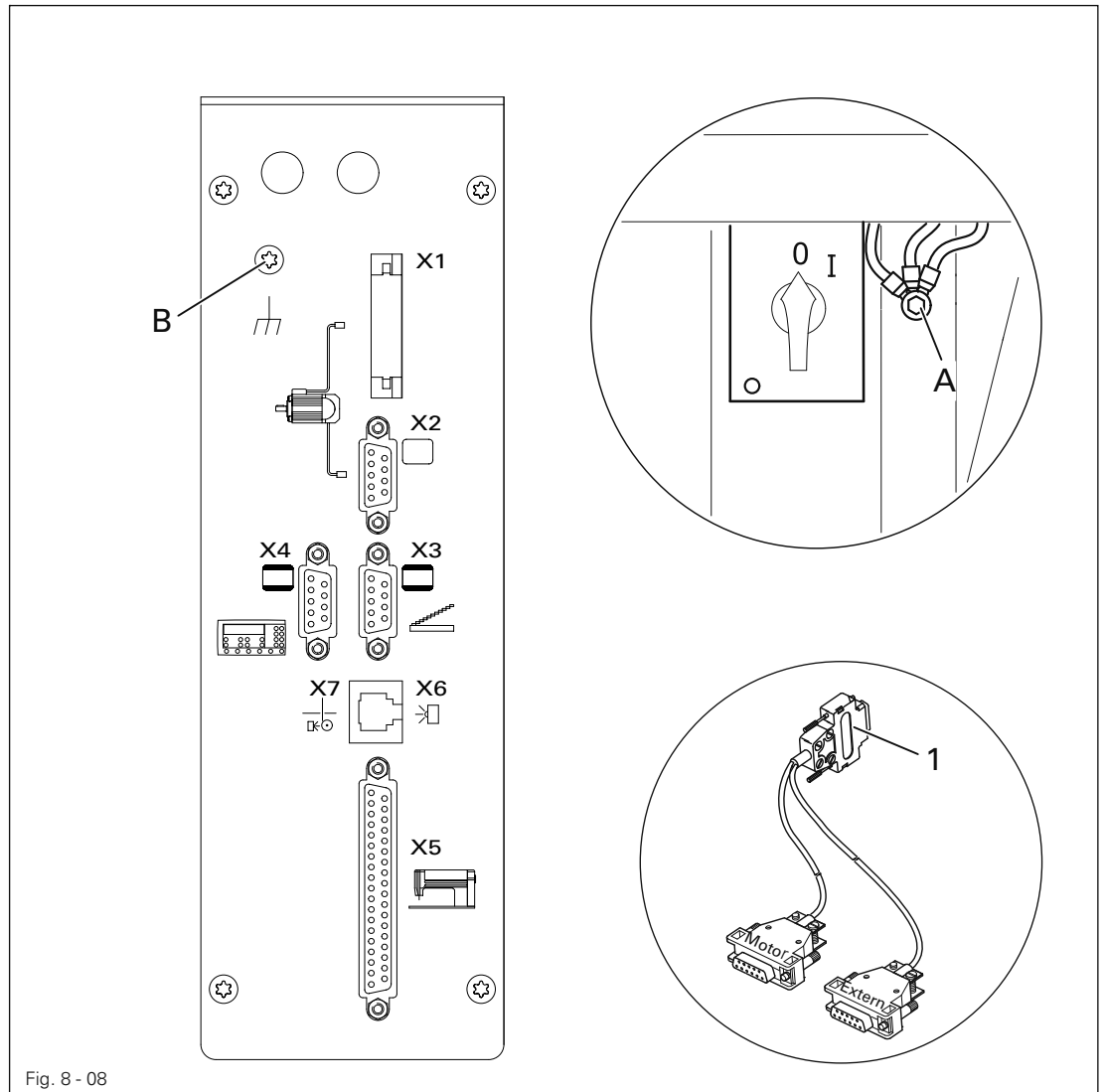


- Screw on stop 1 with screws 2.
- Place synchronizer 3 on the shaft so that stop 1 is in the slot of synchronizer 3, see arrow.
- Tighten screws 4.
- Insert the synchronizer plug into the adapter (see Chapter 8.02 Connecting the plug-in connections and earth cables).

### 8.01.07 Fitting the reel stand

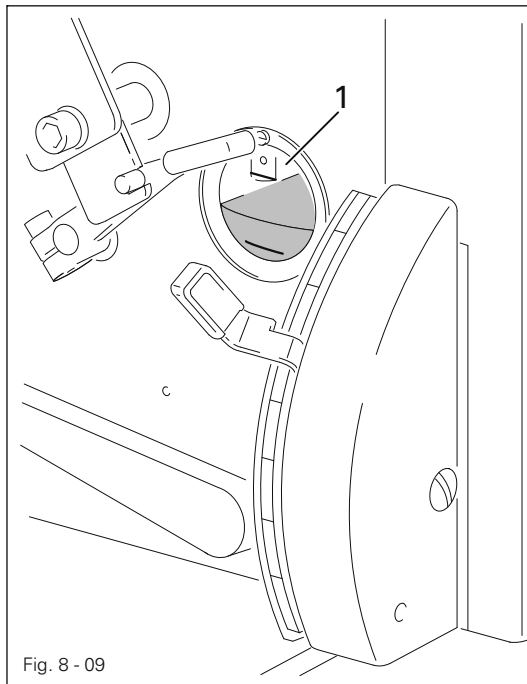


- Fit the reel stand as shown in Fig. 8 - 07.
- Afterwards insert the stand in the hole in the table top and secure it with nuts provided.



- Connect all plugs as labelled to the control box .
- Screw the earth cable from the sewing head and the main switch to earth point **A**.
- Connect earth point **A** to earth point **B** with earth cable.
- Insert plug **1** from the adapter cable to bush **X 2**.
- Connect the motor to the "**Motor**" plug and the synchronizer to the "**Extern**" plug.
- Fasten the earth cable from plug **X1** to earth point **B**.

## 8.03 Commissioning



Before setting up, remove the protective foil from oil glass 1!

- Check the machine, particularly its electrical wiring and pneumatic tube connections, for any damage.
- Clean the machine thoroughly and oil it (see chapter **10 Care and maintenance**).
- Have skilled personnel check if the machine can be operated with the available mains voltage.



Do not operate the machine if there is any discrepancy.



Before commissioning the machine, have specialized personnel check whether the parameter **799** (machine class) is set at "1" and the parameter 800 (sewing direction) is set at "0". If necessary, have the adjustment carried out (see Chapter **8.05 Basic position of the machine drive unit**).



The machine may only be connected to an earthed socket!

- Connect the machine to the compressed air supply. When it is connected, the gauge should show a pressure of approx. **6 bar**. If necessary, have this reading correctly set (see Chapter **10.04, Checking/adjusting the air pressure**)

## 8.04 Switching the machine on/off

- Switch the machine on (see Chapter **7.01, On/off switch**).



### 8.05 Basic position of the machine drive unit P40ED

- Switch on the machine.
- Press the **TE/speed key** twice to select the input mode.
- Select parameter "**798**" by pressing the corresponding **+/- key**, and select service level **C**, see Chapter **Selecting the user level** in the instruction manual for the control panel.
- By pressing the corresponding **+/- key** select the parameter "**799**" (Selecting the machine class).
- Check whether value "**1**" is set, and correct it if necessary.



If the parameter has to be altered, operate the **TE/Speed** key and then switch off the machine and switch it on again. Then select service level **C** again as described above.

- By pressing the corresponding **+/- key**, select parameter "**800**" (selecting the sewing direction).
- By pressing the corresponding **+/- key**, select the value for the parameter at "**0**".
- By pressing the corresponding **+/- key**, select parameter "**700**".
- Sew a stitch by operating the pedal.
- Turn the balance wheel in the sewing direction until the descending needle is level with the top edge of the needle plate.
- Conclude the adjustment of the sewing motor by pressing the **TE/Speed key**.

## 9

### Setting up



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

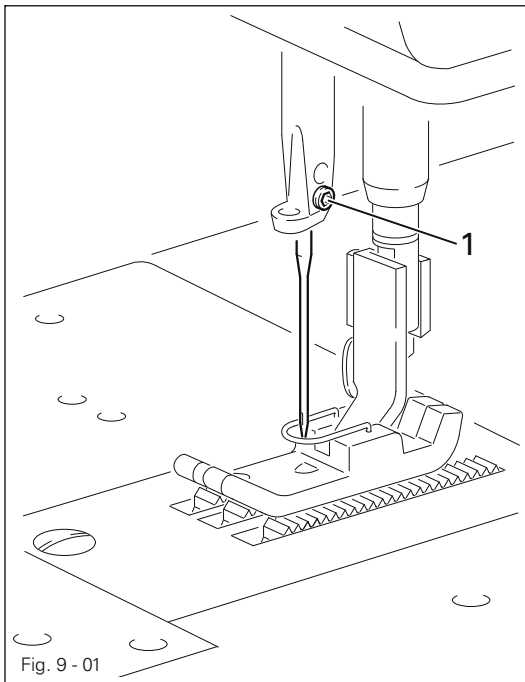


All setting-up work must only be done by personnel with the necessary training.  
For all setting-up work the machine must be isolated from its power supply by turning off the main switch or removing the machine plug from the electric power socket!

### 9.01

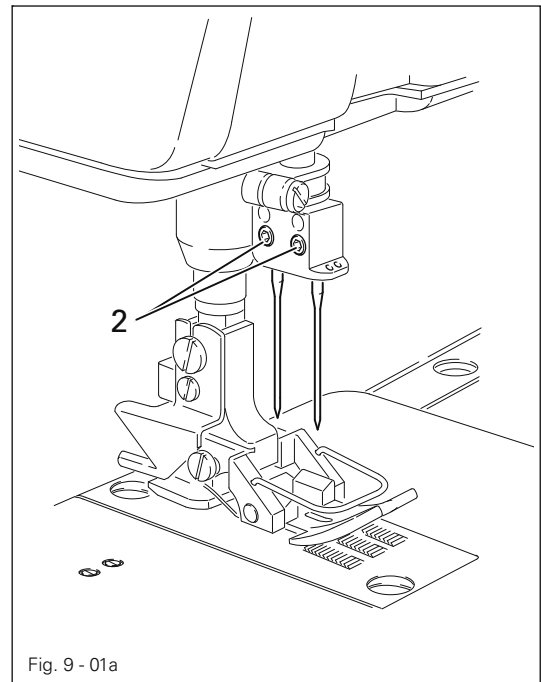
#### Inserting the needle

(on single-needle machines)



#### Inserting the needle

(on two-needle machines)



Switch off the machine!  
Danger of injury due to unintentional starting of the machine!

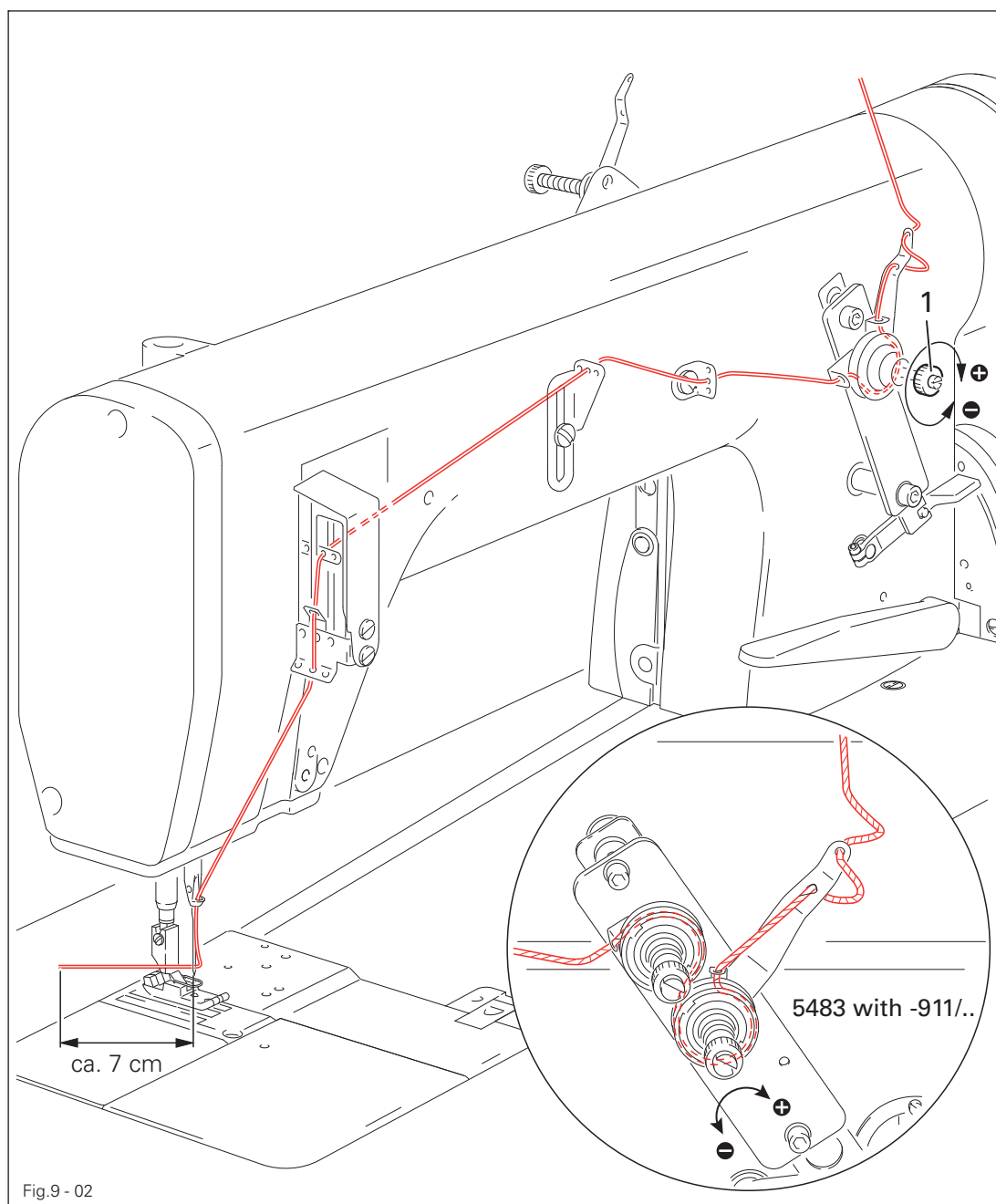


Only use needles from the system intended for the machine,  
see Chapter 3 **Specifications**.

- Set the needle bar at its highest point.
- Loosen screw **1** or **2**.
- Push needle fully into the needle bar (the long needle groove must face to the front).
- Tighten screw **1** or **2**.

## 9.02 Threading the needle thread and regulating its tension

(on single-needle machines)

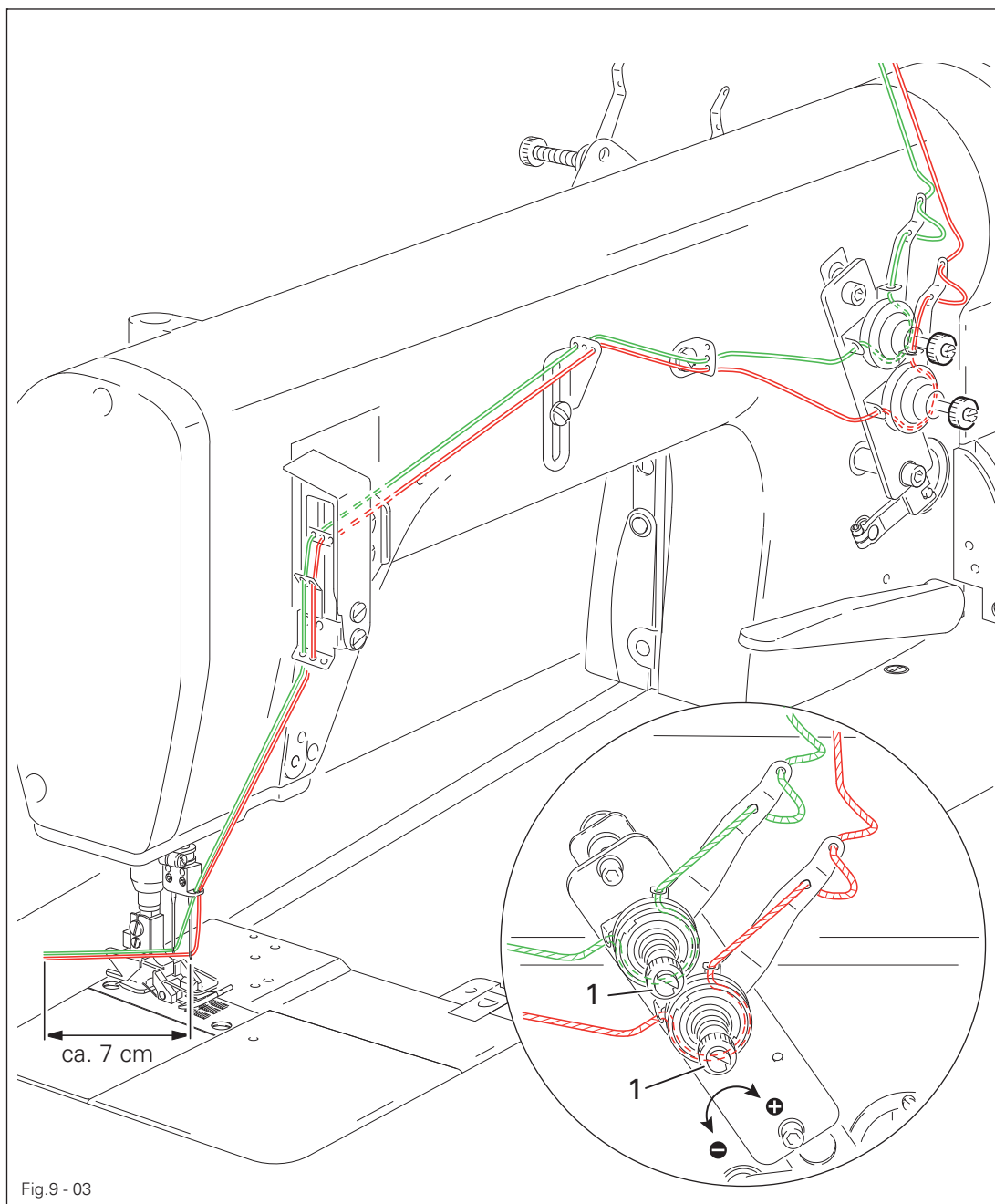


Switch off the machine!

Danger of injury due to unintentional starting of the machine!

- Thread the needle thread as shown in **Fig. 9-02**.
- Regulate the needle thread by turning knurled screw **1**.

### 9.03 Threading the needle thread and regulating its tension (on two-needle machines)

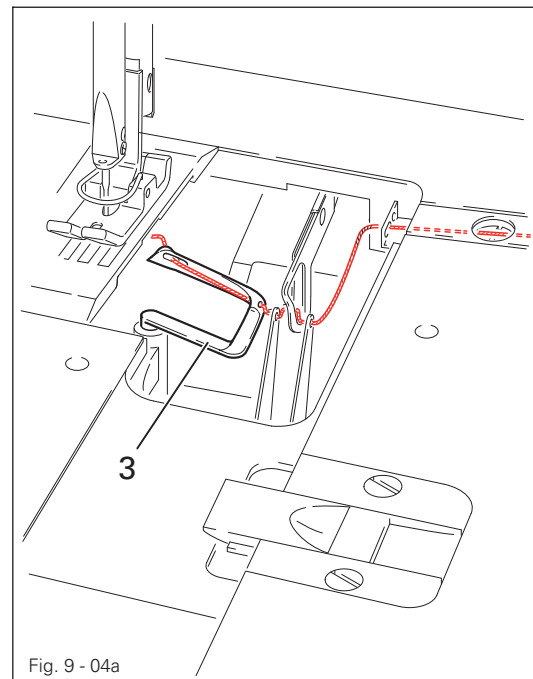
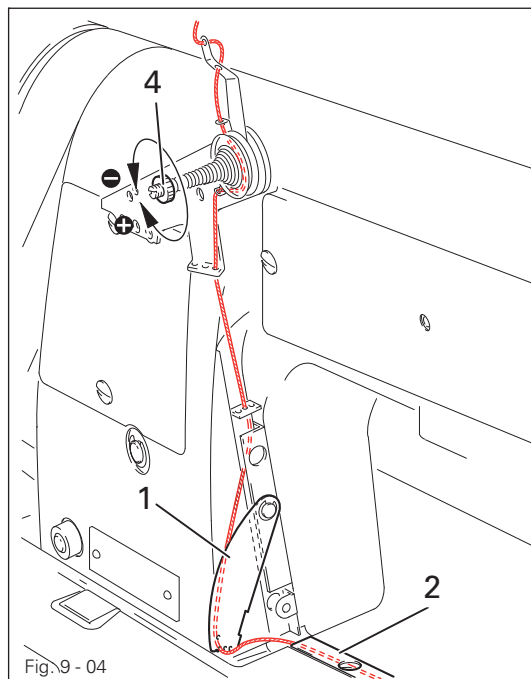


Switch off the machine!  
Danger of injury due to unintentional starting of the machine!

- Thread the needle thread as shown in **Fig. 9-03**.
- Regulate the needle thread by turning knurled screw **1**.

## 9.04 Threading the looper thread and regulating its tension

(on single-needle machines)

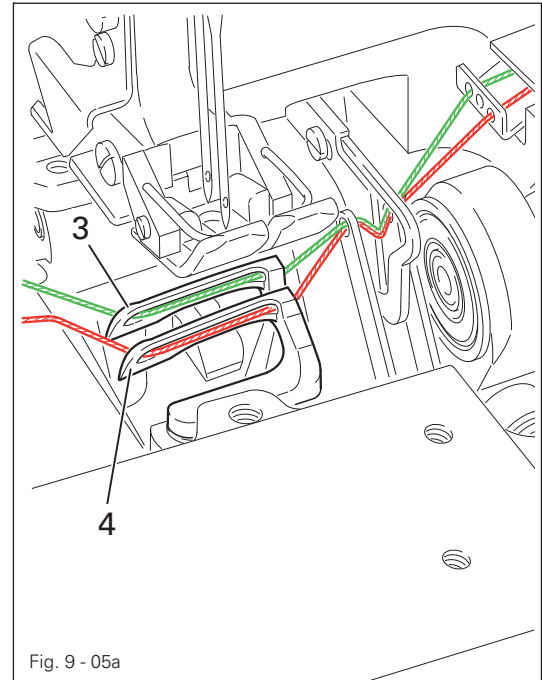
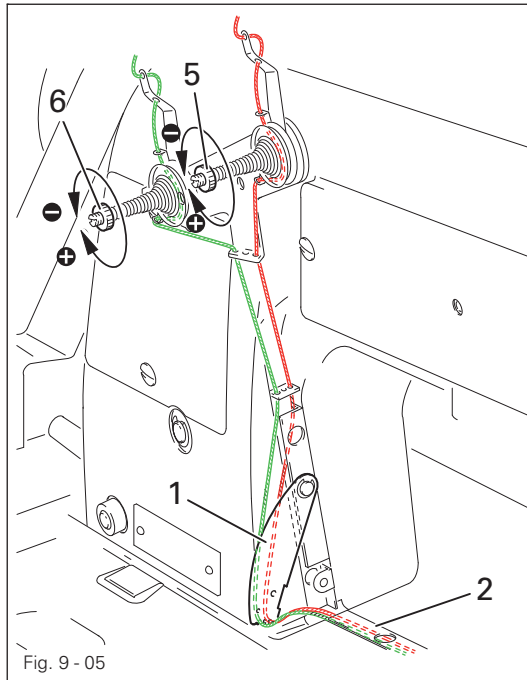


Switch off the machine!

Danger of injury due to unintentional starting of the machine!

- Open the looper cover and swing out thread guide plate 1.
- Thread the looper thread as shown in **Figs. 9-04** and **9-04a** and pull it under guide plate 2.
- Thread looper 3 using tweezers.
- Regulate the looper thread by turning knurled screw 4.
- To pull the thread through, release thread tension (see **Chapter 7.05**)

### 9.05 Threading the looper thread and regulating its tension (on two-needle machines)



Switch off the machine!  
Danger of injury due to unintentional starting of the machine!

- Open the looper cover and swing out thread guide plate 1.
- Thread the looper threads as shown in **Figs. 9-05** and **9-05a** and pull it under guide plate 2.
- Thread looper 3 and 4 using tweezers.
- Regulate the looper thread by turning knurled screw 5 and 6.
- To pull the thread through, release thread tension (see **Chapter 7.05**)

## 10 Care and maintenance

### 10.01 Servicing and maintenance intervals

Clean the looper compartment .....	daily, several times if in continuous operation
Clean the entire machine .....	once a week
Machine oil level.....	daily before use
Control/adjust air pressure .....	as required
Clean air filter of the lubricator/air-filter .....	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.

### 10.02 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 .

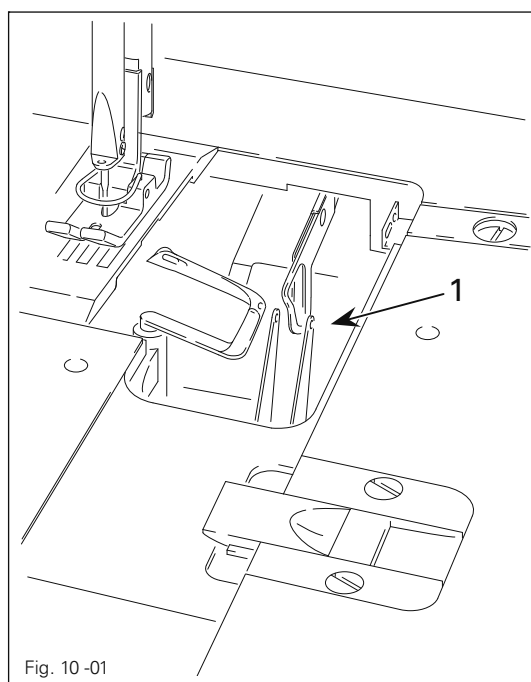


Fig. 10 -01

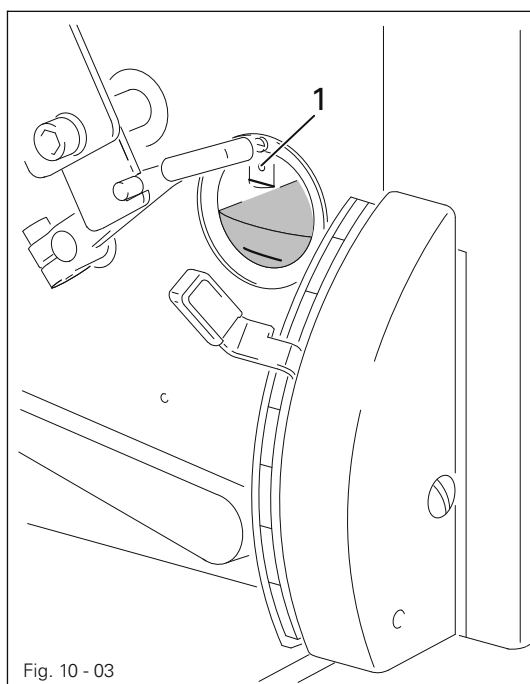
To avoid breakdowns, the following cleaning work is recommended for single shift operation:

- Open the looper cover.
- Clean the hook compartment 1 daily, several times if in continuous use.
- Close the looper cover !



Do not run the machine with the looper cover open. !  
Danger of injury by moving parts.

### 10.03 Lubricating

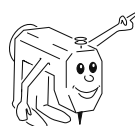


Check the oil level daily before starting the machine!

- The oil level must be between the markings in the inspection glass.
- If required, fill oil into the tank through hole 1.



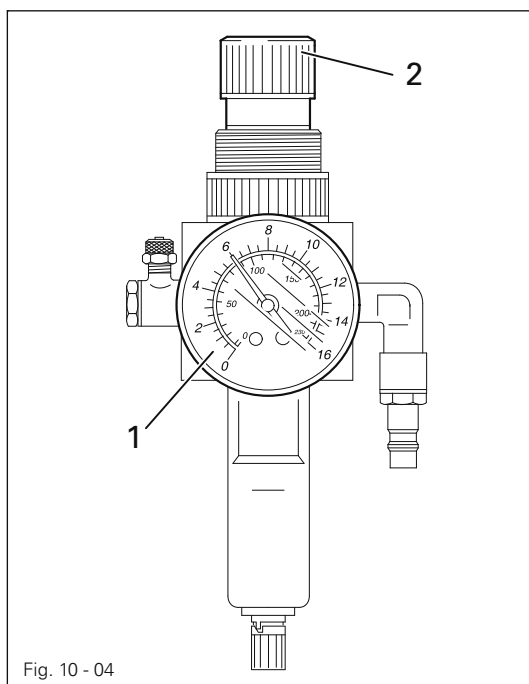
Only use oil with a medium viscosity of **22.0 mm<sup>2</sup>/s** at **40° C** and a density of **0.865 g/cm<sup>3</sup>** at **15°C!**



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

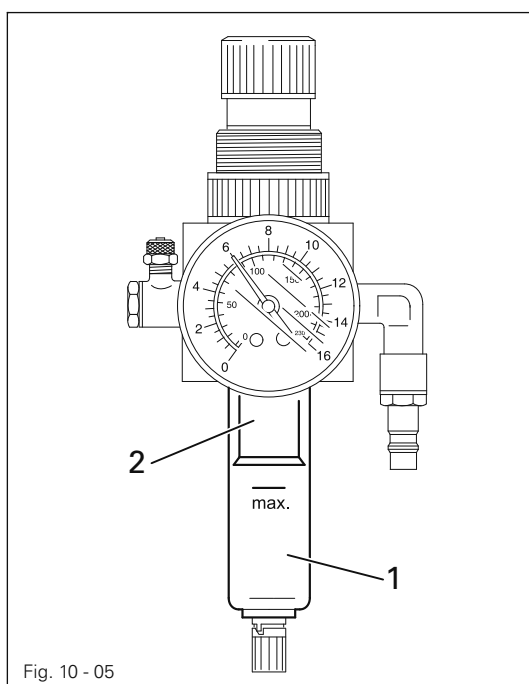


## 10.04 Checking/regulating the air pressure



- 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.

## 10.05 Emptying/cleaning the water bowl of the air filter/regulator



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.



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