DÜRKOPP ADLER

806N-111
806N-121

Operating Instructions

IMPORTANT
READ CAREFULLY BEFORE USE
KEEP FOR FUTURE REFERENCE

1 About these instructions

These instructions have been prepared with utmost care. They contain information and notes intended to ensure long-term and reliable operation.

Should you notice any discrepancies or if you have improvement requests, then we would be glad to receive your feedback through **Customer Service** (📖 *p. 131*).

Consider the instructions part of the product and store them in a place where they are readily available.

1.1 For whom are these instructions intended?

These instructions are intended for:

- Operators:
  This group is familiar with the machine and has access to the instructions. Specifically, chapter **Operation** (📖 *p. 23*) is important for the operators.
- Specialists:
  This group has the appropriate technical training for performing maintenance or repairing malfunctions. Specifically, the chapter **Setup** (📖 *p. 107*) is important for specialists.

Service Instructions are supplied separately.

With regard to minimum qualification and other requirements to be met by personnel, please also follow the chapter **Safety** (📖 *p. 9*).

1.2 Representation conventions – symbols and characters

Various information in these instructions is represented or highlighted by the following characters in order to facilitate easy and quick understanding:

Proper setting

Specifies proper setting.

Disturbances

Specifies the disturbances that can occur due to an incorrect setting.

Cover

Specifies which covers must be removed in order to access the components to be set.

Steps to be performed when operating the machine (sewing and equipping)

Steps to be performed for service, maintenance, and installation

Steps to be performed via the software control panel

The individual steps are numbered:

1. 1. First step
2. 2. Second step

   The steps must always be followed in the specified order.

…

- Lists are marked by bullet points.

Result of performing an operation

Change to the machine or on the display/control panel.

Important

Special attention must be paid to this point when performing a step.

Information

Additional information, e.g. on alternative operating options.

Order

Specifies the work to be performed before or after a setting.

References

🕮 Reference to another section in these instructions.

Safety Important warnings for the machine users are specially designated. Since safety is of particular importance, hazard symbols, levels of danger and their signal words are described separately in the chapter **Safety** (🕮 *p. 9*).

Location information If no other clear location information is used in a figure, indications of **right** or **left** are always from the user's point of view.

1.3 Other documents

The machine includes components from other manufacturers. Each manufacturer has performed a hazard assessment for these purchased parts and confirmed their design compliance with applicable European and national regulations. The proper use of the built-in components is described in the corresponding manufacturer's instructions.

1.4 Liability

All information and notes in these instructions have been compiled in accordance with the latest technology and the applicable standards and regulations.

Dürkopp Adler cannot be held liable for any damage resulting from:

- Breakage and damage during transport
- Failure to observe these instructions
- Improper use
- Unauthorized modifications to the machine
- Use of untrained personnel
- Use of unapproved parts

Transport

Dürkopp Adler cannot be held liable for breakage and transport damages. Inspect the delivery immediately upon receiving it. Report any damage to the last transport manager. This applies even if the packaging is undamaged.

Leave machines, equipment and packaging material in the condition in which they were found when the damage was discovered. This will ensure any claims against the transport company.

Report all other complaints to Dürkopp Adler immediately after receiving the product.

2 Safety

This chapter contains basic information for your safety. Read the instructions carefully before setting up or operating the machine. Make sure to follow the information included in the safety instructions. Failure to do so can result in serious injury and property damage.

2.1 Basic safety instructions

The machine may only be used as described in these instructions.

These instructions must be available at the machine's location at all times.

Work on live components and equipment is prohibited. Exceptions are defined in the DIN VDE 0105.

For the following work, shut down the computer FIRST BEFORE switching off the machine at the main switch or disconnecting the power plug:

- Replacing the needle or other sewing tools
- Leaving the workstation
- Performing maintenance work and repairs
- Threading

Missing or faulty parts could impair safety and damage the machine. Only use original parts from the manufacturer.

Transport

Use a lifting carriage or forklift to transport the machine. Raise the machine max. 20 mm and secure it against slipping.

Setup

The connecting cable must have a power plug approved in the relevant country. The power plug may only be assembled to the power cable by qualified specialists.

Obligations of the operator

Follow the country-specific safety and accident prevention regulations and the legal regulations concerning industrial safety and the protection of the environment.

All the warnings and safety signs on the machine must always be in legible condition. Do not remove!
Missing or damaged warnings and safety signs must be replaced immediately.

Requirements to be met by the personnel

Only qualified specialists may:

- set up the machine
- perform maintenance work and repairs
- perform work on electrical equipment

Only authorized persons may work on the machine and must first have understood these instructions.

Operation

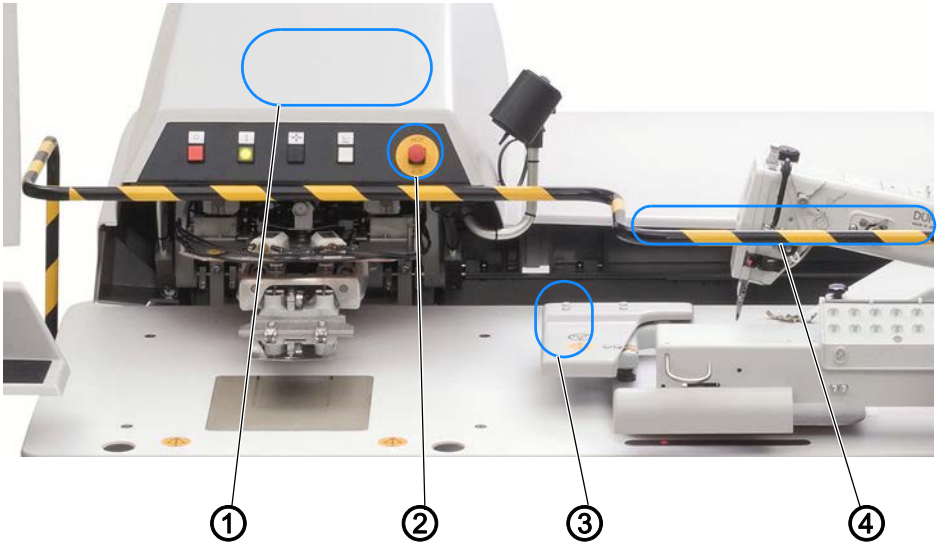
Inspect the machine while in use for any externally visible damage. Stop working if you notice any changes to the machine. Report any changes to your supervisor. Do not use a damaged machine any further.

Safety equipment

Safety equipment should not be removed or deactivated. If it is essential to remove or deactivate safety equipment for a repair operation, it must be assembled and put back into operation immediately afterward.

The safety equipment is located at the illustrated positions on the machine:

Fig. 1: Safety equipment



(1) - Protective hood
(2) - EMERGENCY STOP button
(3) - Integrated EMERGENCY STOP
(4) - Metal bar

The following safety equipment are mounted on the machine:

Figure	Designation	Purpose
	EMERGENCY STOP button	The machine is immediately placed in the EMERGENCY STOP state: – The motors are braked and then disconnected from the power. – The cylinders are depressurized.

Figure	Designation	Purpose
	EMERGENCY STOP integrated	The machine is immediately placed in the EMERGENCY STOP state: – The motors are disconnected from the power. – The cylinders are depressurized.
	Metal bar	Defines limits for the user to provide protection from injury.
	Protective hood	Protects the user from injury and protects the electrical and mechanical elements of the machine from soiling.

2.2 Signal words and symbols used in warnings

Warnings in the text are distinguished by color bars. The color scheme based on the severity of the danger. Signal words indicate the severity of the danger.

Signal words

Signal words and the hazard they describe:

Signal word	Meaning
DANGER	(with hazard symbol) If ignored, fatal or serious injury will result
WARNING	(with hazard symbol) If ignored, fatal or serious injury can result
CAUTION	(with hazard symbol) If ignored, moderate or minor injury can result
CAUTION	(with hazard symbol) If ignored, environmental damage can result
NOTICE	(without hazard symbol) If ignored, property damage can result

Symbols The following symbols indicate the type of danger to personnel:

Symbol	Type of danger
	General
	Electric shock
	Puncture
	Crushing
	Environmental damage

Examples Examples of the layout of warnings in the text:

DANGER

Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that will result in serious injury or even death if ignored.

WARNING

Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in serious or even fatal injury if ignored.

CAUTION

Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in moderate or minor injury if the warning is ignored.

CAUTION

Type and source of danger!

Consequences of non-compliance.

Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in environmental damage if ignored.

NOTICE

Type and source of danger!

Consequences of non-compliance.

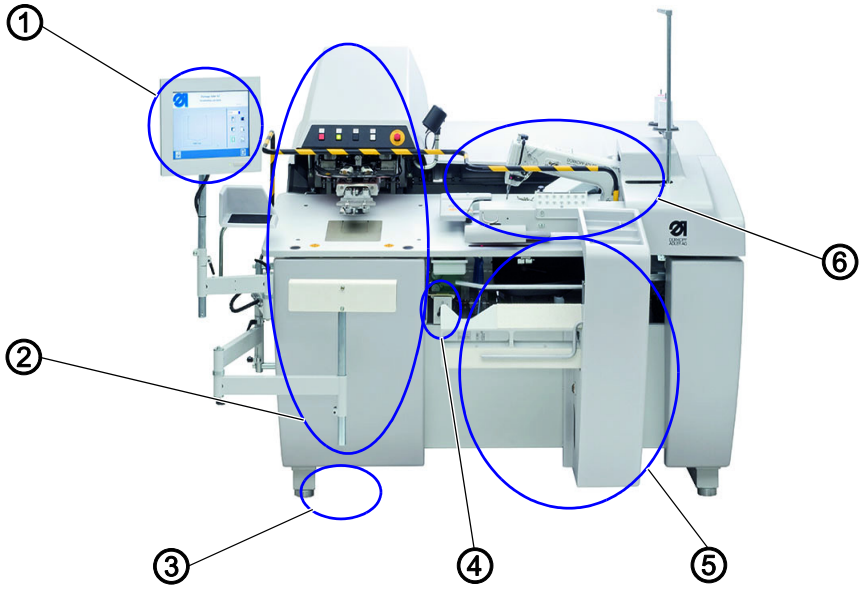
Measures for avoiding the danger.

↳ This is what a warning looks like for a hazard that could result in property damage if ignored.

3 Machine description

3.1 Components of the machine

Fig. 2: Components of the machine



(1) - Control panel
(2) - Edge folding station
(3) - Pedal (not shown)
(4) - Main switch
(5) - Stacker
(6) - Sewing unit

3.1.1 Control panel

Fig. 3: Control panel

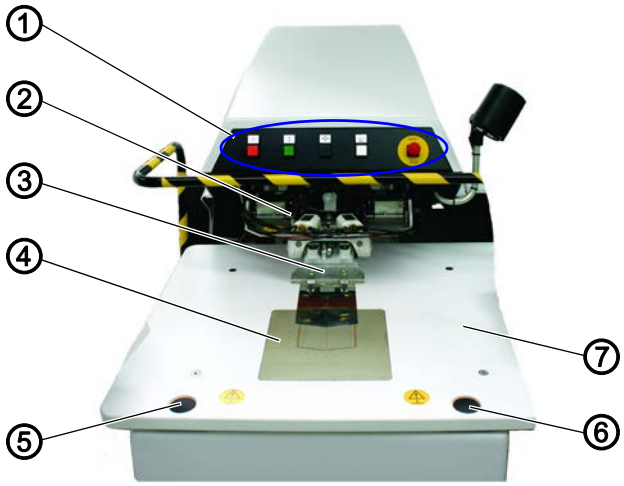
(1) - Touchscreen
(2) - USB port

You can use the touchscreen (1) to set up the sewing unit.

You can import new pocket seam programs, seam programs or other software via the USB port (2) or network interface in the housing.

3.1.2 Edge folding station

Fig. 4: Edge folding station



(1) - Keypad
(2) - Edge folding frame
(3) - Middle slide
(4) - Hose insert (optional)
(5) - Button 1
(6) - Button 2
(7) - Sewing material support surface
(8) - Pedal (not shown)

Place the fabric parts to be sewn on the edge folding station:

- The basic part on the sewing material support surface (7) with integrated hose insert (optional) (4)
- The pocket blank on the middle slide (3)

The edge folding frame (2) is used to fold the (edge) of the pocket blanks.

Furthermore, two buttons (5, 6) and the pedal (8) used to start the sewing cycle can be found here.

The keypad (1) is used to operate the mechanical components and displays the operating status.

Keypad

The individual elements of the key panel always have two components:

- Button
- Label field

A description of the function can be found in the table below in addition to the figure and designation of the buttons

Button	Designation	Function
	Stop button	The **stop button** does not light up. If you press the **stop button**, the machine ends the current work step and comes to a **safe stop**. The activities described in 🕮 *Chapter 5.8 Activities on the machine* can be performed safely.
	Start button	The **start button** can light up or flash in green. If the **start button** lights up, you can start a procedure on the machine by pressing **button 1**. If the **start button** flashes, an error has to be eliminated or a requirement met. Next, press **button 1** to resume the procedure.
	Cancel button	The **cancel button** does not light up. The current edge folding procedure is stopped by pressing the **cancel button**. The sewing procedure is resumed.
	Safe stop	**Safe stop** is not a button, but a lamp which lights up in white. The **safe stop** lamp indicates that no working procedure is active. The activities described in 🕮 *Chapter 5.8 Activities on the machine* can be performed safely.
	EMERGENCY STOP	The **EMERGENCY STOP** button does not light up. The machine stops all procedures and is disconnected from the power supply if you press the **EMERGENCY STOP** button. The **EMERGENCY STOP** button must be reactivated after actuation in order to resume work, 🕮 *Chapter 5.10, Emergency procedure.*

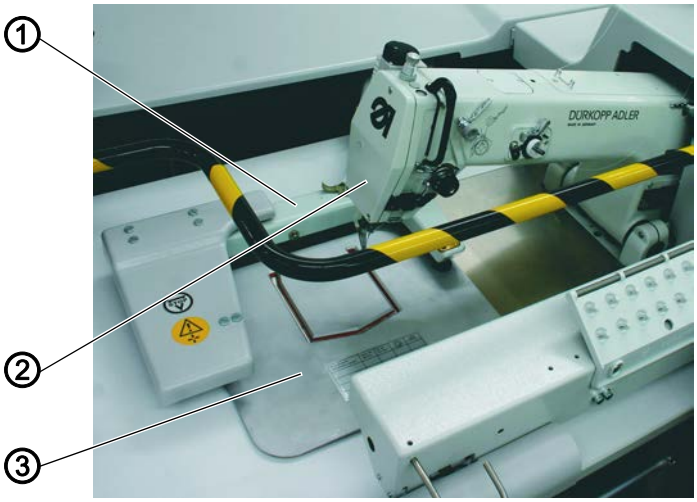
Buttons

The **buttons** and the **pedal** are used to operate the machine. A description of the function can be found in the table below in addition to the figure and designation of the buttons.

Button	Designation	Function
	Button 1	**Button 1** (on the left side): • starts a sewing cycle • activates the air suction for the basic part and pushes the middle slide into the front position • navigates stitch by stitch to the correct point after a needle thread breakage
	Button 2	**Button 2** (on the right side): • lowers the middle slide into the front position • raises the middle slide into the front position
	Pedal	**Pedal**: • activates the air suction for the basic part • moves the middle slide into the front position

3.1.3 Sewing unit

Fig. 5: Sewing unit



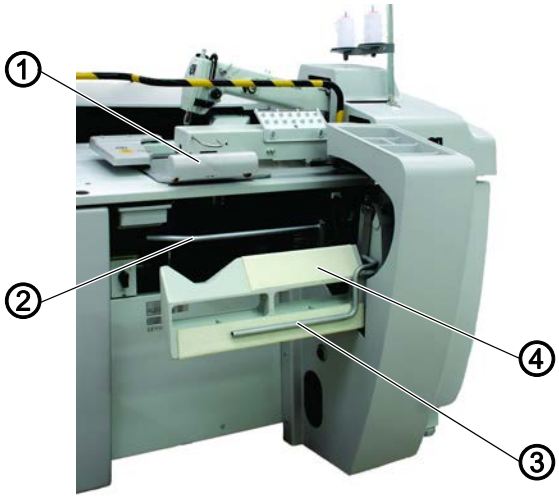
(1) - Transfer frame
(2) - Sewing head
(3) - Transfer plate

The transfer frame (1) of the sewing unit moves to the edge folding station. The fabric parts are transported from the edge folding station to the sewing unit by means of the transfer plate (3).

The sewing head (2) lowers, and the fabric parts are sewn together.

3.1.4 Stacker

Fig. 6: Stacker



(1) - Outfeed roller
(2) - Inner clamp bracket
(3) - Outer clamp bracket
(4) - Tray

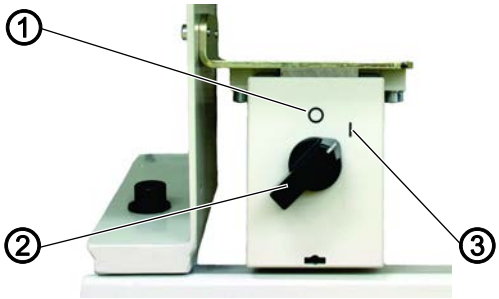
After sewing the fabric parts together, the machine stacks the product cleanly and tidily away.

The product is stacked by:

- Outfeed roller (1)
- Clamp bracket (2, 3)
- Tray (4)

3.1.5 Main switch

Fig. 7: Main switch



(1) - OFF
(2) - Rotary switch
(3) - ON

You can use the main switch to switch on the machine including the operating terminal.

Before switching off the machine with the main switch, you must first shut down the operating terminal.

3.2 Proper use

The machine may only be used with sewing material that satisfies the requirements of the specific application at hand.

The machine is intended only for use with dry sewing material. The sewing material must not contain any hard objects.

The needle thicknesses permissible for the machine are listed in the **Technical Data** (📖 *p. 15*) chapter.

The seam must be completed with a thread that satisfies the requirements of the specific application at hand.

The machine is intended for industrial use.

The machine may only be set up and operated in dry conditions on well-maintained premises. If the machine is operated on premises that are not dry and well-maintained, then further measures may be required which must be compatible with DIN EN 60204-31.

Only authorized persons may work on the machine.

Dürkopp Adler cannot be held liable for damages resulting from improper use.

WARNING

Risk of injury from live, moving and cutting parts as well as from sharp parts!

Improper use can result in electric shock, crushing, cutting and punctures.

Follow all instructions provided.

NOTICE

Non-observance will lead to property damage!

Improper use could result in damage to the machine.

Follow all instructions provided.

3.3 Declaration of Conformity

The machine complies with European regulations ensuring health, safety, and environmental protection as specified in the declaration of conformity or in the declaration of incorporation.

4 Operation

4.1 Preparing the machine for operation

- Changing the needle
- Threading the needle thread
- Winding the hook thread
- Replacing the hook thread bobbin
- Thread tension
  - Setting the needle thread tension
  - Setting the hook thread tension

4.2 Switching on the machine

The machine is switched on through the compressed air shut-off valve and the main switch, which are both located centrally under the sewing material support surface.

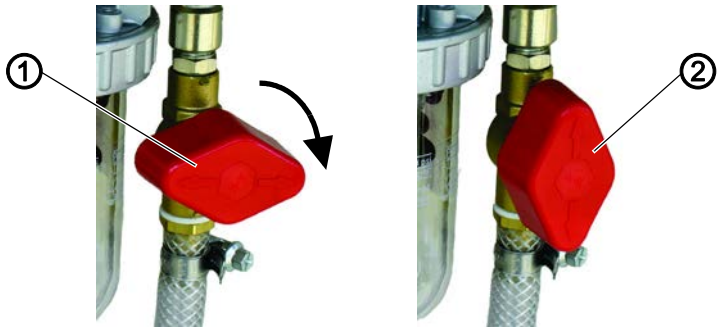
CAUTION

Risk of injury from moving parts!

Crushing.

NEVER reach into the area of moving parts.

Fig. 8: Switching on the machine (1)



(1) - Shut-off valve closed

(2) - Shut-off valve open

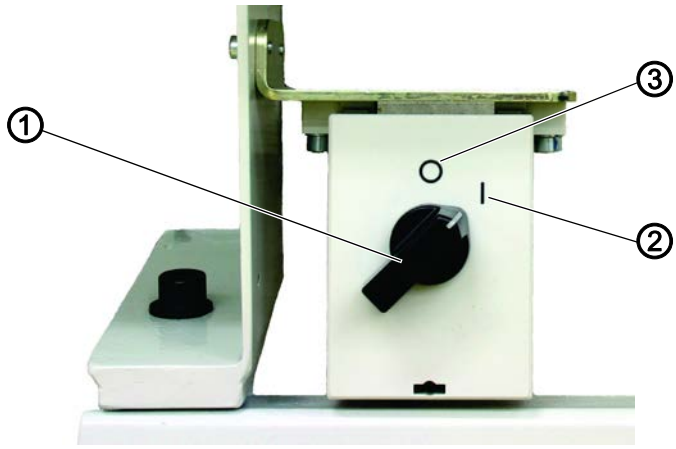
To switch on the machine:

1. Turn the closed shut-off valve (1) clockwise into the vertical position.

↳ The shut-off valve is open (2).

↳ Compressed air flows into the hoses.

Fig. 9: Switching on the machine (2)



(1) - Rotary switch
(2) - ON
(3) - OFF

2. Turn the main switch from the **0** position (1) to the right into the **I** position (2).

↳ The control for the machine starts up and clicks once.
Air flows in audibly.
The **safe stop** light lights up.
The operating terminal starts up, and the **Start screen** appears.

The operating terminal does not need to be switched on separately - it is activated through the power supply.

4.3 Changing the needle

CAUTION

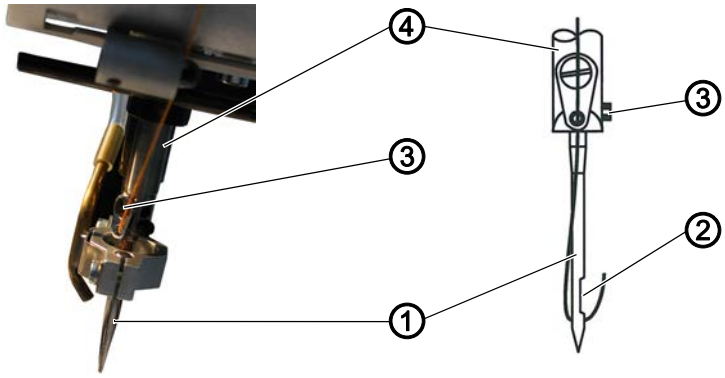
Risk of injury from sharp parts!

Puncture or cutting.

ONLY work on the machine if the safe stop light is lit up.

NEVER reach into the area of the middle slide, the needle or other sharp or sharp-edged parts.

Fig. 10: Changing the needle



(1) - Needle
(2) - Groove
(3) - Screw
(4) - Needle bar

To change the needle:

1. Press the **Stop** button.
   ↳ The machine comes to a **safe stop**.
   ↳ The **safe stop** light lights up.
2. Loosen the screw (3).
3. Pull the needle (1) downwards out of the needle bar (4).
4. Insert the new needle into the needle bar (4) until it reaches the end stop.
5. Align the groove (2) of the needle to the right.
6. Tighten the screw (3).

4.4 Threading the needle thread (806N-121)

CAUTION

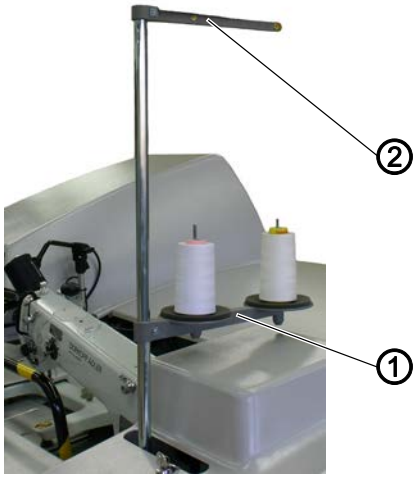
Risk of injury from sharp parts!

Puncture.

ONLY work on the machine if the safe stop light is lit up.

NEVER reach into the area of sharp or sharp-edged parts during operation.

Fig. 11: Threading the needle thread (806N-121) (1)

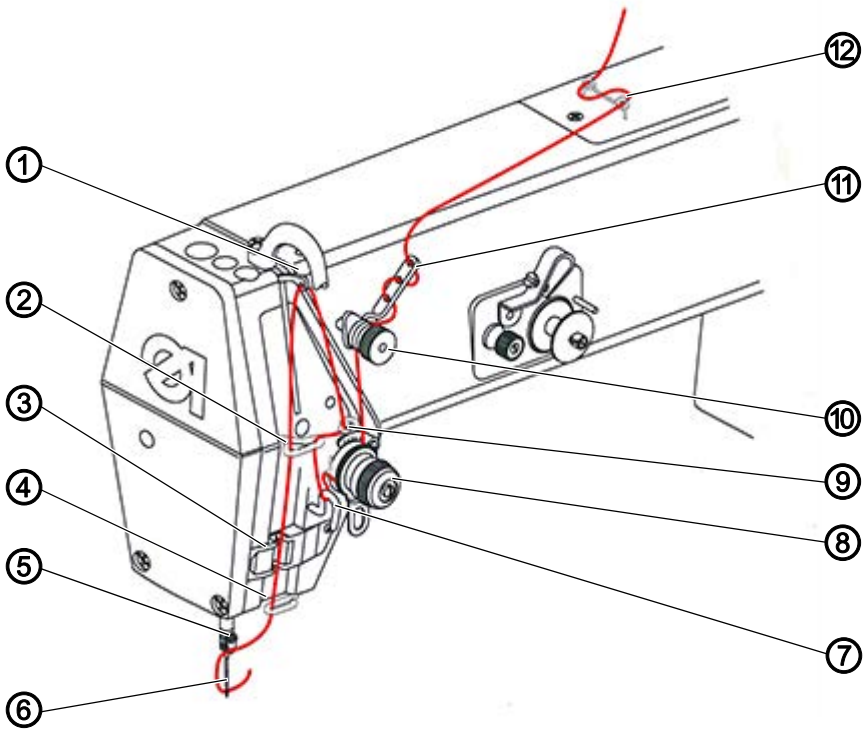


(1) - Thread reel holder *(2) - Thread guide*

To thread the needle thread:

1. Press the **Stop** button.
   - The machine comes to a **safe stop**.
   - The **safe stop** light lights up.
2. Fit the thread reel on the thread reel holder (1).
3. Insert the thread through the thread guide (2).

Fig. 12: Threading the needle thread (806N-121) (2)



(1) - Thread lever
(2) - Guide
(3) - Needle thread monitor
(4) - Guide
(5) - Guide
(6) - Needle eye
(7) - Guide
(8) - Main tensioner
(9) - Thread regulator
(10) - Pre-tensioner
(11) - Guide
(12) - Guide

4. Insert the thread from the right to the left through the rear part of the guide (12).
5. Insert the thread from the right to the left through the front part of the guide (12).
6. Feed the thread in a wavelike manner from the top through the guide (11).
7. Guide the thread counterclockwise around the pre-tensioner (10).
8. Guide the thread clockwise around the main tensioner (8).
9. Feed the thread under the guide (7).
10. Insert the thread through the guide (2).
11. Feed the thread through the thread regulator (9).
12. Feed the thread through the thread lever (1).
13. Insert the thread through the guide (2).
14. Feed the thread through the needle thread monitor (3).
15. Insert the thread through the guide (4).
16. Feed the thread through the guide (5) on the needle bar.
17. Feed the thread through the needle eye (6) from left to right.
18. Pull the thread approx. 5 cm further.

Information

If a thread is already threaded, it is easy to change to another thread of a different color or with different characteristics:

1. Cut off the old thread at the thread reel.
2. Tie the new thread to the old thread.
3. Pull the old thread out of the machine until the new thread reaches the needle.

4.5 Threading the needle thread (806N-111)

CAUTION

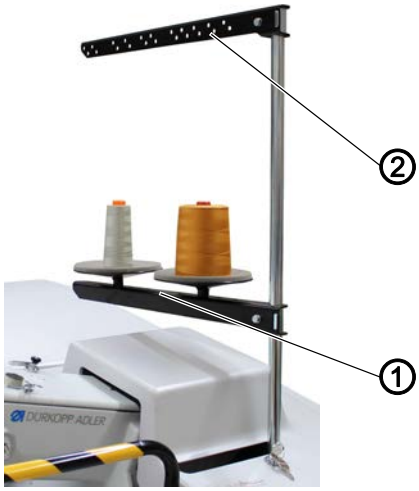
Risk of injury from sharp parts!

Puncture.

ONLY work on the machine if the safe stop light is lit up.

NEVER reach into the area of sharp or sharp-edged parts during operation.

Fig. 13: Threading the needle thread (806N-111) (1)

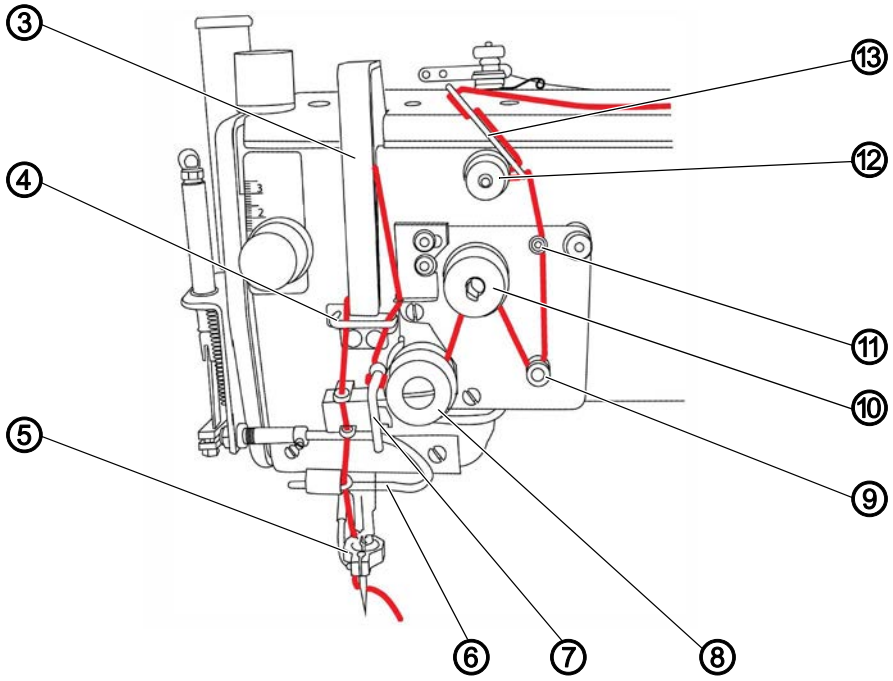


(1) - Thread reel holder *(2) - Thread guide*

To thread the needle thread:

1. Press the **Stop** button.
   - ↳ The machine comes to a **safe stop**.
   - ↳ The **safe stop** light lights up.
2. Fit the thread reel on the thread reel holder (1).
3. Insert the thread through the thread guide (2).

Fig. 14: Threading the needle thread (806N-111) (2)

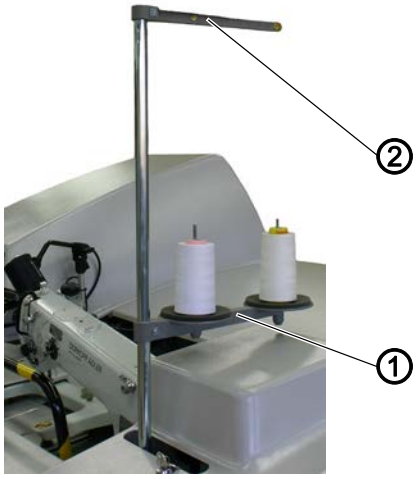


(3) - Thread lever
(4) - Guide
(5) - Guide
(6) - Guide
(7) - Guide
(8) - Thread tensioning spring
(9) - Bolt
(10) - Tensioner
(11) - Bolt
(12) - Bolt
(13) - Guide

4. Insert the thread from the right to the left through the upper hole of the guide (13).
5. Insert the thread from the left to the right through the 2nd upper hole of the guide (13).
6. Insert the thread from the right to the left through the lower hole of the guide (13).
7. Guide the thread clockwise once completely around the bolt (12).
8. Feed the thread along next to the bolt (11) on the right.
9. Guide the thread clockwise around the bolt (9).
10. Feed the thread counterclockwise around the tensioner (10).
11. Guide the thread clockwise around the thread tensioning spring (8).
12. Feed the thread under the guide (7).
13. Feed the thread through the thread guide (4) to the thread lever (3).
14. Insert the thread from the right to the left through the thread lever (3).
15. Insert the thread through the guide (4).
16. Insert the thread through the guide (6).
17. Insert the thread through the guide (5).
18. Insert the thread through the needle eye.
19. Pull the thread approx. 5 cm further.

4.6 Winding the hook thread (806N-121)

Fig. 15: Winding the bobbin thread (806N-121) (1)

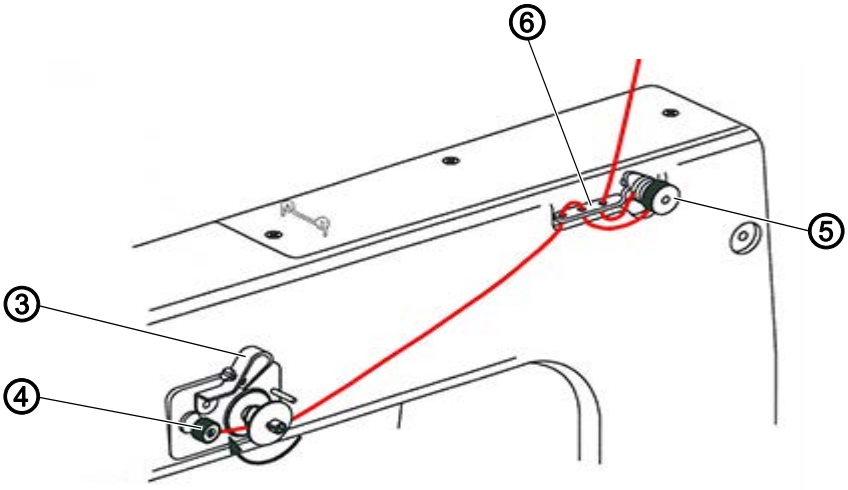


(1) - Thread reel holder
(2) - Thread guide

To wind the bobbin thread:

1. Press the **Stop** button.
   ↳ The machine comes to a **safe stop**.
   ↳ The **safe stop** light lights up.
2. Fit the thread reel on the thread reel holder (1).
3. Insert the thread through the thread guide (2).

Fig. 16: Winding the bobbin thread (806N-121) (2)



(3) - Winder lever
(4) - Cutting clamp
(5) - Tensioner
(6) - Guide

4. Fit an empty bobbin onto the pin below the winder lever (3).
5. Feed the thread from top to bottom through the right hole of the guide (6).
6. Feed the thread clockwise around the tensioner (5).

7. Feed the thread from bottom to top through the hole in the middle of the guide (6).
8. Feed the thread from top to bottom through the left hole of the guide (6).
9. Wind the thread several times clockwise around the bobbin.

↳ The thread is fastened to the bobbin.

10. Press the winder lever (3) against the bobbin.
11. Sew with the selected seam pattern.

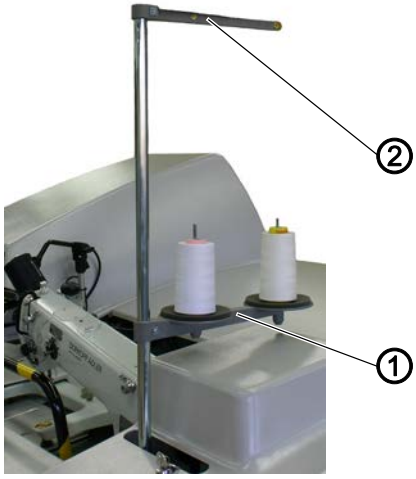
↳ The bobbin thread is wound on.

↳ Winding is automatically stopped by the winder lever (3) when the bobbin is full.

12. When the bobbin is full, cut the thread using the cutting clamp (4) and remove the bobbin.

4.7 Winding the hook thread (806N-111)

Fig. 17: Winding the bobbin thread (806N-111) (1)



(1) - Thread reel holder *(2) - Thread guide*

To wind the bobbin thread:

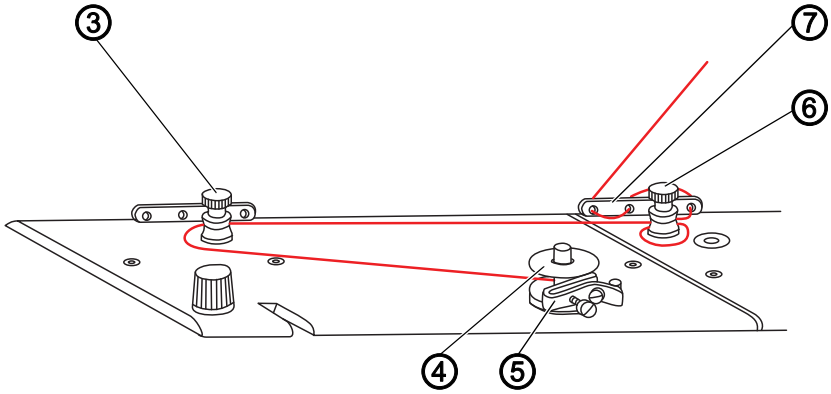
1. Press the **Stop** button.

↳ The machine comes to a **safe stop**.

↳ The **safe stop** light lights up.

2. Fit the thread reel on the thread reel holder (1).
3. Insert the thread through the thread guide (2).

Fig. 18: Winding the bobbin thread (806N-111) (2)



(3) - Bolt
(4) - Bobbin
(5) - Winder lever
(6) - Bolt
(7) - Guide

4. Insert the thread from the rear to the front through the left hole of the guide (7).
5. Feed the thread from the front to the rear through the hole in the middle of the guide (7).
6. Insert the thread from the rear to the front through the right hole of the guide (7).
7. Guide the thread counterclockwise once completely around the bolt (6).
8. Guide the thread counterclockwise around the bolt (1).
9. Wind the thread several times clockwise around the bobbin.

↳ The thread is fastened to the bobbin.

10. Press the winder lever (5) against the bobbin.
11. Sew with the selected seam pattern.

↳ The bobbin thread is wound on.

↳ Winding is automatically stopped by the winder lever (5) when the bobbin is full.

12. When the bobbin is full, cut the thread and remove the bobbin.

4.8 Changing the hook thread bobbin (806N-121)

Information

The number of stitches you can make with the hook thread depends on the type of thread and the sewing material.

For the procedure used to estimate the approximate capacity, see (📖 *p. 80*).

The hook thread bobbin is fitted under the sewing material support surface.

To change the hook thread bobbin:

1. Navigate to the user interface Bobbin menu (📖 *p. 80*).

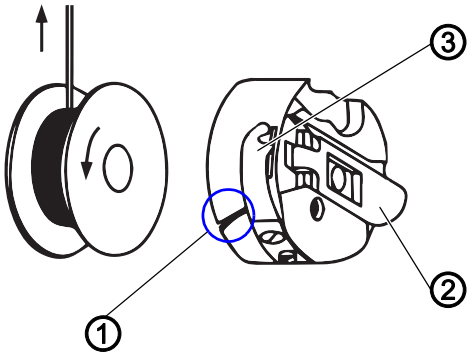
↳ The transfer carriage moves to the side.

2. Press the **Stop** button.

↳ The machine comes to a **safe stop**.

↳ The **safe stop** light lights up.

Fig. 19: Changing the hook thread bobbin (806N-121)



(1) - Slot
(2) - Bobbin case retainer
(3) - Spring

3. Grasp the bobbin capsule, which is located far to the rear and centrally under the sewing material support surface.
4. Lift the bobbin case retainer (2) on the bobbin capsule.

↳ The bobbin capsule is no longer locked in place and can be removed.

5. Remove the bobbin capsule from the hook.
6. Remove the empty bobbin from the bobbin capsule.
7. Press the full bobbin into the bobbin capsule.

Proper setting

Pulling the thread to the left causes the bobbin to rotate clockwise.

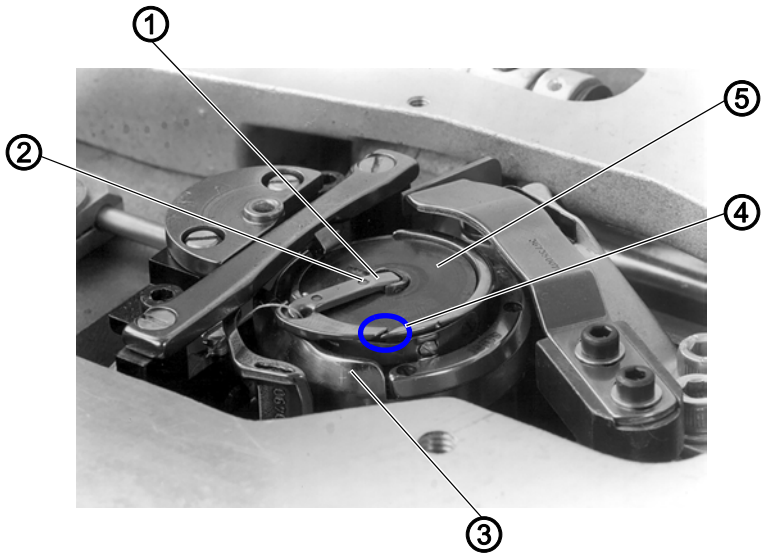
8. Pull out the thread approx. 5 cm.
9. Grasp the bobbin capsule by bobbin case retainer (2) and place it into the hook under the sewing material support surface.

↳ The bobbin capsule locks into place with a noticeable click.

10. Enter the number of stitches on the user interface **Bobbin menu**.
11. Adopt the number of stitches for the bobbin counter (📖 *p. 80*).

4.9 Changing the hook thread bobbin (806N-111)

Fig. 20: Changing the hook thread bobbin (806N-111)

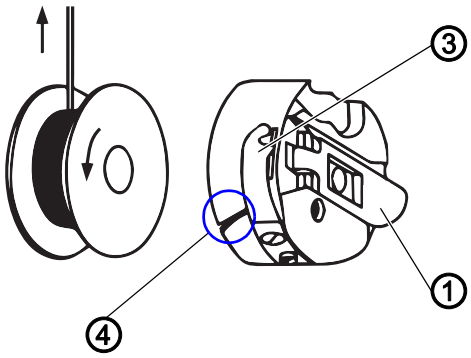


(1) - Bobbin case retainer
(2) - Hole
(3) - Spring
(4) - Slot
(5) - Bobbin

To change the hook thread bobbin:

1. Navigate to the user interface Bobbin menu (📖 *p. 80*).
↳ The transfer carriage moves to the side.
2. Press the **Stop** button.
↳ The machine comes to a **safe stop**.
↳ The **safe stop** light lights up.
3. Flip up the throat plate cover.
4. Fold up the bobbin case retainer (1).
5. Remove the hook thread bobbin (5).
6. Insert a new hook thread bobbin.

Fig. 21: Changing the hook thread bobbin II



(1) - Bobbin case retainer
(3) - Spring
(4) - Slot

Proper setting

The bobbin is correctly fitted in the bobbin capsule when pulling the thread to the left causes the bobbin to rotate clockwise.

7. Pull the thread through the slot (4) under the spring (3).
8. Close the bobbin case retainer (1).
9. Pull out the thread approx. 5 cm.
10. Grasp the bobbin capsule by the lever (2) and place it into the hook under the sewing material support surface.

↳ The bobbin capsule locks into place with a noticeable click.

11. Close the throat plate cover.
12. Enter the number of stitches on the user interface **Bobbin menu**.
13. Adopt the number of stitches for the bobbin counter (📖 *p. 80*).

4.10 Thread tension

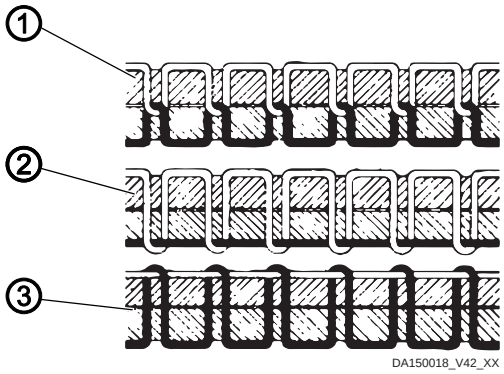
Together with the hook thread tension, the needle thread tension influences the final seam pattern.

The needle thread tension is defined by the pre-tensioner, the main tensioner and the additional tensioner.

Proper setting

If the tension of needle thread and hook thread is identical, the thread interlacing lies in the middle of the sewing material.
Set the needle thread tension so that the desired seam pattern is achieved with the lowest possible tension.

Fig. 22: Thread tension



(1) - Needle thread and hook thread tension are identical
(2) - Hook thread tension higher than needle thread tension
(3) - Needle thread tension higher than hook thread tension

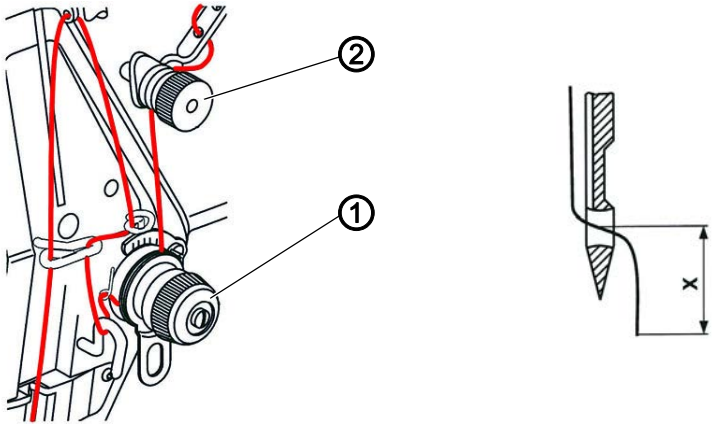
4.10.1 Setting the needle thread tension (806N-121)

Together with the hook thread tension, the needle thread tension influences the final seam pattern.

Set needle thread tension so that the desired seam pattern is achieved with the lowest possible tension.

Reliable operation of the thread cutter can also only be achieved with the lowest possible pretension.

Fig. 23: Setting the needle thread tension (806N-121)



(1) - Main tensioner
(2) - Pre-tensioner
***X**: Length of the needle thread end*

To set the needle thread tension:

1. Turn the pre-tensioner (2):
   - Turn clockwise: Increase tension
   - Turn counterclockwise: Reduce tension
2. Turn the main tensioner (1):
   - Turn clockwise: Increase tension
   - Turn counterclockwise: Reduce tension

Proper setting

Set the needle thread tension so that the desired seam pattern is achieved with the lowest possible tension.

After setting the tension, perform a sewing test and re-adjust the needle thread tension if the desired seam pattern has not been achieved.

Information

The pre-tensioner affects the length of the needle thread end (X):

- Turning the pre-tensioner clockwise: Reduces the length of the needle thread end
- Turning the pre-tensioner counterclockwise: Increases the length of the needle thread end

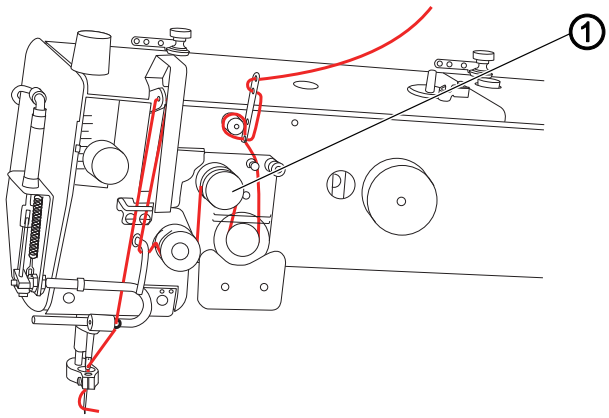
4.10.2 Setting the needle thread tension (806N-111)

Together with the hook thread tension, the needle thread tension influences the final seam pattern.

Set needle thread tension so that the desired seam pattern is achieved with the lowest possible tension.

Reliable operation of the thread cutter can also only be achieved with the lowest possible pretension.

Fig. 24: Setting the needle thread tension (806N-111)



(1) - Pre-tensioner

To set the needle thread tension:

1. Turn the tensioner (1):
   - Turn clockwise: Increase tension
   - Turn counterclockwise: Reduce tension

Proper setting

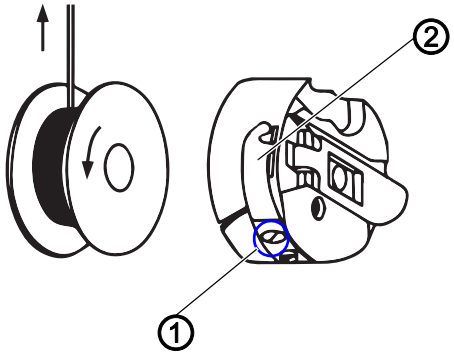
Set the needle thread tension so that the desired seam pattern is achieved with the lowest possible tension.

After setting the tension, perform a sewing test and re-adjust the needle thread tension if the desired seam pattern has not been achieved.

4.10.3 Setting the hook thread tension

Together with the needle thread tension, the hook thread tension influences the final seam pattern.

Fig. 25: Setting the hook thread tension



(1) - Screw *(2) - Spring*

To set the hook thread tension:

1. Navigate to the user interface Bobbin menu (📖 *p. 80*).

↳ The transfer carriage moves to the side.

2. Press the **Stop** button.

↳ The machine comes to a **safe stop**.

↳ The **safe stop** light lights up.

3. Remove the bobbin capsule (806N-121: 📖 *p. 32*, 806N-111: 📖 *p. 34*).
4. Check the hook thread tension by pulling on the hook thread
   - The thread can be pulled out easily: Hook thread tension too low
   - Thread trails: Hook thread tension too low
   - Thread is difficult to pull out: Hook thread tension too high
5. Turn the screw (1)
   - Turn screw (1) clockwise: Increase hook thread tension
   - Turn screw (1) counterclockwise: Reduce hook thread tension
6. Cut off the hook thread approx. 5 cm from the bobbin capsule.
7. Reinsert the hook thread bobbin
   (806N-121: 📖 *p. 32*, 806N-111: 📖 *p. 34*).

After setting the tension, perform a sewing test and re-adjust the hook thread tension if the desired seam pattern has not been achieved.

4.11 Setting the sewing foot

Information

The sewing foot is supposed to hold down the sewing material without clamping it.

If set too low, the sewing foot can cause ruffling on the seam.

If set too high, the sewing foot can cause skip stitches.

CAUTION

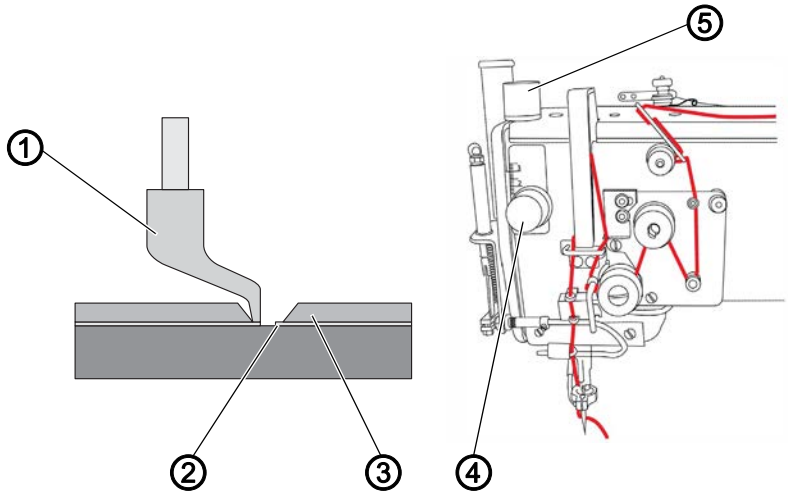
Risk of injury from sharp parts!

Puncture.

Machine is at a safe stop.

4.11.1 Setting the sewing foot height

Fig. 26: Setting the sewing foot height



(1) - Sewing foot
(2) - Plastic
(3) - Transfer plate
(4) - Adjusting wheel
(5) - Adjusting wheel

Information

The sewing foot (1) is supposed to lightly touch the plastic (2) of the transfer plate (3) when at the bottom dead center.

To set the height of the sewing foot:

1. Turn the adjusting wheel (4)
   - Raise sewing foot: turn counterclockwise
   - Lower sewing foot: turn clockwise

4.11.2 Setting the upper stroke position

Information

The sewing foot can be set to the upper stroke position when sewing thicker sewing material.

Sewing thicker sewing material requires that the seam program contain a corresponding entry.

The sewing foot (1) is supposed to lightly touch the plastic (2) of the transfer plate (3) when at the bottom dead center.

To set the upper stroke position:

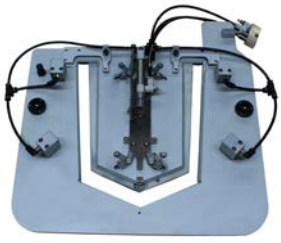
1. Turn the adjusting wheel (5):
   - Raise sewing foot: turn counterclockwise
   - Lower sewing foot: turn clockwise

4.12 Changing the shaping assembly

If you perform the basic settings via the software (📖 *p. 74*), the machine will identify the inserted shape in its reference run. In the selection window for the seam program, you will be able to see the numeric code for the shape and then initiate a change of shape (📖 *p. 85*).

A shaping assembly consists of the following components:

Component	Name and purpose
	Edge folding frame • consisting of an outer frame with inner frame, this component folds the pocket blank

Component	Name and purpose
	Middle slide • the pocket blank is placed here
 Front view	Hose insert (optional) • Keeps the pocket fold shape when the middle slide is withdrawn
 Front view 806N-121  Front view 806N-111	Transfer plate • holds the sewing material on the tabletop and feeds it to the sewing unit • a numeric code is applied to the rear of the metal lug, which the machine uses to detect which seam program is suitable for the transfer plate

CAUTION

Risk of injury from moving parts!

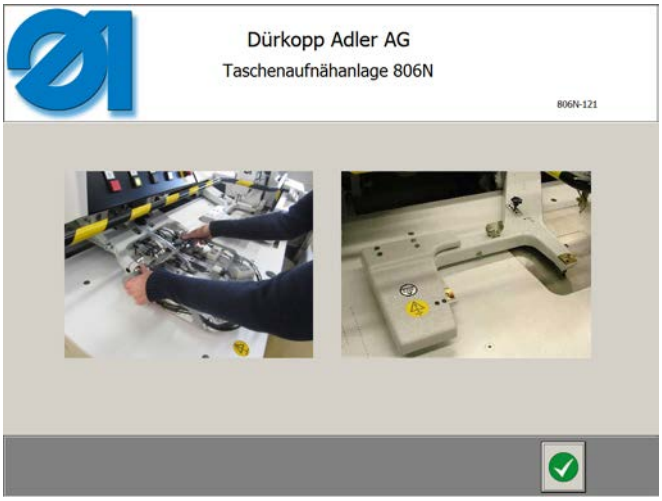
Crushing.

NEVER reach into the area of moving parts.

To change the shape:

1. Navigate to user interface 1 (📖 *p. 74*).
2. Press the **Change shape** button  .

Fig. 27: Changing the edge folding frame I

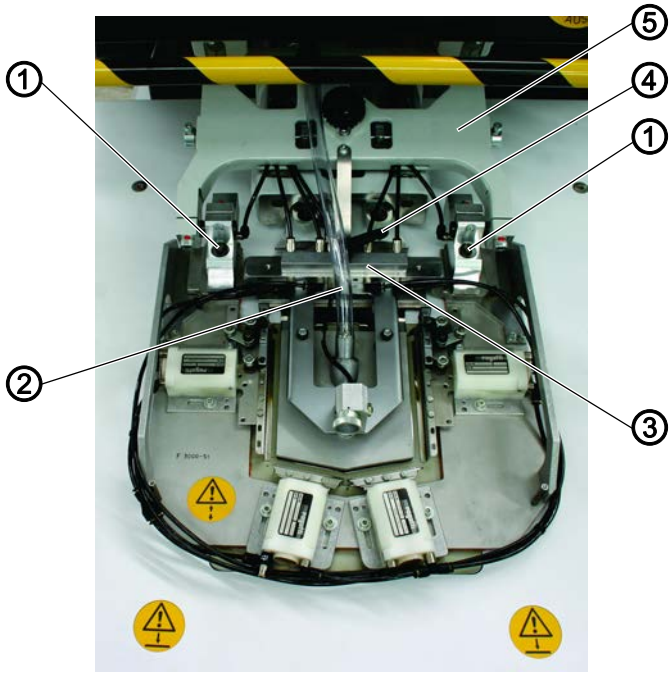


- The transfer plate moves to the initial position.
- Middle slide and edge folding frame are lowered towards the front at the bottom and become depressurized.
- The locking mechanisms are released.
- The **safe stop** light lights up.

4.12.1 Removing the shaping assembly

Removing the edge folding frame

Fig. 28: Removing the edge folding frame



(1) - Pin
(2) - Hose connecting piece
(3) - Coupling strip
(4) - Screw handle
(5) - Carriage

To remove the edge folding frame:

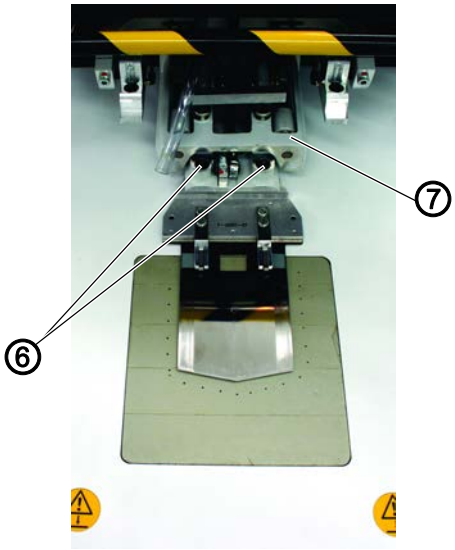
1. Pull off the hose from the hose connecting piece (2) in an upwards direction.
2. Unscrew the screw handle (4) to the left until the coupling strip (3) can be released from the edge folding frame.
3. Lift the coupling strip (3) off the edge folding frame.
4. Raise the carriage (5) on the rear right and left side.

↳ The pins (1) on the edge folding frame are exposed.

5. Pull out the edge folding frame towards the front.

Removing the middle slide

Fig. 29: Removing the middle slide



(6) - Pin *(7) - Carriage*

To remove the middle slide:

1. Remove the edge folding frame.

↳ The middle slide can now be easily reached.

2. Raise the carriage (7) to the rear such that the pins (6) on the middle slide are exposed.
3. Pull out the middle slide towards the front.

Removing the hose insert (optional)

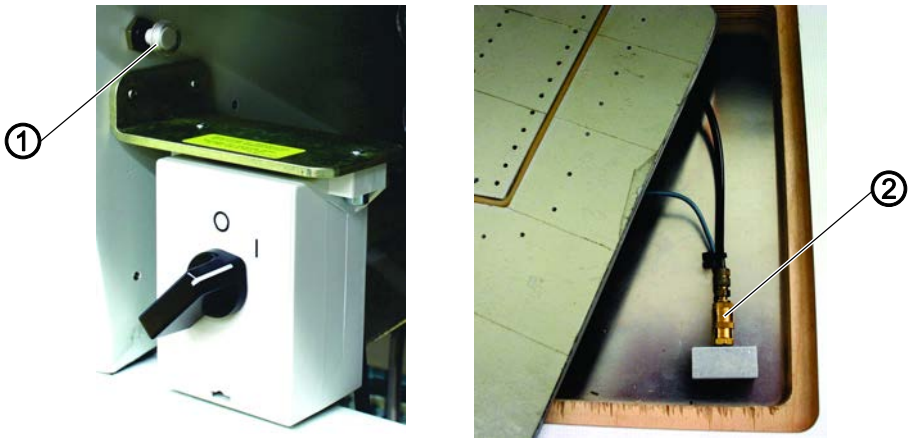
NOTICE

Property damage may occur!

The compressed air connection could become damaged through improper decoupling.

NEVER remove the compressed air connection by force.

Fig. 30: Removing the hose insert (optional)



(1) - Hand valve
(2) - Hose coupling

To remove the hose insert:

1. Press the hand valve (1) under the tabletop using your right hand and hold it there.

   ↳ The hose insert is pushed up on the left side.

2. Raise the hose insert using your left hand before releasing the hand valve (1).
3. Disconnect the hose insert from the compressed air connection. To do this, push the outer ring of the quick coupling to the rear.

   ↳ The compressed air connection is disconnected and the hose insert can be completely removed.

Removing the transfer plate

Fig. 31: Removing the transfer plate

(1) - left side of the transfer plate
(2) - right side of the transfer plate
(3) - Star screw

To remove the transfer plate:

1. Loosen the star screw (3).

2. Pull off the pneumatics.
3. Briefly and firmly press the right side of the transfer plate (2) until the connection is released.

↳ On the right side (2), the transfer plate is no longer connected to the transfer frame.

4. Briefly and firmly press the left side of the transfer plate (1) until the connection is released.

↳ On the left side (1), the transfer plate is no longer connected to the transfer frame.

↳ The transfer plate is no longer connected to the transfer frame.

5. Remove the transfer plate by pulling it out at the front so that it passes underneath the outfeed roller.

4.12.2 Inserting the shaping assembly

Insert the shaping assembly components in the order specified here. This is how you achieve a correctly inserted shaping assembly.

NOTICE

Property damage may occur!

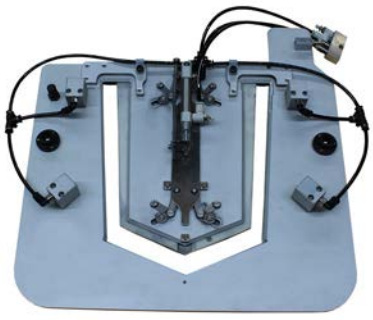
The machine can be damaged if the shaping assembly components are not inserted correctly.

Check that all components in the shaping assembly are securely fixed.

Correct the position of incorrectly inserted parts.

Inserting the transfer plate

Fig. 32: Inserting the transfer plate (1)



To insert the transfer plate:

1. Push through the transfer plate, with the metallic lug aligned upwards to the right, underneath the outfeed roller and place it underneath the transfer frame.

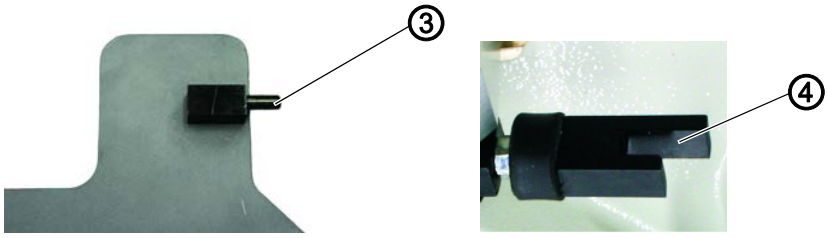
Fig. 33: Inserting the transfer plate (2)

(1)- Connecting piece on transfer frame *(2) - Connecting piece on the transfer plate*

2. Firmly press the connecting piece (2) on the right side of the transfer plate and the connecting piece (1) on the right side of the transfer frame into one another.

↳ They click into place, and the transfer plate is fixed on the right side.

Fig. 34: Inserting the transfer plate (3)



(3) - Peg on the transfer plate *(4) - forked plastic holder*

3. Place the peg (1) at the rear right of the transfer plate in the forked plastic holder (2) to the right, under the transfer frame.
4. Firmly press the connecting piece on the left side of the transfer plate and the connecting piece (1) on the left side of the transfer frame into one another.

↳ They click into place, and the transfer plate is connected to the transfer frame on both sides.

5. Move the transfer plate up and down.

↳ If the plate is wobbling noticeably, the peg is not fixed in the plastic holder.

↳ The transfer plate is correctly inserted if it is no longer wobbling. Carry out a test run.

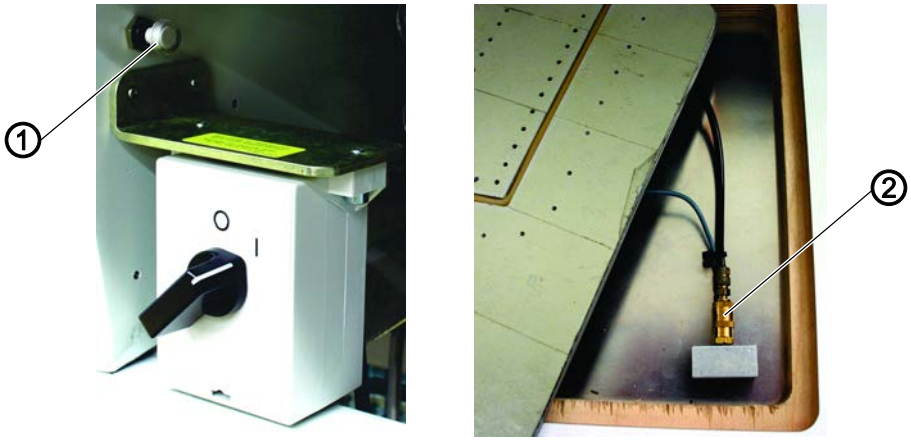
6. Use your right thumb or index finger at the rear right corner of the transfer frame to press the flexible plastic holder downwards until the peg (3) slides in.
7. Move the transfer plate up and down again to check.

↳ The transfer plate is correctly inserted if it is no longer wobbling.

8. Fit the pneumatics.
9. Tighten the star screw.

Inserting the hose insert (optional)

Fig. 35: Inserting the hose insert (optional)



(1) - Hand valve

(2) - Hose coupling

To insert the hose insert:

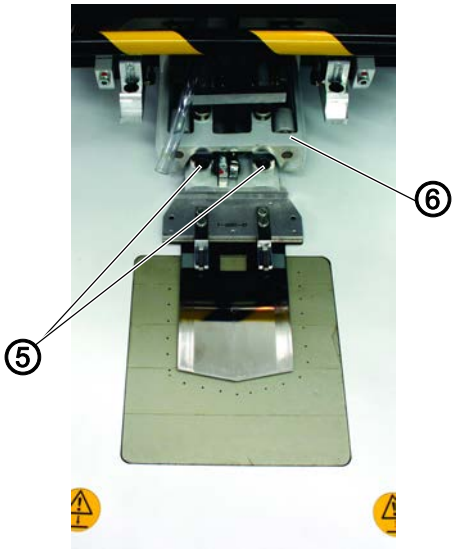
1. Align the hose insert such that the hole line is open and facing upwards.
2. Push the compressed air hose into the port for the quick coupling until it engages.

↳ The hose insert is now connected to the compressed air.

3. Insert the hose insert into the tabletop so that it is flush with it.

Inserting the middle slide

Fig. 36: Inserting the middle slide



(3) - Pin

(4) - Carriage

To insert the middle slide:

1. Insert the transfer plate.
2. Lift the carriage (6).
3. Place the middle slide underneath the carriage (6).

4. Insert the pins (5) on the middle slide into the front locating holes in the center of the carriage (6).
5. Firmly press the carriage (6) once onto the middle slide to ensure a proper connection.

Inserting the edge folding frame

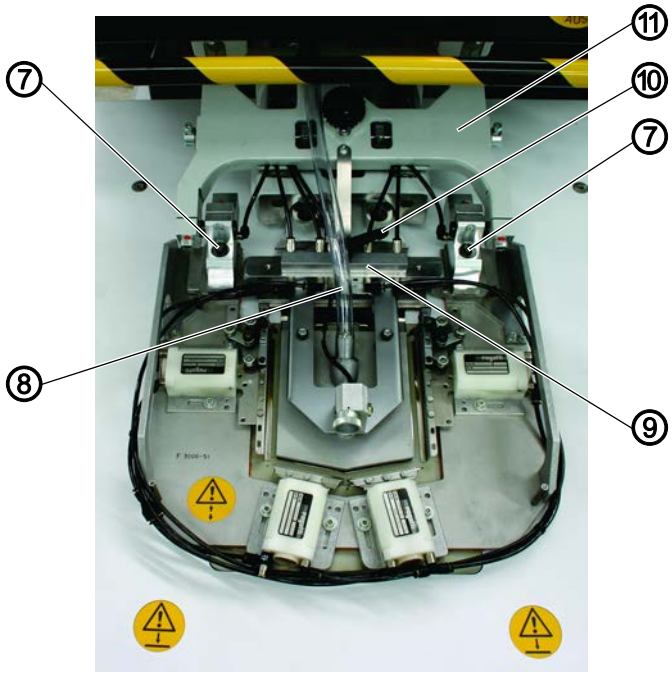
NOTICE

Property damage may occur!

The air hoses can be crushed during a shape change.

Remove hoses out of the area of the pins and the coupling strip.

Fig. 37: Inserting the edge folding frame



(5) - Pin
(6) - Hose connecting piece
(7) - Coupling strip
(8) - Screw handle
(9) - Carriage

To insert the edge folding frame:

1. Insert the transfer plate.
2. Insert the middle slide.
3. Lift the carriage (11).
4. Place the edge folding frame underneath the carriage (11).
5. Insert the pins (7) on the edge folding frame into the front locating holes on the right and left of the carriage (11).

6. Firmly press the carriage (11) once onto the edge folding frame to produce a proper connection.
7. Firmly push the hose onto the hose connecting piece (8) in the center.
8. Place the coupling strip (9) onto the horizontal hole strip.
9. Turn the screw handle (10) to the right until the coupling strip (9) is securely connected to the edge folding frame.

10. Press the Confirm button  .

↳ You will hear a short clicking sound.

↳ The parts in the edge folding station are secure and rigid again.

↳ The machine is at a **safe stop**.

↳ The **Start screen** is displayed on the control panel.

4.13 Performing a test run

You can perform the sewing cycle once, step-by-step, to check that everything is correctly fitted and adjusted.

To perform a step-by-step sewing cycle:

1. Navigate to user interface 1 (📖 *p. 74*).
2. Press the **Global parameters**  button on user interface 1.

↳ The display switches to user interface 2.

3. Press the **Work step by step** button  on user interface 2.

↳ The button is now highlighted in green. The button is also displayed on user interface 1.

4. Press **Button 1** to move one step forwards.
5. Press **Button 2** to move one step backwards.

↳ Each step is executed individually in this manner.

↳ You must deactivate the **Work step by step** button  on user interface 2 in order to return to a normal sewing cycle.

4.14 Sewing after a needle thread breakage

If the needle thread monitor indicates a needle thread breakage, the display shows an error message.

Sewing after a needle thread breakage

Fig. 38: Sewing after a needle thread breakage (1)

- The **Start** button flashes green.
- The machine enters the Safe stop mode.
- The sewing head is raised.

To sew after a needle thread breakage:

1. Thread needle thread (📖 *p. 26*).
2. Press the **Start** button.

- The Start button flashes green.
- Safe stop mode is switched off.
- The machine moves in front of the position where the needle thread broke and lowers the sewing head.
- The display shows a notice.

Fig. 39: Sewing after a needle thread breakage (2)

3. Press and hold button 1.

↳ The machine sews stitch by stitch.

4. Move stitch by stitch to the position where the needle thread broke.
5. Press the **Start** button.

↳ The sewing cycle is started anew.

↳ The seam is sewn to the end.

Canceling sewing after a needle thread breakage

To cancel sewing after a needle thread breakage:

1. Press the **Cancel** button.

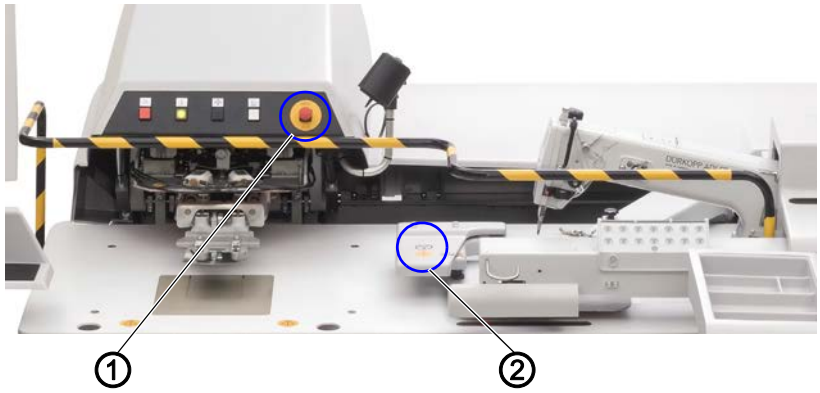
↳ The machine moves to the initial position.

2. Pull the sewing material a short distance out of the sewing area.
3. Cut the hook thread.
4. Completely remove the sewing material.

4.15 How to act in case of an emergency (EMERGENCY STOP)

4.15.1 Activating safety equipment

Fig. 40: Activating safety equipment (1)



(1) - EMERGENCY STOP button *(2) - EMERGENCY STOP in transfer frame*

Act as follows in the event of an emergency:

1. Firmly press the EMERGENCY STOP button.

OR

2. An EMERGENCY STOP is triggered automatically on the left side of the transfer frame if too much resistance is detected.

↳ The motors are immediately braked.

↳ The cylinders are depressurized.

↳ The sewing head stops in the current position.

↳ The operating terminal continues to be supplied with power.

↳ A message is displayed on the operating terminal.

Fig. 41: Activating safety equipment (2)

When the danger situation has passed and you can continue working, you need to deactivate the safety equipment first. The machine can only be operated normally after this has been performed.

4.15.2 Deactivating safety equipment

Deactivating the EMERGENCY STOP button

To deactivate the EMERGENCY STOP button:

1. Correct any disturbance or danger that may be present.
2. Turn the EMERGENCY STOP button counterclockwise until it jumps back to the initial position.

↳ The control for the machine starts up and clicks once.

↳ Air is audibly applied to the moving parts.

↳ The **safe stop** light lights up.

↳ The EMERGENCY STOP message is still displayed on the operating terminal.

3. Press the **Confirm** button to acknowledge the message.

↳ The **Start screen** is displayed on the operating terminal. The machine remains in the **Safe stop** mode.

4. Repeat the settings on user interface 1 and user interface 2 that were deleted by the EMERGENCY STOP.
5. Start a new sewing cycle (🕮 *p. 55*).

Deactivating EMERGENCY STOP in transfer frame

To deactivate the EMERGENCY STOP in the transfer frame:

1. Correct any disturbance or danger that may be present.
2. Pull the left side of the transfer frame to the left until it latches into the initial position with an audible click.

↳ The control for the machine starts up and clicks once.

↳ Air is applied to the moving parts. The **safe stop** light lights up.

↳ The EMERGENCY STOP message is still displayed on the operating terminal.

3. Press the **Confirm** button to acknowledge the message.

↳ The **Start screen** is displayed on the operating terminal. The machine remains in the **Safe stop** mode.

4. Repeat the settings on user interface 1 and user interface 2 that were deleted by the EMERGENCY STOP.

↳ Start a new sewing cycle (📖 *p. 55*).

4.16 Sewing (806N-111 and 806N-121)

Information

Before you can sew, you need to establish the basic settings using the operating software (📖 *p. 74*).

The sewing cycle comprises the following steps:

- Applying the basic part and pocket blank
- Edge folding (folding) the pocket blank
- Transfer of the sewing material
- Sewing the sewing material
- Rolling out and stacking of the sewing material

The user only has to carry out the first step. The other steps are run through by the 806N independently.

CAUTION

Risk of injury from sharp and moving objects!

Crushing, cutting and punctures.

NEVER reach into the area of moving parts.

ONLY work on the machine if the **safe stop** light is lit up.

NOTICE

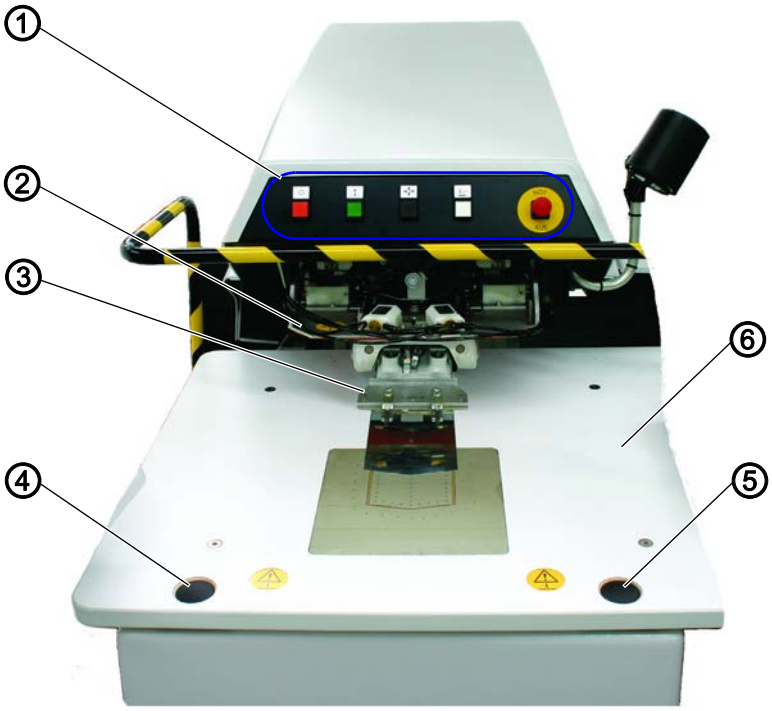
Property damage may occur!

Remnants of fabric and thread entering the machine can result in damage or defects.

Immediately remove any contamination during the sewing process.

Clean the machine daily.

Fig. 42: Sewing



(1) - Keypad
(2) - Edge folding frame
(3) - Middle slide
(4) - Button 1
(5) - Button 2
(6) - Sewing material support surface
(7) - Pedal (not shown)

To sew with the default settings:

1. Switch on the machine (📖 *p. 23*).
   - The Start button lights up green.
   - The middle slide is at the rear.
   - The touchscreen displays user interface 1.
2. Place the basic part onto the sewing material support surface (6) and align it.
3. Press button 1 (4).
   - The air suction is switched on, the basic part is fixed into place.
   - The middle slide (3) advances.
4. Place the pocket blank onto the middle slide (3) and align it.

OPTIONAL:

To align the pocket blank:

1. Press button 2 (5).
   - The middle slide (3) is lowered.
2. Align the material according to the sample.
3. Press button 2 (5).
   - The middle slide (3) is raised.

1. Press button 1 (4).

↳ The edge folding process starts.

↳ The sewing material is then fed to the sewing unit, sewn, and deposited on the stacker using the outfeed roller.

If the transfer of the sewing material to the sewing unit expires, then a new sewing cycle can commence.

A light signaling the machine's readiness for use is not available. If the machine is not yet ready, nothing will happen after a press on button 1 (4).

Information

A laser positioning aid for the 806N is available as additional equipment. It facilitates exact alignment on the sewing material support surface when the basic part is being applied.

4.17 Sewing (806N-521)

Information

Before you can sew, you need to establish the basic settings using the operating software (📖 *p. 74*).

The sewing cycle comprises the following steps:

- Applying the basic part, the pocket blank and the flap
- Edge folding (folding) the pocket blank
- Transfer of the sewing material
- Sewing the sewing material
- Rolling out and stacking of the sewing material

The user only has to carry out the first step. The other steps are run through by the 806N independently.

CAUTION

Risk of injury from sharp and moving objects!

Crushing, cutting and punctures.

NEVER reach into the area of moving parts.

ONLY work on the machine if the **safe stop** light is lit up.

NOTICE

Property damage may occur!

Remnants of fabric and thread entering the machine can result in damage or defects.

Immediately remove any contamination during the sewing process.

Clean the machine daily.

To sew with the default settings:

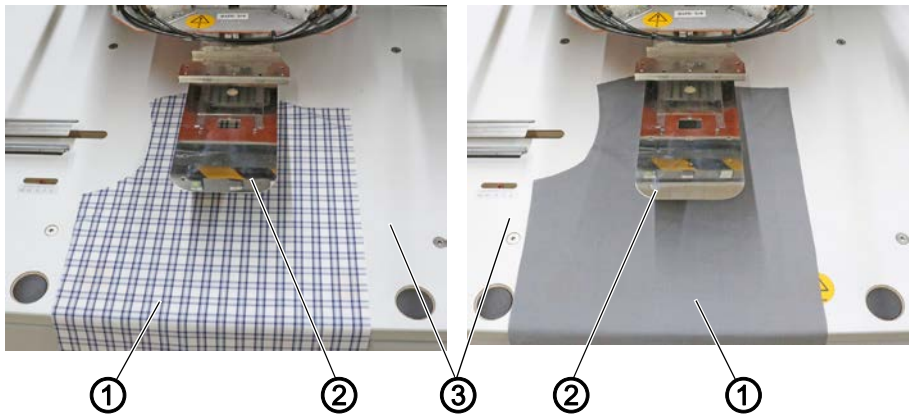
1. Switch on the machine (📖 *p. 23*).

↳ The Start button lights up green.

↳ The middle slide is at the rear.

↳ The touchscreen displays user interface 1.

Fig. 43: Sewing (806N-521) (1)



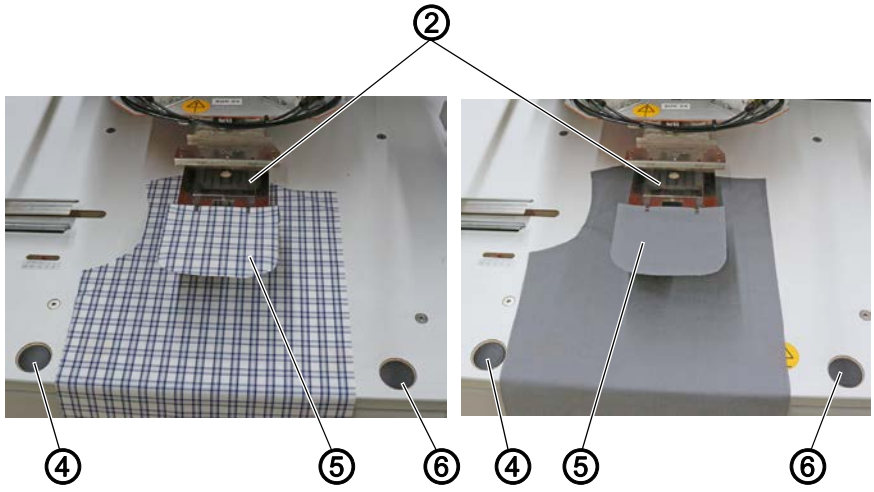
(1) - Basic part
(2) - Middle slide
(3) - Sewing material support surface

2. Place the basic part onto the sewing material support surface (6) and align it.
3. Press button 1 (4).

↳ The air suction is switched on, the basic part is fixed into place.

↳ The middle slide (2) advances.

Fig. 44: Sewing (806N-521) (2)



(2) - Middle slide
(4) - Button 1
(5) - Pocket blank
(6) - Button 2

4. Place the pocket blank (5) onto the middle slide (2) and align it.

OPTIONAL:

To align the pocket blank:

1. Press button 2 (6).

↳ The middle slide (2) is lowered.

2. Align the material according to the sample.

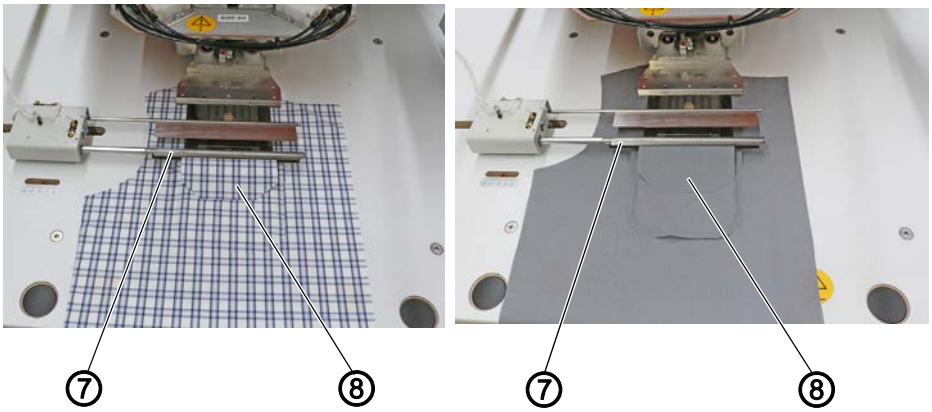
3. Press button 2 (6).

↳ The middle slide (2) is raised.

1. Press button 1 (4).

↳ The flap clamp moves to the right to the loading position.

Fig. 45: Sewing (806N-521) (3)



(7) - Flap clamp

(8) - Flap

2. Position the flap (8) in the flap clamp (7) and align it.
3. Press button 1 (4).

↳ The flap clamp (7) closes.

4. Press button 1 (4).

↳ The flap clamp (7) moves to the left, the folding device moves to the front.

↳ The edge folding process starts.

5. Press button 1 (4).

↳ The sewing material isfed to the sewing unit, sewn, and deposited on the stacker using the outfeed roller.

If the transfer of the sewing material to the sewing unit expires, then a new sewing cycle can commence.

A light signaling the machine's readiness for use is not available. If the machine is not yet ready, nothing will happen after a press on button 1 (4).

Information

A laser positioning aid for the 806N is available as additional equipment. It facilitates exact alignment on the sewing material support surface when the basic part is being applied.

4.18 Switching off the machine

NOTICE

Property damage may occur!

If the operating terminal is not shut down first, this could result in the malfunctioning or the destruction of the operating terminal.

ALWAYS shut down the operating terminal first.

Do not flip the main switch on the machine until you have shut down the operating terminal.

Shutting down the operating terminal

To shut down the operating terminal:

1. Press the **Exit** button on the **Start screen** .

↳ **Exit selection window** appears on the touchscreen.

Fig. 46: Shutting down the operating terminal

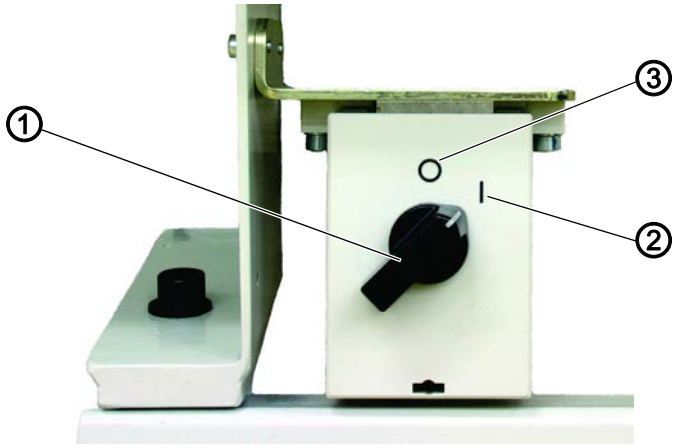
2. Press the **Shut down** button .

↳ The operating terminal shuts down. The screen becomes black.

↳ The LED light on the screen changes its color from green to orange.

Switching off the machine

Fig. 47: Switching off the machine (1)



(1) - Rotary switch
(2) - ON
(3) - OFF

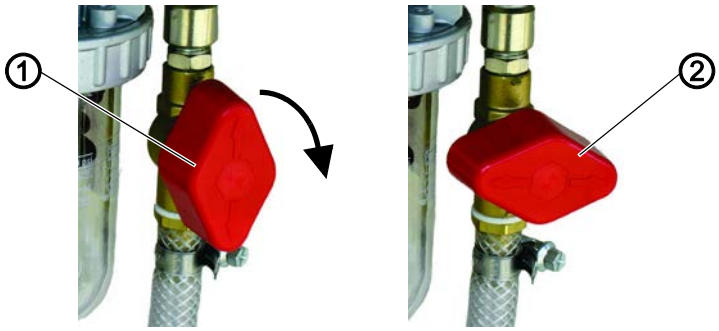
To switch off the machine:

1. Shut down the operating terminal.
2. Turn the rotary switch from position **I** (2) to position **0** (3).

↳ Residual compressed air escapes audibly.

↳ The middle slide, edge folding frame, and transfer plate are lowered slightly and become depressurized.

Fig. 48: Switching off the machine (2)



(1) - Shut-off valve open

(2) - Shut-off valve closed

3. Turn the shut-off valve to the right into the horizontal position (2).

Information

Fig. 49: Compressed air gun

After the shut-off valve is closed, the residual air may be vented using the compressed air gun. The compressed air gun is located under the tabletop.

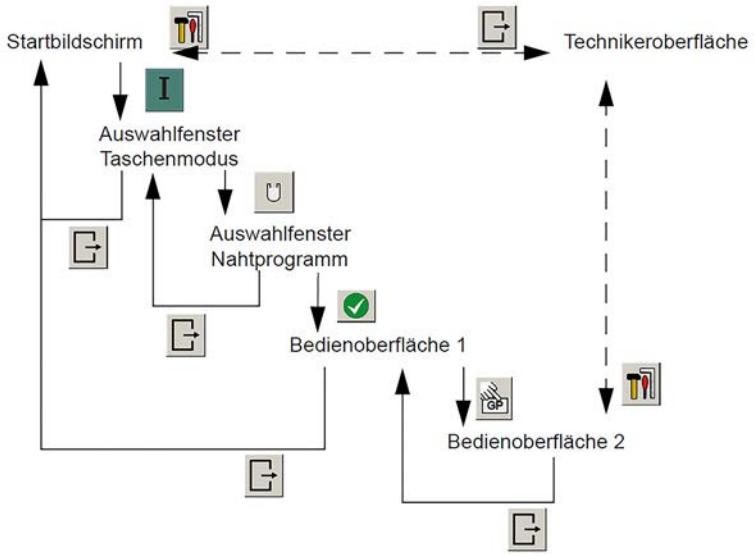
5 Programming

5.1 Structure of the software

The operating software is set up on different user interfaces. The structure ranges from the start screen to the technician's user interface.

Designation	Meaning in the work sequence
Start screen	Basic view of the operating software
Pocket mode selection window	These two selection windows are used to prepare the machine for sewing work, 📖 *p. 74*
Selection window Seam program	
User interface 1	The user mainly works on these user interfaces when sewing. Various machine settings can be made here.
User interface 2	
Technician's user interface	Password required, for technicians only, 📖 *Service Instructions*

Fig. 50: Structure of the software



An overview of the operating software is displayed in the figure.
The arrows indicate the navigation options between the user interfaces.

5.2 Functions of the software

The functions of the individual user interfaces are described in this section.

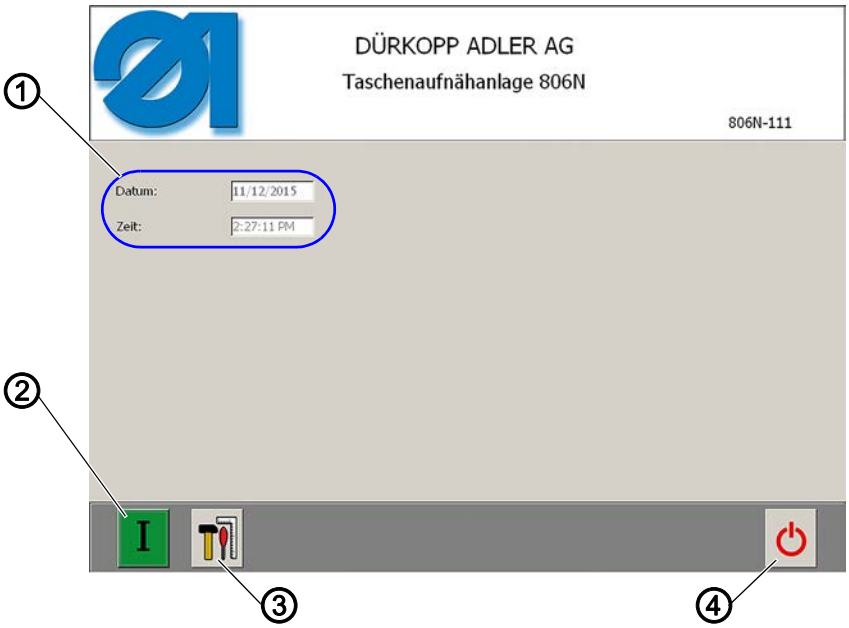
The technician's user interface is not included, since a password is required for access. The technician's user interface is described in the 🕮 *Service Instructions*.

5.2.1 Start screen

When you switch on the machine (🕮 *p. 23*), the start screen appears. On this user interface you can:

- Reference the machine (diagnostic run for reading the code of the transfer plate and finding the initial position) and, in this way, access the pocket mode selection window
- Access the technician's user interface by entering a password
- Exit the operating software or shut down the operating terminal (🕮 *p. 61*).

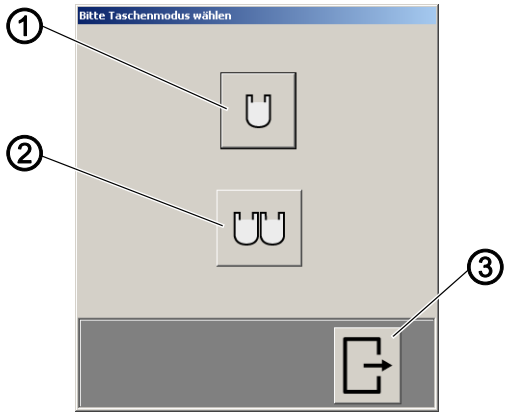
Fig. 51: Start screen



(1) - Display of date and time
(2) - Referencing the machine
(3) - Technician's user interface (with password)
(4) - Exit the operating software or terminal shut down

5.2.2 Pocket mode selection window

Fig. 52: Pocket mode selection window



(1) - Select 1-pocket mode
(2) - Select 2-pocket mode
(3) - Exit the Pocket mode selection window (go to Start screen)

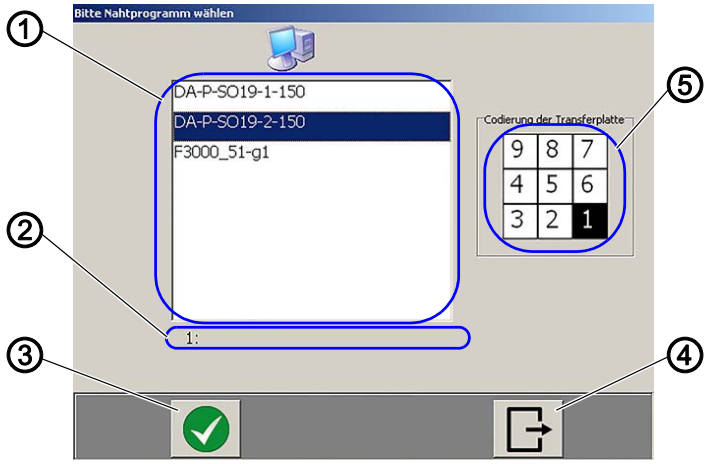
On the Start screen, you use the **Reference machine** button to access the selection window shown above after performing a successful reference run.

You can select the pocket mode here:

- Sew only the right or the left pocket (1)
- Sew the right and the left pocket alternately (2)

5.2.3 Seam program selection window

Fig. 53: Seam program selection window

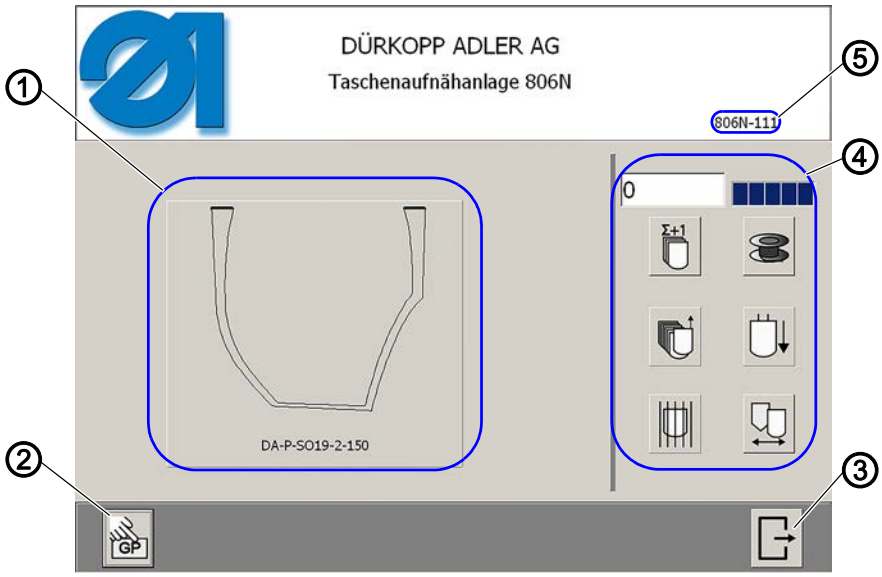


(1) - Selection of the pocket seam programs
(2) - Display the selected seam program
(3) - Confirm selection
(4) - Code for transfer plate identification
(5) - Exit selection (go to Pocket mode selection window)

You automatically go to this selection window by selecting a pocket mode. The identification code of the transfer plate is displayed here (4), see also (🕮 *p. 40*). All pocket seam programs (1) are listed correspondingly. You can select here the seam program to be used for sewing.

5.2.4 User interface 1

Fig. 54: User interface 1

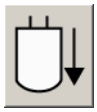
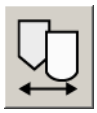


(1) - Display pocket seam configuration
(2) - Set global parameters (go to User interface 2)
(3) - Exit user interface 1 (go to Start screen)
(4) - Select setting options
(5) - Software version number

You go to this user interface by selecting the seam program. Here you can view the seam shape and how the pocket is to be sewed on and make various settings.

Setting options on user interface 1

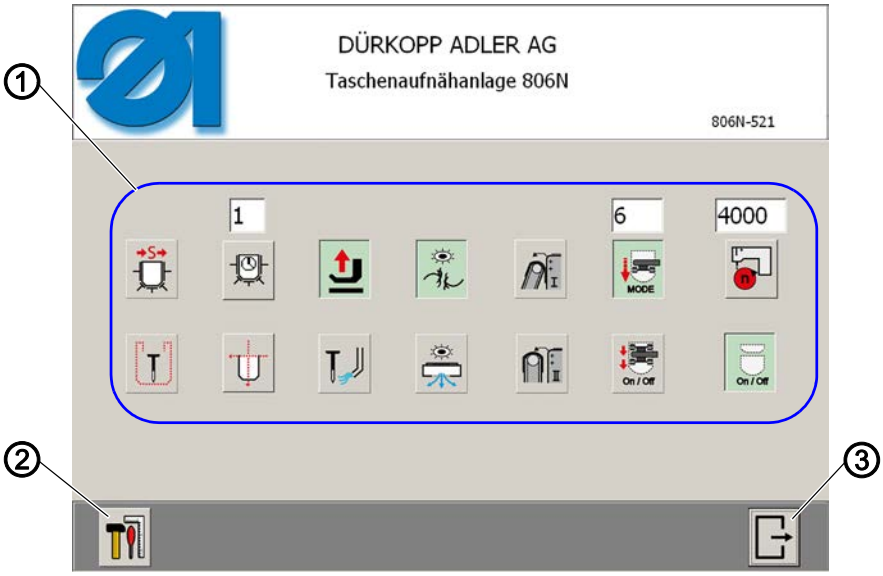
Button	Function
	Resetting the piece counter, 🕮 *p. 80*. The piece counter indicates the number of sewn-on pockets.
	Setting the bobbin counter, 🕮 *p. 80*. The bobbin counter indicates the amount of thread still on the bobbin and opens the bobbin change menu.
	Enabling bundle removal, 🕮 *p. 82*. Allows the finished sewn parts to be removed from the stacker.

Button	Function
	Automatically activating the middle slide at the front, 📖 *p. 83*. The middle slide immediately moves to the front position. It does not have to be brought to the front by button 1.
	Activating the alignment of strips, 📖 *p. 84*. After the edge folding process, the machine stops in order to check the alignment of the pocket blank.
	Initiating a change of shape, 📖 *p. 85*. The change of a shape assembly is initiated.

5.2.5 User interface 2

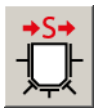
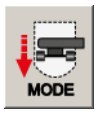
When on user interface 1, you use the **Global parameters** button  to access user interface 2.

Fig. 55: User interface 2



(1) - Select setting options
(2) - Technician's user interface (with password)
(3) - Exit user interface 2 (go to User interface 1)

Setting options on user interface 2

Button	Function
	Working step-by-step, 🕮 *p. 86* The machine advances only step by step, which is useful for sewing-in operations or a test run.
	Activating Sewing without edge folding, 🕮 *p. 87* To test if the sewing head settings are correct.
	Switching the stroke position on/off, 🕮 *p. 87* The stroke position is the clearance between the sewing foot and the sewing material support surface.
	Activating needle cooling, 🕮 *p. 88* Cools the needle, which is heated by the friction on the fabric. Standard equipment, which can be enhanced.
	Activating the needle thread monitor, 🕮 *p. 88* The needle thread monitor notices when the needle thread tears and issues a corresponding error message.
	Activating automatic air suction, 🕮 *p. 89* Additional equipment; air suction is automatically activated by a light barrier.
	Select/deselect stacker variant 1, 🕮 *p. 90* Selection of one of the two stacking variants.
	Select/deselect stacker variant 2, 🕮 *p. 90* Selection of one of the two stacking variants.
	Setting the outfeed roller path, 🕮 *p. 91* Distance the fabric is to be rolled out of the sewing area before it is ejected.
	Activating the advance roller, 🕮 *p. 93* Additional equipment, required for very short seam material, e. g. shorts.

Button	Function
	Adjusting the sewing motor speed, 📖 *p. 93* The speed of the sewing motor can be set between 100 and 4000 rpm.
	Attach flap (only 806N-521), 📖 *p. 94*

5.2.6 Exiting selection window

From the Start screen, you use the **Exit** button  to reach the Exit selection window.

Fig. 56: Exiting selection window

From the Exit selection window you can:

- Go to Windows desktop
- Shut down the operating terminal
- Return to the start screen

Selection options in the Exit selection window

Button	Objective	Function
	Desktop	You can use this button to go to the desktop of the PC. You need a password for this purpose.
	Shut down	You can use this button to shut down the operating terminal. The color of the LED status indicator switches from green to orange when the operating terminal is off.
	Exit	You can use this button to return to the **start screen** of the operating software.

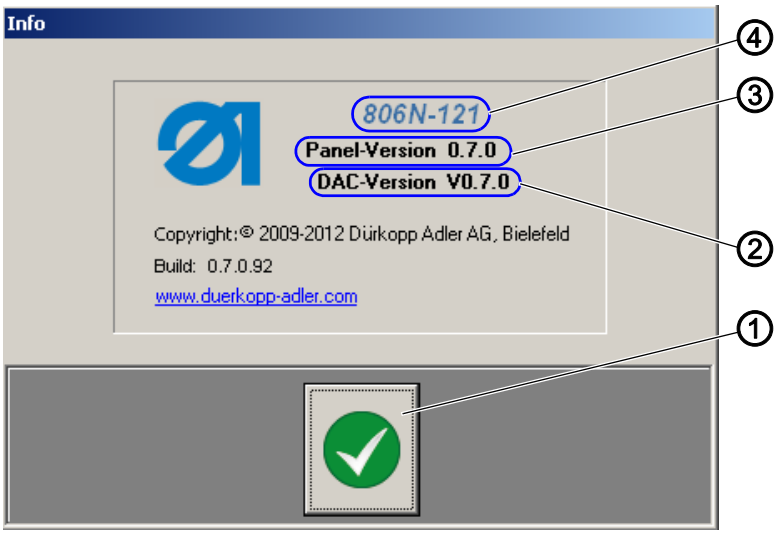
5.3 Operating software version

The operating software version is important for the technicians. It must be easy to find when requested.

User interface 1 (📖 *p. 68*) specifies the designation of the machine.

Pressing the designation displays the following window:

Fig. 57: Operating software version



(1) - Exit the Version window (go to User interface 1)
(2) - DAC software version
(3) - Operating terminal software version
(4) - Machine name

Information

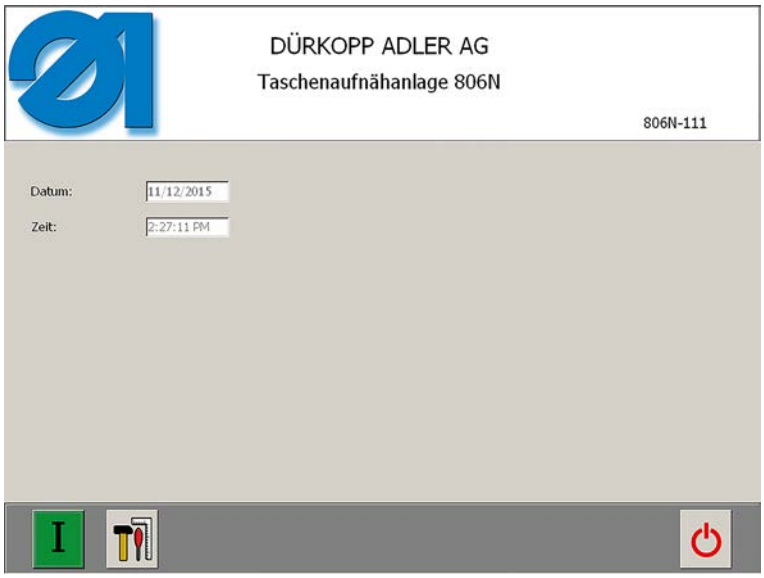
The version of the operating software is not accessible from the Start screen.

To access the version of the operating software, you need to navigate to user interface 1 (📖 *p. 68*).

5.4 Making the basic settings

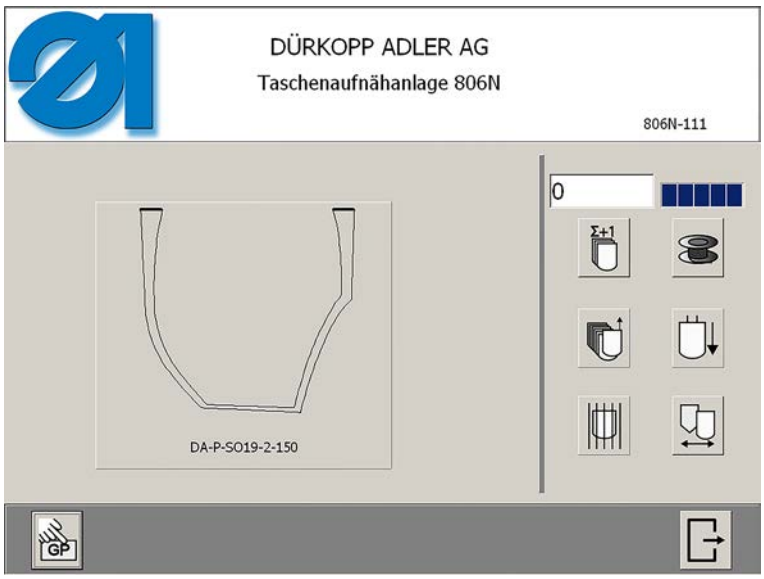
When you start the machine, the operating terminal will start up as well. You are shown the start screen.

Fig. 58: Making the basic settings



5.5 User interface 1

Fig. 59: User interface 1



Settings on user interface 1 can only be performed between two sewing cycles. The buttons are grayed-out and cannot be pressed when the machine is active. Activated buttons are highlighted in green.

To navigate to user interface 1:

1. At the bottom left of the start screen, press the **Reference machine** button.

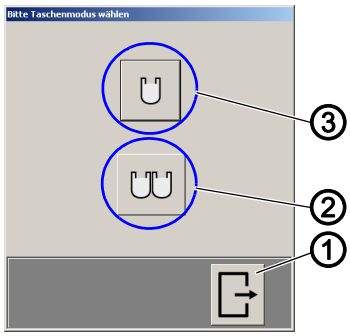
↳ The button changes and indicates that the machine is operating; the **Start** button is flashing in green.

↳ The machine scans the numeric code on the transfer plate in order to identify it. It then moves to the initial position.

↳ The Pocket mode selection window appears on the touchscreen.

5.5.1 Selecting a pocket mode

Fig. 60: Selecting a pocket mode



(1) - Exit
(2) - 2-pocket mode
(3) - 1-pocket mode

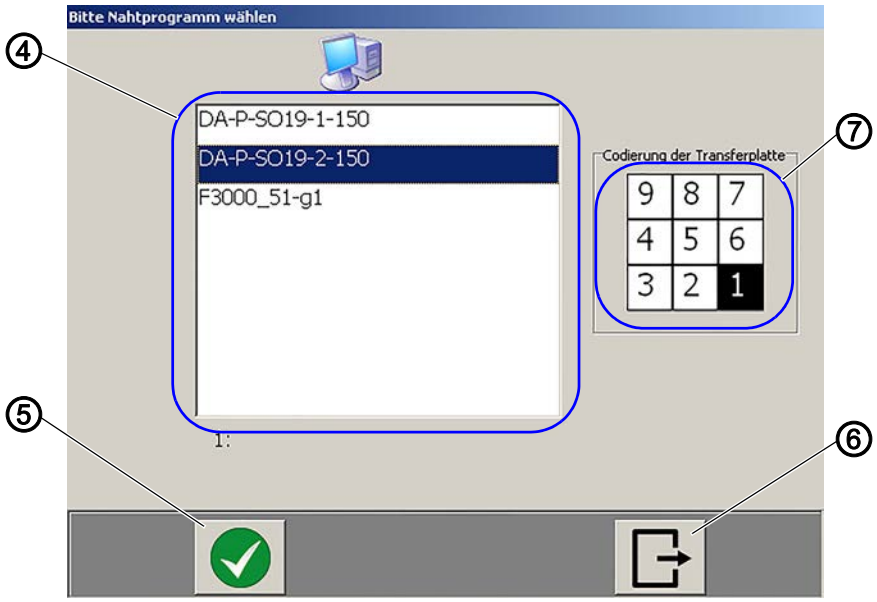
Selecting 1-pocket mode

To select the 1-pocket mode:

1. Press the **1-pocket mode** button (3).

↳ The Seam program **s**election window appears on the touchscreen.

Fig. 61: Selecting 1-pocket mode (1)

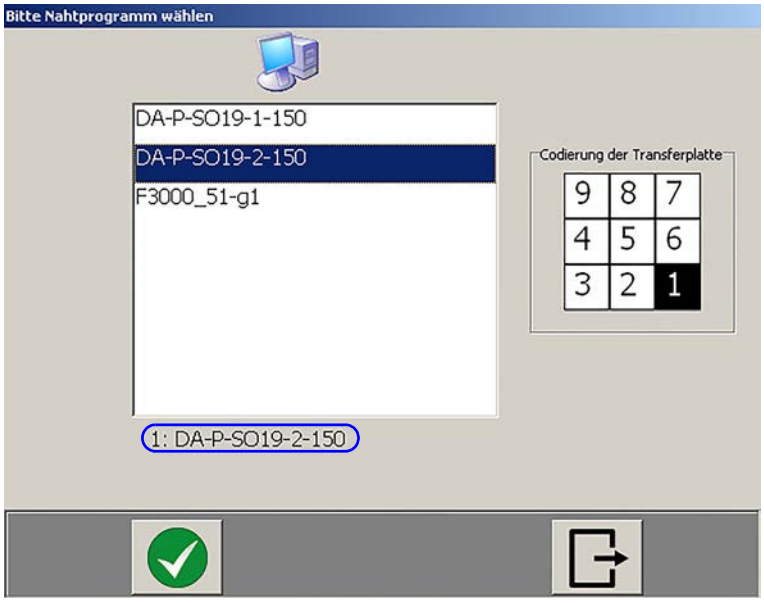


(4) - Available pocket seam programs
(5) - Confirm
(6) - Exit
(7) - Code of the transfer plate

↳ The **Start** button is flashing.

2. Select a pocket seam program from the list.

Fig. 62: Selecting 1-pocket mode (2)

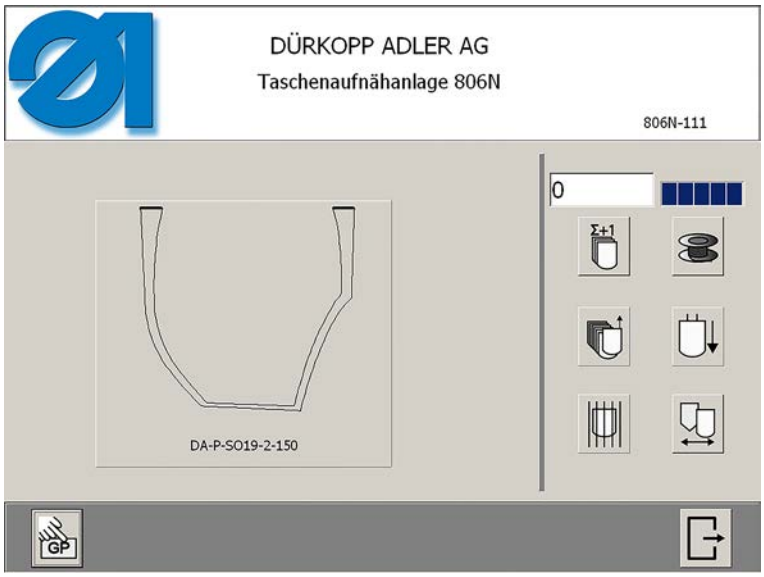


↳ The selected pocket seam program is highlighted in blue and appears in the selection field.

3. Press the Confirm button (5).

↳ The selected pocket seam program is loaded and appears on the user interface 1.

Fig. 63: Selecting 1-pocket mode (3)



- ↳ The **Start** button lights up green.
- ↳ The sewing process can be started (📖 *p. 55*).

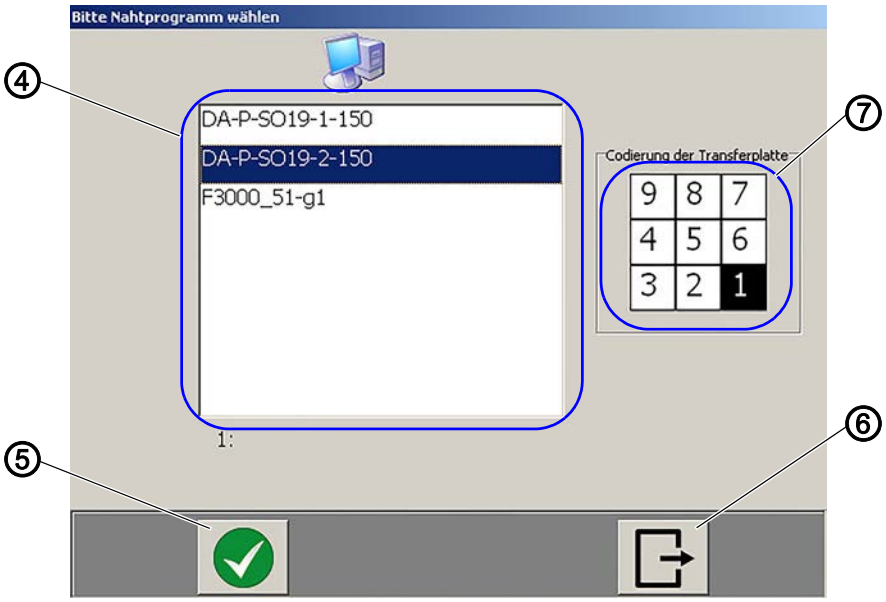
Selecting 2-pocket mode

In addition to the 1-pocket mode, the 806N can also operate in 2-pocket mode. The option to work in 2-pocket mode allows you to use different seam programs to alternately sew right and left pockets on a shirt or pair of trousers.

To select the 2-pocket mode:

1. Press the **2-pocket mode** button (2).
- ↳ The Seam program **s**election window appears on the touchscreen.

Fig. 64: Selecting 2-pocket mode (1)

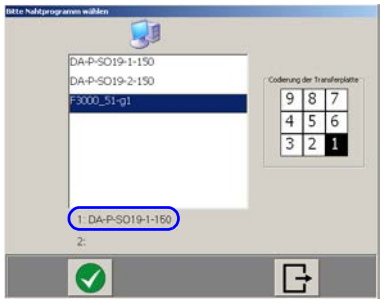


(8) - Available pocket seam programs
(9) - Confirm
(10) - Exit
(11) - Code of the transfer plate

↳ The **Start** button is flashing.

2. Select a pocket seam program for the left pocket from the list.

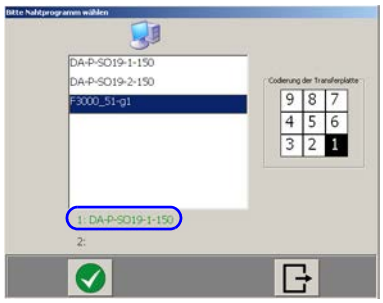
Fig. 65: Selecting 2-pocket mode (2)



↳ The selected pocket seam program is highlighted in blue and appears in the selection field.

3. Press the Confirm button (5).

Fig. 66: Selecting 2-pocket mode (3)

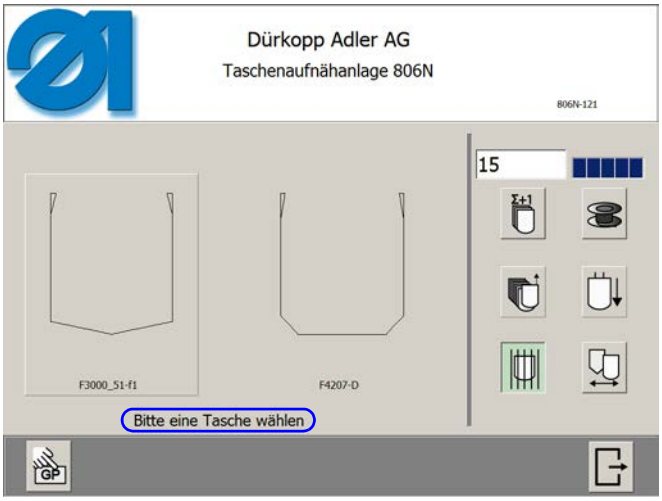


↳ The selected pocket seam program is displayed in green text under the selection field.

4. Select a pocket seam program for the right pocket from the list.
5. Press the Confirm button (5).

↳ The selected pocket seam programs are loaded and appear on the user interface 1.

Fig. 67: Selecting 2-pocket mode (4)



↳ The **Start** button lights up green.

↳ You are asked to specify the first pocket to be sewn in the next sewing cycle.

6. Select the first pocket to be sewn by pressing the desired pocket.

↳ The pocket is highlighted or framed.

7. To start the sewing process, press the **Start** button.

↳ The machine starts the sewing cycle.

↳ The machine switches back and forth between left pocket and right pocket.

To sew the non-highlighted pocket, select the pocket manually at the end of a sewing cycle.

5.5.2 Resetting the piece counter

The piece counter counts the number of sewn pockets or the number of sewing cycles performed. It can be reset at any time between two sewing cycles.

To reset the piece counter:

1. Press the **Reset piece counter** button.

↳ The piece counter is reset to "0".

↳ The piece counter starts counting again after the next sewing cycle.

5.5.3 Setting the bobbin counter

The bobbin counter indicates the amount of thread remaining on the bobbin. The menu for changing the bobbin is also displayed here.

Information

The capacity of the bobbin varies depending on the type of thread and material to be sewn.

The number of stitches to be entered must be estimated. Experience gained from sewing a given product will help you gradually approach a more accurate estimate of the capacity.

To navigate to the bobbin counter and bobbin change menu:

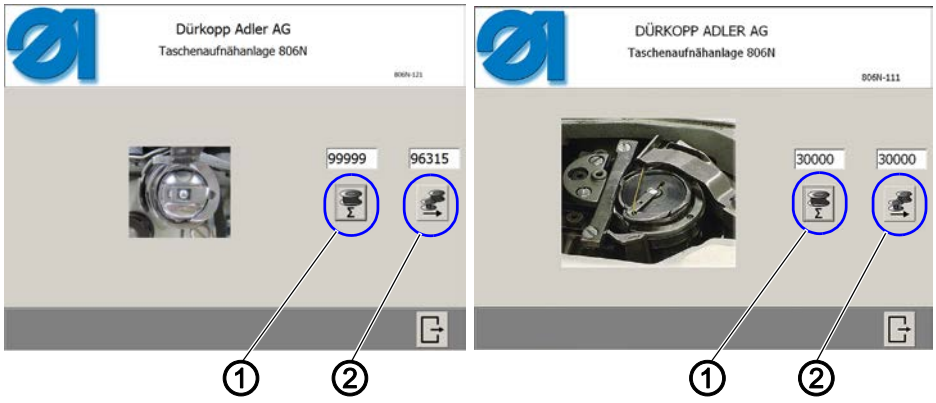
1. Press the **Set bobbin counter** button.

↳ The machine enters the Safe stop mode.

↳ The inner stacker bar opens.

↳ The display switches to the Bobbin menu.

Fig. 68: Setting the bobbin counter (1)



(1) - Number of stitches *(2) - Stitch counter*

Information

This Bobbin menu opens automatically when the stitch counter reaches **0**. The machine enters the Safe stop mode, and you have two possible courses of action:

- If the bobbin is not yet empty: Enter new number of stitches
- If the bobbin is empty: Change the bobbin (📖 *p. 32*)

To set the bobbin counter:

1. Press the **Number of stitches** button (1) .

Fig. 69: Setting the bobbin counter (2)

2. Press the numeric buttons to enter the number of stitches available on the bobbin.

↳ The entered value appears in the input field above.

Confirming your entry

To confirm your entry:

1. Press the Confirm button to confirm your entry.

↳ The input window closes.

↳ The entered value is displayed in the field above the **Number of stitches** button (1).

Correcting your entry

To correct your entry:

1. Press the **Exit** button to correct the entered value.

↳ The entered value is deleted.

Exiting the selection window:

To exit the selection window:

1. Press the **Exit** button again to exit the selection window.

↳ The selection window closes, and you are returned to the Bobbin menu screen.

Adopting the input value

To adopt the entered value:

1. Press the **Stitch counter** button (2) .

↳ The stitch counter adopts the entered stitch value.

2. Press the **Exit** button to exit the Bobbin menu screen.

↳ You are returned to user interface 1.

5.5.4 Enabling bundle removal

You must enable the bundle removal when you want to remove the sewn parts. The stacker opens and allows the parts to be removed.

To enable bundle removal:

1. Press the **Enable bundle removal** button .

↳ The button is highlighted in green.

↳ The stacker bar opens.

2. Remove the finished products.
3. Press the **Enable bundle removal** button again.

↳ The stacker bar closes.

↳ The button is no longer highlighted in green.

5.5.5 Activating middle slide automatically forward

The middle slide is at the front when a new sewing cycle begins.

Activating mode *Middle slide automatically forward*

To activate the mode *Middle slide automatically forward*:

1. Press the **Middle slide automatically forward** button .

↳ The button is highlighted in green.

↳ The mode *Middle slide automatically forward* is activated.

2. Press the **Middle slide automatically forward** button again to exit this mode.

↳ This exits the mode.

↳ The button is no longer highlighted in green.

This setting is deleted after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

Operating mode *Middle slide automatically forward*

CAUTION

Risk of injury from sharp parts!

Cutting.

Do NOT reach into the area of the middle slide.

To operate the mode *Middle slide automatically forward*:

1. Place the pocket blank on the middle slide.
2. Place and align the basic part on the edge folding station.
3. Fasten the basic part by pressing button 1 or the pedal.

↳ The air suction is now switched on.

4. Press button 1 to start the sewing process.

5.5.6 Activating the alignment of strips

After folding the pocket blank, the machine pulls the middle slide out of the pocket and stops. The alignment of the pocket blank can now be checked.

Activating the *Strip alignment* mode

To activate the *Strip alignment* mode:

1. Press the **Strip alignment** button .

↳ The button is highlighted in green.

↳ In the next sewing cycle, the machine stops after folding. The alignment of the pocket blank can be checked.

2. Press the **Strip alignment** button again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The machine no longer stops after folding in the next sewing cycle.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

Operating the *Strip alignment* mode

To operate the *Strip alignment* mode:

↳ The machine stops after folding. The finished folded pocket lies on the basic part.

1. Check the alignment of the pocket on the basic part.
2. If the alignment is correct: Press button 1.

↳ The sewing procedure is resumed.

OR

3. If the alignment is not correct: Press the **Cancel** button.

↳ The sewing procedure is canceled. The basic part and pocket must be placed again.

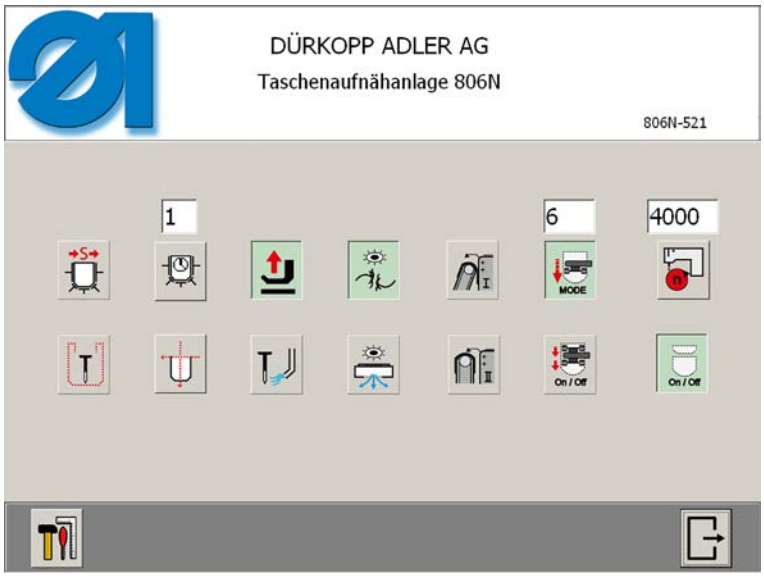
5.5.7 Initiating a change of shape

To initiate a change of shape:

1. Press the **Change shape** button .
2. Change the shaping assembly (📖 *p. 40*).

5.6 User interface 2

Fig. 70: User interface 2



Settings on user interface 2 can only be performed between two sewing cycles. User interface 2 cannot be accessed when the machine is active. Activated buttons are highlighted in green.

Some of the settings available on user interface 2 are additional equipment. These buttons are still present when the additional equipment is not present but are without function and do not change their appearance.

To navigate to user interface 2:

1. Navigate to user interface 1 (📖 *p. 74*).
2. Press the **Global parameters** button .

↳ You are returned to user interface 2.

5.6.1 Working step-by-step

The machine stops after each working sub-step. This setting is useful for checking modified machine settings.

Activating Work step-by-step mode

To activate the Work step-by-step mode:

1. Press the **Work step-by-step** button  .

↳ The button is highlighted in green.

↳ In the next sewing cycle the machine stops after the first working sub-step.

↳ The button is displayed on user interface 1.

2. Press the **Work step-by-step** button  again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The machine does not stop in the next sewing cycle.

Operating Work step-by-step mode

To operate the Work step-by-step mode:

1. Press Button 1 to move one step forwards.
2. Press Button 2 to move one step backwards.

↳ Each step is executed individually in this manner.

You must deactivate the **Work step by step** button  on user interface 2 in order to return to a normal sewing cycle.

This setting is deleted after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.2 Activating Sewing without edge folding

In the Sewing without edge folding mode the machine only sews – the folding procedure is not performed. This mode can be used, for instance, for testing a new seam program or performing a seam quality check.

The speed is also often reduced when using Sewing without edge folding mode. The speed must be reduced separately (📖 *p. 93*).

To activate Sewing without edge folding:

1. Press the **Sew without edge folding** button  .

↳ The button is highlighted in green.

↳ In the next sewing cycle the machine only sews and does not fold.

↳ The button is also displayed on user interface 1.

2. Press the **Sew without edge folding** button  again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The machine will resume folding in the next sewing cycle.

This setting is deleted after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.3 Switching the stroke position on/off

The stroke position is the clearance between the sewing foot and the ssewing material. This clearance should be set to the optimum value so that the sewing material is held on the sewing material support surface when the thread is tightened. This results in a high quality seam.

Stroke position OFF

The sewing foot always remains at the same distance above the sewing material. An adjustment to suit multi-layered material is not possible.

Stroke position ON

The sewing foot adjusts to suit the thickness of multi-layered sewing material. A prerequisite is that the necessary information for this is stored in the respective seam program (📖 *Instructions for use DA-CAD*)?

To switch the Stroke position on and off:

1. Press the **Stroke position** button  .

↳ The button is highlighted in green.

↳ When sewing, the machine automatically adjusts the stroke position according to the information in the seam program.

2. Press the **Stroke position** button  again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The stroke position is no longer adjusted when sewing and remains unchanged.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.4 Activating needle cooling

Information

The needle cooling can be enhanced with an optional extra package.

This system cools the air to provide better needle cooling.

The installation and operation of this system is described in 🕮 *Additional instructions for needle cooling*.

To activate needle cooling:

1. Press the **Needle cooling** button  .

↳ The button is highlighted in green.

↳ The needle is cooled with air in the next sewing cycle.

2. Press the **Needle cooling**  button again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The machine does not cool the needle in the next sewing cycle.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.5 Activating the needle thread monitor

The needle thread monitor signals an error when the needle thread tears.

To activate the needle thread monitor:

1. Press the **Needle thread monitor** button  .

↳ The button is highlighted in green.

↳ The following message is displayed if the needle thread tears during sewing:

Fig. 71: Activating the needle thread monitor

↳ If the needle thread tears, the needle thread needs to be threaded again (📖 *p. 26*), before sewing can resume(📖 *p. 51*).

2. Press the **Needle thread monitor** button again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ A needle thread breakage while sewing is NOT displayed.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.6 Activating automatic air suction

The automatic air suction is a piece of additional equipment that does not need to be additionally activated with button 1. It is automatically activated via a light barrier when this is interrupted by the seam material.

Information

The automatic air suction is better suited for use with heavy material. This allows the position to be corrected after fastening with the air suction. This is difficult with light material because it pulls out of shape when correcting the position under active air suction. A correctly sewn pocket is then no longer possible.

To activate the automatic air suction:

1. Press the **Automatic air suction** button  .

↳ The button is highlighted in green.

↳ The air suction is automatically activated by interruption of the light barrier when the basic part is laid in position.

2. Press the **Automatic air suction**  button again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The air suction is no longer automatically activated, even when a light barrier is installed.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.7 Selecting and deselecting stacker variants

The stacker cleanly stores the finished sewn products.

Information

The stackers are switched off by default when the machine is supplied.

Variant 1

In this variant the stack pivots towards the machine when stacking.

To activate stacker variant 1:

1. Press the button **Stacker 1**  .

↳ The button is highlighted in green.

↳ After the next sewing cycle the machine stores the finished sewn product using the stacker.

2. Press the **Stacker 1** button  again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ After the next sewing cycle the machine does not store the finished sewn product using the stacker.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

Variant 2

With this variant the stack remains in the original position during stacking. This variant is recommended when the material is very slippery. The static loading reduces the danger of the sewn products slipping down after stacking.

To activate stacker variant 2:

1. Press the button **Stacker 2**  .

↳ The button is highlighted in green.

↳ After the next sewing cycle the machine stores the finished sewn product using the stacker.

2. Press the **Stacker 2** button  again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ After the next sewing cycle the machine does not store the finished sewn product using the stacker.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.8 Setting the outfeed roller path

This allows you to set the path over which the finished sewn product is to be rolled before being ejected from the sewing area. Three outfeed roller variants can be set:

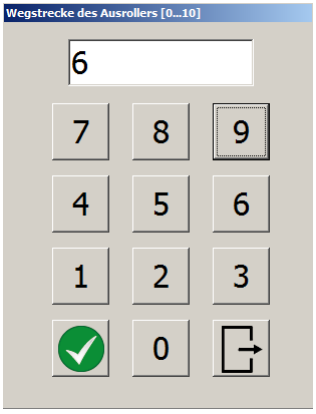
Value	Function
0	The outfeed roller is switched off and does not roll.
1	The outfeed roller is switched on and only rolls the finished sewn products for ejection from the sewing area.
2-10	The outfeed roller is switched on and first slowly rolls the finished sewn products a specific distance out of the sewing area. The outfeed roller then rolls the finished sewn products for ejection from the sewing area.

To set the outfeed roller path:

1. Press the **Outfeed roller path** button  .

↳ The selection window Outfeed roller path opens.

Fig. 72: Setting the outfeed roller path



2. Enter the roller path to be used for rolling out the finished sewn products by pressing the numeric buttons (0-10).

↳ The entered value appears in the input field above. With a value of 0 the button on user interface 2 is not highlighted in green. With values between 1-10 the button is highlighted in green.

Confirming your entry

To confirm your entry:

1. Press the Confirm button to confirm your entry.

↳ The input window closes.

↳ The entered value is displayed in the field above the **Outfeed roller path** button.

Correcting your entry

To correct your entry:

1. Press the **Exit** button to correct the entered value.

↳ The entered value is deleted.

Exiting the selection window:

To exit the selection window:

1. Press the **Exit** button again to exit the selection window.

↳ The selection window closes, and you are returned to user interface 2.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.9 Activating the advance roller

The advance roller is a piece of additional equipment. It is required when the sewn products are so short that the standard outfeed roller cannot reach them in the sewing area.

The advance roller path cannot be set. It rolls the finished product forward until it can be reached by the outfeed roller. This interplay is made possible through the use of a light barrier.

To activate the advance roller:

1. Press the **Advance roller** button  .

↳ The button is highlighted in green.

↳ In the next sewing cycle the advance roller transports the finished product to the outfeed roller.

2. Press the **Advance roller** button  again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The advance roller is no longer active in the next sewing cycle.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.10 Setting the sewing motor speed

The speed of the sewing motor can be set between 100 and 4000 rpm. A speed reduction is useful, for example, if you want to sew stepwise or without folding.

To set the sewing motor speed:

1. Press the **Motor speed** button  .

↳ The Motor speed selection window opens.

Fig. 73: Setting the sewing motor speed

2. Press the numeric buttons to enter the sewing motor speed (100-4000).

↳ The entered value appears in the input field above.

Confirming your entry

To confirm your entry:

1. Press the Confirm button to confirm your entry.

↳ The input window closes.

↳ The entered value is displayed in the field above the **Motor speed** button.

Correcting your entry

To correct your entry:

1. Press the **Exit** button to correct the entered value.

↳ The entered value is deleted.

Exiting the selection window:

To exit the selection window:

1. Press the **Exit** button again to exit the selection window.

↳ The selection window closes, and you are returned to user interface 2.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

5.6.11 Attach flap (only 806N-521)

To select the flap attach:

1. Press the **Flap attach** button .

↳ The button is highlighted in green.

↳ In the next sewing cycle the flap is attached.

2. Press the **Advance roller** button again to deactivate this mode.

↳ The button is no longer highlighted in green.

↳ The flat is not attached in the next sewing cycle.

This setting remains stored after switching off the machine, after loading a different seam program or after an EMERGENCY STOP.

6 Maintenance

This chapter describes maintenance work that needs to be carried out on a regular basis to extend the service life of the machine and achieve the desired seam quality.

Advanced maintenance work may only be carried out by qualified specialists (🕮 *Service Instruct*ions).

Work to be carried out	Operating hours			
	8	40	160	500
Removing lint and thread remnants	●			
Clean the oil pan	●			
Checking the oil level		●		
Topping up with oil		●		

6.1 Cleaning

WARNING

Risk of injury from flying particles!

Cleaning with compressed air can cause injuries to the eyes or respiratory organs.

NEVER blow particles towards other persons.

CAUTION

Risk of injury from sharp and moving objects!

Crushing or punctures.

ONLY maintain the sewing unit when it is switched off.

NOTICE

Property damage may occur!

Blowing remnants of fabric and thread under the covers can damage or destroy the machine motors.

NEVER blow remnants of fabric and thread under the covers, but rather forwards or to the side.

NOTICE

Property damage may occur!

If the throat plate is not lifted carefully the equipotential bonding connected to the plate can be damaged or ripped off.

ALWAYS lift the throat plate carefully.

Pay attention to the equipotential bonding when lifting.

To clean the machine:

1. Shut down the operating terminal (📖 *p. 61*).
2. Switch off the main switch.
3. Do not close the compressed air shut-off valve because compressed air for cleaning will then no longer be available.
4. Use the compressed air gun to blow off sewing dust and thread remnants forwards or to the side.

Points that need to be cleaned particularly thoroughly:

- Sewing material support surface
- Bobbin area
- Hook and surrounding area
- Thread cutter

5. Clean the oil pan with a cloth.

6.2 Lubricating (806N-121)

WARNING

Risk of injury from contact with oil!

Contact with oil can cause irritation, rashes, allergies or skin injuries.

ALWAYS avoid long-term contact with oil.

ALWAYS thoroughly wash the affected areas if skin contact with oil occurs.

CAUTION

Risk of environmental damage from old oil!

Incorrect handling of old oil can result in severe environmental damage.

ALWAYS observe the legally prescribed regulations for handling and disposal of mineral oil.

Take care to ensure that oil is NEVER spilled.

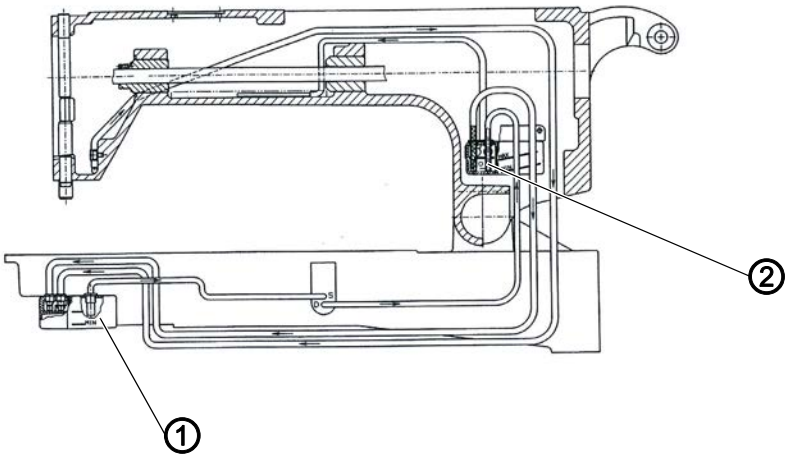
For lubricating the machine, use only lubricating oil DA 10 or oil of equivalent quality with the following specifications:

- Viscosity at 40° C: 10 mm^2/s
- Flash point: 150° C

DA 10 can be obtained from DÜRKOPP ADLER sales offices using the following part number:

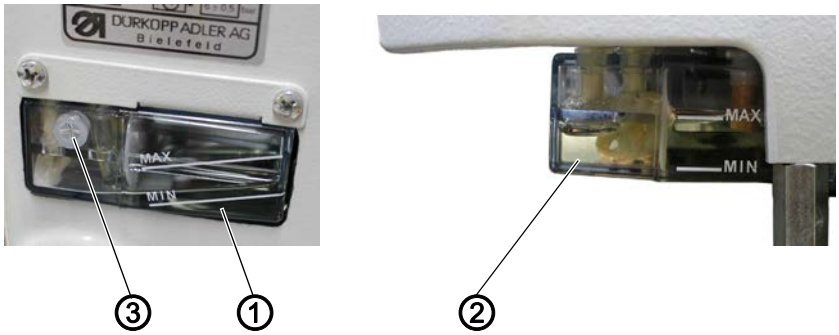
Container	Part number
250 ml	9047 000011
1 l	9047 000012
2 l	9047 000013
5 l	9047 000014

Fig. 74: Lubricating (806N-121) (1)



(1) - Oil reservoir 1
(2) - Oil reservoir 2

Fig. 75: Lubricating (806N-121) (2)



(1) - Oil reservoir 1
(2) - Oil reservoir 2
(3) - Oil filling neck

Oil reservoir 1 (1) supplies oil to the sewing machine head. Oil flows from oil reservoir 2 (2) to the hook oil reservoir via a wick connection.

Oil exceeding the MAX marking in oil reservoir 2 (2) is fed back into the oil reservoir 1 (1) by a pump.

Checking the oil level

To check the oil level:

1. Check the oil level in oil reservoir 1 (1).

↳ The oil level must be between the MIN marking and the MAX marking.

2. If the oil level is below the MIN marking, check the oil level at oil reservoir 2 (2).

↳ Do not top up oil if the oil level in oil reservoir 2 (2) is above the MAX marking. Instead, complete 20 sewing cycles before checking the oil level again.

3. You need to top up oil if the oil level in oil reservoir 2 (2) is at the MIN marking

Topping up with oil

To top up with oil:

1. Top up the oil via the oil filling neck (3) on oil reservoir 1 (1) until the MAX marking is reached.
2. Check the oil supply in oil reservoir 1 (1).

↳ Bubbles must be visible when the machine is running.

6.3 Lubricating (806N-111)

WARNING

Risk of injury from contact with oil!

Contact with oil can cause irritation, rashes, allergies or skin injuries.

ALWAYS avoid long-term contact with oil.

ALWAYS thoroughly wash the affected areas if skin contact with oil occurs.

CAUTION

Risk of environmental damage from old oil!

Incorrect handling of old oil can result in severe environmental damage.

ALWAYS observe the legally prescribed regulations for handling and disposal of mineral oil.

Take care to ensure that oil is NEVER spilled.

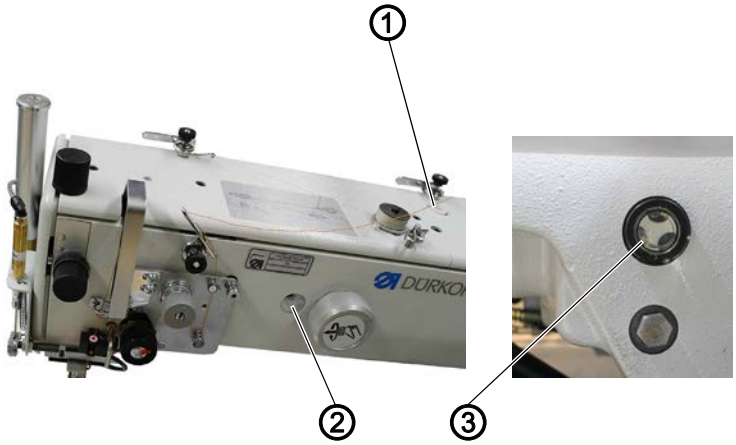
For lubricating the machine, use only lubricating oil DA 10 or oil of equivalent quality with the following specifications:

- Viscosity at 40° C: 10 mm^2/s
- Flash point: 150° C

DA 10 can be obtained from DÜRKOPP ADLER sales offices using the following part number:

Container	Part number
250 ml	9047 000011
1 l	9047 000012
2 l	9047 000013
5 l	9047 000014

Fig. 76: Lubricating (806N-111)



(1) - Oil filling neck
(2) - Inspection glass
(3) - Inspection glass

Checking the oil level

To check the oil level:

1. Check the oil level at the inspection glass (3).

↳ The oil level must be between the middle and the upper edge of the inspection glass (3).

2. Check the oil supply at the inspection glass (2) with the motor running.

↳ An air bubble is visible in the inspection glass.

Topping up with oil

To top up with oil:

1. Top up oil through the oil filling neck (1).

↳ The inspection glass (3) must indicate that it is 3/4 full with oil.

6.4 Maintaining the pneumatic system

6.4.1 Setting the operating pressure

NOTICE

Property damage from incorrect setting!

Incorrect operating pressure can result in damage to the machine.

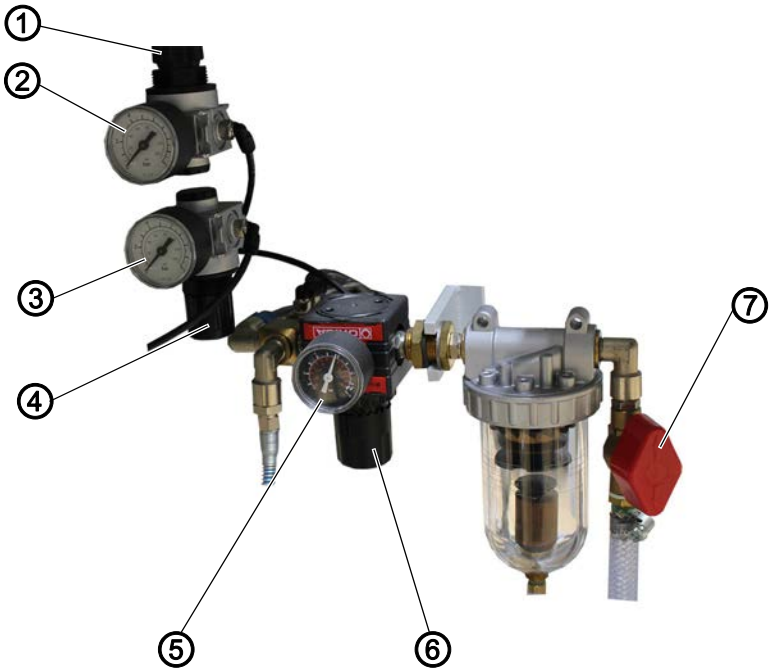
Ensure that the machine is only used when the operating pressure is set correctly.

Proper setting

Refer to the **Technical data** (📖 *p. 135*) chapter for the permissible operating pressure. The operating pressure cannot deviate by more than ± 0.5 bar.

Check the operating pressure on a daily basis.

Fig. 77: Setting the operating pressure



(1) - Pressure controller
(2) - Pressure gage transfer plate (output y 134)
(3) - Pressure gage vacuum (output y 133)
(4) - Pressure controller
(5) - Pressure gage
(6) - Pressure controller operating pressure
(7) - Shut-off valve

To set the operating pressure:

1. Turn the shut-off valve (7) into the horizontal position.
2. Pull the pressure controller operating pressure (6) down.

3. Turn the pressure controller until the pressure gage (5) indicates the proper setting:
   - Increase pressure: turn clockwise
   - Reduce pressure: turn counterclockwise
4. Push the pressure controller (6) up.

NOTICE

Property damage may occur!

Excess pressure on the vacuum unit can cause damage to the machine.

The pressure of the compressed air supplied to the vacuum unit must not exceed 3.5 bar.

Pressure gages (2) and (3) indicate the pressure at which the transfer plate and the vacuum unit are supplied.

Important

The pressure of the compressed air supplied to the vacuum unit must not exceed 3.5 bar.

To set the pressure for the transfer plate and the vacuum unit:

1. Pull pressure controller (1) or (4) down.
2. Turn the pressure controller until pressure gage (2) or (3) indicates the proper setting:
   - Increase pressure: turn clockwise
   - Reduce pressure: turn counterclockwise
3. Push the pressure controller up.

6.4.2 Draining the water condensation

NOTICE

Property damage from excess water!

Excess water can cause damage to the machine.

Drain water as required.

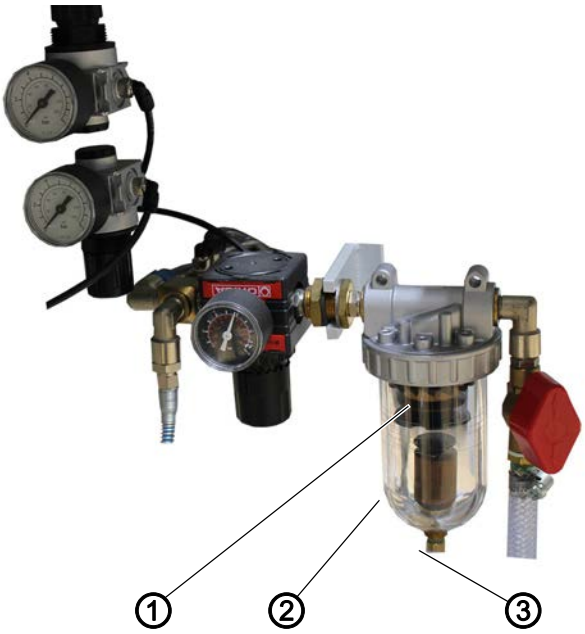
Water condensation accumulates in the water separator (2) of the pressure controller.

Proper setting

Water condensation must not rise up to the level of the filter element (1).

Check the water level in the water separator (2) on a daily basis.

Fig. 78: Draining the water condensation



(1) - Filter element
(2) - Water separator
(3) - Drain screw

To drain water condensation:

1. Disconnect the machine from the compressed air supply.
2. Place the collection tray under the drain screw (3).
3. Unscrew the drain screw (3) completely.
4. Allow water to drain into the collection tray.
5. Tighten the drain screw (3).
6. Connect the machine to the compressed air supply.

6.4.3 Cleaning the filter element

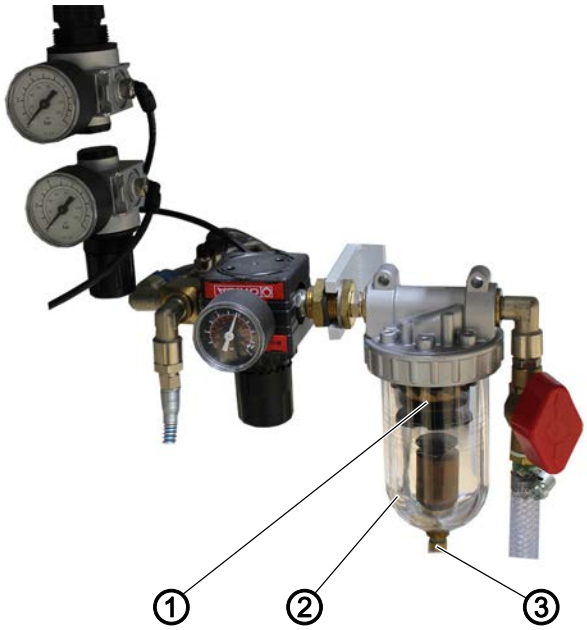
NOTICE

Damage to the paintwork from solvent-based cleaners!

Solvent-based cleaners damage the filter.

Use only solvent-free substances for washing out the filter tray.

Fig. 79: Cleaning the filter element



(1) - Filter element
(2) - Water separator
(3) - Drain screw

To clean the filter element:

1. Disconnect the machine from the compressed air supply.
2. Drain the water condensation (📖 *p. 102*).
3. Unscrew the water separator (2).
4. Unscrew the filter element (1).
5. Blow out the filter element (1) using a compressed air gun.
6. Wash out the filter tray using benzine.
7. Tighten the filter element (1).
8. Tighten the water separator (2).
9. Tighten the drain screw (3).
10. Connect the machine to the compressed air supply.

6.5 Parts list

A parts list can be ordered from Dürkopp Adler. Or visit our website for further information at:

www.duerkopp-adler.com

7 Setup

WARNING

Risk of injury due to a lack of specialist knowledge!

Lack of specialist knowledge can result in serious injuries when setting up the machine.

Allow ONLY trained personnel to set up the machine.

DANGER

Risk of injury from electricity!

Unprotected contact with electricity can result in serious injuries or death.

Work on the electrical system must ONLY be performed by qualified electricians or appropriately trained and authorized personnel.

ALWAYS pull the power plug before working on the electrical equipment.

7.1 Checking the scope of delivery

The scope of delivery depends on your specific order. Check that all parts required are present before setting up the machine:

- Basic equipment
- Additional equipment
- Small parts in an accessory pack

7.2 Removing and assembling the covers

The covers are divided into covers above and below the table level.
The covers above the table level must be removed in order to remove the transport locks.

7.2.1 Removing the covers

NOTICE

Property damage may occur!

The covers above the table level can be damaged when removed in the wrong order.

ALWAYS remove the covers above the table level in the specified order.

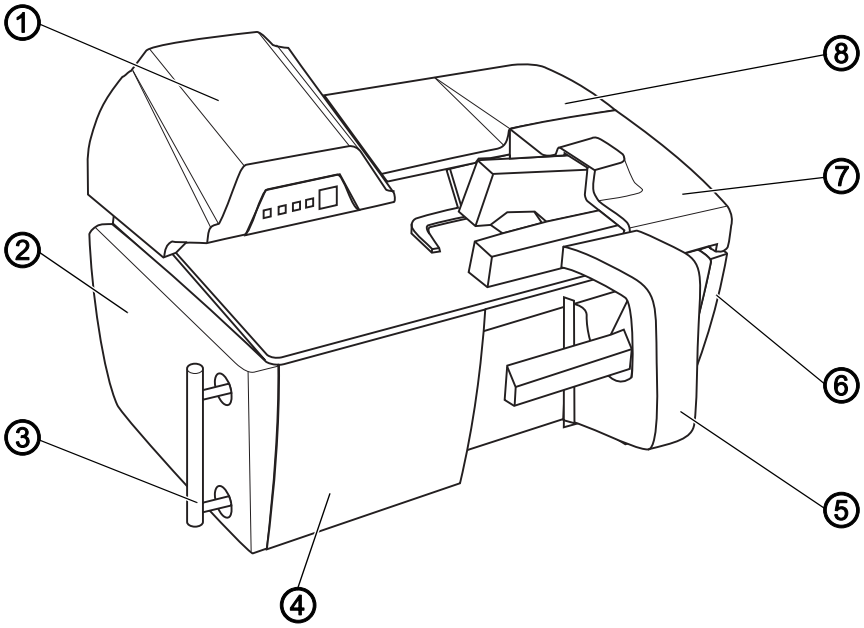
NOTICE

Property damage may occur!

The covers above the table level are fastened with ball-heads that can also damage the protective covers when incorrectly removed.

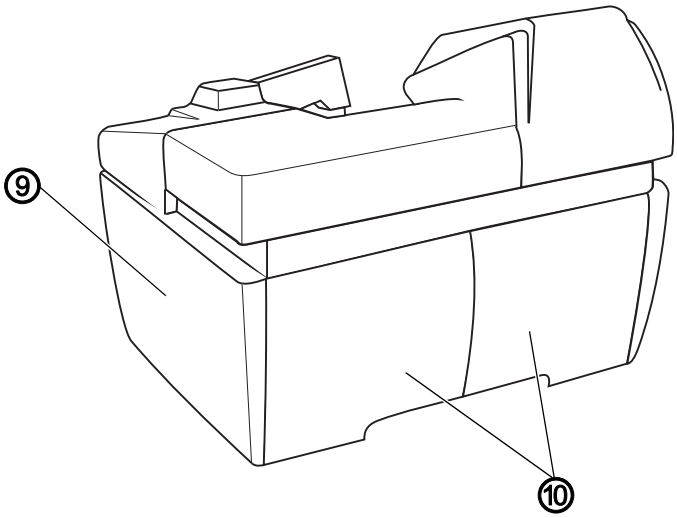
NEVER use force to remove the covers above the table level.

Fig. 80: Removing the covers (1)



(1) - Cover - Edge folding station
(2) - Cover - Left side
(3) - Bar
(4) - Cover - Front left
(5) - Cover - Carriage
(6) - Cover - Sewing head
(7) - Cover - Front right
(8) - Cover - Stacker

Fig. 81: Removing the covers (2)



(9) - Cover - Right side
(10) - Rear cover

Removing the covers above the tabletop

Cover - Sewing head (6)

To remove the sewing head cover (6):

1. Unlock the cover lock using the associated key.
2. Release the clamping lever on the thread reel holder by reaching under the cover.

3. Pull out the thread reel holder upwards.
4. Slide the cover to the right.
5. Lift the cover upwards.

Cover - Carriage (5)

To remove the carriage cover (5):

1. Remove the cover upwards.

Cover - Edge folding station (1)

To remove the edge folding station cover (1):

1. Pay attention to the keypad guide.
2. Remove the cover upwards.

Removing the covers below the tabletop

Covers on the rear (10)

To remove the covers on the rear (10):

1. Pull the cover upwards.
2. Remove the cover forwards.

Cover - Front left (4)

To remove the cover at the front left (4):

1. Pull the cover upwards.
2. Remove the cover forwards.

Cover - Front right (7)

To remove the cover at the front right (5):

1. Release the screw using a hex key through the hole.
2. Pull the cover upwards.
3. Remove the cover forwards.

Cover - Left side (2)

Information

You do not have to remove the cover on the left side (2) when removing the covers on the rear (10). After removing the covers on the rear (10), you can access all components in the machine compartment.

To remove the cover on the left side (2):

1. Release the screws on the retaining bar.
2. Pull out the retaining bar.
3. Pull the cover upwards.
4. Remove the cover forwards.

Cover - Right side (9)

To remove the cover on the right side (9):

1. Release the screws.
2. Remove the plate.
3. Pull the cover upwards.
4. Remove the cover forwards.

Cover - Stacker (8)

To remove the stacker cover (8):

1. Pivot the stacker towards the machine.
2. Loosen the inner earthing cable from the cover.
3. Loosen the hex screw at the outer right of the cover.
4. Loosen the hex screw at the outer left of the cover.
5. Remove the cover forwards.

7.2.2 Assembling the covers

NOTICE

Property damage may occur!

The covers above the table level can be damaged when assembled in the wrong order.

ALWAYS assemble the covers above the table level in the specified order.

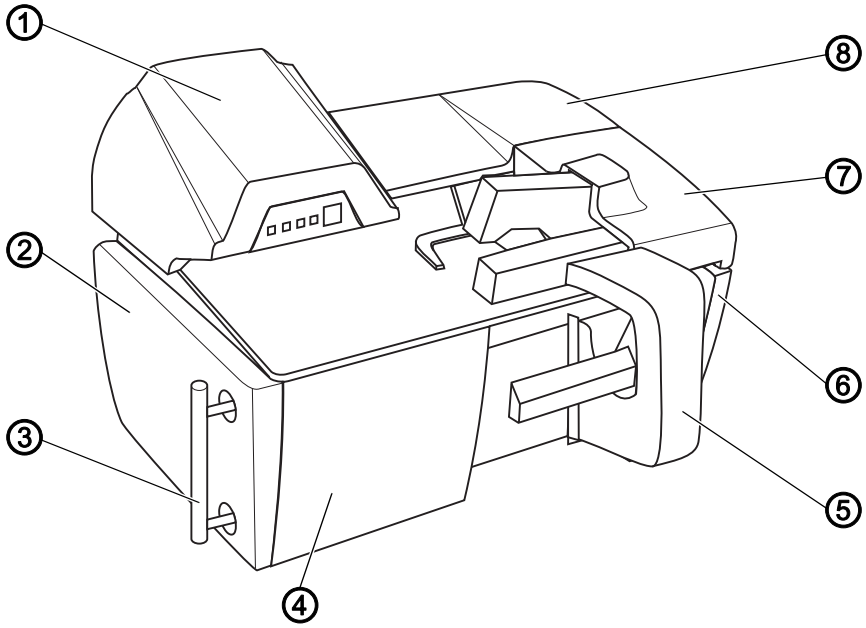
NOTICE

Property damage may occur!

The covers below the table level can be damaged when the snap-locks and springs are not correctly fastened.

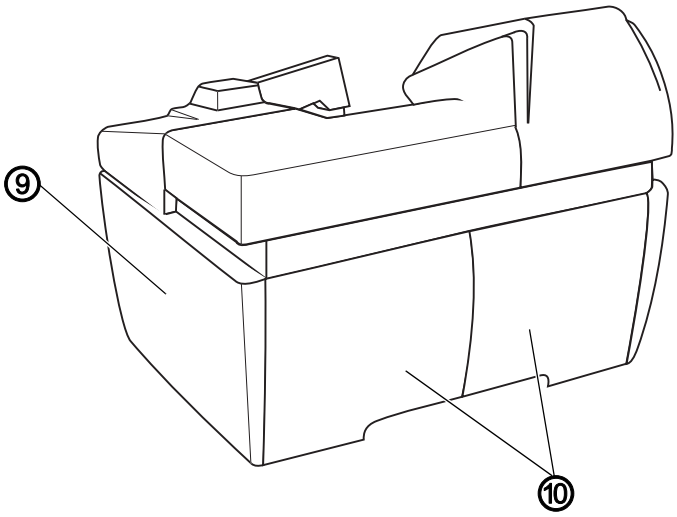
The snap-locks and springs for the covers below the table level must ALWAYS be correctly latched in place.

Fig. 82: Assembling the covers (1)



(1) - Cover - Edge folding station
(2) - Cover - Left side
(3) - Bar
(4) - Cover - Front left
(5) - Cover - Carriage
(6) - Cover - Sewing head
(7) - Cover - Front right
(8) - Cover - Stacker

Fig. 83: Assembling the covers (2)



(9) - Cover - Right side *(10) - Rear cover*

Assembling the covers above the tabletop

Cover - Edge folding station (1)

To assemble the edge folding station cover (1):

1. Pay attention to the control panel guide.
2. Assemble the cover from the top.

Cover - Carriage (5)

To assemble the carriage cover (5):

1. Place the cover on the carriage from above.
2. Insert the cover so that it lies on the edge folding station cover (1).

Cover - Sewing head (6)

To assemble the sewing head cover (6):

1. Insert the cover into the guide at the upper right of the carriage cover (5).
2. Insert the thread reel holder from above.
3. Tighten the clamping lever on the thread reel holder by reaching under the cover.
4. Lock the cover lock using the associated key.

Assembling the covers below the tabletop

Cover - Right side (9)

To assemble the cover on the right side (9):

1. Insert the cover downwards into the guide hooks.

2. Pull the cover upwards.
3. Insert the cover upwards into the guide hooks.

↳ The cover is locked in place by the springs on the lower guide hooks.

4. Fit the plate.
5. Fasten the plate with the screws.

Cover - Left side (2)

To assemble the cover on the left side (2):

1. Insert the cover downwards into the guide hooks.
2. Pull the cover upwards.
3. Insert the cover upwards into the guide hooks.

↳ The cover is locked in place by the springs on the guide hooks.

4. Slide the retaining bar into the guide.
5. Fasten the screws on the retaining bar.

Covers on the rear (10)

To assemble the covers on the rear (10):

1. Insert the cover downwards into the guide hooks.
2. Pull the cover upwards.
3. Insert the cover upwards into the guide hooks.

↳ The cover is locked in place by the springs on the guide hooks.

Cover - Front left (4)

To assemble the cover at the front left (4):

1. Hang the cover in place.

Cover - Front right (7)

To assemble the cover at the front right (7):

1. Insert the cover downwards into the guide hooks.
2. Pull the cover upwards.
3. Insert the cover upwards into the guide hooks.
4. Release the screw using a hex key through the front middle hole.

Cover - Stacker (8)

To assemble the stacker cover (8):

1. Pivot the stacker away from the machine.
2. Insert the cover from above.

3. Tighten the hex screw at the outer left of the cover.
4. Tighten the hex screw at the outer right of the cover.
5. Attach the earthing cable at the inner right.
6. Pivot the stacker towards the machine.

7.3 Removing the transport locks

Transport locks must be assembled to the following machine parts in order to protect the machine from damage during transport:

- Sewing head
- Edge folding station
- Stacker
- Transfer carriage

NOTICE

Property damage may occur!

Incomplete removal of the transport locks can damage or destroy the machine.

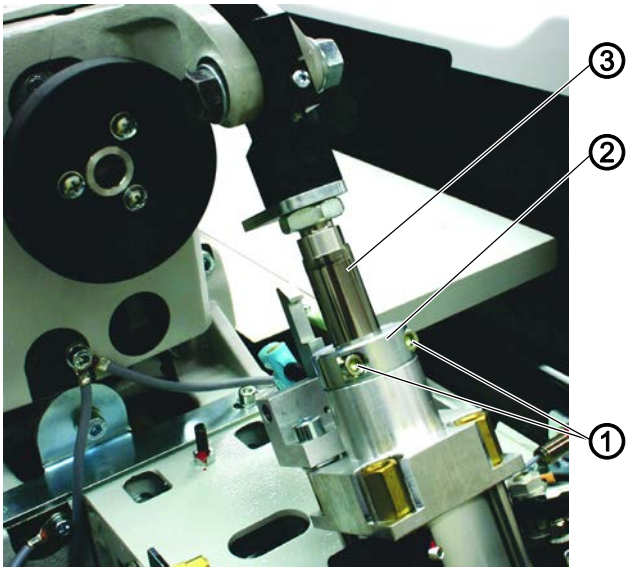
Remove ALL transport locks.

Important

Before you can remove the transport locks, you must take off all covers first (📖 *p. 108*).

Removing the sewing head transport lock

Fig. 84: Removing the sewing head transport lock



(1) - Screws
(2) - Metal ring
(3) - Pressure cylinder

To remove the transport lock from the sewing head:

1. Loosen the screws (1) on the metal ring (2).
2. Remove the metal ring (2) from the sewing head pressure cylinder.

↳ The sewing head transport lock has been removed.

↳ The sewing head can be moved freely.

Removing the transport lock from the edge folding station

Information

The edge folding station is delivered in shape changing mode, even when no shapes are supplied with the machine.

To remove the transport lock from the edge folding station:

1. Remove the polystyrene foam from between the protective bar and edge folding frame at the front of the edge folding station.
2. Remove the fastening tape or cable ties from the carriage of the middle slide and edge folding frame.

↳ The edge folding station transport lock has been removed.

Removing the stacker transport lock

To remove the transport lock from the stacker:

1. Remove the fastening tape used for fastening the stacker to the machine.
2. Remove the tape from the stacker.
3. Pivot the stacker away from the machine.

↳ The stacker transport lock has been removed.

↳ The stacker can move freely.

Removing the transfer carriage transport lock

To remove the transport lock from the transfer carriage:

1. Removing the fastening tape from the transfer carriage.

↳ The transfer carriage is connected to the edge folding frame and the machine frame.

2. Deactivate the EMERGENCY STOP switch by pulling it out to the left (📖 *p. 53*).

↳ The transfer carriage transport lock has been removed.

↳ The transfer carriage can move freely.

Removing the transport lock from the power cable and the pedal

The power cable and pedal are already assembled to the machine. Remove both parts from the machinery space behind the control. To do so, remove the rear covers below the table level (📖 *p. 110*).

7.4 Setting up the sewing unit

WARNING

Risk of injury due to a lack of specialist knowledge!

Lack of specialist knowledge can result in serious injuries when setting up the machine.

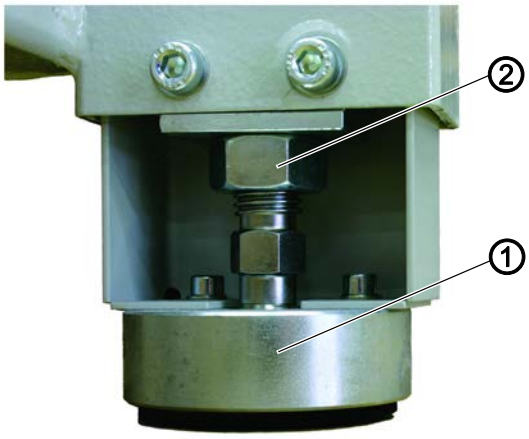
Allow ONLY trained personnel to set up the machine.

7.4.1 Aligning the machine

Important

To prevent accidents the weight of the sewing unit must be evenly distributed over the 4 adjustable feet.

Fig. 85: Aligning the machine



(1) - Adjustable foot *(2) - Counternut*

To align the machine:

1. Place a spirit level on the frame in order to align the machine level (e.g. at the rear by removing the rear bottom covers (📖 *p. 110*)).
2. Loosen the counternut (2).
3. Turn the adjustable foot (1) until it reaches the correct height.

4. Tighten the counternut (2) again.
5. Repeat steps 2 to 4 for the other feet.

↳ The machine is aligned level.

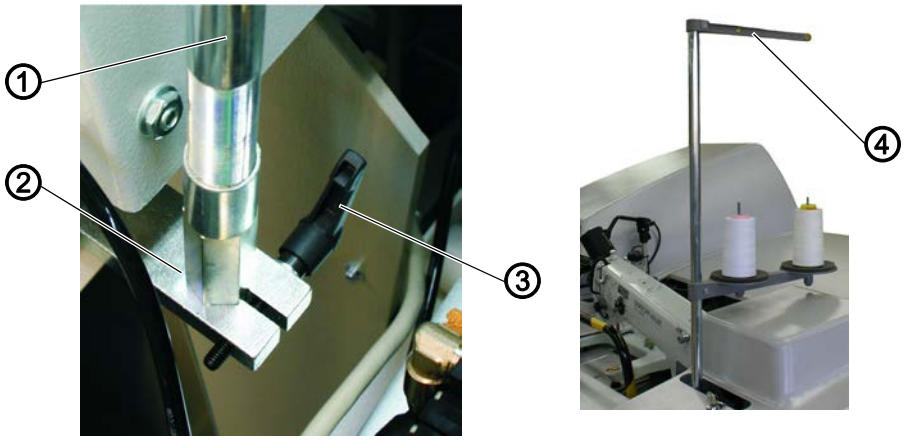
7.4.2 Assembling the thread reel holder

Due to its height the thread reel holder is not installed when the machine is delivered.

Important

The thread reel holder must be installed with the covers in place because the covers can no longer be assembled when the thread reel holder is installed.

Fig. 86: Assembling the thread reel holder



(1) - Thread reel holder
(2) - Thread reel holder bracket
(3) - Clamping bracket
(4) - Thread guide

To assemble the thread reel holder:

1. Insert the thread reel holder (1) into the hole in the thread reel holder bracket (2).
2. Align the thread guide (4) at right angles to the sewing arm.
3. Clamp the thread reel holder (1) using the clamping lever (3).

7.5 Electrical connection

DANGER

Risk of injury from electricity!

Unprotected contact with electricity can result in serious injuries or death.

Work on the electrical system must ONLY be performed by qualified electricians or appropriately trained and authorized personnel.

ALWAYS pull the power plug before working on the electrical equipment.

NOTICE

Property damage may occur!

The machine can be significantly damaged or destroyed by contact with the incorrect mains voltage.

ONLY connect the machine to the specified mains voltage!

The machine is ONLY to be connected by qualified specialists.

The power cable is already installed on the machine. On delivery it lies inside the machine.

Important

A country-specific plug must be fitted to the cable.

7.6 Pneumatic connection

The sewing unit must be provided with dry compressed air for operating the pneumatic components.

NOTICE

Property damage may occur!

The machine can sustain damage if the pressure is too low.

Set the operating pressure to 6 bar.

Information

The connection hose for the pneumatic system is not included in the scope of delivery of the sewing unit. It must be ordered separately.

7.6.1 Connecting the compressed air maintenance unit

Fig. 87: Connecting the compressed air maintenance unit

(1) - Pressure gage

To connect the compressed air maintenance unit:

1. Connect the connection hose with the hose coupling to the compressed air supply.
2. Plug the connection hose onto the hose neck of the pressure gage (1).
3. Fasten the connection hose with a hose clamp.
4. Open the shut-off valve by turning it to the right into the horizontal position.

7.6.2 Setting the operating pressure

The operating pressure is **6 bar**.

Fig. 88: Setting the operating pressure

(1) - Pressure gage *Rotary handle*

To set the operating pressure:

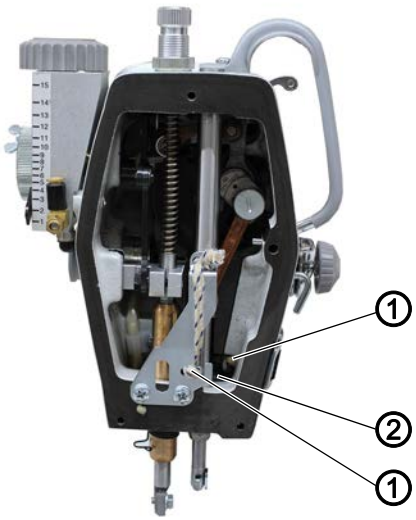
1. Pull the rotary handle (2) down and turn it.
   - Increase pressure: turn clockwise
   - Reduce pressure: turn counterclockwise

↳ The operating pressure is indicated on the pressure gage (1).

7.6.3 Lubricating wicks and felt

The wicks and felt in the sewing head must be soaked with oil when setting up the machine, and especially after longer standstill periods.

Fig. 89: Lubricating wicks and felt



(1) - Wicks *(2) - Felt*

To lubricate the wicks and felt:

1. Release the screws on the head cover.
2. Remove the head cover.

3. Lubricate wicks and felt at positions (1) and (2):
   - Apply a small amount of oil directly from the oil can to the marked positions.
4. Fit the head cover.
5. Tighten the screws on the head cover.

8 Decommissioning

A number of activities must be performed if the machine is to be shut down for a longer period of time or completely decommissioned.

WARNING

Risk of injury from a lack of care!

A lack of care or a lack of sufficient technical knowledge when decommissioning the machine can result in serious injuries.

ONLY clean the machine when it is switched off.

Avoid contact with oil residues.

Allow ONLY trained personnel to disconnect the machine.

To decommission the machine:

1. Switch off the main switch located centrally under the sewing material support surface.
2. Turn the compressed air shut-off valve, at the right next to the main switch, to the right in the horizontal position.
3. Unplug the power plug.
4. Disconnect the pneumatic connection.
5. Remove residual oil from the oil pan under the sewing material support surface using a cloth.
6. Cover the operating terminal to protect it from soiling.
7. Cover the control at the edge folding station to protect it from soiling.
8. Cover the entire machine if possible to protect it from soiling and damage.

Observe the necessary safety precautions for transport, (📖 *p. 125*).

9 Packaging and transport

The aspects relating to packing and transportation are described below. Keep to the procedure described here to ensure fault-free operation of the machine.

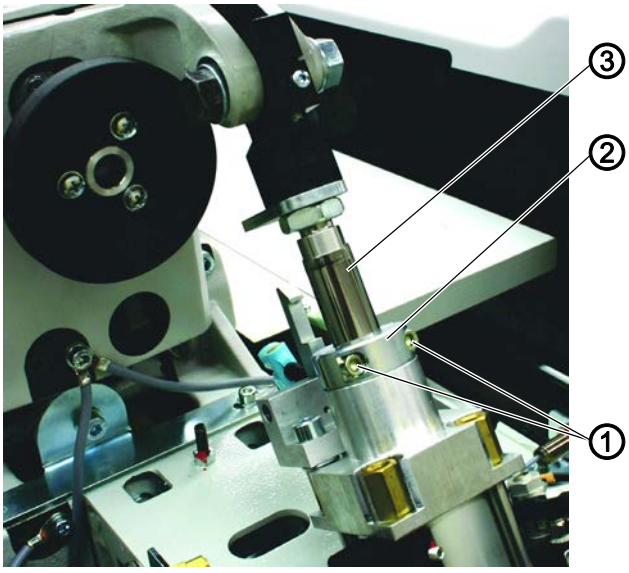
9.1 Assembling the transport locks

Transport locks must be assembled to the following places in order to protect the machine from damage during transport:

- Sewing head
- Edge folding station
- Stacker
- Transfer carriage

9.1.1 Assembling the sewing head transport locks

Fig. 90: Assembling the sewing head transport locks



(1) - Screws
(2) - Metal ring
(3) - Pressure cylinder

To assemble the transport locks:

1. Depressurize the machine and place it in the Safe stop mode.
2. Remove all covers above the tabletop (📖 *p. 109*).
3. Vent the residual compressed air
4. Push the sewing head down.
5. Loosen the screws (1) on the metal ring (2).
6. Fit the metal ring (2) around the sewing head pressure cylinder (3).
7. Tighten the screws (1) on the metal ring (2).

↳ The sewing head transport lock is now installed.

9.1.2 Assembling the transport lock on the edge folding station

To assemble the transport locks:

1. Depressurize the machine and place it in the Safe stop mode.
2. Remove all covers above the tabletop (📖 *p. 109*).
3. Place the machine in the shape changing mode (📖 *p. 85*).
4. Press the EMERGENCY STOP button.
5. Acknowledge the error message and shut down the PC.
6. Switch off the machine at the main switch.
7. Fasten the polystyrene foam between the protective bar and edge folding frame.
8. If necessary, use tape or cable ties to fasten the middle slide carriage and edge folding frame.

↳ The edge folding station components are fastened for transport.

9.1.3 Assembling the stacker transport locks

To assemble the transport locks:

1. Depressurize the machine and place it in the Safe stop mode.
2. Remove all covers above the tabletop (📖 *p. 109*).
3. Use tape or cable ties to fasten the stacker bar to the stacker.
4. Fold the stacker to the machine and tape it to the frame.

↳ The stacker is fastened to the machine.

9.1.4 Assembling the transfer carriage transport locks

To assemble the transport locks:

1. Depressurize the machine and place it in the Safe stop mode.
2. Remove all covers above the tabletop (📖 *p. 109*).
3. Activate the integrated EMERGENCY STOP switch on the transfer carriage: Press the EMERGENCY STOP switch in on the right.
4. Slide the transfer carriage all the way to the left.
5. Tape the transfer carriage to the machine frame and the edge folding frame.

↳ The transfer carriage is secured for transport.

9.1.5 Securing power cable and pedal for transport

The power cable and pedal are permanently assembled to the machine. They can be stored in the area behind the control. Remove the rear cover below the table level to store the cable more easily.

9.2 Packing the machine

WARNING

Risk of injury due to own weight of machine and sharp-edged packaging materials!

Crushing or cutting.

ALWAYS wear gloves and safety shoes when packing the machine.

ALWAYS watch out for sharp edges on clamps, paper and packing straps.

Pack the machine so that it cannot slip or fall over. Select a stable base and fasten the machine to this. Use covers to provide protection from external damage to the machine.

9.3 Transporting the machine

WARNING

Risk of injury due to unstable transport!

Crushing.

ALWAYS use a sturdy lifting carriage.

ALWAYS wear safety gloves and safety shoes.

Lift the machine a MAXIMUM of 20 mm.

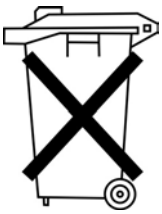
ALWAYS securely fasten the machine.

Assemble the transport locks before transporting the machine.

Ensure the highest possible degree of safety when transporting the machine:

- Fasten the machine
- Wear the designated protective equipment

10 Disposal



Do not dispose of the machine in the general household waste.

The machine must be disposed of in a suitable and proper manner and in accordance with all applicable national regulations.

CAUTION

Risk of environmental damage from improper disposal!

Improper disposal of the machine can result in serious environmental damage.

ALWAYS comply with the legal regulations regarding disposal.

When disposing of the machine, be aware that it consists of a range of different materials (steel, plastic, electronic components, etc.). Observe the applicable national regulations when disposing of these materials.

11 Troubleshooting

11.1 Customer Service

Contact for repairs and issues with the machine:

Dürkopp Adler GmbH

Potsdamer Str. 190
33719 Bielefeld, Germany

Tel. +49 (0) 180 5 383 756
Fax +49 (0) 521 925 2594
Email: service@duerkopp-adler.com
Internet: www.duerkopp-adler.com

11.2 Messages of the software

Please contact customer service if an error occurs that is not described here. Do not attempt to correct the error yourself.

11.2.1 Information messages

Information	
9221	Button pressed too long
9222	Button pressed too long
9223	Button pressed too long
9224	Button pressed too long
9225	Button pressed too long
9226	Button pressed too long

11.2.2 Error messages

Error	Possible causes	Remedy
Transmission to DAC failed	Connection to the control system cannot be established	• Deactivate the EMERGENCY STOP devices 🕮 *p. 53* • Notify technician
3121	• Compressed air too low • Compressed air not connected	• Set the operating pressure 🕮 *p. 121* • Connect compressed air 🕮 *p. 120*
5302	Seam program contour data too large	• Select different seam program 🕮 *p. 75* • Install new seam program
9116	Unknown pocket shape	• Select different seam program 🕮 *p. 75* • Install new seam program
9170	No transfer plate	Insert transfer plate 🕮 *p. 46* and reference machine again 
9180	No technology point for switching the transfer plate	Select different seam program 🕮 *p. 75*

11.3 Errors in sewing process

Error	Possible causes	Remedy
Thread broken		• Thread needle thread 🕮 *p. 26* • Continue or cancel sewing 🕮 *p. 51*
Bobbin empty		insert new hook thread bobbin 🕮 *p. 32*
no seam program can be selected	• Reflector strips on the rear side of the transfer plate are damaged or incomplete • Code on the transfer plate does not match the desired seam program • Light sensor for reading the code is soiled	• Replace or re-attach the reflector strips • Change the shaping assembly 🕮 *p. 40* • install new seam program • Insert transfer plate and reference machine again 
Needle thread monitor signals an error	Needle thread broken	Thread needle thread 🕮 *p. 26*
The stacker is not stacking	Stacker is not active	Activate stacker 🕮 *p. 90*
Pocket blank is not folded	Sewing without edge folding is active	Deactivate sewing without edge folding 🕮 *p. 87*
Machine works only step by step	Work step-by-step mode is active	Deactivate Work step-by-step mode 🕮 *p. 86*

12 Technical data

The Dürkopp Adler 806N is a CNC-controlled sewing unit for automatically sewing pockets onto moderately heavy sewing material such as jeans (806N-111) or shirts (806N-121).

Data and characteristic values

Technical data	Unit	806N-111	806N-121
Machine type		Sewing unit	Sewing unit
Hook type		Vertical hook	Horizontal hook
Stitch type		301/Double lockstitch	301/Double lockstitch
Number of needles		1	1
Needle system		134	134
Needle strength	[Nm]	80-140	70-100
Thread strength	[Nm]	12/3	50/2
Stitch length	[mm]	3.5	3
Max. speed	[min^{-1}]	3800	4000
Mains voltage	[V]	1 x 230	1 x 230
Operating pressure	[bar]	6	6
Length	[mm]	2300	2300
Width	[mm]	1750	1750
Height	[mm]	1750	1750
Weight	[kg]	630	600

Characteristics

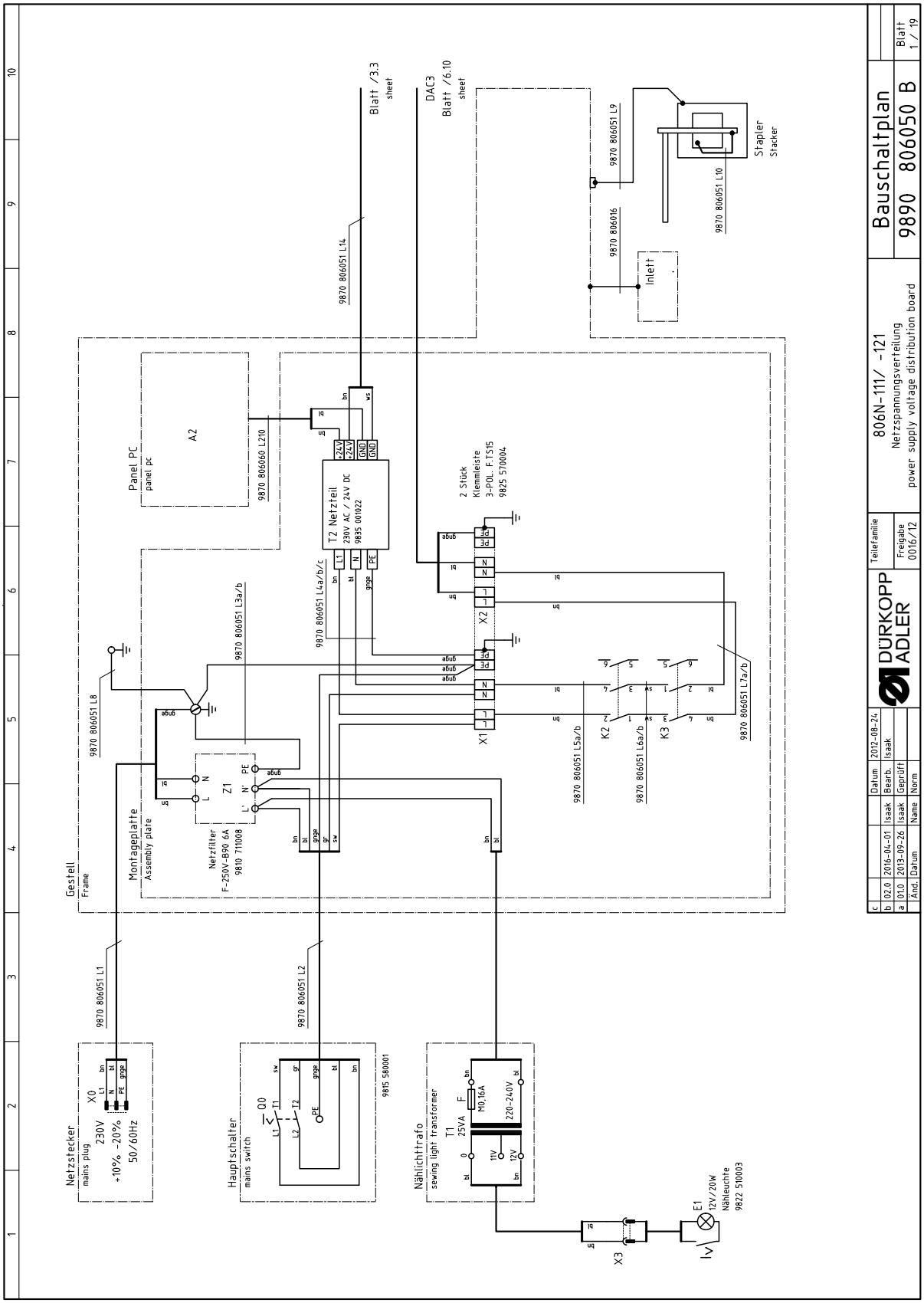
- Stepper motors for short running times and exact needle guidance, which means particularly high pocket quality
- DAC III control (Dürkopp Adler Control)
- In-house software for operating the system
- Software symbols adopted from the previous control system, which means easy handling and fast familiarization
- Air suction device (vacuum) in the ergonomically inclined (10 degrees) sewing material support surface, for fastening the sewing material
- Constant feed of sewing material during the sewing process
- up to 3,800 stitches/min. with 3.5 mm stitch length

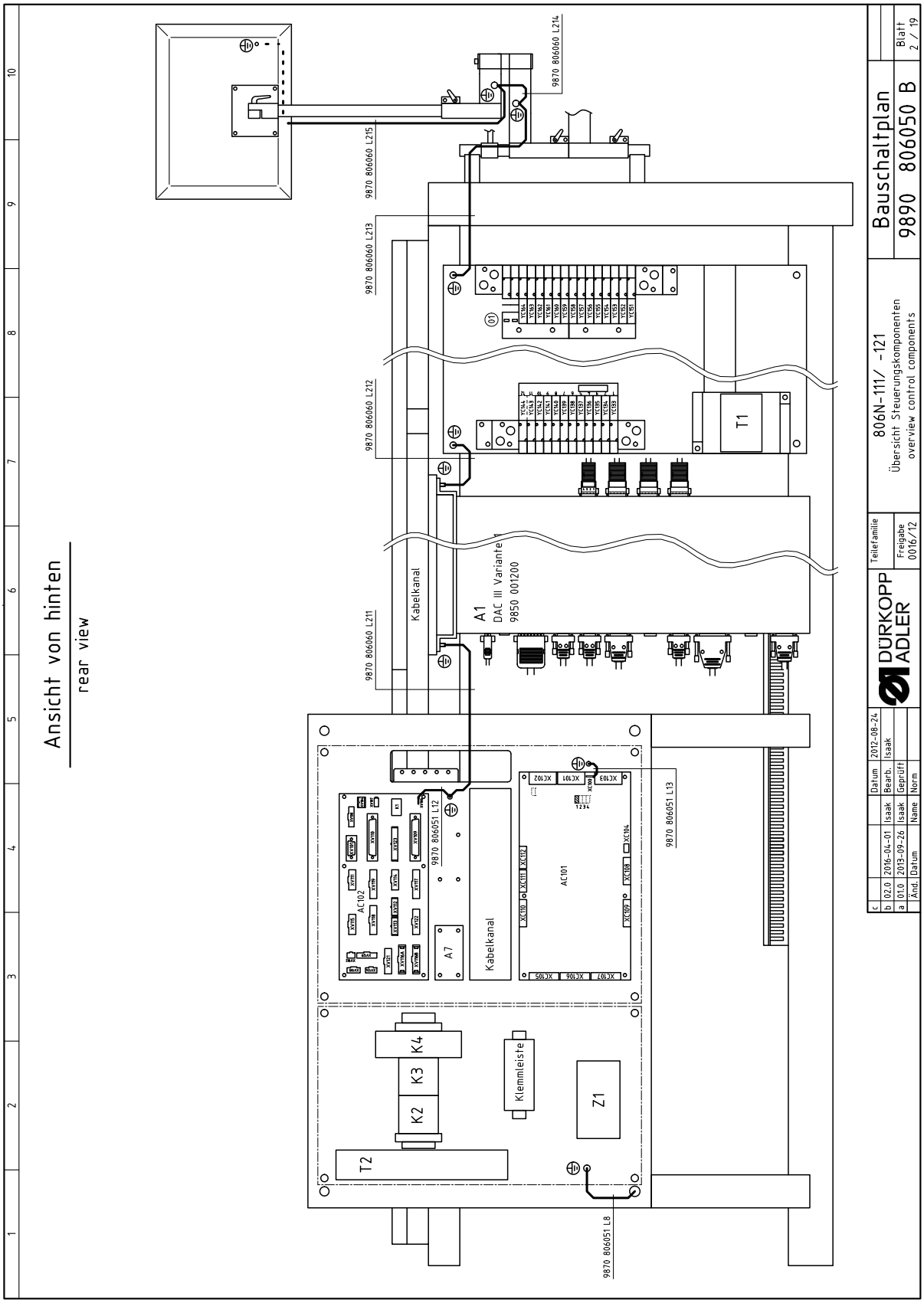
13 Glossary

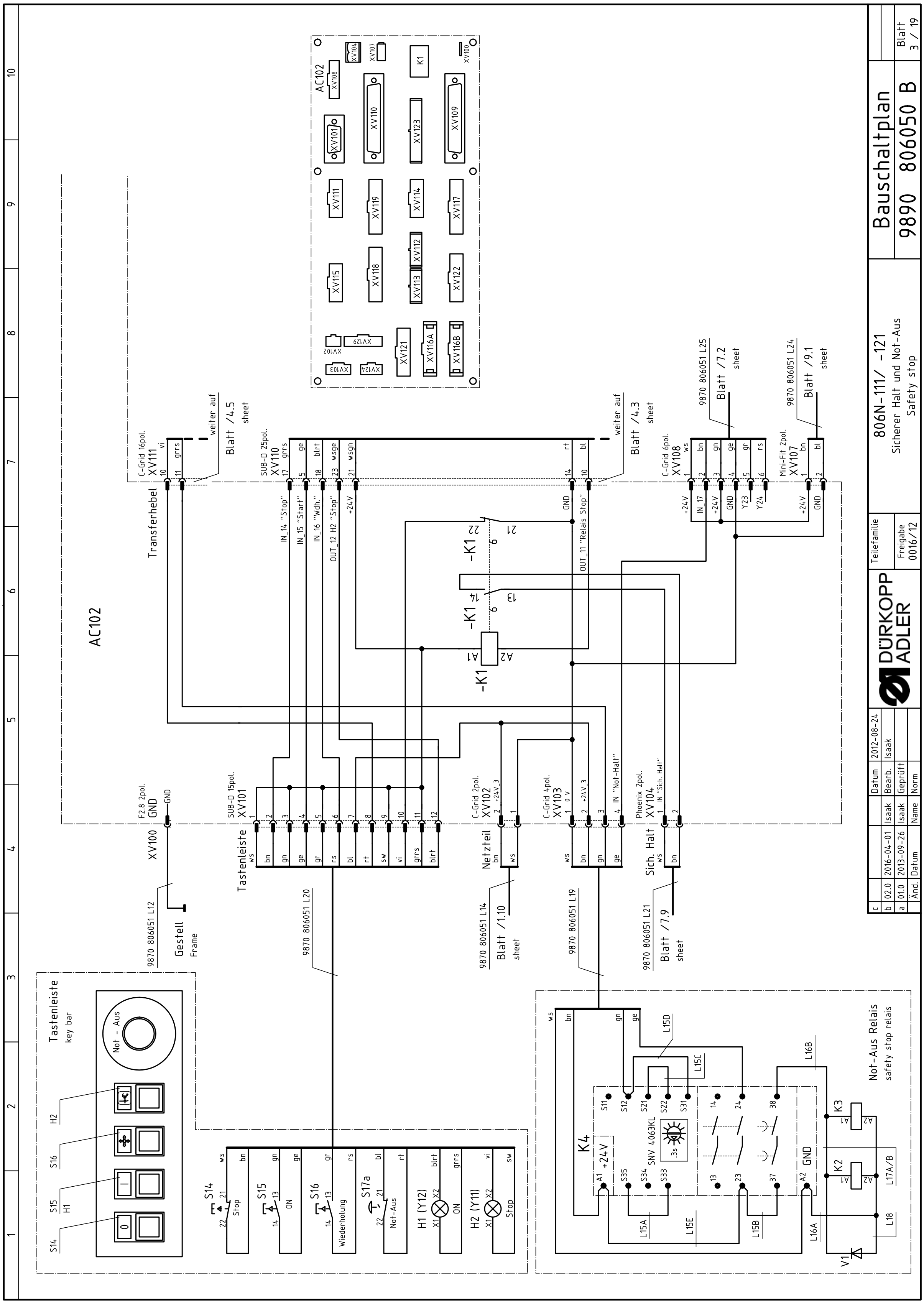
Term	Explanation
TC	See thread cutter
Thread cutter	The thread cutter is located under the sewing material support surface and cuts off the hook thread and needle thread after each sewing cycle.
Needle thread breakage	A needle thread breakage is defined as a breakage of the needle thread.
Shaping assembly	The shaping assembly is important for the seam program. A shaping assembly consists of: • Edge folding frame • Middle slide • Transfer plate • Hose insert
Hook thread	The hook thread is the thread coming from the bobbin. It is located under the sewing material support surface.
Basic part	The basic part is the material product onto which the pocket is to be sewn.
Initial position	In the initial position the middle slide is at the rear and the transfer plate is at the right.
Air suction	The air suction is located in the sewing material support surface in the edge folding area. The air suction fastens the basic part on the sewing material support surface.
Middle slide	The middle slide is a component of the edge folding station. The pocket blank is placed on this.
Needle thread	The needle thread is the thread coming from the thread reel. It runs through the needle.
Sewing material support surface	The sewing material support surface extends from the edge folding station to the sewing unit. The sewing material support surface supports the basic part and transports the material to the sewing unit.
Equipotential bonding	The equipotential bonding minimizes different electrical potentials resulting from friction. This protects the machine from damage and faulty behavior.
Reference run	In a reference run the machine senses the numeric code on the transfer plate and checks the compatibility of the seam program. The machine also searches for its starting point or initial position.
Referencing	The machine performs a reference run.
Hose insert	The hose insert is only important for the "Shirts/Underwear" variant. It ensures that the folding of the pocket blank is retained when the middle slide is removed after folding.
Snapper	The snapper functions like a spring. For example, the spring pressure ensures that the covers remain in place and do not fall down.

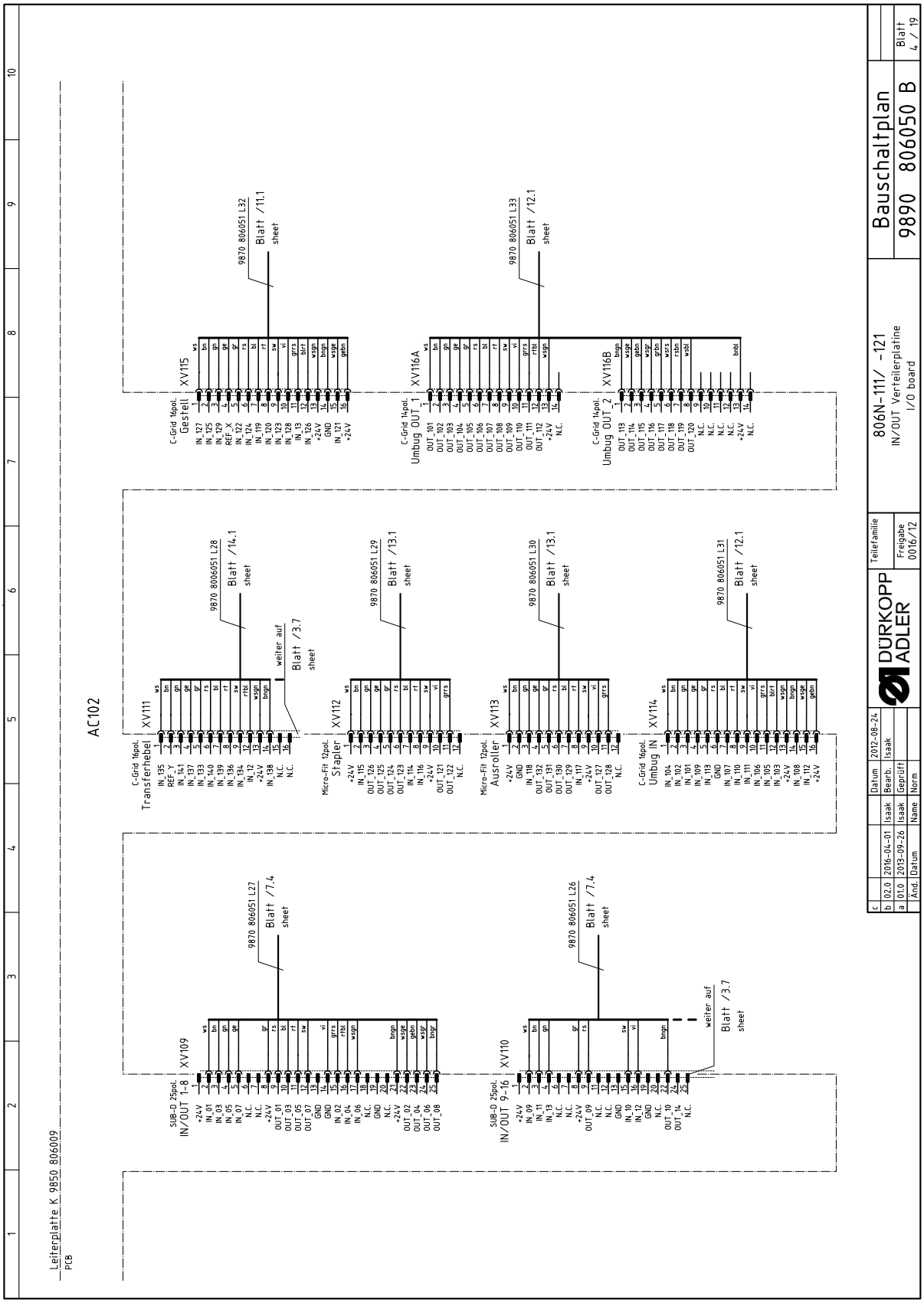
Term	Explanation
Safe stop	Power is removed from the sewing motor and the stepper motors are in the holding position.
Bobbin	The hook thread is wound on the bobbin. The bobbin is located under the sewing material support surface.
Throat plate	The throat plate is integrated into the tabletop of the sewing unit. It supports the material to be sewn and the cover and the equipotential bonding is also attached to this.
Pocket blank	The pocket blank is the piece of material that is folded in the edge folding station and then sewn as a pocket onto the basic part.
Transfer arm	The transfer plate is attached to the transfer arm. The transfer arm moves to the edge folding station and fetches the material to be sewn to the sewing unit. An EMERGENCY STOP switch is integrated into the transfer arm.
Transfer plate	The transfer plate holds the material to be sewn on the tabletop and transports it to the sewing unit via the transfer arm. The machine uses the numeric code on the rear side of the transfer plate to determine which seam program is compatible with the transfer plate.
Edge folding	Edge folding describes the process of folding the pocket blank via the edge folding frame.
Edge folding frame	The edge folding frame is used to fold the (edge) of the pocket blank.
Edge folding station	The pocket blank is edge folded in the edge folding station. Various buttons for operating the machine are also located here 📖 *p. 16*
Edge folding set	The edge folding set is defined as the inner frame and outer frame of the edge folding frame.
Vacuum	See air suction

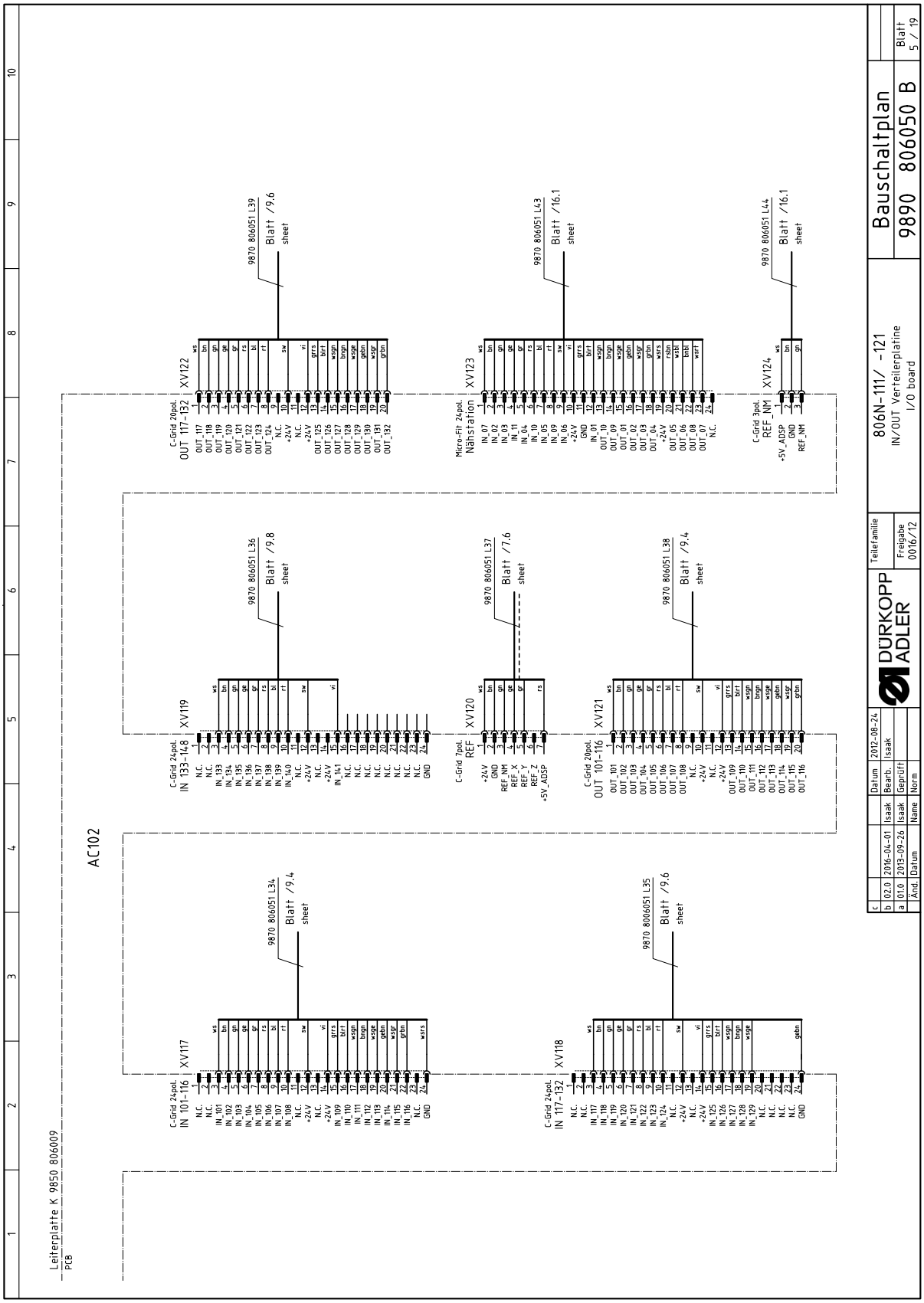
14 Appendix

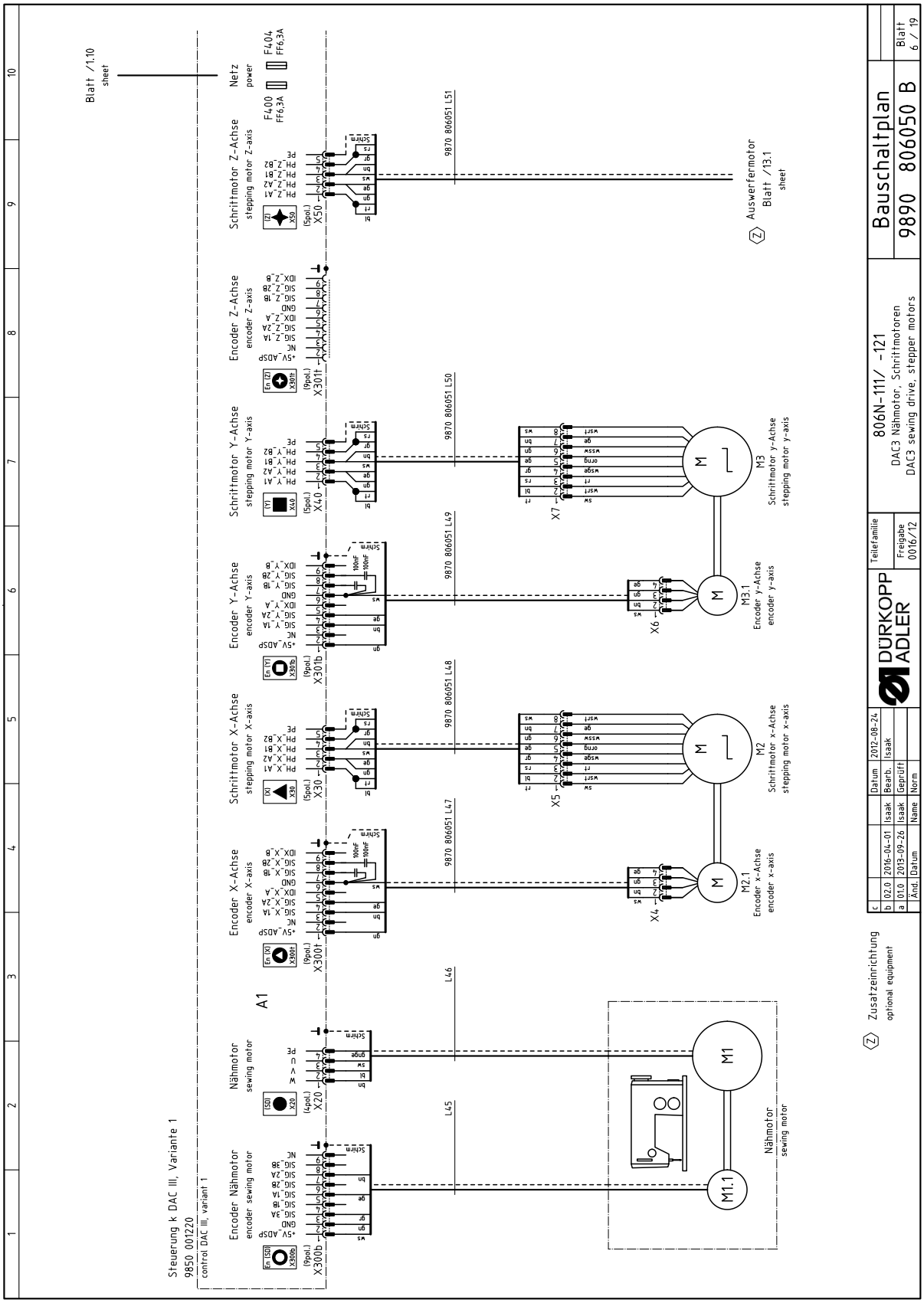

Bauschaltplan
9890 806050 B
806N-111/ -121
Netzspannungsverteilung
power supply voltage distribution board
DÜRKOPP ADLER
Gestell
Frame
Montageplatte
Assembly plate
Panel PC
A2
T2 Netzteil
230V AC / 24V DC
9835 001022
Netzfilter
F-250V-B90 6A
9810 711008
Netzstecker
mains plug
230V
+10% -20%
50/60Hz
Hauptschalter
mains switch
Nählichttrafo
sewing light transformer
T1
25VA
220-240V
12V/20W
Nähleuchte
9822 510003
Stapler
Stacker
Inlett
2 Stück
Klemmleiste
3-POL F.TS15
9825 570004
Blatt /3.3
sheet
DAC3
Blatt /6.10
sheet

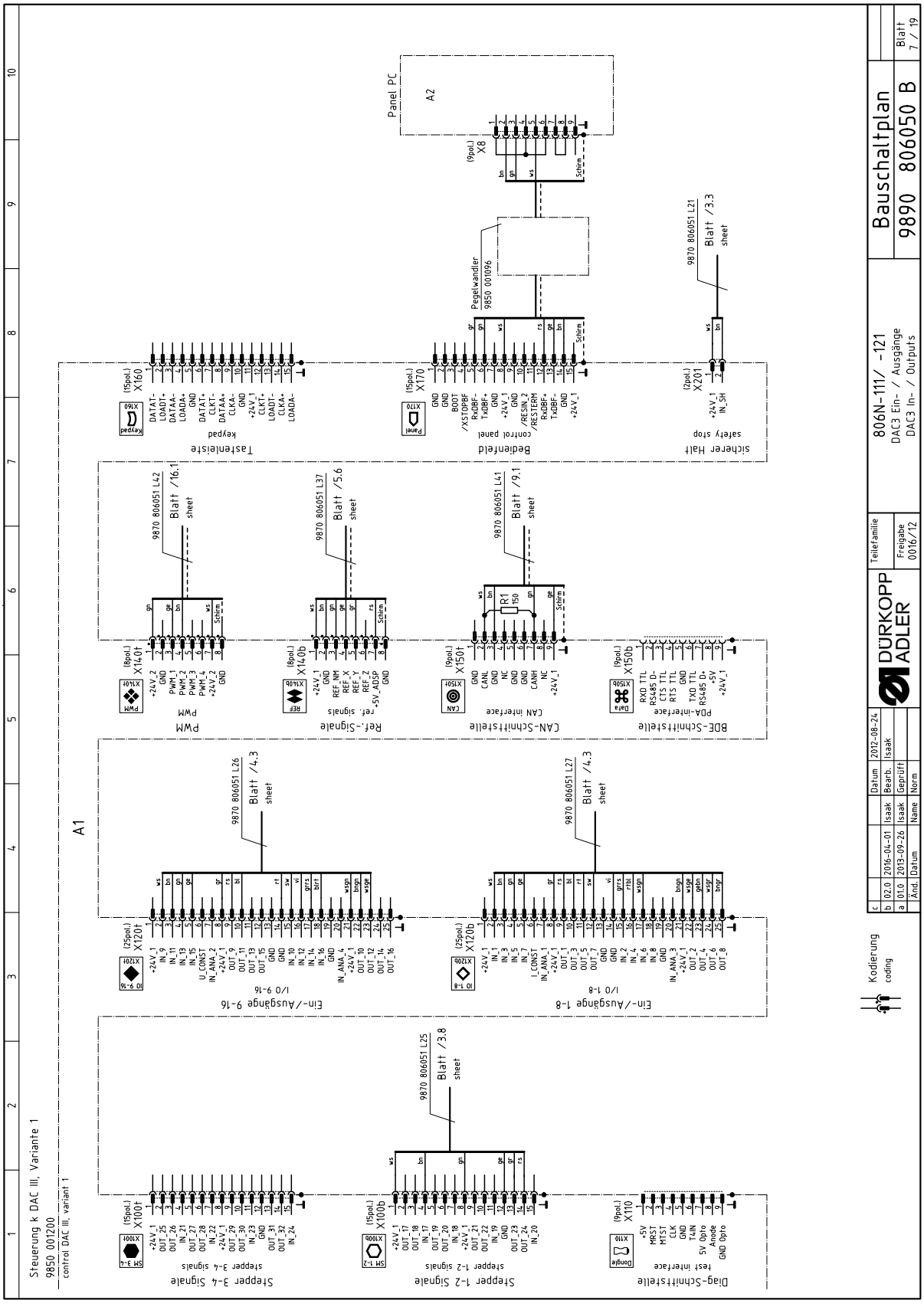

Ansicht von hinten
rear view
Bauschaltplan
9890 806050 B
Blatt 2 / 19
806N-111/ -121
Übersicht Steuerungskomponenten
overview control components
DÜRKOPP ADLER
Teilefamilie
Freigabe 0016/12
Datum 2012-08-24
Bearb. Isaak
Geprüft
Norm
Name
And. Datum
c
b 02.0 2016-04-01 Isaak
a 01.0 2013-09-26 Isaak
9870 806060 L214
9870 806060 L215
9870 806060 L213
9870 806060 L212
9870 806060 L211
9870 806051 L12
9870 806051 L13
9870 806051 L8
A1
DAC III Variante
9850 001200
Kabelkanal
Kabelkanal
A7
AC102
AC101
T1
T2
K2
K3
K4
Klemmleiste
Z1

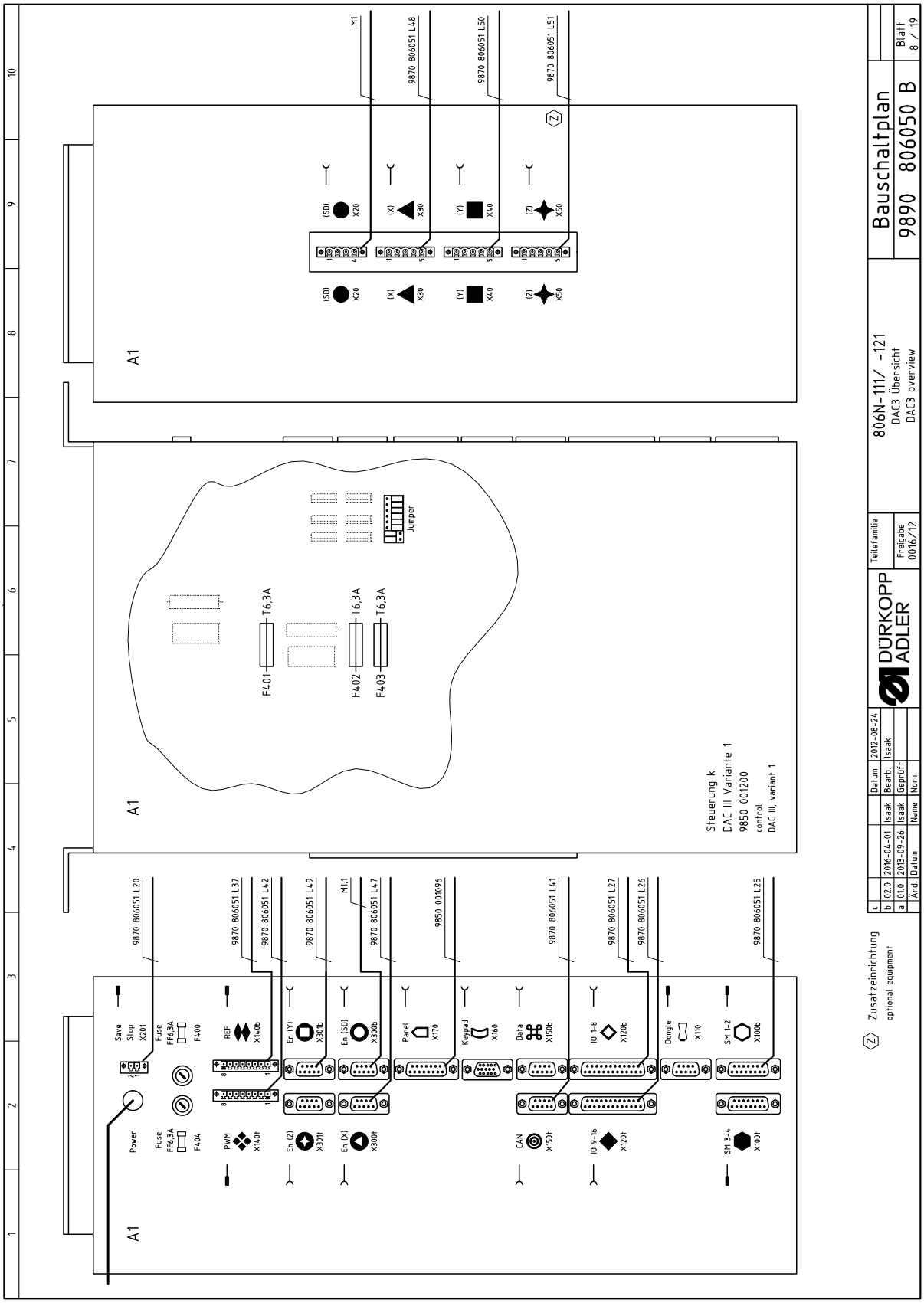

Bauschaltplan
9890 806050 B
806N-111/ -121
Sicherer Halt und Not-Aus
Safety stop
Blatt
3 / 19
AC102
Not-Aus Relais
safety stop relais
Tastenleiste
key bar

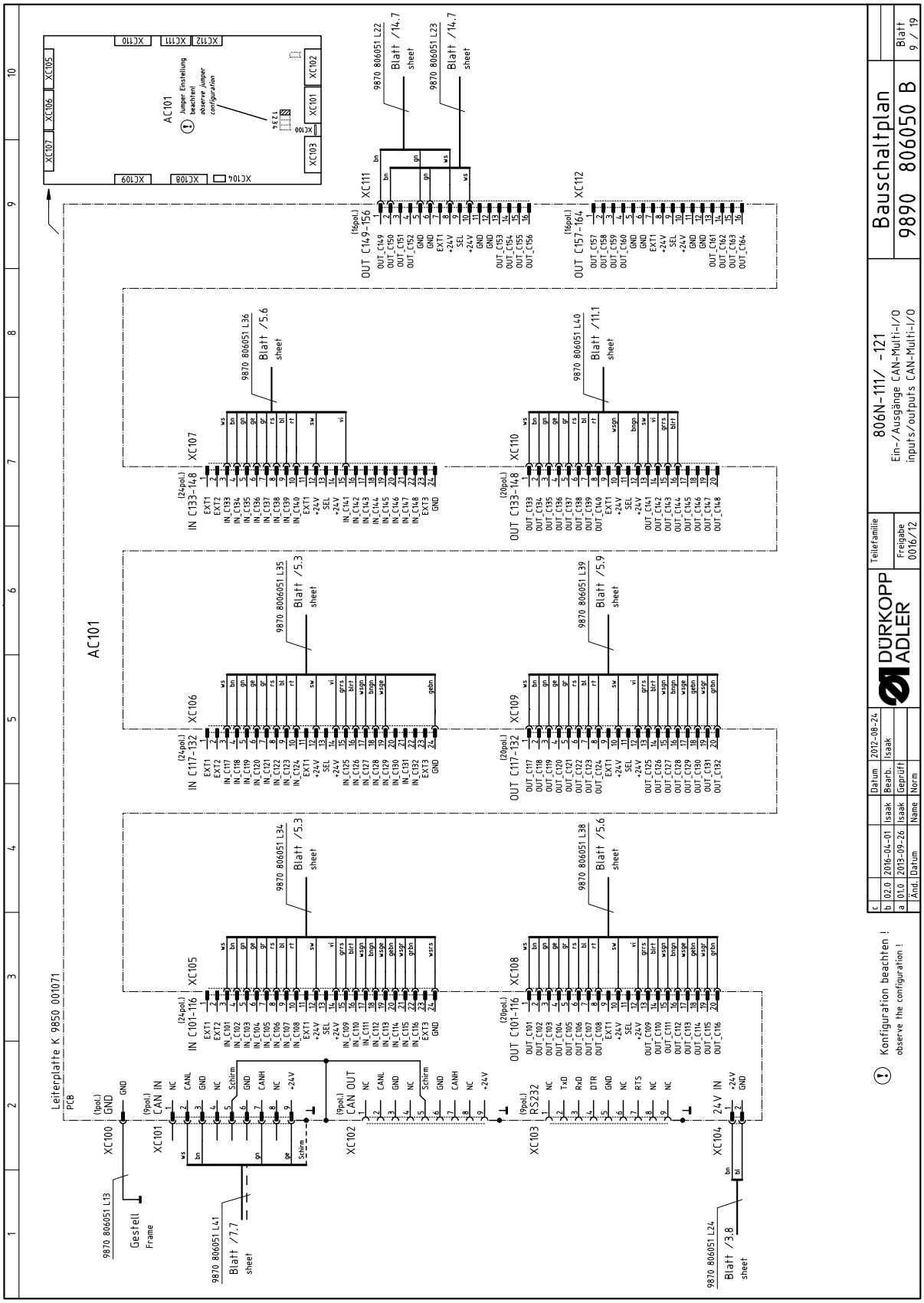

Bauschaltplan
9890 806050 B
806N-111/ -121
IN/OUT Verteilerplatine
I/O board
DÜRKOPP ADLER
Teilefamilie
Freigabe 0016/12
Leiterplatte K 9850 806009
PCB
AC102
SUB-D 25pol. IN/OUT 1-8 XV109
SUB-D 25pol. IN/OUT 9-16 XV110
C-Grid 16pol. Transferhebel XV111
Micro-Fit 12pol. Stapler XV112
Micro-Fit 12pol. Ausroller XV113
C-Grid 16pol. Umbug IN XV114
C-Grid 16pol. Gestell XV115
C-Grid 14pol. Umbug OUT_1 XV116A
C-Grid 14pol. Umbug OUT_2 XV116B
9870 806051 L26
9870 806051 L27
9870 806051 L28
9870 806051 L29
9870 806051 L30
9870 806051 L31
9870 806051 L32
9870 806051 L33
Blatt /3.7
Blatt /7.4
Blatt /14.1
Blatt /13.1
Blatt /12.1
Blatt /11.1
weiter auf
sheet

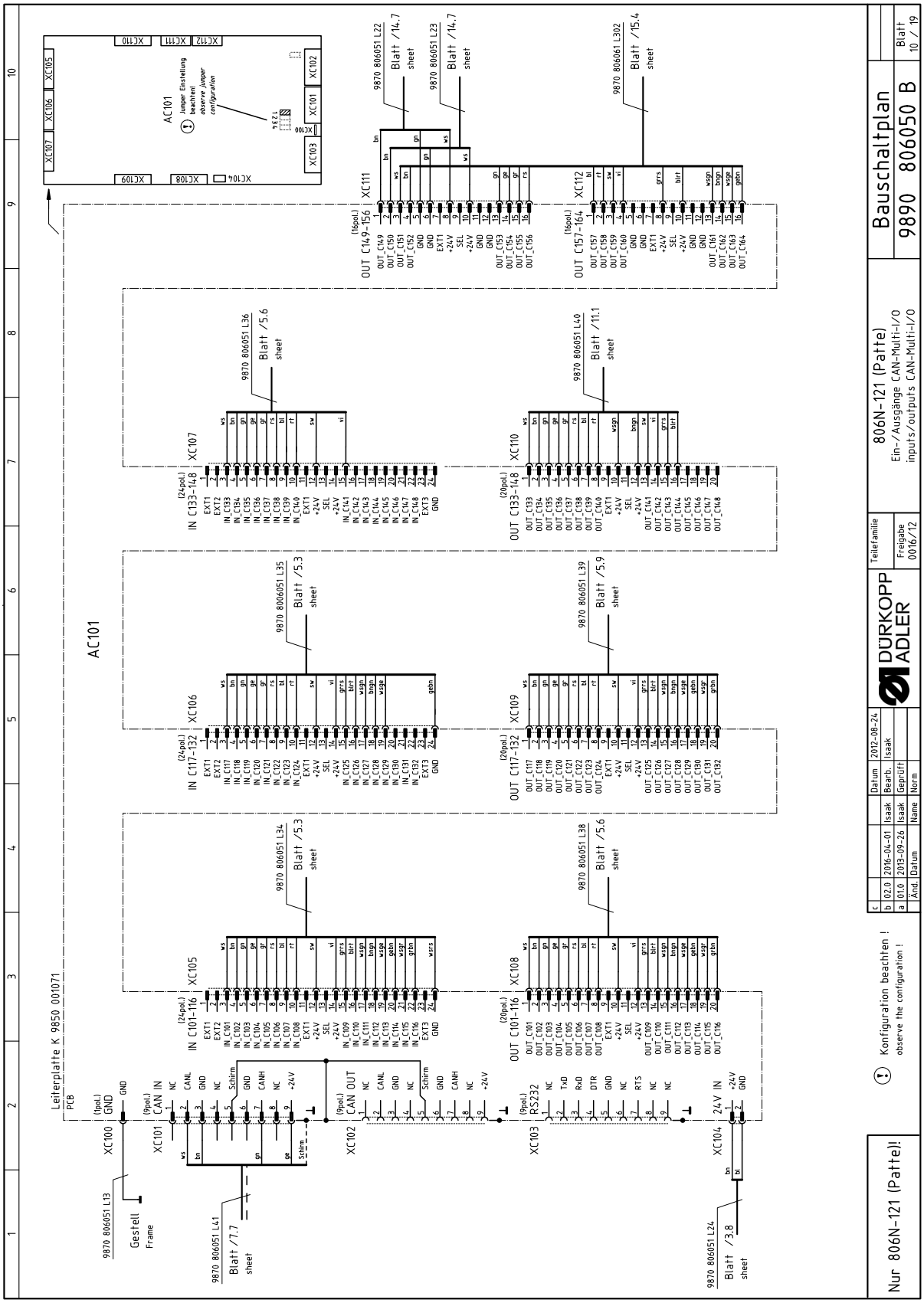

Bauschaltplan
9890 806050 B
806N-111/ -121
IN/OUT Verteilerplatine
I/O board
Leiterplatte K 9850 806009
PCB
AC102
XV117
XV118
XV119
XV120
XV121
XV122
XV123
XV124
C-Grid 24pol. IN 101-116
C-Grid 24pol. IN 117-132
C-Grid 24pol. IN 133-148
C-Grid 7pol. REF
C-Grid 20pol. OUT 101-116
C-Grid 20pol. OUT 117-132
Micro-Fit 24pol. Nähstation
C-Grid 3pol. REF_NM
9870 806051 L34
9870 8006051 L35
9870 806051 L36
9870 806051 L37
9870 806051 L38
9870 806051 L39
9870 806051 L43
9870 806051 L44

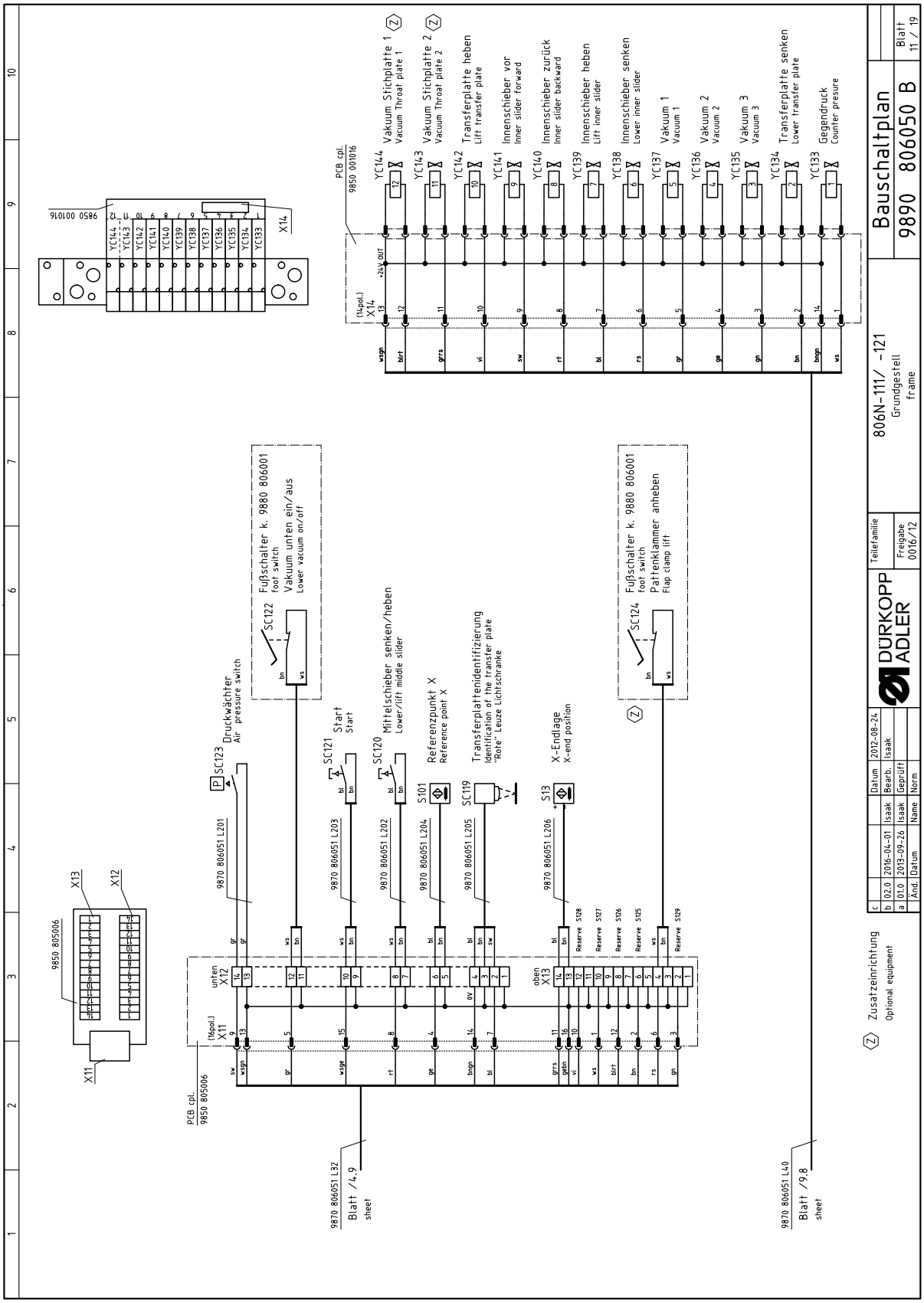

Steuerung k DAC III, Variante 1
9850 001220
control DAC III, variant 1
Blatt /1.10
sheet
Netz
power
F4.00 FF6,3A
F4.04 FF6,3A
Schrittmotor Z-Achse
stepping motor Z-axis
Encoder Z-Achse
encoder Z-axis
Schrittmotor Y-Achse
stepping motor Y-axis
Encoder Y-Achse
encoder Y-axis
Schrittmotor X-Achse
stepping motor X-axis
Encoder X-Achse
encoder X-axis
Nähmotor
sewing motor
Encoder Nähmotor
encoder sewing motor
A1
X50
X40
X30
X20
X301t
X301b
X300t
X300b
9870 806051 L51
9870 806051 L50
9870 806051 L49
9870 806051 L48
9870 806051 L47
L46
L45
Auswerfermotor
Blatt /13.1
M3
M3.1
M2
M2.1
M1
M1.1
X7
X6
X5
X4
806N-111/ -121
DAC3 Nähmotor, Schrittmotoren
DAC3 sewing drive, stepper motors
Bauschaltplan
9890 806050 B
Blatt 6 / 19
Zusatzeinrichtung
optional equipment

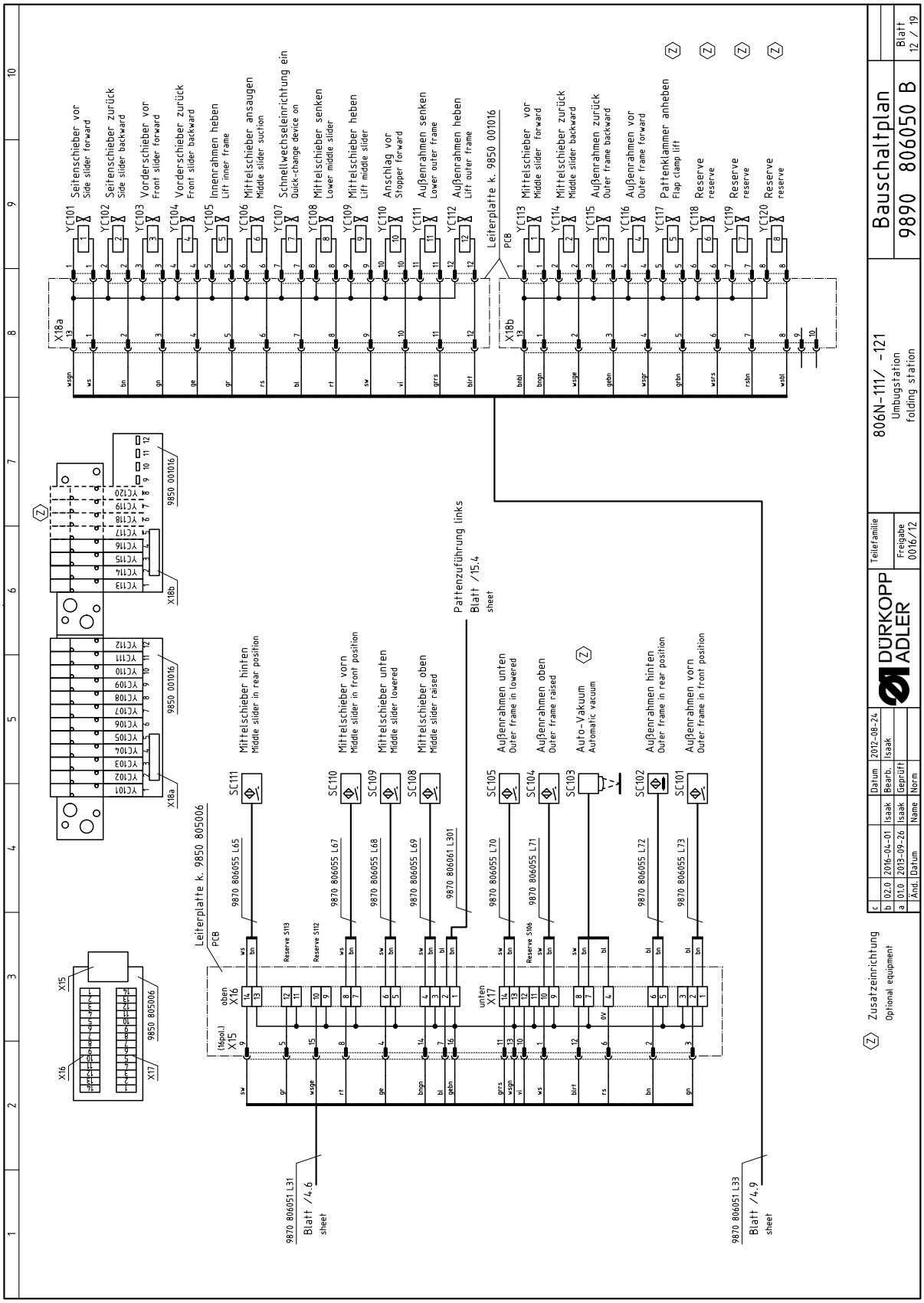

Steuerung k DAC III, Variante 1
9850 001200
control DAC III, variant 1
A1
806N-111/ -121
DAC3 Ein- / Ausgänge
DAC3 In- / Outputs
Bauschaltplan
9890 806050 B
Blatt 7 / 19
Teilefamilie
Freigabe 0016/12
DÜRKOPP ADLER
Datum 2012-08-24
Bearb. Isaak
Geprüft
Norm
Name Isaak Isaak
Datum 2016-04-01 2013-09-26
And.
c
b 02.0
a 01.0
Kodierung
coding
Panel PC
A2
Pegelwandler
9850 001096
Bedienfeld
control panel
Tastenfeld
keypad
sicherer Halt
safety stop
PWM
Ref.-Signale
CAN-Schnittstelle
CAN interface
BDE-Schnittstelle
PDA-interface
Ein-/Ausgänge 1-8
I/O 1-8
Ein-/Ausgänge 9-16
I/O 9-16
Stepper 1-2 Signale
stepper 1-2 signals
Stepper 3-4 Signale
stepper 3-4 signals
Diag-Schnittstelle
test interface

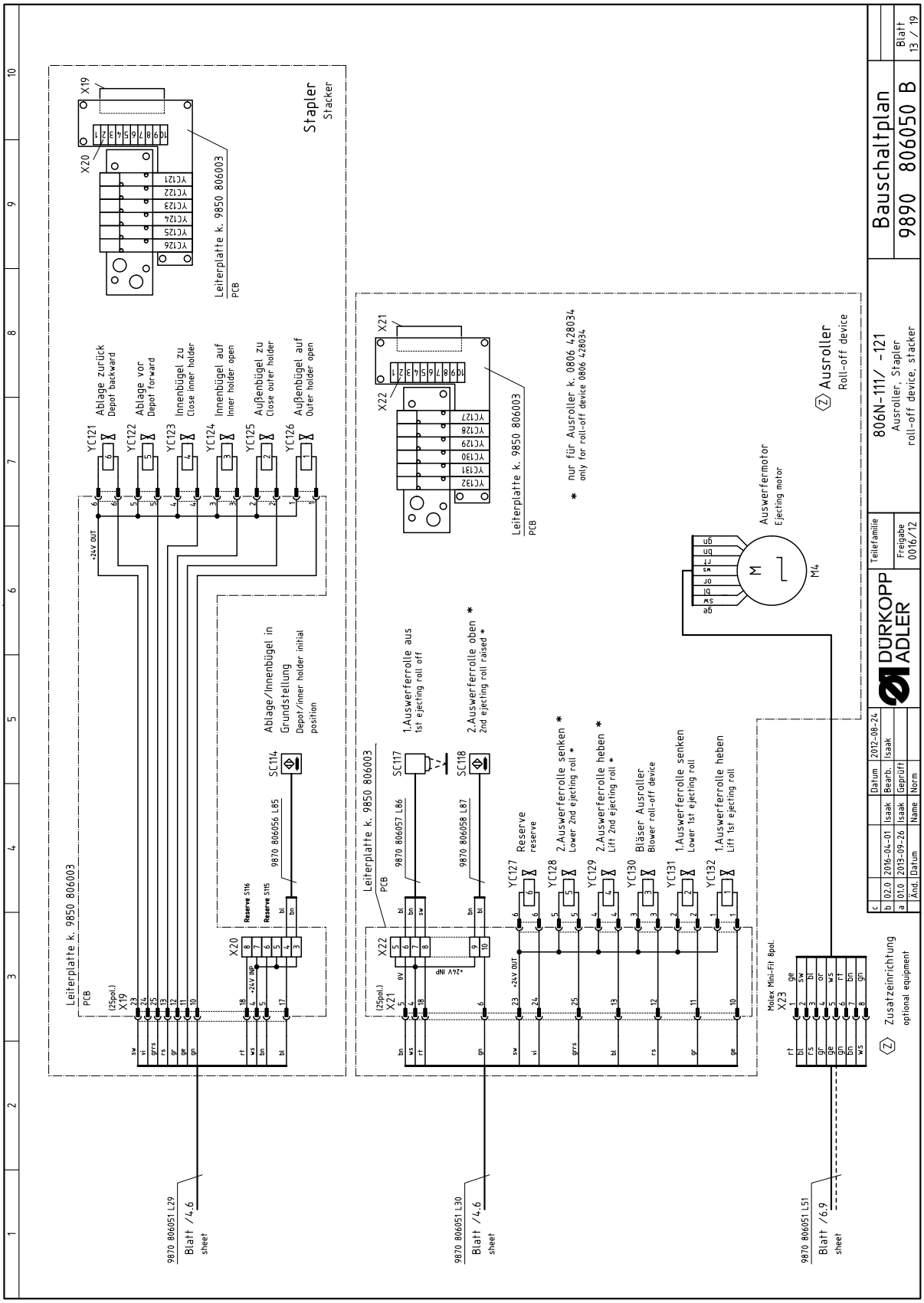

Bauschaltplan
9890 806050 B
Blatt 8 / 19
806N-111/ -121
DAC3 Übersicht
DAC3 overview
DÜRKOPP ADLER
Teilefamilie
Freigabe 0016/12
Steuerung k
DAC III Variante 1
9850 001200
control
DAC III, variant 1
Zusatzeinrichtung
optional equipment
A1
F401 T6,3A
F402 T6,3A
F403 T6,3A
Jumper
Save Stop X201
Fuse FF6,3A F400
REF X140b
En (Y) X30b
En (SD) X30b
Panel X170
Keypad X160
Data X150b
IO 1-8 X120b
Dongle X110
SM 1-2 X100b
Power
Fuse FF6,3A F404
PWM X140f
En (Z) X30f
En (X) X30f
CAN X150f
IO 9-16 X120f
SM 3-4 X100f
M1
9870 806051 L48
9870 806051 L50
9870 806051 L51
9870 806051 L20
9870 806051 L37
9870 806051 L42
9870 806051 L49
M1.1
9870 806051 L47
9850 001096
9870 806051 L41
9870 806051 L27
9870 806051 L26
9870 806051 L25

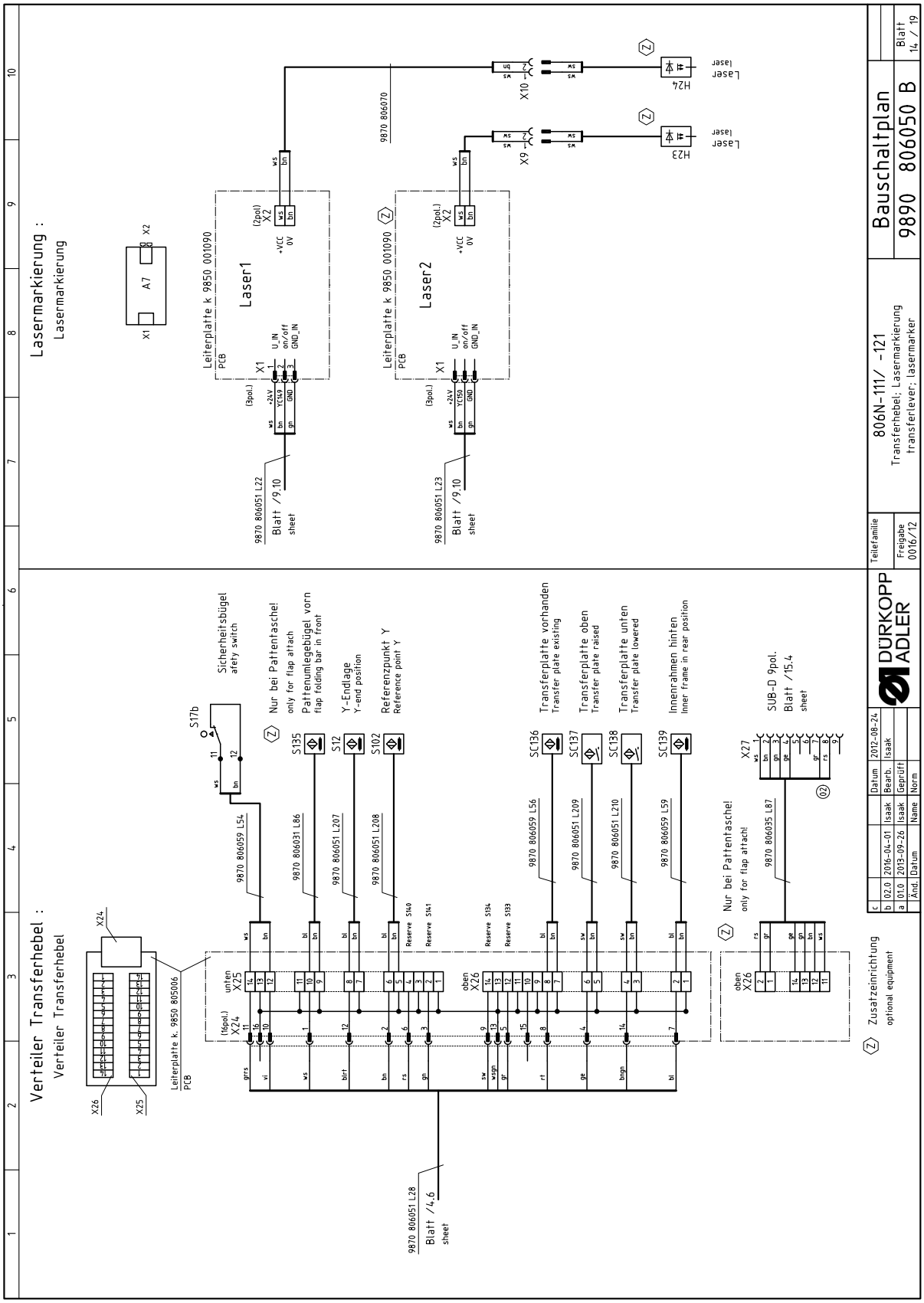

AC101
Leiterplatte K 9850 001071
PCB
Bauschaltplan
9890 806050 B
806N-111/ -121
Ein-/Ausgänge CAN-Multi-I/O
inputs/outputs CAN-Multi-I/O
Konfiguration beachten !
observe the configuration !
XC100
XC101
XC102
XC103
XC104
XC105
XC106
XC107
XC108
XC109
XC110
XC111
XC112
IN C133-148
OUT C133-148
IN C117-132
OUT C117-132
IN C101-116
OUT C101-116
OUT C149-156
OUT C157-164
Gestell
Frame
CAN IN
CAN OUT
RS232
24V IN

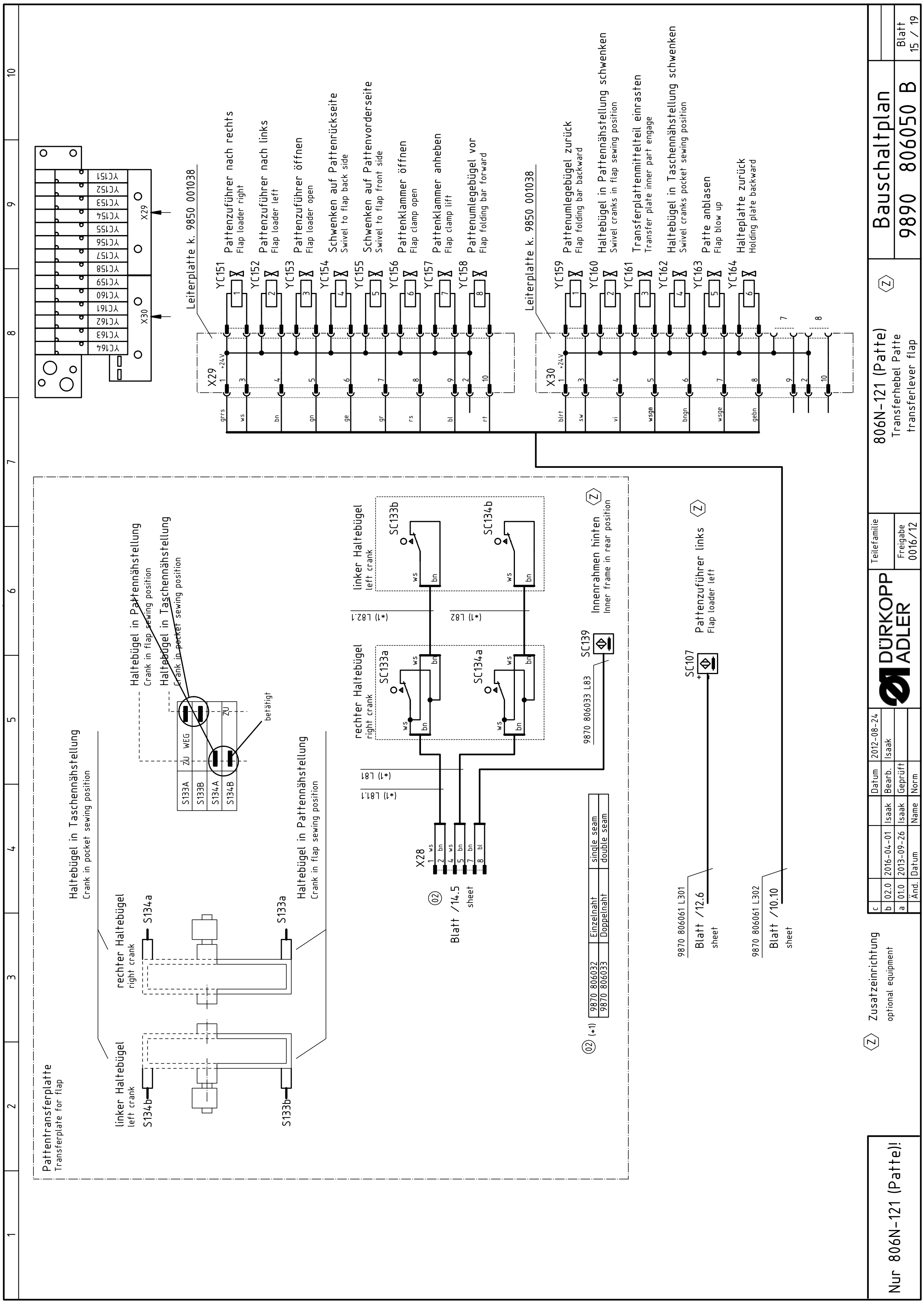

Bauschaltplan
9890 806050 B
806N-121 (Pattel)
Ein-/Ausgänge CAN-Multi-I/O
inputs/outputs CAN-Multi-I/O
Nur 806N-121 (Pattel)
Konfiguration beachten !
observe the configuration !
Leiterplatte K 9850 001071
PCB
AC101
XC100
XC101
XC102
XC103
XC104
XC105
XC106
XC107
XC108
XC109
XC110
XC111
XC112
Gestell
Frame
CAN IN
CAN OUT
RS232
24V IN
IN C101-116
IN C117-132
IN C133-148
OUT C101-116
OUT C117-132
OUT C133-148
OUT C149-156
OUT C157-164


Bauschaltplan
9890 806050 B
Blatt 11 / 19
806N-111/ -121
Grundgestell
frame
Zusatzeinrichtung
Optional equipment
PCB cpl. 9850 001016
PCB cpl. 9850 805006
Vakuum Stichplatte 1
Vacuum Throat plate 1
Vakuum Stichplatte 2
Vacuum Throat plate 2
Transferplatte heben
Lift transfer plate
Innenschieber vor
Inner slider forward
Innenschieber zurück
Inner slider backward
Innenschieber heben
Lift inner slider
Innenschieber senken
Lower inner slider
Vakuum 1
Vacuum 1
Vakuum 2
Vacuum 2
Vakuum 3
Vacuum 3
Transferplatte senken
Lower transfer plate
Gegendruck
Counter pressure
Fußschalter k. 9880 806001
foot switch
Vakuum unten ein/aus
Lower vacuum on/off
Druckwächter
Air pressure switch
Start
Start
Mittelschieber senken/heben
Lower/lift middle slider
Referenzpunkt X
Reference point X
Transferplattenidentifizierung
Identification of the transfer plate
"Rote" Leuze Lichtschranke
X-Endlage
X-end position
Fußschalter k. 9880 806001
foot switch
Paffenklammer anheben
Flap clamp lift
9870 806051 L32
Blatt /4.9
sheet
9870 806051 L40
Blatt /9.8
sheet

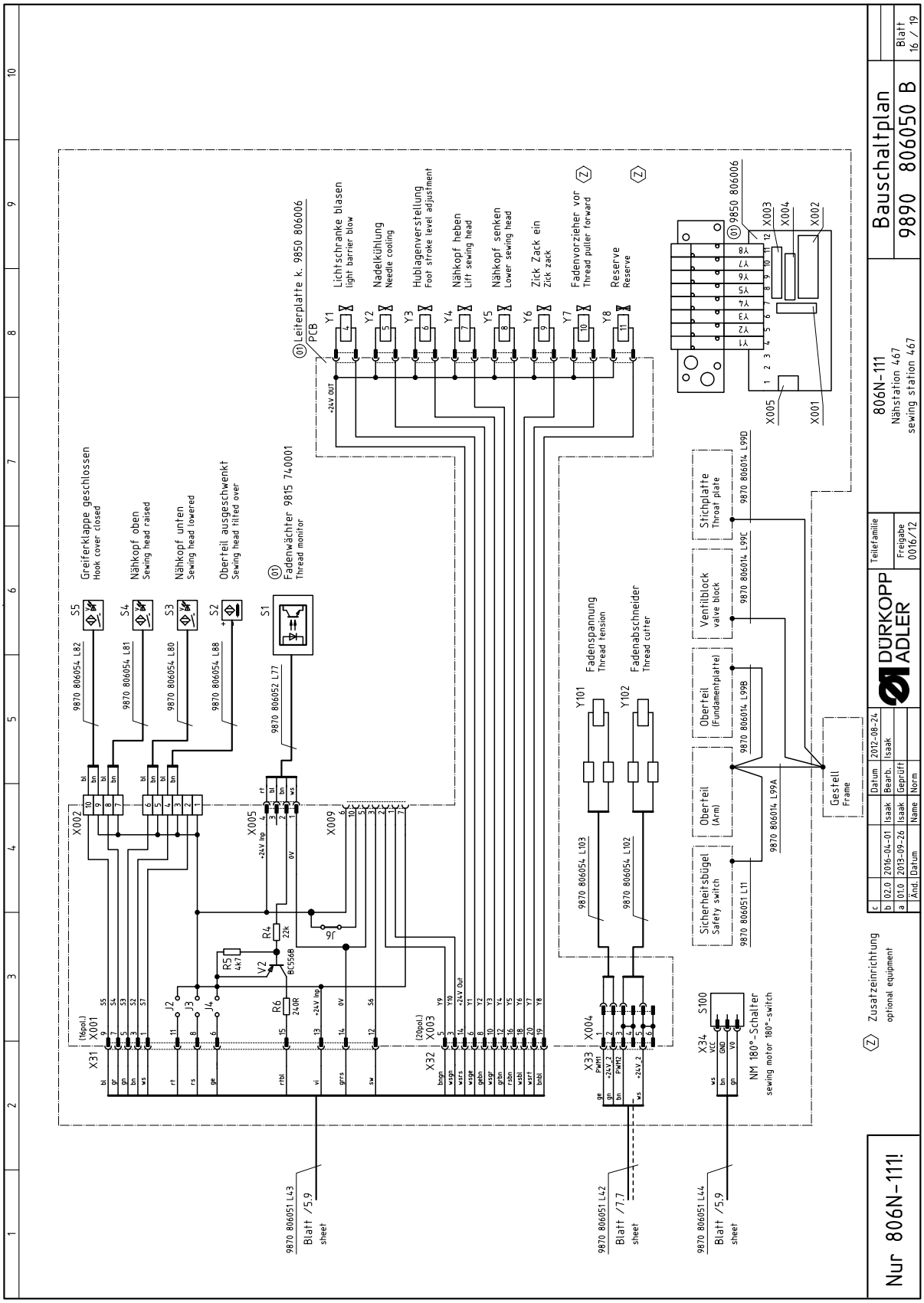

Bauschaltplan
9890 806050 B
Blatt 12 / 19
806N-111/ -121
Umbugstation
folding station
DÜRKOPP ADLER
Teilefamilie
Freigabe 0016/12
Zusatzeinrichtung
Optional equipment
Leiterplatte k. 9850 805006
Leiterplatte k. 9850 001016
Pattenzuführung links
Blatt /15.4
Blatt /4.6
Blatt /4.9
Seitenschieber vor
Side slider forward
Seitenschieber zurück
Side slider backward
Vorderschieber vor
Front slider forward
Vorderschieber zurück
Front slider backward
Innenrahmen heben
Lift inner frame
Mittelschieber ansaugen
Middle slider suction
Schnellwechseleinrichtung ein
Quick-change device on
Mittelschieber senken
Lower middle slider
Mittelschieber heben
Lift middle slider
Anschlag vor
Stopper forward
Außenrahmen senken
Lower outer frame
Außenrahmen heben
Lift outer frame
Mittelschieber vor
Middle slider forward
Mittelschieber zurück
Middle slider backward
Außenrahmen zurück
Outer frame backward
Außenrahmen vor
Outer frame forward
Pattenklammer anheben
Flap clamp lift
Reserve
reserve
Mittelschieber hinten
Middle slider in rear position
Mittelschieber vorn
Middle slider in front position
Mittelschieber unten
Middle slider lowered
Mittelschieber oben
Middle slider raised
Außenrahmen unten
Outer frame in lowered
Außenrahmen oben
Outer frame raised
Auto-Vakuum
Automatic vacuum
Außenrahmen hinten
Outer frame in rear position
Außenrahmen vorn
Outer frame in front position

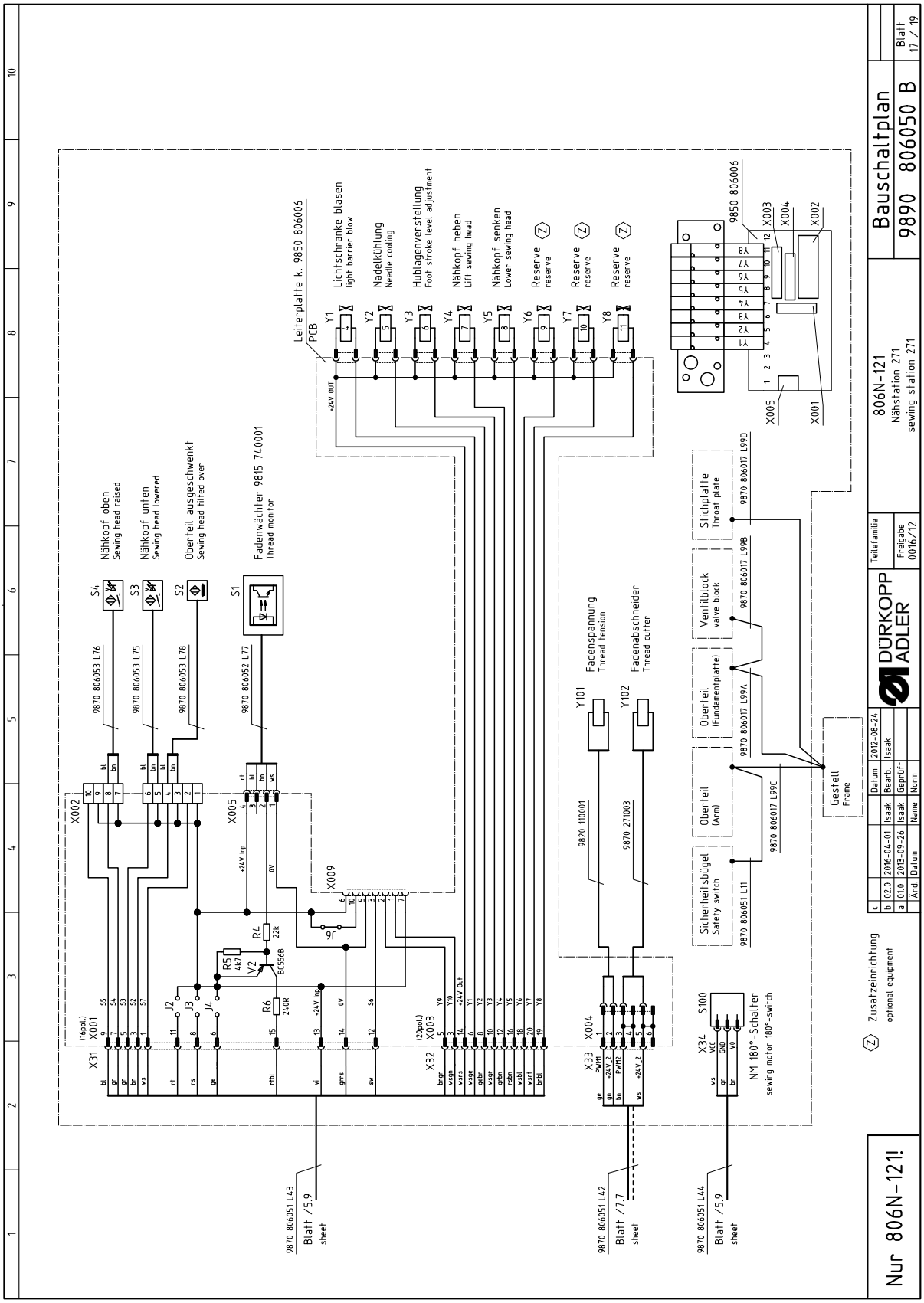

Stapler
Stacker
Leiterplatte k. 9850 806003
PCB
X19
X20
YC121
YC122
YC123
YC124
YC125
YC126
Ablage zurück
Depot backward
Ablage vor
Depot forward
Innenbügel zu
Close inner holder
Innenbügel auf
Inner holder open
Außenbügel zu
Close outer holder
Außenbügel auf
Outer holder open
+24V OUT
Ablage/Innenbügel in Grundstellung
Depot/inner holder initial position
SC114
9870 806056 L85
Reserve S116
Reserve S115
(25pol.)
X21
X22
9870 806057 L86
9870 806058 L87
SC117
SC118
1.Auswerferrolle aus
1st ejecting roll off
2.Auswerferrolle oben *
2nd ejecting roll raised *
+24V INP
0V
YC127
YC128
YC129
YC130
YC131
YC132
Reserve
reserve
2.Auswerferrolle senken *
Lower 2nd ejecting roll *
2.Auswerferrolle heben *
Lift 2nd ejecting roll *
Bläser Ausroller
Blower roll-off device
1.Auswerferrolle senken
Lower 1st ejecting roll
1.Auswerferrolle heben
Lift 1st ejecting roll
Molex Mini-Fit 8pol.
X23
Zusatzeinrichtung
optional equipment
9870 806051 L29
Blatt /4.6
sheet
9870 806051 L30
Blatt /4.6
sheet
9870 806051 L51
Blatt /6.9
sheet
Ausroller
Roll-off device
* nur für Ausroller k. 0806 428034
only for roll-off device 0806 428034
Auswerfermotor
Ejecting motor
M4
DÜRKOPP ADLER
Teilefamilie
Freigabe
0016/12
806N-111/ -121
Ausroller, Stapler
roll-off device, stacker
Bauschaltplan
9890 806050 B
Blatt
13 / 19
c
b 02.0 2016-04-01 Isaak
a 01.0 2013-09-26 Isaak
And. Datum Name
Datum 2012-08-24
Bearb. Isaak
Geprüft
Norm


Lasermarkierung :
Lasermarkierung
Verteiler Transferhebel :
Verteiler Transferhebel
Leiterplatte k 9850 001090
Laser1
Laser2
Leiterplatte k. 9850 805006
Sicherheitsbügel
afety switch
Nur bei Pattentasche!
only for flap attach
Pattenumlegebügel vorn
flap folding bar in front
Y-Endlage
Y-end position
Referenzpunkt Y
Reference point Y
Transferplatte vorhanden
Transfer plate existing
Transferplatte oben
Transfer plate raised
Transferplatte unten
Transfer plate lowered
Innenrahmen hinten
Inner frame in rear position
SUB-D 9pol.
Blatt /15.4
sheet
Zusatzeinrichtung
optional equipment
806N-111/ -121
Transferhebel; Lasermarkierung
transferlever; lasermarker
Bauschaltplan
9890 806050 B
Blatt
14 / 19
DÜRKOPP ADLER



Bauschaltplan
9890 806050 B
Blatt 15 / 19
806N-121 (Patte)
Transferhebel Patte
transferlever flap
Nur 806N-121 (Patte)!
Zusatzeinrichtung
optional equipment
Leiterplatte k. 9850 001038
X29
X30
YC151 Pattenzuführer nach rechts
Flap loader right
YC152 Pattenzuführer nach links
Flap loader left
YC153 Pattenzuführer öffnen
Flap loader open
YC154 Schwenken auf Pattenrückseite
Swivel to flap back side
YC155 Schwenken auf Pattenvorderseite
Swivel to flap front side
YC156 Pattenklammer öffnen
Flap clamp open
YC157 Pattenklammer anheben
Flap clamp lift
YC158 Pattenumlegebügel vor
Flap folding bar forward
YC159 Pattenumlegebügel zurück
Flap folding bar backward
YC160 Haltebügel in Pattennähstellung schwenken
Swivel cranks in flap sewing position
YC161 Transferplattenmittelteil einrasten
Transfer plate inner part engage
YC162 Haltebügel in Taschennähstellung schwenken
Swivel cranks pocket sewing position
YC163 Patte anblasen
Flap blow up
YC164 Halteplatte zurück
Holding plate backward
Pattentransferplatte
Transferplate for flap
linker Haltebügel
left crank
rechter Haltebügel
right crank
Haltebügel in Taschennähstellung
Crank in pocket sewing position
Haltebügel in Pattennähstellung
Crank in flap sewing position
S133a
S133b
S134a
S134b
betätigt
SC133a
SC133b
SC134a
SC134b
Innenrahmen hinten
Inner frame in rear position
SC139
9870 806033 L83
Pattenzuführer links
Flap loader left
SC107
X28
Blatt /14.5
sheet
9870 806061 L301
Blatt /12.6
sheet
9870 806061 L302
Blatt /10.10
sheet
9870 806032 Einzelnaht single seam
9870 806033 Doppelnaht double seam
DÜRKOPP ADLER


Bauschaltplan
9890 806050 B
Blatt 16 / 19
806N-111
Nähstation 467
sewing station 467
Nur 806N-111!
Greiferklappe geschlossen
Hook cover closed
Nähkopf oben
Sewing head raised
Nähkopf unten
Sewing head lowered
Oberteil ausgeschwenkt
Sewing head tilted over
Fadenwächter 9815 740001
Thread monitor
Leiterplatte k. 9850 806006
PCB
Lichtschranke blasen
light barrier blow
Nadelkühlung
Needle cooling
Hublagenverstellung
Foot stroke level adjustment
Nähkopf heben
Lift sewing head
Nähkopf senken
Lower sewing head
Zick Zack ein
Zick zack
Fadenvorzieher vor
Thread puller forward
Reserve
Reserve
Fadenspannung
Thread tension
Fadenabschneider
Thread cutter
Ventilblock
valve block
Stichplatte
Throat plate
Oberteil
(Fundamentplatte)
Oberteil
(Arm)
Sicherheitsbügel
Safety switch
Gestell
Frame
NM 180°-Schalter
sewing motor 180°-switch
Zusatzeinrichtung
optional equipment


Bauschaltplan
9890 806050 B
806N-121
Nähstation 271
sewing station 271
Blatt 17 / 19
Nur 806N-121!
Leiterplatte k. 9850 806006
PCB
Lichtschranke blasen
light barrier blow
Nadelkühlung
Needle cooling
Hublagenverstellung
Foot stroke level adjustment
Nähkopf heben
Lift sewing head
Nähkopf senken
Lower sewing head
Reserve
reserve
Nähkopf oben
Sewing head raised
Nähkopf unten
Sewing head lowered
Oberteil ausgeschwenkt
Sewing head tilted over
Fadenwächter 9815 740001
Thread monitor
Fadenspannung
Thread tension
Fadenabschneider
Thread cutter
Stichplatte
Throat plate
Ventilblock
valve block
Oberteil
(Fundamentplatte)
Oberteil
(Arm)
Sicherheitsbügel
Safety switch
Gestell
Frame
NM 180°-Schalter
sewing motor 180°-switch
Zusatzeinrichtung
optional equipment
DÜRKOPP ADLER
Teilefamilie
Freigabe
0016/12
Datum
Bearb.
Geprüft
Norm
Name
Blatt /5.9
Blatt /7.7
Blatt /5.9
sheet

⑪ Ein-/ Ausgangsliste Klasse 806 / 806N

Nähstation Eingänge

806	806N	DAC 3	Bezeichnung
S1	S1	IN_01	Fadenwächter
S20	S2	IN_02	Oberteil ausgeschwenkt
S21	S3	IN_03	Nähkopf unten
S22	S4	IN_04	Nähkopf oben
S23	S5	IN_05	Greiferklappe geschlossen (467)
S24	S6	IN_06	Restfadenwächter (271)
S25	S7	IN_07	Reserve

Umbugstation Eingänge

806	806N	DAC 3	Bezeichnung
S2	SC101	IN_C101	Außenrahmen vorn
S3	SC102	IN_C102	Außenrahmen hinten
S4	SC103	IN_C103	Ⓩ Auto-Vakuum
S6	SC104	IN_C104	Außenrahmen oben
S8	SC105	IN_C105	Außenrahmen unten
S7	SC106	IN_C106	Reserve
S9	SC107	IN_C107	Ⓩ Pattenzuführer links (Patte)
S10	SC108	IN_C108	Mittelschieber oben
S11	SC109	IN_C109	Mittelschieber unten
S12	SC110	IN_C110	Mittelschieber vorn
S15	SC111	IN_C111	Mittelschieber hinten
S13	SC112	IN_C112	Reserve
S14	SC113	IN_C113	Reserve

Stapler Eingänge

806	806N	DAC 3	Bezeichnung
S29	SC114	IN_C114	Ablage/Innenbügel in Grundstellung
S27	SC115	IN_C115	Reserve
S28	SC116	IN_C116	Reserve

Ⓩ Ausroller Eingänge

806	806N	DAC 3	Bezeichnung
S30	SC117	IN_C117	1. Auswerferrolle aus
S31	SC118	IN_C118	Ⓩ 2. Auswerferrolle oben

Grundgestell Eingänge

806	806N	DAC 3	Bezeichnung
S33	S101	REF_X	Referenz X-Achse
S34	SC119	IN_C119	Transferplattenidentifizierung
S35	SC120	IN_C120	Mittelschieber senken/heben
S36	SC121	IN_C121	Start
S37	SC122	IN_C122	Fußschalter Vakuum unten ein/aus
S38	SC123	IN_C123	Druckwächter
NEU	SC124	IN_C124	Ⓩ Fußschalter Pattenklammer
NEU	SC125	IN_C125	Reserve
NEU	SC126	IN_C126	Reserve
S43	SC127	IN_C127	Reserve
S44	SC128	IN_C128	Reserve
NEU	SC129	IN_C129	Reserve
S45	S13	IN_13	X-Endlage

Tastenleiste Eingänge

806	806N	DAC 3	Bezeichnung
S50	S17	K4/IN_17	NOT-AUS
S51	S14	IN_14	STOP
S52	S15	IN_15	ON
S53	S16	IN_16	Wiederholung

Transferhebel Eingänge

806	806N	DAC 3	Bezeichnung
S99	S17	K4/IN_17	NOT-AUS Sicherheitsbügel
S59	S12	IN_12	Y-Endlage
S60	S102	REF_Y	Referenz Y-Achse
S57	SC133	IN_C133	Ⓩ Haltebügel in Pattennähstellung
S58	SC134	IN_C134	Ⓩ Haltebügel in Taschennähstellg.
S47	SC135	IN_C135	Ⓩ Pattenumlegebügel vorn
S61	SC136	IN_C136	Transferplatte vorhanden
S62	SC137	IN_C137	Transferplatte oben
S63	SC138	IN_C138	Transferplatte unten
S64	SC139	IN_C139	Innenrahmen hinten
NEU	SC140	IN_C140	Reserve
NEU	SC141	IN_C141	Reserve

Nähstation Ausgänge

806	806N	DAC 3	Bezeichnung
Y34	Y01	OUT_01	Lichtschranke blasen
Y35	Y02	OUT_02	Nadelkühlung
Y36	Y03	OUT_03	Hublagenverstellung
Y37	Y04	OUT_04	Nähkopf heben
Y38	Y05	OUT_05	Nähkopf senken
Y39	Y06	OUT_06	Zick-Zack ein (467)
Y42	Y07	OUT_07	Ⓩ Fadenvorzieher vor (467)
Y43	Y08	OUT_08	Ⓩ Reserve
Y40	Y09	OUT_09	Reset FW (nicht bei 806N)
Y41	Y10	OUT_10	Empf. FW (nicht bei 806N)

Umbugstation Ausgänge

806	806N	DAC 3	Bezeichnung
Y10	YC101	OUT_C101	Seitenschieber vor
Y11	YC102	OUT_C102	Seitenschieber zurück
Y12	YC103	OUT_C103	Vorderschieber vor
Y13	YC104	OUT_C104	Vorderschieber zurück
Y16	YC105	OUT_C105	Innenrahmen heben
Y14	YC106	OUT_C106	Mittelschieber ansaugen
Y15	YC107	OUT_C107	Schnellwechseleinrichtung ein
Y6	YC108	OUT_C108	Mittelschieber senken
Y5	YC109	OUT_C109	Mittelschieber heben
Y9	YC110	OUT_C110	Anschlag vor

Umbugstation Ausgänge

806	806N	DAC 3	Bezeichnung
Y2	YC111	OUT_C111	Außenrahmen senken
Y1	YC112	OUT_C112	Außenrahmen heben
Y7	YC113	OUT_C113	Mittelschieber vor
Y8	YC114	OUT_C114	Mittelschieber zurück
Y4	YC115	OUT_C115	Außenrahmen zurück
Y3	YC116	OUT_C116	Außenrahmen vor
Y17	YC117	OUT_C117	Ⓩ Pattenklammer anheben (Patte)
Y18	YC118	OUT_C118	Ⓩ Reserve
Y19	YC119	OUT_C119	Ⓩ Reserve
Y20	YC120	OUT_C120	Ⓩ Reserve

Stapler Ausgänge

806	806N	DAC 3	Bezeichnung
Y27	YC121	OUT_C121	Ablage zurück
Y28	YC122	OUT_C122	Ablage vor
Y29	YC123	OUT_C123	Innenbügel zu
Y30	YC124	OUT_C124	Innenbügel auf
Y31	YC125	OUT_C125	Außenbügel zu
Y32	YC126	OUT_C126	Außenbügel auf

Ⓩ Ausroller Ausgänge

806	806N	DAC 3	Bezeichnung
Y59	YC127	OUT_C127	Ⓩ Reserve
Y60	YC128	OUT_C128	Ⓩ 2. Auswerferrolle senken
Y61	YC129	OUT_C129	Ⓩ 2. Auswerferrolle heben
Y62	YC130	OUT_C130	Bläser Ausroller
Y63	YC131	OUT_C131	1. Auswerferrolle senken
Y64	YC132	OUT_C132	1. Auswerferrolle heben

Grundgestell Ausgänge

806	806N	DAC 3	Bezeichnung
Y53	YC133	OUT_C133	Gegendruck
Y48	YC134	OUT_C134	Transferplatte senken
Y56	YC135	OUT_C135	Vakuum 3
Y55	YC136	OUT_C136	Vakuum 2
Y54	YC137	OUT_C137	Vakuum 1
Y52	YC138	OUT_C138	Innenschieber senken
Y51	YC139	OUT_C139	Innenschieber heben
Y50	YC140	OUT_C140	Innenschieber zurück
Y49	YC141	OUT_C141	Innenschieber vor
Y47	YC142	OUT_C142	Transferplatte heben
Y57	YC143	OUT_C143	Ⓩ Vakuum Stichplatte 2 (Patte)
Y58	YC144	OUT_C144	Ⓩ Vakuum Stichplatte 1 (Patte)

Tastenleiste Ausgänge

806	806N	DAC 3	Bezeichnung
H1	H1	OUT_12	LED "Start"
H2	H2	OUT_11	LED "Sicherer Halt"

Laser Ausgänge

806	806N	DAC 3	Bezeichnung
NEU	YC149	OUT_C149	Ⓩ Laser 1
NEU	YC150	OUT_C150	Ⓩ Laser 2

Ⓩ Ausgänge Patte

806	806N	DAC 3	Bezeichnung
Y65	YC151	OUT_C151	Pattenzuführer nach rechts
Y66	YC152	OUT_C152	Pattenzuführer nach links
Y67	YC153	OUT_C153	Pattenzuführer öffnen
Y68	YC154	OUT_C154	Schwenken auf Pattenrückseite
Y69	YC155	OUT_C155	Schwenken auf Pattenvorderseite
Y70	YC156	OUT_C156	Pattenklammer öffnen
Y71	YC157	OUT_C157	Pattenklammer anheben
Y72	YC158	OUT_C158	Pattenumlegebügel vor
Y73	YC159	OUT_C159	Pattenumlegebügel zurück
Y74	YC160	OUT_C160	Haltebügel in Pattennähstellung schwenken
Y75	YC161	OUT_C161	Transferplattenmittelteil einrasten
Y76	YC162	OUT_C162	Haltebügel in Taschennähstellung schwenken
Y77	YC163	OUT_C163	Patte anblasen
Y78	YC164	OUT_C164	Halteplatte zurück

c				Datum	2012-08-24
b	02.0	2016-04-01	Isaak	Bearb.	Isaak
a	01.0	2013-09-26	Isaak	Geprüft	
	Änd.	Datum	Name	Norm	

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Teilefamilie

Freigabe 0016/12

806N-111/ -121
Ein- /Ausgangsliste

Bauschaltplan
9890 806050 B

Blatt 18 / 19

⓪① I-/O list class 806 / 806N

sewing station inputs

806	806N	DAC 3	Denomination
S1	S1	IN_01	thread monitor
S20	S2	IN_02	sewing head tilted over
S21	S3	IN_03	sewing head lowered
S22	S4	IN_04	sewing head raised
S23	S5	IN_05	hook cover closed (467)
S24	S6	IN_06	bobbin thread monitor (271)
S25	S7	IN_07	reserve

folding station inputs

806	806N	DAC 3	Denomination
S2	SC101	IN_C101	outer frame in front position
S3	SC102	IN_C102	outer frame in rear position
S4	SC103	IN_C103	Ⓩ automatic vacuum
S6	SC104	IN_C104	outer frame raised
S8	SC105	IN_C105	outer frame lowered
S7	SC106	IN_C106	reserve
S9	SC107	IN_C107	Ⓩ flap loader left (flap)
S10	SC108	IN_C108	middle slider raised
S11	SC109	IN_C109	middle slider lowered
S12	SC110	IN_C110	middle slider in front position
S15	SC111	IN_C111	middle slider in rear position
S13	SC112	IN_C112	reserve
S14	SC113	IN_C113	reserve

stacker inputs

806	806N	DAC 3	Denomination
S29	SC114	IN_C114	depot / inner holder initial position
S27	SC115	IN_C115	reserve
S28	SC116	IN_C116	reserve

Ⓩ roll-off device inputs

806	806N	DAC 3	Denomination
S30	SC117	IN_C117	1st ejecting roll off
S31	SC118	IN_C118	Ⓩ 2nd ejecting roll raised

frame inputs

806	806N	DAC 3	Denomination
S33	S101	REF_X	referenz point X-axis
S34	SC119	IN_C119	identification of the transfer plate
S35	SC120	IN_C120	lower / lift middle slider
S36	SC121	IN_C121	start
S37	SC122	IN_C122	foot switch vacuum on/off
S38	SC123	IN_C123	air pressure switch
NEU	SC124	IN_C124	Ⓩ foot switch flap clamp lift
NEU	SC125	IN_C125	reserve
NEU	SC126	IN_C126	reserve
S43	SC127	IN_C127	reserve
S44	SC128	IN_C128	reserve
NEU	SC129	IN_C129	reserve
S45	S13	IN_13	X-end position

key bar inputs

806	806N	DAC 3	Denomination
S50	S17	K4/IN_17	emergency stop
S51	S14	IN_14	STOP
S52	S15	IN_15	ON
S53	S16	IN_16	repeat

transferlever inputs

806	806N	DAC 3	Denomination
S99	S17	K4/IN_17	safety switch
S59	S12	IN_12	Y-end position
S60	S102	REF_Y	referenz Y-axis
S57	SC133	IN_C133	Ⓩ crank in flap sewing position
S58	SC134	IN_C134	Ⓩ crank in pocket sewing position
S47	SC135	IN_C135	Ⓩ flap folding bar in front
S61	SC136	IN_C136	transfer plate existing
S62	SC137	IN_C137	transfer plate raised
S63	SC138	IN_C138	transfer plate lowered
S64	SC139	IN_C139	inner frame in rear position
NEU	SC140	IN_C140	reserve
NEU	SC141	IN_C141	reserve

sewing station outputs

806	806N	DAC 3	Denomination
Y34	Y01	OUT_01	light barrier blow
Y35	Y02	OUT_02	needle cooling
Y36	Y03	OUT_03	foot stroke level adjustment
Y37	Y04	OUT_04	lift sewing head
Y38	Y05	OUT_05	lower sewing head
Y39	Y06	OUT_06	zick-zack on (467)
Y42	Y07	OUT_07	Ⓩ thread puller forward (467)
Y43	Y08	OUT_08	Ⓩ reserve
Y40	Y09	OUT_09	reset thread monitor (not for 806N)
Y41	Y10	OUT_10	recieve thread monitor (n.f. 806N)

folding station outputs

806	806N	DAC 3	Denomination
Y10	YC101	OUT_C101	side slider forward
Y11	YC102	OUT_C102	side slider backward
Y12	YC103	OUT_C103	front slider forward
Y13	YC104	OUT_C104	front slider backward
Y16	YC105	OUT_C105	lift inner frame
Y14	YC106	OUT_C106	middle slider suction
Y15	YC107	OUT_C107	quick-change device on
Y6	YC108	OUT_C108	lower middle slider
Y5	YC109	OUT_C109	lift middle slider
Y9	YC110	OUT_C110	stopper forward

folding station outputs

806	806N	DAC 3	Denomination
Y2	YC111	OUT_C111	lower outer frame
Y1	YC112	OUT_C112	lift outer frame
Y7	YC113	OUT_C113	middle slider forward
Y8	YC114	OUT_C114	middle slider backward
Y4	YC115	OUT_C115	outer frame backward
Y3	YC116	OUT_C116	outer frame forward
Y17	YC117	OUT_C117	Ⓩ flap clamp lift (flap)
Y18	YC118	OUT_C118	Ⓩ reserve
Y19	YC119	OUT_C119	Ⓩ reserve
Y20	YC120	OUT_C120	Ⓩ reserve

stacker outputs

806	806N	DAC 3	Denomination
Y27	YC121	OUT_C121	depot backward
Y28	YC122	OUT_C122	depot forward
Y29	YC123	OUT_C123	close inner holder
Y30	YC124	OUT_C124	open inner holder
Y31	YC125	OUT_C125	close outer holder
Y32	YC126	OUT_C126	open outer holder

Ⓩ roll-off device output

806	806N	DAC 3	Denomination
Y59	YC127	OUT_C127	Ⓩ reserve
Y60	YC128	OUT_C128	Ⓩ lower 2nd ejecting roll
Y61	YC129	OUT_C129	Ⓩ lift 2nd ejecting roll
Y62	YC130	OUT_C130	blower roll-off device
Y63	YC131	OUT_C131	lower 1st ejecting roll
Y64	YC132	OUT_C132	lift 1st ejecting roll

frame outputs

806	806N	DAC 3	Denomination
Y53	YC133	OUT_C133	counter pressure
Y48	YC134	OUT_C134	lower transfer plate
Y56	YC135	OUT_C135	vacuum 3
Y55	YC136	OUT_C136	vacuum 2
Y54	YC137	OUT_C137	vacuum 1
Y52	YC138	OUT_C138	lower inner slider
Y51	YC139	OUT_C139	lift inner slider
Y50	YC140	OUT_C140	inner slider backward
Y49	YC141	OUT_C141	inner slider forward
Y47	YC142	OUT_C142	lift transferplate
Y57	YC143	OUT_C143	Ⓩ vacuum throat plate 2 (flap)
Y58	YC144	OUT_C144	Ⓩ vacuum throat plate 1 (flap)

key bar outputs

806	806N	DAC 3	Denomination
H1	H1	OUT_12	LED "start"
H2	H2	OUT_11	LED "safe stop"

laser outputs

806	806N	DAC 3	Denomination
NEU	YC149	OUT_C149	Ⓩ laser 1
NEU	YC150	OUT_C150	Ⓩ laser 2

Ⓩ outputs flap

806	806N	DAC 3	Denomination
Y65	YC151	OUT_C151	flap loader right
Y66	YC152	OUT_C152	flap loader left
Y67	YC153	OUT_C153	open flap loader
Y68	YC154	OUT_C154	swivel to flap back side
Y69	YC155	OUT_C155	swivel to flap front side
Y70	YC156	OUT_C156	open flap clamp
Y71	YC157	OUT_C157	lift flap clamp
Y72	YC158	OUT_C158	flap folding bar forward
Y73	YC159	OUT_C159	flap folding bar backward
Y74	YC160	OUT_C160	swivel cranks in flap sewing position
Y75	YC161	OUT_C161	transfer plate inner part engage
Y76	YC162	OUT_C162	swivel cranks in pocket sewing position
Y77	YC163	OUT_C163	flap blow up
Y78	YC164	OUT_C164	holding plate backward

c				Datum	2012-08-24
b	02.0	2016-04-01	Isaak	Bearb.	Isaak
a	01.0	2013-09-26	Isaak	Geprüft	
	Änd.	Datum	Name	Norm	

DÜRKOPP ADLER

Teilefamilie
Freigabe 0016/12

806N-111/ -121
input / output list

Bauschaltplan
9890 806050 B

Blatt 19 / 19

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