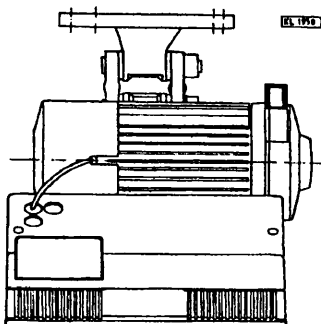


Date: 30/08/94 (gb)

Replacing:

Replaced by:



**FIELD OF APPLICATION:** Chainstitch machines with stitch condensing, overlock machines with air and thread saving device, flat seam machines with function "unlocking the chain" e.g. UNION SPECIAL classes 36200 and 39500

**Output signals for:**

Thread tension release	(max. 3.0A)
Chain cutter	(max. 3.0A)
Presser foot lifting	(max. 6.5A)
Chain suction	(max. 3.0A)
Disposal of chain cuttings by suction	(max. 3.0A)
Blowing fabric on stacker	(max. 3.0A)
High lift walking	(max. 3.0A)
4 other signals	each (max. 3.0A)
Additional signal outputs such as pos. 1, pos. 2, generator impulses, motor running, presser foot lifting (max. 30mA per output)	
Reflection light barrier module for the sensing of the edge of the fabric	
Reflection light barrier for the sensing of the edge of the fabric with V736	

Power supply 24V d.c., max. 0.5A for further additional devices

**CHARACTERISTICS:** All functions and setting values (e.g. direction of rotation of the motor) are entered into the control or changed and saved in the control by the corresponding control panel VARIOCONTROL (description see separate specification). Unintentional modifications of important settings are impossible. The control has sockets that are required for the connection of the motor, position transmitter, control panel, light barrier module, external actuator, solenoids, solenoid valves, etc.

The following functions are available and can be adapted to the machine:

- **SOFTSTART:** On/off, number of stitches and speed can be set at the start of the seam (2 stitches / 400 RPM at delivery).
- **BASIC POSITION:** Needle position at stop in the seam up/down.
- **PARTIAL BRAKING AT MACHINE STOP:** Braking effect can be set.
- **PRESSER FOOT LIFTING:** - At stop in the seam automatic /by pedal.  
- After thread trimming automatic /by pedal.  
- Start delay from lifted presser foot can be set.
- **BLOWING FABRIC ON STACKER:** On/off.
- **CHAIN SUCTION:** At the beginning on/off, at the end on/off.
- **DISPOSAL OF CHAIN CUTTINGS BY SUCTION:** At the beginning on/off, at the end on/off.
- **CHAIN CUTTER:** At the start of the seam on/off, at the end of the seam on/off.
- **OUTPUT SIGNALS:** 4 signals can be programmed in various seam sections.
- **REVERSION:** Reversing angle up to 350° and activation delay adjustable.
- **UNLOCKING THE CHAIN:** On/off, reversing angle adjustable as with reversion.
- **DIRECTION OF ROTATION OF THE MACHINE:** Switchable left/right.
- **SPEED RANGE:** 70 RPM to 9900 RPM (depending on machine).

Buttons or switches for the following functions can be connected:

- **MANUAL CHAIN CUTTER**
- **CHAIN CUTTER SUPPRESSION / RECALL**
- **FLIP-FLOP SWITCHING** with speed limitation
- **MANUAL LIGHT BARRIER END** activation of manual seam end execution
- **NEEDLE UP/DOWN POSITION**
- **BLOCKING OF MACHINE RUN**

By means of the **DETACHABLE EXTERNAL ACTUATOR** 12 speed stages are switched. Stage 1 (positioning speed) and stage 12 (maximum speed) can be set. The maximum speed of the set value can be reduced by stages. The basic setting of the maximum speed is not modified. Stages 2...11 (intermediate speeds) adapt automatically to the respective maximum speed.

**UNIT**

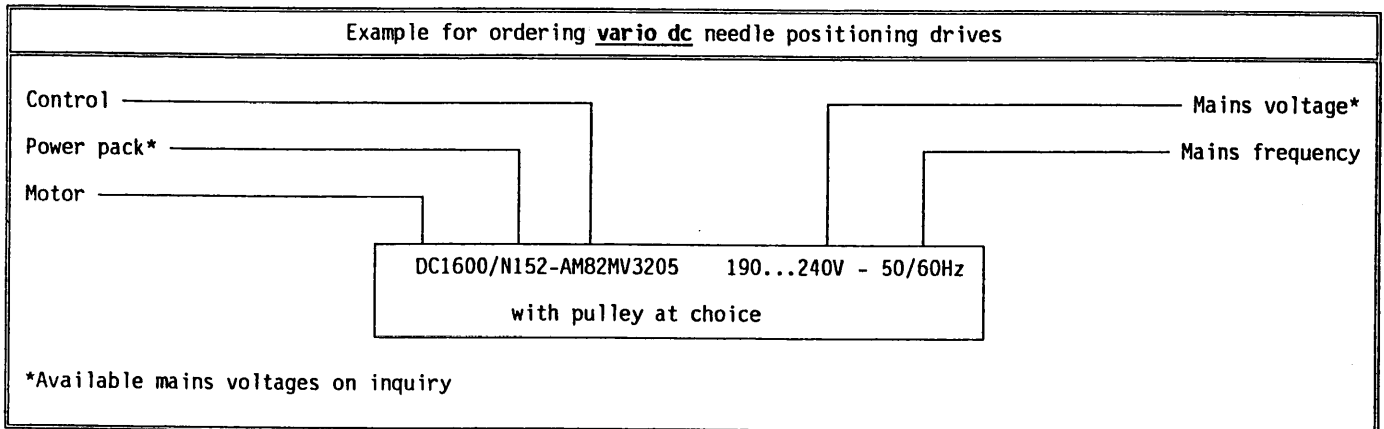
- CONSISTING OF:**
- |  |  |
|--|--|
| 1 direct current motor type DC... *1)  | 1 set of standard accessories (consisting of): |
| 1 control type N...-AM82MV3205         | 1 belt guard complete                          |
| with power pack type N152 or N153      | 1 set of hardware                              |
| or N155 *2) and external actuator      | 1 motor foot                                   |
| EB301 (optional EB302 with reduced     | 1 bracket 1 and 2                              |
| actuating force)                       | 1 instruction manual                           |
| 1 position transmitter type P6-1       | 1 set of accessories Z32 (consisting of):      |
| 1 mains switch type NS105 *3)          | 1 pitman rod complete                          |
| 1 control panel VARIOCONTROL Type V736 | 1 6-pin plug (Mes60BZ)                         |
| 1 reflection light barrier VARIOLUX    | 1 10-pin plug (Mes100)                         |
| LS-001-004                             | 1 pulley DIN42692-L- *4)                       |

**SPECIAL ACCESSORIES - SEE BACKSIDE**

- \*1) Available motors see backside
- \*2) N152 = standard version according to VDE (190...240V)  
N153 = USA/Canada version (190...240V)  
N155 = USA/Canada version (95...120V)
- \*3) Available versions see MAINS SWITCH specification
- \*4) The following sizes are available: B58-L, B63-L, B67-L, B71-L, B75-L, B80-L, B85-L, B90-L, B95-L (pulleys of the sizes 40 and/or 50 mm  $\phi$  see Special Accessories).  
Note: Select the pulley such that the motor runs at approx. 4000 RPM with max. number of stitches.

**SPECIAL ACCESSORIES, AGAINST EXTRA CHARGE:**

- Storage unit Memory Box MB001 - part no. 7900052
- Storage card Memory Card MC001 - part no. 1111602
- Reflection light barrier module Variolux LSM001 - part no. 6100028
- Solenoid type EM1.. (for e.g. presser foot lift, backtacking, etc.) - available versions see specification solenoids
- Extension cable for external actuator, approx. 750 mm long, complete with plug and socket connector - part no. 1111845
- Extension cable for external actuator, approx. 1500 mm long, complete with plug and socket connector - part no. 1111787
- 5-pin plug with slide index for the connection of another external control - part no. 0501278
- Foot control type FB302 for standing operation with approx. 1400 mm connecting cable and plug - part no. 4160018
- Potential equalization cord 700 mm long, LIY 2.5 mm<sup>2</sup>, grey, with forked cable brackets on both sides - part no. 1100313
- Fitting piece for position transmitter - part no. 0300019
- Extension cable for positioner P6-., approx. 1100 mm long, complete with plug and socket connector - part no. 1100409
- Extension cable for commutation transmitter, approx. 315 mm long, complete with plug and socket connector - part no. 1111229
- Extension cable for commutation transmitter, approx. 1100 mm long, complete with plug and socket connector - part no. 1111584
- Extension cable for motor connection, approx. 400 mm long - part no. 1111858
- Extension cable for motor connection, approx. 1500 mm long - part no. 1111857
- Pulley 40 mm  $\phi$  with special belt intake and slip-off protection (use SPZ belt) - part no. 1112223
- Pulley 50 mm  $\phi$  with special belt intake and slip-off protection (use SPZ belt) - part no. 1112224
- Knee switch type KN3 (pushbutton) with cord of approx. 950 mm length without plug, for switching the functions overleaf - part no. 58.0013
- Sewing light transformer - please indicate line voltage and sewing light voltage (6.3V or 12V)
- 6-pin plug (Mes60) - part no. 0500457
- 10-pin plug (Mes100) - part no. 0500357
- 6-pin plug with slide index (Mas6100) - part no. 0500703
- 7-pin plug with slide index (Mas7100S) - part no. 0502474
- 8-pin plug with slide index (Mas8100S) - part no. 0502865



Available motors							
Type	Rated Torque Nm	Maximum Torque Nm	Nominal Speed RPM	Power W	Weight *I) kg	Protection	Notes
DC1600	1.5 at 5000 RPM	6.6 at 1500 RPM	5000	750	8.7	IP 40	

\*I) - Weight for motor with foot, brackets, pulley ( $\phi$ 71) and belt guard (DOK05/94)  
 - Weight of the control with actuator, position transmitter and mains switch (according to type) approx. 7.5 kg