

▪ FIELD OF APPLICATION

Industrial sewing machines of various manufacturers especially for the following sewing machines:

Brand	Series
PFAFF	All lockstitch machines with thread trimmer 900 (el.-magn. and el.-pneum.)

With connections and/or outputs for:

Thread trimmer/magn.	(max. 3.0A)
Thread trimmer/pneum.	(max. 3.0A)
Presser foot lifting	(max. 6.5A/3.0A)
Needle cooling	(max. 3.0A)

The total power of the outputs is to be limited to 96VA!

Reflection light barrier module for the sensing of the edge of the fabric

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

▪ CHARACTERISTICS

The control has a digital touch control panel for programming all parameters (functions, times, speeds, etc.). Moreover, a reflection light barrier module LSM001 can be connected to the control (part nos. see Special Accessories).

▪ THE FOLLOWING FUNCTIONS ARE AVAILABLE AND CAN BE ADAPTED TO THE MACHINE:

- **SOFTSTART:** On/off; number of stitches and speed at the start of the seam can be set (factory setting: 2 stitches / 400 RPM).
- **BASIC POSITION:** Needle position at stop in the seam up/down.
- **BRAKING POWER AT MACHINE STANDSTILL:** Braking effect can be set.
- **PRESSER FOOT LIFTING:** At stop in the seam automatic/by pedal, after thread trimming automatic/by pedal, start delay after switching off the presser foot lift signal can be set.
- **THREAD TRIMMER:** Can be switched on and off on the control.
- **SPEED RANGE:** 70 RPM to 9900 RPM (depending on machine).
- **SPEED LIMITATION:** Can be varied during machine run and at intermediate stop.

▪ If THE LIGHT BARRIER IS NOT CONNECTED, THE LIGHT BARRIER INPUT CAN BE USED FOR THE FOLLOWING TOUCH AND/OR SWITCHING FUNCTIONS:

- |  |  |
|--|--|
| - <b>NEEDLE POSITION UP/DOWN</b>       | - <b>BLOCKING OF MACHINE RUN:</b> positioned stop; break contact [N.C.]/make contact [N.O.] selectable   |
| - <b>NEEDLE POSITION UP</b>            | - <b>BLOCKING OF MACHINE RUN:</b> unpositioned stop; break contact [N.C.]/make contact [N.O.] selectable |
| - <b>SINGLE STITCH:</b> basting stitch | - <b>AUTOMATIC SPEED</b>   |
| - <b>FULL STITCH</b>                   | - <b>LIMITED SPEED WHEN PUSHING THE PEDAL</b>  |
| - <b>NEEDLE TO POSITION 2</b>          | - <b>PRESSER FOOT UP</b>   |

By means of the internal 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

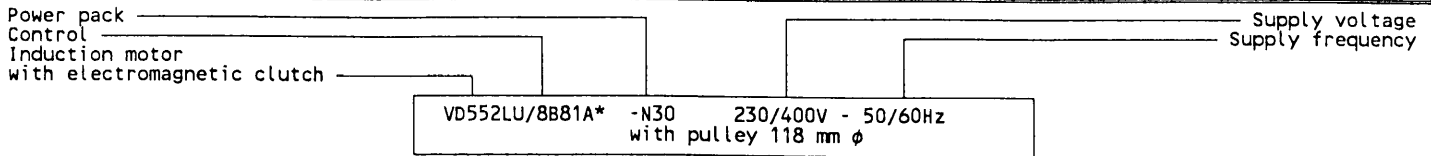
- |   |   |
|---|---|
| 1 induction motor with electromagnetic clutch type V.... * 1) | 1 set of standard accessories B10 (consisting of):        |
| 1 electronic control type 8B81A with power pack type N30      | 1 belt guard, complete (for pulleys up to 132 mm $\phi$ ) |
| 1 position transmitter type P5-2                              | 1 set of hardware   |
|   | 1 motor mounting foot                                     |
|   | 1 bracket 1 and 2, short                                  |
|   | 1 documentation   |
|   | 1 set of accessories Z8 (consisting of):                  |
|   | 1 pitman rod, complete                                    |
|   | 1 6-pin plug (Mes60)                                      |
|   | 1 pulley DIN42692-L (size according to request)           |

▪ SPECIAL ACCESSORIES - SEE REVERSE:

\*1) Available motors see last page

■ SPECIAL ACCESSORIES, AGAINST EXTRA CHARGE:	Part No.
<p><b>Belt guard</b> (for pulleys up to 180mmφ)  <b>Reflection light barrier module</b> LSM001  <b>Reflection light barrier</b> Variolux LS-001-004 (only in conjunction with V730)  <b>Solenoid type</b> EM1.. (for e.g. presser foot lift, etc.)</p> <p><b>Extension cable</b> for external actuator, approx. 750 mm long, complete with plug and socket connector  <b>Extension cable</b> for external actuator, approx. 1500 mm long, complete with plug and socket connector  <b>5-pin plug</b> with locking screw for the connection of another external actuator  <b>External actuator</b> type EB301 with approx. 250 mm connecting cable and 5-pin plug with locking screw  <b>External actuator</b> type EB302 (softer spring) with approx. 250 mm connecting cable and 5-pin plug with locking screw  <b>Foot control</b> type FB301 with one pedal for standing operation with approx. 1400 mm connecting cable and plug  <b>Foot control</b> type FB302 with three pedals for standing operation with approx. 1400 mm connecting cable and plug  <b>Potential equalization cord</b> 700 mm long, LIY 2.5 mm<sup>2</sup>, grey with forked cable brackets on both sides  <b>Extension cable</b> for position transmitter P5-..., approx. 1100 mm long, complete with plug and socket connector  <b>Extension cable</b> for position transmitter P5-..., approx. 315 mm long, complete with plug and socket connector  <b>Knee switch</b> type KN3 (pushbutton) with cord of approx. 950 mm length without plug, for switching the functions overleaf  <b>Sewing light transformer</b></p> <p><b>6-pin plug</b> with locking screw (Mas 6100)  <b>6-pin plug</b> (Mes 60)</p>	<p>7960012  6100028  6100007  available versions see specification "solenoids"  1111845  1111787  0501278  41.0011  41.0012</p> <p>4170013  4170018</p> <p>1100313  1111584</p> <p>1111229</p> <p>58.0013</p> <p>please indicate line voltage and sewing light voltage (6.3V or 12V)  0500703  0500457</p>

**Example For Ordering VARIOSTOP Positioning Drives (Series 80 / 81)**



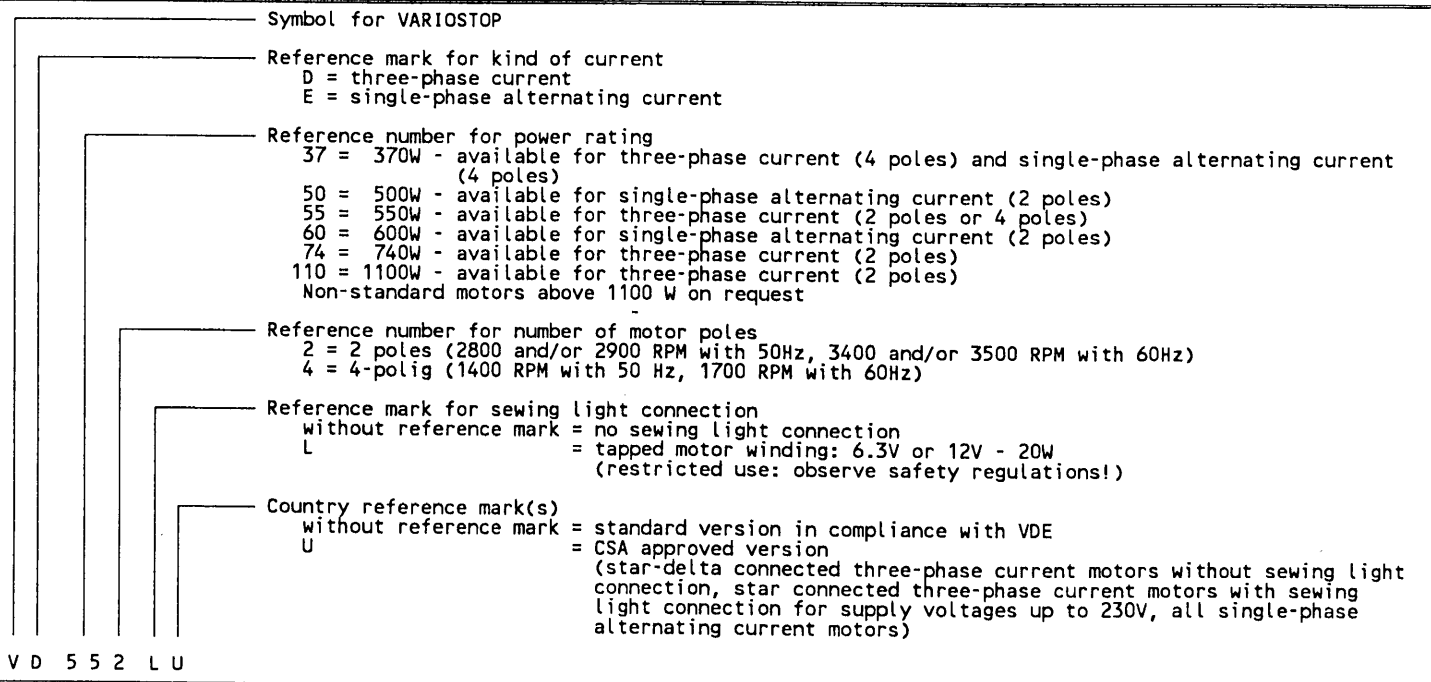
\* Besides the type designation, the control nameplate indicates the respective state of development (e.g. 8B81A....Y1). The state of development is only required in the case of technical inquiries or repairs.

**Induction Motors With Electromagnetic Clutch**

Type	Power Rating (W)	Speed (RPM)	Frequency (Hz)	Type	Power Rating (W)	Speed (RPM)	Frequency (Hz)	Type	Power Rating (W)	Speed (RPM)	Frequency (Hz)
VD374 VD374U VD374LU	370	1400/ 1700	50/ 60	VD742 VD742U VD742LU	740	2800/ 3400	50/ 60	VE374 VE374LU	370	1400/ 1700	50/ 60
VD552 VD552LU	550	2800/ 3400	50/ 60					VE502 VE502LU	500	2900/ 3500	50/ 60
VD554* VD554U* VD554LU*	550	1400/ 1700	50/ 60	VD1102* VD1102U* VD1102LU*	1100	2800/ 3400	50/ 60	VE602 VE602LU	600	2900/ 3500	50/ 60

\* in series with reinforced clutch

**Type Code For Induction Motors With Electromagnetic Clutch**



(DOK210995DE)