



Instruction manual

1183i - 7

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Foreword

This instruction manual is intended to help the user to become familiar with the machine and take advantage of its application possibilities in accordance with the recommendations.

The instruction manual contains important information on how to operate the machine securely, properly and economically. Observation of the instructions eliminates danger, reduces costs for repair and down-times, and increases the reliability and life of the machine.

The instruction manual is intended to complement existing national accident prevention and environment protection regulations.

The instruction manual must always be available at the machine/sewing unit.

The instruction manual must be read and applied by any person that is authorized to work on the machine/sewing unit. This means:

- Operation, including equipping, troubleshooting during the work cycle, removing of fabric waste
- Service (maintenance, inspection, repair and/or)
- Transport.

The user also has to assure that only authorized personnel work on the machine.

The user is obliged to check the machine at least once per shift for apparent damages and to immediately report any changes (including the performance in service), which impair the safety.

The user company must ensure that the machine is only operated in perfect working order.

Never remove or disable any safety devices.

If safety devices need to be removed for equipping, repairing or maintaining, the safety devices must be remounted directly after completion of the maintenance and repair work.

Unauthorized modification of the machine rules out liability of the manufacturer for damage resulting from this.

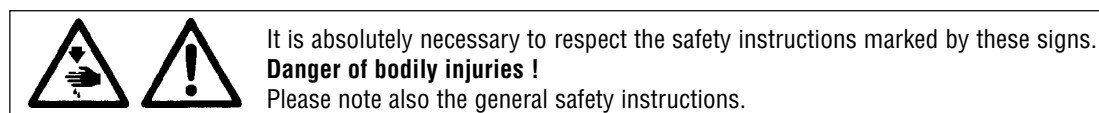
Observe all safety and danger recommendations on the machine/unit! The yellow-and-black striped surfaces designate permanent danger areas, eg danger of squashing, cutting, shearing or collision.

Besides the recommendations in this instruction manual also observe the general safety and accident prevention regulations!

General safety instructions

The non-observance of the following safety instructions can cause bodily injuries or damages to the machine.

1. The machine must only be commissioned of the instruction book and operated by persons with appropriate training.
2. Before putting into service also read the safety rules and instructions of the motor supplier.
3. The machine must be used only for the purpose intended. Use of the machine without the safety devices is not permitted. Observe all the relevant safety regulations.
4. When gauge parts are exchanged (e.g. needle, presser foot, needle plate, feed dog and bobbin) when tread-ing, when the workplace is left, and during service work, the machine must be disconnected from the mains by switching off the master switch or disconnecting the mains plug.
5. Daily servicing work must be carried out only by appropriately trained persons.
6. Repairs, conversion and special maintenance work must only be carried out by technicians or persons with appropriate training.
7. For service or repair work on pneumatic systems the machine must be disconnected from the compressed air supply system. Exceptions to this are only adjustments and functions checks made by appropriately trained technicians.
8. Work on the electrical equipment must be carried out only by electricians or appropriately trained persons.
9. Work on parts and systems under electric current is not permitted, except as specified in regulations DIN VDE 0105.
10. Conversion or changes to the machine must be authorized by us and made only in adherence to all safety regulations.
11. For repairs, only replacement parts approved by us must be used.
12. Commissioning of the sewing head is prohibited until such time as the entire sewing unit is found to comply with EC directives.



IMPORTANT WARNING!

To the feeding network cord, it is necessary to connect the respective network plug which has been approved in the country of utilizing the machine. This operation should be performed by a worker acquainted with the electric safety rules being in force in the given country. The supplier is not responsible for any damages caused by defective plug or owing to incorrect assembly of the plug.

In spite of all safety measures made on the machines, inappropriate actions of the operator may lead to dangerous situations. In industrial sewing machines, attention should be paid to the following still remaining possible sources of injury:

1. Moving sewing needle
 - risk of injury when sewing with raised pressure foot or top roller, because the finger guard is then positioned too high.
2. Moving thread take-up lever
 - risk of injury when inadvertently or intentionally inserting the finger(s) between the thread take-up lever and its guard.
3. Moving pressure member
 - risk of injury when holding sewn work in immediate vicinity of the pressure member and beginning to insert under the pressure member a considerably thicker sewn work portion,
 - risk of injury when sinking the pressure member.
4. Moving trimming knife
 - risk of injury when sewing and trimming with lifted presser element (roller, foot), because the finger guard is high
 - risk of injury when inadvertently threading down of the motor treadle.
5. When switched off, the clutch motor slows down by inertia but would be reactivated by an accidental tread-ing down of the motor treadle. To avoid such risk, it is advised to hold the handwheel by hand and slightly to depress the motor treadle.

Part A - Instruction manual

1. Proper use of the machine

The machine is used in the shoemaking industry when sewing uppers of light, medium-heavy and heavy footwear, for sewing on with simultaneous vertical edge trimming. It is suitable for sewing natural and man made leathers, shoemaking textiles and even plastic parts of sports shoes. The machine is also used in the fancy goods industry for sewing bags, handbags, rucksacks and cases from the usual fancy goods materials. When trimming edges, be sure in using always a sharp knife. The knife is driven by an independent motor. It ensures a high-quality material trimming on inner and on outer curves as well. When trimming soft materials, in some cases, it is necessary to hold the material trimmed in stretched state in facilitating so the trimming operation. The machine sews with a double needle stitch. In its standard version, it is provided with lengthened needles, system 134-35 LR, suitable for sewing leather. For sewing textile materials, it is necessary to mount also the lengthened needle, system 134-35. The machine enables the sewing of both technical and decorative seams which have almost the constant length of the stitch at a different sewing speed.

Only a dry material, which cannot be thicker than 8 mm when depressed by top roller, can be sewn by these machines, generally. The material cannot contain any hard subjects, to the contrary case it is possible to work only with applied eye-protective shield. Such a shield is not available to delivery at this time. Generally threads up to size 500 dtex x 1 x 3 (Labelled number 20) have been used namely synthetic, cotton or core threads. Whoever should like to use other special threads, that one should consider the resulting risks and make appropriate safety measures.

The total thickness is determined by sewing with a thicker needle of very strong material. In such case, it is necessary to considerably reduce the sewing speed below the values indicated in the technical parameters of the machine – par. 5.

These special machines may be installed and operated only in dry and kept up expanses. We, as industrial sewing machines manufacturers, agree with the fact that our products are operated, at the least, so far learned operators who can carry out all usual operating functions and suppose their possible risks as perceptible.

Machine noisiness

Machine noisiness has been measured in accordance with the standards ISO 3746, ISO 11204 at maximum speed.

L_{aeq} = equivalent machine noise of the self-standing machine on the working place, converted to % machine employment (dB)
- stated in the table

Type of the machine	Noisiness dB	% machine employment
1183i-7XX-200	79	20
1183i-7XX-300	73	20

2. Popis stroje

It is single needle flat-bed machine. It sews with a double threaded lock-stitch. It has a lower circular feed, needle feed and a top roller which is driven. There are two possibilities for feeding. At the first step it feeds a lower circular feed, needle and top roller. Secondly it feeds only the circular feed and the top roller (the needle is above the throat plate). Feeding can be in both directions. The stitch length can be adjusted with an adjusting dial. Stitch length up to 5 mm at max. sewing speed up to 2500 rpm.



Caution!

Maximum allowed speed must not be exceeded for the given system of sewing. Otherwise it can cause damage to the feeding mechanism.

The machine is provided with a large-diameter vertical hook, situated to the left from the needle, protected by an safety clutch. The machine uses a wick lubrication system with central oil supply. The hook is lubricated from an independent oil source. The simplest sub-class is standardly equipped with a knee operated lever. Specially for the Czech republic and if required with treadle. Reverse stitching is with a manually operated lever.

Higher sub-classes have always mechanical control like the simplest sub-class, and furthermore there is a possibility of levelling the needle, thread trimmer, electromagnetic top roller lift and electromagnetic reverse stitching (according to your order).

Each sub-class can be delivered in two sewing categories. Sewing category is determined by the number of the thread label and the corresponding number of the needle. The machine is adjusted in the factory so that it corresponds to the ordered sewing category. Changes of adjustment can be carried out only by a skilled and trained mechanic. A stand is in the simplest sub-class equipped with a lever clutch motor and if required with a stop motor which enables the levelling of the needle.

In higher sub-classes, the stop motor is either situated on the machine table top or as a minimotor integrated on the machine head. The type of mechanical top roller lift depending on the stand has one or two treadles.

3. Machine sub-classes and sewing categories

3.1 Sub-class

Table 1

Type of the machine	Top roller lift				Reverse stitching		Thread trimmer
Class-subclass -sewing category	Via knee lever	Treadle	Via electro-mag. + knee lever	Via electro-mag. + treadle	Via hand lever	Via electro-mag. + hand lever	
1183i-711-XXX	•				•		
1183i-721-XXX*		•			•		
1183i-747-XXX			•			•	•
1183i-757-XXX*				•		•	•

* only for Czech republic

3.2 Sewing categories

This code indication includes the equipment assembled on the machine head, both necessary equipment and optional equipment. The standard configuration of the equipment has been preset, according to the table 2a or 2b, in the factory which includes only necessary equipment. If the buyer demands a different configuration then the factory allocates a new code indication.

All standard sets of sewing equipment contain:

M 083 - wheel feeder with pitch of teeth 0,6 mm

M 173 - top roller ø 35 mm,

M 341 - top roller holder

* When the customer has not supplied another specification, then the following standard configuration is delivered for the given sewing category.

Table 2a - Sewing category 200

Class, subclass, sewing category	Use for sewing	Set of sewing equipment No.	Trimming distance mm	Throat plate cpl.	Replaceable stationary knife	Throat plate insert	Hole of throat plate mm	Needle (System/No.)
1183i -7XX-200	medium M	1183 E70200*	1,3	M 343	-	M 345	1,5	S548 000265 (134-35 LR-100)
			1,3	M 581	S080 870226	-		
			1,4	M 581	S080 870231	-		
			1,5	M 343	-	M 357		
			1,5	M 581	S080 870232	-		
			1,7	M 581	S080 870233	-		
			2,0	M 343	-	M 358		
			2,0	M 581	S080 870224	-		
			2,2	M 581	S080 870228	-		
			2,5	M 581	S080 870230	-		
			2,8	M 581	S080 870229	-		
			3,0	M 582	S080 870226	-		
			3,1	M 582	S080 870231	-		
			3,2	M 582	S080 870232	-		
			3,4		S080 870233	-		
			3,7	M 582	S080 870224	-		
			3,9	M 582	S080 870228	-		
			4,2	M 582	S080 870230	-		
			4,5	M 582	S080 870229	-		

Table 2b - Sewing category 300

Class, subclass, sewing category	Use for sewing	Set of sewing equipment No.	Trimming distance mm	Throat plate cpl.	Replaceable stationary knife	Throat plate insert	Hole of throat plate mm	Needle (System/No.)
1183i -7XX-300	medium heavy M-H		1,6	M 583	S080 870226	-	2,0	S548 000270 (134-35 LR/130)
		1183 E70300*	1,7	M 343	-	M 346		
			1,7	M 583	S080 870231	-		
			1,8	M 583	S080 870232	-		
			2,0	M 343	-	M 359		
			2,0	M 583	S080 870233	-		
			2,3	M 583	S080 870224	-		
			2,5	M 583	S080 870228	-		
			2,8	M 583	S080 870230	-		
			3,0	M 343	-	M 360		
			3,0	M 584	S080 870226	-		
			3,1	M 584	S080 870231	-		
			3,2	M 584	S080 870232	-		
			3,4	M 584	S080 870233	-		
			3,7	M 584	S080 870224	-		
			3,9	M 584	S080 870228	-		
			4,2	M 584	S080 870230	-		
			4,5	M 584	S080 870229	-		

4. Survey of equipment

This survey does not include the equipment assembled on the stand.

4.1 Equipment (at least one of each from the following group of equipment is assembled)

4.1.1 Needles

see tab. 2a, 2b

4.1.2 Wheel feeders

M 083 - wheel feeder with pitch of teeth 0,6 mm

M 082 - wheel feeder with pitch of teeth 1,2 mm

4.1.3 Top roller holder

M 341 - top roller holder $\varnothing$ 35 mm

4.1.4 Top rollers

M 173 - top roller $\varnothing$ 35 mm

M 175 - rubberized top roller $\varnothing$ 35 mm

M 311 - smooth top roller $\varnothing$ 35 mm

4.1.5 Throat plate

see tab. 2a, 2b

4.1.6 Throat plate inserts

see tab. 2a, 2b

4.1.7 Trimmer knives stationary

see tab. 2a, 2b

4.1.8 Trimmer knives movable

S080 870240 - trimmer knife „D“ small radius for the material being trimmed

S080 870244 - trimmer knife „F“

4.1.9 Connecting cables of the head to the drive

M 318 - connecting cable to the drive EFKA DC 1600/DA82GA; EFKA VD 552/6F82FA and EFKA VD 554/6F82FA

M 055 - connecting cable without any specified drive (with free cable end)

Note: For the machine provided with a minimotor, the cable is component part of the drive thereof.

4.2 Optional equipment

M 010 - built-in lighting (including transformer 230/12V)

M 341 - sewn work guide

M 242 - setting gauge

1183 711001V - high mortality spare parts kit in plastic box for sub-class without thread trimmer

1183 747001V - high mortality spare parts kit in plastic box for sub-class with thread trimmer

S794 222012 - halogen lighting (12 V, 20 W - contains transformer)

5. Technical data

Table 3

Sewing category	Sewn material		Distance between the needle axis and the work trimmer line		Stitch length		Labelled number of polyester thread		Number of needle		Sewing speed		Hook
	Thickness of one layer	Number of layers	Minimum	Standard	Standard	Maximum	Standard	Range	Standard	Range	Standard	Maximum	
	mm	-	mm	mm	mm	mm	-	-	0,01mm	0,01mm	SPM	SPM	
-200 -medium	1	2	1.3	see tab. 2a, 2b	2.5	5	40	50-30	100	80-110	2500	2500	R 820 *
-300 medium heavy	1.5	1-2	1.6		3.5	5	20	25;20	130	110-140	1600	2000	R 820 **

* The splice with the so-called spur is being mounted as a standard with the sewing categorie 200 and is designed for sewing thin materials. For sewing thicker materials with a maximum stitch length it is possible to use a splice without spur.

** Splice without spur is mounted as a standard with the sewing categorie 300.

Stitch type
Top roller stroke

Double thread lock-stitch
6 mm - via hand lever
12.5 mm - via knee lever, treadle, electromagnet

Hook
Needle

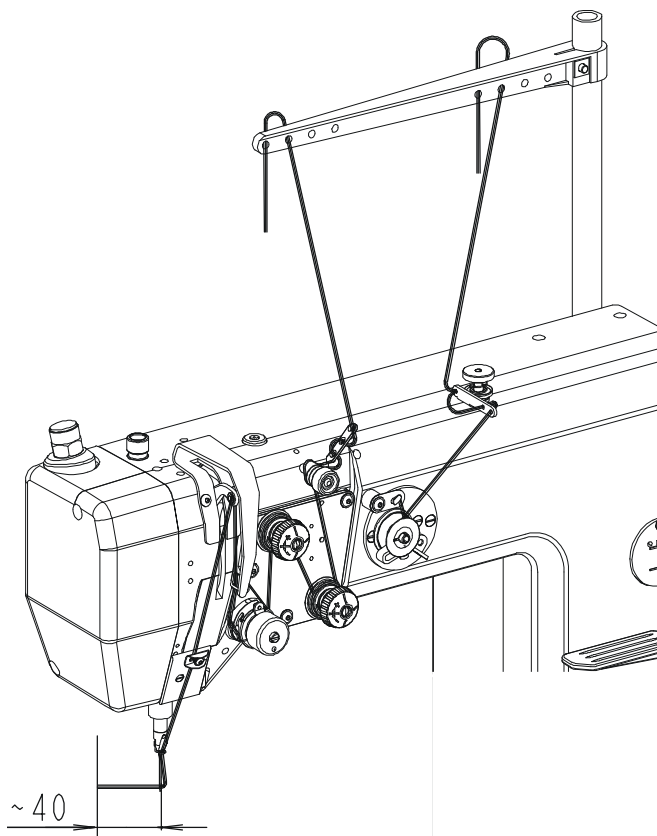
R 820 - vertical large
System 134-35 LR
System 134-35

Driving unit

Lever clutch 4 poles change motor min. 0.4 kW, lower clutch
2 poles change motor min. 0.4 kW
Stopmotor min. 0.4 kW

Weight of the head
Weight of the stand
Opening space of machine head
Dimension of bed plate
Length of trimmed thread ends
Input machine with clutch motor
Input machine with stop motor
Trimmed material
Distance between the needle axis and the work trimmer line
Power output of the work trimmer motor
Stroke frequency of the work trimmer knife
Stroke range of the work trimmer knife
Layout dimensions of the machine (including the stand)
Height of the machine (including the stand)

max. 46 kg (52 kg head with minimotor)
max. 61 kg (38 kg for head with minimotor)
267 x 125 mm
178 x 518 mm
8...11 mm
Max. 700 W
Max. 800 W (600 W with minimotor)
max. thickness - 6 mm
1.3 - 4.5 mm (according to sewing category)
25 W
3500 strokes/min (constant)
adjustable to 2.4 mm
1060 x 550 mm
1680 mm



6. Operation of the machine

6.1 Threading a thread



Caution! Risk of injury!

Before threading a thread, turn the main switch off and wait until the machine stops!

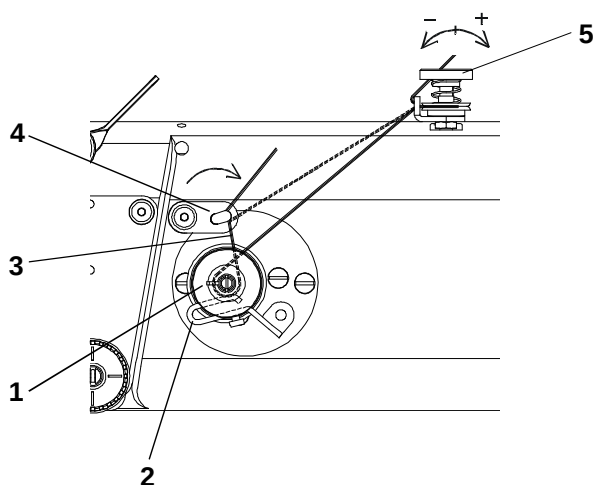
Thread the threads as it is shown in picture.



Caution!

Not following the correct method of threading a thread may cause serious damage to the function of the machine.

6.2 Bobbin thread winding



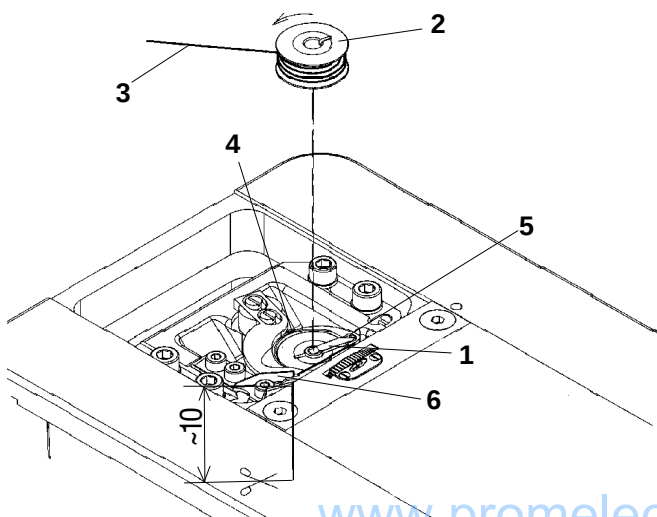
- Insert the bobbin (1).
- Spool counter-clockwise manually onto the bobbin, minimum six threads of the lower thread (3).
- Insert the thread ends into the equipment (4) and cut off the ends.
- Press the lever (2) until it reaches its limit.
- Switch on the machine.
- The winder will automatically switch off after winding.
- Take off the hook bobbin and cut off the end in the equipment (4).
- The nut (5) is instrumental to thread tension control for winding. Turning clockwise sense the thread tension is increased and the single threads are more firmly fixed on the bobbin.
- The tension cannot be so extensive as far as slipping of the winder friction drive has occurred.

6.3 Inserting the bobbin and threading the lower thread



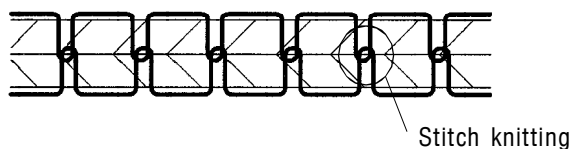
Caution! Risk of injury!

Turn the main switch off and wait until the motor stops!

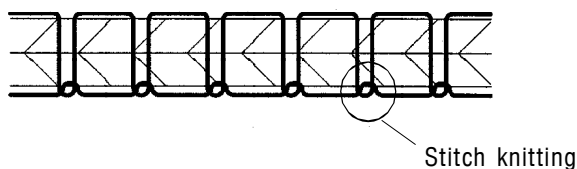


- Tilt the shutter (1) up.
- Insert the bobbin (2) with thread end (3) in the direction as shown in the picture.
- Thread the thread through the notch (4) and the space (5) and place under the spring (6).
- Cut off the thread end as shown.

Fitting seam



Decorative seam



6.4 Regulating the thread tension

The thread tension must conform to the thickness of the sewn threads, thickness and hardness of sewn material (thin and soft material will fold with high tension) and the kind of seam. An ordinary fitting seam should be formed with stitches knitted in the middle of the sewn material.

A decorative seam is mostly used with rough threads (20) on thin material and it has tied up threads on the reverse side of the material for achieving a decorative appearance.

Thread tension adjustment is by standard sewing (par. 5, table 3) conditions in accordance with table No. 4.

If achieving of a decorative seam with stitch knitting on the underside is wished, it is necessary to decrease the upper thread tension, it is carried out by turning of nuts (1), in the counter-clockwise sense.

Thread tension

Table 4

Sewing category	Kind of seam	Identified value upper thread tension	Maximum tension of lower thread
		N	N
2	-	4.5	1.5
3	Fitting	8	2
	Decorative	5	



If the maximum lower thread tension exceeds the values given in table No. 4, it may cause problems in the beginning of sewing after the previous thread trim.

Measurement of tension is done by dynamometer.

Warning:

The upper thread tensioner has been loosened automatically after every trimming and top roller lifting. In these cases the thread tension cannot be measured.

Regulating the thread tension



Caution! Risk of injury!

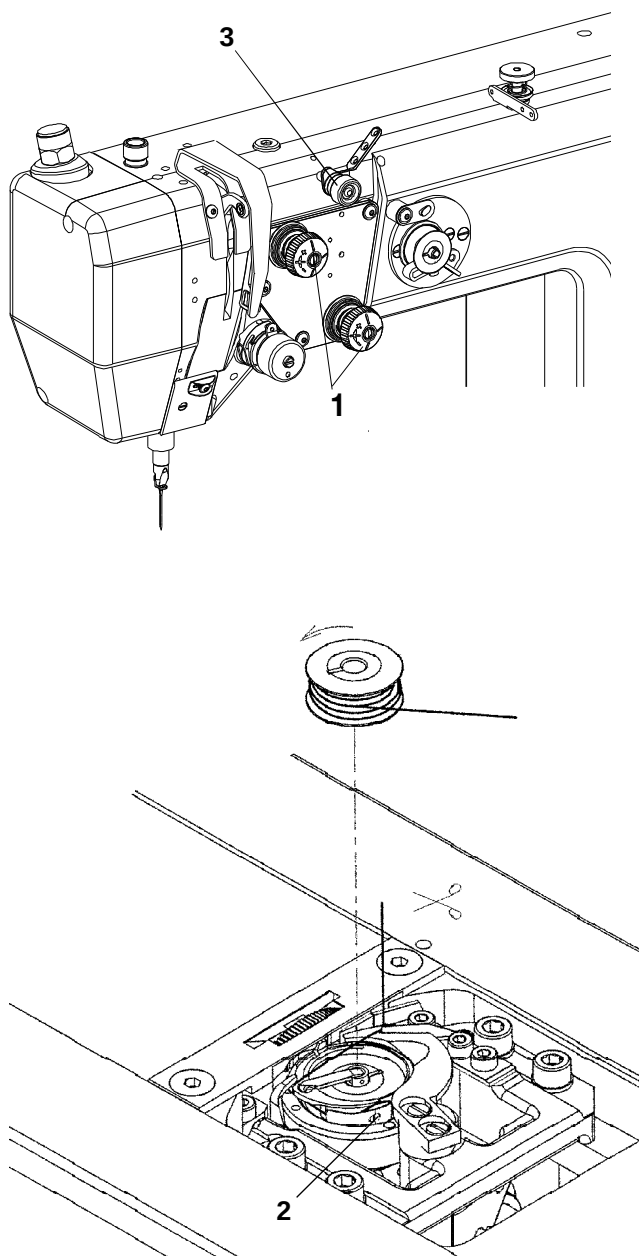
Before regulating the lower thread tension, turn the main switch off and wait until the motor stops.

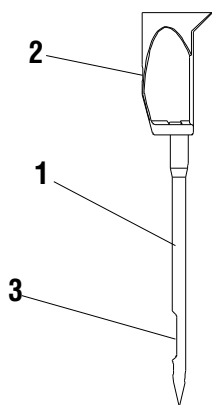
The upper thread tension is adjusted with nuts (1). Its clockwise turning increases the tension.

The tension of the auxiliary tensioner (3) should be as low as possible but it should be on a level so that the upper thread would not pull out of the tensioner when the work is being removed.

The lower thread tension is adjusted with a screw (2). Its clockwise turning increases the tension.

Tension correlation rate defines the depth of the seam tied through. The result of raising the upper tension will be the decreasing depth of tie through. The opposite will apply with the lower thread.





6.5 Needle replacement



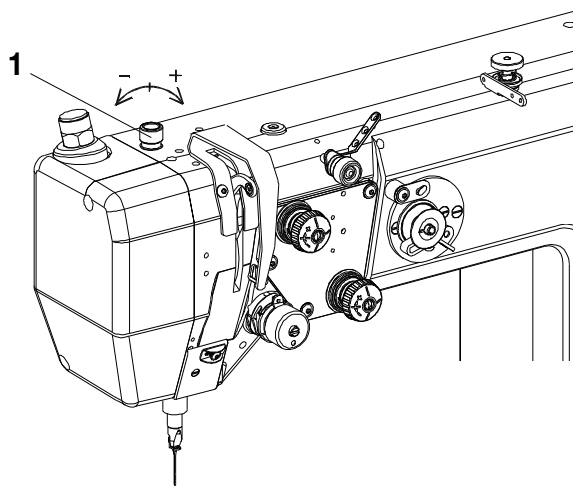
Caution! Risk of injury!

Before removing and inserting the needle turn the main switch off and wait until the motor stops!

- Turn with the hand wheel as far as the top needle (1) position has been reached.
- Loosen the screw (2) and take the needle out.
- When inserting a new needle, care is to be taken that groove (3) above the needle's eye was in the same direction as the hook.
- Tighten the screw (2).



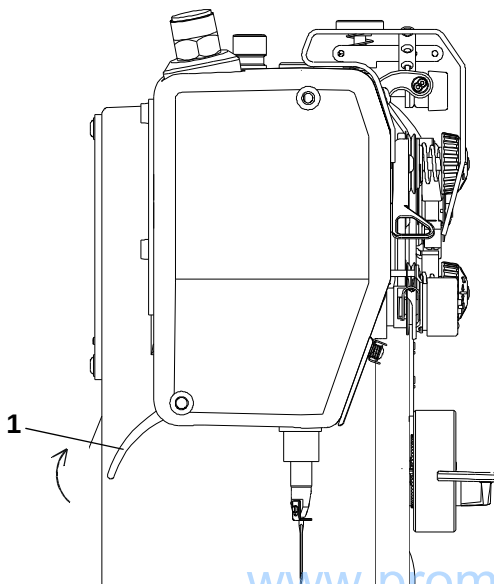
The inserted needle must respond to the sewing category according to paragraph No. 5, table 3. Otherwise it will cause damage to sewing, or eventually the machine could be broken.



6.6 Regulation of pressing the top roller

The pressing of the top roller should be as low as possible but on a level so that the top roller would not fly over when needle comes off the material and that the feeding power got over the thread pull by stitch tightening.

By turning of the screw (1) clockwise pressing of the top roller has been increased, by counter-clockwise turning pressing of the top roller has been decreased.

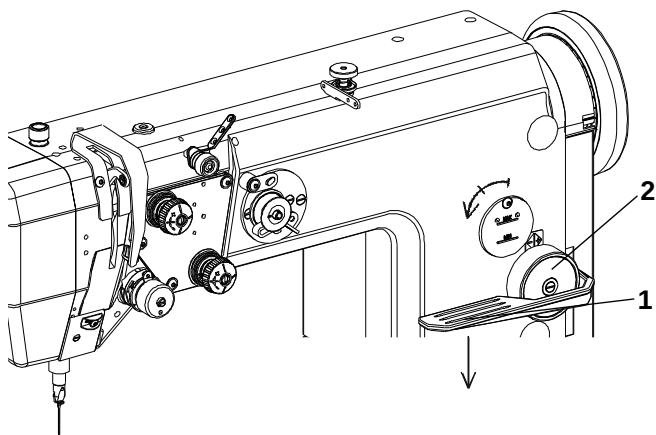


6.7 Lifting the top roller up

Mechanical lifting of the top roller is enabled by means of the hand lever (1), which contemporarily, after it has been lifted in the arrow direction, is locking the top roller in its top position and turning (adjustment) of the machine is possible. The top roller can be lifted via knee lever or left treadle - depending on the machine sub-class. Automatical lifting by means of electromagnet is described in the paragraph No. 7.



When lifting top roller via knee lever or the treadle or electromagnet, the needle must be in the upper position and the machine has to come to a full stop.



6.8 Reverse stitching

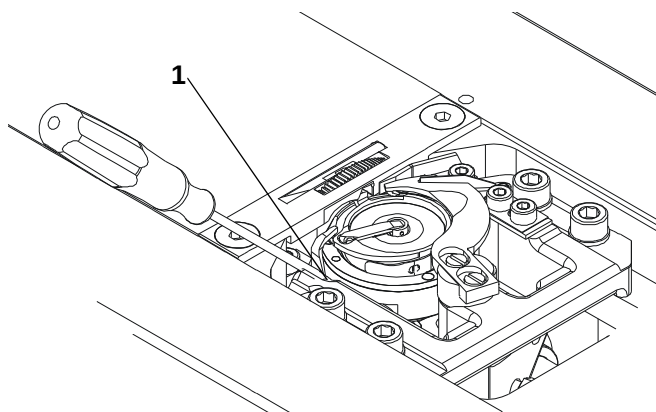
The change of direction of sewn work can be mechanically controlled via a reverse stitching lever (1) by its depression in the arrow direction (down). The sub-class defines whether the machine has electromagnetic reverse stitching – see paragraph No. 7.

6.9 Stitch length adjustment

Stitch length adjustment is by dial (2) by its turning. Turning clockwise stitch length is decreased, turning counter-clockwise stitch is length increased.



If it comes to a substantial change of length of stitch it is necessary to adjust of the throat plate insert in accordance with the following paragraph, by the machines with the thread trimmer.



6.10 Safety clutch

The machine is provided with a safety clutch which disengages the driving unit, when the hook is blocked. Reconnection must be done in the following way:



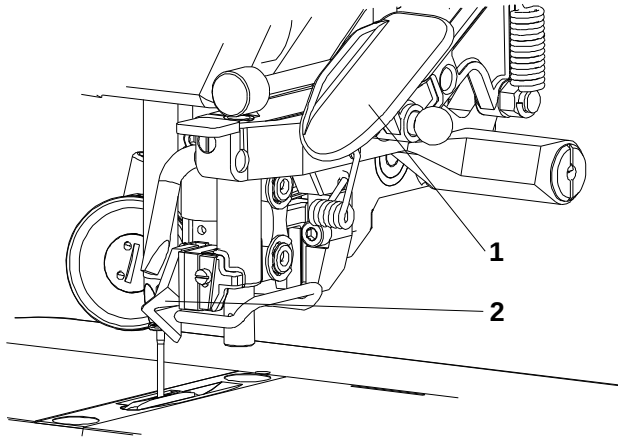
Caution! Risk of injury!

Before assembly turn the main switch off and wait until the motor stops!

- Turn the manually operated wheel as far as you can reach the suitable point for inserting a screwdriver into the space(1).
- Continue turning the manually operated wheel in direction of the arrow located on it, until you feel the drop in of the safety clutch.

6.11 Starting of the material trimming operation

The trimming operation can be started at the beginning of the seam, but also at any moment during the sewing operation. In such case, the knife pierces the trimmed material and, starting from this spot, the trimming operation starts running.



- Put the material to be sewn under the presser foot.
- Engage the trimming device in depressing the engaging lever (1) downwards. The trimming knife (2) will move downwards into its working position.



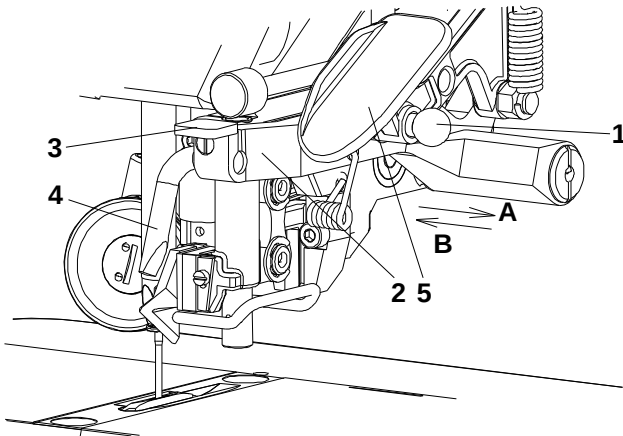
Caution! Risk of injury!

When starting the trimming operation, do not put your fingers under the trimming knife.

- Sew a seam.
- Disengage the trimming device in pulling the engaging lever (1) upwards.



Especially when starting the trimming operation in the middle of the trimmed material, do not exceed its maximum permissible thickness = 6 mm. This may break the trimming knife. When applying the maximum sewing speed together with the maximum stitch length, a smooth trimming cut cannot be ensured. It is necessary to reduce one or the other in proceeding to a test on the material to be trimmed.



6.12 Control of the material guide regardless the engaged trimming device

- Pull the sphere (1) in the direction of the arrow (A), until its pin disengages from the engagement with the lever (2).
- In depressing the handrail (3) downwards, lower the guide (4) into its working position. Using the inverse procedure, lift the guide upwards.

6.13 Control of the material guide with regard to the engaged trimming device

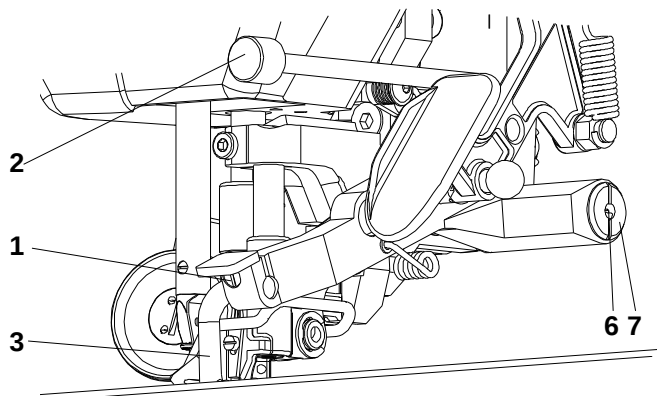
- Disengage the trimming device by means of the lever (5) and lift the guide (4) in its top position
- Depress the sphere (1) in the direction of the arrow (B), until its pin fits into the recess in the lever (2).
- Engage the trimming device using the lever (5). The guide shifts in its working position. When disengaging the trimming device, the guide lifts too.

6.14 Setting of the material guide



Caution! Risk of injury!

Proceed to the guide setting only with the machine switched off!



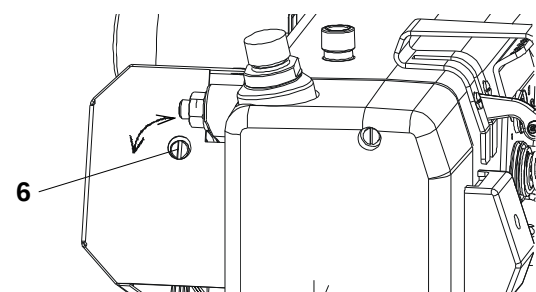
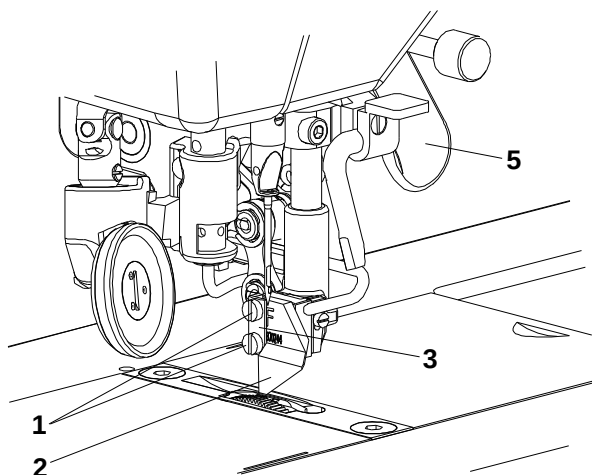
- Switch off the machine with the main switch.
- Engage the trimming device (lower the knife in its working position).
- Loosen the screw (1)
- Loosen the screw (2) until the guide (3) bears against the insert.
- In tightening the screw (2), set the guide (3) in such a way, so that between the guide and the throat plate there is sufficient clearance, when turning the guide in its vertical position.
- For coarse adjustment of the distance of the guide (3) from the trimming knife, shift the guide (3) into its correct position before tightening the screw (1).
- For fine adjustment of the guide (3) loosen the screw (6) inside the screw (7). Turn the screw (7) in suitable direction, until setting the required distance between the guide and the trimming knife. Retighten then the screw (6), in arresting so the screw (7).
- The height setting of the guide (3) with the screw (2) may be done even when the main switch is being switched on.

6.15 Replacement of the trimming knife



Caution! Risk of injury!

Replace the trimming knife only with the machine switched off!



- Switch off the main switch of the machine.
- Put the knife in its top position, loosen the upper screw (1), unscrew the bottom screw (1) and shift the knife (2) downward.
- Slide the new knife into its uppermost position, tighten very slightly the screws (1) in such a way, so that the knife may still slide under the gib (3).
- With a slow movement of the lever (5), lower the knife downwards.
- Using a screw driver, turn the shaft (6) in such a way, so that the trimming knife is in its lowest position.
- Push the free end of the trimming knife in shifting it downward in such a way, so that between its point and the bottom surface of the throat plate insert there is a clearance of about 0,2 mm and, at the same time, when turning the shaft (6) into the highest position of the knife, this knife would not leave the cutting edge on the throat plate insert.
- Tighten the screws (1).
- Check the movement of the trimming knife in turning by hand the shaft (6).



The trimming knife must not strike in its bottom dead centre against the throat plate insert. In the top dead centre, the trimming knife must not leave the cutting edge on the throat plate insert.

6.16 Change of the sewing category

When proceeding to this change, it is necessary to replace the throat plate insert (it can be additionally purchased). Together with the insert replacement, the width of the trimmed edge is changed - the side setting of the knife must be changed. It is described in the service book.

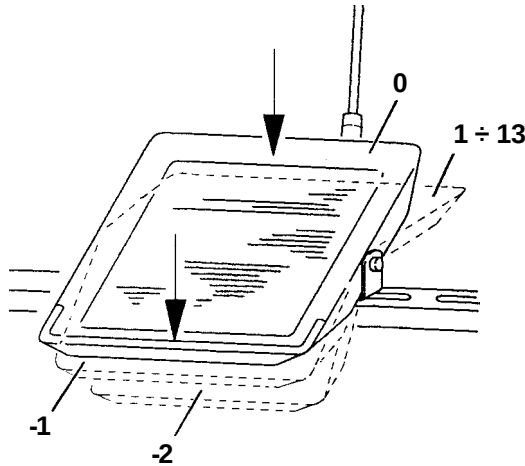
7. Electronic control of the machine

(it is valid for sub-classes equipped with stop motor)

7.1 Control of sewing by means of control elements

7.1.1 Via treadle (treadle positions and function possibilities)

The position of the treadle is read by the reader, which can recognise 16 levels. Its meaning is shown on the table.



Treadle position	Treadle	Meaning
-2	Foot full backwards	Command for thread trimming (seam finishing)
-1	Foot slightly	Command lifting the top roller up
0	Neutral position	Note
1	Slightly forwards	Command releasing top roller
2	Continually forwards	Sewing at minimum speed (1. gear)
3	Continually forwards	Sewing at second speed level
:	:	:
13	Fully forwards	Sewing at maximum speed (12. gear)

Note: It is possible to pre-adjust the needle position (up/down) and foot position (up/down) by stopping in seam (introducing the treadle in neutral position). Foot position (up/down) after seam finishing (pressing the treadle by foot fully backwards).

7.1.2 Via pushbutton panel

There are four built-in pushbuttons in the panel with fixed adjustable functions:

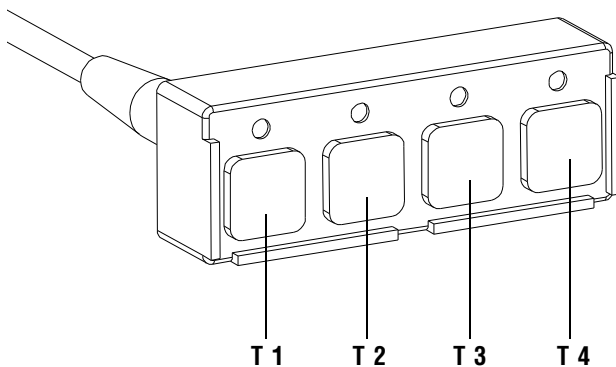
- T1 - bar operation (by pressing this pushbutton during sewing the sewn work is feed back)
- T2 - needle up/down (each press of the pushbutton changes the needle position)
- T3 - temporary cancelling (recalling) bar (in case) the bar is pre programmed at the start and end of the seam, by pressing the pushbutton down will uniformly switch off; if it is not chosen it will switch on by pressing the pushbutton
- T4 - revolutions limitation (valid for motor Efka DA82GA)
 - reduction of pressure of the presser foot for Mini-stop EFKA DA320 (see The instructions for assembling with Mini-stop, par. 5.2.4)

7.1.3 Via control panel Efka V 810/V 820

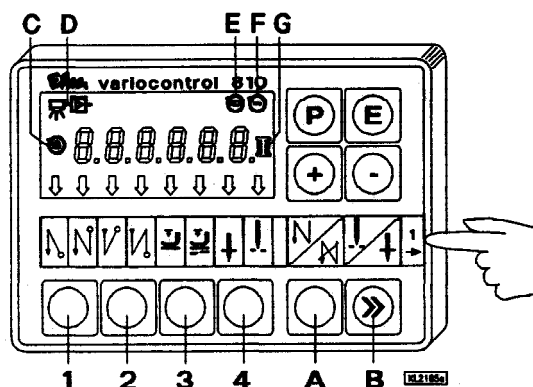
These functions are standardly assigned to the pushbuttons A, B:

- A - cancelling (recalling) the bar (the same function as T3 of the pushbutton panel)
- B - needle up/down (the same function as T2 of the pushbutton panel)

Note: function of the A,B pushbuttons can be changed by different adjustment of parameters 293,294 (see the parameters list of driving unit Efka DA82GA).



7.2.1 By using stop motor Efka with panel V 810



Functioning pushbuttons engagement:

Pushbutton P	Recalling and program mode termination
Pushbutton E	Confirmation of program mode changes
Pushbutton +	Increase of value displayed in program mode

Pushbutton - Decreasing value displayed in program mode

Pushbutton 1	Start bar	SINGLE/DOUBLE/OFF
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Pushbutton 1	Start bar	SINGLE/DOUBLE/ON
Pushbutton 2	End bar	SINGLE/DOUBLE/OFF

Pushbutton 2	End bar SINGLE/DOUBLE/ON
Pushbutton 3	Automatic top roller lifting after stopping at the seam ON/OFF

Automatic top roller lifting after thread trimming (end of seam) ON/OFF

Automatic presser foot lifting after
thread trimming (end of seam) ON/OFF

Automatic reduction of pressure of the presser foot ON/OFF (only for DC 1550/DA320; see The instructions for assembling with Mini-stop, par. 5.2.4)

Pushbutton 4 Basic position of needle UP/DOWN

Pushbutton A	Basic position of handle UP/DOWN
Pushbutton B	For cancelling respectively recalling the bar

Pushbutton B for switch over the needle position UP/DOWN respective shift pushbutton in program mode

Symbol C	Connection of automatic revolutions
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Symbol C	Connection of automatic valve
Symbol D	Connection of lighting barrier

Symbol D	connection of lighting
Symbol E	The machine is running

Symbol E	The machine is running
Symbol F	The revolutions limitation switch on

Symbol G	Connection of lower thread controller, flashing light indicator symbol when the threads supply on the bobbin is running out
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The arrows on the display indicate switching the functions which are displayed by symbols above the pushbuttons on.

7.2.1.1 Adjustment by means of buttons with fixed setting function

Note: It is important to finish the seam in order to reach effective button pressing (press the treadle fully backwards down).

Setting start bar:

Drive enables sewing start bar automatically. It is necessary to choose the type (single, double, off) and number of stitches which will be sewn forwards and backwards.

The arrow above its symbol shows the type of bar (chosen by gradually pressing pushbutton 1). It will be displayed following after pressing pushbutton 1.

Arv (SAv) XXX - number of stitches of start (fancy) bar forwards or

Arr (SAr) XXX - number of stitches of start (fancy) bar backwards) for about 3 sec.

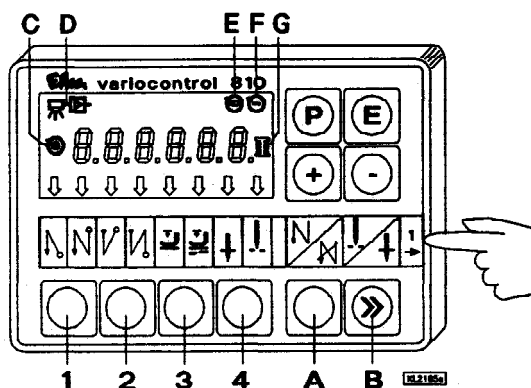
At this time you can change the number of stitches by gradually pressing the pushbutton + or -.

Setting end bar:

The same applies to the start bar (setting by the means of pushbutton 2).

Erv (SEv) XXX - end (fancy) bar number of stitches forwards

Err (SEr) XXX - end (fancy) bar number of stitches backwards



Note: The last section of end bar must have at least 3 stitches.
Foot position adjustment by stopping at the seam (by neutral position of treadle) and after finishing seam (by neutral position of treadle):

Setting is by means of pushbutton 3, arrow indication above the corresponding symbol.

Needle position adjustment by stopping at the seam:

Setting is by means of pushbutton 4.

7.2.1.2 Setting by means of parameters

Drive memory contains the parameters which enables sewing system tuning. These parameters have exact meaning and they are divided into 3 levels. Further parameters which are available only for operation will be quoted. Each parameter has its (sequence) number and value.

General procedure by changing parameters of operation level:

- switch the main switch on or finish the seam by pressing the treadle fully backwards down
- press pushbutton P on the panel V 810
- it will be displayed on the display F 000 (000 it is the number of parameter)
- by several times pressing + (or -) set the requested number of parameter
- push pushbutton E down and it will be shown the value of parameter on the display
- you can change the value by means of pushbutton + or -
- by pushing pushbutton E down you will change the sequence to the following number of parameter
- by pushing pushbutton P down you will leave the mode of changing parameters

Note: 1. For permanent memory storing of changed parameter, it is necessary to press treadle forwards down after changing of parameters.

2. Mode of changing parameters is possible only after finishing of the seam.

Number of stitches in bars:

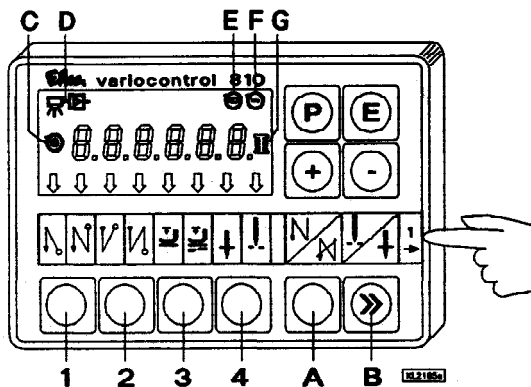
Number of stitches is stored in parameter's number.

No. of parameter	Value range of parameter	Description of parameters
000(080)	0-254	Number of stitches of start (fancy) bar forwards
001(081)	0-254	Number of stitches of start (fancy)bar backwards
002(082)	0-254	Number of stitches of end (fancy) bar backwards
003(083)	0-254	Number of stitches of end (fancy)bar forwards

Sewing according to sewing program:

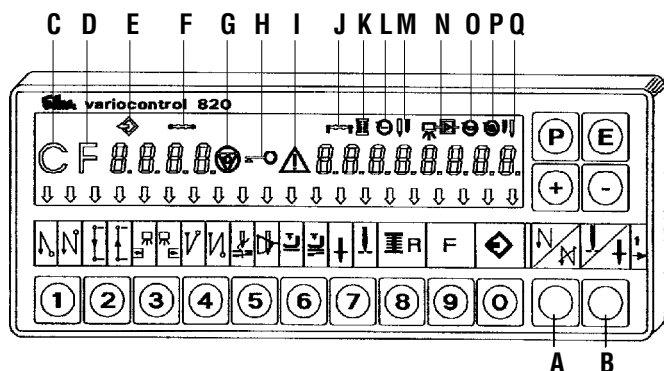
Drive with panel V810 automatically enables sewing of 1 seam with setting number of stitches. It is necessary to set in corresponding number of stitches, and initialisation of sewing program.

No. of parameter	Value range of parameter	Description of parameters
007	0-254	Number of stitches
015	ON/OFF	ON/OFF sewing under sewing program



ON/OFF thread trimmer:

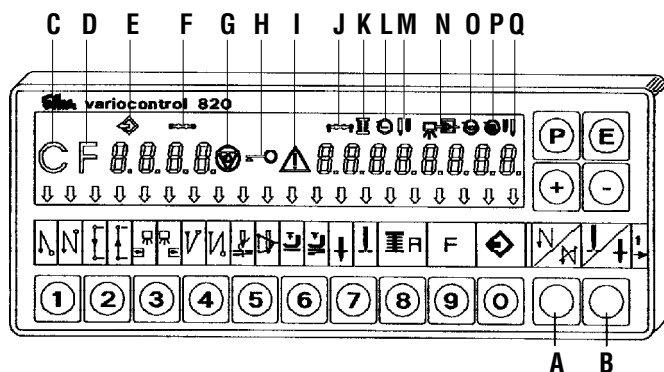
No. of parameter	Value range of parameter	Description of parameters
013	ON/OFF	Thread trimmer ON/OFF



7.2.2 By using stopmotor Efka with panel V 820

Functioning pushbuttons engagement:

Pushbutton P	Call and termination of programming mode
Pushbutton E	Confirmation when changing programming mode
Pushbutton +	Increasing the value displayed in programming mode
Pushbutton -	Reducing the value displayed in programming mode
Pushbutton 1	Start bar SINGLE/DOUBLE/OFF
Pushbutton 2	Stitch counting FORWARD/BACK/OFF
Pushbutton 3	Light barrier function LIGHT-DARK/DARK-LIGHT/OFF
Pushbutton 4	End bar SINGLE/DOUBLE/OFF
Pushbutton 5	Function TRIMMING/TRIMMING+EJECTOR/OFF
Pushbutton 6	Automatic top roller lifting after having stopped inside the seam ON/OFF Automatic top roller lifting after trimming ON/OFF Automatic presser foot lifting after thread trimming (end of seam) ON/OFF Automatic reduction of pressure of the presser foot ON/OFF (only for DC 1550/DA320; see The instructions for assembling with Mini-stop, par. 5.2.4)
Pushbutton 7	Basic needle position UP/DOWN
Pushbutton 8	Lower thread waste controlling ON/OFF
Pushbutton 9	Operation pushbutton - programmable
Pushbutton 0	Programming/processing of 40 possible sewing sections (seams)
Pushbutton A	For cancelling or calling the bar
Pushbutton B	For switching needle position UP/DOWN, resp. shifting pushbutton in the programming mode
Symbol C	Designating symbol C for code number
Symbol D	Designating symbol F for parameter number
Symbol E	Programme number in TEACH IN mode
Symbol F	Seam number in TEACH IN mode
Symbol G	Run blocking ON
Symbol H	Blocked insertion by pushbutton
Symbol I	Fault reporting
Symbol J	Insertion of stitch number in TEACH IN mode
Symbol K	Connected lower thread controller, flashing symbol when running out thread reserve on bobbin
Symbol L	Limitation of revolutions ON
Symbol M	Right needle disconnected
symbol N	Evening stitches for light barrier in the TEACH IN mode
Symbol O	Machine is running



Symbol P
Symbol Q

Automatic revolutions ON
Left needle disconnected

The arrows on the display indicate switching the functions which are displayed by symbols above the pushbuttons on.

7.2.2.1 Adjustment by means of buttons with fixed setting function

Note: It is important to finish the seam in order to reach effective button pressing (press the treadle fully backwards down).

Setting start bar:

Drive enables sewing start bar automatically. It is necessary to choose the type (single, double, off) and number of stitches which will be sewn forwards and backwards.

The arrow above its symbol shows the type of bar (chosen by gradually pressing pushbutton 1). It will be displayed following after pressing pushbutton 1.

Arv (SAv) XXX - number of stitches of start (fancy) bar forwards or

Arr (SAr) XXX - number of stitches of start (fancy) bar backwards for about 3 sec.

At this time you can change the number of stitches by gradually pressing the pushbutton + or -.

Setting end bar:

The same applies to the start bar (setting by the means of pushbutton 4).

Erv (SEv) XXX - end (fancy) bar number of stitches forwards

Err (SEr) XXX - end (fancy) bar number of stitches backwards

Note: The last section of end bar must have at least 3 stitches.

Foot position adjustment by stopping at the seam (by neutral position of treadle) and after finishing seam (by neutral position of treadle):

Setting is by means of pushbutton 6, arrow indication above the corresponding symbol.

Needle position adjustment by stopping at the seam:

Setting is by means of pushbutton 7.

Trimming switched ON/OFF:

To be set using pushbutton 5.

Sewing programme ON:

To be switched on using pushbutton 0.

Switching ON/OFF the function of the pushbutton F:

The pushbutton F on panel can have assigned one of the following functions: Sst - softstart

SrS - fancy bar

Frd - reverse angle after trimming

7.2.2.2 Setting by means of parameters

Drive memory contains the parameters which enables sewing system tuning. These parameters have exact meaning and they are divided into 3 levels. Further parameters which are available only for operation will be quoted. Each parameter has its (sequence) number and value.

General procedure by changing parameters of operation level:
- switch the main switch on or finish the seam by pressing the treadle fully backwards down

- press pushbutton P on the panel V 820

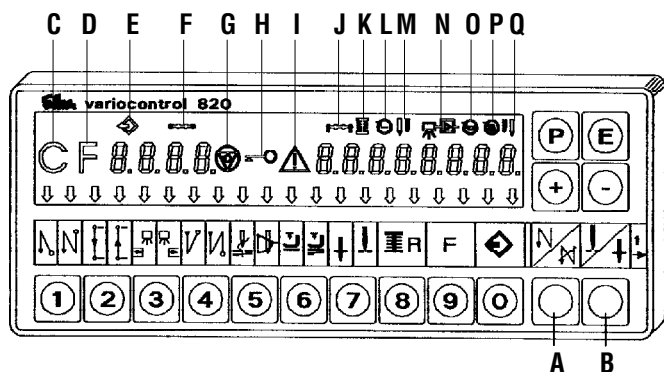
- on the display there is no data shown

- by depressing the pushbutton E several times, set the required parameter (without having displayed the parameter number)

- you can change the value using pushbuttons + or -

- by depressing the pushbutton E you will pass in the given sequence to the following parameter

- by depressing the pushbutton P down you will leave the mode of changing parameters



- Note:** 1. For permanent memory storing of changed parameter, it is necessary to press treadle forwards down after changing of parameters.
2. Mode of changing parameters is possible only after finishing of the seam.

Number of stitches in bars:

Number of stitches is stored in parameter's number.

No. of parameter	Value range of parameter	Description of parameters
000(080)	0-254	Number of stitches of start (fancy) bar forwards
001(081)	0-254	Number of stitches of start (fancy) bar backwards
002(082)	0-254	Number of stitches of end (fancy) bar backwards
003(083)	0-254	Number of stitches of end (fancy) bar forwards

The drive with the panel V 820 enables sewing automatically up to 40 seams distributed up into eight programmes with the given stitch numbers and sewing direction (forwards/rearwards). For more detailed information see the original driving instructions.

8. Maintenance

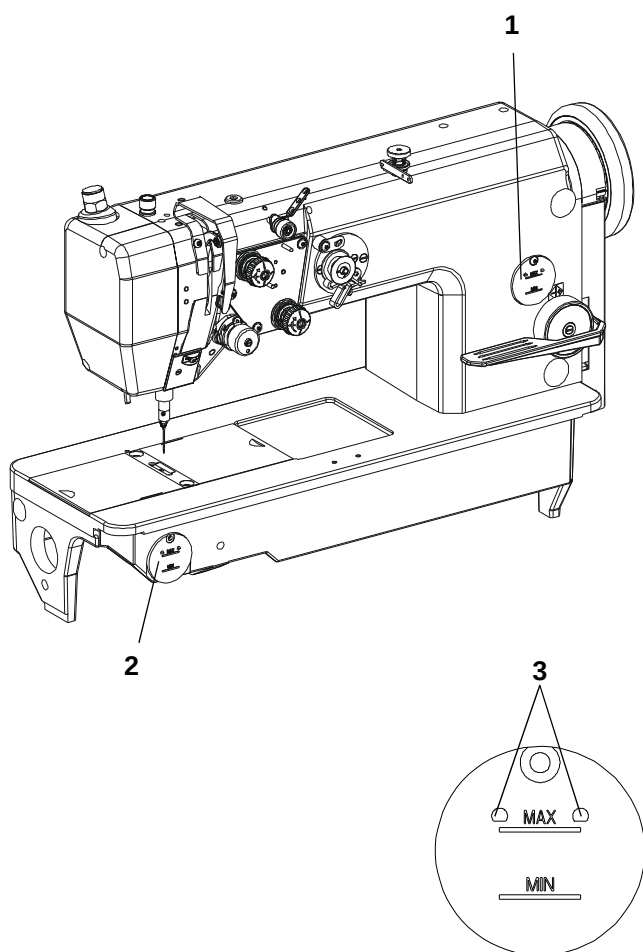
Caution! Risk of injury!
Maintenance work can only be carried out when the machine is off and the motor stops.

Maintenance work which must be carried out and the intervals between them and set out in the following table.

Maintenance work	Interval
Removing throat plate and its cleaning. Cleaning of circular feed dog, hook and space around feeding wheel of material and thread residues. To clean it, use brush. It is prohibited to use compressed air for cleaning without protective guards preventing injury of persons with flying impurities. Hook lubrication - (one drop of oil).	1 day
Checking the oil level in the hook lubrication oil tank.	1 week
Checking the oil level in the oil tank of the central distribution. Regreasing of the greasing spots of the trimming system (pins with felt).	1 month

For the lubrication of this machine Esso SP-NK 10, DA 10 or an equivalent quality lubricating oil is recommended (viscosity at 40° C: 10 mm²/s; flash point: 150°C).

The oil tank (1) of the central distribution and the tank (2) of the hook lubrication are to be filled the holes (3) up to the mark max.



Operating instructions for eventual trouble shooting

Meaning of abbreviations: NP - Instruction manual
SK - Instructions for service

Note: When the machine is driven by a stop motor, it is indispensable to check up, before starting its repair, the setting of its parameters according to NP, part B, par. 5.

Trouble	Cause	Method of troubleshooting
1. Upper thread breaking.	1.1 Incorrect threading of the upper thread. 1.2 Excessive thread tension. 1.3 Needle incorrectly inserted or damaged. 1.4 Needle thickness does not suit to that of thread or sewn material. 1.5 Hook point sticks the thread. 1.6 Needle thread excessively elastic. 1.7 Low quality thread. 1.8 Needle thickness unsuitable for the hole in the throat plate insert. 1.9 Damaged throat plate insert. 1.10 Incorrect setting of opening bobbin case lifter (little opening).	Thread the upper thread according to NP, par. 6.1. Set the tension according to NP, par. 6.4. Replace needle according to NP, par. 6.5. Use a thicker needle. Set distance between hook and needle according to SK, par. 3.1.3 and 3.1.5. Increase the hook timing and set the needle bar height according to SK, par. 3.2.3. Replace thread. Replace insert. Replace insert. Set according to SK, par. 3.1.6.
2. Lower thread breaking.	2.1 Incorrect threading. 2.2 Damaged bobbin.	Thread according to NP, par. 6.3. Replace bobbin.
3. Skipped stitches at the seam beginning after previous thread trimming.	3.1 Short thread end in needle after trimming (thread too tensioned in the moment of trimming). 3.2 Excessive thread tension. 3.3 Upper thread not squeezed, at the first needle piercing, between sewn material and rear edge of piercing hole. 3.4 Upper thread incorrectly caught by movable trimming knife. Lumps of thread remaining in hook space. 3.5 Needle too thick with regard to thickness of thread and sewn material.	Thread upper thread according to NP, par. 6.1. Reduce tension of pretension unit according to NP, par. 6.4. Accelerate slightly OFF position of main tensioner according to SK, par. 4.8; NP, part B, par. 5.2.2, 5.3.2; Mini-stop, par. 5.2.5 - parameter 192. Set thread tension according to NP, par. 6.4. Reduce height of wheel feeder according to SK, par. 3.5.3.2.1. Put nearer top roller to needle and shift it rearwards according to SK, par. 3.6.6.2. Set correctly hook opening according to SK, par. 3.1.6 and adjust setting of trimming cam according to SK, par. 4.3. Use thinner needle.
4. Stitch skipping.	4.1 Needle incorrectly inserted. 4.2 Too big distance between needle and hook point. 4.3 Incorrectly set needle hook timing or needle height. 4.4 Excessively elastic material or excessively elastic thread. 4.5 Damaged hook point.	Insert needle according to NP, par. 6.5. Set according to SK, par. 3.1.3 and 3.1.5. Set according to SK, par. 3.1.4 and 3.2.3. Increase timing as needed and set the needle bar height according to SK, par. 3.2.3. Replace hook.
5. Incorrect stitch locking. Threads are locked on top side of sewn material.	5.1 Lower thread tension. 5.2 Incorrect threading and tension setting of upper thread.	Set according to NP, par. 6.4. Thread according to NP, par. 6.1 set according to NP, par. 6.4.

6. Incorrect stitch locking. Threads are locked on bottom side of sewn material and increasing of tension is of upper thread no help.	6.1 Upper thread out of tensioning dishes.	Thread correctly according to NP par. 6.1.
	6.2 Opening bobbin case lifter incorrectly set (it opens too little).	Set according to SK, par. 3.1.6.
	6.3 Wheel feeder too low - difficult passage of thread between sewn material and throat plate.	Set wheel feeder height according to SK, par. 3.5.3.2.1.
	6.4 Upper thread insufficiently tensioned when passing through hook.	Shift thread limiter to the right and to the top according to SK, par. 3.4.5 or by more than the value quoted there.
7. Stitches insufficiently tightened and with irregular positioning. Thread unravelled.	7.1 Low tension of upper and lower threads.	Set tension according to NP, par. 6.4.
	7.2 Upper thread insufficiently tensioned when passing through hook.	Shift thread limiter to the top and to the right according to SK, par. 3.4.5 or more than the value quoted there.
	7.3 Thin needle with regard to thread thickness.	Use a thicker needle.
8. Sewn material wavy in seam.	8.1 Thread tension too high for sewn material.	Reduce tension of both threads.
9. Machine does not feed or is feeding slowly or in reverse sense.	9.1 Overrun safety clutch against hook overload.	Engage correctly clutch according to NP, par. 6.10.
10. Difficult and irregular machine feed.	10.1 Wheel feeder too low (especially when sewing soft and thick materials).	Raise feeder more from throat plate according to SK, par. 3.5.3.2.1.
	10.2 Feeder teeth unsuitable (too fine) for sewn material.	Use feeder with 1.2 mm teeth pitch. Replace according to SK, par. 3.5.3.2.2.
11. Hook blocked.	11.1 Incorrect lower thread threading when replacing hook bobbin - lower thread caught by hook point.	Thread lower thread according to NP, par. 6.3.
	11.2 Upper thread out of tensioning dishes and 2x caught by hook point.	Thread upper thread according to NP, par. 6.1.
	11.3 Insufficient gap between needle and piercing hole from hook side.	Set side position of the needle bar holder according to SK par. 3.2.5.
12. No upper thread trimming.	12.1 Incorrectly threaded thread.	Thread the thread according to NP, par. 6.1.
	12.2 Upper thread excessively braked when moving upwards due to thin needle, thick elastic material, low feeder position, low thread tension.	Insert thicker needle according to NP, par. 6.5. Lift wheel feeder according to SK, par. 3.5.3.2.1.
	12.3 Tensioner electromagnet cuts soon main tensioner during trimming.	Delay position of cutting the main tensioner according to SK, par. 4.8 and according NP, part B, par. 5.2.2, 5.3.2; Mini-stop, par. 5.2. - parameter 192.
	12.4 Fixed trimming knife does not fit with all its width against movable knife.	Set knives according to SK, par. 4.6.
	12.5 Movable knife does not run over movable knife edge.	Set knife according to SK, par. 4.5.
	12.6 During trimming cycle, safety clutch against hook overload gets disengaged.	Increase clutch disengaging moment according SK, par. 3.9.2.
13. No lower thread trimming.	13.1 Incorrect movable knife path setting.	Set knife according to SK, par. 4.5.
	13.2 Short movable knife path.	Increase path by correct fork setting according to SK, par. 4.4.
	13.3 Incorrect cam setting.	Set cam according to SK, par. 4.3.
	13.4 Incorrect trimming knife height setting.	Set height according to SK, par. 4.5.

14. Second and third stitches incorrectly locked at the beginning of sewing after previous trimming.	14.1 Incorrect setting of lower hook thread retaining spring.	Set spring according to SK, par. 4.7.
15. Pinched out cutting edge of cutting knife.	15.1 Pinching out of cutting edge during the knife exchange: The fastening screws have not been slightly tightened before setting the knife.	Fix the knife according to NP, par. 6.15.
	15.2 Faulty lateral position of the knife in relation to the throat plate insert: excessive pressure between the knife and the insert.	a) Switch off the machine, set the knife to its lower position, loosen the screws of the throat plate and retighten them. b) Set the lateral position of the knife as in SK.
	15.3 The knife collides with the sewn work guide.	Adjust the guide according to NP, par. 6.14.
16. Poor cutting quality.	16.1 Play between the cutting edges of the knife and of the throat plate insert.	a) Loosen the throat plate screws, press the throat plate against the knife and retighten the screws. b) Set the lateral position of the knife according to SK.
	16.2 Slow run of work cutter motor: faulty connection of supply transformer.	Change the branch of primary winding of the transformer according to NP, part B, par. 4.8.
	16.3 Blunt knife.	Exchange the knife.
17. Uneven stitch length of direct seam.	17.1 Blunt knife.	Exchange the knife.
	17.2 Sewing speed too great for the chosen stitch length.	Reduce the sewing speed according to NP, par. 5.
	17.3 Insufficient height of lower wheel feed over the throat plate.	Lift the feed wheel according to SK, par. 3.5.3.2.2.

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Part B - The instructions for assembling

1. Safety instructions

**Caution !**

Assembly of the machine must only be carried out by appropriately trained technician.

Any operations to be performed on the electric installation of the sewing machine are to be done only by a competent electrician.

2. The way of machine supply

The contents of supply will be determined in agreement between the supplier and buyer. There are following possibilities:

2.1 Complete head with accessories

In this case the supply contains:

- Complete head.
- Chosen spare parts in the bag under the presser element (see parts indicated * in catalogue of spare parts).
- Standard accessories (it contains tools-see module in catalogue of spare parts).
- Special accessories (it contains some components of a stand and upper belt cover-see module in catalogue of spare parts).

The supply like this is not complete. Buyer will provide missing components himself or he can put in an extra order to get them according to the following paragraphs.

2.2 Stand

Delivery contains components of a stand, however, without components of a stand included in special accessories supplied with machine head (see par.2.1) and without any electrical components.

If it hasn't been agreed otherwise, the stand is supplied in separate pieces. If the assembled stand is asked, special accessories are used from head supply.

Stand (ordered number S100 010000) contains following items:

MG55 000501	Stand frame
MG53 002501	Big treadle
MG53 007511	Set of parts for a stand
S615 000321	Table top

Equipment for foot lifting by treadle:

S522 000450	Small treadle
S980 060028	Foot lifting rod

2.3 Motor

The supply contains its own motor, switch - circuit breaker, all cabling (except of the plug) and material for connection. It can contain a control panel according to the type of motor. If it hasn't been agreed otherwise, it is supplied in separate pieces. A machine without trimming is equipped with clutch lever motor. However if positioning is asked or electromagnetic foot lifting or electromagnetic reverse stitching (bartacking) the machine without trimming must be equipped with stopmotor.

Motors are chosen according to the following table:

Machine subclass	Ordered number	Name	Diameter of pulley	Machine rev. max./min 50 Hz/60 Hz	Approx. specification
X11 X21	S359 600030 63	FIR 1148	63	2500/3000	asynchronous clutch motor; switch-circuit breaker with cabling; connection material
	S359 600030 50	3 x 400/230 V, 2800 RPM, 50 Hz	50	2000/2400	
	S359 600030 42		42	1600/2000	
	S359 600031 75	FIR 1147F	75	1500/1800	asynchronous clutch motor; switch-circuit breaker with cabling; connection material
	S359 600031 63	3 x 400/230 V, 1400 RPM, 50 Hz	63	1200/1500	
	S359 600031 42		42	800/1000	
X12 X22 X4X X5X	S359 600045 810	Stopmotor EFKA DC 1600/DA82GA 1 x 230 V, 50/60 Hz	58	adjustable	DC motor (AC servo) control panel V810; mains switch with cabling; connection material
	S359 600045 820		58	adjustable	DC motor (AC servo) control panel V820; mains switch with cabling; connection material
	S359 600052 63	Stopmotor EFKA * VD 552/6F82FA	63	2500/3000	asynchronous stopmotor with friction clutch and brake; switch-circuit breaker; connection material
	S359 600052 50	3 x 400/230 V, 2800 RPM, 50/60 Hz	50	2000/2400	
	S359 600052 42		42	1600/2000	
	S359 600056 75	Stopmotor EFKA * VD 554/6F82FA	75	1500/1800	asynchronous stopmotor with friction clutch and brake; switch-circuit breaker; connection material
	S359 600056 63	3 x 400/230 V, 1400 RPM, 50/60 Hz	63	1200/1500	
	S359 600056 42		42	800/1000	

* Control panel S359 600038/V810 or S359 600050/V820 it is possible to order for setting the stop motor, however, it is not included in supply of the stopmotor and it has to be ordered separately.



Above mentioned stop motors were tested in the machine and they meet functional requirements. Other types of stop motors can have but need not have suitable parameters. Producer does not recommend using the other stopmotor without testing.

2.4 Motor pulley

By stopmotor EFKA DC 1600/DA 82 GA is revolutions are set continuously by electronics.

The diameter of the motor pulley in mm must be by asynchronous motors according to the following quotation:

$$\text{Diameter of pulley} = 71 \times \frac{\text{sewing speed (st/min)}}{\text{motor revolutions (rev./min)}}$$

The smallest diameter of pulley is 42 mm considering used V-belt. Belt cover on the motor limits the biggest diameter of pulley to 127 mm.

The pulley for the maximum or other sewing speed will be supplied on express wish of the customer.

Motor pulley diameter

Sewing speed of machines: standard ¹⁾

Mains voltage frequency: 50 Hz

		Ordered number/motor pulley diameter ²⁾				
Model	Sewing speed (SPM)	EFKA DC 1600/DA82GA 3312 4000 RPM	EFKA VD 552/6F82FA 2800 RPM	FIR 1148/552/3 2800 RPM	EFKA VD 554/6F82FA 1400 RPM	FIR 1147F/554/3 1400 RPM
1180-5XX-100	2500					
-200	2500	S359 600045 810/ø 58	S359 600052 63/ø 63	S359 600030 63/ø 63	-	-
-300	1600	S359 600045 820/ø 58	S359 600052 42/ø 42	S359 600030 42/ø 42	S359 600056 75/ø 75	S359 600031 75/ø 75
-400	1200		-	-	S359 600056 63/ø 63	S359 600031 63/ø 63

¹⁾ When the customer will not order anything else, he will get a pulley for standard sewing speed. Owing to a limited assortment of pulleys, the effective sewing speed may slightly differ from that declared and quoted in the column.

²⁾ The table gives effective pulley diameter which is by 4 to 5 mm lower than the outer diameter.

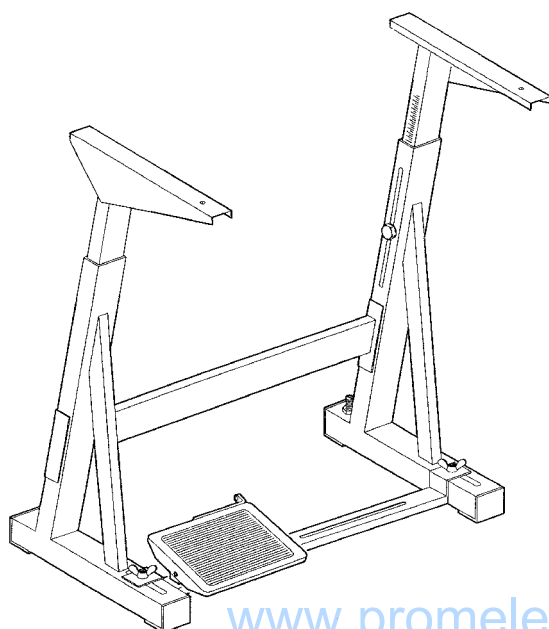
Note.: The effective diameter of the hand wheel pulley is 71 mm.

Sewing speed of machines: standard ¹⁾
Mains voltage frequency: 60 Hz

		Ordered number/motor pulley diameter ²⁾				
Model	Sewing speed (SPM)	EFKA DC 1600/ DA82GA 3312 4000 RPM	EFKA VD 552/ 6F82FA 3360 RPM	FIR 1148/552/3 3360 RPM	EFKA VD 554/ 6F82FA 1680 RPM	FIR 1147F/554/3 1680 RPM
1180-5XX-100	2500	S359 600045 810/ø 58 S359 600045 820/ø 58	S359 600052 50/ø 50	S359 600030 50/ø 50	-	-
-200	2500		-	-	S359 600056 63/ø 63	S359 600031 63/ø 63
-300	1600		-	-	S359 600056 42/ø 42	S359 600031 42/ø 42
-400	1200		-	-		

When the customer requires another sewing speed than standard, he may additionally order another pulley according to the following table:

Motor	Sewing speed 50 Hz	Sewing speed 60 Hz	Diameter of pulley (mm)	Ordered number
FIR 1148/552/3 EFKA VD552	1660	1990	42	S980 045548
	1850	2220	47	S980 045377
	1970	2370	50	S980 045491
	2130	2560	54	S980 045361
	2290	2740	58	S980 045472
	2480	2980	63	S980 045378
	2640	3170	67	S980 045476
	2760	3310	70	S980 045370
	2960		75	S980 045384
	3150		80	S980 045479
	3350		85	S980 045480
FIR 1147F/554/3 EFKA VD554	830	990	42	S980 045548
	930	1110	47	S980 045377
	990	1180	50	S980 045491
	1060	1280	54	S980 045361
	1140	1370	58	S980 045472
	1240	1490	63	S980 045378
	1320	1590	67	S980 045476
	1380	1660	70	S980 045370
	1480	1770	75	S980 045384
	1580	1890	80	S980 045479
	1680	2010	85	S980 045480
	1770	2130	90	S980 045481
	1970	2370	100	S980 045483
	2090	2510	106	S980 045484
	2210	2650	112	S980 045485
	2500	3010	127	S980 045337



3. Table top

In case buyer will provide his own table top its drawing is shown in supplement.

4. Machine assembly

It is described machine assembly with stand here which is supplied in separate pieces. Otherwise use these instructions adequate.

4.1 Stand frame assembly

A frame is assembled according to the picture.

4.2 Assembly of components on the bottom of table top

- Put down antiskid (rubber) bands on the stand frame.
- Turn the table top up side down and put it down on prepared bands.
- By means of screws screw the drawer (1) down.
- Nail down the rubber stop (2).
- By means of screws fasten transformer for lighting (3) if available.
- By means of screws fastened transformer for trimming (4) if available.
- By means of screws fasten switch – circuit breaker (5).
- Screw the motor holder down (6) (possibly motor). Lever clutch motor is assembled into the holes (A). Stopmotor into holes (B).
- By means of clips (7) install transmission line of heavy current conductors. Connection is different from the type of motor, supply voltage and number of conductors of electric supply. In case of quad (four wire) supply 3 x 400 V, transformer for lighting must be supplied with separate supply cable 1 x 230 V.



Caution!

The voltage in the mains must be in conformity with the voltage indicated on the drive plate.

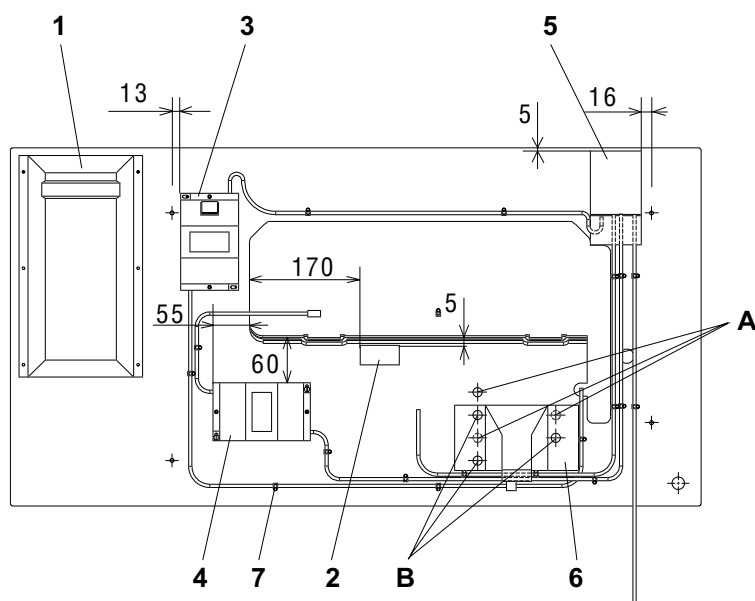


Caution!

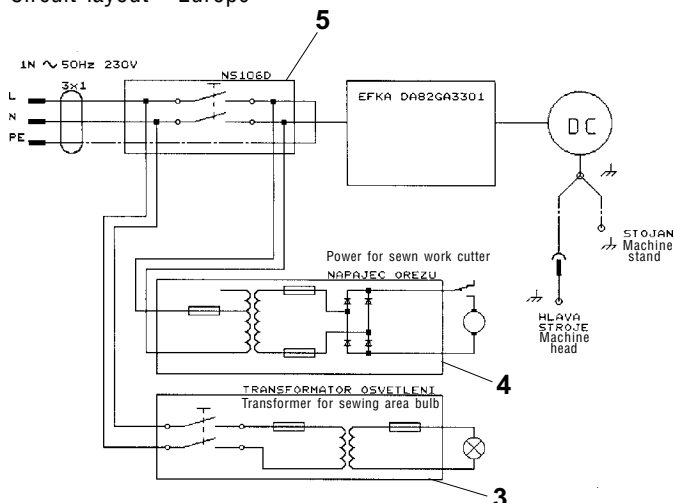
The transformer of the bulb for the sewing area is not switched off by the main switch (EN 60204-3-1). Before proceeding to any repair operation in the transformer box (such as a fuse exchange) the plug categorically must be taken out of the socket. Such operations may be carried out only by persons with adequate electrotechnical skill.

Choose the suitable variant according to the pictures:

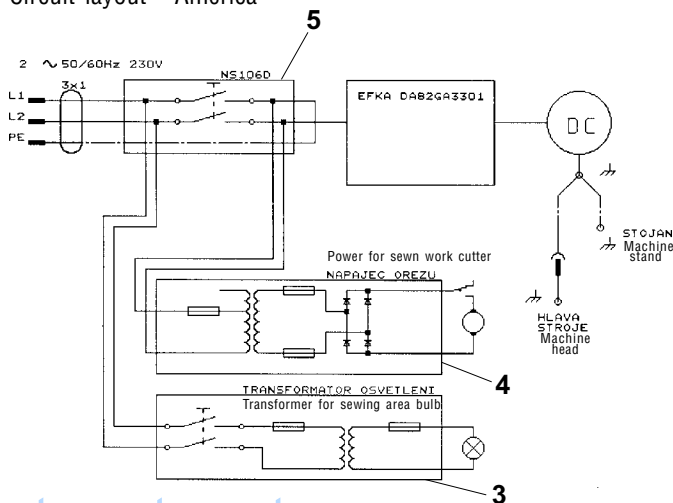
4.2.1 Power supply 1 x 230 V - DC motor



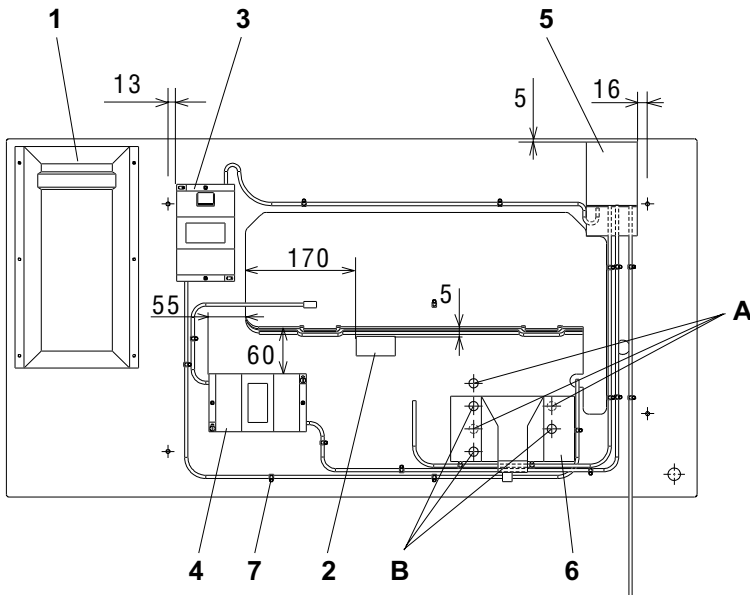
Circuit layout - Europe



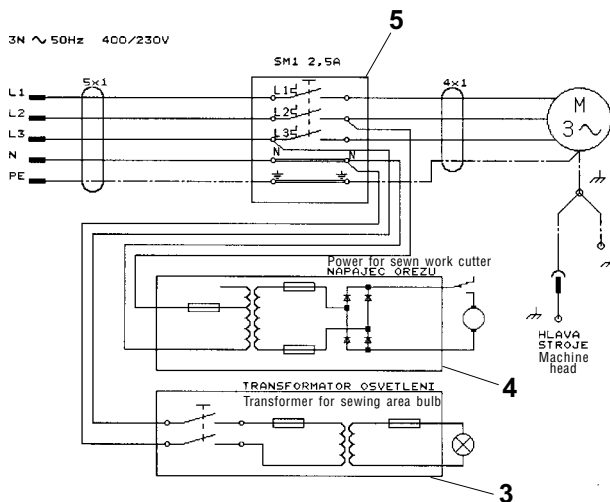
Circuit layout - America



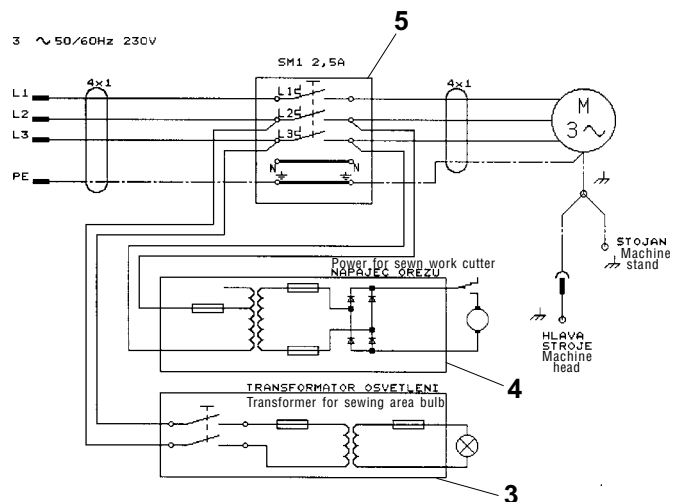
4.2.2 Power supply 3 x 400 V - five wire power distribution, power supply 3 x 230 V - four wire or five wire power distribution



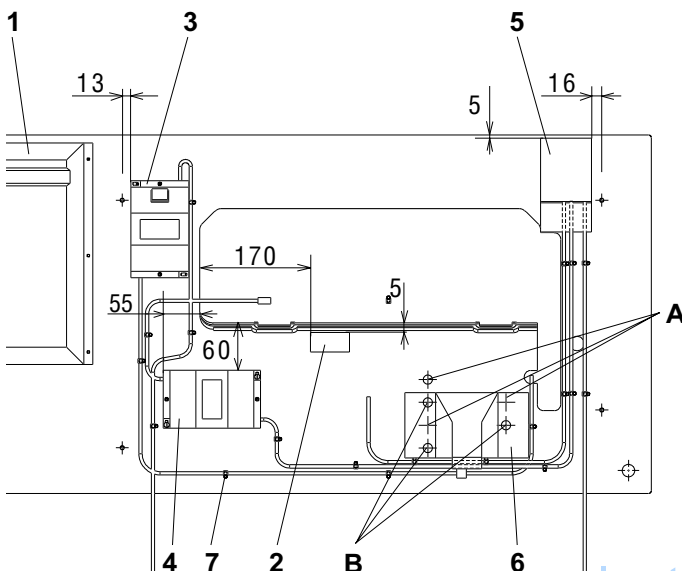
Circuit layout - Europe



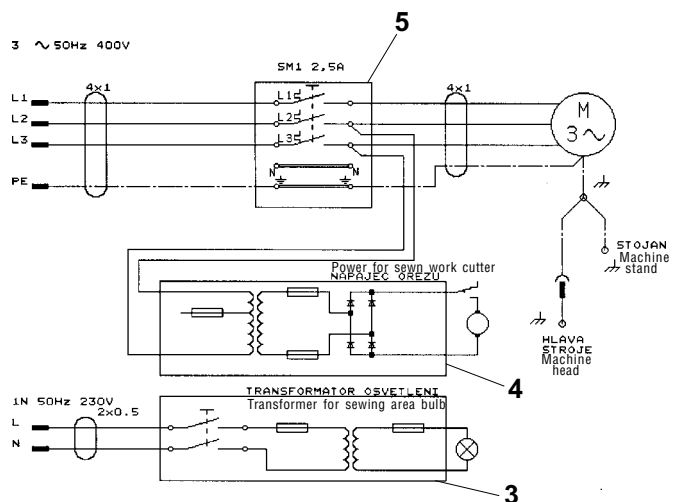
Circuit layout - America

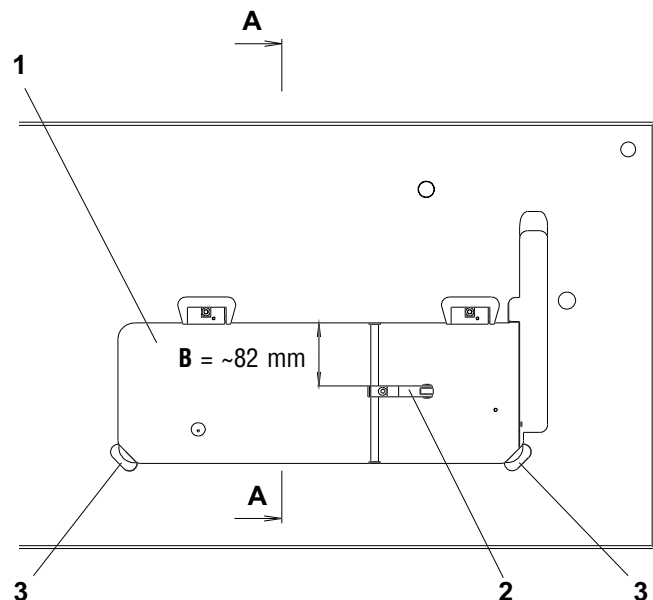


4.2.3 Power supply 3 x 400 V - four wire power distribution plus 1 x 230 V - two wire cable

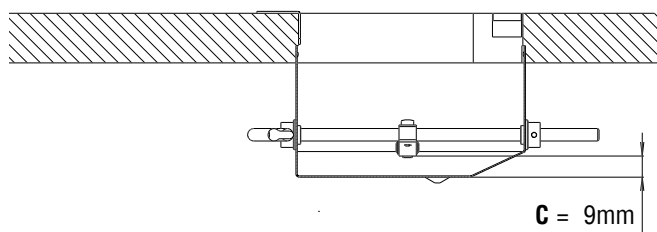


Circuit layout



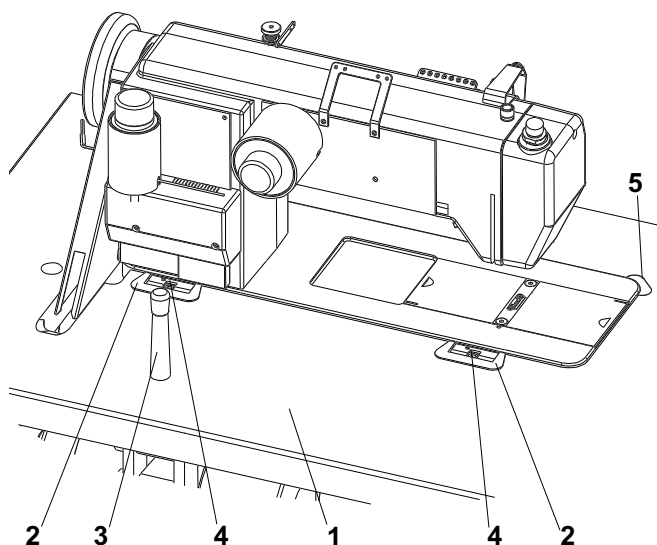


A - A



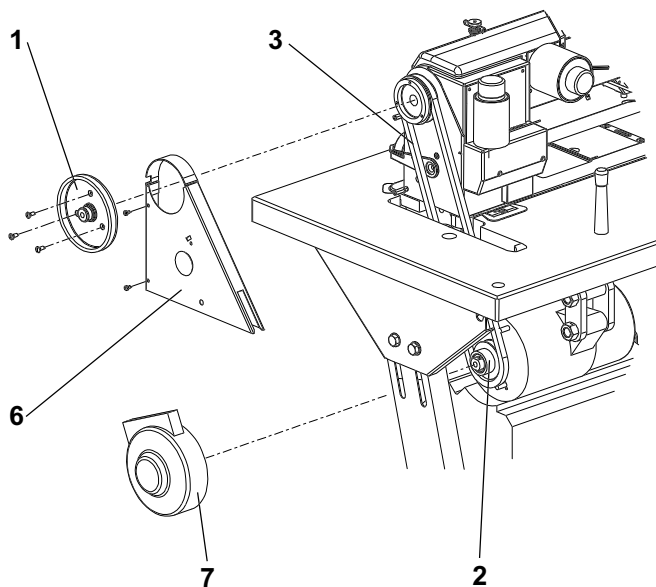
4.3 Assembly of a table top on a stand frame, assembly of oil tank

- Turn the table top around and screw it down to the frame by means of screw $\varnothing 8 \times 35$ mm.
When applying a frame different from that recommended by the producer, be sure to adapt its position so as to ensure the stability of the machine head in its tilted state.
- Oil tank (1) with assembled lever (2) insert through the bottom part into the cut hole in the table top and put down as shown in that way, that the edge of the tank would fit in with the edge of the cut hole in the table top. Set the height of the tank according to the section A-A. Tank may not protrude out of upper surface of a table top. Nail down the tank with nails $\varnothing 2 \times 40$ mm.
- Adjust the lever (2) to the dimensions "B" and "C".
- Insert rubber inlays (3) into the groove in a table top.



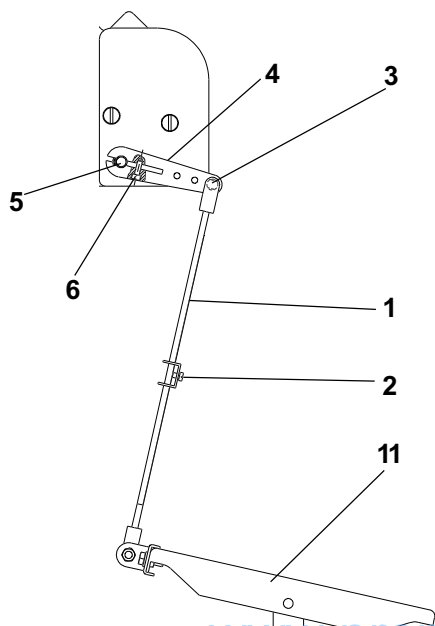
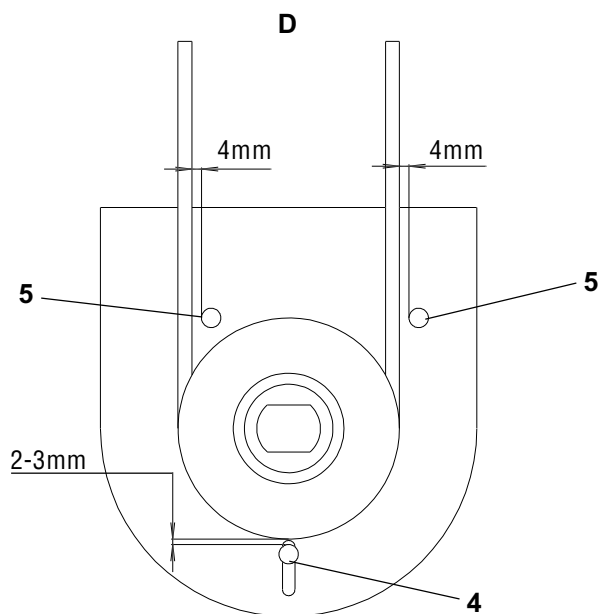
4.4 Assembly of machine head onto a stand

- Stick down rubber inlays (2) with glue into the table top (1).
- Disassemble transported tank (cover) from the machine head and assemble hangers (4) on the head.
- Put the head down into the rubber inlays (2) and (5).
- Define space along circumference of basic machine plate - 1,5 mm.
- Insert supporting pin (3).



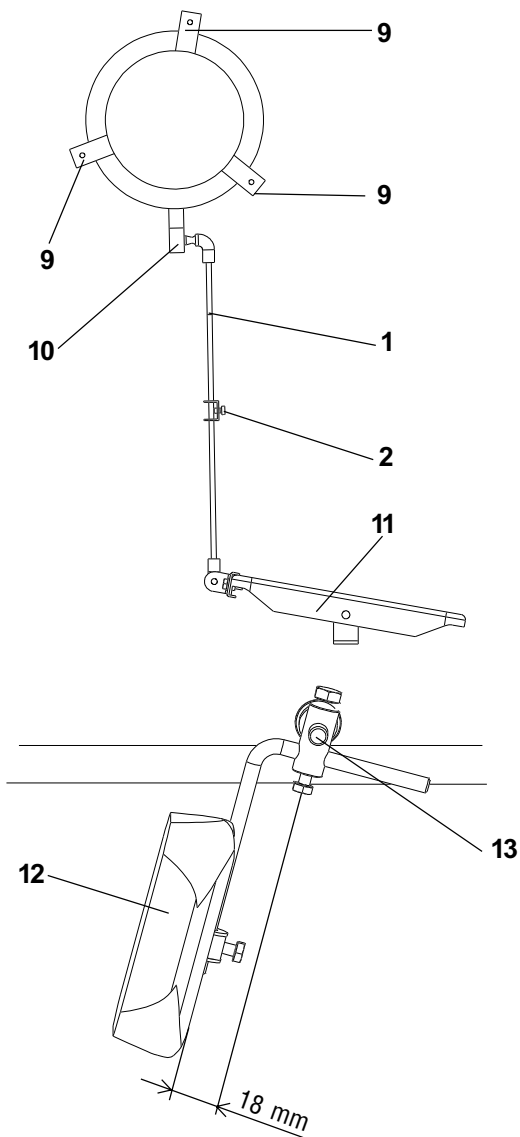
4.5 Assembly of motor pulley, belt, belt covers, hand wheel

- Disassemble hand wheel (1).
- Assemble motor pulley (2).
- Insert V-belt (3) and tighten it by leaning out of the motor. V-belt is tightened correctly when the opposite sides of belt are approaching to each other in distance of about 20 mm with power 10 having an effect in the middle of both sides. Stop motor should be leveled so that the bottom surface of its control panel would be horizontal.
- Adjust the stop (4) by bigger pulleys against falling the belt out of the pulley so that the distance from the belt will be 2-3 mm. Adjust pins by smaller pulleys (5) according to the detail (D).
- Assemble the bottom cover belt (7) on to the motor.
- Assemble upper cover belt (6) and hand wheel (1) by clutch lever motor.
- Assemble upper cover belt (6), hand wheel (1) and position reader by stop motor but only after electrical connection of the head to the stopmotor (see par. 4.7).



4.6 Assembly of treadle rod, setting rod and of position reader, knee lever

- Insert treadle rod (1) on pins.
- Adjust approx. length of rod by means of screw (2). If the ends of rod are too long, shorten them.
- Install the pin into the hole (3) by stopmotor EFKA. Adjust the lever (4) so that it would be approx. square angle at a rod (1) - take off the ring (5), loosen the screw (6), take of the lever (4) and assemble it into desirable position.



- Loosen the screws (9) by clutch lever motor and turn the motor with lever in such a way that the lever (10) would be in direction of the rod axis (1).
- Adjust angular turning of treadle (11). The position of treadle is correctly adjusted if there is a square angle at the shin-bone of the operator to the treadle.

- Fasten knee lever (12) onto the shaft (13) and adjust it in a position that it is shown in the picture (slightly leant out).

4.7 Electrical connection of machine head to the stopmotor

4.7.1 Connecting cable

Together with the machine head there is supplied a connecting cable for the following drives:

EFKA DC 1600/DA82GA 3311 and higher

EFKA VD 552/6F82FA 2315 and higher

EFKA VD 554/6F82FA

When there is no drive specified, a cable without any connecting power plug is supplied (mind the caution 2.3).

For the information sake, there are given the respective circuit layout.

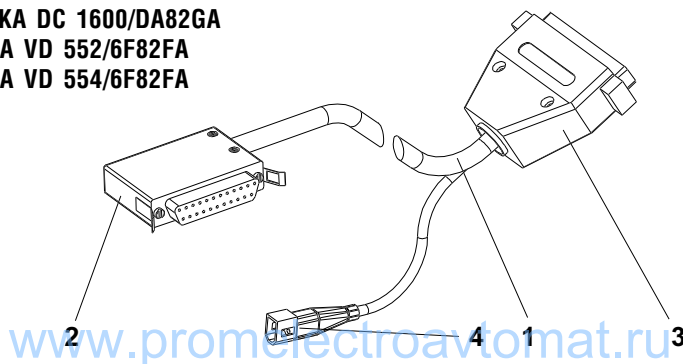
The colours are indicated with numbers in brackets (6 – green, 7 – blue, 8 – pink, 9 – black, 10 – white, 11 – violet, 12 – yellow, 13 – red, 14 – grey, 15 – brown). Included insulating covers PVC (5) are put on the bunches and they are put together with remaining part of cable insulation by means of contracted tube (4) (it is heated up with fire of lighter).

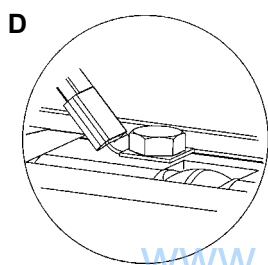
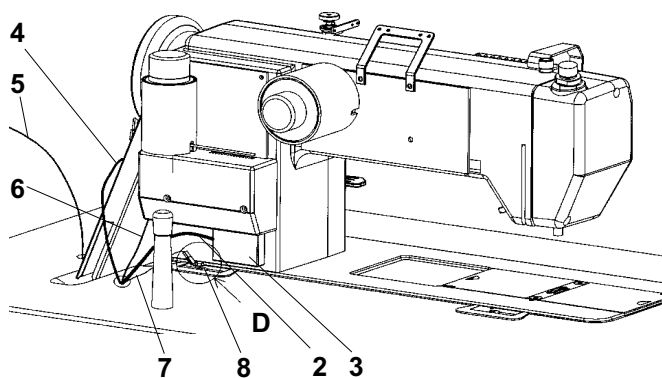
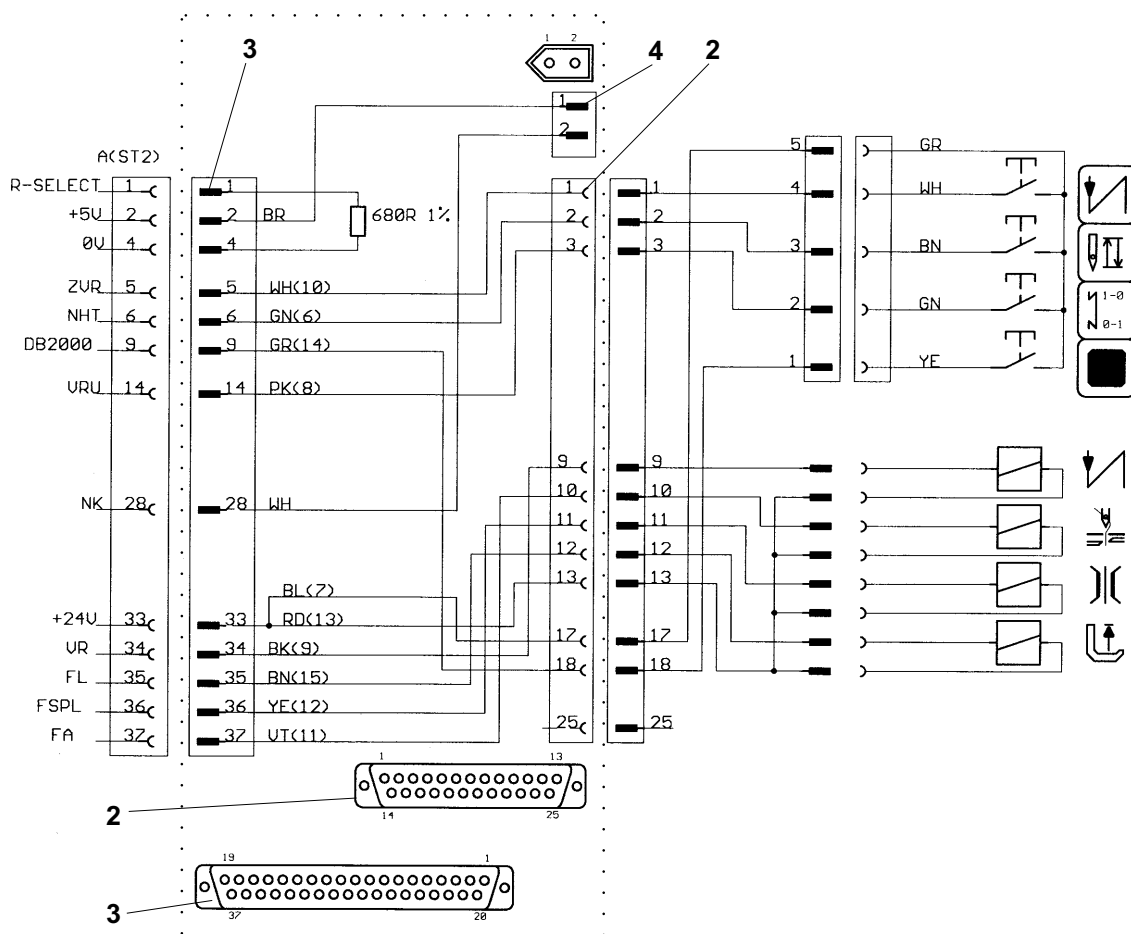
Power connecting cable is marked off with dotted line in circuit layout.

Stopmotor S359 600045 XXX - EFKA DC 1600/DA82GA

Stopmotor S359 600052 XX - EFKA VD 552/6F82FA

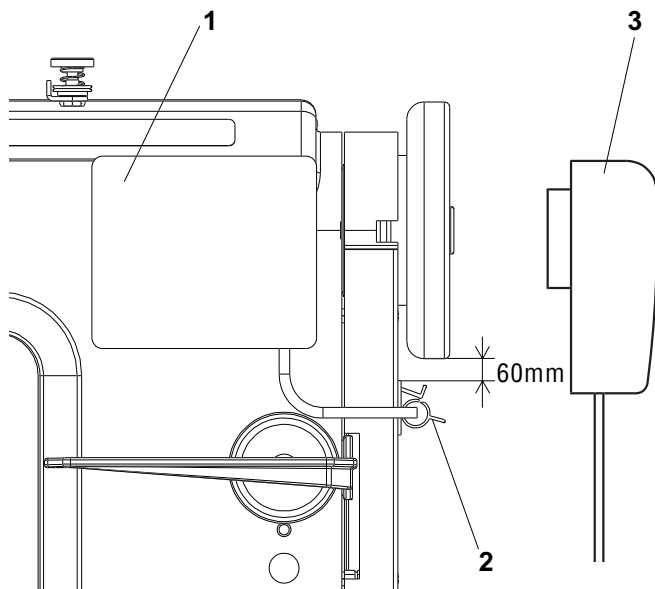
Stopmotor S359 600056 XX - EFKA VD 554/6F82FA





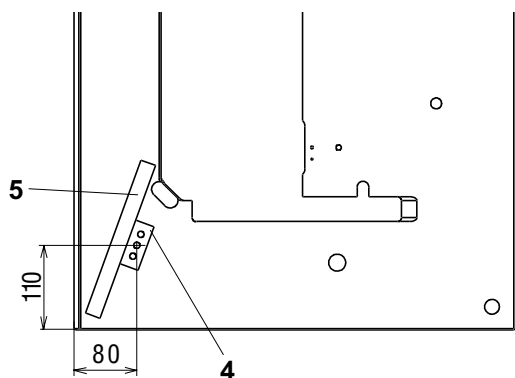
4.7.2 The actual electrical connection

- Install the power supply cable (2) so that connector (3) is in the direction of a head. The other connector (connectors) is (are) connected into terminal box rack of the stop motor according to the pictographs that are situated on it.
- Install the cable of control panel (4) and connect it to the terminal box of stop the motor according to the pictographs.
- Pass the cable of position reader through (5) and connect it to the terminal box of the stopmotor according to the pictographs.
- Install lighting if available and connect its cable (6) to the cable of transformer.
- Install the earthing cable (7) one end to the hanger (8) and second end to the holder of stopmotor.

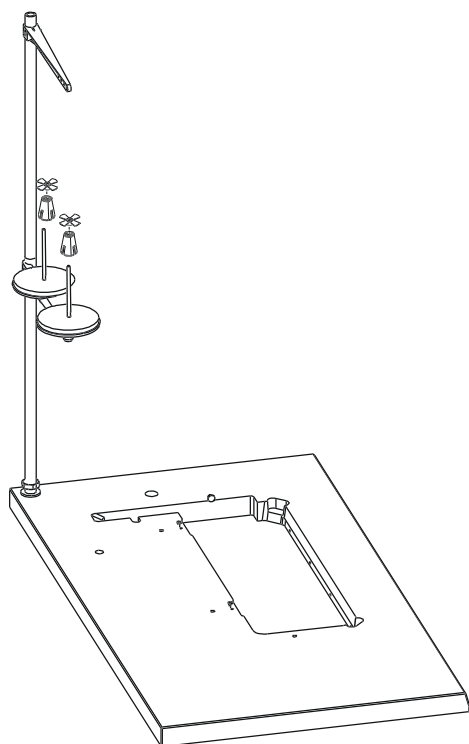


4.7.3 Fastening upper cover belt, position reader, control panel of stopmotor and thread stand

- Screw the stop to the belt guard.
- Assemble upper cover belt and hand wheel according to par.4.5.
- Set the position reader (3) on the handwheel pin so as to match the stop groove of the position reader with the stop (thus immobilizing the position reader).
- Fix the position reader by retightening the two hexagonal screws.
- Fix the control panel of stopmotor:
- Stick the panel V 810 (1) by stopmotor EFKA on the machine head (if any). Defat the contact surface properly. Stick the clip (2) on the cover belt.

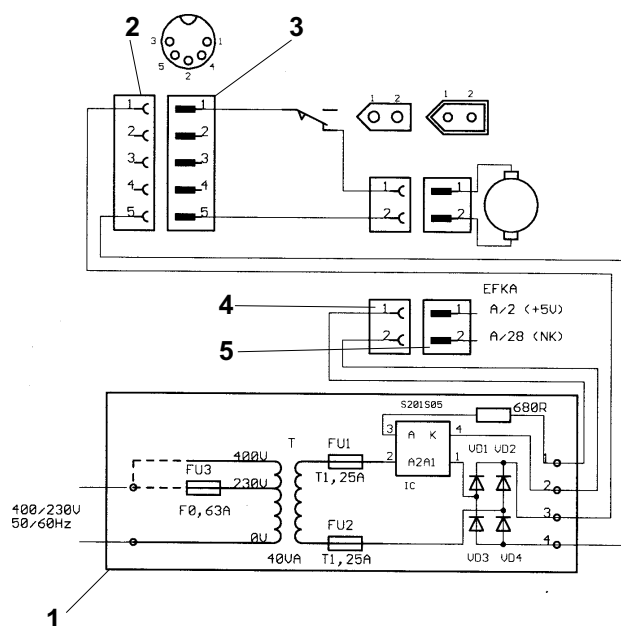


- With the Efka stopmotor, mount the holder (4) on the panel V820 (5) (if any) using screw and screw on the holder with the panel to the stand table.

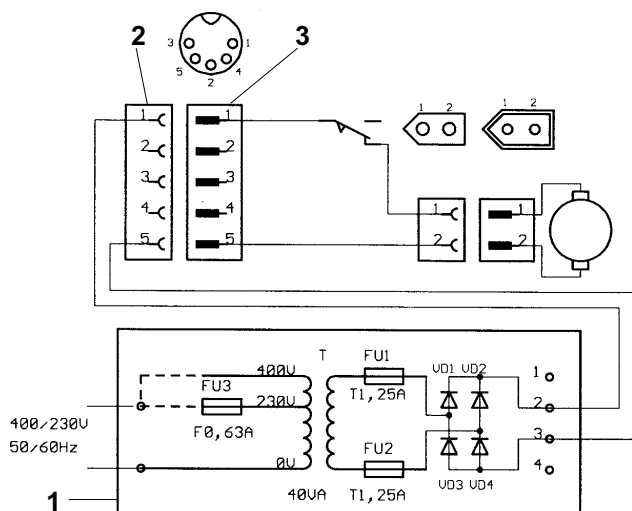


- Assemble the thread stand so that its arms would be parallel to the longer edge of a table top.

Wiring diagram of work trimmer and its supply



Wiring diagram of work trimmer and its supply



4.8 Wiring of the work trimmer

4.8.1 For machines having the Efka stopmotor

- Remove the cover of the work trimmer power supply (1).
- Check the connection of the power supply cable with the primary winding of the transformer and adapt it, if needed, as specified in par. 4.2. Mount the cover.
- Pass the connector (2) through the hole for the V-belt in the table top, fix the cable from the rear side to the machine head by the attached self-seal clip (be sure to degrease the seal area first).
- Connect the connector (2) to the plug situated under the motor of the work cutter.
- Check the sense of rotation of the work cutter shaft whose end fitted with a notch can be seen through the hole in the work cutter cover. The shaft must rotate clockwise. If this is not the case, reverse the polarity of the outputs 3 and 4 in the feeder (1).
- Connect the connector (4) into the connector (5) on the connecting cable.

4.8.2 For machine having the clutch motor

- Remove the cover of the work trimmer power supply (1).
- Check the connection of the power supply cable with the primary winding of the transformer and adapt it, if needed, as specified in par. 4.2. Mount the cover.
- Pass the connector (2) through the hole for the V-belt in the table top, fix the cable from the rear side to the machine head by the attached self-seal clip (be sure to degrease the seal area first).
- Connect the connector (2) to the plug situated under the motor of the work cutter.
- Check the sense of rotation of the work cutter shaft whose end fitted with a notch can be seen through the hole in the work cutter cover. The shaft must rotate clockwise. If this is not the case, reverse the polarity of the outputs 2 and 3 in the feeder (1).

5. Basic setting of stopmotor and position reader

5.1 Generally

The procedure of setting parameters of the stopmotor S359 600045 XXX - EFKA DC 1600/DA82GA on the level of the operator is described in the first part of the Instruction manual - par. 7.2.1.2 (V810); par. 7.2.2.2 (V820).

A correct function of the sewing machine with drive is attained when changing some parameters of the drive, which are inaccessible for the attendance of the machine. Hereinafter there is a description of the possible procedures of changing all parameters.

Procedure of changing parameters of the drive Efka S359 600045 810 - DC 1600/DA82GA; S359 600052 XX - VD 552/6F82FA and S359 600056 XX - VD 554/6F82FA (panel V 810)

- depress the pushbutton **P** on panel and switch on thereafter the main switch
- on the display there will appear **C 0000**, the 1st digit flashes
- using pushbutton **+** - set the 1st digit on the value **3**
- depress the pushbutton **>>**, the 2nd digit flashes
- in the same way set the remaining digits in the way to get displayed on the display **C 3112** (the number of the code for the possibility of changing all parameters of the drive)
- depress the pushbutton **E**, on the display will appear **F 200** (parameter number **200**)
- using pushbuttons **>>**, **+**, **-** - set the required parameter number and depress the button **E**
- using pushbuttons **+**, **-** - set the required parameter value
- depress the pushbutton **E** (a parameter number following in the sequence will appear) or **P** (the same parameter number will appear)
- carry out the termination of changes in depressing the pushbutton **P** (return to the respective sewing mode)

You will find a detailed information in the original directins for use of the drive.

Note: To get the change of parameters permanently stored, it is necessary, after having changed the parameter, to depress the pedal in forward direction.

Procedure of changing parameters of the drive Efka S359 600045 820 - DC 1600/DA82GA; S359 600052 XX - VD 552/6F82FA and S359 600056 XX - VD 554/6F82FA (panel V 820)

- depress the pushbutton **P** on panel and switch on thereafter the main switch
- on the display there will appear **C 0000**, the 1st digit flashes
- using pushbutton **0 ÷ 9** set **C 3112** on the display (code number for possible changing of all drive parameters)
- depress the pushbutton **E**, on the display will appear **F 200** (parameter number **200**)
- using pushbutton **0 ÷ 9**, set the required parameter number and depress the pushbutton **E**
- using pushbutton **+**, **-** , set the required parameter value
- depress the pushbutton **E** (there will appear further parameter number in the given sequence) or **P** (return to the given sewing mode)
- the termination of changes is to be done in depressing the pushbutton **P** (return to the sewing mode)

A detailed information is in the original directions for use of the drive.

Note.: To get the change of parameters permanently stored, it is necessary, after having changed the parameter, to depress the pedal in forward direction.

5.2 Stopmotor setting S359 600045 XXX - EFKA DC 1600/DA82GA 3312

5.2.1 Setting position reader

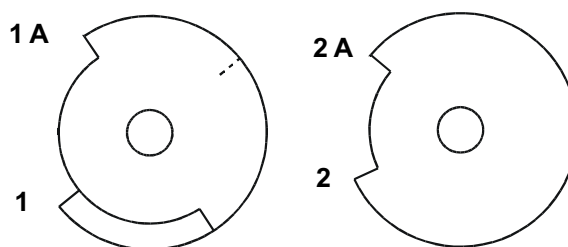
- set parameter **170**, **Sr1** is shown on the display (reference position)
- depress pushbutton **>>**, **PoS 0** appears on the display and changing symbol of rotation
- turn the hand wheel until symbol of rotation disappears
- turn the hand wheel to angular value **105°** of hand wheel (thread tip is approx. in the level of throat plate)
- depress pushbutton **E**, changeover to parameter **171**
- set parameter **171**, **Sr2** is shown on the display (all positions)
- depress pushbutton **>>**
- **1 XXX** is shown on the display (value of first position of needle)
- turn the hand wheel until value **XXX** begins changing
- turn the hand wheel to the angular value of first position (**135°** on the hand wheel respective **30** on the panel)
- depress pushbutton **E**
- **2 XXX** is shown on the display (value of upper position of take-up lever)
- turn the hand wheel until value **XXX** begins changing
- turn the hand wheel to the angular value of upper position (**65°** on the hand wheel respective **450** on the panel)
- depress pushbutton **P** 2x (return to the sewing mode)
- step shortly treadle down forwards (entry to the memory)

5.2.2 Changes of setting parameters of stopmotor setting considering original producer setting

Parameter No	Parameter value	
111	-	Max. revolutions (according to a type of machine)
116	180	Trimming revolutions
170	-	Reference position
171	30	First position of needle
183	500	Switching off delay of the trimming device after having ended the sewing operation (ms) /value range 0 - 5000/
192	340	Delay angle of tensioner switch on
202	120	Delay of start run after switch off the signal foot
225	3	Type of the machine

5.3 Setting stopmotor S359 600052 XX-EFKA VD 552/6F82FA and S359 600056 XX-EFKA VD 554/6F82FA

5.3.1 Setting position reader



Positions are set by means of discs with cut outs directly in position reader.

Setting bottom position:

- Disassemble the cover of position reader
- Disconnect head power supply cable from drive
- Switch on the power supply switch
- Step treadle shortly down forwards (machine stops in first position of needle)
- Switch off the power supply switch
- Turn the beginning of cut out **1** of coinciding discs so that machine would stop at the value **135°** of the hand wheel
- Carry out check by repeating procedure

Setting upper position of thread lever:

- Step treadle down backwards (machine stops in upper position of needle)
- Switch off the power supply switch
- Turn the beginning of cut out **2** of separate disc so that machine would stop at the value **65°** of the hand wheel
- Carry out check by repeating procedure

5.3.2 Changes in parameters of stopmotor setting considering original producer setting

Parameter No	Parameter value	
111		Max. revolutions (according to a type of machine)
116	180	Trimming revolutions
136	ON	Stitch by thread trimmer (back)
183	500	Switching off delay of the trimming device after having ended the sewing operation (ms) /value range 0 - 5000/
192	86	Delay angle of tensioner switch on
202	120	Delay of start run after switch off the signal foot

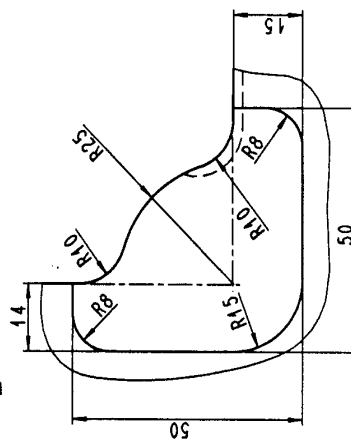
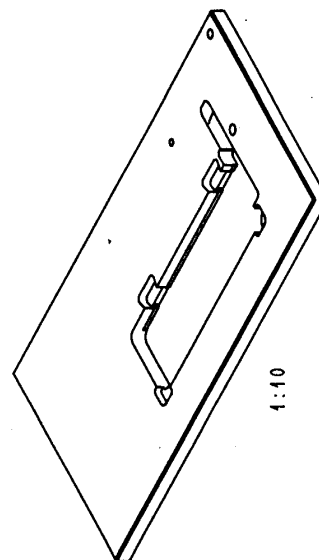
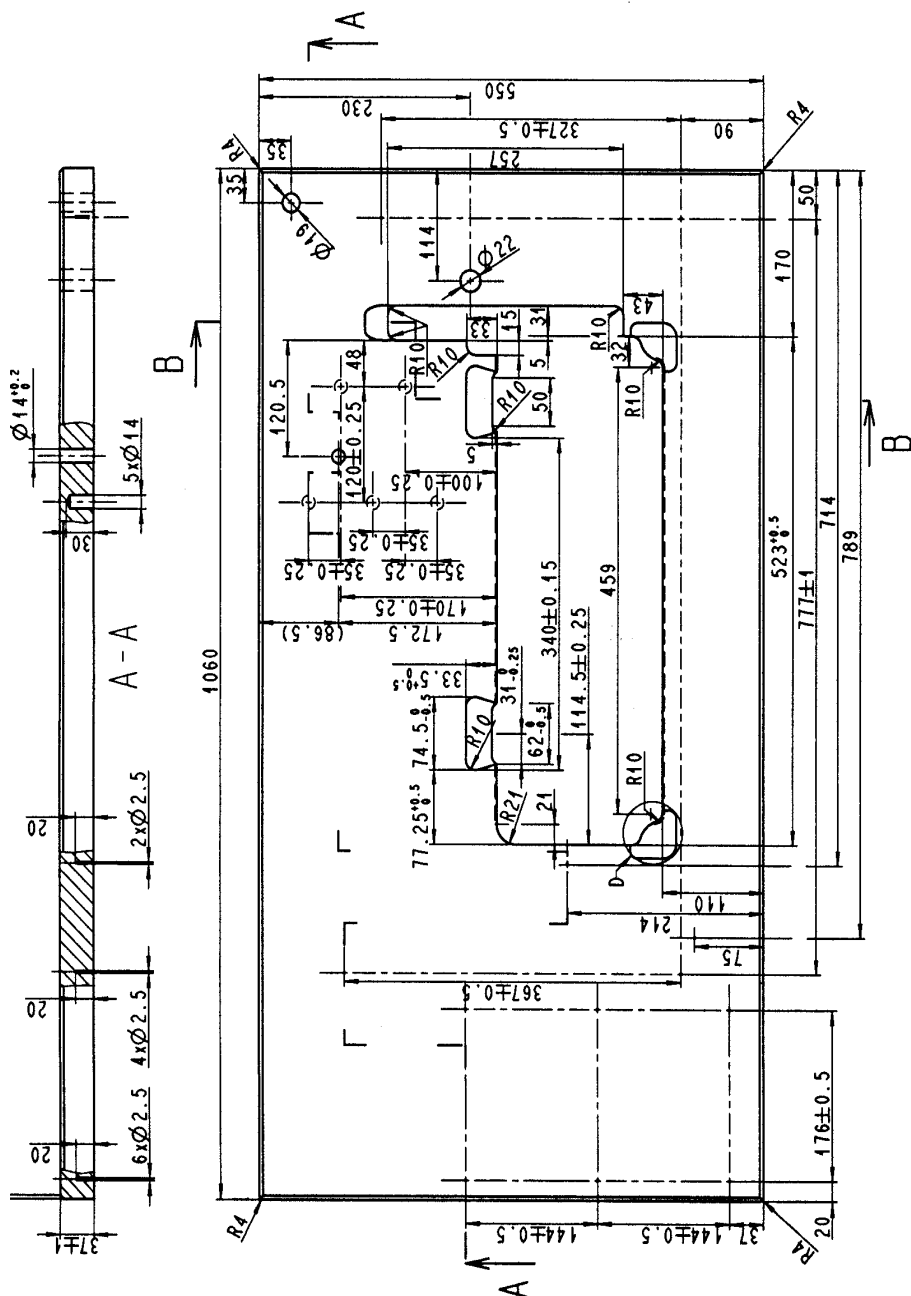
6. Examination of sewing



Caution! Risk of injury!

Before threading a thread switch the main switch off and wait until the motor stops.

- Check the sense of turning the hand wheel – according to the arrow situated on it.
- Thread a thread.
- Choose sewing material.
- Switch the desirable function on the control panel of stopmotor. Examination should be carried out with selection of fancy bar.
- First sew slowly then speed up the sewing.
- If the stitch does not meet requirements, follow the first part of instructions manual or service book.



D (1:1)