



1281/5-1

Sewing unit for closing seams for trousers and skirts

Operating Instructions

[Installation Instructions](#)

Service Instructions

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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 in full knowledge 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 threading, 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, disconnect the machine from the compressed air supply system (max. 7-10 bar). Before disconnecting, reduce the pressure of the maintenance unit. 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.
13. The line cord should be equipped with a country-specific mains plug. This work must be carried out by appropriately trained technicians (see paragraph 8).



It is absolutely necessary to respect the safety instructions marked by these signs.

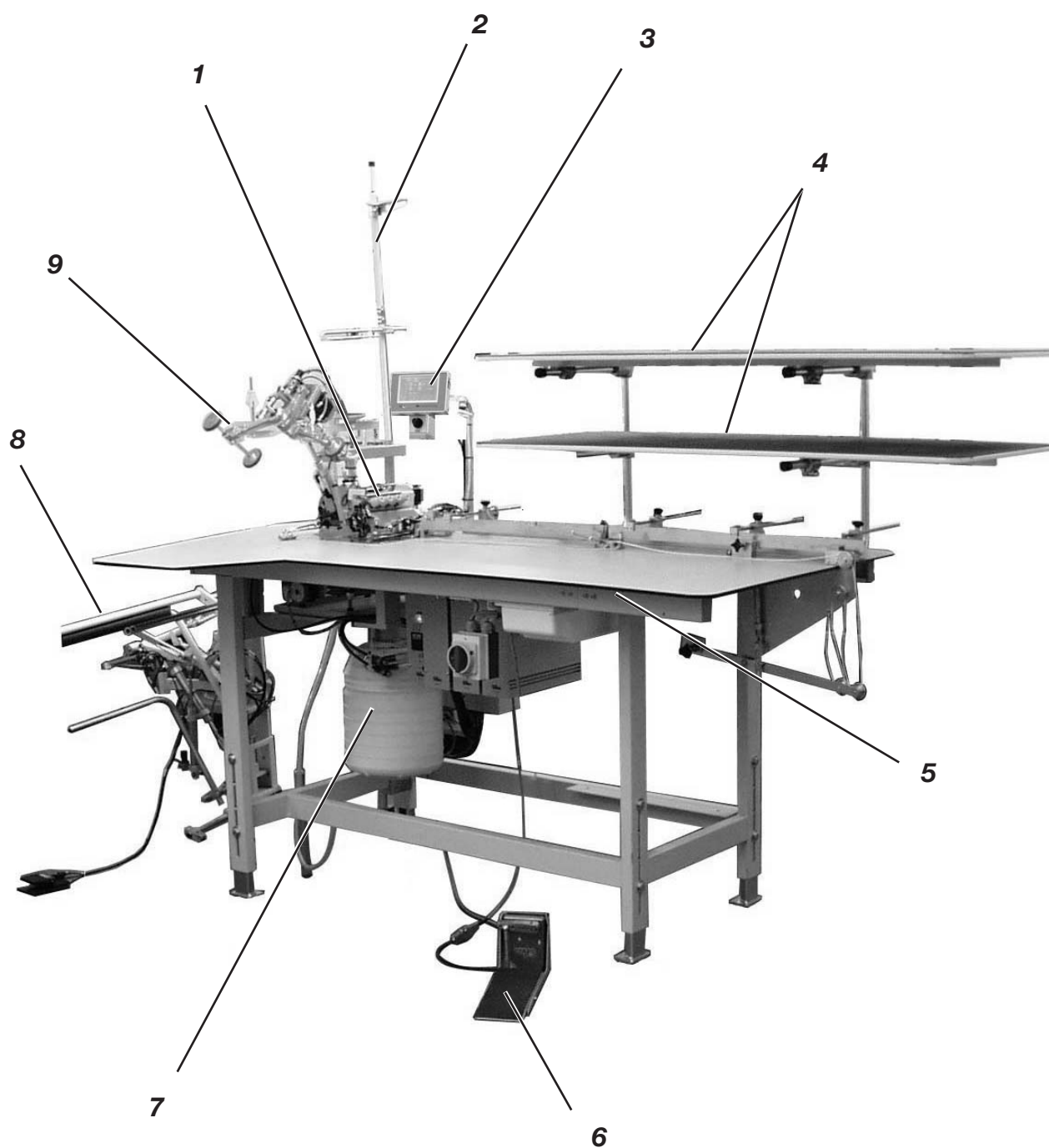
Danger of bodily injuries !

Please note also the general safety instructions.



Part 2: Installation Instructions Cl. 1281/5-1

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1 Scope of delivery

The scope of delivery **depends upon your order**.
Sewing unit comprising:

- **1** Sewing machine head (depending upon order)
- **2** Yarn stand
- **2** Control system with operating panel
- **4** Workpiece storage members
- **5** Stand with table top
- **6** Pedal
- **7** Suction unit with suction container
- **8** Stacker
- **9** Transport unit with puller
- Compressed air monitoring unit with air blow gun

2 General Information

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ATTENTION !

The sewing unit may be set up only by trained and qualified personnel.

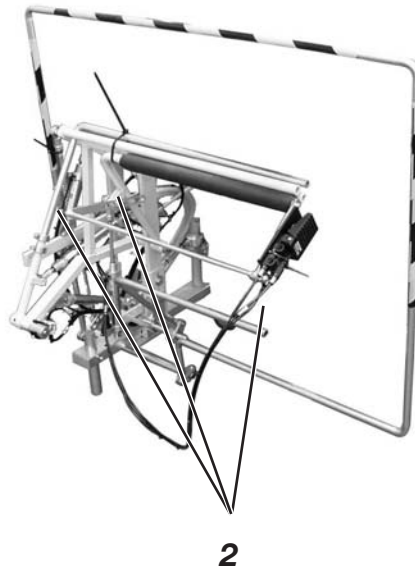
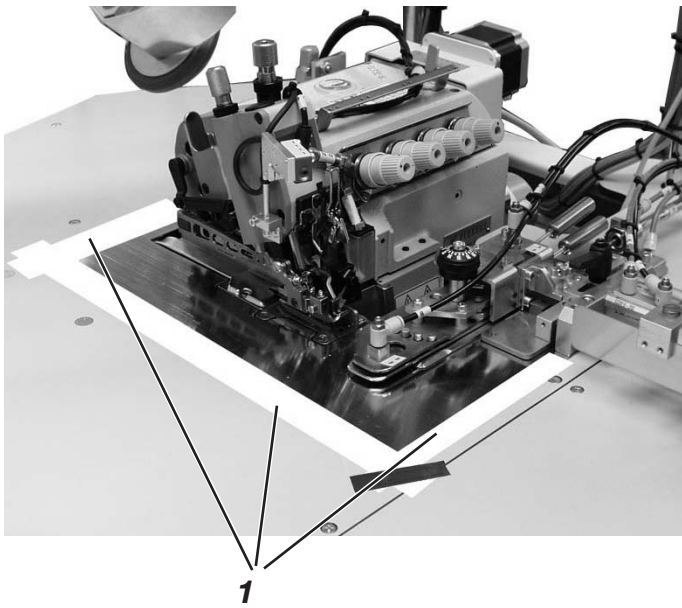
All jobs on the electrical equipment of the sewing unit may be performed only by qualified electricians or appropriately trained personnel.

In the process, make sure that the mains plug is pulled out.

Kindly follow the enclosed operating instructions by the manufacturer of the drive motor.

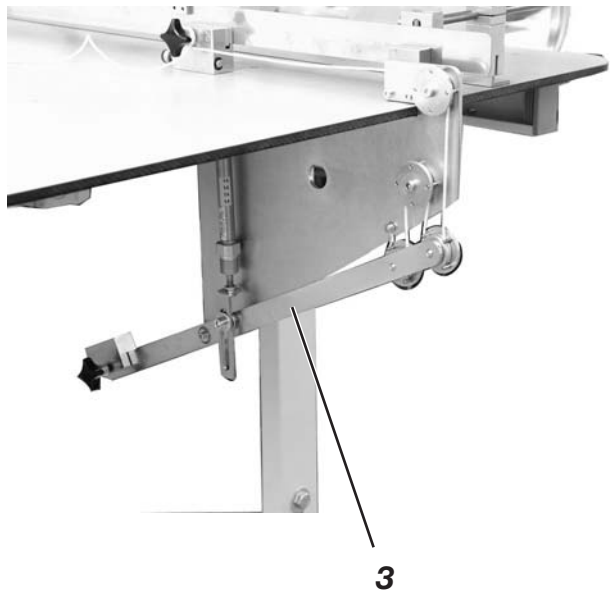
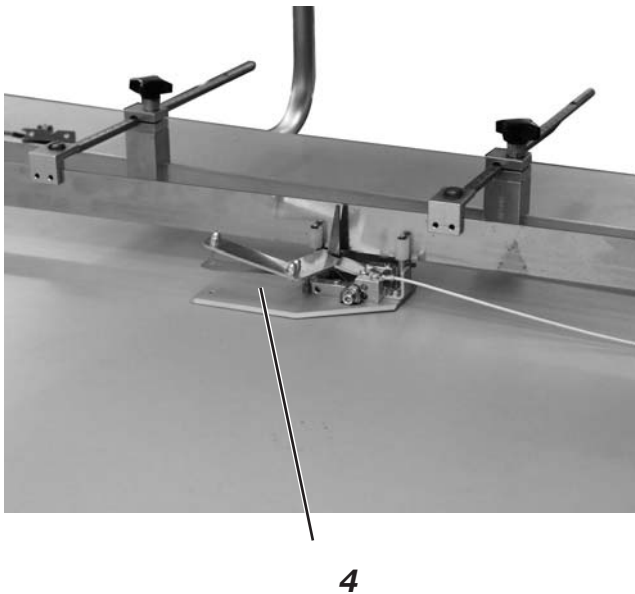
3 Setting up the sewing unit

3.1 Shipping braces



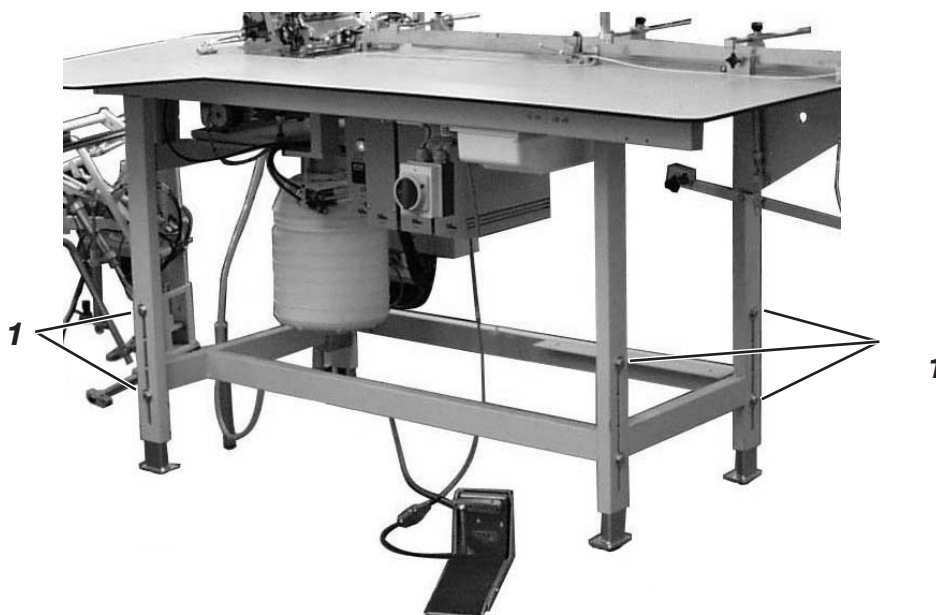
All the shipping braces are to be removed prior to setting up the sewing unit.

- Remove safety bands on the yarn stand, machine table etc.
- Remove protective films 1.
- Remove safety bands 2 on the stacker.



- Remove the safety braces on the mouse 4 and the return device 3.

3.2 Adjusting the working height

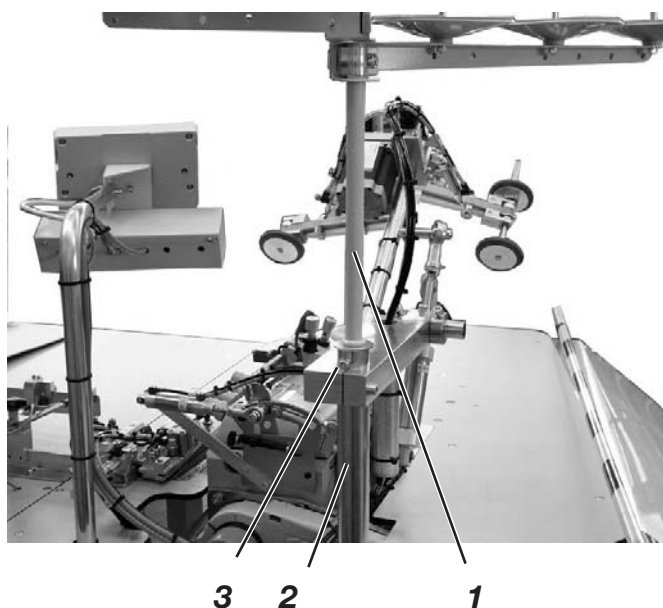


The working height can be adjusted between 850...1200 mm (measured up to the upper edge of the table top).

- Loosen the screws 1 at the spars.
- Adjust the sewing unit to the desired working height with the appropriate auxiliary means.
Lift the work table uniformly on both sides in order to prevent twisting.
- Retighten the screws 1 at the spars.

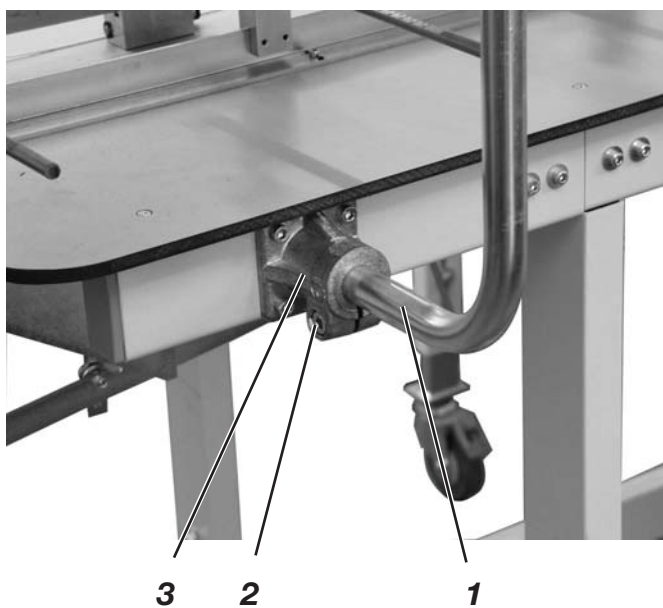
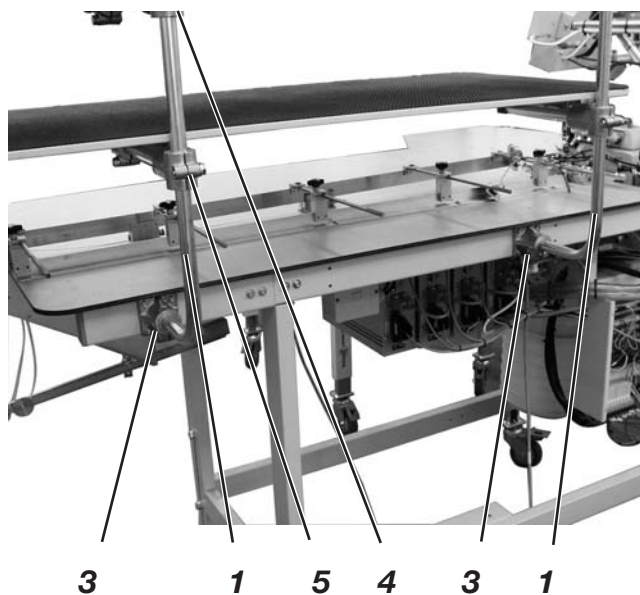
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3.3 Assembling the yarn stand



- Insert yarn support tube 1 in the holder 2.
- Tighten the yarn support tube with both the screws 3.

3.4 Assembling the workpiece storage members



The workpiece storage members have been dismantled for the purpose of transportation.

- Loosen the screws 2 at the holders 3.
- Insert holding rods 1 in the holders 3.
- Retighten the screws 2 at the holders 3.
- Loosen the screws on the holders 4 and 5 and adjust the height of the workpiece storage members.
- Retighten the screws on the holders 4 and 5.

4 Electrical Connection



ATTENTION !

All jobs on the electrical equipment of the sewing unit may be performed only by qualified electricians or appropriately trained personnel.
In the process, make sure that the mains plug is pulled out.

4.1 Checking the nominal voltage



ATTENTION !

The nominal voltage specified on the rating plate of the sewing unit control system must correspond to the mains voltage.
Nominal voltage = 190 - 240 V, 50/60 Hz

4.2 Establishing the mains connection

- Connect the mains plug.

5 Pneumatic Connection

For the operation of the pneumatic components, the sewing unit must be supplied with anhydrous compressed air.



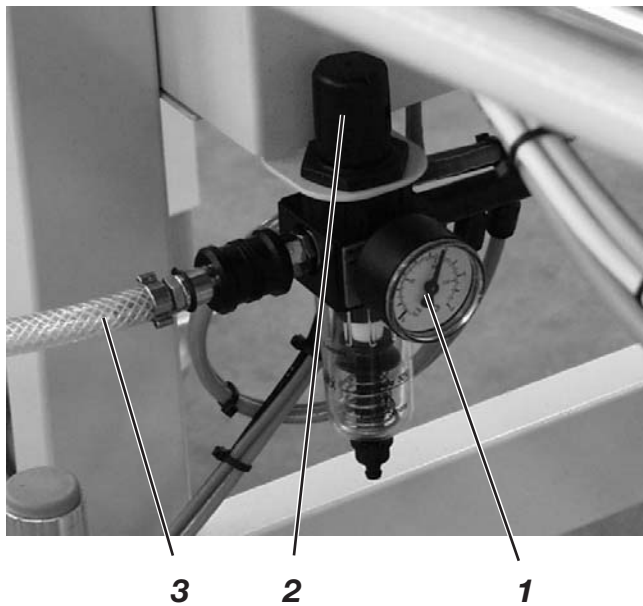
ATTENTION !

For faultless functioning of the pneumatic control operations, the compressed air network must be designed as follows:

Make sure that a minimum operating pressure of **6 bar** is not exceeded even when air consumption is at its highest.

In the event of excessive compressed air drop:

- Increase the compressor performance.
- Increase the diameter of the compressed air supply line.



Connect the compressed air maintenance unit

- Connect the connecting hose 3 to the compressed air network.

Adjust the operating pressure

- The operating pressure is 6 bar.
It can be read out on the manometer 1.
- Lift up and turn the turning handle 2 for adjusting the operating pressure.
 - Turning in clockwise direction = Increase pressure
 - Turning in anti-clockwise direction = Reduce pressure



ATTENTION!

The compressed air network may not be used to supply oiled compressed air.

Behind the filter, purified compressed air is extracted as blow air for the cleaning of machine parts and for blowing out the sewing parts. Oil particles that are entrained with the blow air lead to functional faults and contamination of the sewing parts.

6 Putting into operation

6.1 Sewing test

A sewing test should be performed once the setting up job has ended.

- Connect the mains plug.



Caution: Risk of Injury!

Switch off the main switch.

Thread the needle and looper thread only when the sewing unit is switched off.

- Thread the needle and looper thread (see operating instructions of the sewing machine head).
- Switch on the main switch.
The control unit is initialised.
- Select the sewing programme.
- Positioning and operating are described in Part 1: Operating Instructions 1281/5-1.

Notes: