

**267**

## **Special sewing machine**

Instructions for operating

**CN**

**GB**





# 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.



It is absolutely necessary to respect  
the safety instructions marked by these signs.  
**Danger of bodily injuries !**  
Please note also the general safety instructions.



## Description of proper use or proper application:

The **K267** is a sewing head which can be used for sewing light to medium heavy sewing material. In general, such sewing material is made up of textile fibres but also leather. Such sewing materials are used by the clothing and upholstery industry. It would also be possible to make so called technical seams with these sewing machines. However, for this application the operator of the machine(s) must have the possible dangers assessed (cooperation with Dürkopp Adler would be welcomed), as such applications are, on the one hand, relatively rare and, on the other hand, have an immensely wide range of possibilities. Depending on the results of this assessment suitable safety measures might have to be implemented.

In general, only dry sewing material may be used on this machine. The material must not exceed 10 mm in thickness when compressed by the lowered needle butt. The material must not contain any hard objects as eye shields would otherwise have to be worn when operating the machine. However, such eye shields are currently not available.

In general, the seam will be sewn with sewing threads made of textile fibres in sizes of up to 10/3 NeB (cotton threads), 10/3 Nm (synthetic thread), or 11/3 Nm (covering twists). Using other threads would also require an assessment of the related possible dangers and risks in advance, and the implementation, where necessary, of suitable safety measures.

This sewing machine may only be put up and used in dry and clean rooms. Should the machine be used in other rooms which are not dry and clean, further measures may have to be taken which have to be agreed (see EN 60204-31: 1999).

As a manufacturer of industrial sewing machines we assume that operators who are at least semi-skilled will work at our products, so that it can be assumed that all standard operations and, where applicable, the dangers are known.

## Noise level Lc

Workstation related emission according to DIN 45635-48-A-I-KL2

|                     |                                                   |                 |
|---------------------|---------------------------------------------------|-----------------|
| Subclass:           | K267-73; -373                                     | K267-273        |
| Number of stitches: | 1700 min-1                                        | 1700 min-1      |
| Stitch length:      | 4,8 mm                                            | 4,8 mm          |
| Sewing material:    | 2-play Skai 1,6 mm 900 g/m <sup>2</sup> DIN 53352 |                 |
| <b>Lc =</b>         | <b>82 dB (A)</b>                                  | <b>83 dB(A)</b> |



**Adler Class 267  
Operating Instructions**

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## 1 General

### 1.1 Class 267- with subclasses

|                      |     |   |
|----------------------|-----|---|
| <b>Subclass</b>      | :   |   |
| Needle system        | :   | 1 |
| Needle No.           | :   |   |
| Synth. sewing thread | Nm: |   |
| Braided thread       | Nm: |   |

|                      |     |  |  |  |
|----------------------|-----|--|--|--|
| <b>Subclass</b>      | :   |  |  |  |
| Needle system        | :   |  |  |  |
| Needle No.           | :   |  |  |  |
| Synth. sewing thread | Nm: |  |  |  |
| Braided thread       | Nm: |  |  |  |

|                      |     |  |
|----------------------|-----|--|
| <b>Subclass</b>      | :   |  |
| Needle system        | :   |  |
| Needle No.           | :   |  |
| Synth. sewing thread | Nm: |  |
| Braided thread       | Nm: |  |

|                      |     |  |
|----------------------|-----|--|
| <b>Subclass</b>      | :   |  |
| Needle system        | :   |  |
| Needle No.           | :   |  |
| Synth. sewing thread | Nm: |  |
| Braided thread       | Nm: |  |

|                      |     |  |
|----------------------|-----|--|
| <b>Subclass</b>      | :   |  |
| Needle system        | :   |  |
| Needle No.           | :   |  |
| Synth. sewing thread | Nm: |  |
| Braided thread       | Nm: |  |

|                      |     |  |
|----------------------|-----|--|
| <b>Subclass</b>      | :   |  |
| Needle system        | :   |  |
| Needle No.           | :   |  |
| Synth. sewing thread | Nm: |  |
| Braided thread       | Nm: |  |

|                      |     |  |
|----------------------|-----|--|
| <b>Subclass</b>      | :   |  |
| Needle system        | :   |  |
| Needle No.           | :   |  |
| Synth. sewing thread | Nm: |  |
| Braided thread       | Nm: |  |

|                      |     |      |        |  |
|----------------------|-----|------|--------|--|
| <b>Subclass</b>      | :   | 273  | 373    |  |
| Needle system        | :   |      | 134-35 |  |
| Needle No.           | :   | 134  | 130    |  |
| Synth. sewing thread | Nm: | 120  |        |  |
| Braided thread       | Nm: | 30/3 | 20/3   |  |

## 1.2 References and illustration

A functional element mentioned in the text gets a reference (e.g. "A") if it is illustrated in the appendix. The supplement of the reference, consisting of a fraction stroke and of a figure (e.g. "A/3") indicates the respective illustration 3 in the appendix.

An electrical or pneumatic functional element bears in all technical documentation (e.g. plan of electrical or pneumatic system) the same reference (e.g. "s1" or "24.2") as that in the text, preceding the fraction stroke.

In the attached illustration this reference stands in a circle.

## 1.3 Instalng the belt guard (see fig. 1 and 2)

## 1.4 Taking into service

- Turn on the main switch,
- Lower the presser foot by the lever 0/12,
- For pulling up the bobbin thread, hold the needle thread behind the presser foot and rotate the machine,
- Lift the presser foot,
- Place both threads backwards and position the material,
- Lower the presser foot,
- Lower the pedal forwards. The machine will operate faster if the pedal is lowered more (do not push or pull the material),
- Operate machine without material only with lifted presser foot. After sewing, turn off the main switch, and in case of machines with pneumatic connection, stop the compressed air supply.

## 2. Control elements and functional elements on the sewing machine

### 2.1 Basic equipment of the subclass 267-H6K-

|      |                                                                                                                 |
|------|-----------------------------------------------------------------------------------------------------------------|
| A/17 | Knurled screw for regulating the presser foot                                                                   |
| B/17 | Rotary button for regulating main tension of the needle thread                                                  |
| D/17 | Thread guide                                                                                                    |
| d/17 | Thread guide                                                                                                    |
| G/15 | Adjustable bobbin winder pre-tension                                                                            |
| h/17 | Bobbin winder with stop lever                                                                                   |
| K/17 | Thread guide                                                                                                    |
| M/15 | Knurled button for regulating the stitch length                                                                 |
| m/17 | Knife for separating the wound bobbin thread                                                                    |
| 0/12 | Lever for arresting the sewing foot in its upper position and for lifting the main tension of the needle thread |
| Q/17 | Thread guide                                                                                                    |
| R/17 | Thread pulling spring                                                                                           |
| S/17 | Thread guide                                                                                                    |

## 2.2 Basic equipment of further subclasses

|            |                                                                              |
|------------|------------------------------------------------------------------------------|
| A/15       | Knurled screw with counter-nut for regulating the cloth presser foot         |
| A/16/19    | Knurled screw for regulating the presser foot                                |
| C/15/16/18 | Rotary button for adjusting the needle thread pre-tension                    |
| Y/19       | Rotary button for adjusting the 1st main tension for the right needle thread |
| y/19       | Rotary button for adjusting the 1st main tension of the left needle thread   |
| q/16/18    | Adjustable thread guide                                                      |
| r/19       | Non-adjustable thread guide                                                  |
| k/19       | Thread guide                                                                 |
| S/13       | Roller foot                                                                  |
| S/16       | Thread guide                                                                 |

## 2.3 Safety clutch (fig. 3)

The classes 267 HGK (horizontal hook) have no friction clutch.

### Rule:

In case of a slipping safety clutch a jammed hook can be liberated by turning the handwheel only if the clutch has been previously blocked.

### Indication:

For blocking, turn the handwheel slowly until a pin, passed through both clutch parts, can be introduced in the hole A. The pin should not be hardened and its diameter should be slightly inferior than 5.0 mm.

For snapping-on, remove pin, hold the hook and turn the handwheel carefully. After snapping, the clutch and the hook will operate synchronously.

For adjusting, see the instructions for mechanics, chapter "Adjusting the safety clutch".

## 3. Control elements and functional elements on the stand

### 3.1 Basic equipment (fig. 4)

- a1 Main switch
- b Knee lever for lifting the presser foot and the needle thread main tension
- c Pedal

### 3.2 Additional equipment and special equipment (fig. 4)

- d Knee button if equipped with "HP11-1"  
left Pedal, if equipped with "HP11-2"  
Conditioning unit on request

## **4. Instructions for sewing**

### **4.1 Needle**

According to the sub-class, see the suitable needle in the table 1.1.

#### **4.1.1 Needle change**

- Lift the needle to the upper dead point,
- Loosen screw e/17 and pull out the needle,
- Place the new needle with the short groove towards the hook, introduce it up to the stop and tighten the screw.

### **4.2 Threads**

According to the sub-class, see the maximum limits of the suitable needle and bobbin threads in the table 1.1.

#### **4.2.1 Threading of needle thread (1 needle machines)**

Pass the needle thread according to fig. 17 (fig. 20, 22)

- through the reel stand,
- from right through the thread guide D,
- from right through the upper hole in the thread guide d,
- from left through the middle hole of the thread guide d,
- from right through the lower hole of the thread guide d,
- counter-clockwise around the adjustable needle thread pre-tension C/18 (except cl. 267-HGK-)
- back through the lower hole of the thread guide C/18,
- clockwise over the thread guide K,
- counter-clockwise in the adjustable needle thread main tension B, clockwise in the thread guide r, up to the hook,
- from outside below the pulling spring R,
- from below behind the thread guide Q,
- from below behind the adjustable thread guide q/18, (with exception class 267-HGK-)
- from right through the lower hole in the thread take-up lever,
- from above through the thread guide Q (if available),
- behind the thread guide S/17, (S/11 in case of wheel-feed-type)
- through the thread guide d/11,
- to the hook through the needle and advance some 8,0 cm

#### **4.2.2 Threading of needle thread (2 needle machines) (fig. 18, 23)**

- Pass the left needle thread as specified under 4.2.1
- Pass the right hand needle thread accordingly.

#### **4.2.3 Threading of needle thread (2 needle machines with needle lift "NH")**

Pass the r/h needle thread according to fig. 19 (fig. 23)

- through the reel stand,
- from right through the lower hole in the thread guide D,
- from right through the third hole in the thread guide d,
- from right through the fourth hole in the thread guide d,
- from right through the needle thread h,
- counter-clockwise between the disks of the needle thread pre-tension c,
- counter-clockwise in the adjustable 1st needle thread main tension Y,

- clockwise between the disks in the adjustable 2nd needle thread main tension y,
- clockwise in the needle-thread r pull in front of the hook
- from outside below the rear thread pulling spring R,
- from below behind the thread guide Q,
- from right through the upper hole in the thread guide,
- from above through the thread guide Q,
- below the thread guide S,
- through the thread guide D,
- to the hook through the needle (lift the other needle for easier threading) and advance some 8,0 cm
- Pass the left needle thread accordingly.

### 4.3 Thread tension

#### 4.3.1 Adjusting the thread tensions (fig. 15)

##### Rule 1:

A good seam pattern with regularly tightened stitches is often obtained only by regulating the needle thread tensioning elements, principally by the needle thread main tension B.

##### Indication 1:

When adapting the needle thread tension, loosen first the needle thread pre-tension C and regulate only the needle thread main tension B, until the bobbin thread and the needle thread are locked in the material, fig. 6.

The needle thread pre-tension should be regulated finally, because it is always lower than the main tension of the needle thread.

##### Rule 2:

In case of a general adjustment of the thread tensioning elements, adjust first the bobbin thread tension G for a low value and adapt it then to the needle thread tension.

##### Indication 2:

For a lockstitch seam, the low bobbin thread tension can already be influenced during the winding process by the adjustable bobbin winder pre-tension G. The bobbin thread pre-tension G should be adjusted so that the bobbin thread is wound regularly with the lowest possible tension.

#### 4.3.2 Lifting the thread tension

- automatically with the "presser foot lift"
- in the sub-classes with the designation "NH" (needle lift), by swinging the lever F/19, it is possible to connect or disconnect the 1st needle thread main tension where, after turning the material, a regular thread position is required on the upper and on the lower side of the fabric, (except 267-FA-203-SNH 1).

### 4.4 Bobbin thread

According to the sub-class, see the maximum limits of the suitable bobbin thread in the table 1.1.

#### 4.4.1 Winding the bobbin thread (fig. 9)

Pass the bobbin thread

- through the reel stand,
- from left through the rear hole in the thread guide G,
- clockwise between the disks around the adjustable bobbin winder pre-tension G,

- from right back through the rear hole in the thread guide G,
- from left through the middle hole in the thread guide G,
- from right through the front hole in the thread guide G,
- counter-clockwise several times around the bobbin s,
- pass the excessive thread end in the knife m for cutting it off,
- press the bobbin winder lever h. The winder will stop automatically.
- Pull the bobbin thread in the knife m for cutting it off.  
The bobbin winder pre-tension G should be set so low that the thread is wound regularly at low tension.  
When winding at an excessive pre-tension, the aluminium bobbins s may be separated and considerable thread cutting disturbances may occur.

#### **4.4.2 Bobbin change (figs. 7 and 8)**

For changing the bobbin,

- Move the thread take-up lever to its topmost point,
- Swing the lever 0/12 upwards (for arresting the presser foot in its upper position),
- Lift the flap and remove the bobbin case top from the hook,
- Place the other bobbin so that the bobbin rotates contrary to the thread pulling direction,
- Pull the bobbin thread under the spring d in the slit and advance it from below through the hole for about 8,0 cm,
- Hold the bobbin case top with bobbin at the free thread end and place it into the hook,  
Close the flap.

#### **4.4.3 Adjusting the bobbin thread tension**

##### **Rule 1:**

Work with the lowest possible bobbin thread tension.

##### **Indication 1:**

For correcting, turn the screw g/7/8.

##### **Rule 2:**

For a lockstitch seam, the low bobbin thread tension can already be influenced during the winding process by the adjustable bobbin winder pre-tension G/9.

##### **Indication 2:**

The bobbin thread pre-tension G should be adjusted so that the bobbin thread is wound regularly with the lowest possible tension.

#### **4.5 Presser foot**

##### **4.5.1 Lifting the presser foot**

- by knee lever in basic equipment
- automatically after thread cutting in case of special equipment with presser foot lift "FLP" or seam bartacking "RAP" until the pedal is released. According to the switch position on the motor control box the presser foot can be lifted as often as required by repeatedly lowering the pedal.  
The lifted presser foot can be arrested in its upper position by turning the lever 0/12.

#### **4.5.2 Regulating the presser foot (figs. 15, 16, 17 and 19)**

- by the knurled screw A, according to the equipment  
Turn clockwise for higher pressure  
Turn counter-clockwise for lower pressure

#### **4.5.3 Changing the presser foot**

- Arrest the presser foot in its upper position by turning the lever O/12,
- Move the needle to its upper dead point
- Loosen the screw and pull off the presser foot,  
Fit the other presser foot in inverted sequence.

#### **4.5.4 Swinging out the roller foot**

- this can be done in lifted or upper position,
- in case of basic equipment, push down the holder N/13,
- by advancing the lever N/11 in case of special equipment with driven roller foot "AR".

### **4.6 Feed**

#### **4.6.1 Feed dog**

##### **4.6.1.1 Stitch length**

- For adjusting the stitch length, turn the knurled handle M/15.  
Turn clockwise = for reducing the stitch length  
Turn counter-clockwise = for increasing the stitch length

##### **4.6.1.2 Stitch regulator**

- Lift the stitch regulator M/15 for sewing backwards or for bartacking,  
In case of special equipment with driven roller foot "AR2" the free running of the roller foot becomes effective as soon as the machine is switched over for reverse stitches.

##### **4.6.1.3 Bartacking**

- by lifting the stitch regulator lever M/15 in case of basic equipment,
- automatically by heeling down the pedal in case of an additional equipment for bartacking "RAP", see item 6.6.

### **5. Functions-description of further subclasses**

#### **5.1 Needle feed and alternating top feed**

##### **5.1.1 Adjusting the stitch length**

- by the knurled handle M/15

##### **5.1.2 Adjusting the alternating top feed**

by displacing the traction rod in the coulisse M/14 according to the fabric thickness.

Traction rod downwards = minimum stroke

Traction rod upwards = maximum stroke

In case of additional equipment with HP 11- (pneumatic stroke adjustment), the basic adjustment of the machine corresponds to the **minimum stroke**.

For obtaining the maximum stroke, operate the knee switch or the pedal while sewing.

## 5.2 -82, Intermittent wheel feed

### 5.2.1 Adjusting the stitch length

- by the push button L/16 for the intermittent wheel feed in the base plate.
- by the push button L/9 in case of special equipment with driven roller foot "AR" and also on the upper arm.

The stitch length adjusted is shown by the letters A to E in a sight glass.

A = min. stitch length

E = max. stitch length

For resetting

- Depress and hold the button,
- Turn the handwheel slowly until the button snaps,
- Turn the handwheel further until the desired stitch length is shown in the sight glass by a different letter.
- Release the button

**Note:**

It is seldom that both windows show the same letter.

### 5.3 "FA" - Thread cutter

- After sewing, heel down the pedal beyond the neutral position, up to the 2nd position.

### 5.4 NH1, Needle lift (fig. 19)

- for the left needle by turning the lever U to the left
  - for the right needle by turning the lever U to the right.
- For re-coupling of the lifted needle press lever T. Note, that the other needle bar must exceed the upper dead point. The levers can be operated while sewing and with the machine stopped.

**Note:**

Since a needle bar is uncoupled and coupled always when the upper dead point is being crossed, pay attention to a well timed operation of the lever when the needle bar is ascending or descending.

If, for uncoupling, the lever is turned to the left or to the right while the needle is descending, both needles will still perform the following stitch.

If for uncoupling, the lever is turned to the left or to the right while the needle is ascending, the needle will be arrested in its upper position after the last stitch.

If, for coupling, the lever is operated while the needle is descending, the following stitch will be executed only by one needle.

If, for coupling, the lever is operated while the needle is ascending, the following stitch will be executed by both needles.

If, for coupling and uncoupling, the levers have been operated too late, for instance when the needle is descending, the other switching function can still be obtained by turning the handwheel to the left, about 3,0 mm beyond the upper dead point of the needle bar.

## **6. Additional equipment**

### **6.1 AR1-1, -2, -5, -8 Driven roller foot**

- feeding only forwards

For swinging out in the upper position, operate the lever N/11.

#### **6.1.1 Adjusting the stitch length**

- by the knurled handle M/15,
- by the push button L/16 in case of intermittent lower wheel feed.  
The stitch length adjusted is shown by a letter A to E in the sight glass.  
A = min. stitch length  
E = max. stitch length  
For resetting
  - Depress and hold the button,
  - Turn the handwheel slowly until the button snaps,
  - Turn the handwheel slowly further until the desired stitch length is shown by a different letter in the sight glass.
  - Release the button.

### **6.2 AR2-1, -2, -5 Driven roller foot**

- feeding forwards and freewheeling when switched over for reverse stitches, otherwise as AR1.

### **6.3 FLP 12-1 Pneumatic presser foot lift**

- operated by heeling down the pedal in case of basic equipment with a clutch motor.  
The presser foot can be lifted as often as required by heeling down the pedal repeatedly.

#### **6.3.1 FLP 12-2 Pneumatic presser foot lift**

- operated by heeling down the pedal into the 1st position in case of a stop motor for additional equipment with thread cutter FA,
- operated automatically after thread cutting by heeling down the pedal into the 2nd position. The presser foot remains lifted until the pedal is released.
- According to the switch position on the motor control box the cloth presser foot can be lifted as often as required by heeling down the pedal repeatedly.

### **6.4 HP 11-1, -2 Instantaneous stroke adjustment**

- operated by knee switch in case of special equipment HP 11-1,
- operated by lowering the l/h pedal forwards down to the stop and by releasing simultaneous the r/h pedal at reduced speed in case of special equipment with HP 11-2.  
In case of alternating top feed the basic adjustment of the top feed stroke corresponds to = minimum stroke.  
The maximum stroke is obtained while sewing.

### **6.5 NP 12-, Electro-pneumatic needle positioning**

- automatically after thread cutting with the needle in upper position. Thus, the stroke of the presser foot can be fully utilized for thick material.

### **6.6 RAP 12-2, Electro-pneumatic bartacking**

- automatically by lowering the pedal backwards into the 2nd position and compulsory thread cutting. The presser foot remains lifted until the pedal is released. Initial and final bartacking (normally 3 stitches each, adjustable in the control box) can be connected and disconnected by the switches on the motor. The initial bartacking can be single or double, depending on the switch position.

The bartacking stitch length can be modified with respect to the preset stitch length by the knurled button N/10.

Turn clockwise = for longer bartacking stitches

Turn counter-clockwise = for shorter bartacking stitches

Turn the sleeve M/10 clockwise for short forward and reverse stitches

Turn the sleeve M/10 counter-clockwise for long forward and reverse stitches.

#### **Note:**

According to the position of the switch on the motor control box, the presser foot remains lifted or lowered until the pedal is released. If, by means of the sleeve M/10 on the stitch regulator lever, a shorter forward stitch is adjusted, it is necessary to shorten also the bartacking stitch by the knurled screw N/10. Accordingly, in case of longer forward stitches it is necessary to adapt the length of the bartacking stitches.

In order to avoid any damage to the stitch regulating system, the stitch regulator lever M/10 should not knock against the stitch length scale hardly. When switching over for seam bartacking and when the stitch regulator lever moves upwards in the position "Rueckwaertsstich" (reverse stitch), the piston, being in the final position, should touch the bottom of the cylinder.

When resetting the forward stitch length, the length of the bartacking stitches should be adapted accordingly.

When, at the end of bartacking, the stitch regulator lever M/10 moves towards the stitch length scale to "Vorwaertsstich" (forward stitch), the impact is reduced by the throttle valve (single adjustment of the escape air throttle).

### **6.7 SP 464, SP 465, Puller feed**

- for the sub-classes with bottom and needle feed,
- for sub-classes with bottom feed, needle feed, and alternating top feed

#### **6.7.1 Adjusting the advance**

by displacing the clamping piece in the coulisse

Clamping piece upwards = maximum advance

Clamping piece downwards = minimum advance

## 7. Maintenance

### 7.1 Cleaning

**Rule:**

In case of full-shift service clean at short intervals, possibly daily, by using a brush.

**Indication:**

Some materials are inclined to an increased separation of fluff, finishing agents, etc., the sediments of which are quickly solidified particularly by the pushing and lifting movement of the feed dog, impeding thus the machine function.

For thorough cleaning remove also the throat plate.

At longer intervals unscrew the head cover and clean the arm head.

### 7.2 Oil lubrication (fig. 21)

The oil points marked by an arrow as well as the outside and inside joints should be lubricated additionally, preferably when starting the work. In case of a full-shift service apply about daily 1 or 2 drops of oil. (At longer intervals remove also the upper arm cover and head cover).

**Attention:**

Prior to the first operation resp. after a longer standstill of the machine all marked positions of machine must be oiled.

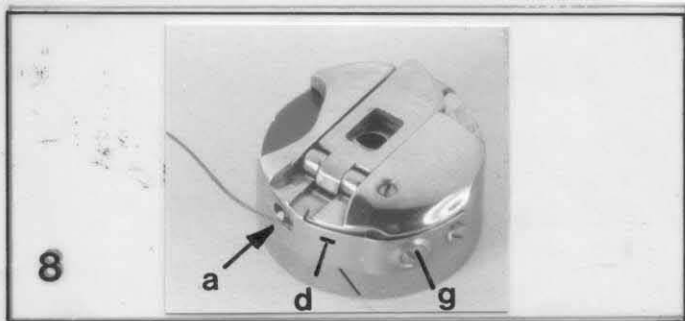
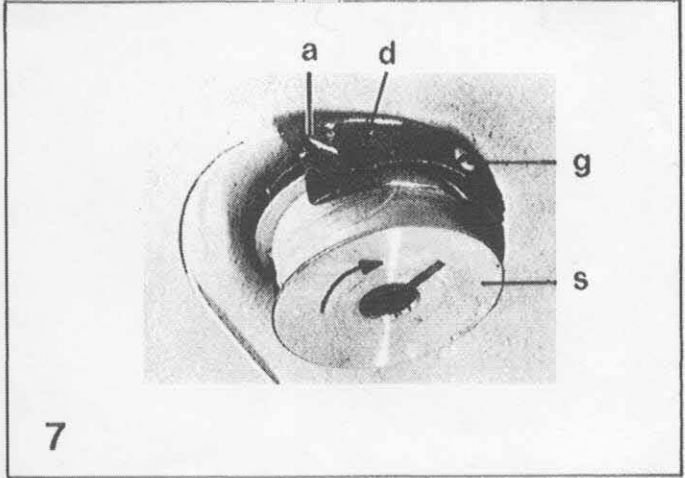
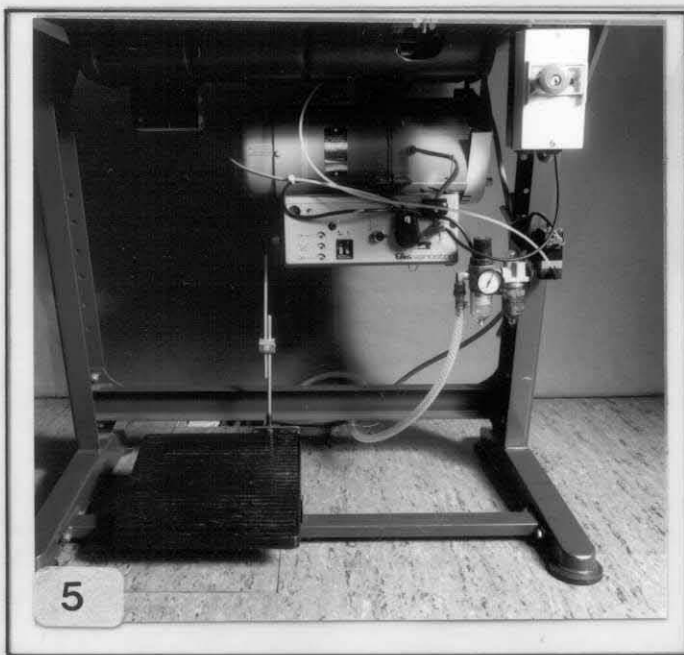
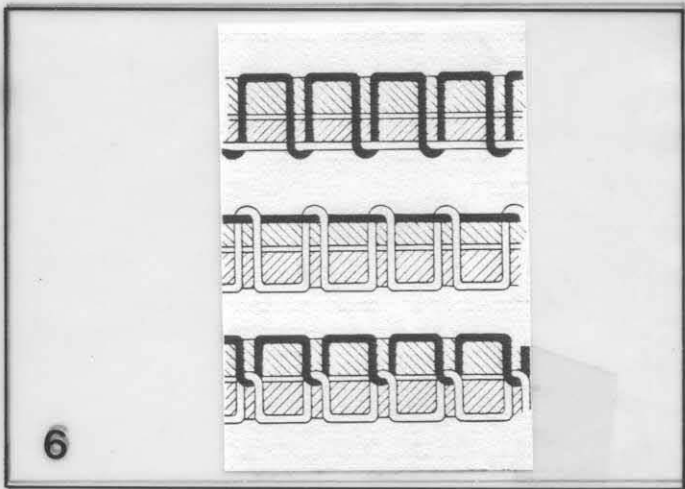
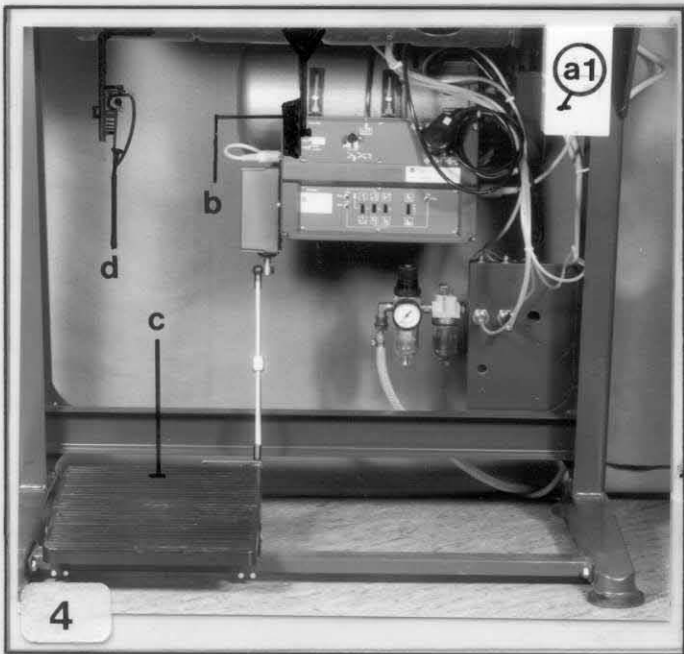
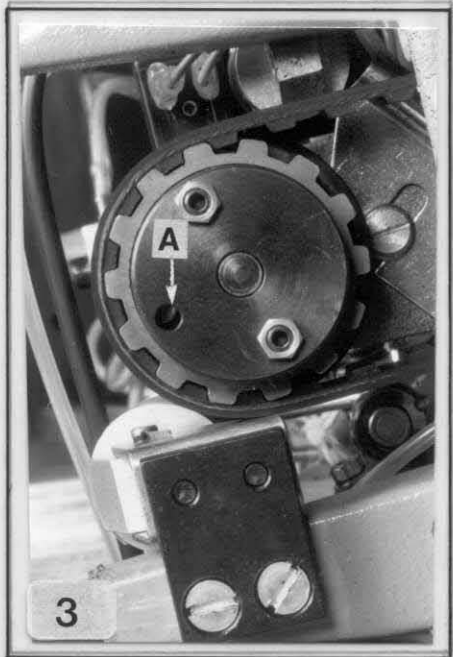
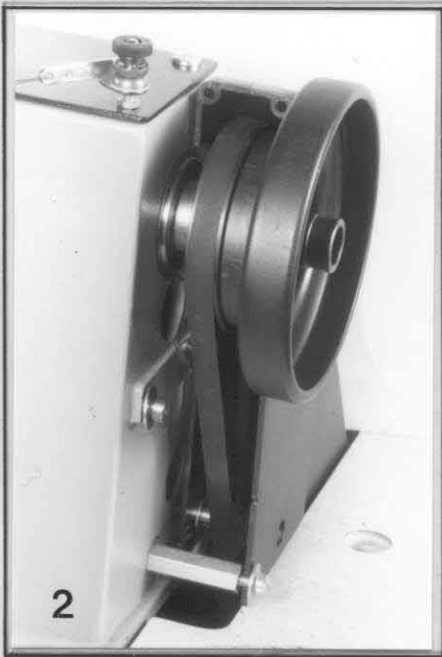
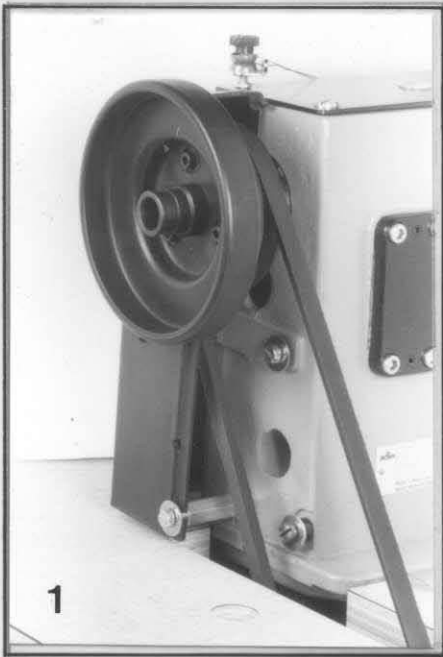
#### 7.2.1 Oil qualities

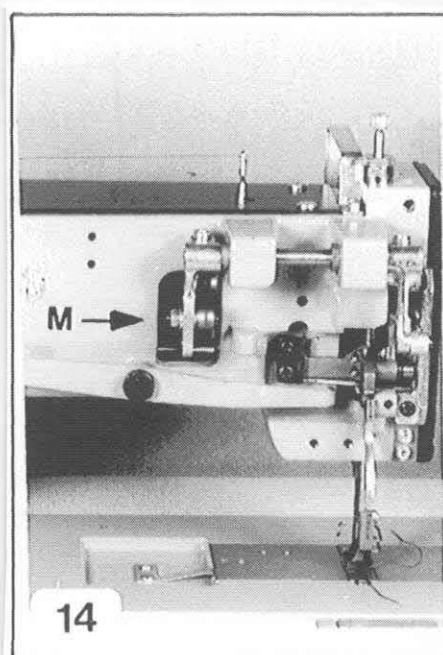
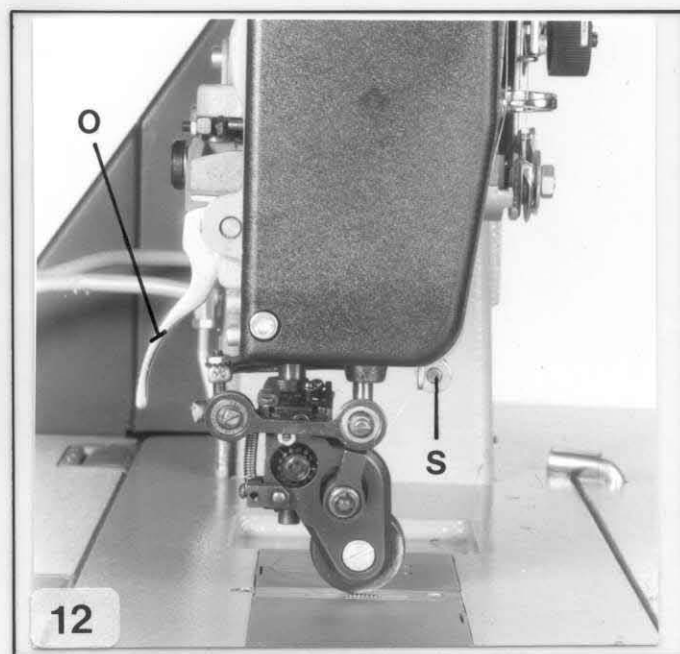
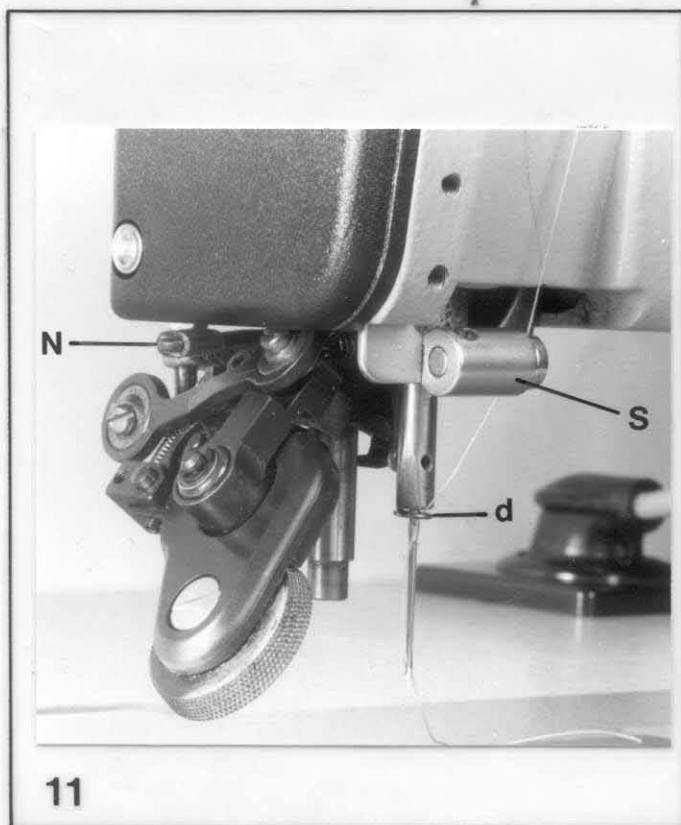
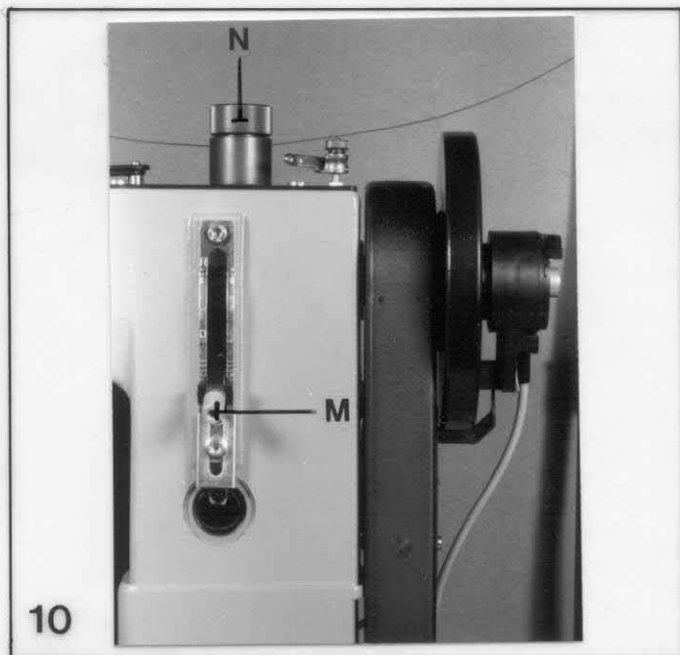
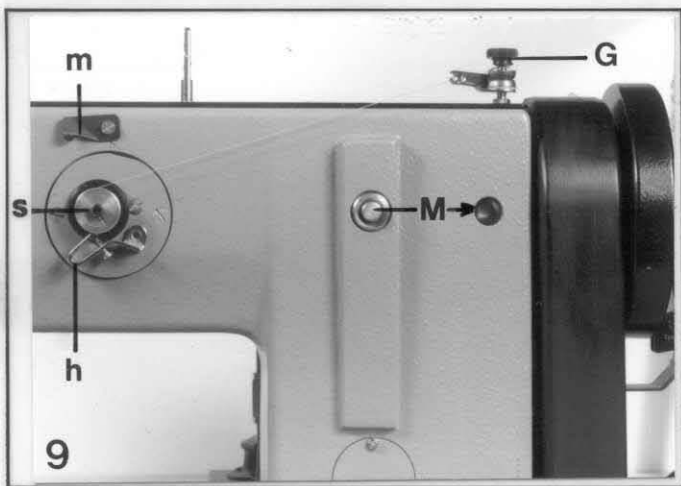
Recommended is DA-68 of Duerkopp Adler AG or other brands with following features:

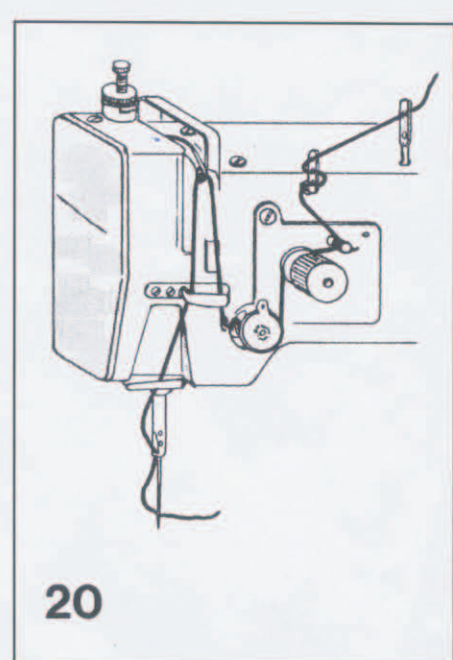
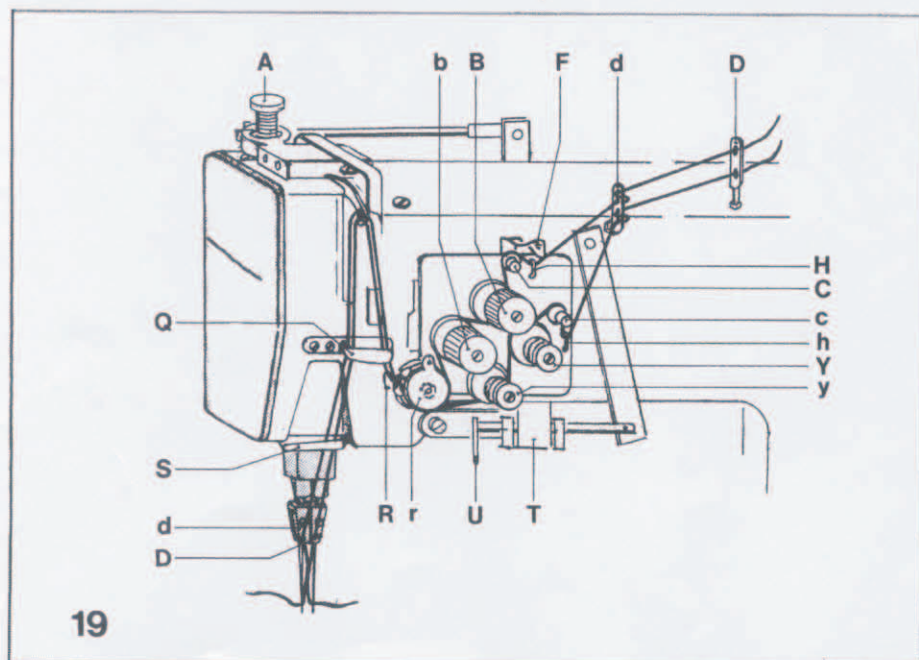
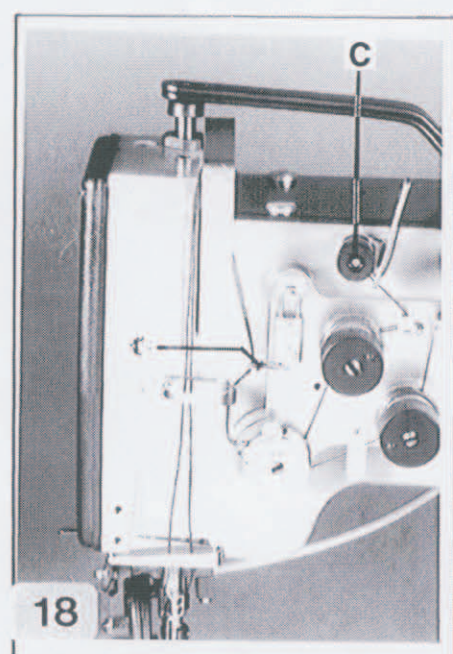
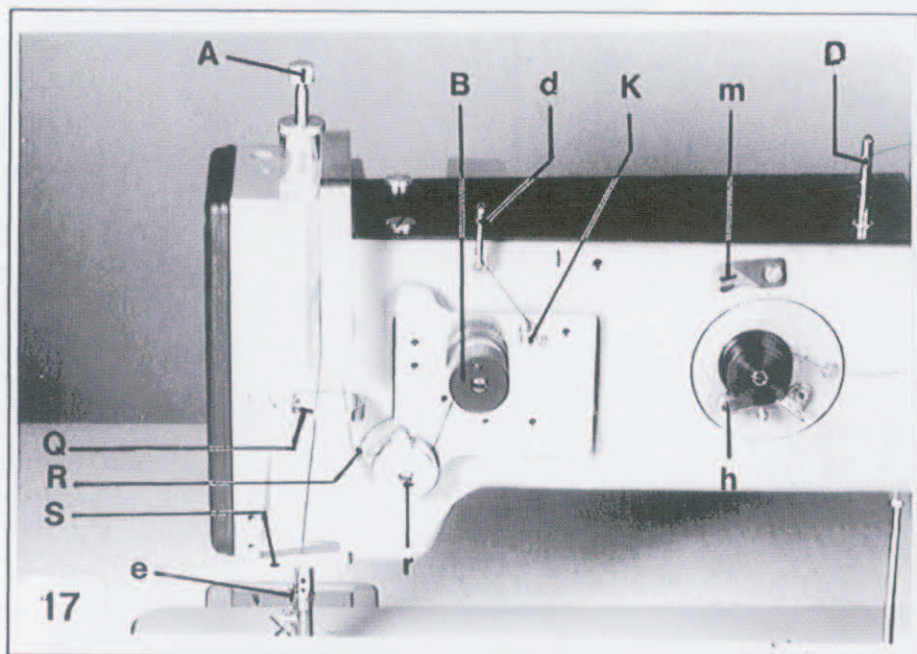
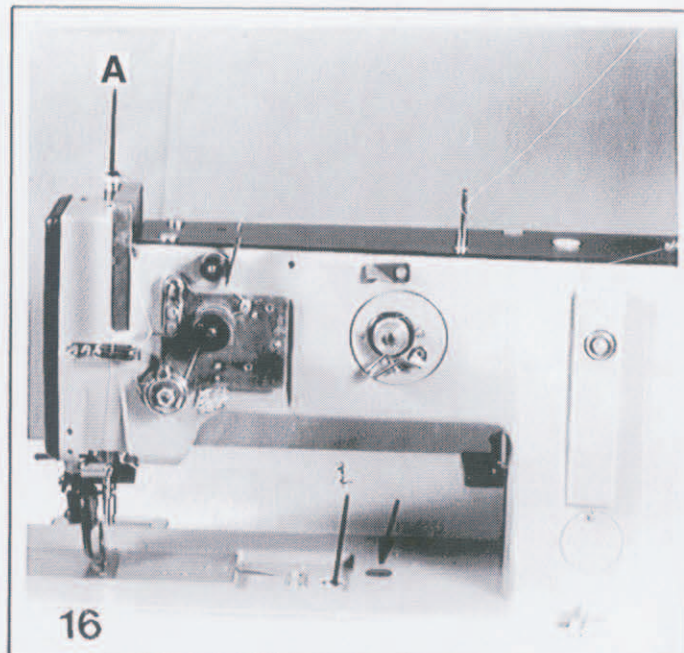
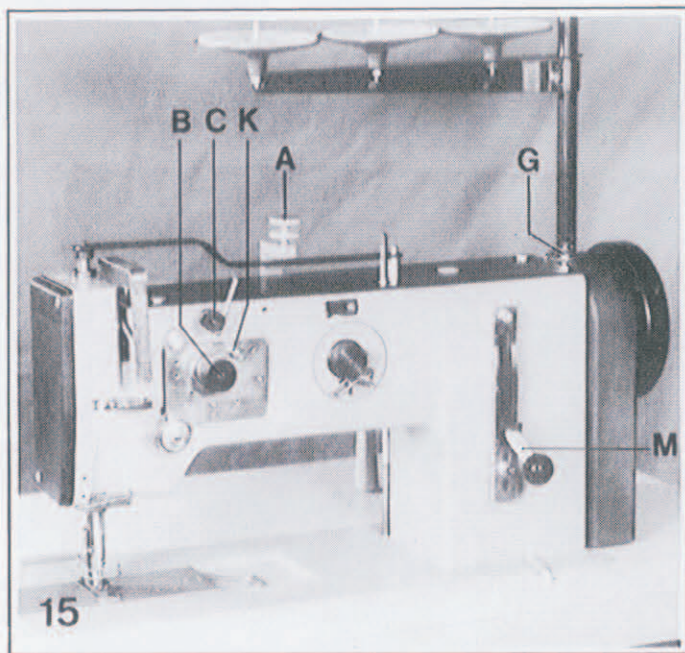
|                   |                       |
|-------------------|-----------------------|
| Viscosity at 40°: | 65 mm <sup>2</sup> /s |
| Flash point:      | 212°C                 |

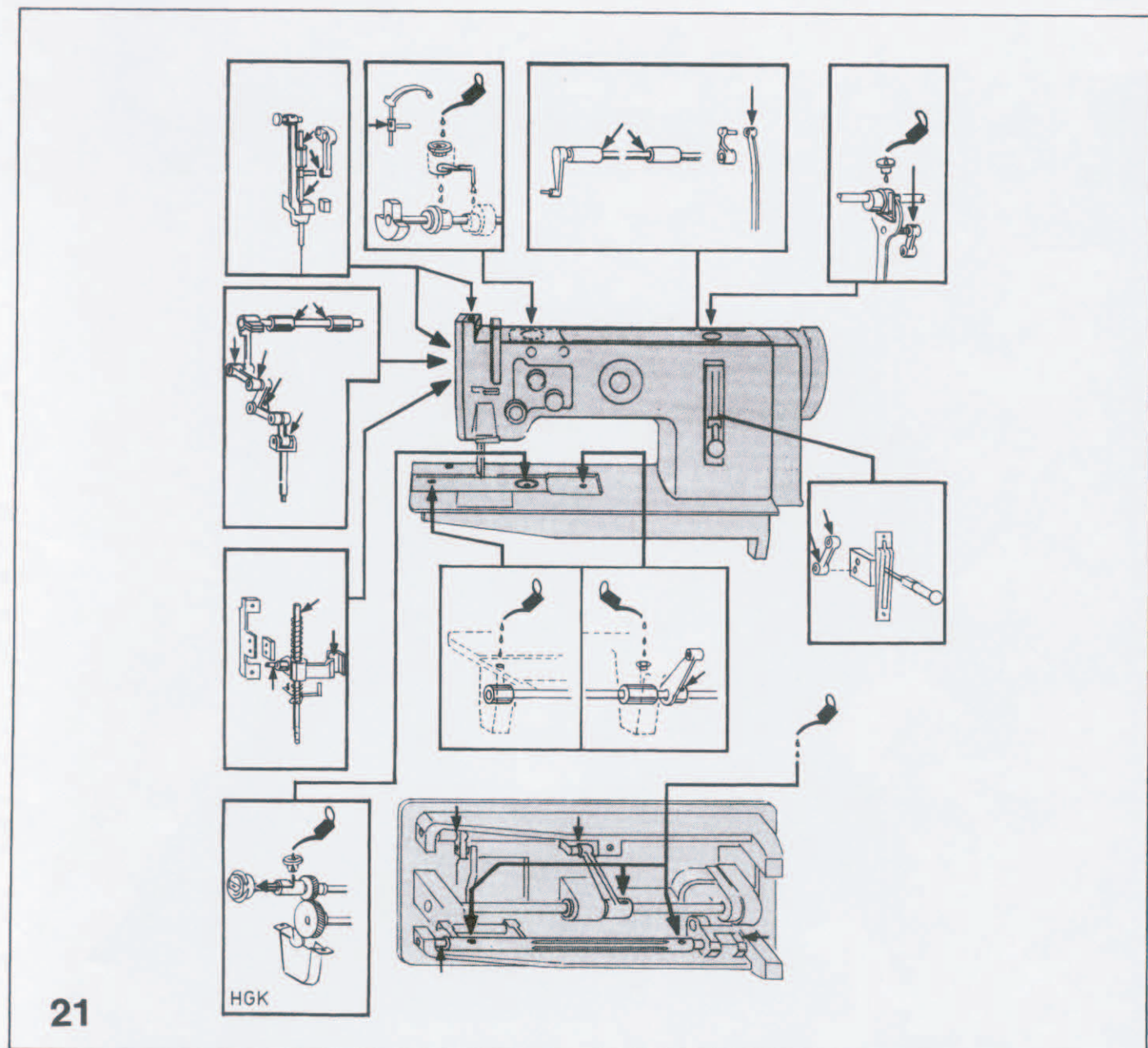
This oil can be obtained from Duerkopp Adler AG :

|             |                   |
|-------------|-------------------|
| 9047 000040 | 1 litre container |
| 9047 000041 | 5 litre container |

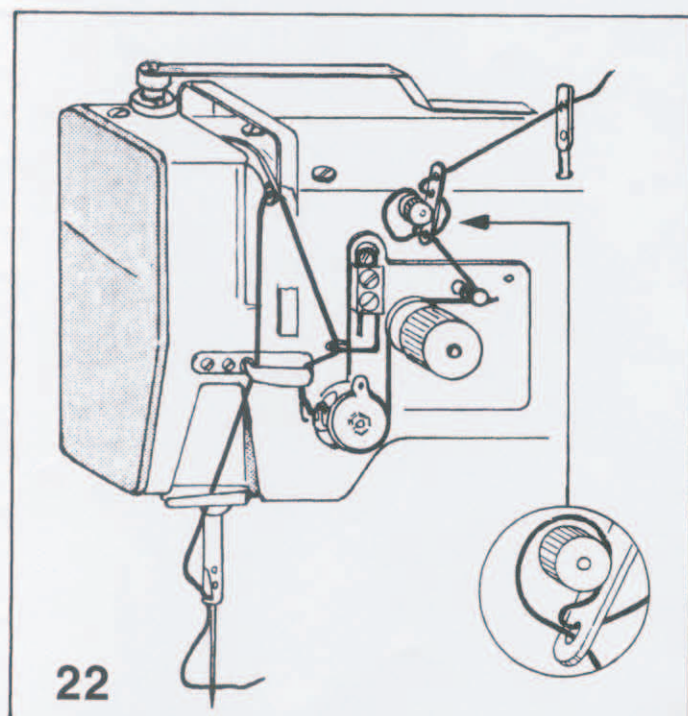




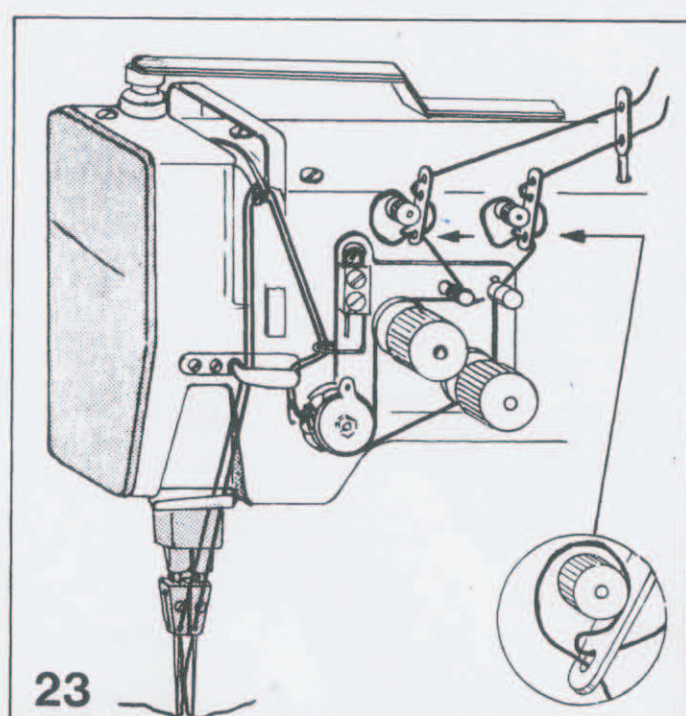




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