

745 - 34 Speedpocket

Sewing unit for runstitching of rectangular piped pockets

Operating Instructions

1

Installation Instructions

2

Service Instructions

3

[Instructions for programming DAC](#)

4



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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.

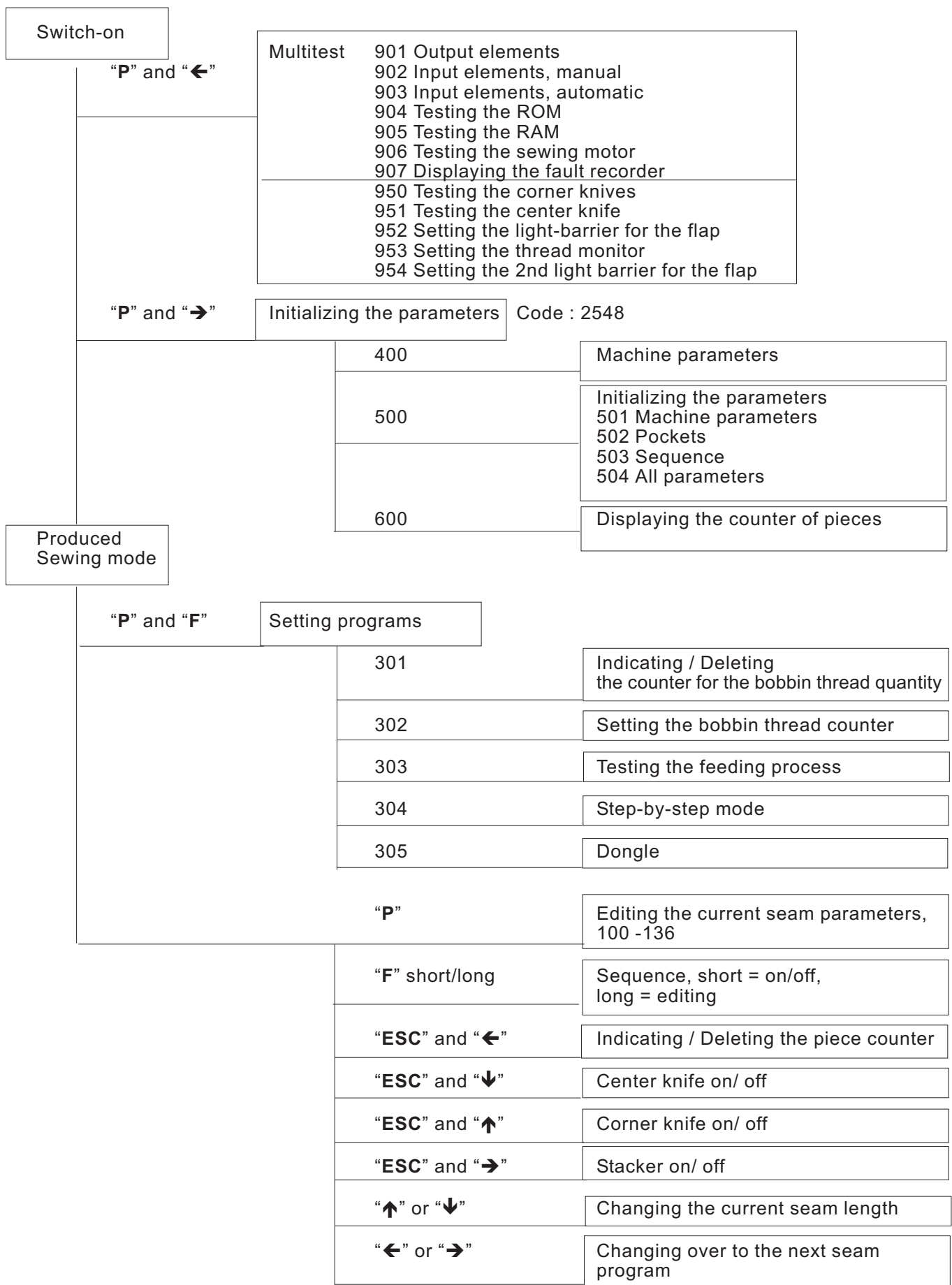


Part 4: Programming Instructions DAC CI. 745-34 Speedpocket

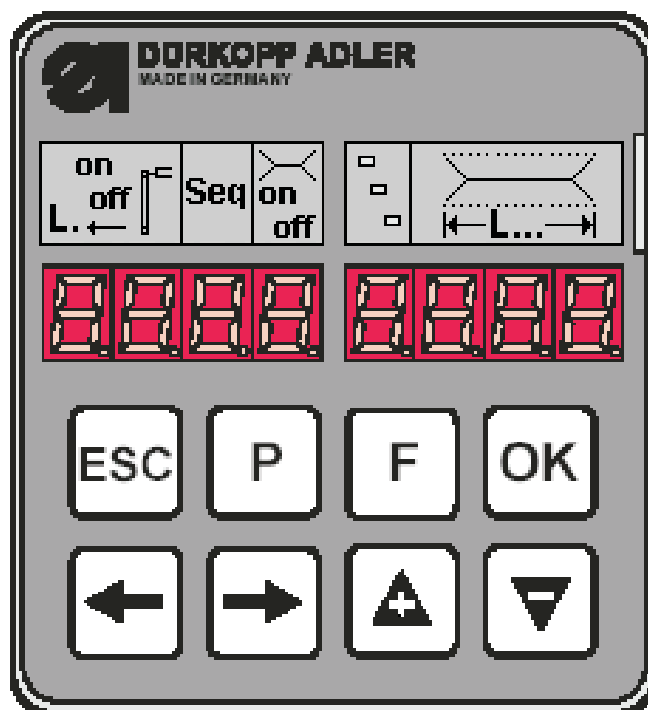
Program version A 02.0

1.	Structure of menu	3
2.	Operation	
2.1	Editing the pocket program	5
2.2	Editing the sequence	6
3.	Setting programs of the machine	
3.1	Indicating / Deleting the counter for the bobbin thread quantity	7
3.2	Setting the counter for the bobbin thread quantity	7
3.3	Testing the feeding process	7
3.4	Step-by-step mode	8
3.5	Dongle menu	9
4.	Multitest	
4.1	Testing the output elements	12
4.2	Testing the input elements manually	12
4.3	Testing the input elements automatically	12
4.4	Testing the ROM	13
4.5	Testing the RAM	13
4.6	Testing the sewing motor	13
4.7	Displaying the fault recorder	13
4.8	Testing the corner knives	14
4.9	Testing the center knife activation	14
4.10	Setting the light-barrier for the flap	14
4.11	Optional equipment - Setting the thread monitor	15
4.12	Optional equipment - Setting the 2 nd light barrier for the flap	15
5.	Table Seam Parameters	16
6.	Machine parameters	18
7.	Error messages/ Functional indications	19
8.	Input elements	24
9.	Output elements	24

1. Structure of menu



2. Operation



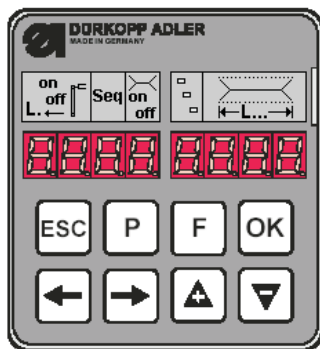
If neither the key (“P” and “→”) nor the key (“P” and “←”) is pressed within 2 seconds after switching on, the program starts the sewing mode.

First the machine has to carry out the reference run initiated by the pedal.

Until then the display will flash.

r E F	
-------	--

2.1 Editing the pocket program



When the machine is in basic position and in the sewing mode and the key “P” is actuated, you get into the level for editing the current pocket program.

In case the feeding process has started already, this is not possible. For this purpose the feeding operation would have to be cancelled so that the machine is in its basic position again.

Selecting the seam parameter

1 0 0	2 3
-------	-----

current parameter value

The parameter number flashes, select with the keys “↑” and “↓”. After “OK” the display changes, e.g. ->

Editing the seam parameter

1 0 8	0 5 4
-------	-------

One digit of the value 054 flashes and can be changed with the keys “↑” and “↓” and saved with “OK”. “ESC” -> no alteration and back.

With the keys “←” or “→” you can change to the next editable digit.

Parameter No. 108

Initializing the pocket program

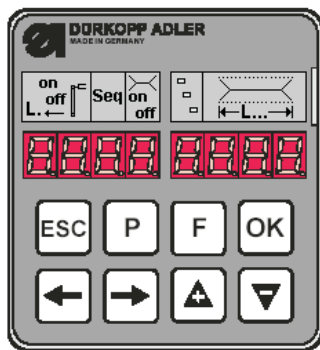
1 P P	I n I
-------	-------

After a short actuation of “F” the display changes to this submenu. The initialization is carried out with “OK” and aborted with “ESC”. With the initialization a pocket program with standard values is loaded.

9 P P	I n I
-------	-------

With a long actuation of “F” all 9 seam programs are initialized. Afterwards the display changes to the mode for selecting a seam parameter in the current seam program again.

2.2 Editing the sequence



When in the sewing mode key “**F**” is pressed longer than 2 seconds, you get into the level for editing the sequence.

With a short actuation of “**F**” the sequence is switched on or off.

1	
---	--

At the beginning of editing the sequence the current sequence is cancelled and the first digit after the “**S**” flashes.

1 2 3	4 5 6 7
-------	---------

With the keys “↑” and “↓” the program number can be altered. With the keys “←” or “→” you change to the next position.

After actuating the key “←” the position right of the flashing digit is cancelled. Thus, the number of seam programs per sequence is determined. Max. 7 seam programs can be entered per sequence.

With “**OK**” the editing of the sequence is finished and the display goes back to the sewing mode with sequence.

2.3 Piece counter

When actuating “**ESC**” and “←” in the sewing mode, the daily piece counter is displayed.

S	1 0 5 4
---	---------

With a short touch of key “**ESC**” you change to the sewing mode again. With a long actuation of “**OK**” the counter is set to “0” and the display “0” appears until the “**ESC**”-key is actuated.

3. Setting programs of the machine

The setting programs can be reached from the sewing mode by actuating “P” and “F” simultaneously

List of setting programs:

- | | |
|-----|--|
| 301 | Indicating the counter for the bobbin thread quantity / Deleting |
| 302 | Setting the counter for the bobbin thread quantity |
| 303 | Testing the feeding process |
| 304 | Step-by-step mode |

The various setting programs can be selected with the keys “↑” and “↓”, activated with “OK” and quitted with “ESC”.

3 0 x	_ _ _ _
-------	---------

After actuating “OK” the selected program is activated.

3.1 Indicating the counter for the bobbin thread quantity / Deleting

3 0 1	1 2 3 4
-------	---------

The current value can be reset to the programmed maximum value by a long actuation of “OK”.
The indicated value has to be multiplied by 10.

3.2 Setting the counter for the bobbin thread quantity

3 0 2	1 2 3 4
-------	---------

The value flashes and can be altered with the keys “↑” and “↓”. When actuating “OK” the value is saved and a setting program can be selected again.

The indicated value has to be multiplied by 10.

At the value 0 the bobbin thread counter is switched off.

3.3 Testing the feeding process

3 0 3	o n
-------	-----

After a long actuation of “OK” the program changes to the sewing process.

After the reference run the feeding process is carried out as in the sewing program. When actuating the pedal in inching operation the transport carriage runs in its rear position. The feeding clamps are lifted and the flap clamps open. The process can be started anew or quitted with “ESC”.

Switch the machine off in order to quit the program.

3.4 Step-by-step mode

3 0 4	S t E P
-------	---------

With a long actuation of “**OK**” the program changes to the sewing process.

At the stops at the seam beginning and seam end the following display appears:

S P	P E d
-----	-------

After stepping on the pedal the sewing process continues up to the next stop.

While the sewing program is running, the display changes to the normal sewing process again.

Switch the machine off in order to quit the program.

3.5 Dongle Menu

Important:

To save the parameters you will need an empty dongle. It can be bought at the sales point of Dürkopp Adler AG under the following part number 9835 901005.

3 0 5	
-------	--

After actuating the “OK” key, the display changes to a lower level. Using the key “←” will bring it back, one level higher. For other choices within the menu use the “↑” and “↓” keys.

At the same time, the right half of the display flashes.

If no dongle is connected at the plug connection “X110”, the message “Info 4301” will be displayed. The left and right half of each menu item will flash during the data transmission.

Menu item display dongle content

d o	d i r
-----	-------

The following displays may appear after actuating the “OK” key

Data dongle, e.g. for Cl. 745-34S

(to save the parameters)

d 7 4 5	- 3 4 S
---------	---------

Boot dongle, e.g. for Cl. 745-34S

b 7 4 5	- 3 4 S
---------	---------

Empty Dongle (not formatted)

I n f o	4 3 0 2
---------	---------

(The dongle has to be formatted first, check menu item format dongle).

Exit and go back to the **Menu item display dongle content** by actuating the “OK” key.

Menu item load the machine parameter

d o L	P P P
-------	-------

Confirmation

I n F o	4 3 2 3
---------	---------

After actuating the “OK” key, the machine parameter will be loaded from the dongle to the control.

Exit and go back to the **Menu item load the machine parameter** by actuating the “ESC” key.

If the dongle contains no machine parameter, the message “Info 4325” displays, it has to be confirmed by actuating the “OK” key.

d o L	9 P S
-------	-------

Menu item load pocket program and sequence

Confirmation

I n F o	4 3 2 4
---------	---------

After actuating the “OK” key, the pocket parameter and the sequence will be loaded from the dongle to the control.

Exit and go back to the **Menu item load pocket program and sequence** by actuating the “ESC” key.

If the dongle contains no pocket program, the message “Info 4326” displays, it has to be confirmed by actuating the “OK” key.

d o S	P P P
-------	-------

Menu item save machine parameter

Confirmation

I n F o	4 3 2 1
---------	---------

After actuating the “OK” key, the machine parameter of the sewing unit will be saved onto the dongle.

Exit and go back to the **Menu item save machine parameter** by actuating the “ESC” key.

d o S	9 P S
-------	-------

Menu item save pocket program and sequence

Confirmation

I n F o	4 3 2 2
---------	---------

After actuating the “OK” key, the pocket parameters and the sequence will be saved onto the dongle.

Exit and go back to the **Menu item save pocket program and sequence** by actuating the “ESC” key.

d o	F o r
-----	-------

Menu item format dongle

Confirmation

I n F o	4 3 2 0
---------	---------

After actuating the “OK” key, the dongle will be formatted.

Format cancel and go back to the **Menu item format dongle** by actuating the “ESC” key.

During the format process the display flashes

d 7 4 5	F o r
---------	-------

When the format process ends, the **Menu item format dongle** is displayed again.

Important:

The data on the dongle will be erased through the formatting.
A formatting of the dongle is necessary, if in the **Menu item display dongle content** does not display, the following.

d 7 4 5	- 3 4 S
---------	---------

but for example

Boot-Dongle, e.g. for cl. 745-34S

b 7 4 5	- 3 4 S
---------	---------

Empty Dongle

I n f o	4 3 0 2
---------	---------

4. Multitest

The Multitest programs can be reached by switching on and actuating “P” and “←” simultaneously.

List of programs:

901	Testing the output elements
902	Testing the input elements manually
903	Testing the input elements automatically
904	Testing the ROM
905	Testing the RAM
906	Testing the sewing motor
907	Displaying the fault recorder
950	Testing the corner knives
951	Testing the center knife
952	Setting the light-barrier for the flap
953	Setting the thread monitor
954	Setting the 2nd light barrier for the flap

4.1 Testing the output elements

9 0 1	— — — —
-------	---------

After “OK” the display changes to

Y 0 1	0
-------	---

In the left half of the display the number of the output element flashes, the right half shows its state:

0 = off,
1 = on.

With the keys “↑” and “↓” the number of the output element can be selected.

With “OK” this output element is switched on or off.

When changing over to the next output element the state of the preceding one remains unchanged.

4.2 Testing the input elements manually

9 0 2	— — — —
-------	---------

After “OK” the display changes to

S 0 1	0
-------	---

In the left half of the display the number of the input element flashes.

In the right half the state is indicated;
0 or 1 respectively.

With the keys “↑” and “↓” the number of the input element can be selected.

4.3 Testing the input elements automatically

9 0 3	— — — —
-------	---------

After “OK” the display changes to

E 0 1	0
-------	---

In the right half the state of the input element is indicated which changed last.

4.4 Testing the ROM

9 0 4	— — — —
-------	---------

	b u S Y
--	---------

Display during the test

Display after the test
check sum, e.g.

1 = OK 0 = Error

1 C 3 F	H 1
---------	-----

4.5 Testing the RAM

9 0 5	— — — —
-------	---------

	b u S Y
--	---------

Display during the test

Display after the test

1 = OK 1 = OK
0 = Error 0 = Error

R 1 . 1	r 2 . 1
---------	---------

4.6 Testing the sewing motor

9 0 6	— — — —
-------	---------

After “OK” the display changes to

n	0
---	---

With the keys “+” and “-” the speed can be changed in steps of 100 rpm.

4.7 Displaying the fault recorder

9 0 7	— — — —
-------	---------

1 Er	1 0 5 2
------	---------

The last 10 errors will be displayed.
For scrolling, use the keys “+” and “-”.

4.8 Testing the corner knives

9 5 0	1 2 3
-------	-------

In the right LED field the current seam length of L1 flashes.
With key "P" the corner knives are moved up and down.

4.9 Checking the center knife activation

9 5 1	o n
-------	-----

The center knife is switched on and off with key "F".

4.10 Setting the light-barrier for the flap

- Before activating the program, swing out the folding station.
- Place the fabric under the feeding clamp.

9 5 2	— — — —
-------	---------

After actuating the "OK" key, the switching status of the light-barrier to the flap-scanning will be shown in the right half of the display flashing.

Reflecting → LS 1
No reflection → LS 0

9 5 2	L S 1
-------	-------

Activate the following output elements:

Lower the feeding clamps left and right
Close the folding sheets
Close the flap clamps

- Pull the feeding clamp to the feeding area.
- Align the light-barrier with the center of the reflecting foil.
Please check the area from the seam beginning to the seam end on the clamp.
- Determine the distance between the switch actuation point of the light-barrier to the needle. For this purpose lay a pattern made of paper having the same size as the flap under the flap clamps. Then push the feeding clamps from the feeding area to the machine head until the light-barrier has no longer reflexion. Then measure the distance between the front edge of the pattern to the needle.
- Enter the distance between the switch actuation point of the light-barrier and the needle in the machine parameters. Switch the machine off, when switching it on strike the "P" and "→" keys simultaneously in order to switch over to the programming level (400) for machine parameters (Code 2548). In the menu item 406 enter the distance in 1/10 mm.

Orange LED	on = reflection available
Orange LED	off = no reflection
Green LED	on = stable switching signal

If the green LED does not shine, the light-barrier should be cleaned, readjusted, replaced or a new reflecting foil should be fitted.

4.11 Optional equipment - Setting the thread monitor

9 5 3	— — — —
-------	---------

(see operating instructions)

4.12 Optional equipment - Setting the 2nd light barrier for the flap

- Before activating the program, swing out the folding station.
- Place the fabric under the feeding clamp.

9 5 4	— — — —
-------	---------

After actuating the “OK” key, the switching status of the light-barrier to the flap-scanning will be shown in the right half of the display flashing.

Reflecting → LS 1
No reflection → LS 0

9 5 4	L S 1
-------	-------

Activate the following output elements:

Lower the feeding clamps left and right
Close the folding sheets
Close the flap clamps

- Pull the feeding clamp to the feeding area.
- Align the light-barrier with the center of the reflecting foil.
Please check the area from the seam beginning to the seam end on the clamp.
- Determine the distance between the switch actuation point of the light-barrier to the needle. For this purpose lay a pattern made of paper having the same size as the flap under the flap clamps. Then push the feeding clamps from the feeding area to the machine head until the light-barrier has no longer reflexion. Then measure the distance between the front edge of the pattern to the needle.
- Enter the distance between the switch actuation point of the light-barrier and the needle in the machine parameters. Switch the machine off, when switching it on strike the “P” and “→” keys simultaneously in order to switch over to the programming level (400) for machine parameters (Code 2548).
The menu item 409 must be activated.
In the menu item 410 enter the distance in 1/10 mm.

5. Table Seam Parameters

Press key “P” in the main level.

In the programming level initialize key “F” -> current program and “F-Long” all seam programs.

Number Menu item	Description	Minimum value	Maximum value	Standard value
100	Seam length mm	20	180	180
101	Stacker on / off			on
102	Center knife on / off			on
103	Center knife correction seam beginning 1/10 mm	-9,9	9,9	0
104	Center knife correction seam end 1/10 mm	-9,9	9,9	0
105	Corner knife on / off			on
106	Corner knife correction seam beginning 1/10 mm	-20	20	0
107	Corner knife correction seam end 1/10 mm	-20	20	0
108	Stitch length 1/10 mm	2,0	3,0	2,5
109	Sewing motor speed	2000	3000	2750
110	Sewing motor soft start on / off			on
111	Sewing motor number of soft start stitches	1	20	2
112	Sewing motor soft start speed	500	900	900
113	Clamping mode 0 = Lower left and right feeding clamp simultaneously 1 = Lower left feeding clamp first 2 = Lower right feeding clamp first			0
114	Positioning point 0 = front 1 = center 2 = rear			0
115	Positioning point offset mm	1	170	90
116	Type seam tightening seam beginning 0 = Bartack 1 = Condensed stitches			1
117	Number of condensed stitches seam beginning	1	10	4
118	Stitch length condensed stitches / Bartack Seam beginning 1/10 mm	0,5	3,0	1,0
119	Number of bartacks seam beginning	1	5	3
120	Type seam tightening seam end 0 = Bartack 1 = Condensed stitches			1
121	Number of condensed stitches seam end	1	10	4
122	Stitch length condensed stitches / Bartack Seam end 1/10 mm	0,5	3,0	1,0
123	Number of bartacks seam end	1	5	3
124	Material feed type 0 = Material runs to the loading position 1 = Material runs to the stacking position 2 = no run, in stacking position			2

Number Menu item	Description	Minimum value	Maximum value	Standard value
125	Type of waiting position 0 = Feeding clamp runs to the waiting position 1 = Feeding clamp remains in stacking position			1
126	Material feed to the stacking position	1	100	40
127	Loading speed %	10	100	80
128	Return speed %	10	100	80
129	Downholder on / off			on
130	Sewing mode 0 = Constant sewing length 1 = Light-barrier for flap scanning			0
131	Light-barrier correction seam beginning 1/10 mm	-20	20	0
132	Light-barrier correction seam end 1/10 mm	-20	20	0
133	Material feed to the waiting position	1	515	100
134	Max. flap length	30	180	180
135	Flap clamp on / off			on
136	Pedal mode 0 = normal 1 = Pedal has to be in basic position before the next step 2 = Pedal actuation for moving in sewing position (flap clamp)			0
137	Second light barrier active 0 = 1st light barrier active 1 = 2nd light barrier active			0

6. Machine parameters

When starting the machine hold the keys “P” and “→” pressed.
Enter code : 2548

Number Menu item	Description	Minimum value	Maximum value	Standard value
400	Submenu machine configuration			
401	Stacker available			1=available
402	Downholder available			1=available
403	Thread monitor on / off			1=on
404	Needle distance (10, 12)			10
405	Max. sewing length 180 / 200	180	200	180
406	Dist. light-barrier - needles 1/10 mm	1	375	55
407	Dist. between corner knife seam end and needles	1	375	130
408	Thread monitor available			1 = available
409	2nd light barrier available			1 = available
410	Dist. 2nd light barrier - needles 1/10 mm	1	375	55
500	Initialize parameter			
501	Machine parameter			
502	Pocket parameter			
503	Sequence			
504	All parameters			
600	Indicate counter of pieces produced			

When selecting an initializing program (501 to 504) “InI” flashes in the right half of the display.
For initializing in the programs 501 to 504 hold the key “OK” pressed.

5 0 1	I n I
-------	-------

After initializing the machine parameters to the default values (factory setting), the parameters 401-407 must be adapted to the machine equipment.

5 0 2	I n I
-------	-------

After initialization of the pocket parameters, the default values will be loaded.

5 0 3	I n I
-------	-------

After initialization the sequence will be loaded with the default value.

5 0 4	I n I
-------	-------

Initialize all parameters i.e. load the standard values for the machine, pocket parameters and sequence.

7. Error messages / Functional indications

Error/ Info	Meaning	Remedy
Control		
1051	Sewing motor Timeout · Faulty cable to the sewing motor reference switch · Faulty reference switch	· Exchange the cable · Exchange the reference switch
1052	Sewing motor excess current · Faulty sewing motor cable · Faulty sewing motor · Faulty control	· Exchange the sewing motor cable · Exchange the sewing motor · Exchange the control
1053	Too high mains voltage	Check the mains voltage
1055	Sewing motor overcharge · Sewing motor blocked/ moves too heavy · Faulty sewing motor · Faulty control	· Eliminate the blocking/ rough running · Exchange the sewing motor · Exchange the control
1056	Sewing motor excess temperature · Sewing motor moves too heavy · Faulty sewing motor · Faulty control	· Eliminate the rough running · Exchange the sewing motor · Exchange the control
1058	Sewing motor speed Faulty sewing motor	· Exchange the sewing motor
1062	Sewing motor defect of IDMA Autoincrement	Switch machine off and on again
1302	Sewing motor error Control receives no impulse from the impulse transmitter in the motor	Check the cable from the impulse transmitter in the motor to the control
1342 - 1344	Sewing motor failure Internal fault	· Switch machine off and on again · Software update · Information to the DA-Service
2101	Step motor X-axis Timeout Reference · Cable to the reference switch defective · Defective reference switch	· Exchange the cable · Exchange the reference switch
2103	Step motor feed clamp (X-axis) has step loss	Check that the feed clamp moves freely
2152	Step motor X-axis excess current	· Exchange the step motor X-axis · Exchange the control
2153	Step motor X-axis excess voltage Too high mains voltage	Check the mains voltage
2156	Step motor X-axis excess temperature · Step motor X-axis moves too heavy · Step motor X-axis defective · Faulty control	· Eliminate the rough running · Exchange the step motor X-axis · Exchange the control
2162	Step motor X-axis Defect of IDMA Autoincrement	Switch machine off and on again

Error/ Info	Meaning	Remedy
3100	Machine Control voltage Temporary mains voltage dip	Check the mains voltage
3101	Machine Power voltage Temporary mains voltage dip	Check the mains voltage
3102	Machine Voltage Sewing motor Temporary mains voltage dip	Check the mains voltage
3103	Machine Voltage Step motors Temporary mains voltage dip	Check the mains voltage
3107	Machine Temperature · Vent holes closed · Ventilation grid soiled	· Check the vent holes · Clean the ventilation grid
3210	Thread breakage	Thread in the thread again
3215	Bobbin thread counter is zero	Insert a full bobbin
3220	Empty bobbin	Insert a full bobbin
3500 - 3507 3520 - 3530 3540 3545 3721 3722	Error Control command interpreter / Motor synchronization Internal fault	· Switch machine off and on again · Software update · Information to the DA-Service
Dongle		
4301	No dongle plugged in	
4304	Wrong dongle type, to be able to save, a data dongle must be available	The dongle must be formatted
4320	Confirmation before formatting the dongle	"OK" key → format "ESC" key → cancel
4321	Confirmation before saving the machine parameter onto the dongle	"OK" key → save "ESC" key → cancel
4322	Confirmation before saving the pocket parameter onto the dongle	"OK" key → speichern "ESC" key → cancel Info 4323
	Confirmation before loading the machine parameter from the dongle to the control.	"OK" key → save "ESC" key → cancel
4324	Confirmation before loading the pocket parameters from the dongle to the control.	"OK" key → save "ESC" key → cancel
4325	The loading of the machine parameter from the dongle to the control is not possible because there is no machine parameter stored.	

Error/ Info	Meaning	Remedy
Dongle		
4326	The loading of the pocket parameter from the dongle to the control is not possible because there is no pocket parameter stored.	
6551 - 6554 6651 - 6653 6751 - 6761	Error Machine head position/ AD Converter/ Processor error Internal fault	· Switch machine off and on again · Software update · Information to the DA-Service
6952	Error Step motor driver Internal fault	· Switch machine off and on again · Software update · Information to the DA-Service
7451 7453 7454	Communication Test interface Internal fault	· Switch the machine off and on again
7452 7455	Communication Test interface · Line fault · Cable Test interface defective · Internal fault	· Eliminate the malfunction · Exchange the cable · Switch the machine off and on again
7551 - 7555 7558 7559	Communication Control panel interface Internal fault	· Switch the machine off and on again · Software update · Information to the DA-Service
7556 7557	Communication Control panel interface · Line fault · Cable Control panel interface defective	· Eliminate the malfunction · Exchange the cable
8151 8156 - 8159	IDMA error · Malfunction · Faulty control	· Switch the machine off and on again · Exchange the control
8152 - 8154	IDMA error Internal fault	· Switch the machine off and on again · Software update · Information to the DA-Service
8251 8255	Error ADSP Booting/ Booting Internal fault	· Switch the machine off and on again · Software update · Information to the DA-Service
8252 8257 8258 / 8253 8256 8254	ADSP Booting/ XILINX Booting/ Booting Malfunction	Switch the machine off and on again

Error/ Info	Meaning	Remedy
8351 8801 - 8805 8806 8890 8891	Error Testpins/ Signals / Event processing/ Memory Wrapper/ List of functions Internal fault	· Switch the machine off and on again · Software update · Information to the DA-Service
System		
Info 9001	Corner knife station is swung out	Swing corner knife station in
Err 9001	Corner knife station is swung out during the sewing process. Step back on the pedal; afterwards the transport carriage runs to the back; start the process.	Check/ adjust fastening of the corner knife station
Info 9002	Folding station is swung out	Swing folding station in
Err 9002	Folding station is swung out during the sewing process. Step back on the pedal; afterwards the transport carriage runs to the back; start the process.	Check/ adjust fastening of the folding station
9003	Wrong needle position before sewing start	Turn manually the hand wheel in lever up position
9601	Pedal has been stepped back during the sewing process	For cancelling the pedal has to be actuated once again. Afterwards the feeding clamp runs in its rear position
9604	Light-barrier (s4) for fabric removal inactive	Adjust light-barrier (s4) for fabric removal
9700	Folder not in top position	Correct folder adjustment (mechanical collision; check switch S8)
9701	Folder not in low position	Correct folder adjustment (mechanical collision; check switch S8)
9710	Limit switch feeding clamp active	Check material feed and limit switch
9720	Error when scanning the flap by light-barrier	Check the reflecting foil; check alignment of the light-barriers
9721	Flap has been positioned in front of the front positioning point	Position the flap correctly
9722	Flap protrudes from the maximum sewing area (behind the rear positioning point)	Check the flap size; Position the flap correctly
9723	Fluff at the flap beginning	Feed flaps with smooth edges; Check the reflecting foil
9726	Flap too large or reflecting foil soiled or defective	Check flap size and reflecting foil

Error/ Info	Meaning	Remedy
9730	Corner knife at the seam beginning cannot be driven to	Alter L1 (adjust corner knife distance) or change positioning point of the current seam
9800	Hardware error DC motor control	Check DC motor, DC controller and cable; check voltage supply
9900	Defective machine parameters (check sum error)	Initialize machine parameters anew (test program); Set machine parameters
9901	Defective pocket sequences (check sum error)	Initialize pocket sequences anew (test program); Set pocket sequences
9902	Defective pocket programs (check sum error)	Initialize defective pocket programs (test program); Set pocket programs
reF	Request to carry out the reference run after switching the machine on	Step back on the pedal
Current seam length flashes	Corner knife for seam beginning cannot be reached	Change the present seam length, or change the loading position, or change L1 (adjust distance counter knife).

8. Input elements

S1	Folding device swung in
S2	Folder in low position
S3	Knife support swung in
S4	Light-barrier workpiece removed / Hood monitoring
S5	Pedal forward
S6	Pedal back
S9	Needle thread monitor right needle
S10	Needle thread monitor left needle
S17	Light-barrier for flap scanning
S100	Reference switch sewing motor
S101	Reference switch feeding clamp

9. Output elements

Y1	Close folding sheets
Y2	Open flap clamp
Y3	Lower left feeding clamp
Y4	Lower right feeding clamp
Y5	Lower folder
Y6	Folder lifting off
Y7	Downholder on
Y8	Reserve
Y9	Knife support seam beginning
Y10	Knife support seam end
Y11	Stacking tongs forward
Y12	Swing stacking bow out
Y13	Reserve
Y14	Reserve
Y15	Reserve
Y16	Reserve
Y17	Open needle thread scissors
Y18	Lower center knife
Y19	Blow fluff out
Y20	Open bobbin thread clamp
Y21	Close bobbin thread scissors
Y22	Close thread tension