Gauge for setting the zero point plus the needle position.
# 95-730 242-75/993
SAFETY INSTRUCTIONS

- The machine must only be used for the purpose it was designed for. In case of conversion into another version all valid safety instructions have to be considered.

- Do not operate the machine without the safety devices it is equipped with.

- The machine must only be switched on and operated by persons who have been instructed accordingly.

- When exchanging gauge parts (e.g. needle, presser foot, needle plate, feed dog, bobbin), threading the machine or leaving it, and when making maintenance work, the machine must be disconnected either by actuating the master switch or by removing the mains plug. In case of mechanically-actuated clutch motors wait for the motor to stand still.

- When carrying out maintenance- or repair work on pneumatic devices the machine must be disconnected from the pneumatic supply source. The only exceptions permitted are adjustments and performance checks made by competent personnel.

- Work on the electrical equipment of the machine must only be carried out by electricians or other persons who have been instructed accordingly.

- Apart from the permissible deviations according to DIN 57105 or VDE 0105, work on live parts and equipment is not permitted.

NORMES DE SÉCURITÉ

- N'utiliser la machine que pour les travaux auxquels elle est destinée. En cas de transformation en une autre version, respecter toutes les prescriptions de sécurité valables.

- Ne pas utiliser la machine sans les dispositifs de sécurité.

- Seule l'opératrice instruite en conséquence devra mettre la machine en circuit et coudre.

- Avant le changement d'organes de couture tels que l'aiguille, le pied presseur, la plaque à aiguille, la griffe et la canette, avant l'enfilage, avant de quitter la machine et avant les travaux d'entretien, la machine est à mettre hors circuit à l'interrupteur général ou par enlèvement de la fiche secteur.

- Pour les moteurs-transmetteurs mécaniques, attendre l'arrêt du moteur.

- Pour les travaux d'entretien et de réparation au système pneumatique, couper la machine du réseau pneumatique. Seules exceptions admises: réglages et contrôles par du personnel compétent.

- Les travaux aux équipements électriques sont à confier à un électricien ou à du personnel compétent.

- Les travaux aux pièces et dispositifs sous tension ne sont pas admis, sauf les exceptions selon la normes DIN 57 105 ou VDE 0105.
### Contents

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Functions of switches and keys

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7. Regulating the bottom thread tension  
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### Additional instructions

1. Loading the workpiece on version with stationary pocket plate  
2. Sewing on version with stationary pocket plate
FUNKTION DER SCHALTER UND TASTEN
FUNCTIONS OF SWITCHES AND KEYS
FONCTIONS DES INTERRUPTEURS ET TOUCHES
FUNCIONES DE LOS INTERRUPTORES Y PULSADORES

mit Gegenüberstellung alter und neuer Symbole
with a comparison of old and new symbols
avec comparaison des anciens et des nouveaux symboles
con comparación de los símbolos antiguos y nuevos

Beispiel: Alte Ausführung - Neue Ausführung
Example: Old version - New version
Exemple: Ancien modèle - Nouvelle version
Ejemplo: Tipo antiguo - Nuevo tipo
Bedienung Automatik
Automatic operation
Commande automatique
Manejo automático

Bedienung manuell
Manual operation
Commande manuelle
Manejo manual

Eingabe (taste drücken, bevor Haupt- bzw. Teilfunktionen eingegeben werden)
Input (press before entering primary or partial functions)
Entrée (appuyer sur cette touche avant d’entrer les fonctions principales ou partielles)
Entrada (pulsar botón antes de registrar las funciones principales y parciales)
Servico (taste drücken, bevor Servicefunktionen eingegeben werden)
Service (press before entering service functions)
Service (appuyer sur cette touche avant d’entrer les fonctions de service)
Servicio (pulsar botón antes de registrar las funciones de servicio)

1. Haupt- und Teilfunktionen aus SERV und INP abfragen
2. Übernahme von neuen Eingaben
1. Inquiring primary and partial functions from SERV and INP
2. Adoption of new inputs
1. Questionner les fonctions principales et partielles de SERV et INP
2. Reprise de nouvelles entrées
1. Toma de las funciones principales y parciales de SERV e INP
2. Aceptación de nuevas entradas

Fehler-Rücksetzung (nach Beheben von Fehlern oder Spulenwechsel)
Error reset (after removal of errors or after bobbin changes)
Réarmer (après l’élimination de défauts ou le changement de canette)
Repoificado de errores (después de subsanar fallos o de cambiar la canilla)

Nähstückvorwärts takten
Click sewing jig forwards
Avancer le gabarit de couture pas à pas
Para avance de la plantilla de costura

Nähstückrückwärts takten
Clock sewing jig backwards
Reculer le gabarit de couture pas à pas
Para retroceso de la plantilla de costura

Nähprogramm in Grundstellung
Basic position of sewing program
Programme de couture en position de base
Programa de costura en posición básica

Nadel positionieren in Hochstellung
Needle up position
L’aiguille positionne en haut
Para posicionado superior de la aguja

Stapler vor - zurück (zum Spulenwechsel)
Stacker forwards - backwards (to change bobbin)
L’empeleur avance – recule (pour le changement de la canette)
Apilador avanza – retrocede (para cambiar la canilla)

Programm-Stop
Program stop
Arrêt de programme
Parada del programa

Nähren Start
Programmfortsetzung nach Stop
Start sewing
Program continued after stop
Lancement couture
Reprise de programme après interruption
Comienzo de la costura
Continuación del programa después de la parada
Programmablauf ohne Nähen bei "AUTO"
Program without sewing in "AUTO"
 en "AUTO", déroulement du programme sans couture
Desarrollo del programa sin coser con "AUTO"

Umbagger und Schablontransport in Grundstellung
Basic position of edge folder and jig feed
Conformeuse et gabarit en position de base
Grupo doblador y transporte de la plantilla en posición básica

Funktionenablauf in Einzelschritten bei "MAN" ohne Nähvorgang
Function flow in single steps in "MAN" without sewing
Séquence de fonctionnement pas à pas
en commande "MAN", sans opération de couture
Funcionamiento en pasos individuales con "MAN" sin proceso de costura

Maschine ein
Machine on
Machine en fonction
Conexión de la máquina

Nähen ein bei "MAN"
Sewing on in "MAN"
Décrochement de la couture en service "MAN"
Costura con "MAN"

Aufhebung von STOP (Bedienpult Umbagger)
STOP cancelled (control panel edge folder)
Elimination de "STOP" (console de la conformeuse)
Desbloqueo del STOP (pupitre de mandos, grupo doblador)

Hauptschalter
Master switch
Interrupteur général
Interruptor general

NOT - AUS
EMERGENCY OFF
ARRET D'URGENCE
PARADA DE EMERGENCIA
Bei "MAN":
Taschenblech vor (bei Ausführung mit schwenkbarem Taschenblech)
Umburger und Tisch ab (bei Ausführung mit starrer Taschenblech)
In "MAN":
Pocket plate forwards (on version with movable pocket plate)
Edge folder and table down (on version with stationary pocket plate)
Avec commande "MAN":
Gabarit de poche avance (module à gabarit de poche pivotant)
Conformeuse et table descendante (module à gabarit de poche rigide)
Con "MAN":
Chapa de bolsillo avanza (en el tipo con chapa de bolsillo giratoria)
Grupo doblador y mesa descienden (en el tipo con chapa de bolsillo rigida)

Bei "AUTO"
Programmstart
In "AUTO"
Prograse start
Avec commande "AUTO"
Démarrage du programme
Con "AUTO"
Puesta en marcha del programa
Switching on the machine

Open compressed air valve 1 (Figs. 1, 1.1).

Check that gauge 2 (Fig. 2) shows a pressure of 6 bar. Have this pressure set by a mechanic, if it does not.

Set master switch 3 (Fig. 2) at "1" - key "ERROR RESET" lights up.

Press key "ON"
- control carriage in basic position, keys "MAN" and "START" light up.

The machine is ready for manual operation.

For automatic work cycle press key "AUTO" in addition
- keys "AUTO" and "STOP" light up.

Press key "START"
- key "START" lights up,
- key "STOP" goes out, the machine is operative.
Inserting the needle

Use system 134 CL suk NM 110-140 needles.

RELEASE RATCHET LEVER 1 (Fig. 1) AND PUSH BAR 2 FULLY TOWARDS THE MACHINE - KEY "STOP" LIGHTS UP, THE MACHINE IS OUT OF OPERATION.

Fully insert the needle in the needle bar and turn until the long groove faces the folding station.

Tighten needle retaining screw 3 (Fig. 2).

RETURN BAR 1 (Fig. 1) TO ORIGINAL POSITION AND PRESS KEY "START" - KEY "STOP" GOES OUT, THE MACHINE IS OPERATIVE.
Winding the bottom thread

Place an empty bobbin on the bobbin winder spindle.

Press down trip 1 (Fig. 1). (If it resists, turn the bobbin lightly).

Wrap the thread (threaded according to Fig. 1) several times around the bobbin in clockwise direction.

During sewing, the bobbin winder runs as long as it takes to fill the bobbin and is then switched off automatically.

Regulating the bobbin thread tension

By turning milled screw 2 (Fig. 1) in clockwise direction, the tension is decreased, by turning it counter-clockwise it is increased.
Removing the bobbin case

RELEASE RATCHET LEVER 1 (Fig. 1) AND PUSH BAR 2 FULLY TOWARDS THE MACHINE - KEY "STOP" LIGHTS UP, THE MACHINE IS OUT OF OPERATION.

Press keys "ERROR RESET" and "STACKER" - stacker flap moves forwards.

Open flap 3 (Fig. 2) and pull bobbin case out of sewing hook.

Threading the bottom thread

Insert the full bobbin in the bobbin case so that it turns in the direction indicated by the arrow when thread is wound off (Fig. 3).

Hold the bobbin. Insert the thread in groove 4 and pull through under the tension spring until it emerges again behind delivery eye 5. Then insert the thread in grooves 6 and 7 and pull it through the holes.

Regulating the bottom thread tension

By turning screw 8 (Fig. 3) in clockwise direction, the tension is increased, by turning it counter-clockwise it is decreased.

Inserting the bobbin case

Open flap 3 (Fig. 2); thus the bobbin cannot fall out.

Insert the bobbin case in the sewing hook and let flap 3 go.

Lightly press in the bobbin case so it engages properly.

Press key "STACKER" - the stacker flap moves back.

RETURN BAR 2 (Fig. 1) TO ORIGINAL POSITION AND PRESS KEY "START" - KEY "STOP" GOES OUT, THE MACHINE IS OPERATIVE.
9 Threading the needle thread

RELEASE RATCHET LEVER 1 (Fig. 1) AND PUSH BAR 2 FULLY TOWARDS THE MACHINE
- KEY "STOP" LIGHTS UP, THE MACHINE IS OUT OF OPERATION.

Thread the needle according to Fig. 2 and pull approx. 7 cm through the needle eye, so it does not unwind when sewing is started.

RETURN BAR 2 TO ORIGINAL POSITION AND PRESS KEY "START"
- KEY "STOP" GOES OUT, THE MACHINE IS OPERATIVE.

10 Regulating the needle thread tension

By turning nut 3 (Fig. 2) in clockwise direction, the tension is increased, by turning it counter-clockwise it is decreased.
11 Inquiring the primary functions

In basic state of input, all primary functions with their numbers can be displayed by key "ENTER".

Switch on the machine.

Press key "INP" on the control panel (Fig. 1).

By pressing key "ENTER" repeatedly, the primary functions are displayed.

1 ... PROGRAM NUMBER
2 ... SOURCE
3 ... SEWING SPEED
4 ... RESET OF COUNTERS
5 ... READ, DELETE, DIR. OF PROGRAMS
6 ... MANIPULATION OF TIMES
7 ... SWITC FUNCTIONS

Press one of the operation mode keys to leave the input status.

11.1 Inquiring the partial functions

In the respective primary function, all available partial functions and their numbers can be displayed by operating key "ENTER" (see input summary in section 12).
Basic state

1. Program number
2. Program source
   1. EPROM
   2. Memory
3. Sewing speeds
   1. Max. sewing speed
   2. Reduced sewing speed
4. Setting/resetting counters
   1. Piece counter
   2. Bottom thread stitch counter
   3. Preliminary setting of bottom thread stitch counter
   4. Delay of zigzag on
   5. Delay of zigzag off
5. Reading, deleting, directory of programs
   1. Directory
      1. EPROM
      2. Memory
   2. Delete one program
   3. Delete all programs
   4. Read in one program from EPROM
   5. Read in all programs from EPROM
   6. Read in programs via interface
6. Manipulation of times
   1. Stacker airblast
   2. Fabric feed roller
   3. Positioning pin up
   4. After table up
   5. Edge folder slide
   6. Jig feed forwards
7. Switch functions
   1. Airblast selection
      1. Needle cooling during feed
      2. Needle cooling during stacking
      3. Fabric feed assistance during feed forwards
      4. Fabric feed assistance during stacking
      5. Fabric feed assistance during sewing
   2. Puller
   3. Positioning pin
   4. Thread monitor
Program selection

The input of program numbers is only possible with the machine in basic position.

Press key "INP" on the control panel - input.

Press key 1 - on the display of the control panel appears: NEW PROGRAM NUMBER ...

By pressing keys 0 to 9, input the required program number.

Press key "ENTER" - the program number is adopted and appears in the left top corner of the display.*

Press one of the two operation mode keys "MAN" or "AUTO" - end of input.

When changing programs sewing jig and edge folder may have to be changed, too.

* If the selected program number is not available in the current program source, a warning is issued - "NO PROGRAM NUMBER ..." (i.e. the input number).

Although the program is adopted when key "ENTER" is pressed again, it cannot be sewn before the selected program has been included in the current program source.
Program source

Input of the program source is only possible with the machine in basic position.

Press key "INP"
- input.

Press key 2
- on the display of the control panel appears:
  1 - EPROM/2 - MEMORY.

If the current program number is available in the selected program source, the new program source is adopted and the program can be processed.*

* If the current program number is not available in the selected program source (EPROM or MEMORY), a warning is issued "NO PROGRAM NUMBER ... (i.e. the input number).

Although the program source is adopted when key "ENTER" is pressed again, sewing cannot start before the correct program number has been selected.
Sewing speeds

Both top and reduced sewing speeds can be displayed and affected.

The sewing speed can be input in steps from 1 to 15, the 15 standing for top speed (= 100%).

Between 100% and 40% the sewing speed is changed by 5% with each step, from 40% the change per step is 10%.
The respective percentage appears in the display.

15.1 Top speed

Press keys "INP", 3 and 1.

The lower line of the display shows the current speed level (e.g. MAX SPEED 15).

By pressing keys 0 to 9, the required speed level is input and indicated in percentage.

By pressing key "ENTER", the value is adopted.

15.2 Reduced sewing speed

Press keys "INP", 3 and 2.

The current speed level (e.g. RED SPEED 15) is indicated in the lower line of the display.

By pressing keys 0 to 9, the required speed level is input and indicated in percentage.

By pressing key "ENTER", the value is adopted.
16 Setting, resetting the counters

16.1 Piece counter

The piece counter continuously counts the pockets sewn on.

For resetting at "0", press keys "INP", [4], [1] and [0] in the sequence indicated. Afterwards press one of the operation mode keys.

16.2 Bottom thread stitch counter

The bottom thread stitch counter counts the number of sewn stitches in units of 100 stitches.

The number of stitch units which can be sewn with a full bobbin must be ascertained individually.

For 100 stitches each, the stitch counter advances by one unit until the preset value is achieved. The started seam is finished and the program remains in position "jig feed at rear". "CHANGE BOBBIN" appears on the display.

Change the bobbin according to sections 5 - 9 and press keys "ERROR RESET" and "START" - the program is continued.

In case of premature bobbin change (i.e. before the set value is reached) the bottom thread stitch counter must be reset by pressing keys "INP", [4], [2] and [0].

16.3 Pre-setting of bottom thread stitch counter

Preset the ascertained value by pressing keys "INP", [4] and [3].

Afterwards input the setting value by pressing keys [0] to [9] and adopt by pressing key "ENTER".
16.4 Zigzag delay on

The command for "zigzag on" is programmed 7 stitches before start of backtack. Due to the propagation delay of valve and cylinder, the command must be issued with a delay, depending on the speed.

When changing the sewing speed, the number of stitches between command "zigzag on" and start of backtack (Fig. 1) must be changed.

Press key "IMP" and twice key 4.

The current delay value is indicated in stitches.
Input a new value by pressing keys 0 to 9 and adopt by pressing key "ENTER".
16.5 Zigzag delay off

The command for "zigzag off" is programmed 7 stitches before end of backtack. Due to the propagation delay of valve and cylinder, the command must be issued with a delay, depending on the speed.

When changing the sewing speed, the number of stitches between command "zigzag off" and end of backtack (Fig. 2) must be changed.

Press keys "INP", [4] and [5].

The current delay value is indicated in stitches.
Input a new value by pressing keys [0] to [9] and adopt by pressing key "ENTER".

Correct

Incorrect

Delay too short
Increase number of stitches

Incorrect

Delay too long
Reduce number of stitches
Reading, deleting, directory of programs

After pressing keys "INP" and [5], it is possible to scroll through the possible partial functions by means of key "ENTER".

In doing so, the function number of each partial function is indicated too.

1 ... Directory of programs

After pressing key [1], it is possible to display the programs in the EPROM by operating key [1] again or those in the memory by pressing key [2].

If one line is not sufficient for the display of all available program numbers, the display can be continued by pressing key "ENTER".

After the last program number END appears.

2 ... deleting individual programs

The deletion of programs is only possible in basic position of the machine.

Press key [2] and input the program number to be deleted.

Press key "ENTER" - the deleting action is triggered and confirmed afterwards.

3 ... deleting all programs

First press key [3], then "ENTER" - all programs are deleted and the deleting action is confirmed.

4 ... Reading in a program from EPROM in memory

After pressing key [4], input the program number to be read in and press key "ENTER" - the input is started.

If the program to be read in cannot be found in the EPROM, or if the same program number is already available in the memory, or if the storage location is not sufficient, there is a corresponding error message.
18 Manipulation of times

18.1 Stacker airblast

The airblast timing must be adjusted so as to ensure that the part to be stacked is blown reliably over the stacker buck.


"TIMING FOR AIR BLAST STACKER" and the adjusted value in seconds appear in the lower line of the display.

Input a new value by operating keys [0] to [9] and adopt by pressing key "ENTER".

18.2 Timing of fabric feed roller

The stacked workpiece must be positioned in the middle of the stacker buck (Fig. 1).


"TIMING FOR STACKER ROLLER" and the adjusted value in seconds appear in the lower line of the display.

Input a new value by operating keys [0] to [9] and adopt by pressing key "ENTER".

18.3 Positioning pin up

(For setting see service manual)

18.4 Table up

(For setting see service manual)

18.5 Edge folder slide

(For setting see service manual)

18.6 Jig feed

(For setting see service manual)
5 ... Reading in all programs from an EPROM in the memory

Press "ENTER" after having operated key 5 first - the programs are read in; the reading in function is confirmed at the end.

6 ... Reading in programs in memory via Interface

After operating key 6, the machine is ready for transfer.

The transfer is started at the personal computer.

At the end, the reading in function is confirmed or an error message issued.
CORRECT

INCORRECT
Increase timing

INCORRECT
Increase timing
Switch functions

19.1 Airblast selection

Needle cooling during feed forwards

To avoid the starting thread from being pushed under the presser foot while the workpiece is fed to the sewing station.

Press keys "INP", [7], [1] and again key [7].

The airblast is switched on by key [7], and switched off by key [0].

Needle cooling during stacking

(If required)

Airblast "fabric feed assistance"
(Work aid)

When processing large workpieces, it is possible to work with the "fabric feed assistance" airblast during the functions "jig feed forwards" and "stacking", and "sewing" in order to avoid the material from jamming.

Airblast during "feed forwards"

Press keys "INP", [7], [1] and [3].

The airblast is switched off by key 0, and switched on by key 1.

Airblast during "stacking"

Press keys "INP", [7], [1] and [4].

The airblast is switched off by key 0, and switched on by key 1.

Airblast during "sewing"

Press keys "INP", [7], [1] and [5].

The airblast is switched off by key 0, and switched on by key 1.
19.2 **Puller**  
(Work aid)


The puller is switched off by key [0], and switched on by key [1].

19.3 **Positioning pin**

On machine versions with positioning pin, the folding action can be triggered with or without positioning pin, as required.

Press keys "INP", [7] and [3].

The positioning pins are switched off by key [0], and switched on by key [1].

19.4 **Thread monitor**

Press keys "INP", [7] and [4].

The thread monitor is switched off by key [0], and switched on by key [1]. (Mainly for inspection purposes.)
Inquiring service functions
(Only for mechanics, detailed instructions in service manual)

In the basic state of service, all service functions with their function numbers can be indicated by pressing key "ENTER".

Switch on the machine.

Press key "SERV" on the control panel.

By pressing key "ENTER" repeatedly, the service functions are displayed.

1 ... Setting/resetting exits
2 ... Step motor for X-coordinate
3 ... Step motor for Y-coordinate
4 ... Sewing motor
5 ... Thread trimming sequence
6 ... Display of entries
Loading the workpiece on version with movable pocket plate
(For versions with stationary pocket plate see additional instruction book)

With colored adhesive tape, mark the position of the cutting on the work table (see arrow in Fig. 1).

Press key 1 (Fig. 1) and keep pressed - clamping strip 2 opens.

Insert cutting in folding station and level out according to marking.

Let key 1 go afterwards - the cutting is held by clamping strip 2.

Place the cutting on pocket plate 3 (Fig. 2), push underneath leaf springs 4 up to stops 5 and position in the middle of the pocket plate.
22 Sewing on version with movable pocket plate
   (For versions with stationary pocket plate
   see additional instruction book)

22.1 Manual operation (key "MAN" lights up)

   After the workpiece is loaded and aligned,
   press buttons 1 simultaneously (Fig. 1)
   - pocket plate forwards and down.

   Clock through the program sequence by
   pressing key "STEP" repeatedly.

   - Edge folder and table down
   - Edge folder slide on and off
   - Edge folder and table up
   - Sewing jig moves to folding station,
     stacker in function
   - Sewing jig lowered
   - Pocket plate backwards
   - Sewing jig moves to sewing station

   Press key "SEW" - sewing on.

22.2 Automatic work sequence

   Press keys "AUTO" and "START"
   - the machine switches over to automatic
     work sequence.

   After the workpiece is loaded and aligned,
   press buttons 1 simultaneously (Fig. 1)
   - the entire work sequence runs off
     automatically.
Malfuctions

When the thread breaks, THREAD ERROR appears on the display of the control panel, the machine automatically clocks back 12 stitches back and stops.

Thread the needle thread according to section 9.

Press keys "FWD" or "BACK" until the sewing jig has reached the position to continue sewing.

Press key "START"
- the sewing operation is continued until end of program.

Switching off the machine

Set master switch 1 (Fig. 1) at "0" and close compressed air valve 2 (Fig. 2), (see Fig. 2.1).

If the machine is to be switched off immediately, press either key 3 (Fig. 1) or key 4 (Fig. 3) - EMERGENCY OFF.
25 Care and maintenance

25.1 Air filter/lubricator

When using the machine continuously, check the air filter/lubricator daily.

The oil level must not drop below the mark on oil reservoir 1 (see arrow in Fig. 1). (Have oil topped up by a mechanic, if necessary).

The water level must not exceed the mark on container 2 (see arrow). Open drain screw 3 by two or three turns and let the water drain off. Afterwards tighten drain screw 3 firmly.

25.2 Oiling the sewing unit

When using the machine continuously, check both oil levels in oil sight glass 4 on the sewing unit (Fig. 2) daily. They must not drop below marks 5 and 6 respectively.

If required, top up oil through hole 7 until both oil levels have reached marks 8 and 9.

We recommend Pfaff sewing machine oil, part No. 280-1-120 144 or an oil with a mean viscosity of 22.0 mm²/s at 40°C and a density of 0.865 g/cm³.

25.3 Cleaning the machine

Clean the entire machine regularly.

The sewing hook area however must be cleaned several times a day.
Additional instructions
Loading the workpiece on version with stationary pocket plate

Cuttings on which the location of the pockets is marked are aligned according to positioning lights.

In case of unmarked cuttings, mark the position of the cuttings on the work table.

Press pedal 1 (Fig. 1) backwards (and keep pressed), - clamp strip 2 (Fig. 2) opens.

Insert and align cutting in edge folder.

Release pedal 1 afterwards - the cutting is held by the clamp strip.

Press pedal 1 (Fig. 1) forwards - the pocket plate moves forwards.

Place the cutting on pocket plate 3 (Fig. 3), push underneath leaf springs 4 against stops 5 and and position in the middle of the pocket plate.
2 Sewing on version with stationary pocket plate

2.1 Manual operation (key "MAN" lights up)

When the workpiece is loaded and aligned, press buttons 1 simultaneously (Fig. 1)
- pocket plate forwards and down

Clock through the program by repeatedly pressing key "STEP".
- Edge folder slide on and off
- Edge folder and table up
- Sewing jig moves to folding station, stacker in function
- Sewing jig lowers
- Pocket plate backwards
- Sewing jig moves to sewing station

Press key "SEW" - sewing on.

2.2 Automatic work sequence

Press keys "AUTO" and "START"
- the machine switches over to automatic work sequence.

When the workpiece is loaded and aligned, press buttons 1 simultaneously (Fig. 1)
- the entire work sequence runs off automatically.