

# PFAFF

## 3371-1/01

### Adjustment Manual

This Adjustment Manual is valid for machines from the following serial numbers onwards:

# 6 001 000 →

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## 14 Adjustment



Please observe all notes from **Chapter 1 Safety** of the instruction manual! In particular care must be taken to see that all protective devices are refitted properly after adjustment, see **Chapter 1.06 Danger warnings** of the instruction manual!



If not otherwise stated, the machine must be disconnected from the electrical power supply.

### 14.01 Notes on adjustment

All following adjustments are based on a fully assembled machine and may only be carried out by expert staff trained for this purpose.

Machine covers, which have to be removed and replaced to carry out checks and adjustments, are not mentioned in the text.

The order of the following chapters corresponds to the most logical work sequence for machines which have to be completely adjusted. If only specific individual work steps are carried out, both the preceding and following chapters must be observed.

Screws, nuts indicated in brackets ( ) are fastenings for machine parts, which must be loosened before adjustment and tightened again afterwards.

### 14.02 Tools, gauges and other accessories

- 1 set of screwdrivers with blade widths from 2 to 10 mm
- 1 set of spanners with jaw widths from 7 to 14 mm
- 1 set of Allen keys from 1.5 to 6 mm
- 1 metal ruler, part no. 08-880 218-00

### 14.03 Abbreviations

t.d.c. = top dead centre

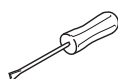
b.d.c. = bottom dead centre

### 14.04 Explanation of the symbols

In this adjustment manual, symbols emphasize operations to be carried out or important information. The symbols used have the following meaning:



Note, information

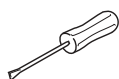
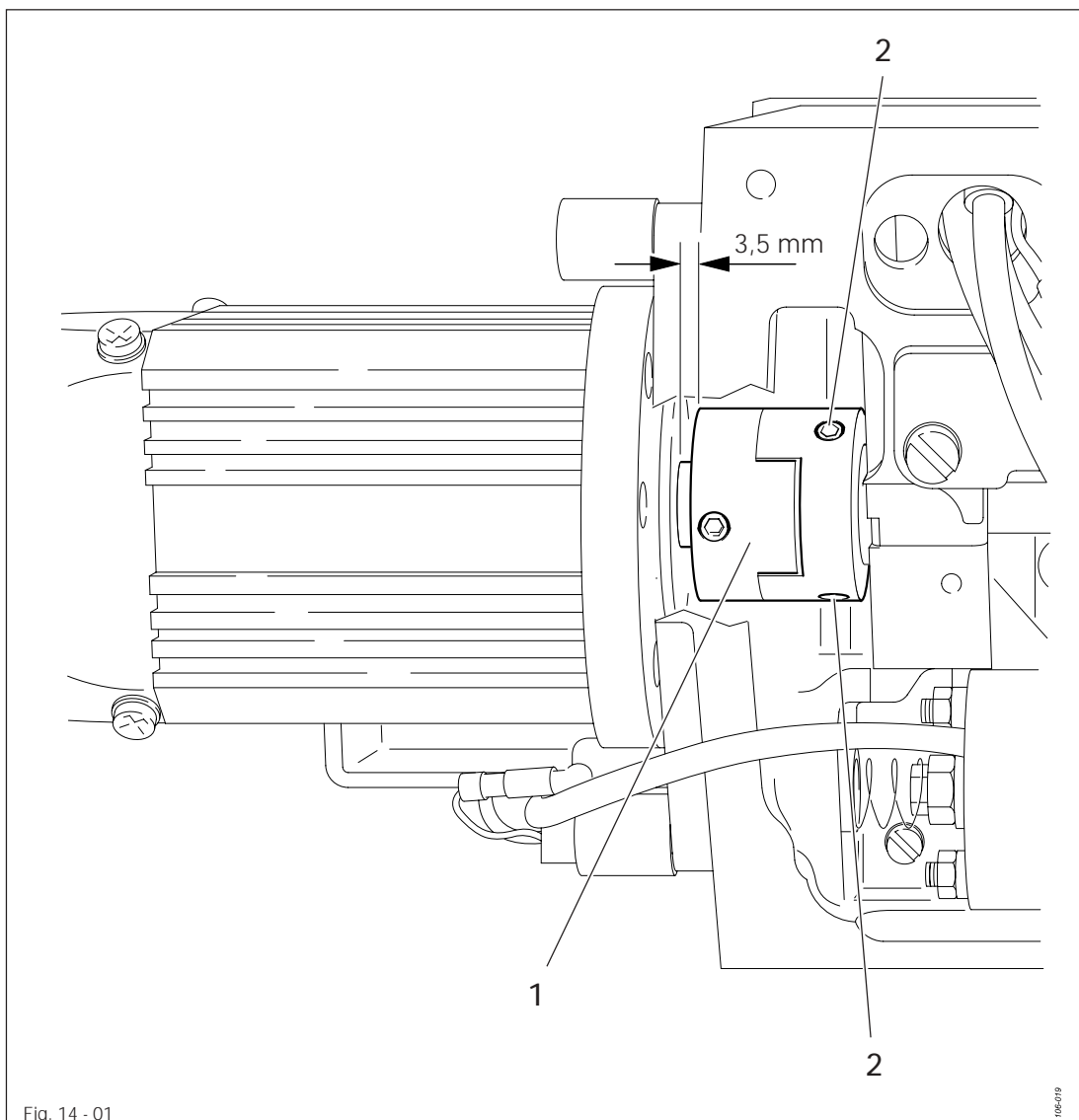


Service, repair, adjustment, maintenance  
(work to be carried out by qualified staff only)

## 14.05 Basic position of the machine

## Requirement

After the machine has been switched on, it should position in t.d.c. needle bar.



- Switch on the machine.
- Hold clutch 1 (screws 2) and bring the needle bar into the appropriate position by turning the balance wheel.
- Switch off the machine.



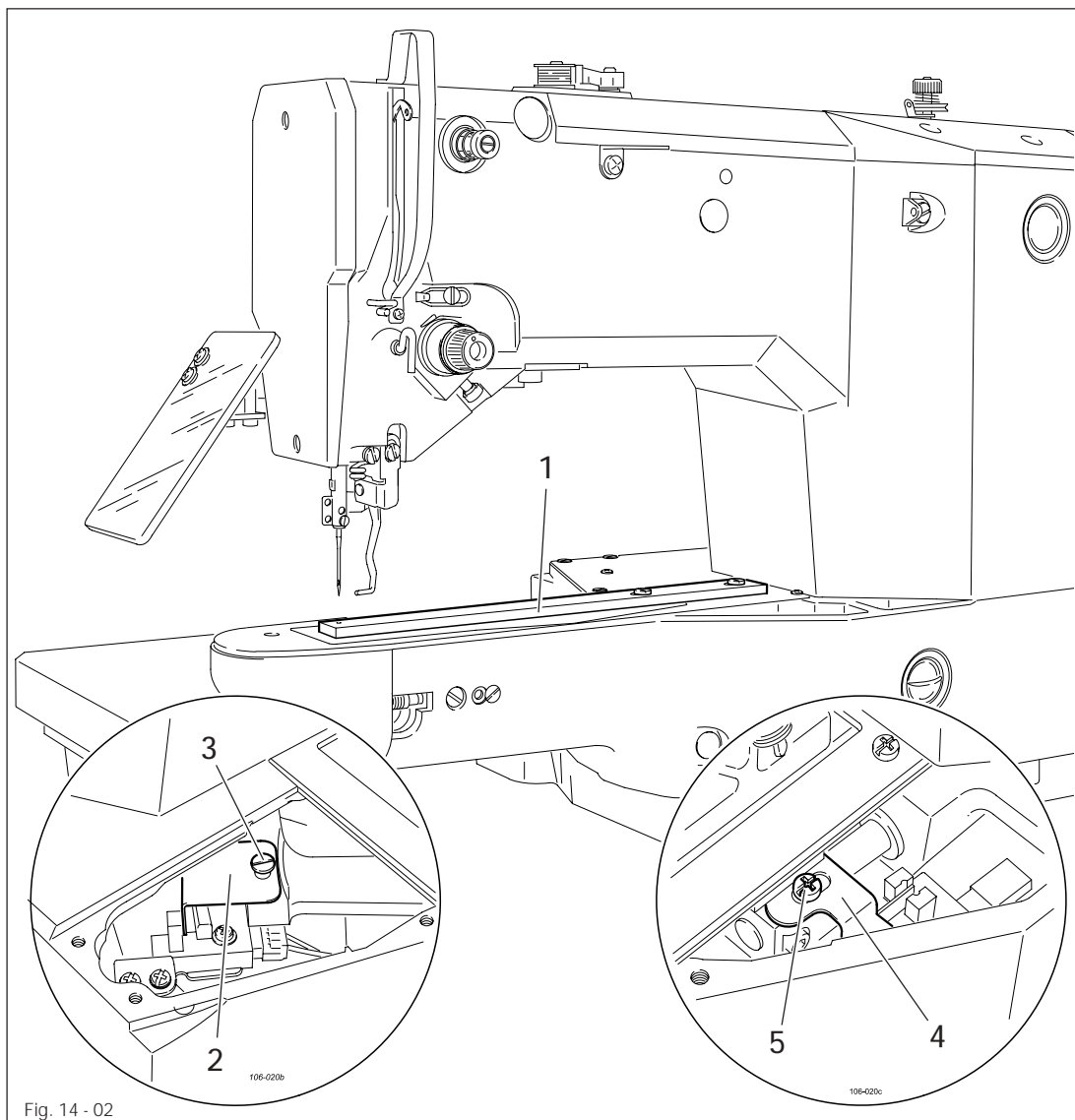
The distance from the clutch 1 to the motor plate should be 3.5 mm.

## 14.06 Work clamp zero point

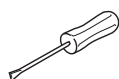
### Requirement

After the machine has been switched on and parameter "608" selected,

1. the needle should be centred to the hole in the adjustment gauge,
2. the switch lugs 2 and 4 should be centred to the respective initiator.



When removing the work clamp holder, take care that the ball bearings in the arm support do not drop out !



- Remove the work clamp holder and the lower feed plate .
- Screw adjustment gauge 1 (part no. xxxxxxxx) to the work clamp drive unit.

### Preliminary adjustment

- Move the work clamp drive unit by hand in accordance with requirement 1.
- Adjust switch lug 2 (screw 3) and switch lug 4 (screw 5) in accordance with requirement 2.

## Fine adjustment

- Switch on the machine.
- In the input mode, select parameter "608", see **Chapter 11.03 Parameter input** in the instruction manual.
- If necessary, enter the access code, see **Chapter 11.04.01 Entering the access code** in the instruction manual.

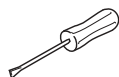
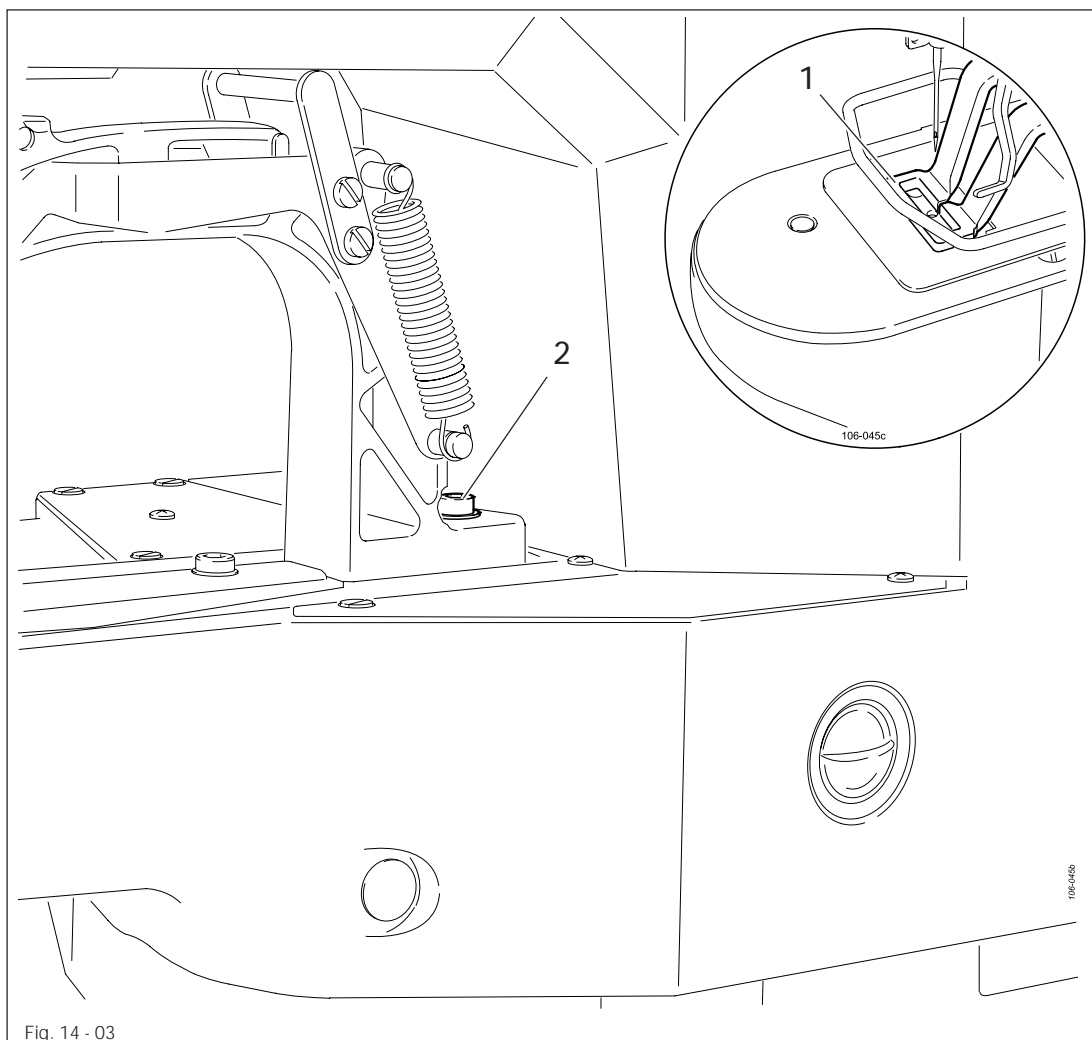


- With the corresponding **plus/minus key** move the work clamp drive unit in accordance with **requirement 1**, also see **Chapter 11.03 Parameter input**.
- Switch off the machine.
- Remove adjustment gauge 1.
- Fit the lower feed plate and work clamp holder.

## 14.07 Aligning the work clamp

### Requirement

The work clamp should be aligned in "X" and "Y" direction, so that it does not touch the needle during sewing.



- Switch on the machine.
- Set the sewing area size (see Chapter 9.07 Adjusting the size of sewing area in the instruction manual)
- In the input mode, select parameter "609", see Chapter 11.03 Parameter input in the instruction manual
- If necessary, enter the access code, see Chapter 11.04.01 Entering the access code in the instruction manual.
- With the **plus/minus** keys move the work clamp in the X-direction in accordance with the **requirement**.
- Select parameter "610".
- Slide work clamp 1 (screw 2) in the Y-direction in accordance with the **requirement**, or move it with the **plus/minus** keys.
- Conclude the input.

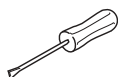
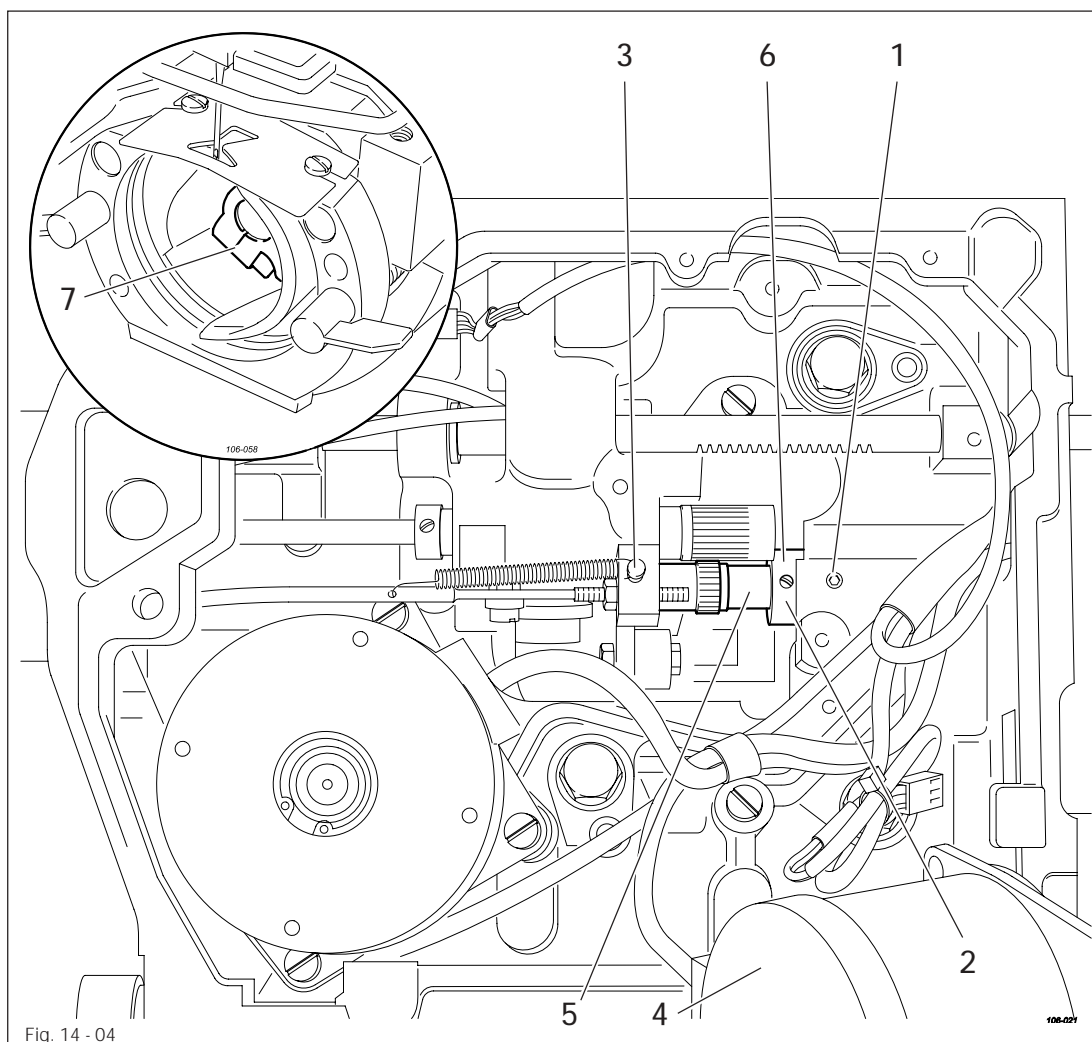




## 14.08 Hook driver

## Requirement

1. When the balance wheel is turned, the machine should not bind.
2. The play of catch 7 should be less than 0.1 mm.



- Remove the hook.
- Loosen screws 1, 2 and 3 (remove motor 4).
- Move the eccentric shaft 5 in accordance with **requirement 1** and twist it in accordance with **requirement 2**.
- Tighten screws 1 and 3.
- Move adjustment ring 6 against the metal edge and tighten screw 2.
- Insert the hook.

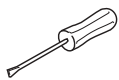
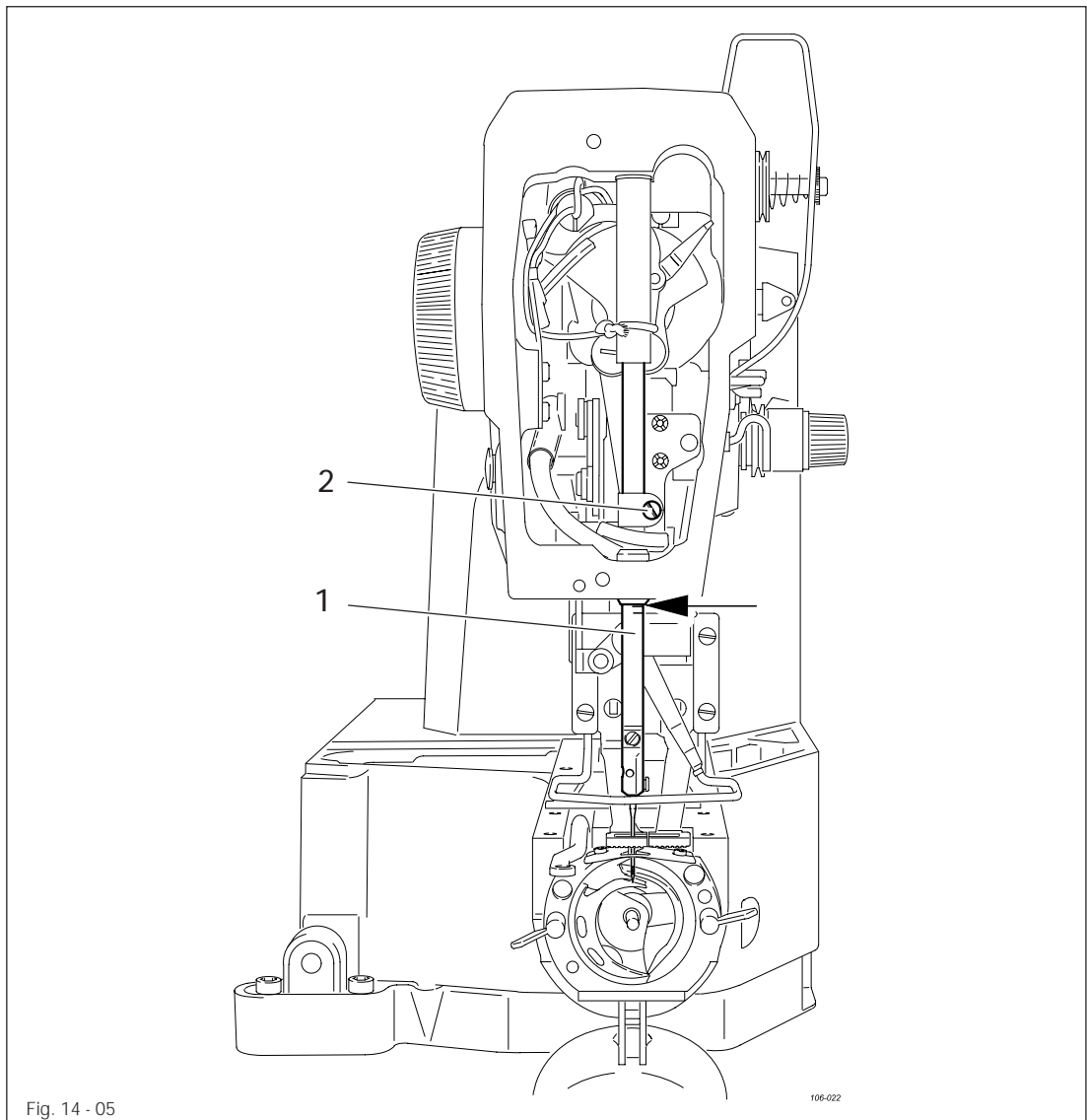


If catch 7 has too much play, the running noise of the machine increases. Too little play may cause the machine to jam.

## 14.09 Needle height

### Requirement

With the needle bar in b.d.c., the upper marking on the needle bar 1 should be flush with the lower edge of the needle bar bush.



- Adjust needle bar 1 (screw 2) in accordance with the requirement.

## 14.10 Hook-to-needle clearance

**Requirement**

When the bottom marking of the ascending needle bar is level with the lower edge of the needle bar bush

1. hook 5 should be 0.05 – 0.1 mm behind the needle and
2. the distance between the needle and the tip of the hook race should be 7.5 mm.

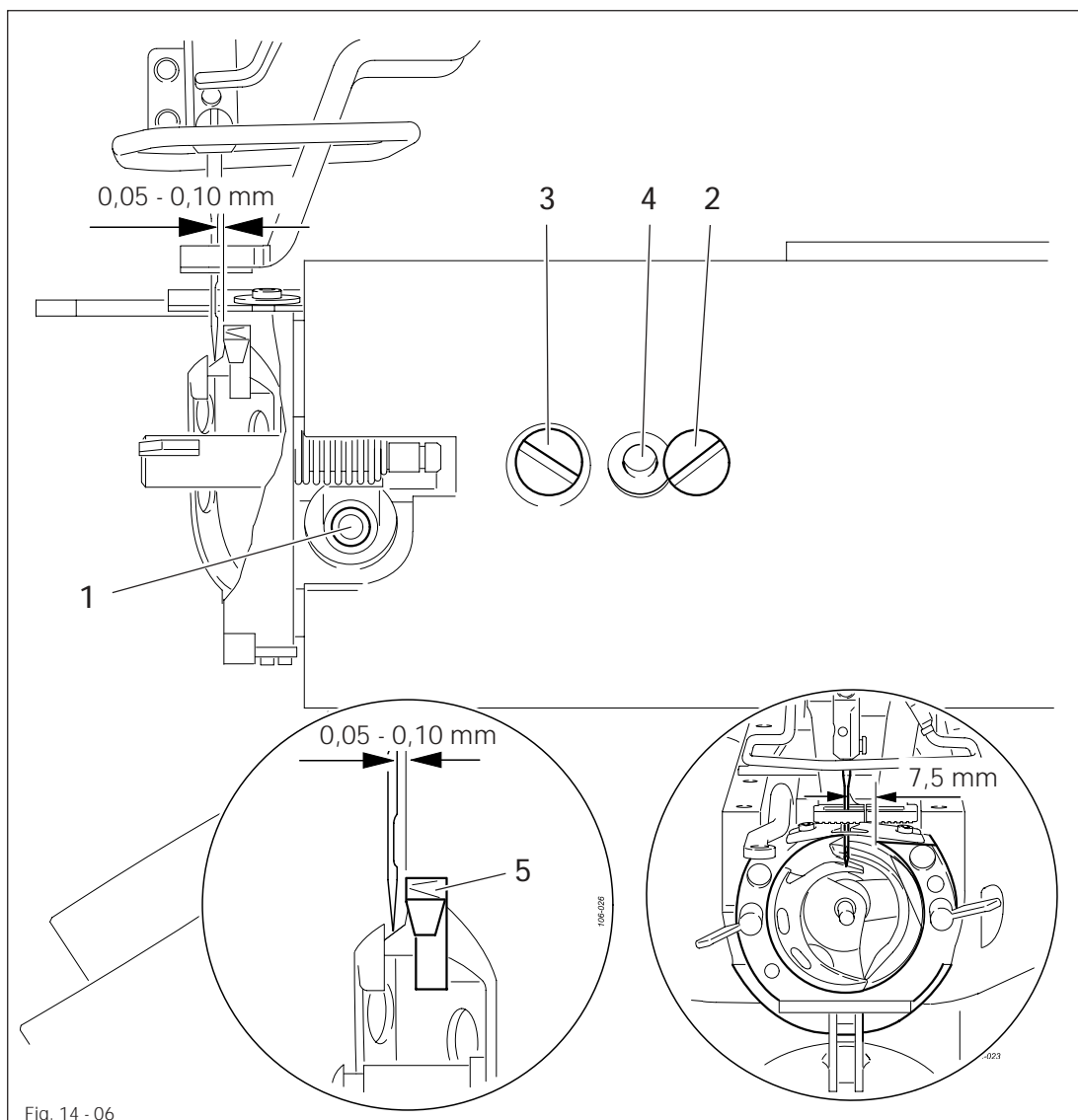
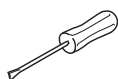


Fig. 14 - 06



- Loosen screws 1, 2 and 3.
- Turn the eccentric pin 4 in accordance with the requirements.
- Tighten screws 2 and 3.



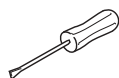
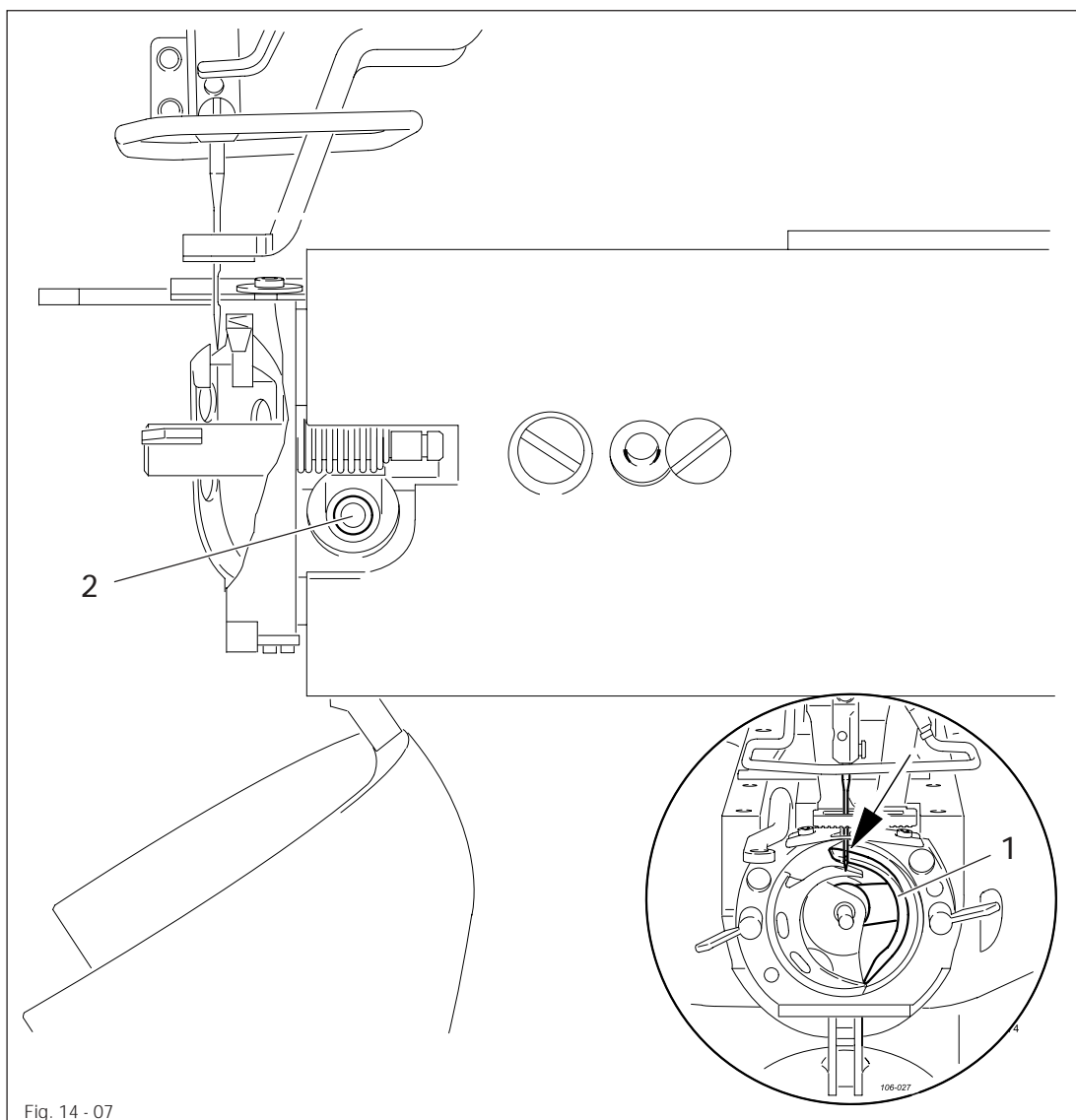
Screw 1 remains loosened for further adjustments.

## 14.11 Needle rise and needle guard

### Requirement

When the bottom marking of the ascending needle bar is level with the lower edge of the needle bar bush

1. the hook point should be centred to the needle and
2. the needle guard (see arrow) should slightly touch the needle.

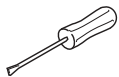
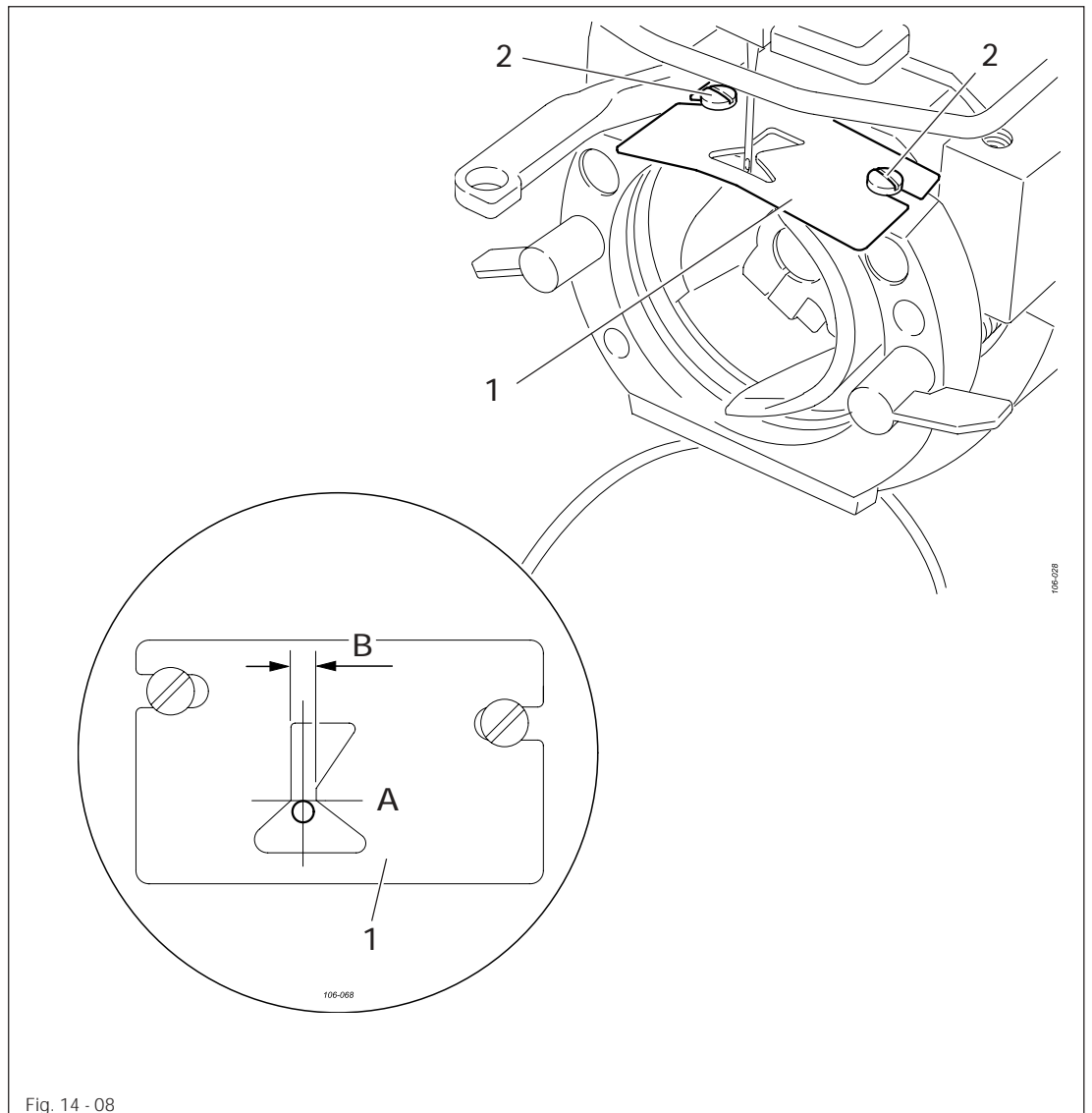


- Turn catch 1 (screw 2) in accordance with requirement 1, or move it in accordance with requirement 2.

## 14.12 Aligning the hook race cover

**Requirement**

The needle should be centred to cutout B and the rear side of the needle flush to the imaginary line A.

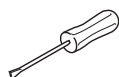
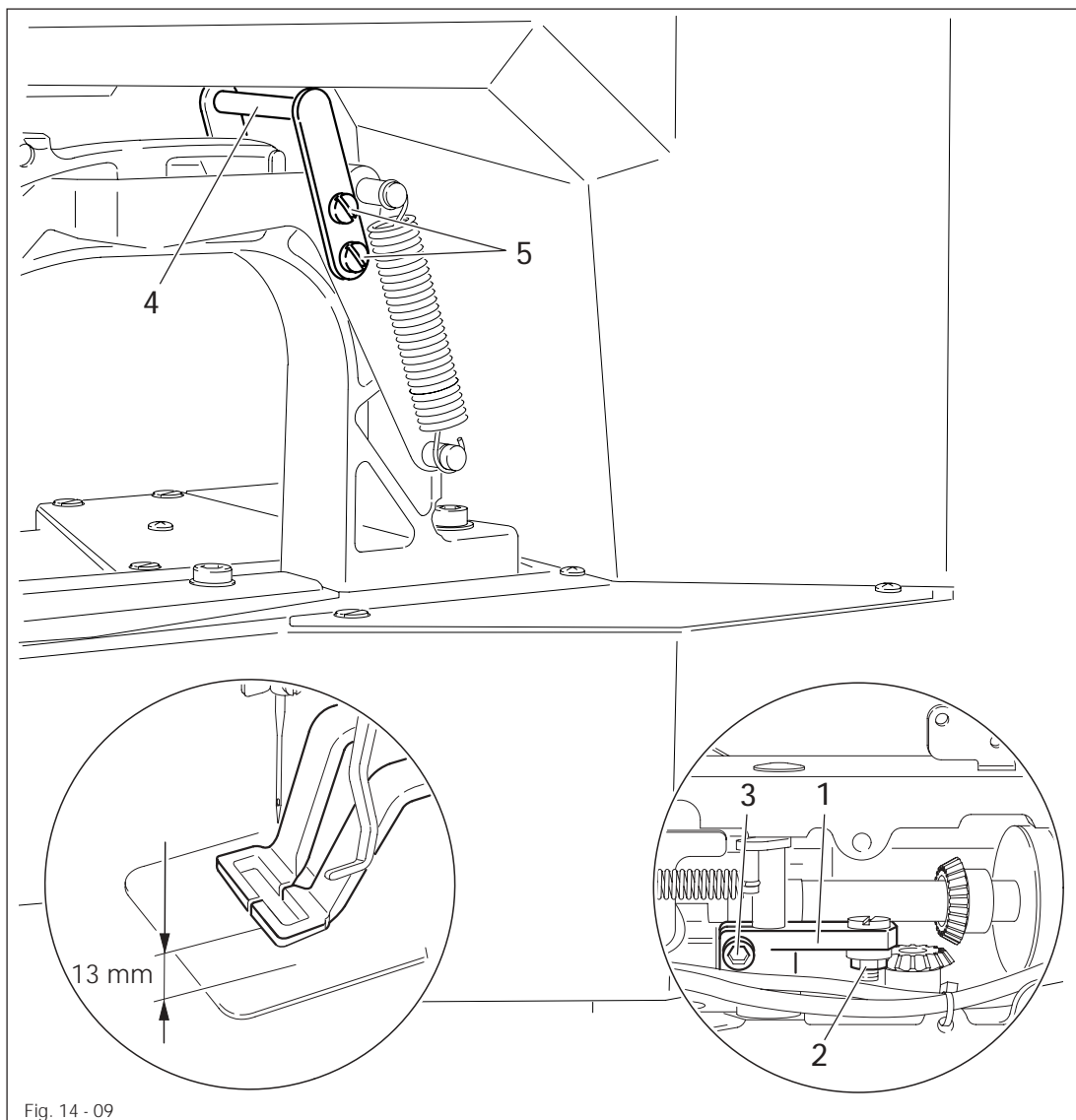


- Move the hook race cover 1 (screws 2) in accordance with the requirement.

## 14.13 Work clamp height

### Requirement

1. The work clamp should be **13 mm** above the upper edge of the needle plate.
2. Both halves of the work clamp should be parallel to each other.



- Turn lever 1 (nut 2 and screw 3) in accordance with **requirement 1**.
- Move lift plate 4 (screws 5) in accordance with **requirement 2**.

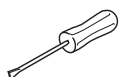
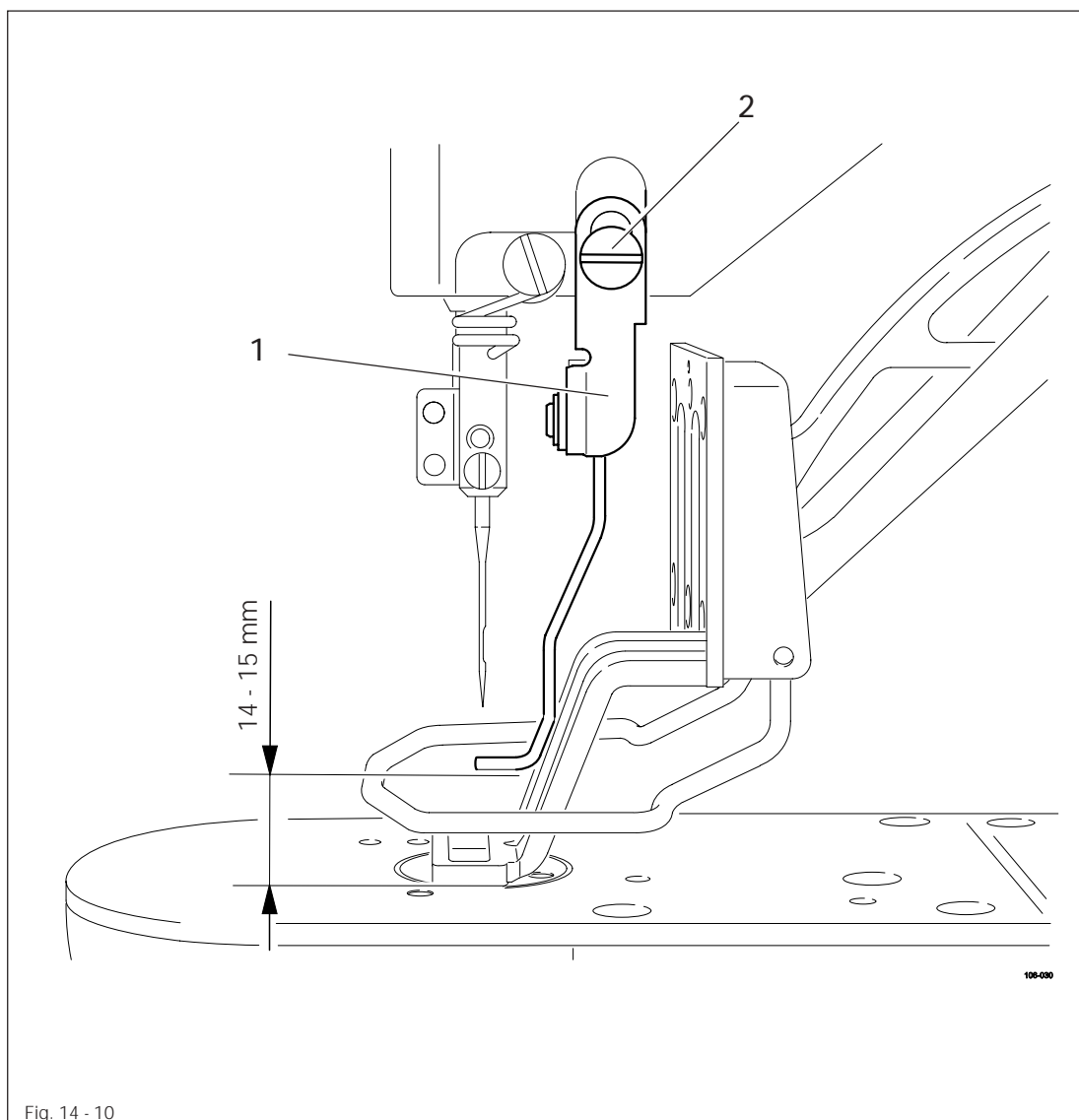


After aligning the work clamp, it is imperative to check the position of the thread wiper, see **Chapter 14.14. Position of the thread wiper!** Danger of needle breakage!

## 14.14 Position of the thread wiper

**Requirement**

When the thread wiper is centred to the needle, its lower edge should be 14 – 15 mm above the upper edge of the needle plate.

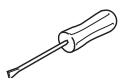
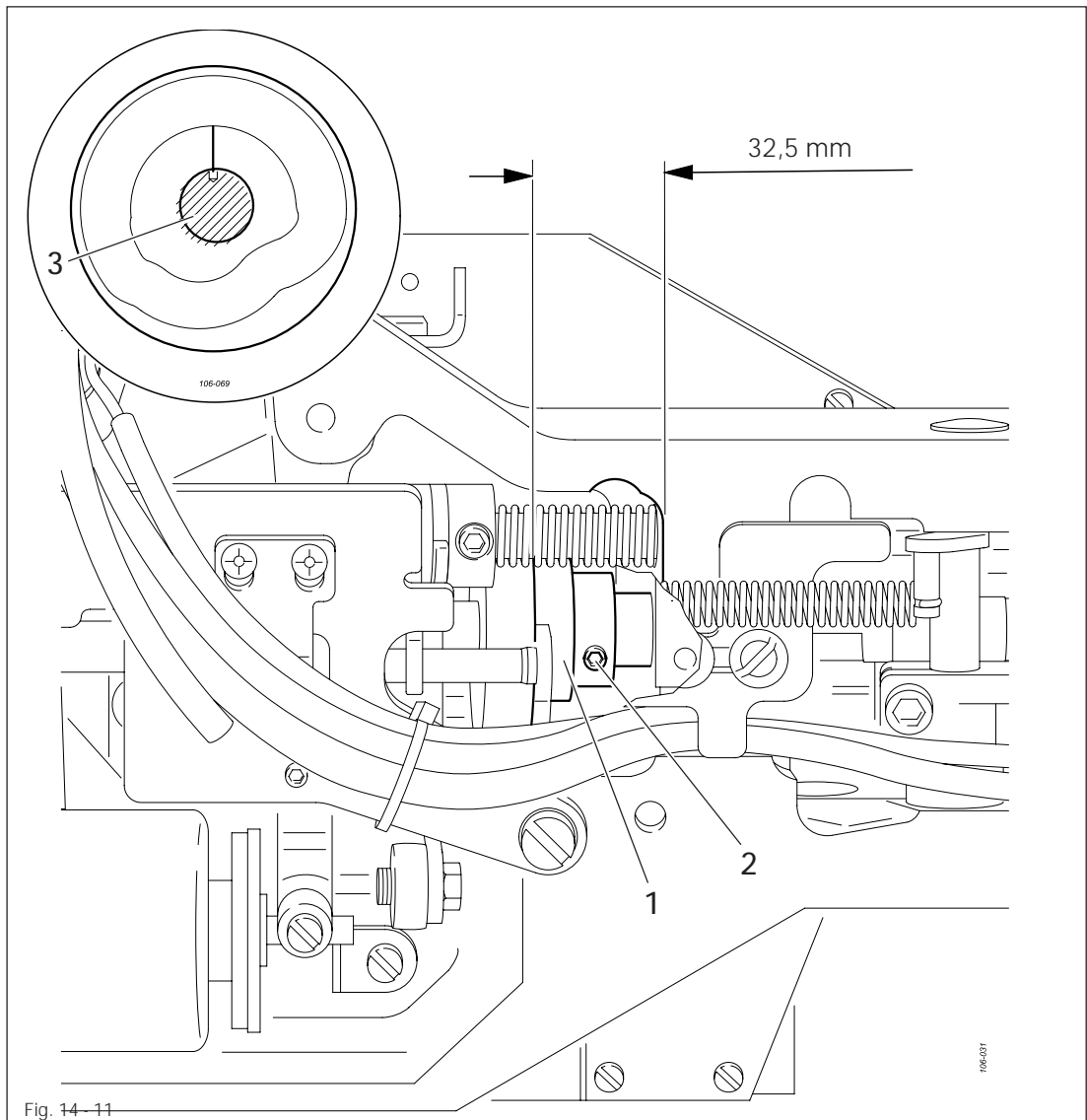


- Bring the thread wiper 1 into the appropriate position by operating the work clamp manually.
- Move thread wiper 1 (screw 2) in accordance with the requirement.

## 14.15 Position of the control cam

### Requirement

1. The markings on control cam 1 and arm shaft 3 should correspond with each other.
2. The outer edge of control cam 1 should be at a distance of 32.5 mm from the metal surface of the case.



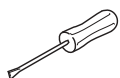
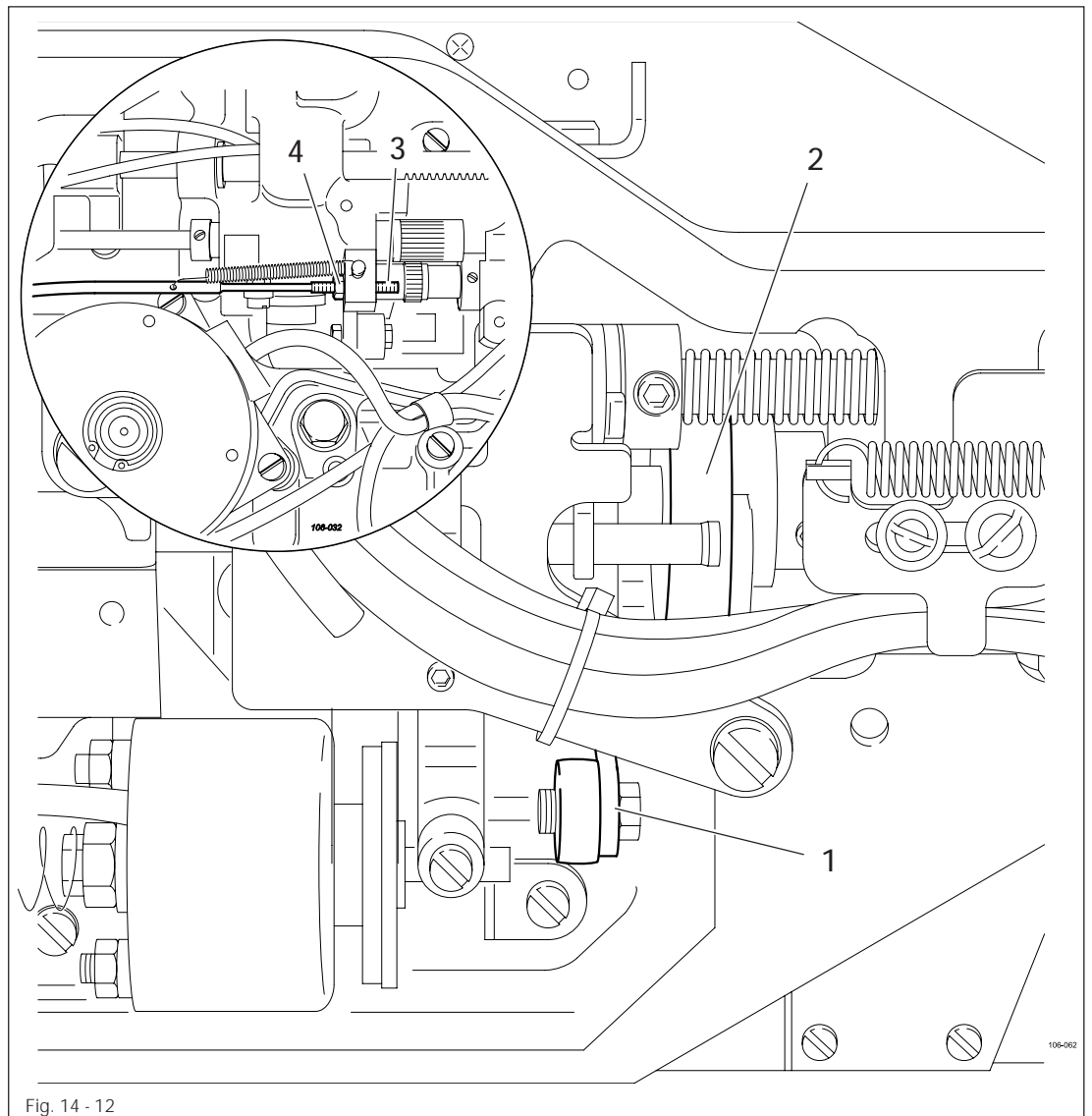
- Turn control cam 1 (screw 2) in accordance with requirement 1, or move it in accordance with requirement 2.



## 14.16 Position of the control roller

**Requirement**

When the needle bar is at its b.d.c., the control roller should be centred to the running path of control cam 2.

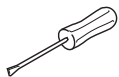
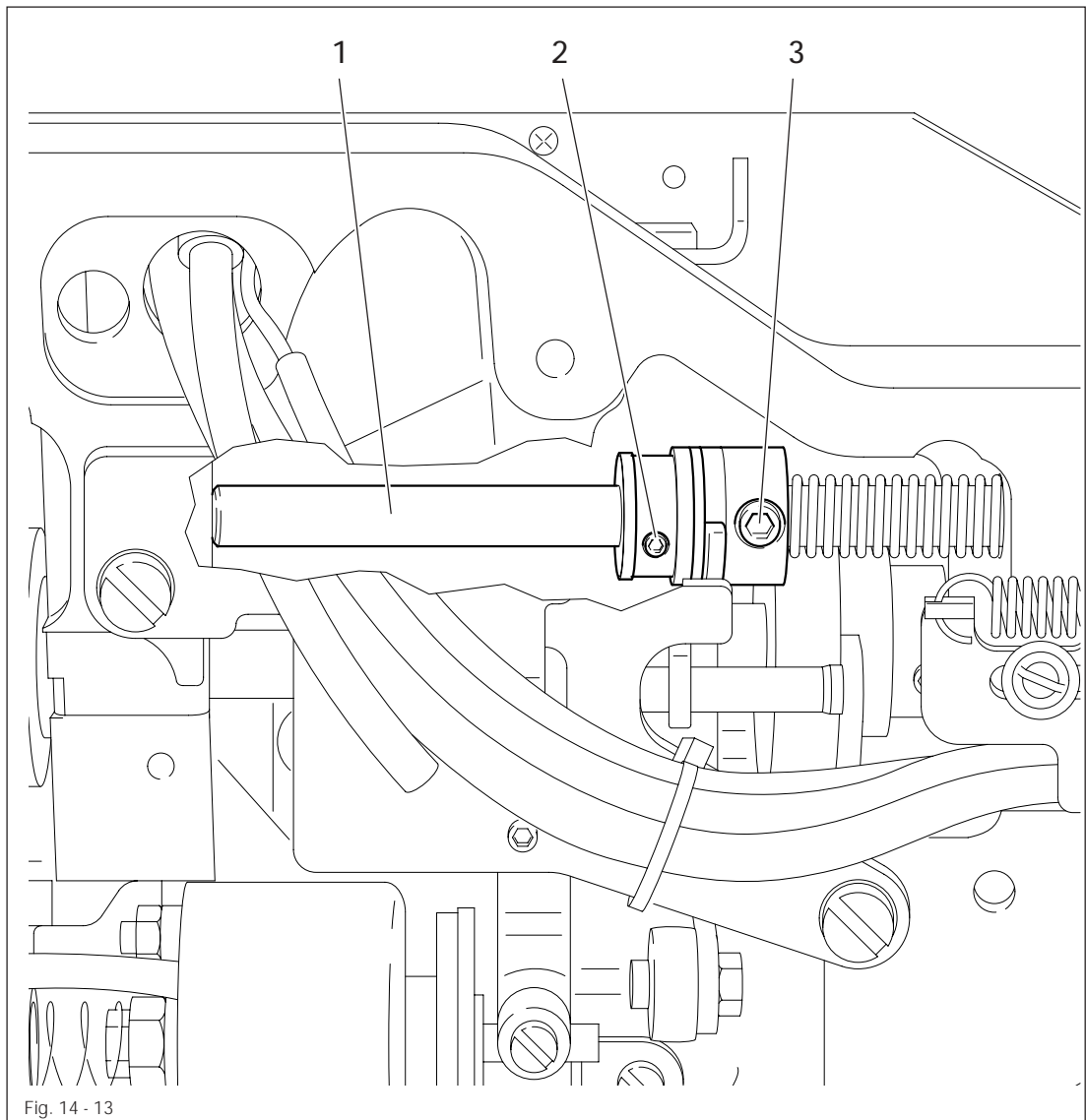


- Turn screw 3 (nut 4) in accordance with the **requirement**.
- For checking purposes, operate lever 1 by hand to let the control roller fall into the running path of control cam 2.

## 14.17 Position of the drive shaft of the thread trimmer

### Requirement

When the thread trimmer is in its basic position, shaft 1 should be flush with the metal edge of the machine case.

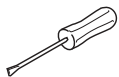
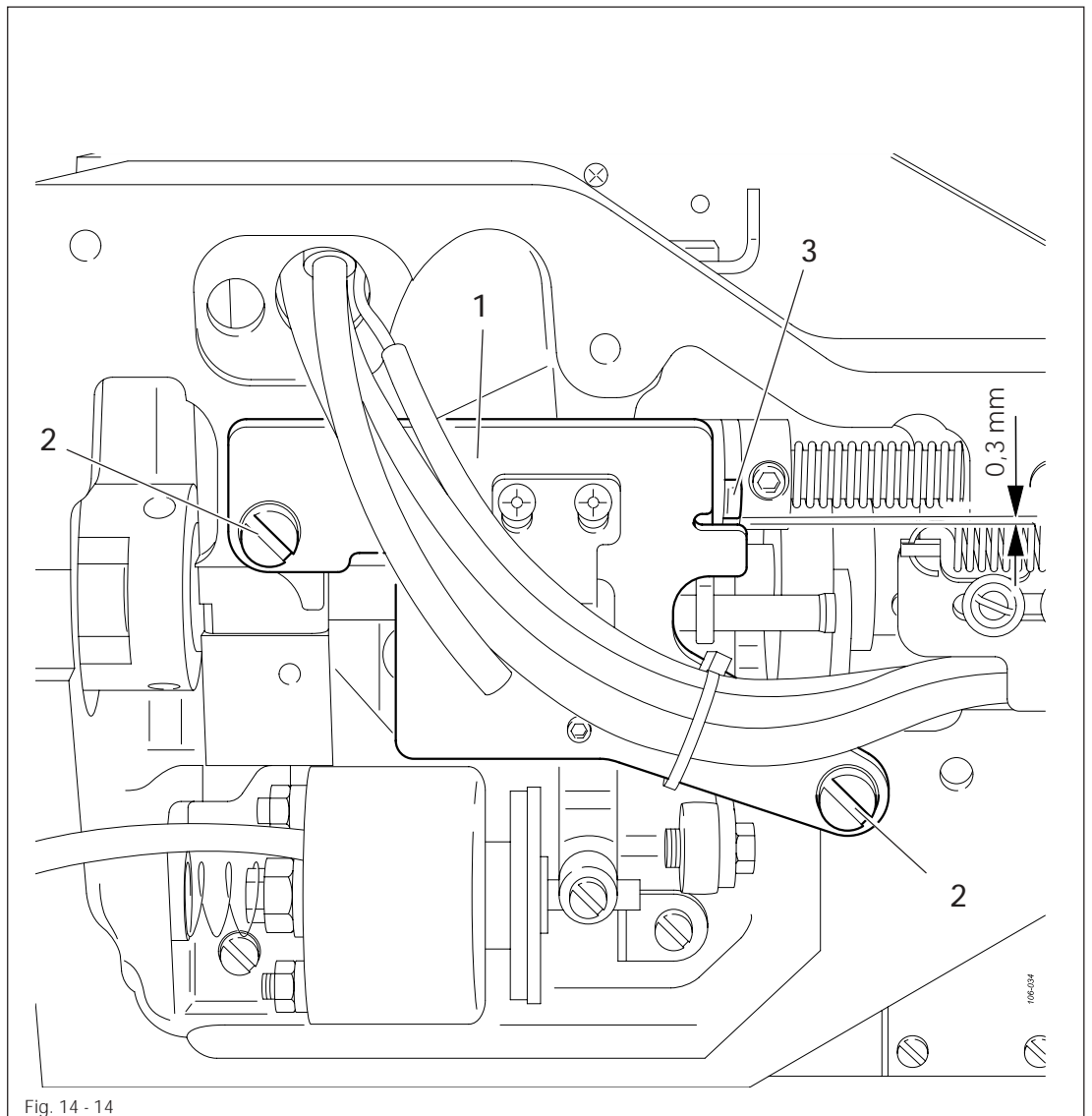


- Move shaft 1 (screws 2 and 3) in accordance with the requirement.

## 14.18 Aligning the stop plate

**Requirement**

When the thread trimmer is in its basic position, there should be a clearance of 0.3 mm between lever 3 and plate 1.

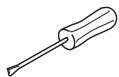
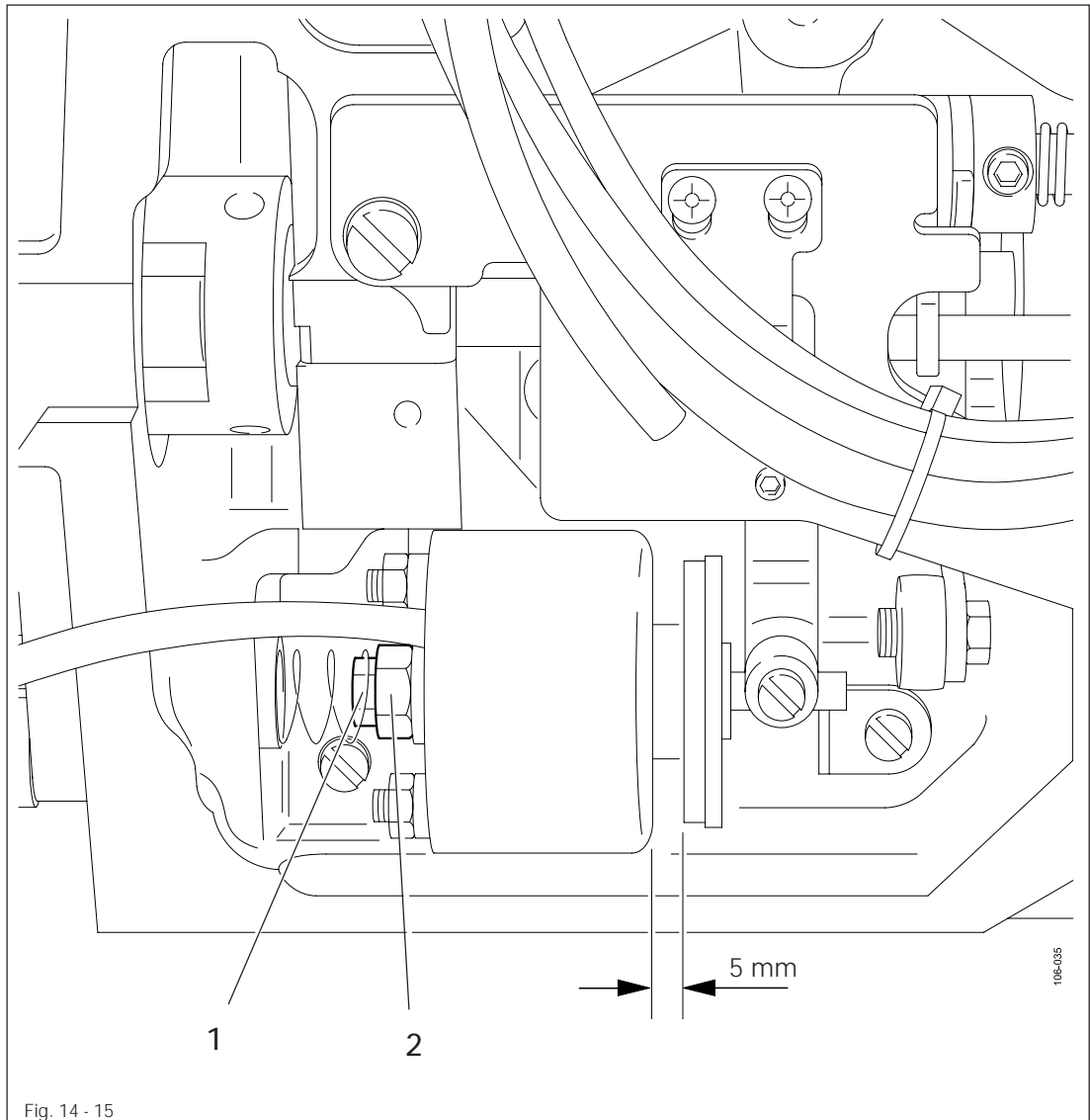


- Move plate 1 (screws 2) in accordance with the requirement.

## 14.19 Adjusting the trimmer solenoid

### Requirement

When the thread trimmer is in its neutral position, solenoid 1 should be at a distance of 5 mm from the case.

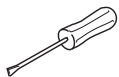
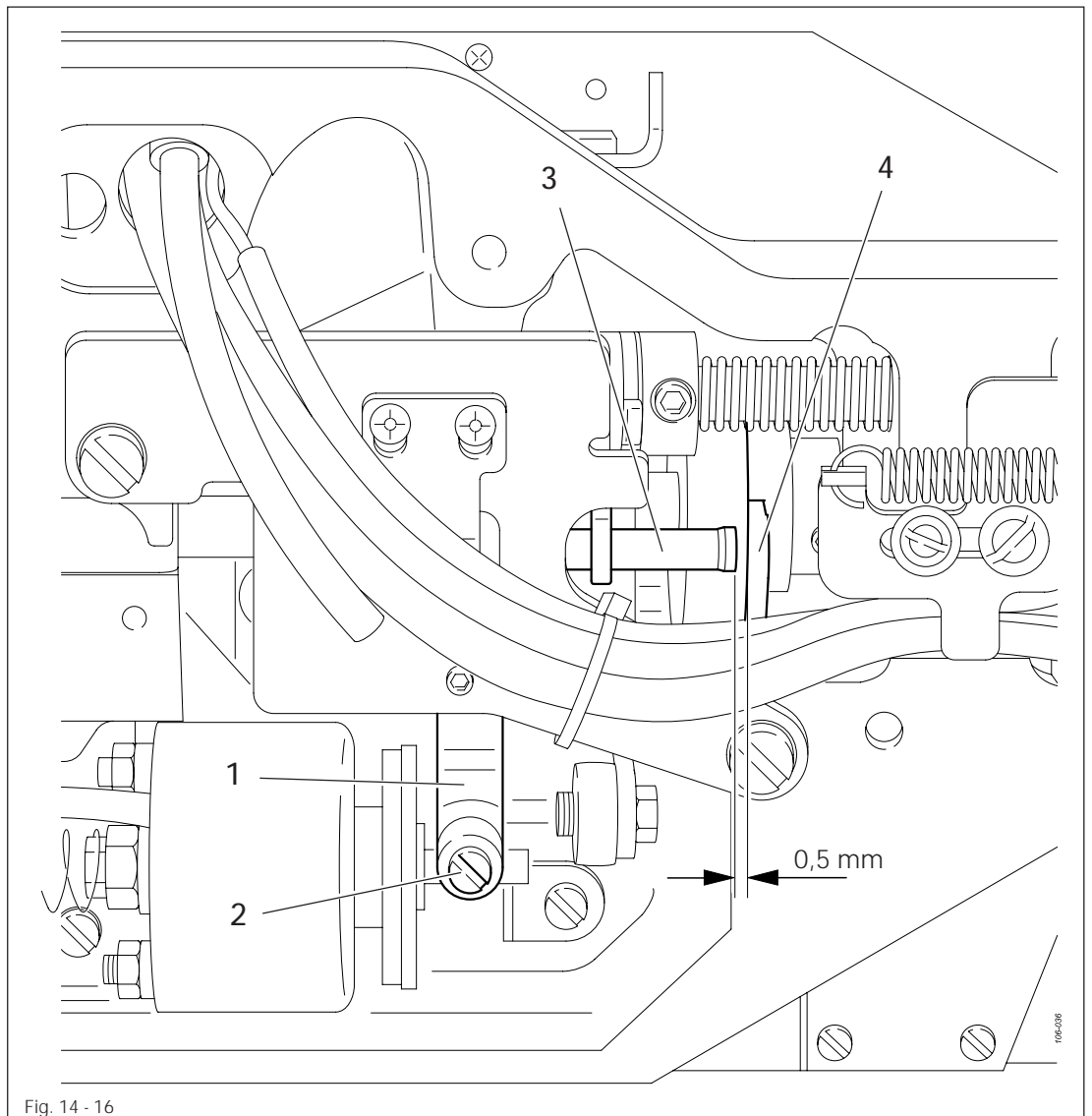


- Turn nut 1 (nut 2) in accordance with the requirement.

## 14.20 Adjusting the engaging lever

**Requirement**

When the thread trimmer is in its neutral position, pin 3 should be at a distance of 0.5 mm from release trip 4.



- Move lever 1 (screws 2) in accordance with the requirement.

## 14.21 Position of the thread catcher and knife

### Requirement

When the machine is in its basic position

1. the tip of the thread catcher **1** should be at a distance of **4.5 mm** from the centre of the needle hole.
2. The blade of knife **3** should be at distance of **0.5 mm** from the needle plate insert.

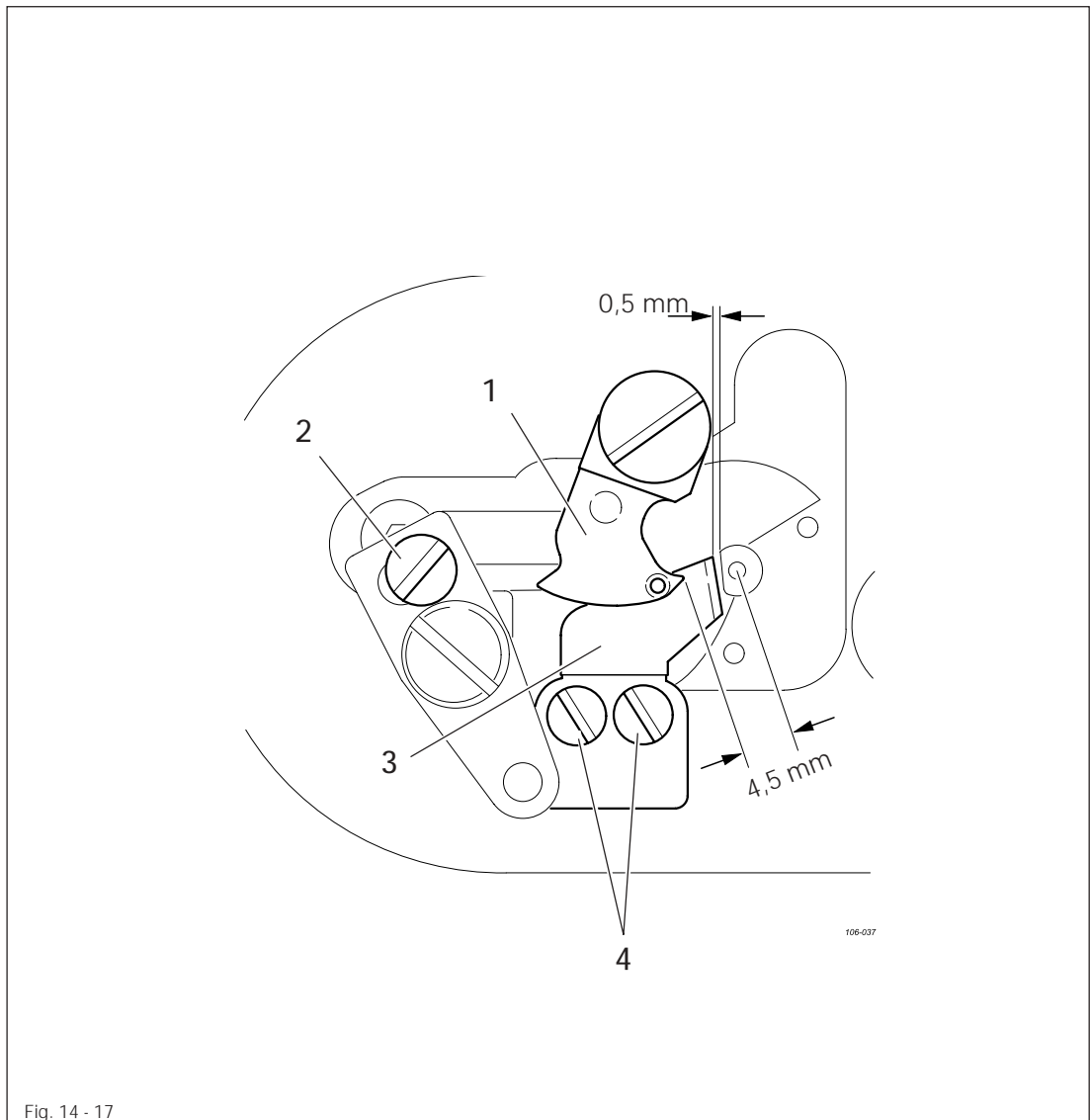
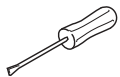


Fig. 14 - 17

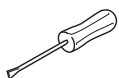
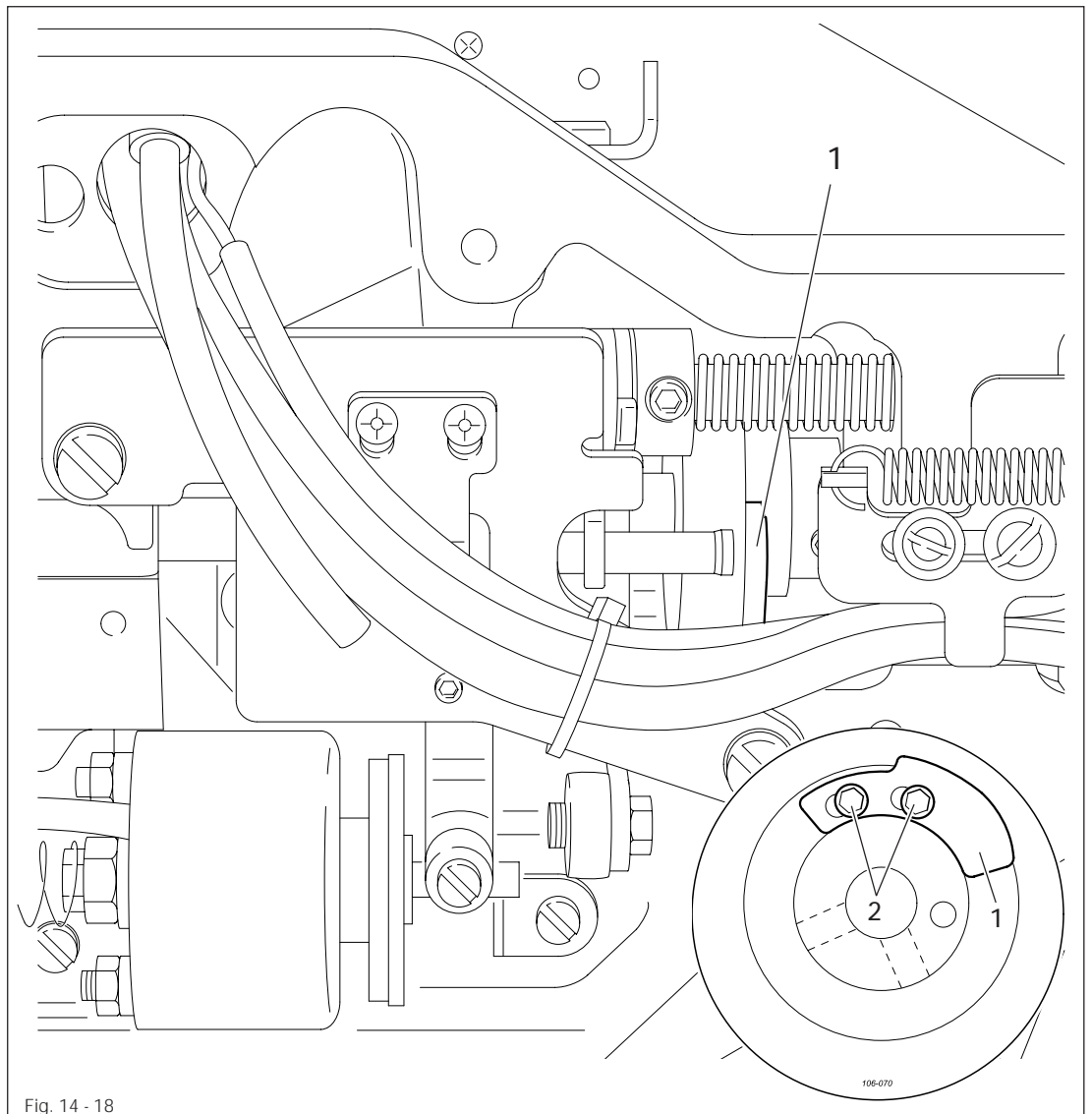


- Adjust thread catcher **1** (screw **2**) in accordance with requirement 1.
- Adjust knife **3** (screws **4**) in accordance with requirement 2.

## 14.22 Position of the release trip

### Requirement

The slots of trip 1 should be touching screws 2 on the right side.



- Move trip 1 (screws 2) in accordance with the requirement.



If the needle thread is too short after trimming, trip 1 can be slightly readjusted.

## 14.23 Position of the release catch

### Requirement

When lever 6 is touching release catch 7, there should be a distance of 0.3 mm between drive lever 5 and pin 1.

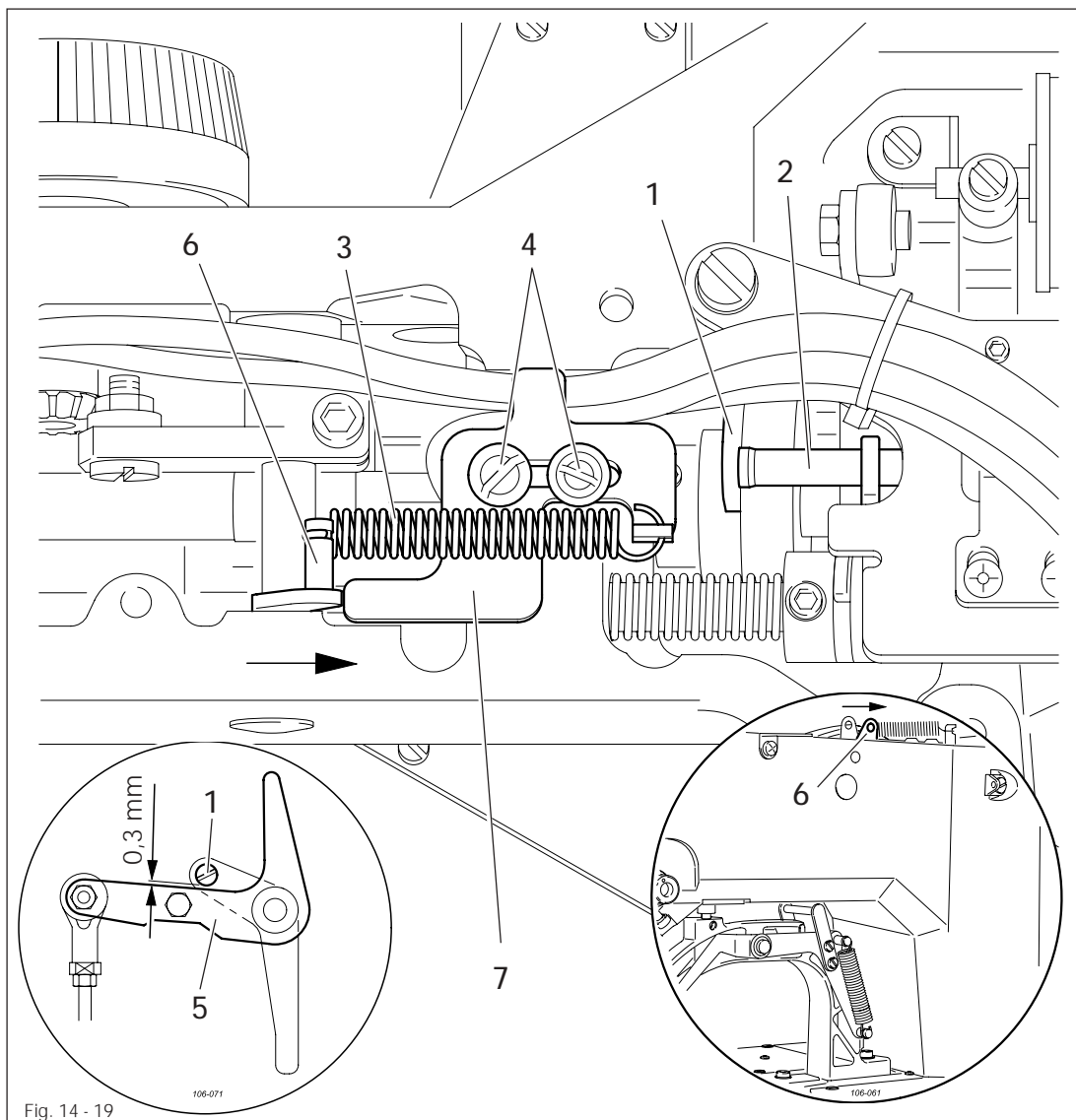
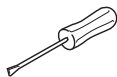


Fig. 14 - 19



- Turn the balance wheel until pin 1 is no longer on the release trip 2.
- Release spring 3 and loosen screws 4.
- In accordance with the requirement, place the feeler gauge between the drive lever 5 and pin 1.
- Push lever 6 lightly in the direction shown by the arrow.
- Move release catch 7 against lever 6 and tighten screws 4.
- Remove the feeler gauge and attach spring 3.



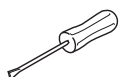
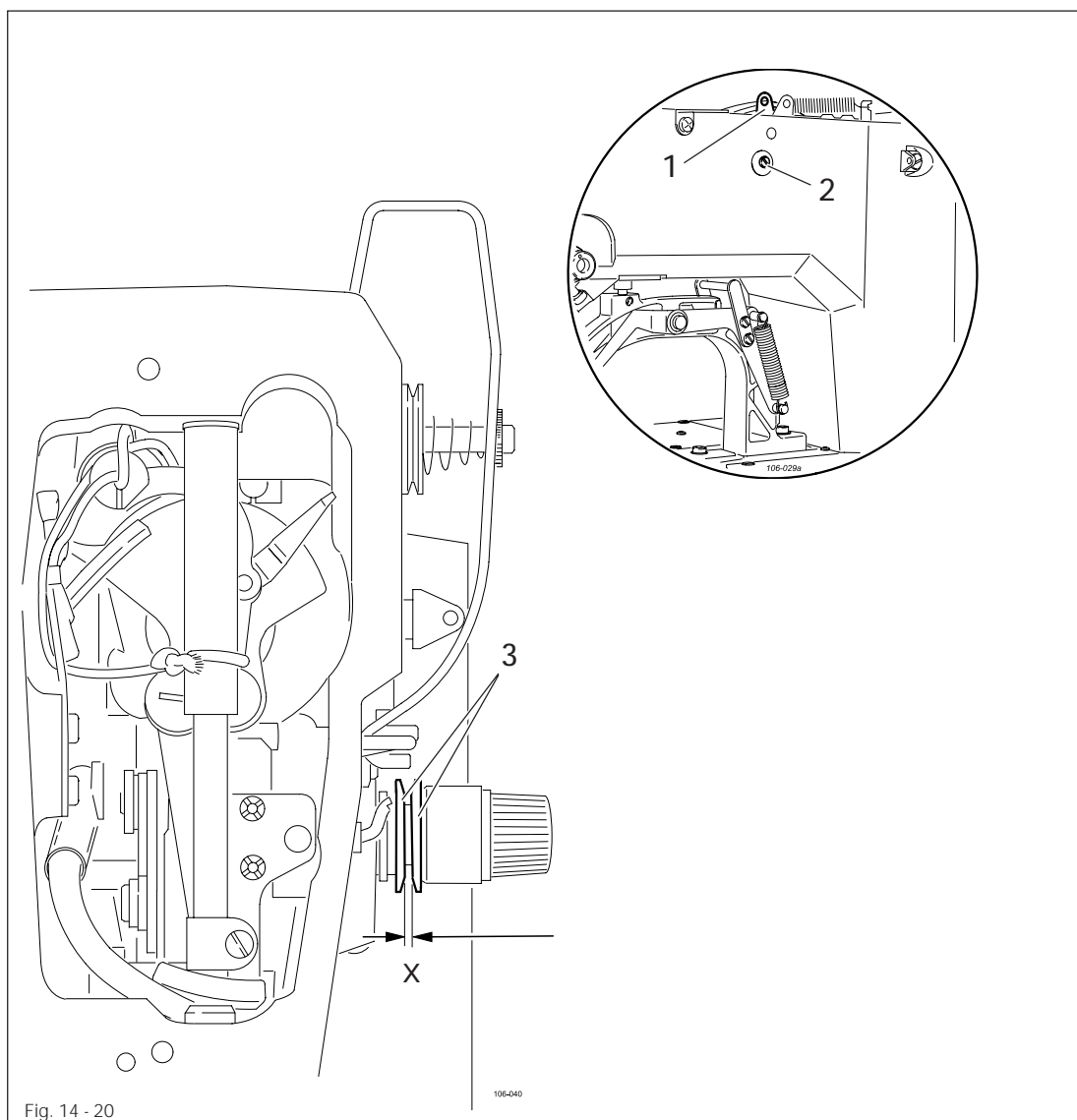
Spring 3 should only be released and attached with suitable tools!  
Danger of injury!



## 14.24 Needle thread tension release

**Requirement**

After thread trimming the distance **X** between tension discs **3** should be **0.6 – 0.8 mm** for normal materials and **0.8 – 1.0 mm** for heavy materials.

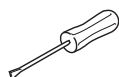
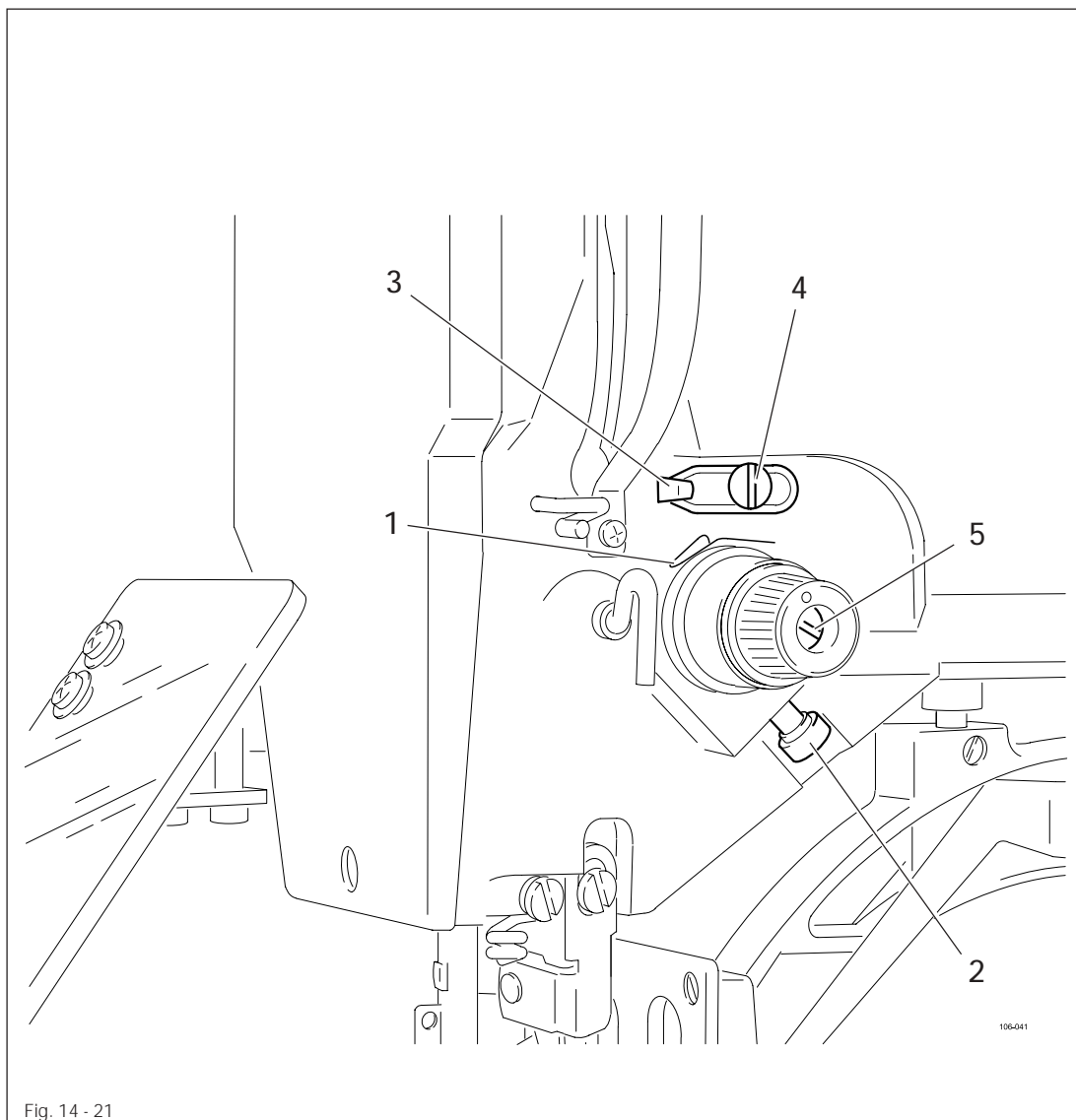


- Bring the machine into the cutting position by hand.
- Move lever 1 (screw 2) in accordance with the requirement.

## 14.25 Thread check spring and thread regulator

### Requirement

1. The thread check spring 1 should have a 6 – 8 mm stroke.
2. Screw 4 should be positioned in the centre of the slot of thread regulator 3.



- Adjust thread check spring 1 (screw 2) in accordance with **requirement 1**.
- Move thread regulator 3 (screw 4) in accordance with **requirement 2**.

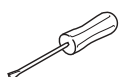
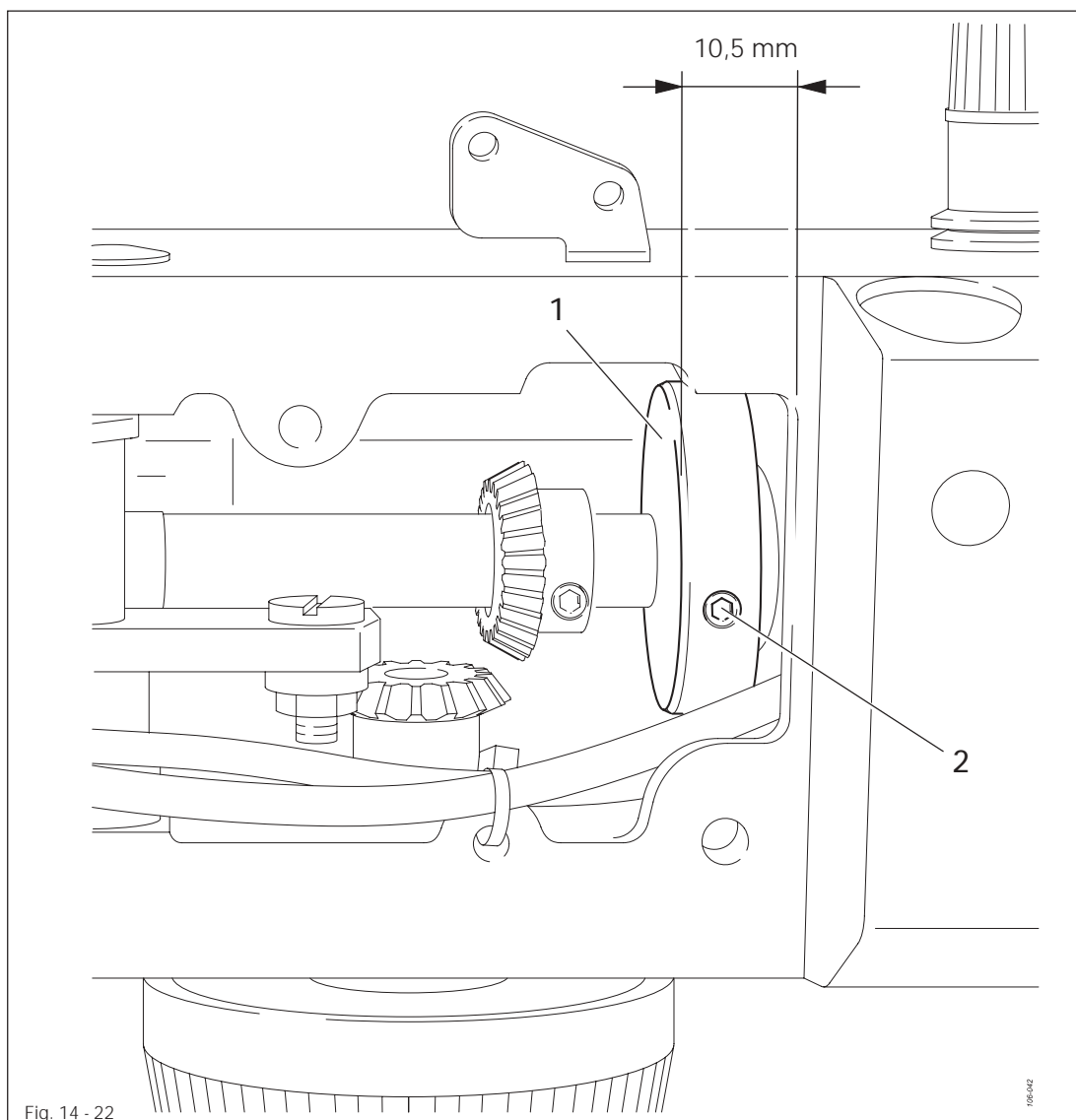


Turn pin 5 to adjust the thread spring resistance. All settings of the thread check spring 1 depend on the material and might have to be corrected to achieve the desired result.

## 14.26 Bobbin winder drive wheel

## Requirement

1. There should be a distance of **approx. 10.5 mm** between drive wheel 1 and the metal edge of the machine case.
2. When the bobbin winder is switched on, its friction wheel should be driven by drive wheel 1. When the bobbin winder is switched off, drive wheel 1 must not touch the friction wheel of the bobbin winder.

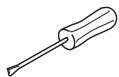
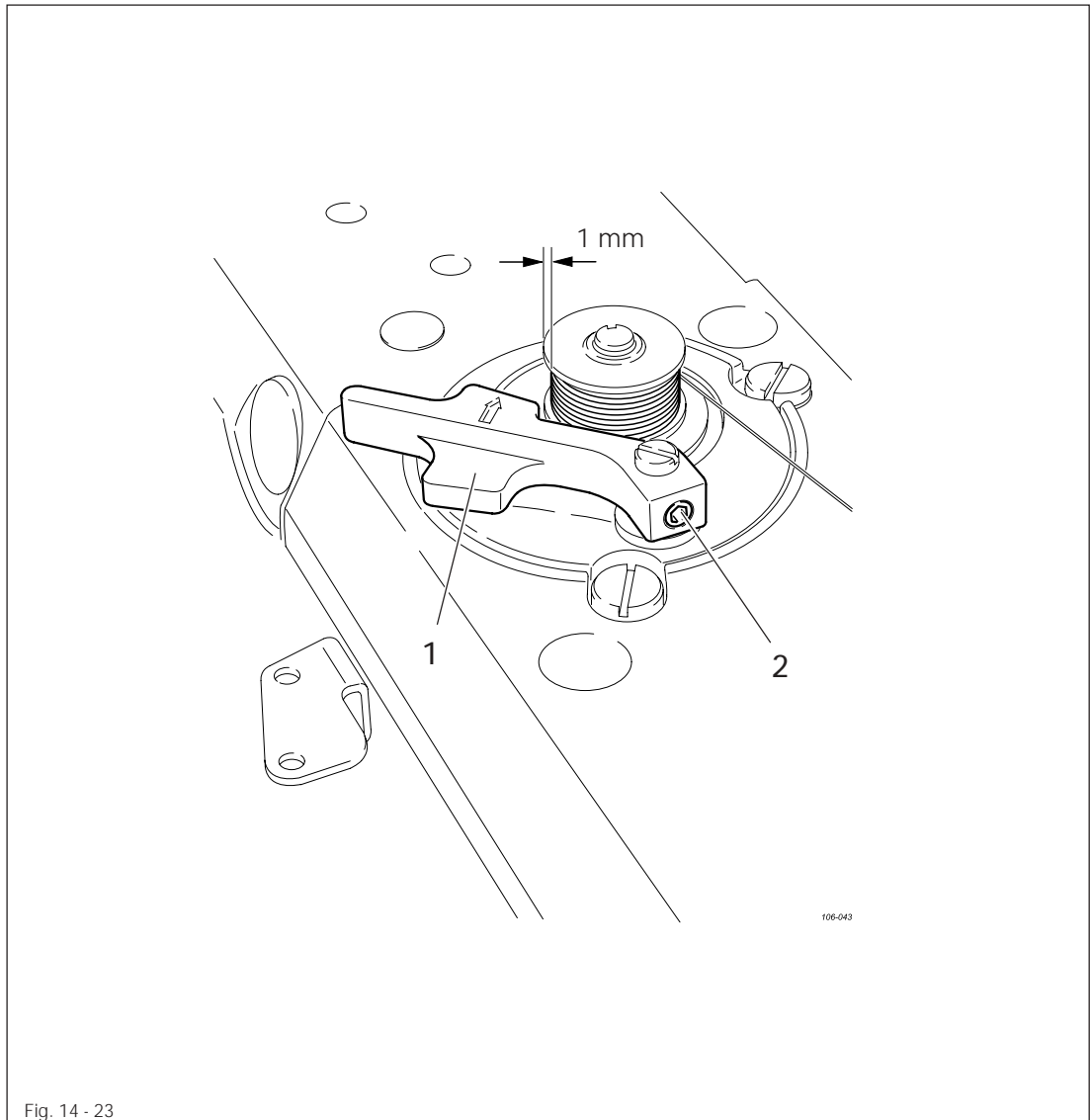


- Adjust drive wheel 1 (screw 2) in accordance with the requirements.

## 14.27 Bobbin winder

### Requirement

The bobbin winder should switch off automatically, when the thread level is about **1 mm** from the edge of the bobbin.

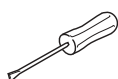
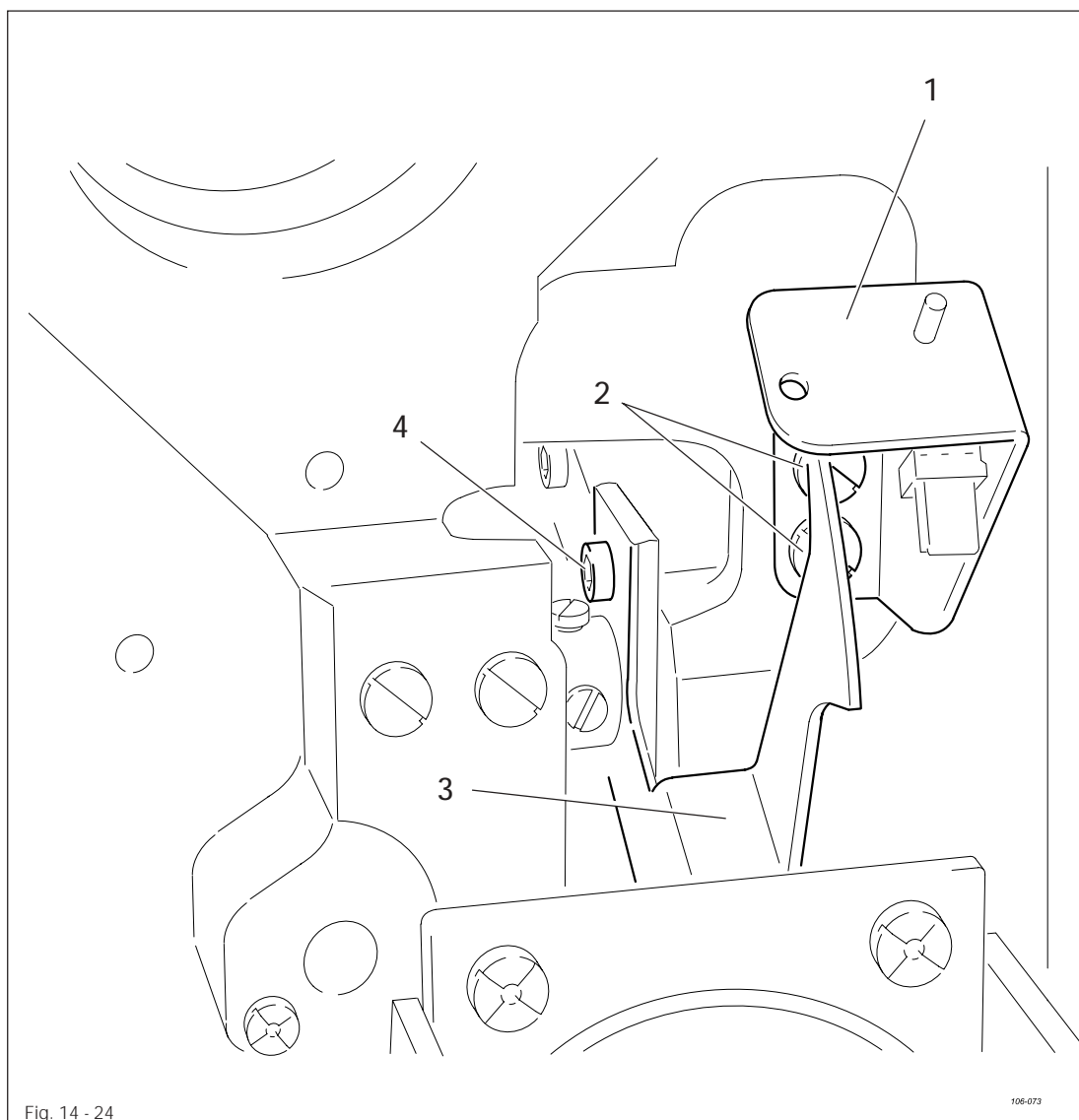


- Turn lever 1 (screw 2) in accordance with the requirement.

## 14.28 Work clamp initiator

**Requirement**

When the work clamp is lowered, the initiator should be actuated (input "3" parameter "601" is in the "Off" position).



- Switch on the machine.
- In the input mode, select parameter "601", see Chapter 11.03 Parameter input in the instruction manual.
- Select input "3" with the corresponding plus/minus key.
- If necessary, enter the access code, see Chapter 11.04.01 Entering the access code in the instruction manual.
- Adjust bracket 1 (screws 2) and switch lug 3 (screws 4) in accordance with the requirement.
- Switch off the machine.

## 14.29 Changing the work clamp

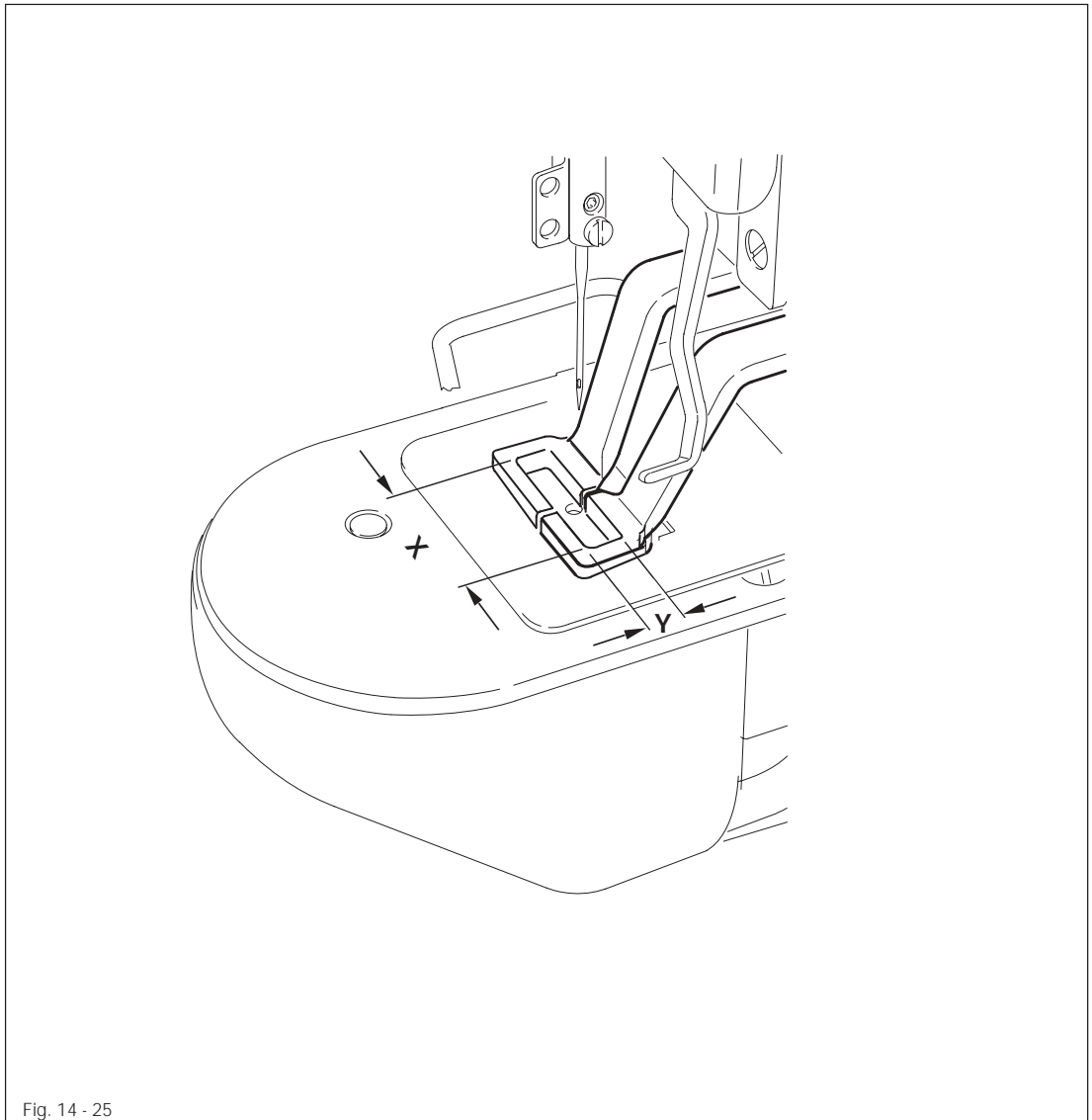


Fig. 14 - 25

- Measure the cutout of the new work clamp in X- and Y-direction.
- Adjust the sewing area size as described in **Chapter 9.07** of the instruction manual.
- Fit the new work clamp and align it in as described in **Chapter 14.07**.
- Select the seam program to match the work clamp cutout (see **Chapter 9.06** of the instruction manual).
- Check the seam program by **tacting** (see **Chapter 7.04** of the instruction manual).



If the actual size of the sewing area differs from the size entered, serious damage can be caused to the machine!

## 14.30 Cold start



When a cold start is carried out, the seam patterns 50 – 99 and all altered parameter settings are deleted! The machine is reset to its condition on delivery, the machine's zero points remain unaffected.

- Switch on the machine.



- Select parameter "607" with the corresponding **plus/minus** keys.

- If necessary, enter the code, see **Chapter 11.04.01 Entering the access code** in the instruction manual.



- With the corresponding **plus/minus** key carry out the reset operation.
- Switch the machine off and on again after approx. 3 seconds.

## 14.31 Internet update of the machine software

The machine software can be updated with PFAFF flash programming. For this purpose the PFP boot program and the appropriate control software for the machine type must be installed on a PC. To transfer the data to the machine, the PC and the machine control unit must be connected with an appropriate null modem cable (part no. 91-291 998-91).



The PFP boot program and the control software of the machine type can be downloaded from the PFAFF-homepage using the following path:  
[www.pfaff-industrial.com/de/service/download/steuerungssoftware.html](http://www.pfaff-industrial.com/de/service/download/steuerungssoftware.html)

To update the machine software carry out the following steps:



While the machine software is being updated, no setting up, maintenance or adjustment work may be carried out on the machine!

- Switch off the machine.
- Connect the PC (serial interface or appropriate USB-adapter) and the machine control unit (RS232). To do so disconnect the plug of the control panel.

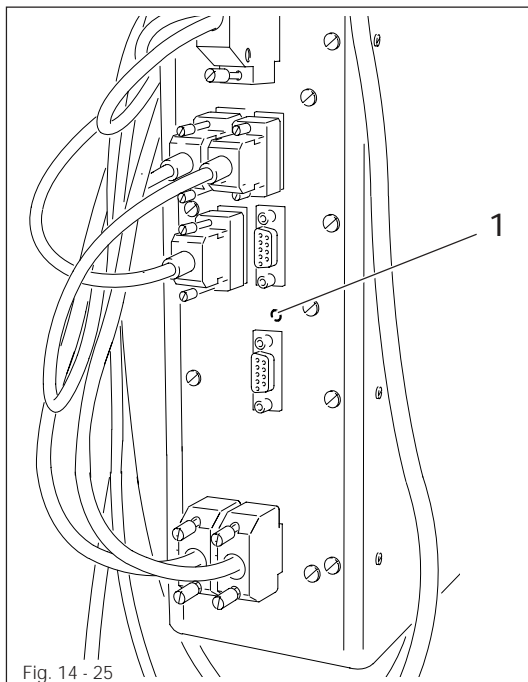


Fig. 14 - 25

- Switch on the PC and start the PFP boot program.
- Select the machine type.
- Press the "programming" button.
- Switch on the machine, keeping the boot key 1 pressed.
- Press the "OK" button.  
The software update is carried out, the update progress is shown on the bar display of the PFP boot program.
- When the update has been completed, switch off the machine and end the PFP boot program.
- End the connection between the PC and the machine control unit and reconnect the control panel to the machine control unit.

- Switch on the machine.  
A plausibility control is carried out and, if necessary, a cold start.



More information and assistance is at your disposal in the file "PFPHILFE.TXT", which can be called up from the PFP boot program by pressing the "help" button.



## 14.32 List of parameters

Group	Parameter	Description	Setting range	Set value
000	001	<b>Maximum speed</b> This parameter is used to fix the max. sewing speed (upper limit).	200 – 2700	2700
	002	Sewing speed for start stitches With this parameter the speeds for the 5 start stitches are fixed.		
		Speed (spm) for start stitch no. 1	200 – 2700	400
		Speed (spm) for start stitch no. 2	200 – 2700	900
		Speed (spm) for start stitch no. 3	200 – 2700	2700
		Speed (spm) for start stitch no. 4	200 – 2700	2700
	Speed (spm) for start stitch no. 5	200 – 2700	2700	
	003	<b>Locking/releasing seam patterns</b> This parameter is used to release (ON) or lock (OFF) the individual seam patterns (0 to 99) to be carried out in the sewing mode.	ON – OFF	
004	<b>Switch bobbin thread counter on/off</b> <b>Standard value (pieces per bobbin)</b> In the sewing mode, the bobbin thread counter counts the pieces sewn backwards from the standard value. If the bobbin thread counter is switched on, in the sewing mode a signal is given when the value 0 is reached.	ON – OFF 1 - 9999	ON 1000	
006	<b>Reversing after thread trimming</b> <b>Reverse position [°]</b> With this parameter it is possible to switch the automatic reversing function after thread trimming on or off. If the reversing function is switched on, the reverse position can be set by turning the balance wheel. The access code is necessary for this adjustment.	ON – OFF 0 – 45	ON 11	
007	<b>Starting point = scale reference point</b> With this parameter it is possible to choose whether the scale reference point is the starting point (ON) or the zero point (OFF).	ON – OFF	OFF	
008	<b>Speed for the "winding" function</b> This parameter is used to fix the speed for the winding operation.	200 2700	1000	

Group	Parameter	Description	Setting range	Set value
000	009	<b>Via zero point to starting point after end of sequence</b> With this parameter it is possible to choose that, after the end of the sequence, the X-, Y-drive moves to the seam starting point via the reference initiators.	ON –OFF	OFF
	010	<b>Via zero point to starting point after number of program cycles</b> <b>Number of program cycles</b> With this parameter it is possible to choose that, after a certain number of program cycles, the X-, Y-drive moves to the seam starting point via the reference initiators.	ON –OFF 1 - 100	OFF
	011	<b>Pedal mode</b> Switchover between level mode (0) and flip flop mode (1).	0 – 1	0
	013	<b>NIS "needle in material" [°]</b> This parameter is used to set the NIS signal. If the function is executed, the position can be entered by turning the balance wheel. If the position is altered, the result is a change in the point of time when the carriage is moved. The access code is necessary for this adjustment.	65 – 166	107
	014	<b>Thread trimming speed [min-1]</b> This parameter is used to fix the speed for thread trimming.	100 – 700	200
	015	<b>Reduced current for stepping motors</b> The reduction function of the holding current at rest with closed work clamp is switched on or off.	ON – OFF	ON
	016	<b>Key tone</b> The key tone, as reaction to a key on the control panel being pressed, is switched on or off. The double tone for incorrect inputs always remains switched on.	ON – OFF	ON

Group	Parameter	Description	Setting range	Set value
000	017	<b>Clamp solenoid Operating time [10 ms]</b> The time, for which the solenoid is under full current, is entered.	5 – 100	20
	018	<b>Clamp solenoid duty-cycle [%]</b> At the end of the clamp solenoid operating time (Parameter "017") the solenoid is clocked. The relationship between duration of operation and non-operation is entered here.	5 – 100	25
	019	<b>Thread trimming solenoid operating time [10 ms]</b> The time, for which the solenoid is under full current, is entered.	5 – 100	25
	020	<b>Thread trimming solenoid duty-cycle</b> At present without a function		
	021	<b>Thread take-up lever t.d.c. [°]</b> The position for the t.d.c. thread take-up lever is entered here. If the function is executed, the position can be set by turning the balance wheel. The access code is necessary for this adjustment.	45 – 53	51
	022	<b>Thread trimming position (in relation to t.d.c. needle) [°]</b> The position, at which the thread trimming solenoid is switched on, is entered here. The adjustment is set by turning the balance wheel. The access code is necessary for this adjustment.	180 – 253	180
	023	<b>Sewing area size X [1/10 mm]</b> To avoid mechanical collisions, the sewing area size of the clamp in use is entered. The control unit checks the path and, if necessary, issues an error message.	10 – 400	200
	024	<b>Sewing area size Y [1/10 mm]</b> To avoid mechanical collisions, the sewing area size of the clamp in use is entered. The control unit checks the path and, if necessary, issues an error message.	10 – 200	30

Group	Parameter	Description	Setting range	Set value
100	101	<b>Software version main processor</b> The software version of the main processor is displayed		
	102	<b>Software version sewing drive unit</b> The software version of the sewing drive module is displayed.		
	103	<b>Software version control panel</b> The soft- and hardware version of the control panel are displayed.		
600	601	<b>Display inputs</b> With this function the digital inputs can be checked. "IN" shows the input numbers (1 – 16). Under "VAL" the respective switch status is displayed.  IN            VAL 1            IN1,        programmable input 1 2            IN2,        programmable input 2 3            E3,         work clamp raised 4 5 6 7 8 9 10 11 12 13 14 15 16		
	602	<b>Display special inputs</b> With this function it is possible to check the special inputs pedal, reference X (SM1) and reference Y (SM2). "IN" shows the inputs (PED, REFX, REFY). Under "VAL" the respective switch status is displayed. IN            VAL PED         Pedal (speed control unit -1; 0; +1; 2) REFX        Reference input X REFY        Reference input Y		

Group	Parameter	Description	Setting range	Set value																																																			
600	603	<p><b>Connect outputs</b>            With this function the outlets can be connected. "OUT" shows the outlet selected (1-16). Under "VAL" the selected output is set (S) with the plus/minus key (+), and reset (R) with the plus/minus key. Interlocks are checked. Non-assigned outlets are not connected.</p> <table border="0"> <tr> <td>OUT</td> <td>VAL</td> <td></td> </tr> <tr> <td>1</td> <td>S/R</td> <td>Solenoid for work clamp open</td> </tr> <tr> <td>2</td> <td>S/R</td> <td></td> </tr> <tr> <td>3</td> <td>S/R</td> <td>Solenoid for thread trimming</td> </tr> <tr> <td>4</td> <td>S/R</td> <td></td> </tr> <tr> <td>5</td> <td>S/R</td> <td></td> </tr> <tr> <td>6</td> <td>S/R</td> <td>Program outlet</td> </tr> <tr> <td>7</td> <td>S/R</td> <td>Program outlet</td> </tr> <tr> <td>8</td> <td>S/R</td> <td></td> </tr> <tr> <td>9</td> <td>S/R</td> <td></td> </tr> <tr> <td>10</td> <td>S/R</td> <td></td> </tr> <tr> <td>11</td> <td>S/R</td> <td></td> </tr> <tr> <td>12</td> <td>S/R</td> <td></td> </tr> <tr> <td>13</td> <td>S/R</td> <td></td> </tr> <tr> <td>14</td> <td>S/R</td> <td></td> </tr> <tr> <td>15</td> <td>S/R</td> <td></td> </tr> <tr> <td>16</td> <td>S/R</td> <td></td> </tr> </table>	OUT	VAL		1	S/R	Solenoid for work clamp open	2	S/R		3	S/R	Solenoid for thread trimming	4	S/R		5	S/R		6	S/R	Program outlet	7	S/R	Program outlet	8	S/R		9	S/R		10	S/R		11	S/R		12	S/R		13	S/R		14	S/R		15	S/R		16	S/R			
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	604	<p><b>Move stepping motors</b>             The stepping motors SM1 (X-axis) and SM2 (Y-axis) are moved individually with the respective plus/minus keys. Interlocks are not checked.</p>																																																					
	605	<p><b>Turn sewing motor</b>            The sewing motor can be operated with a selectable set speed by pressing the pedal. After the sewing motor has been started, the current speed is also displayed.</p>																																																					
	606	<p><b>Thread trimming sequence</b>            The sequence for a complete thread trimming cycle is started with the plus/minus key (+) below CUT and below THR.</p>																																																					

Group	Parameter	Description	Setting range	Set value
600	607	<p><b>Cold start (RESET)</b>            With this function the control unit carries out a cold start (RESET) with which the data is reset. After this function has been selected, the machine must be switched off and then on again.</p>		
	608	<p><b>Setting zero points</b>            With this function and the adjustment gauge, the zero points for the X/Y-drive unit can be set. (stepping motor correction values for the reference points REFX, REFY). The access code is required for this adjustment.</p>		
	609	<p><b>Setting the clamp centre X</b>            This function is used to set the centre of the clamp in X-direction. When entering the function, the machine moves to the current clamp centre, after which it is possible to move to the right or left edge of the clamp, depending on the set limits (param. "023"). A correction can be made with the plus/minus keys. The relocation value is displayed.</p>		
	610	<p><b>Setting the clamp centre Y</b>            This function is used to help set the centre of the clamp in Y-direction. After entering this function, the machine moves to the current clamp centre, after pressing a key to the front or the rear limit (param. "024"). The clamp must be shifted manually.</p>		
	611	<p><b>Automatic clamp opening off</b>            With this function the automatic opening of the clamp after thread trimming can be switched off. After the machine has been switched off, the automatic clamp opening function is always activated.</p>	ON - OFF	

Group	Parameter	Description	Setting range	Set value
700		These parameters influence the control of the sewing motor and should only be altered by appropriately instructed persons.		
	701	P-quota speed controller	1 – 50	10
	702	I-quota speed controller	0 – 100	35
	703	P-quota position controller	1 – 50	30
	704	D-quota position controller	1 – 100	25
	705	Time for position controller	0 – 100	25
	706	P-quota position controller for rest brake	1 – 50	25
	707	D-quota position controller for rest brake	1 – 50	15
	708	Maximum moment for rest brake	0 – 100	5
	709	Minimum machine speed	2 – 64	2
	710	Maximum machine speed	1 – 35	27
	711	Maximum motor speed	1 – 35	27
	712	Positioning speed	2 – 40	30
	713	Acceleration ramp	1 – 50	35
	714	Brake ramp	1 – 50	30
	715	Reference position (NIS)	1 – 127	38
	716	Time-out	0 – 255	40
	717	Starting current motor	3 – 10	6
	718	Anti-vibration filter	1 – 10	3
	719	Logical rotation direction allocation	0 – 255	255
	720	NIS – deformation flag position	0 – 127	64
	721	High level motor configuration	0 – 255	1
	722	not assigned		0
	723	not assigned		0
	724	not assigned		0

## Adjustment

Group	Parameter	Description	Setting range	Set value
700	725	not assigned		0
	726	not assigned		0
	727	not assigned		0
	728	not assigned		0
	729	not assigned		0
	730	not assigned		0
800		The function groups and the functions Programming the Function Keys P, P1-P8 and C1-C3 can be released for manipulation (ON) or locked (OFF). If a function group is suppressed, its parameters cannot be changed until a valid access code has been entered. Once a valid access code has been entered, the suppression is cancelled until the machine is switched off.		
	801	Right of access function group 000	ON – OFF	ON
	802	Right of access function group 100	ON – OFF	ON
	807	Right of access function group 600	ON – OFF	OFF
	808	Right of access function group 700	ON – OFF	OFF
	809	Right of access function group 800	ON – OFF	OFF
	810	Right of access to keys "P", "P1" – "P8" and "C1" – "C3"	ON – OFF	ON
	811	Access code This parameter is used to alter the access code. Upon delivery the machine is set with the access code "3371".		3371



### 14.33 Error messages on the display

Following error messages are shown on the control panel display.

ERROR: 1	Processor error STACK_OVERFLOW
ERROR: 2	Processor error STACK_UNDERFLOW
ERROR: 3	Processor error UNDEF_OPCODE
ERROR: 4	Processor error PROTECTION_FAULT
ERROR: 5	Processor error ILLEGAL_WORD_OPERAND
ERROR: 6	Processor error ILLEGAL_INSTRUCTION
ERROR: 7	Processor error ILLEGAL_BUS_ACCESS
ERROR: 8	Processor error NMI
ERROR: 10	OTE (Sewing head recognition unit) not attached
ERROR: 11	OTE not programmed (new)
ERROR: 12	OTE check sum error
ERROR: 13	OTE header invalid
ERROR: 14	OTE user data invalid
ERROR: 30(#)	(OTE error see cap. 14.35)
ERROR: 31(#)	(Error Sewing motor see cap. 14.34)
ERROR: 50	Incorrect control panel
ERROR: 51	Incorrect machine class in OTE
ERROR: 101	Mains voltage
ERROR: 102	Power supply overload
ERROR: 103	24 V too low
ERROR: 201(#)	(Error Sewing motor see cap. 14.34)
ERROR: 202	Pattern too large
ERROR: 203	Overload data transfer sewing motor
ERROR: 204	Tacting function locked
ERROR: 205	Run function locked
ERROR: 206	No NIS
ERROR: 207	Not end of ramp
ERROR: 208	Zero point not found
ERROR: 209	Sewing function locked
ERROR: 210	Bobbin thread fault
ERROR: 211	Stitch too large

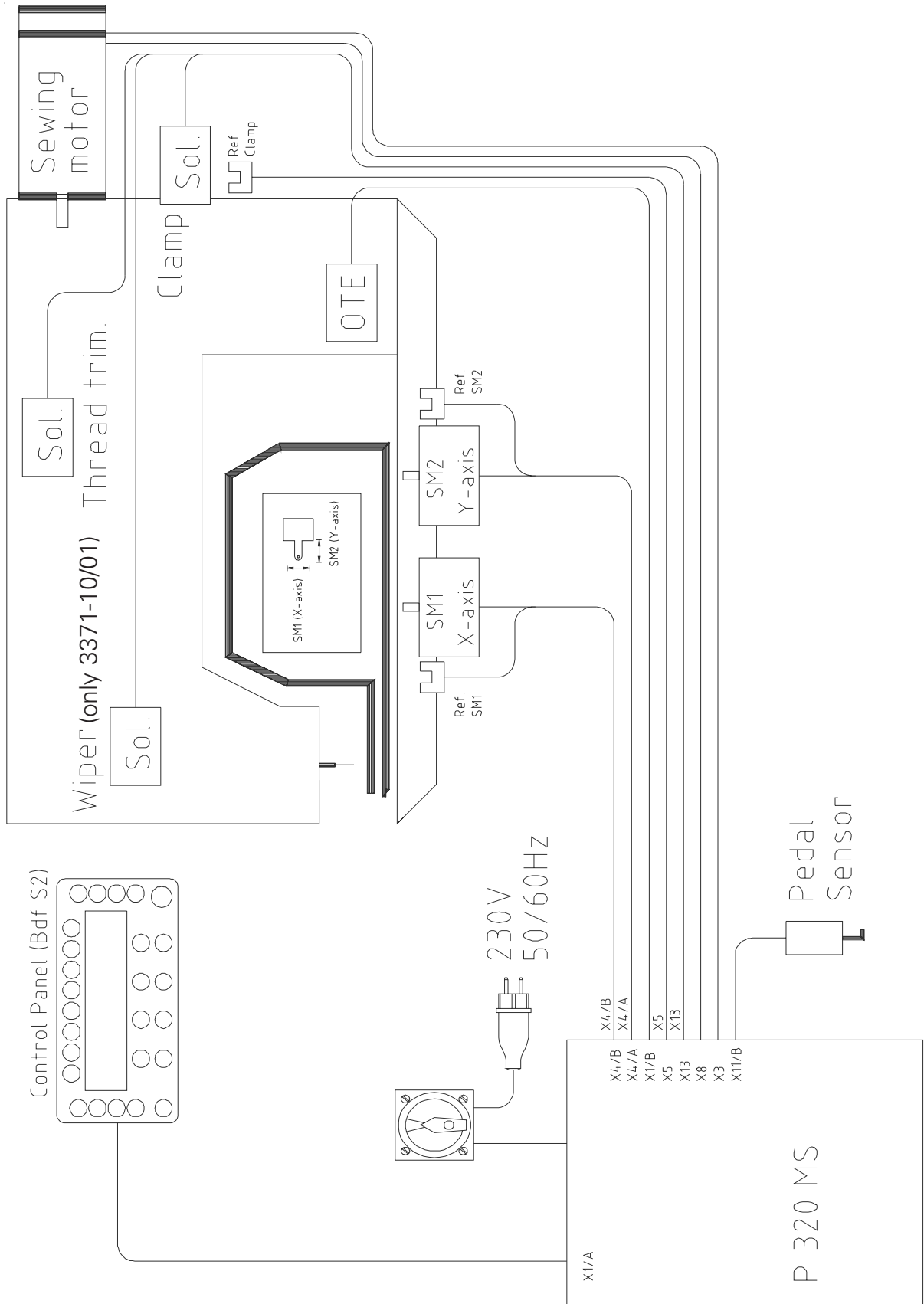
ERROR: 301	Raise clamp not completed
ERROR: 302	Lower clamp not completed
ERROR: 303	Raise clamp locked (needle position)
ERROR: 304	Lower clamp locked (needle position)
ERROR: 305	Thread wiper on locked (needle position)
ERROR: 401	Error sewing motor
ERROR: 402	Overload data transfer sewing motor
ERROR: 403	Program station not programmed
ERROR: 404	Program locked
ERROR: 405	Program does not exist
ERROR: 406	No NIS
ERROR: 407	Zero points invalid
ERROR: 408	Machine not in basic position
ERROR: 409	Zero point not found

### 14.34 Sewing motor errors

1	Time out	70	Motor blocking
9	Position not reached	71	No incremental connector
34	Brake path too short	73	Motor running interrupted
35	Communication error	75	Controller locked
36	Initialisation (Init.) not completed	170	Invalid transmission
65	Extint low at Init	171	Zero mark invalid
66	Short circuit	175	Start error
68	Extint low in operation	222	Time-out monitoring
69	No increments		

### 14.35 OTE-errors (Sewing Head recognition unit)

1	Read error
2	Write error
3	Full EEPROM
4	No EEPROM
5	Invalid size
6	Invalid address
7	Address overflow
8	Checksum failed
9	Serialnr. changed



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