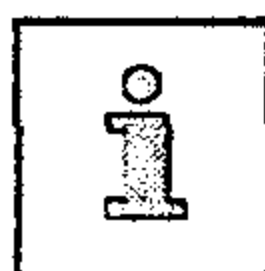


PFAFF

Supplement to the instruction manual
for machines with SRP or -948/51

1 Supplement for machines with SRP

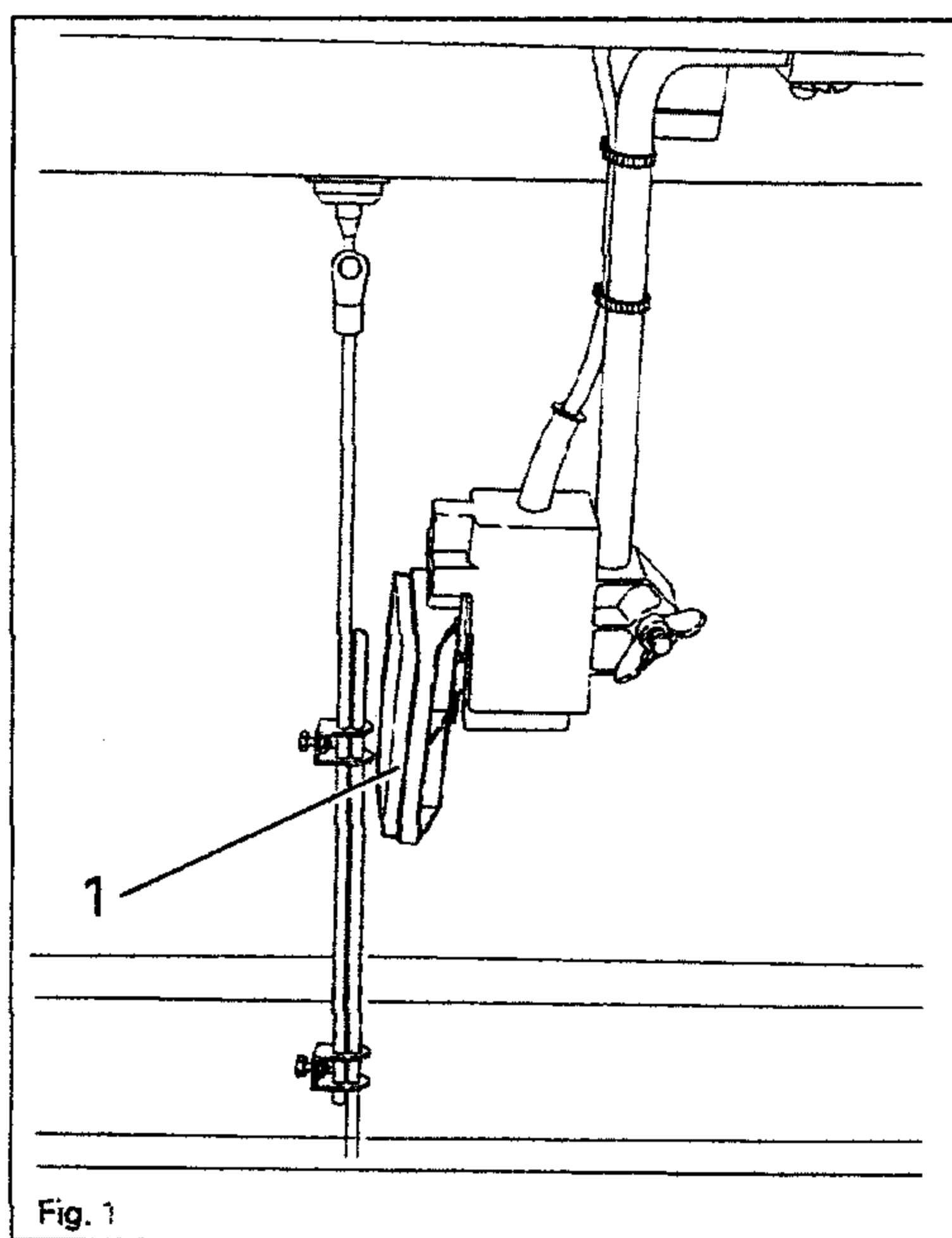
1.01 SRP-System (Speed responsive pressurefoot control)



By means of a linear motor, the SRP-system makes it possible to adapt the pressure on the presser foot to suit the respective sewing speed or the workpiece. In addition the clearance under the presser foot can be adjusted individually.

All adjustments are made by changing the parameters (See Chapters 1.03 and 1.04)

1.02 Knee switch



- By operating knee switch 1, the presser foot can be raised when sewing is interrupted.

1.03 Selecting and altering parameters

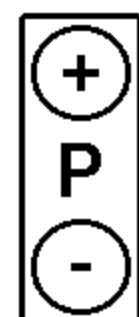
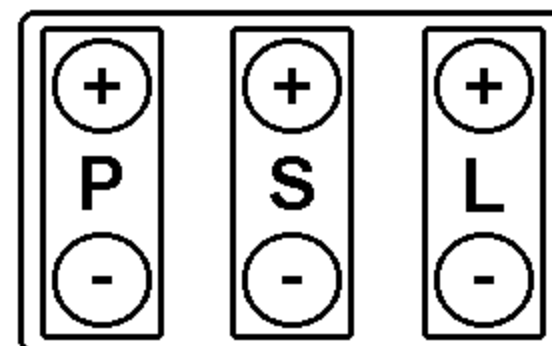


- Press and hold key PE and TE simultaneously.
- Switch on the machine.



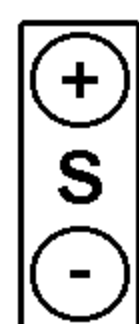
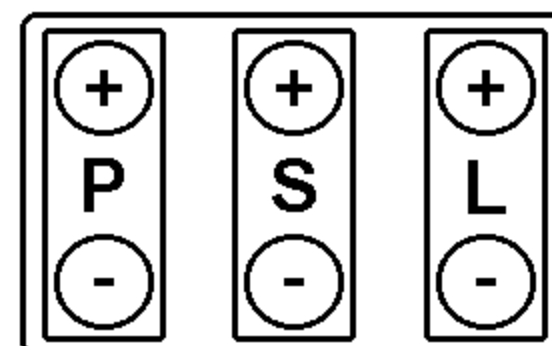
- Press the **Parameter input** key (LED on).

100



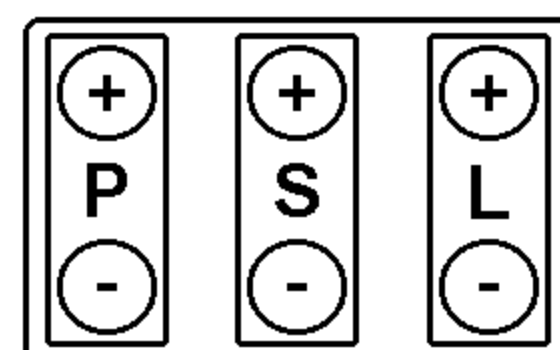
- By pressing +/- on the **P** key select the desired group, e.g. "200".

200



- By pressing +/- on the **S** key select the desired parameter, e.g. "250".

250



- Set the desired value (e.g. clearance under the presser foot) by pressing +/- (L key).



- Save the input by ending the parameter input (LED off).

1.04 List of parameters For S.R.P. machines

Group	Parameter	Description	Access level	Setting range	Standard value
2	250	Presser foot clearance when raising presser foot with automatic presser foot lift	B, C	0 – 255	190
	251	Presser foot lift delay	B, C	0 – 255	5
	252	Presser foot clearance when raising pressure foot with knee switch	B, C	0 – 255	150
	255	Presser foot pressure dependent on speed	B, C	0 – 10	5
	256	Constant presser foot pressure before sewing	B, C	0 – 32	10
	257	Constant spring pressure during the feed phase	B, C	0 – 90	60
	258	Machine class 1 = 1051 and 1181 2 = 1053 and 1183	B, C		II
	259	Beginning of the presser foot pressure (on the 1051 and 1181)	C	0 – 126	12
	260	End of the presser foot pressure (on the 1051 and 1181)	C	0 – 126	67
	261	Beginning of the presser foot pressure (on the 1053 and 1183)	C	0 – 126	81
262	End of the presser foot pressure (on the 1053 and 1183)	C	0 – 126	126	

Parameter # 255 can be changed for the different weights of fabric.



For more information and displays see the motor instruction manual.

P 41 MS II motor panel

2 Supplement for machines with Puller -948/51

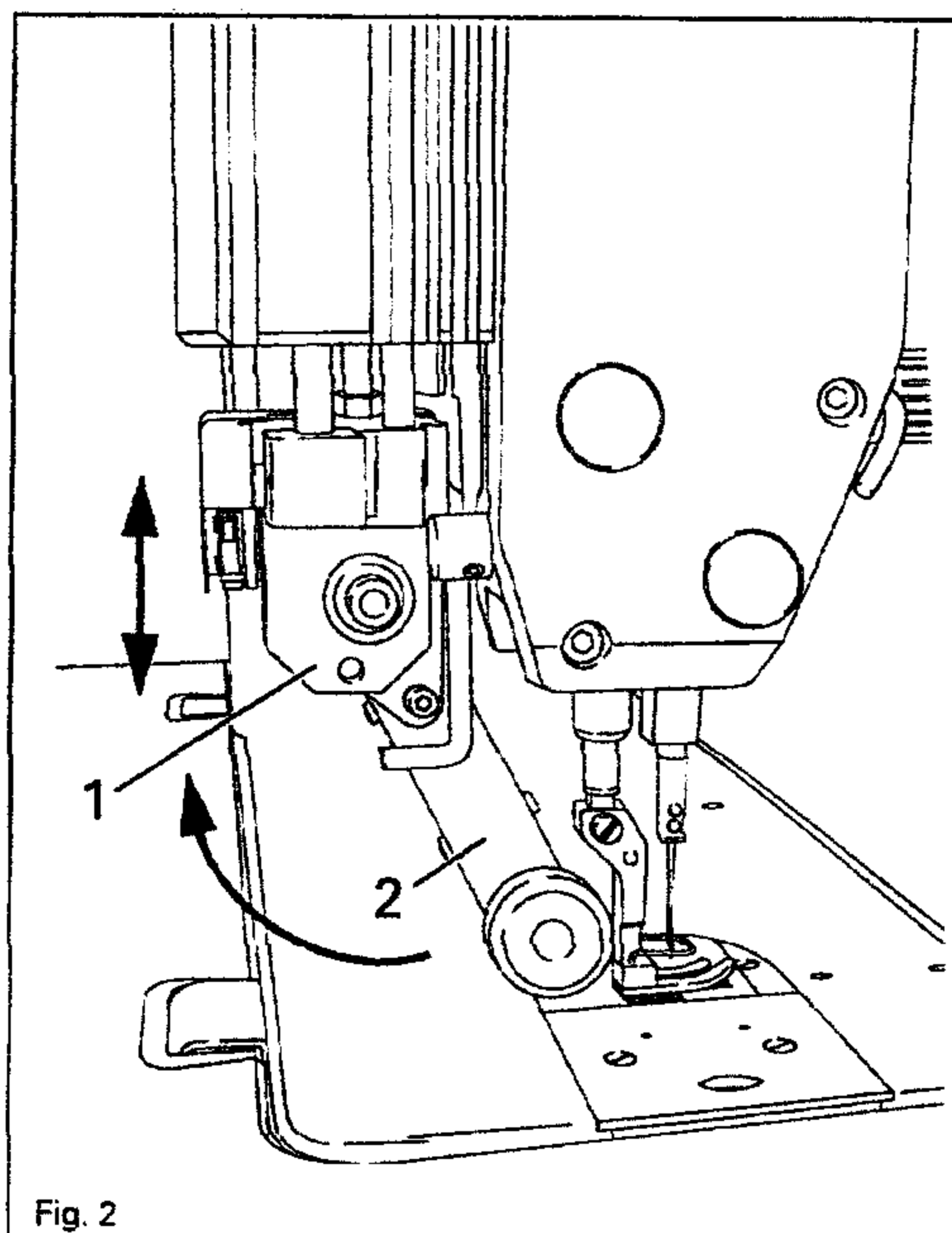
2.01 Puller -948/51

By permanently turning the puller roller, the puller enables to a great extent sewing without the workpiece shifting and puckering. The linear motor of the puller enables individual clearance space between the needle plate and puller roller.



All adjustments such as puller feed motion, clearance under the puller roller etc. can be made by changing the parameters (see Chap. 2.03 and 2.04).

2.02 Puller functions



Engaging/disengaging the puller

- Raise the puller drive unit 1 until it locks into place and swing puller arm 2 back as far as possible. To engage the puller, follow the instructions in the reverse order.

Switching the puller on/off

- The puller is automatically switched on or off when the puller unit is engaged or disengaged.

Setting the puller feed motion

- The feed motion of the puller is set by means of parameters (see Chap. 2.04 List of parameters and the Motor Instruction Manual)

The feeding of the puller is intermittent up to 500 RPM

The puller is not for very heavy fabric.

The puller helps to control the length of the stitch

2.03 Selecting and altering parameters

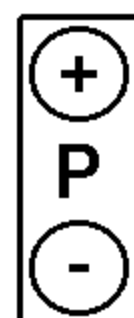
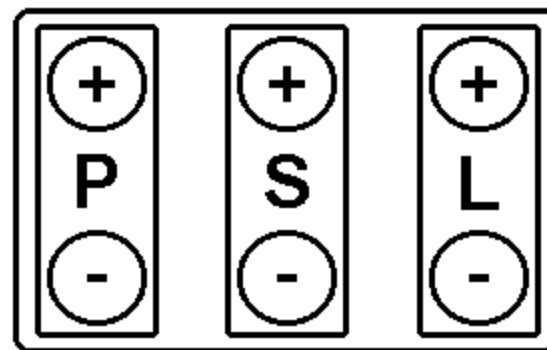


- Press and hold key PE and TE simultaneously.
- Switch on the machine.



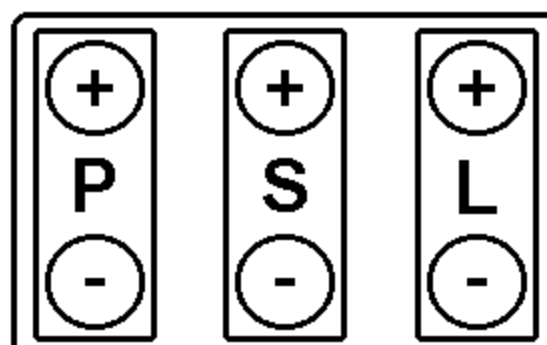
- Press the Parameter input key (LED on).

100



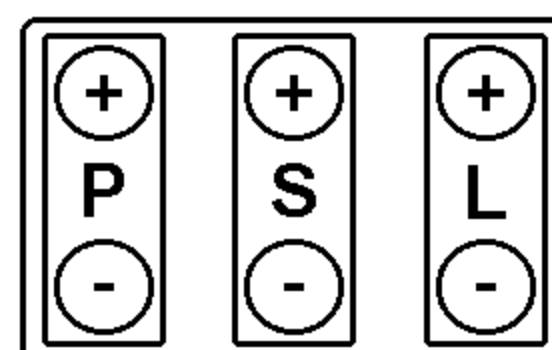
- By pressing +/- on the P key select the desired group, e.g. "200".

200



- By pressing +/- on the S key select the desired parameter, e.g. "252".

252



- Set the desired value (e.g. clearance under puller roller) by pressing +/- (key L).



- Save the input by ending the parameter input (LED off).

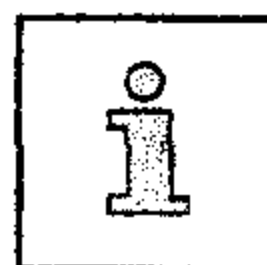
Maximum RPM is 4500

2.04 List of parameters

Group	Parameter	Description	Access level	Setting range	Standard value
2	252	Clearance under puller roller when presser foot is raised or during backtacking	A, B, C	0 - 252	110
	253	Puller starting time in intermittent range (on the PFAFF 1051 and 1181) (on the PFAFF 1053 and 1183)	B, C	0 - 128	10
			B, C	0 - 128	70
	254	Height of the puller roller after the cutting action	B, C	0 - 255	120
	255	Roller pressure dependent on sewing speed	B, C	0 - 10	2
	256	Constant roller pressure	B, C	0 - 31	8
	259	Raising the puller roller by turning the balance wheel manually	B, C	0 - 255	18
	260	Feed motion of the puller roller	A, B, C	0 - 60	30
	261	Starting properties of the puller roller	B, C	0 - 255	75
	262	Advance of the puller roller in intermittent operation	B, C	0 - 255	40
	264	Rotary speed of the puller roller during initialisation after switch-on	B, C	0 - 255	113
	265	Run time of the puller roller after switch-on	B, C	0 - 255	3
	266	Height of puller roller after the machine is switched on	B, C	0 - 255	140
267	Holding current of the puller roller	B, C	0 - 255	80	
4	445	No. of stitches after the machines starts before the puller roller makes contact	B, C	0 - 255	0

acceleration ramp of the roller for each stitch

amount of roller rotation during intermittent feeding



For more information and displays see the motor instruction manual.

Puller 948/51 for series 1050/1180

Description of the function keys F1, F2, F3 and F5 on the OC-Top E-Prom: 7Z 060 A

The function keys F1, F2, and F3 are used to adapt the feed motion of the puller roller either to different material properties or to different stitch lengths.

The function keys F1, F2, and F3 can be freely programmed with the respective parameter 278 (F1), 279 (F2), or 280 (F3). The function of the afore mentioned parameter numbers are identical.

With function key F5, any one of the 3 function keys F1, F2, or F3 can be activated.

When the machine is restarted, the last F1, F2, or F3 value used is reloaded automatically, and indicated on the operating panel.

An LED indicated the function key currently in use.

Example for setting a 2mm stitch length:

1. Set the required stitch length on the machine with the stitch length con troll button.
2. Using F5 (as described above) select on of the 3 function keys.
Example: Activated F5 (LED on), activate F1 (LED on).
3. Activate TE-key (LED on).
4. Using + or – on the P key, select the parameter group 200.
5. Using + or – on the S key, select the parameter 278 (F1).
6. Using + or – on the L key, select standard value 10 which corresponds to a preset machine stitch length of 2 mm.
7. Switch off the TE-key (LED off).
8. Sew a test seam. If the presetting is correct, the material being sewn should move in a slightly stretched state between the presser foot shoe and the puller roller. If the material bubbles up behind the presser foot, the feed motion speed of the puller roller must be increased, i.e. parameter 278 for F1 should be set e.g. at value 11 or higher. If the material is stretched too much, reduce the value of parameter 278.

Attention: The puller system requires that the pressure of the presser foot match the sewing speed with adequate resistance against the light pulling action of the puller wheel. Otherwise a negative influence of the stitch length results.

Other stitch lengths or different material properties can be programmed for keys F2 and F3 as described in this example and selected by simply activating the above-mentioned F-keys.

List of parameters for Puller 948/51 Series 1050/1180. E-Prom: 7Z 060 A

<u>Parameter</u>	<u>Access level</u>	<u>Setting range</u>	<u>Standard value</u>	<u>Actual value</u>
252	A, B, C	0-252	110	
253	B, C	0-128	10 or 70	
254	B, C	0-255	120	
255	B, C	0-10	2	
256	B, C	0-31	8	
259	B, C	0-255	18	
261	B, C	0-255	75	
262	B, C	0-255	40	
264	B, C	0-255	113	
265	B, C	0-255	3	
266	B, C	0-255	140	
267	B, C	0-255	80	
278	A, B, C	0-60	10	
279	A, B, C	0-60	30	
280	A, B, C	0-60	50	
445	B, C	0-255	0	

Parameter

- 252** Clearance under the puller roller when back tacking.
- 253** Puller starting time in intermittent range.
(KL 1051/1181= 10, KL 1053/1183= 70).
- 254** Clearance under the puller roller after trimming.
- 255** Roller pressure dependent on sewing speed.
- 256** Constant roller pressure.
- 259** Raising the puller roller when turning the balance wheel manually.
- 261** Starting properties of the puller roller.
- 262** Feed motion of the puller roller with intermittent operation.
- 278** Pre-selected feed motion of the puller roller, F1 can be operated when F5 is activated.
- 279** Pre-selected feed motion of the puller roller, F2 can be operated when F5 is activated.
- 280** Pre-selected feed motion of the puller roller, F3 can be operated when F5 is activated.
- 445** Number of stitches before puller is lowered.

Initialization of the puller roller

- 264** Speed of the puller roller at initialization after connection.
- 265** Running time of the puller roller after connection.
- 266** Clearance of the puller roller after connection.
- 267** Retaining current of the puller roller.

Puller 948/51
1050/1180. E-Prom: 7Z 060 A

<u>Parameter</u>	<u>Access level</u>	<u>Setting range</u>	<u>Standard value</u>	<u>Actual value</u>
252	A, B, C	0-252	110	
253	B, C	0-128	10 or 70	
254	B, C	0-255	120	
255	B, C	0-10	2	
256	B, C	0-31	8	
259	B, C	0-255	18	
261	B, C	0-255	75	
262	B, C	0-255	40	
264	B, C	0-255	113	
265	B, C	0-255	3	
266	B, C	0-255	140	
267	B, C	0-255	80	
278	A, B, C	0-60	10	
279	A, B, C	0-60	30	
280	A, B, C	0-60	50	
445	B, C	0-255	0	