For the professional user

Operating Instructions

Für den professionellen Anwender

Betriebsanleitung

Class: **810C**
Klasse:

Model: **3**
Ausführung:

Dated:
Stand:

STROBEL
Spezialmaschinen GmbH

The sign of quality

You find the Strobel trademark on every Strobel machine leaving our works. And with good reason. This symbol is a guarantee of the high quality of our products. Quality which creates trust – trust in our technology, our service and, not least of all, in our good name.

Im Zeichen der Qualität

Sie finden die Strobel-Schutzmarke auf jeder Strobel-Maschine, die unser Werk verlässt. Und das aus gutem Grund. Denn dieses Zeichen garantiert Ihnen die hohe Qualität unserer Produkte. Qualität, die Vertrauen schafft – in unsere Technik, unseren Service und nicht zuletzt in unseren guten Namen.

A decision with future

Strobel clients know that they can expect a particularly high standard of performance from our company and our machines. Now you have settled for one of our products. For us this is a source of encouragement and of obligation to Justify your trust.

If you wish to profit from the performance and efficiency of your Strobel machine as long as possible, exact handling and thorough care is necessary. For this reason we kindly request that you read the operating instructions closely.
It provides all the information you need for trouble free operation.

And if you do happen to need a spare part the enclosed spare parts list gives a complete overview. It is clearly classified according to components so that you can find the required part quickly and easily. In order to avoid errors we request you to quote machine class, machine number and part number completely on your spare part order.

We wish you lots of success in your work with your new Strobel machine.

STROBEL
Spezialmaschinen GmbH

Garantiekarte/Warranty Sheet

STROBEL
Boschstraße 16
D-82178 Puchheim
Tel.: 089/80096-0
Fax: 089/80096-190
info@strobel.biz

Maschinenklasse/Machine class: _____

Serien-Nr./Serial No: _____

Auftrags-Nr./Order Confirmation No: _____

Lieferdatum/Delivery Date: _____

Rechnungs-Nr./Invoice No: _____

Rechnungsdatum/Invoice Date: _____

Beanstandung/Complaint: _____

_____

_____

_____

_____

_____ _____

Datum/Date Unterschrift/Signature:

Bitte nicht vom Kunden ausfüllen/To be filled out by Strobel:

	Datum	Bemerkung
EXA:		
ETA:		
PROD:		
EXA:		
BH:		

STROBEL

Operating Instructions
STROBEL Class 810C

Table of contents

1 General notes on safety 3

2 General notes 5

2.1 Operating Instructions 5
2.2 Class description, serial number and initial basis for description 5
2.3 Range of application and intended use 5
2.4 Technical data 6
2.5 Adjustment values 9

3 Setup and commissioning 11

3.1 Unpacking the machine 11
3.2 Setting up the machine (Fig. 5) 11
3.3 Direction of rotation on machine (Fig. 6) 14
3.4 Motor drive via toothed belt 14
3.4.1 Tension of the toothed belt (Fig. 7 und Fig. 8) 14

4 Notes on usage 16

4.1 Needle 16
4.1.1 Thread 16
4.2 Inserting the needle (Fig. 9) 17
4.3 Threading and straight grain (Fig. 10) 17
4.4 Winding the thread (Fig. 11) 20
4.4.1 Inserting the bobbin and threading the bobbin thread (Fig. 12) 21
4.5 Thread tension 22
4.5.1 Thread tension – needle thread (Fig. 13) 22
4.5.2 Thread tension – bobbin thread (Fig. 14) 22
4.5.3 Oil the hook (Fig. 15) 23
4.6 Operating control, general 24
4.6.1 Basic information 25
4.6.2 General procedure for changing the following values (simultaneously): 26
4.6.3 Procedure for changing a certain value (e.g. machine speed): 26
4.6.4 Program number (button 1 to 6) 27
4.6.5 Backtack at the beginning 27
4.6.6 Backtack at the end 28
4.6.7 Thread trimmer 28
4.6.8 One-off backtack suppression 28
4.6.9 Single stitch 28

5 Operating the sewing machine (Fig. 21) 29
5.1 Switching on 30
5.2 Insertion and removal of sewing material 30
5.3 Sewing 31
5.3.1 Sewing a car seat cover/sewing on "TieDown" 31
5.3.2 Swing-type material guide 32
5.3.3 Stichplatte 34
5.3.4 Thread trimming 34
5.4 Sewing drive 35
5.4.1 Control sockets control box (DAC Classic) 35
5.4.2 Connection cables motor sewing drive (DA432) 37
5.5 Sewing problems and troubleshooting 38
6 Servicing the machine 41
6.1 General 41
7 Optional extras 42
7.1 Swing-type material guide 286.0468 42
8 Parameter list DC1500-AB425S ..... **Fehler! Textmarke nicht definiert.**

Subject to change without prior notice

1 General notes on safety

Manuals and additional information can be found on the STROBEL website at:

http://www.strobel.biz

Every person in charge of setting up, operating, servicing and repairing the machine must first read and understand the operating instructions and particularly the safety instructions before starting up the machine.

Failure to comply with the following safety instructions can lead to physical injuries or damage to the machine.

1. The machine must only be operated by persons familiar with the relevant operating instructions and who have been instructed accordingly.
2. Before commissioning also read the notes on safety and the operating instructions of the sewing drive manufacturer.
3. Only use the machine in the intended manner and never without the provided guards. Always observe the pertinent safety regulations.
4. Switch off the main switch or pull the power plug for threading, changing the bobbin, exchanging sewing tools such as needle, hook, stitch plate, transport devices, trimming knive and cutting block, for cleaning and when leaving the workplace as well as for maintenance.
5. General maintenance tasks may be carried out only by properly trained persons in accordance with the operating instructions.
6. Repair work, retrofitting and maintenance may be carried out only by technicians or specially trained personnel.
7. When servicing or repairing pneumatic equipment, the machine must be disconnected from the pneumatic supply. Exceptions are only allowed for adjustment work and tests of functionality performed by specially trained technicians.
8. Only specially qualified technicians may work on the electrical equipment.
9. It is forbidden to work on electrically live components! Exemptions are covered by the EN50110 (DIN VDE0105) regulations.
10. Any retrofitting or alterations to the machine may only be performed under strict compliance with all pertinent safety regulations.
11. Only use our approved spare parts when servicing and/or repairing the machine.
12. It is forbidden to operate the sewing head until it is determined that the entire sewing unit complies with EU provisions.

13. It is essential that you observe and follow these instructions as well as the generally valid safety regulations.

14. Warning instructions given in the operating instructions that pertain to especially dangerous parts of the machine must be indicated at these positions using a safety symbol.

Warning instructions given in the operating instructions that pertain to special injury hazards for operating personnel or technicians must be indicated at these positions using a safety symbol.

2 General notes

In the operating- and mechanic instructions you will find references to the titles of the video tutorials for the machine class 810C.

For further information please contact us by mail:

Mr. Strobl strobl@strobel.biz
Mr. Jäger jaeger@strobel.biz

Videos: „Introduce 810C with DAC“
“02_What is blindstitch.MTS”

2.1 Operating Instructions

Every person involved with setting up, operating, servicing and repairing the machine must first read and understand the operating instructions and particularly the safety instructions before starting up the machine.

2.2 Class description, serial number and initial basis for description

For side-referenced descriptions, the operating side of the machine is the starting base.

The class description (type), serial and model number (after the dash) are located centrally at the bottom of the right side of the type plate.

2.3 Range of application and intended use

Two-thread blind-stitch double lockstitch machine for sewing flow profiles onto car seat covers.

Videos: “02_What is blindstitch.MTS”
“03_What is blindstitch_needle.MTS”
“04_What is blindstitch_Plunger_part_1.MTS”
“05_What is blindstitch_Plunger_part_2.MTS”
“06_What is blindstitch_Plunger_part_3.MTS”

2.4 Technical data

	Technische Daten / Technical data	
	Maximal Drehzahl / Maximum speed	1200 min-1
	Stichlänge / stitch length	2,0 - 6,0 mm Auslieferzustand / delivery condition 3,5 mm
	Schrittmotor gesteuerter Bandtransport / Step motor controlled bottom belt feed	Einstellwerte für Stichlänge 0,1 mm Schritte/ Setting values for stitch length 0.1 mm Steps
	Stichtiefeneinstellung über Schrittmotor gesteuerten Taucher / Stitch depth adjustment via step motor controlled plunger	(Einstellgenauigkeit) Taucher mit 0,01 mm Schritte/ (setting accuracy) plunger with 0.01 mm steps
	Nadelsystem / needle system Nadelstärke / needle size	GROZ-BECKERT 1717 SRUE 110/18
	<u>Fadenspannung / thread tension</u> Nadelfaden / needle thread Spulenfaden / bobbin thread Fadenhersteller / Bezeichnung Thread manufacturer / description Faden / thread <u>Fadendicke / thread thickness:</u> Nadelfaden / needle thread Spulenfaden / bobbin thread	 Auslieferzustand / delivery condition 400 cN Auslieferzustand / delivery condition 40 cN AMANN / Strongfil, Onyx, Serafil GÜTERMANN / Calora, Tera Polyester, endlos gezwirnt / polyester continuous filament 40 60
	Programmierbar / Programmable	6 Nahtprogramme / 6 Sewing programs

	Einfacher Anfangsriegel / Simple initial backtack		Einfacher Endriegel / Simple end tack
	Doppelter Anfangsriegel / Double initial backtack		Doppelter Endriegel / Double end tack
	Einmalige Riegelunterdrückung / One-time tack suppression		Halbstich / Half stitch
	Fadenabschneider / Thread trimmer		Anschiebetisch / table extension
	LED Leuchte / LED sewing lamp		Separater Fadenspuler / Separate thread spooler
	Höhenverstellbares Gestell / height adjustable stand	Verstellbereich 400 mm setting range 400 mm	

Technischer Auslieferzustand / delivery condition:	
Motor-Leistung min. - Steuerung / min. motor power – control box	500 W-DA432 / DAC Classic
Motor-Leistung min. / min. motor power	550 W
Zahnriemenscheibe Maschine / toothed belt pulley/machine	Z = 20
Zahnriemenprofil / toothed belt profile	HTD 5M-9
Stichart / stitch type	Zweifaden -Blindstich - Doppelsteppstich Typ 314 / two thread lockstitch blind stitch type 314
Anschluss pneumatisch / pneumatic connection	6 bar
Luftverbrauch, Mittelwert / avarage air consumption	30 l / h
Stellfläche / Foot print	1,2 m x 1,4 m
Arbeitsgeräusch / operating noise at 1200 min-1 nach DIN 45635-48-1 KL3	LpAm 77,5 dB(A)

2.5 Adjustment values

Loop stroke (Fig. 1)	3.1 ±0.2 mm
Setting from hook point to needle eye (Fig. 1)	1.5 ±0.3 mm
Height setting of hook point to needle (Fig. 2)	0.2 ±0.1 mm
Plunger, highest position to needle (Fig. 3)	Needle point at the inner edge of the needle guide
Plunger stops toward needle (Fig. 4)	Until the eye of the needle has passed the stitch plate rise by approx. 5 mm
Transport length belt feed	2 - 6 mm
Lifting value between belt feed and stitch plate	15 mm

Fig. 1

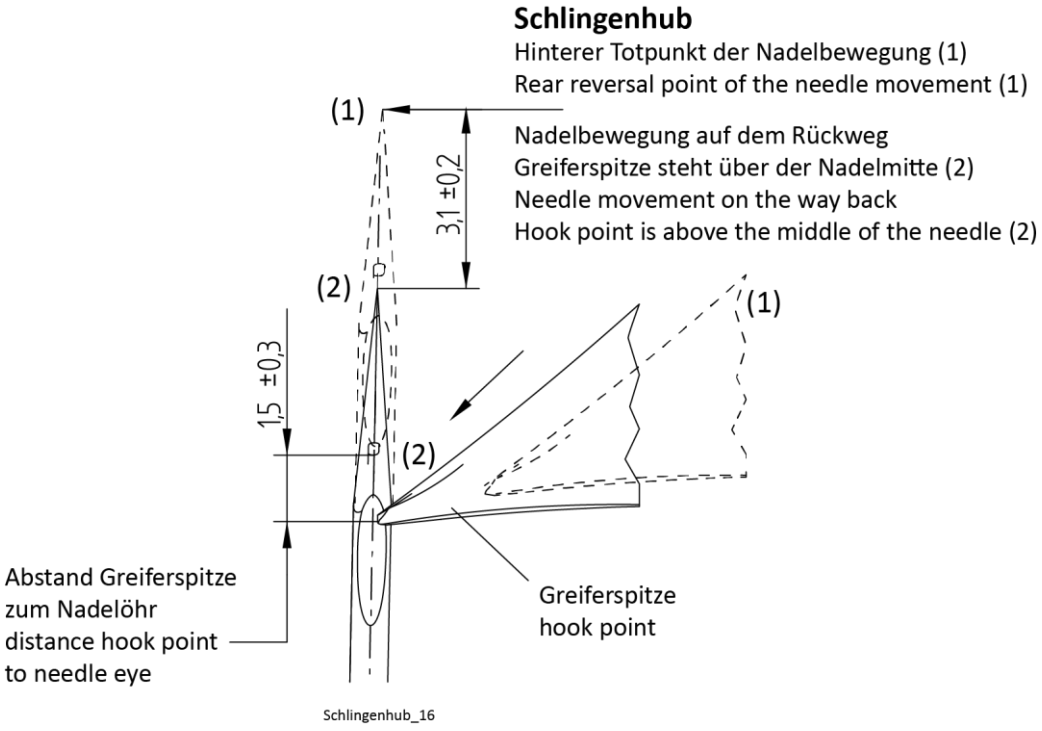


Fig. 2

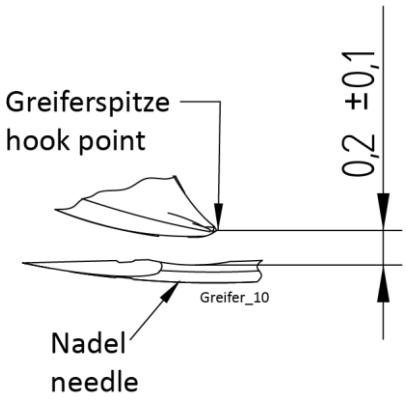


Fig. 3

Nadelspitze = Kante Nadelgleitplättchen
needle point = edge of needle guide

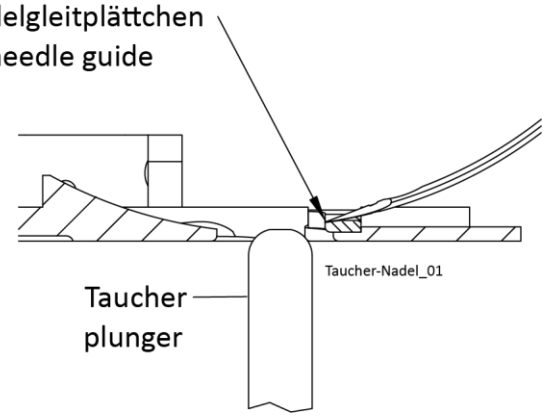
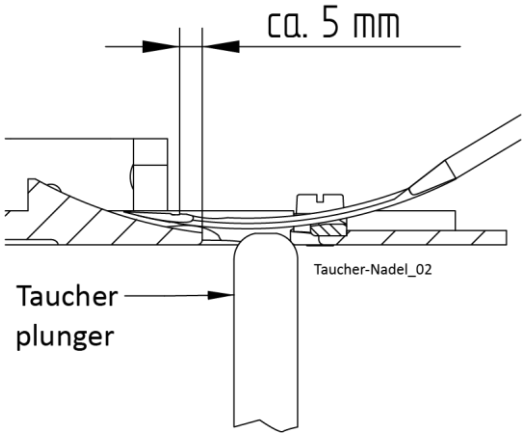


Fig. 4



3 Setup and commissioning

C A U T I O N ! Danger of injury!

Due to pulling in of parts of clothing or hair as well as **danger** of crushing of fingers!

3.1 Unpacking the machine

The machine is only delivered completely with stand.

The thread stand and other machine accessories are included in the packaging.

Before disposing of the packaging material, carefully check whether all accessory components have been unpacked.

3.2 Setting up the machine (Fig. 5)

A T T E N T I O N !

The machine may not be switched on without compressed air connected. The operating pressure is 6 bar.

A T T E N T I O N !

If you release or even loosen positions that are marked in yellow, important factory settings can get lost!!

These screws do not have to be released for maintenance work.

If, however, you do release these screws, please contact the manufacturer.

A T T E N T I O N !

Lubricate the hook every day with a drop of oil.

A T T E N T I O N !

Before starting the machine, check that the electrical specifications given on the type plate of the motor, in particular the network voltage and frequency, are appropriate for your electric system and that all other connection values, e.g. for air, comply with the values specified on the machine and in the operating instructions.

Carry out the electrical connection according to the cable identification or the supplied connection diagram.

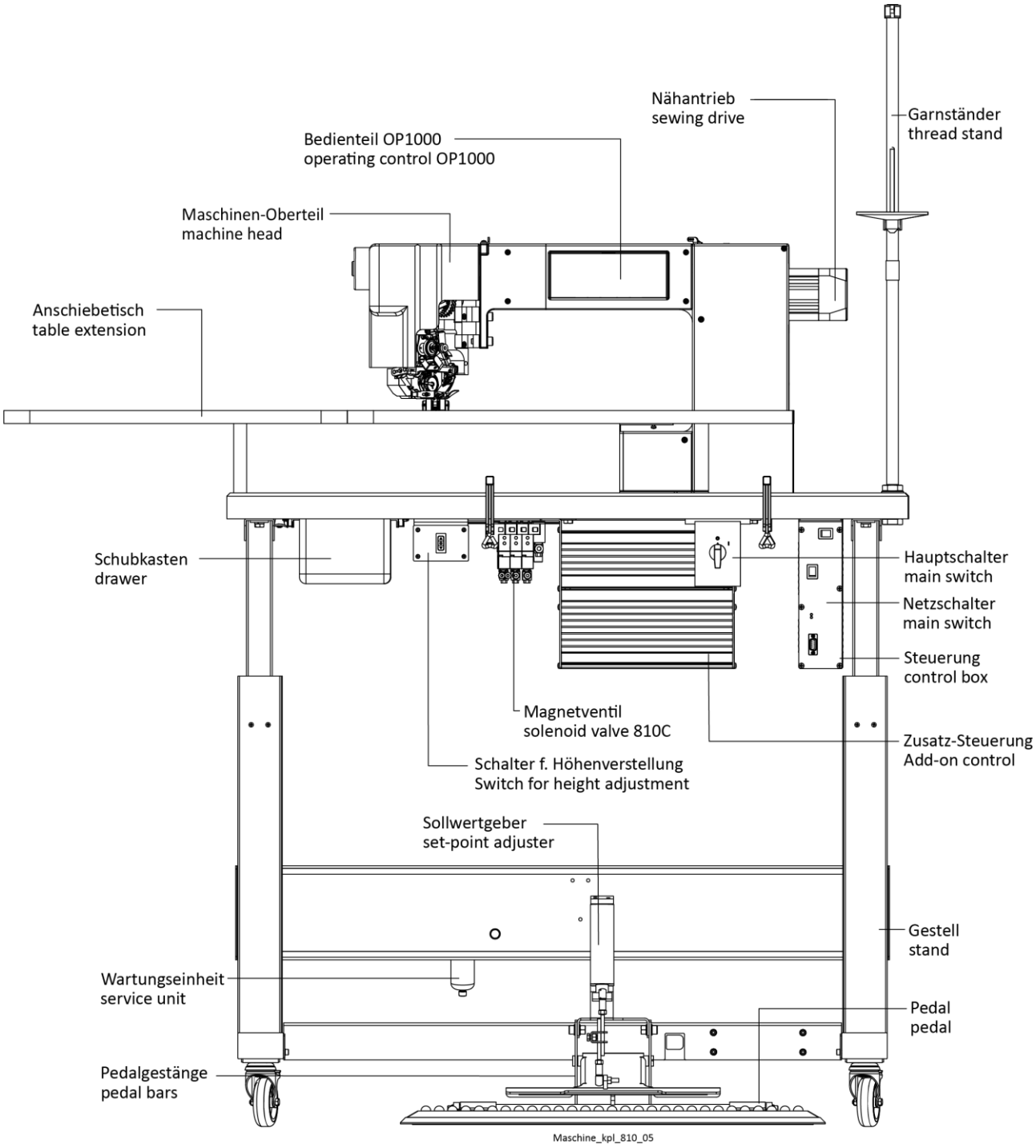
Check that all screws on the stand are firmly installed and retighten if necessary.

After the machine lifting and several other activities happen pneumatically, a **compressed air connection of 6 bar** is required (see point "2.4 Technical data"). The air pressure can be regulated with the service unit.

After assembling the individual parts, mount the thread stand on the back right of the table extension. (Fig. 5).

Video: „01_Installing the machine.MTS“

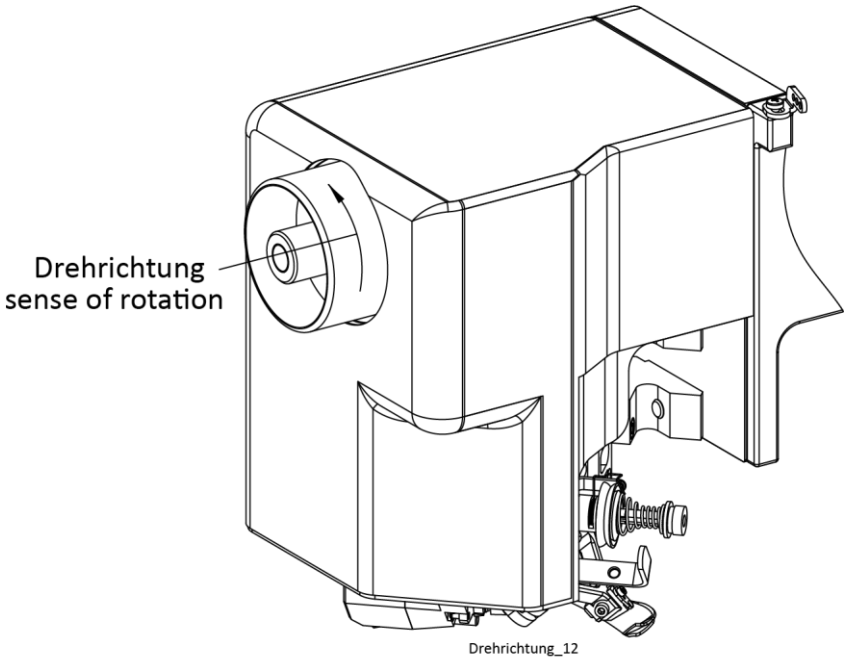
Fig. 5


Nähantrieb
sewing drive
Garnständer
thread stand
Bedienteil OP1000
operating control OP1000
Maschinen-Oberteil
machine head
Anschiebetisch
table extension
Schubkasten
drawer
Hauptschalter
main switch
Netzschalter
main switch
Steuerung
control box
Magnetventil
solenoid valve 810C
Zusatz-Steuerung
Add-on control
Schalter f. Höhenverstellung
Switch for height adjustment
Sollwertgeber
set-point adjuster
Gestell
stand
Wartungseinheit
service unit
Pedal
pedal
Pedalgestänge
pedal bars
Maschine_kpl_810_05

3.3 Direction of rotation on machine (Fig. 6)

The sense of rotation of the handwheel is counter-clockwise.

Fig. 6



3.4 Motor drive via toothed belt

3.4.1 Tension of the toothed belt (Fig. 7 und Fig. 8)

C A U T I O N ! Danger of injury!

To check the tension of the toothed belt, switch off the machine electrically, pull the power plug, and depress the motor switch pedal to make sure that the machine is truly switched off.

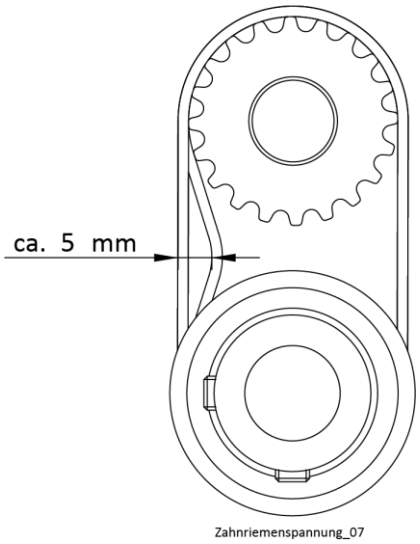
The tension of the toothed belt should not be too great. Slight thumb pressure should be able to push the belt through by approx. 5 mm. (Fig. 7)

A too little or too great toothed belt tension can deteriorate the positioning of the machine and therefore impair the function sequence.

Tensioning the toothed belt (Fig. 8 a + b):

- Loosen the four screws (2).
- Adjust the correct tension of the belt (3) by means of the screw (1).
  - The tension can be checked via the opening (5) in the bearing block (4).
- Then retighten the four screws (2).

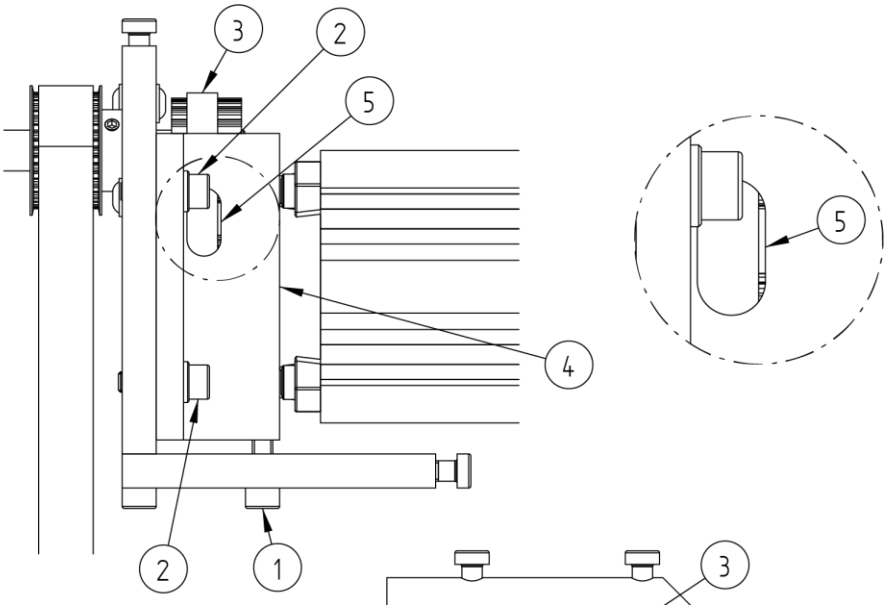
Fig. 7



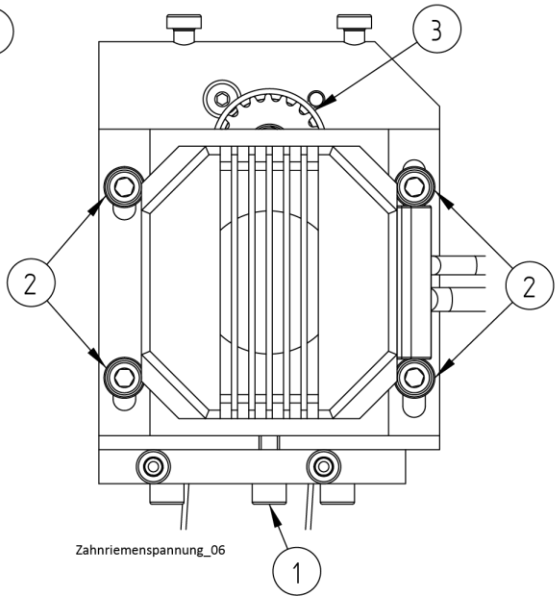
Zahnriemenspannung_07

Fig. 8

a



b



Zahnriemenspannung_06

4 Notes on usage

4.1 Needle

Only use the approved GROZ-BECKERT needle system 1717 SRUE with thickness 110/18.

NOTE: An intact needle is very important for ensuring good quality stitching. Bent needle points, that may only be visible under a magnifying glass, will lead to poorer sewing results. Replace your needles in time!

G u a r a n t e e n o t e !

This machine has been configured and broken in using original GROZ-BECKERT needles.

No guarantees can be given when the machine is readjusted for the use of different needles.

4.1.1 Thread

The following sewing threads have been approved by STROBEL Spezialmaschinen GmbH in consultation with the automotive industry for use with the 810C machine:

Thread manufacturer / description	**AMANN / Strongfil, Onyx, Serafil** **GÜTERMANN / Calora, Tera**

4.2 Inserting the needle (Fig. 9)

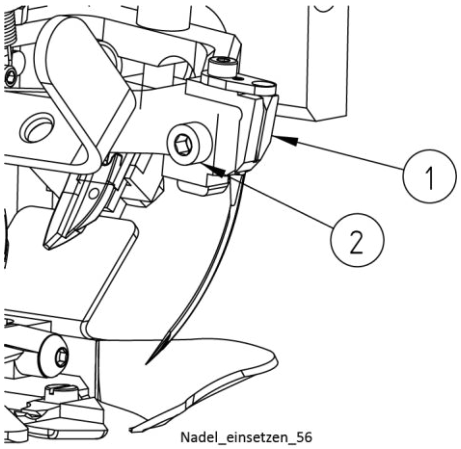
C A U T I O N ! Danger of injury!

Before replacing the needle, switch off the machine electrically, and depress the motor switch pedal to make sure that the machine is truly switched off.

Otherwise there is a **danger of injury** from crushing and needle punctures.

The curved shape of the needles determines the position of the needle lever. Only ensure that the needle shank is pushed into the groove of the needle lever until it stops, and the needle clamping plate (1) is tightly fastened using screw (2).

Fig. 9



4.3 Threading and straight grain (Fig. 10)

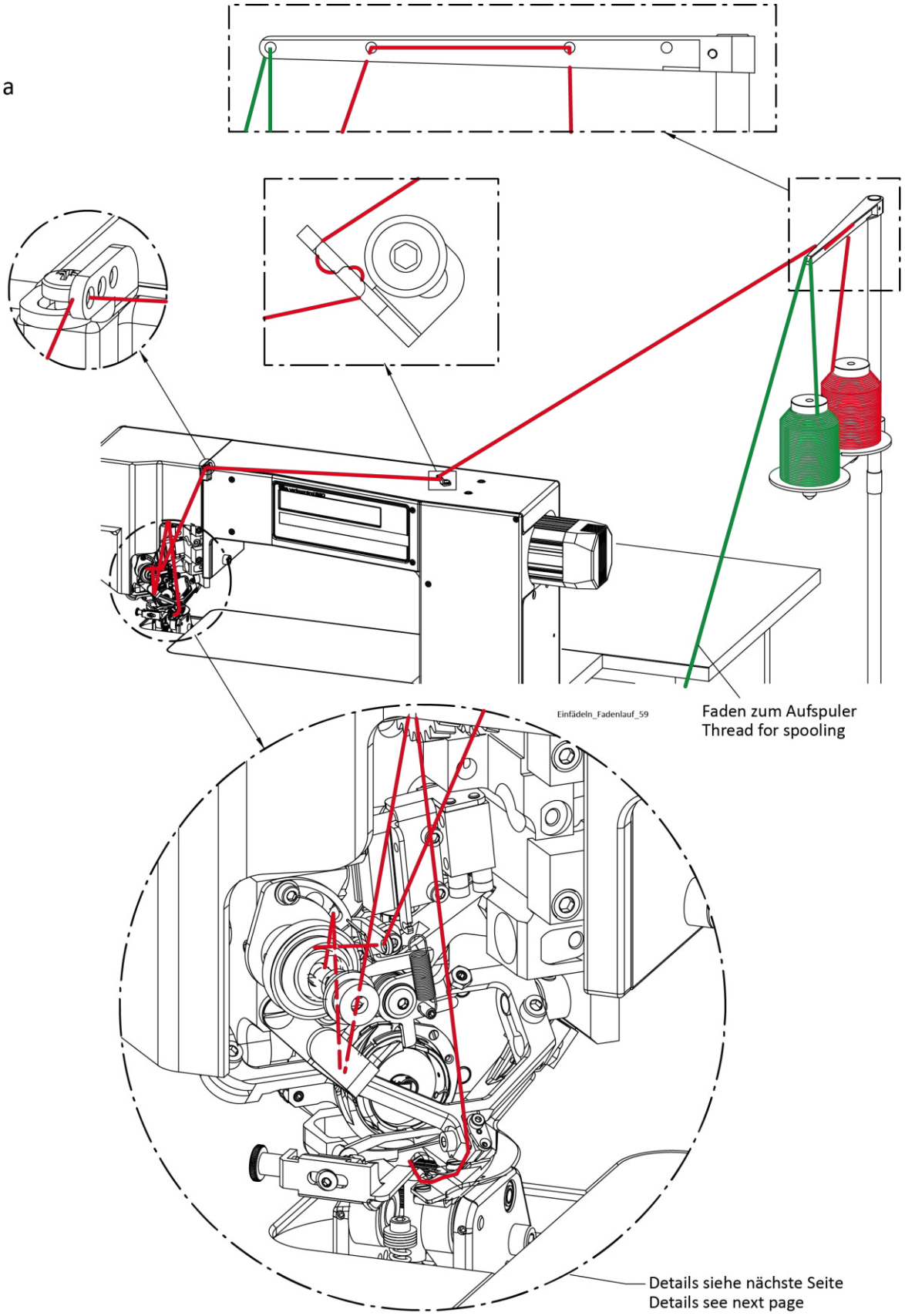
C A U T I O N ! Danger of injury!

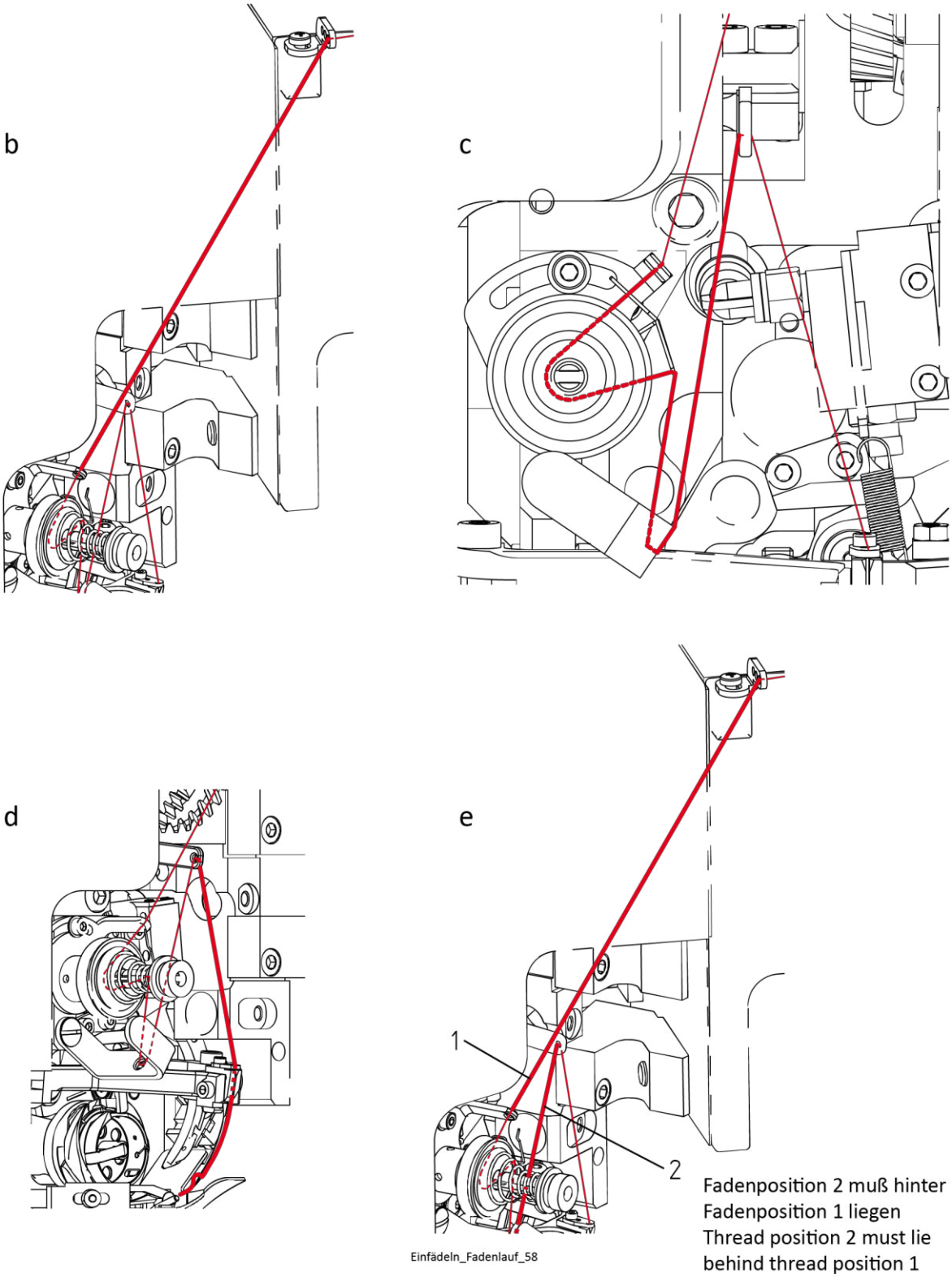
Before threading, switch off the machine electrically, and depress the motor switch pedal to make sure that the machine is truly switched off.

Fig. 10 indicates the correct threading using the thread take-up lever.

Fig. 10

a


Einfädeln_Fadenlauf_59
Faden zum Aufspuler
Thread for spooling
Details siehe nächste Seite
Details see next page



Videos: „Threading the machine_part_1.MTS“
„Threading the machine_part_2.MTS“
„Threading the machine_part_3.MTS“

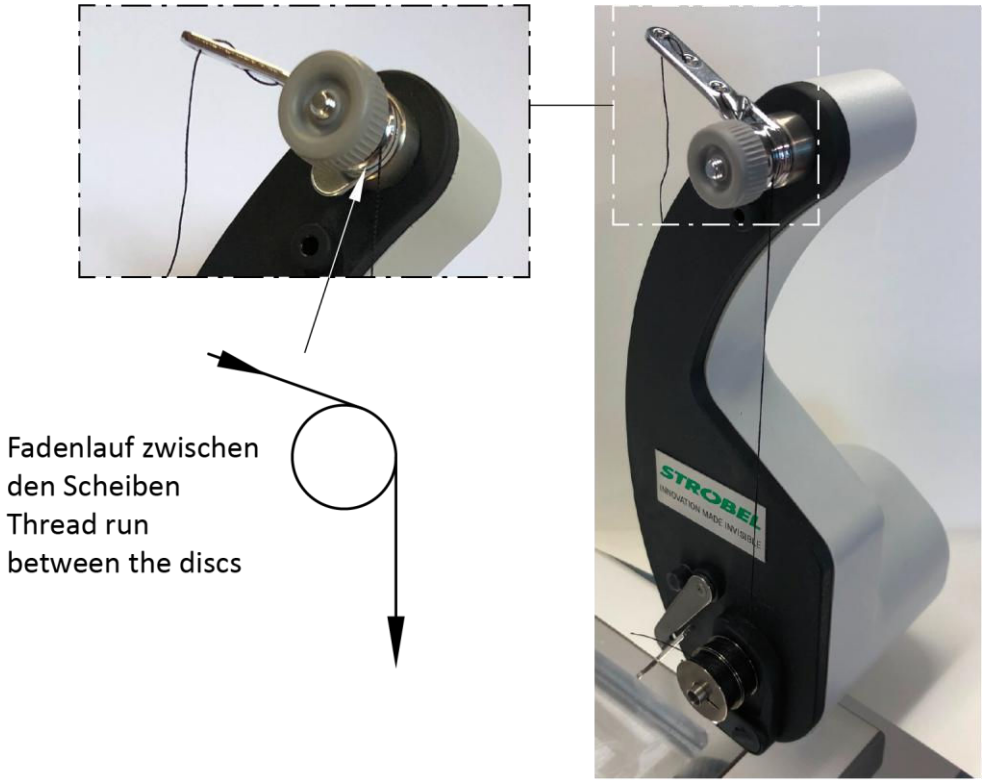
4.4 Winding the thread (Fig. 11)

Fig. 11 shows the straight grain during winding.

Make sure that not too much thread is wound onto the bobbin, and that the bobbin walls are not pressed apart. Damaged bobbins should be replaced immediately by new ones. The bobbin should not be filled beyond the edge, rather should be ended approx. 1 mm below the bobbin edge.

Video: „Fill the bobbin.MTS“

Fig. 11



Faden_aufspulen_05

4.4.1 Inserting the bobbin and threading the bobbin thread (Fig. 12)

C A U T I O N ! Danger of injury!

Before threading, switch off the machine electrically, and depress the motor switch pedal to make sure that the machine is truly switched off.

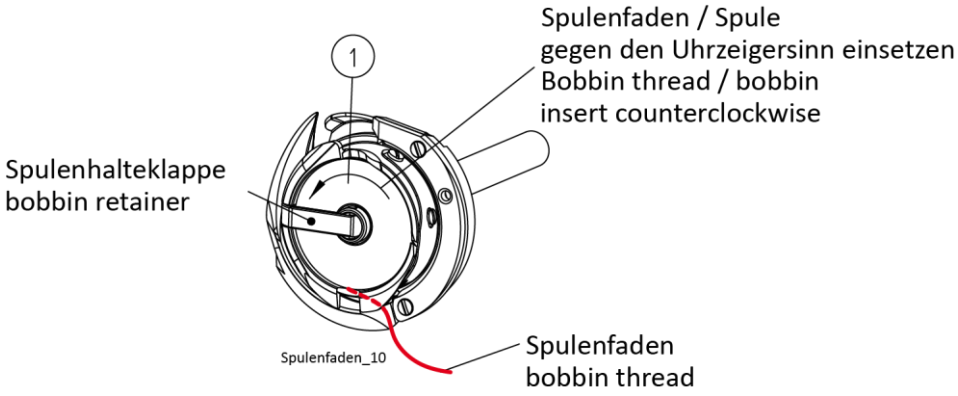
Turn the handwheel to move the needle lever to its highest position to remove and reinsert the bobbin (1). Fold the latch that holds the bobbin away from the bobbin case with a short jerk. The bobbin will then jump out of the bobbin case by spring pressure so that it can be easily removed.

Please make sure that the flat springs remain in the hook bobbin.

When inserting the bobbin, observe that the bobbin thread unwinds counter-clockwise from the rear side of the bobbin. Then guide the start of the bobbin thread through the slit on the right side and push this slanting downwards in towards the stitch plate. Guide the bobbin thread out to the right on the stitch plate. Cut off anything that protrudes for approx. 10 cm from the bobbin.

Video: „Change the bobbin.MTS“

Fig. 12



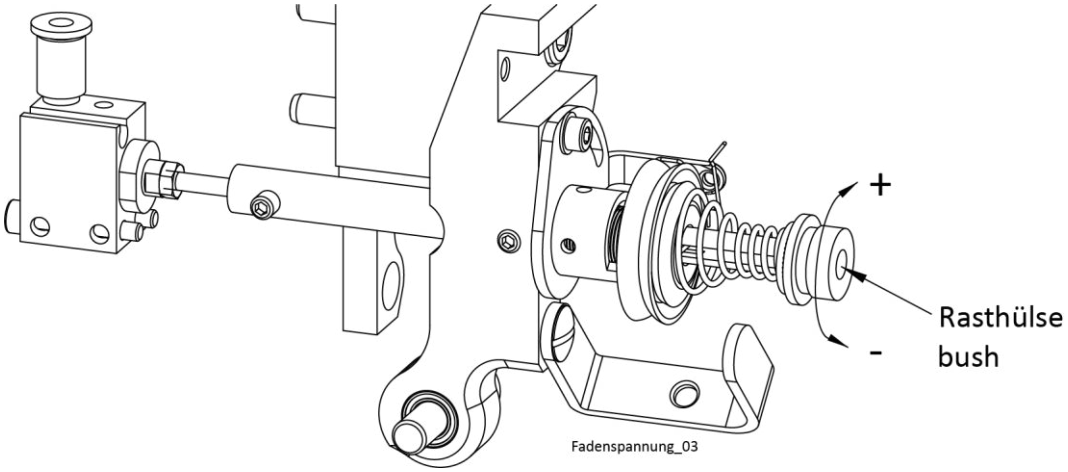
4.5 Thread tension

Depending on the thread thickness and properties of the sewing material, the thread tension is set to the desired stitch formation.

4.5.1 Thread tension – needle thread (Fig. 13)

The thread tension is set by turning the bush.

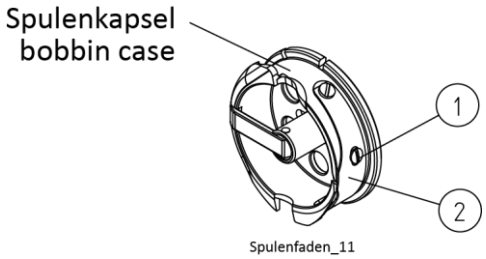
Fig. 13



4.5.2 Thread tension – bobbin thread (Fig. 14)

The flat spring (2) regulates the bobbin thread tension. The thread tension can be set for the bobbin thread by turning the flat headed screw with detent (1).

Fig. 14



4.5.3 Oil the hook (Fig. 15)

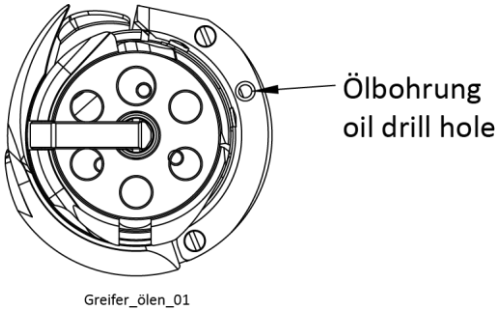
A T T E N T I O N !

Lubricate the hook every day with a drop of oil.

Lubricate the hook every day with a drop of oil at the oil drill hole.

Video: „Lubrication of the hook.MTS“

Fig. 15



Greifer_ölen_01

4.6 Operating control, general

Fig. 16

Button	Function
	Single- double backtack at seam start
	Backtack supression
	Single- double bartack at seam end
	Half stitch
	Switch to the next step in the teach-in mode
	Call the teach-in mode/Exit parameter input
	Save the programming (teach-in) and exit
	Needle up- down position
	Thread trimmer

4.6.1 Basic information

"P" button:

- Pressing the "P" button takes you to programming mode (teach-in) and the first value starts to flash on the display.
- The values for the plunger height, stitch depth and machine speed can be set using the A to D +/- buttons.
- Sewing can/must also be carried out in teach-in mode, as the corresponding stitch depth must be determined.
- The "P" button is also used to exit the parameter setting.

“OK“ button:

- Pressing the "OK" button confirms the change and takes you to the next input field.
- The values for the plunger height, stitch depth and machine speed can be set using the A to D +/- buttons.

“ESC“ button:

- The "ESC" button is used to exit teach-in mode and the values are saved in the corresponding sewing program.

Buttons “1-6“

- The Class 810 has 6 sewing programs that can be individually assigned a plunger value and a machine speed.
  During sewing, you only have to stop briefly and you can switch to any sewing program.

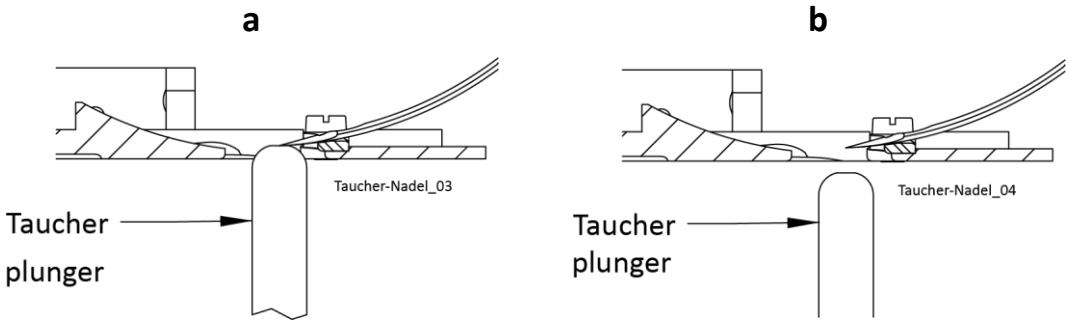
Stitch depth:

- Stitch depth is the distance between the highest plunger position and the outer radius of the needle. The plunger presses the fabric into the stitch plate opening from below so that the needle penetrates the fabric layers at the desired depth.
- The stitch depth can be set using the "+/-" buttons C and D in the programming button group block.
- In "1" increments (=0.01 mm) Button group D.
- In "10" increments (=0.10 mm) Button group C.
- The setting range of the plunger is from 0 - 254 = 0 - 2.54 mm.
  - „+“ = plunger moves down = needle penetrates less deeply
  - „-„ = plunger moves up = needle penetrates deeper
  - Basically the following applies: (Fig. 17)
    a) Small stitch depth – thin material / 0 = needle touches the plunger
    b) Large stitch depth – thick material / 254 = The plunger has 2.54 mm from the needle
- If the stitch depth is too shallow or too deep, skips or punctures may occur.

Stitch length:

- The stitch length can be set using the "+/-" buttons A and B in the programming button group block.

Fig. 17



4.6.2 General procedure for changing the following values (simultaneously):

- Stitch depth
- Machine speed
- Stitch length
  - Select sewing program (1 to 6)
  - Press the "P" button once and the stitch depth value flashes
  - Change the value using the "+/- " buttons block C and D
  - Press the "OK" button to confirm the value, save it and jump to the next value.

  INFO: You can also sew if the value is still flashing and has not yet been confirmed! This is used to find the correct setting.
- When you have finished, press the "ESC" button to exit programming mode.

4.6.3 Procedure for changing a certain value (e.g. machine speed):

- Press the "P" button once
- Press the "OK" button twice
- Change the machine speed value with the "+/-" button Block B, C and D
- B= step of 100
- C= Step of 10
- D= 1 step
- Press the "ESC" button once to save the change and exit programming mode.

4.6.4 Program number (button 1 to 6)

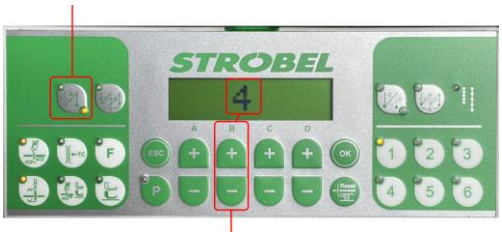
Sewing programs with different values such as stitch depth, stitch length and machine speed can be selected using the function buttons "1-6". It is also possible to change to a different sewing program while sewing. The sewing process must be stopped briefly, then you can switch to a new sewing program.

4.6.5 Backtack at the beginning

You can activate and deactivate the single- double start backtack using the " " button.

Single start backtack lower light on.

The number of backtack stitches can be changed using the "+/-“ buttons in block B.



Double start backtack both lights on.

The number of backtack stitches can be changed using the "+/-" buttons block A and B.

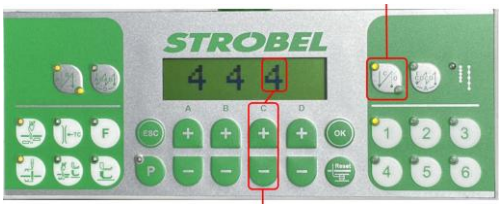
To deactivate the start backtack, both lights in the symbol must be off!

4.6.6 Backtack at the end

You can activate and deactivate the single- double end backtack using the " " button.

Single end backtack upper light on.

The number of backtack stitches can be changed using the "+/-“ buttons in block C.



Double end backtack both lights on.

The number of backtack stitches can be changed using the "+/-" buttons block C and D.

To deactivate the end backtack, both lights in the symbol must be off!

4.6.7 Thread trimmer

The thread trimmer is activated and deactivated by pressing the " " button once.

4.6.8 One-off backtack suppression

When the " " button is pressed at the beginning or end of the seam, the backtack stitch is suppressed once. The next time it is carried out again.

4.6.9 Single stitch

Only a half-stitch is performed when the button “ ” is pressed.

5 Operating the sewing machine (Fig. 18)

The machine is lifted pneumatically via the foot pedal. The stitching program sequence is automatic.

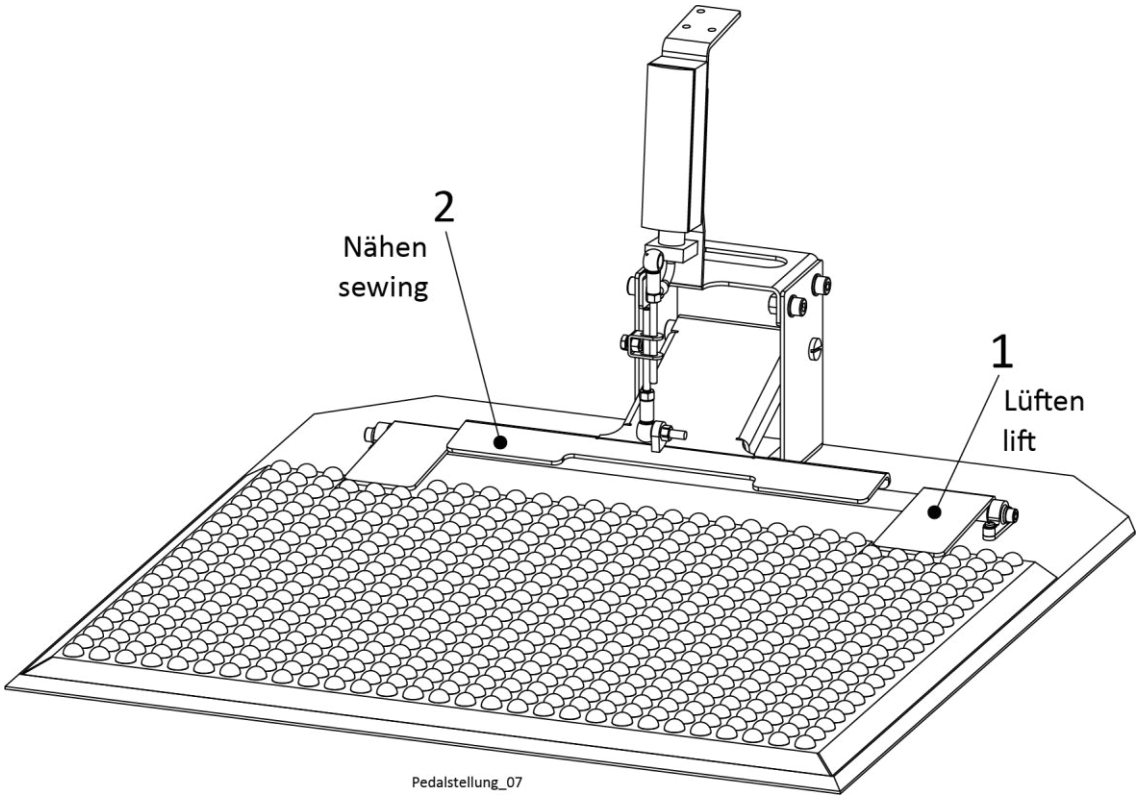
C A U T I O N ! Danger of injury!

During sewing, exercise appropriate caution and observe the sewing area!

Otherwise there is a **danger of injury** by crushing and needle punctures.

The lifting is always closed when the machine is switched on.

Fig. 18



5.1 Switching on

A T T E N T I O N !

The machine may not be switched on without compressed air connected. The operating pressure is 6 bar.

Switch on the control box or main switch on the right under the table top. The control lamp lights up.

5.2 Insertion and removal of sewing material

Press the pedal (1) to lift the bottom belt feed and the thread tension.

Now you can insert the sewing material between the stitch plate and the bottom belt feed.

Releasing the pedal closes the lifting of the bottom belt feed.

To realign the sewing material, press the pedal (1) again so that the bottom belt feed lifts, and then release the pedal again.

Now you can start sewing by pressing the pedal (2).

When the stitch is finished step on the pedal (1). It is positioned automatically. The thread is cut off, the bottom belt feed is lifted and you can remove the sewing material.

A T T E N T I O N !

Do not let a threaded-in machine run without sewing material!

5.3 Sewing

5.3.1 Sewing a car seat cover/sewing on "TieDown"

If no previous experience has been gathered, proceed as follows.

- When the machine is switched on, you are in one of the six sewing programs. Select a sewing program and then press the "P" button on the OP1000 control panel to enter Teach-in mode/programming mode.
- Place the car seat cover together with a "TieDown" between the stitch plate and the belt underfeed and align the "TieDown" with the material guide
- Now set the desired stitch depth with the "+/-" button, sew a piece and then check the sewing result. If the sewing result matches the stitch depth, press the "OK" button once. If the sewing result does not match the stitch depth, this must be corrected until the sewing result matches.
- You can now set the stitch length and then press the "OK" button.
- You can now set the speed and then press the "OK" button.
- When you are finished with all the settings, you can press the "ESC" button once to exit programming mode and save the selected seam program.

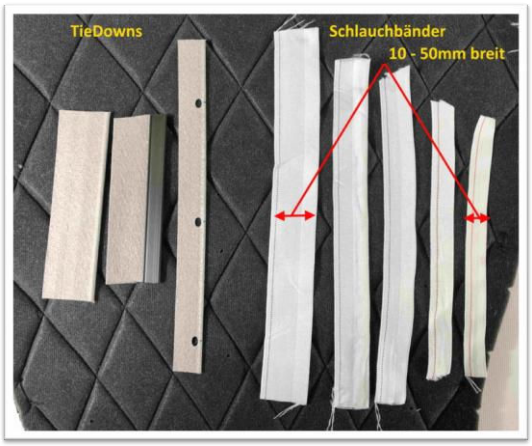
Avoid jerky sewing.

5.3.2 Swing-type material guide

5.3.2.1 General notes

The swing-type material guide is for sewing tubular tapes and TieDown for seat covers.
The swing-type material guide can be retrofitted to the Cl. 810C from version 1.

Fig. 19



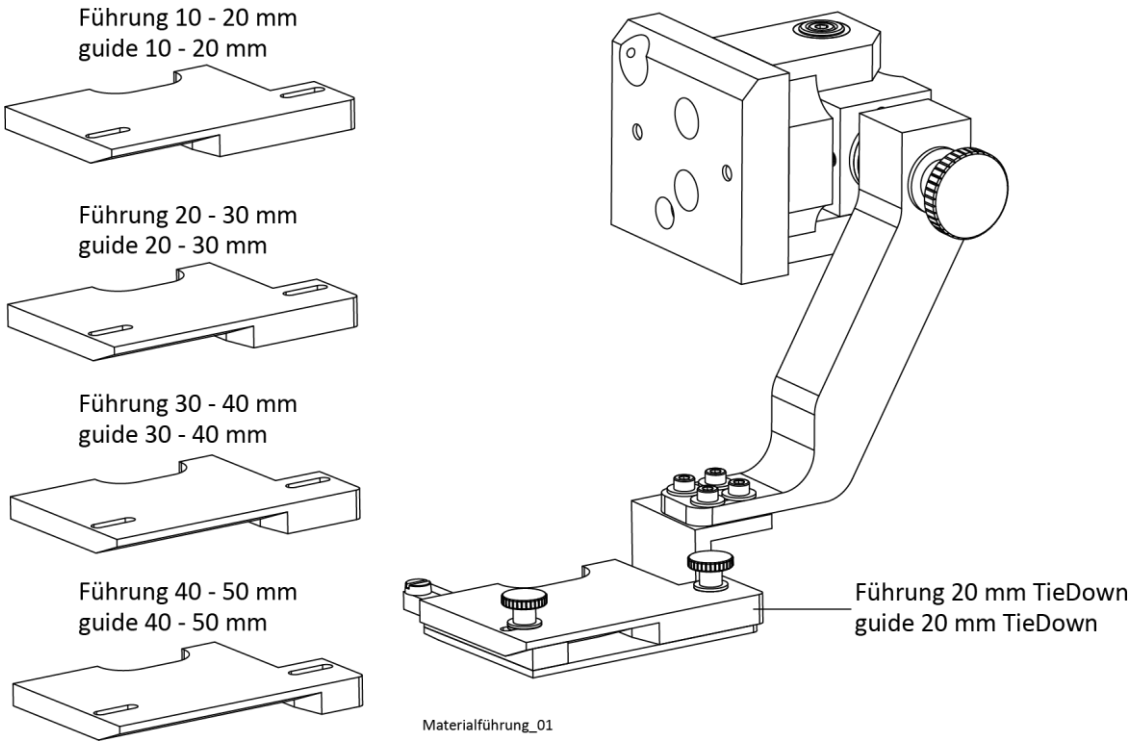
5.3.2.2 Structure of the material guide

To cover the range of tubular tapes we have 4 interchangeable guides.
There is a special guide for processing 20 mm TieDown.
Please note! For 20 mm TieDown the stitch plate 280.0298 is required.

The guides are easy to change.

1. 15 mm tubular tape guide is adjustable from 10 mm to 20 mm.
2. 25 mm tubular tape guide is adjustable from 20 mm to 30 mm
3. 35 mm tubular tape guide is adjustable from 30 mm to 40 mm
4. 45 mm tubular tape guide is adjustable from 40 mm to 50 mm
5. 20 mm guide for TieDown.

Fig. 20



5.3.2.3 Functional description

The aim of the material guide is that after inserting/positioning the tubular tape or the TieDown, sewing is necessary without additional manual guiding by the machine operator.

After positioning the seat cover under the stitch plate and then inserting the tubular tape or the TieDown into the material guide, the release of the belt feed is cancelled and the belt feed closes.

Now the sewing process can be started until the TieDown/tubular tape is sewn.

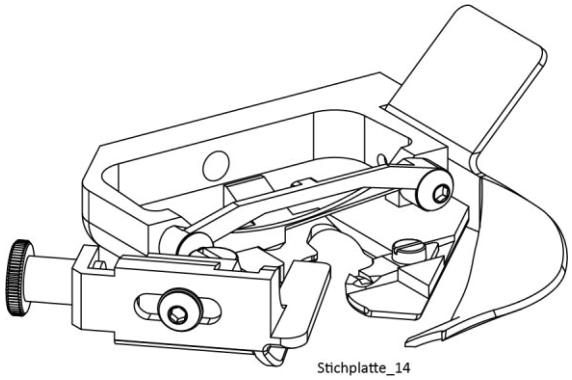
When there are markings on the seat cover, the machine operator can concentrate on sewing and no longer has to worry about guiding the tubular tape or the TieDown.

5.3.2.4 Mounting

Video: „Mounting swing-type material guide“

5.3.3 Stichplatte

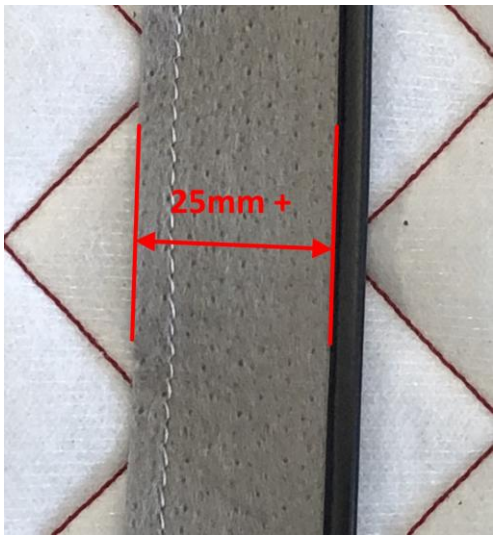
Fig. 21

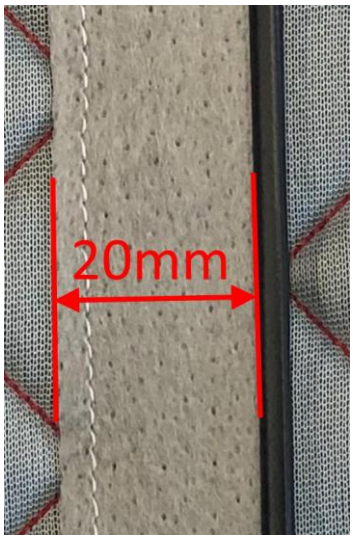


For the processing of TieDown from 25 mm width the stitch plate 280.0294 (standard in version 1) can be used.

For the processing of TieDown from 20 mm width the stitch plate 280.0298 (standard from version 2) is required.

Fig. 22





5.3.4 Thread trimming

After thread trimming, the bobbin thread, if not caught in the felt, must be visibly on the right side.

Please note: Otherwise there is a possibility that the thread will get jammed in the hook when continuing to sew and the hook will block.

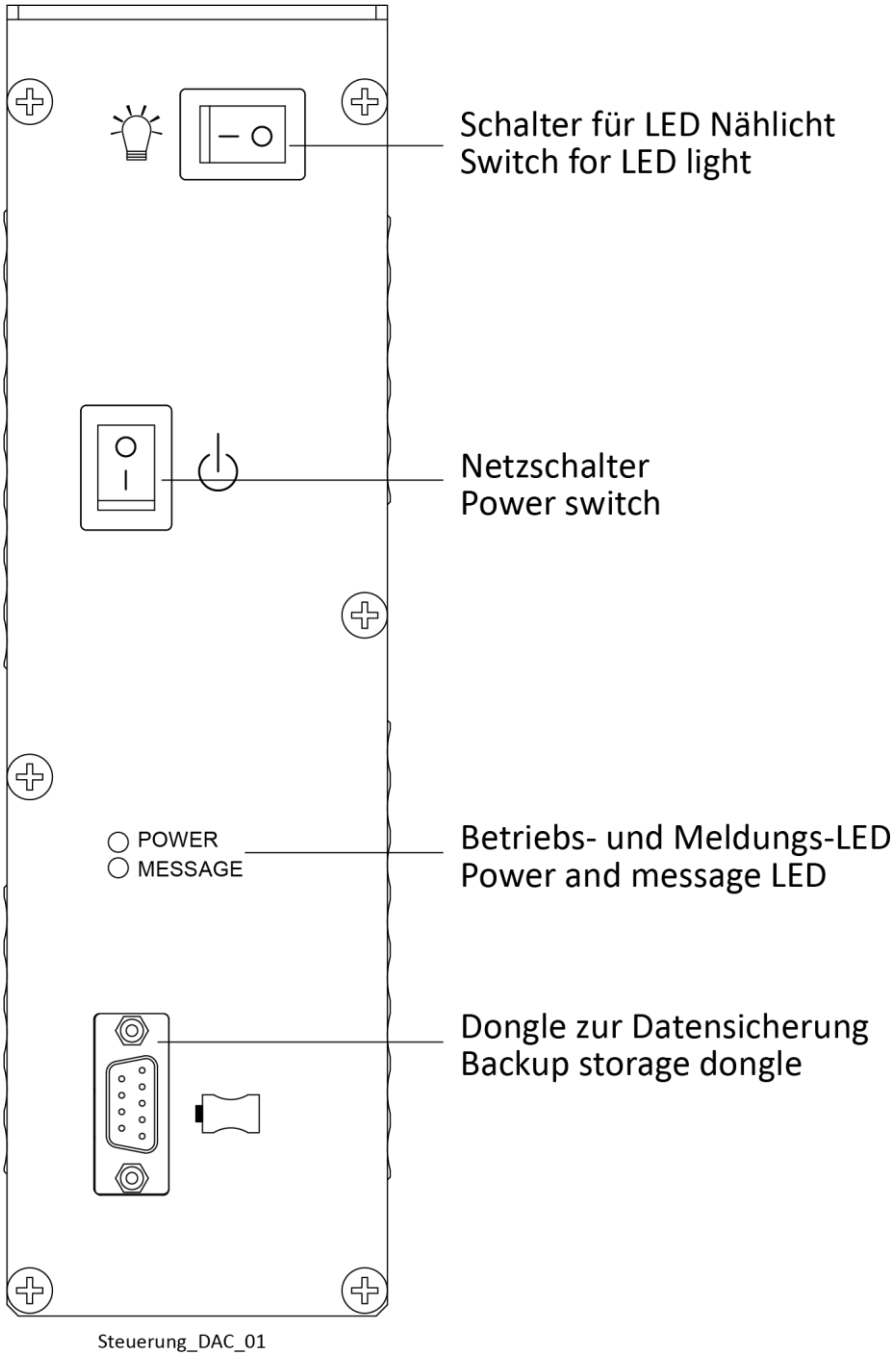
5.4 Sewing drive

The machine is equipped with a DA432 sewing drive motor and a DAC Classic sewing drive control unit.

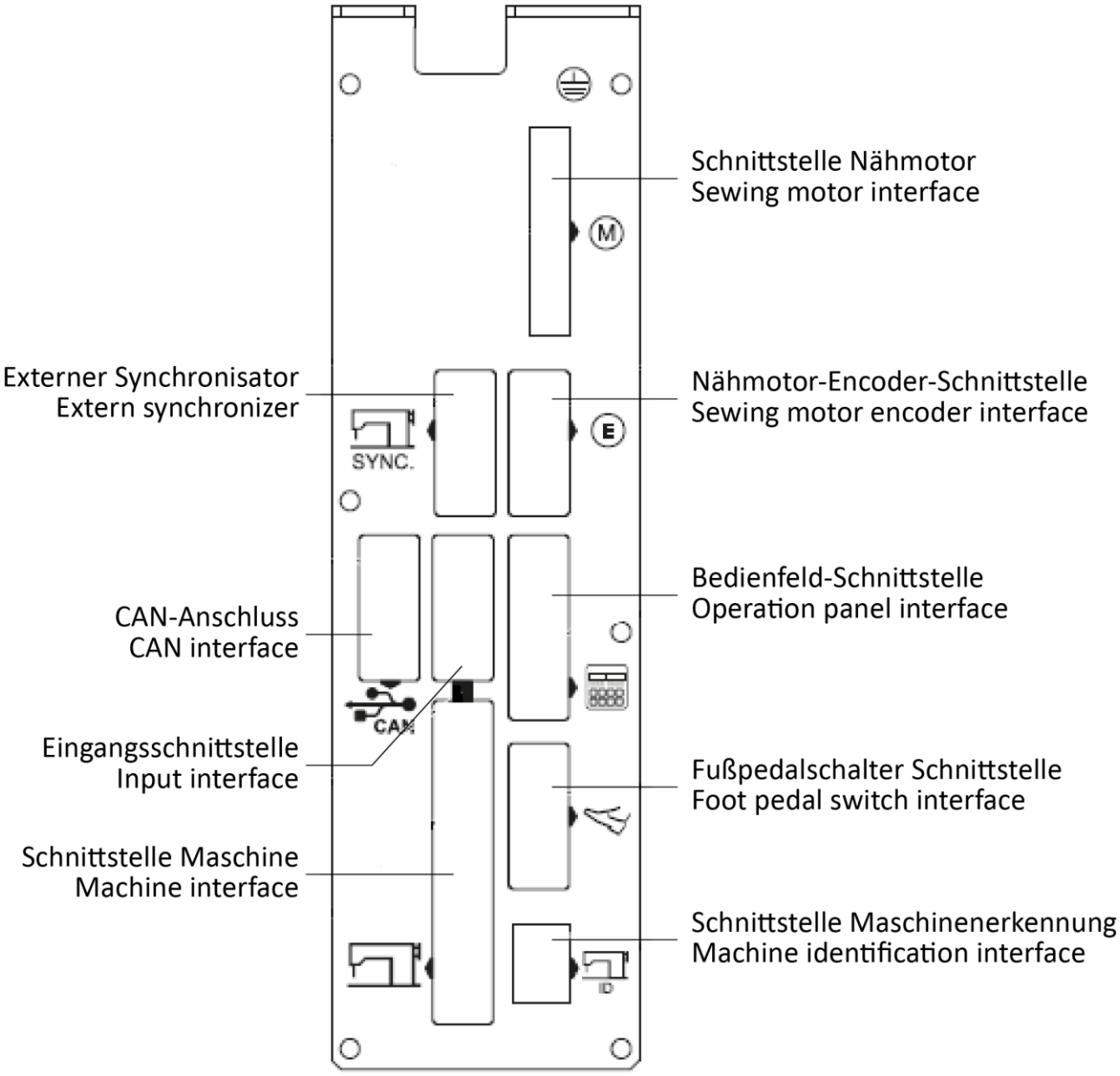
5.4.1 Control sockets control box (DAC Classic)

Fig. 23

Front side



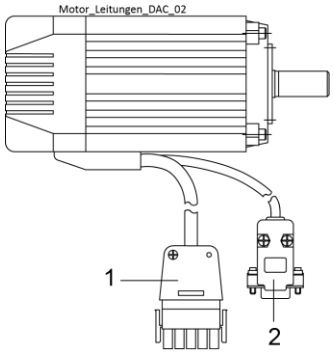
Back side



Steuerung_DAC_02

5.4.2 Connection cables motor sewing drive (DA432)

Fig. 24



1 Cable 1 for motor supply

2 Cable 2 for motor sensors

5.5 Sewing problems and troubleshooting

C A U T I O N ! Danger of injury!

Before threading, switch off the machine electrically and depress the motor switch pedal to make sure that the machine is truly switched off.

Otherwise there is **danger of injury** by crushing and needle punctures.

- **Thread breakage**

  Possible causes:

  - Sharp edges or grooves in the needle guide, thread take-up lever, hook or needle's eye after the machine has been used for a long time
  - The thread between hook and bobbin case breaks or is cut off
  - The bobbin is too tight, or the bobbin walls are pressed apart by too tightly wound thread
  - Bobbin case lifting or hook bridge are not set correctly
  - The hook to the needle or the loop stroke have not been set correctly or have moved, and therefore the thread loop is not always caught
  - The thread tension is set too lightly or too tightly

  Solutions:

  - Replace or repolish the damaged parts
  - Remove the hook, remove the bobbin case and polish the infeed edges of the bobbin case and the hook race
  - Insert new bobbin
  - Turn the machine slowly by hand and check whether the loop is gliding unhindered over the hook; if not, readjust bobbin case lifting or hook bridge
  - Correct the hook setting or loop stroke
  - Correct the thread tension, check the straight grain

  CAUTION! Straight grain, thread, stitch plate with corresponding plunger and cloth retainer, approved needle and thread tension must correspond to the sewing material being processed!

- **Imprecise stitching**

  Possible causes:

  - Worn or damaged needles
  - Height of stitch plate or needle guide is incorrectly set

  Solutions:

  - Replace damaged needle. Check settings, correct if necessary; select correct needle thickness SRUE 1717 – 110/18

- **Loops are left out**

  Possible causes:

  - Incorrectly adjusted or misaligned hook
  - Loop stroke too small or too big

  Solutions:

  - Turn the machine by hand and check the hook movement; in most cases, the cause can be seen
  - Also correct the thread tension or thread take-up spring if necessary
  - Correct the loop stroke

- **Loops are stopping (hook is knitting)**

  Possible causes:

  - Thread tension too light
  - Needle does not penetrate

  Solutions:

  - Check the thread tension or thread take-up spring
  - Check the stitch plate (also for interval stitch)

- **Machine does not start**

  Possible causes:

  - Control box error
  - Mechanical damage
  - Handwheel blocked

  Solutions:

  - Turn the machine off and back on again
  - Eliminate any mechanical faults
  - Check the programming. If necessary, call customer service

- **The sewing result does not meet your expectations**

  Possible causes:

  - Damaged sewing tools, wear due to improper use, or normal wear after prolonged use of the machine
  - Machine has lost its mechanical settings
  - Unsuitable needle thickness (see point "4.1 Needle")
  - Unsuitable sewing thread (see point "4.1 Needle").

  Solutions:

  - Replace damaged parts, customer service
  - By a technician; see also Technician's Manual; call customer service if necessary
  - Replace needle. Also check needle point for damage.

- **Plunger**

  Possible causes:

  - The plunger does initialise any longer

  Solutions:

  - Check plug for correct fit on the control box
  - Switch off machine, wait 20 seconds, and then switch on again
  - Contact manufacturer

6 Servicing the machine

6.1 General

C A U T I O N ! Danger of injury!

Disconnect the machine from the mains and ensure that it is off by pressing the pedal for switching the motor.

Otherwise there is a **danger of injury** through crushing and needle stitches.

A T T E N T I O N !

The maintenance instructions according to the operating instructions must be followed!

A T T E N T I O N !

If you release or even loosen positions that are marked in yellow, important factory settings can get lost!!

These screws do not have to be released for maintenance work.

If, however, you do release these screws, please contact the manufacturer.

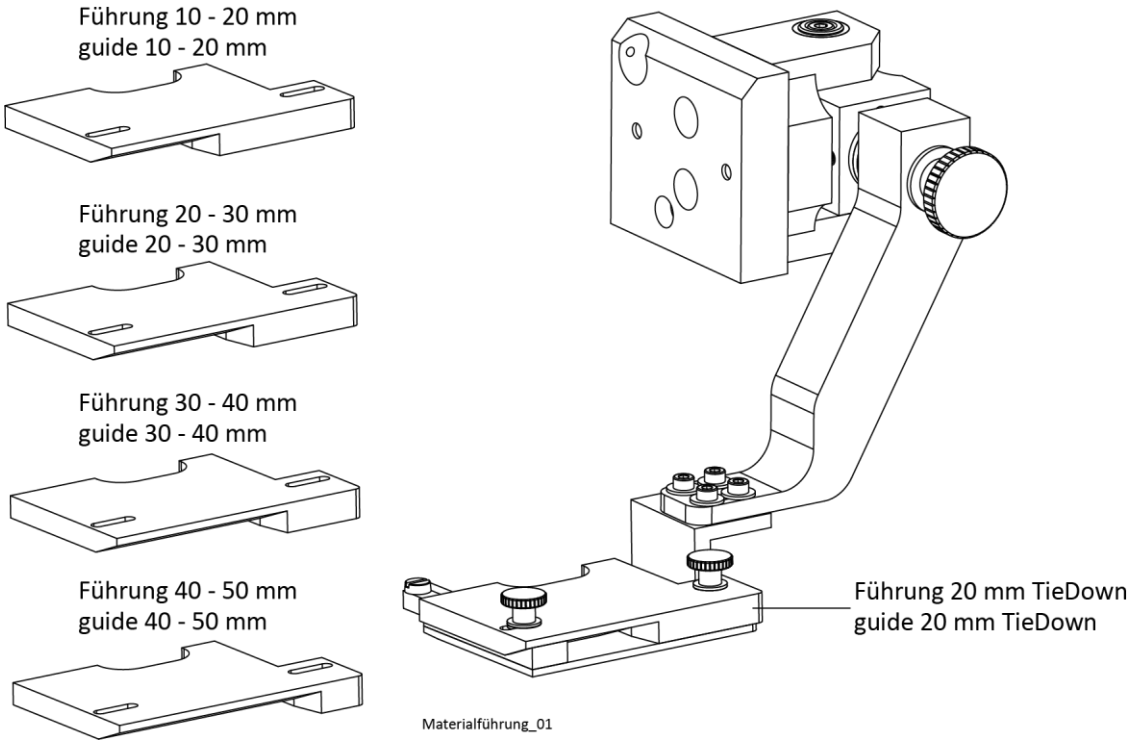
Fabric fibres and dirt that accumulate on the moving parts of the machine must be removed, as they can cause malfunctions and impair operational safety.

The hook race should also be lubricated from time to time with a drop of oil. There is a drill hole for this in the hook cover.

7 Optional extras

The following devices are available as optional extras and can be ordered together with the machine or as separate kits.

7.1 Swing-type material guide 286.0468



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und

weitere Spezial-Nähmaschinen

For the clothing industry:

Single and two thread high performance hemming machines

Bluff edge hemming machines

Two thread blind stitch felling machines

Roll and flat padding machines

Automatic lapel padding machine

and other special sewing machines

Für die Schuhverarbeitung:

Einfaden-Überwendlichmaschinen mit und ohne Differentialtransport

For the shoe industry:

Single-thread overseaming machines with and without differential feed

Für Kürschnereien und Pelzkonfektion:

Pelzschnellnäher

For the fur industry:

High-speed fur sewing machines

Für Heimtextilien:

Ein- und Zweifaden-Blindstichmaschinen

For the home textiles industry:

Single and two thread blind stitch machines

Für die Polsterverarbeitung:

Ein- und Zweifaden-Überwendlichmaschinen

Ein- und Zweifaden-Blindstichmaschinen

For the upholstery industry:

Single and two thread overseaming machines

Single and two thread blind stitch machines

Für die Konfektion technischer Textilien:

Ein- und Zweifaden-Überwendlichmaschinen

For the processing of technical textiles:

Single and two thread overseaming machines

Noch Fragen?

Dann rufen Sie uns an, schreiben Sie uns oder kommen Sie einfach bei uns vorbei.
Sie können jederzeit weitere Informationen über unsere Produkte anfodern oder die Strobel-Nähmaschinen in unserem Ausstellungsraum live erleben. Wir freuen uns auf Sie!

Any further questions?

Then phone, write or simply come and see us. You can have further information about our products at any time, or experience the Strobel machines live in our show room. We're looking forward to meeting you!

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