For the professional user

Operating Instructions

Für den professionellen Anwender

Betriebsanleitung

Class: **VEB100-6**
Klasse:

Model: **4**
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: _____

_____

_____

_____

_____

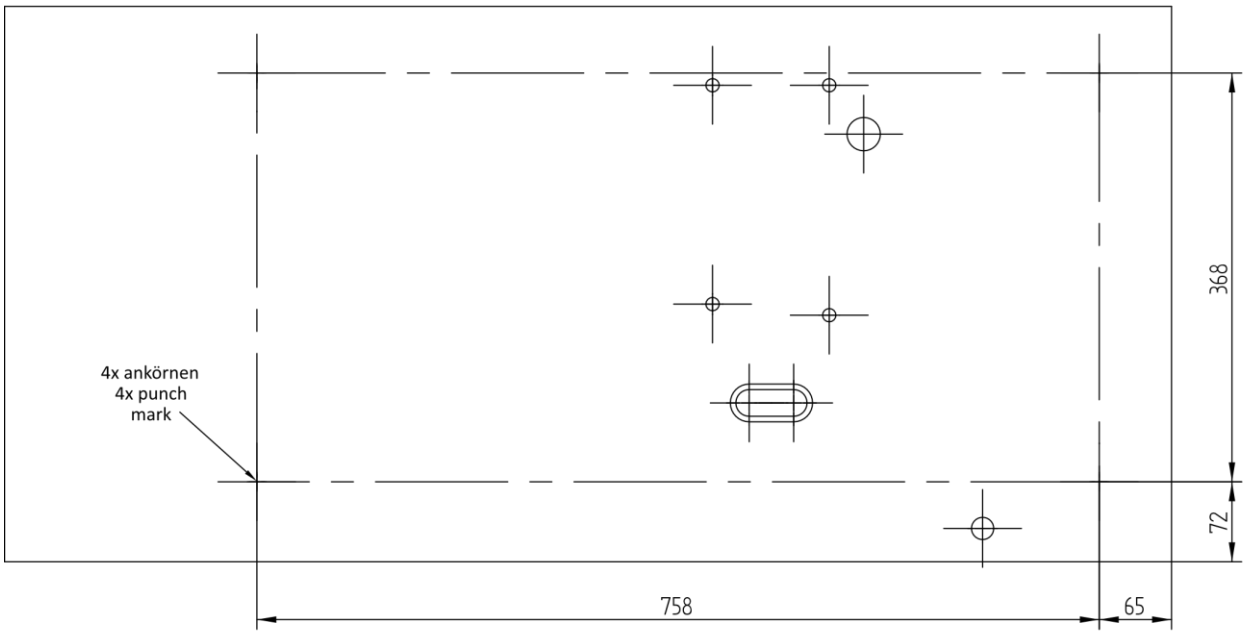
_____ _____

Datum/Date Unterschrift/Signature:

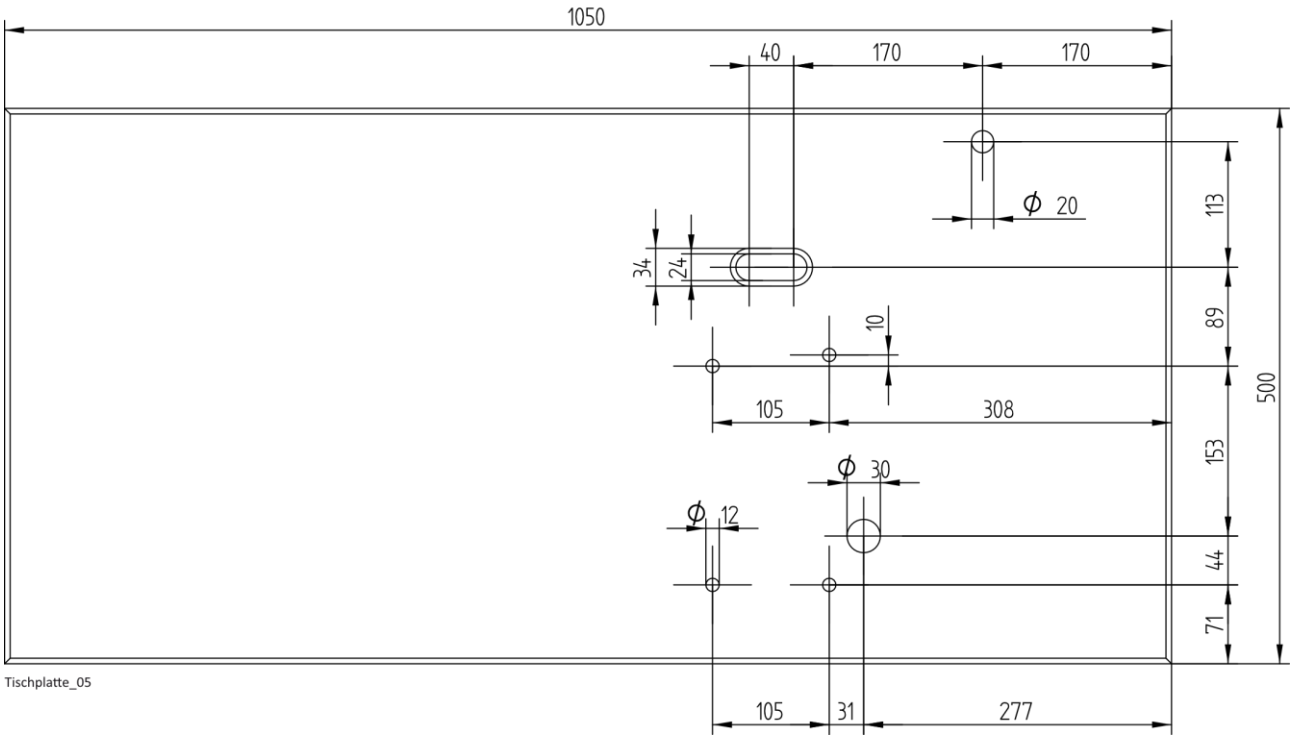
Bitte nicht vom Kunden ausfüllen/To be filled out by Strobel:

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

Unterseite/underside



Oberseite/upperside



Tischplatte_05

STROBEL

Operating instructions
STROBEL-Class VEB100-6

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Subject to change without prior notice

1 General safety instructions

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

2.1 Operating instructions

Any person involved in the installation, operation, maintenance and repair of the machine must have read and understood the operating instructions and mainly the safety instructions before starting the machine.

2.2 Class description, serial number and initial basis for description

Für seitenbezogene Beschreibung ist die Bedienungsseite der Maschine die Ausgangsbasis.

The class identification (type) as well as serial and model number (after the dash) are located on the frontside of the housing.

2.3 Range of application and intended use

For blindstitching a tape coated on one side for example to front parts of sack coats or for attaching facings.

After switching the function “Sewing with tape“ off, the machine is also ready for use for other sewing tasks.

2.4 Power supply

2.4.1 General notes

C A U T I O N !

Work on the sewing machine's electrical equipment or sewing drive may only be done by electricians!

There is the **DANGER** of a fatal electrical shock.

When working on the electrical equipment, the machine with the S1 power switch has to be switched off and the power plug pulled out!

The operating instructions (including safety instructions) of the sewing machine and sewing drive must be observed!

2.5 Technical data

	Empfohlene Nennstichzahl / Recommended rated speed	1800 min-1
	Stichlänge / stitch length	3,0 - 7,0 mm (abhängig vom Nähmaterial / depend on fabric) Auslieferzustand / delivery condition 7,0 mm
	Obertransport / top feed	Sägeverzahnung / saw thoothing Pyramidenverzahnung / pyramid thoothing optional
	gefederter Drücker / spring loaded plunger	Drückervariation optional /plunger variation optional
	Stichplattenöffnung / needle plate opening	6,0 mm
	Stichtiefenanzeige / stitch depth display	digital display optional
	Intervall mit Stichtiefenregulierung / skip stitch with depth regulation	1:2
	Nadelsystem / needle system Nadelstärke / needle size	GROZ-BECKERT 1669 EEO 90/14
	Fadenabschneider / thread trimmer	
	Fadenspannung / thread tension Faden / thread	Auslieferzustand / delivery condition 6 cN Polyester, endlos gezwirnt / polyester continuous filament 120/2
	Automatische Bandeinführung und Bandschere / automatic tape feeding and cutting device	
	Bandführung / tape guide	15 - 25 mm einstellbar / adjustable Auslieferzustand für 15 mm Bandbreite / delivery condition for 15 mm tape size
	Einblasdüse / tubes	bis 25 mm optional Auslieferzustand 15 mm / delivery condition 15 mm
	Nahtlängenprogrammierung bis 254 Stiche / programable seam length up to 254 stitches	
	Durchgangsraum / arm space	150 mm
	LED Leuchte / LED sewing lamp	

Technischer Auslieferzustand / delivery condition:	
Motor-Leistung min. / min. motor power	550 W
Zahnriemenscheibe Maschine / toothed belt pulley/machine	Z = 38
Zahnriemenprofil / toothed belt profile	HTD 5M-9
Stichart / stitch type	Einfaden-Kettenstich-Blindstich Typ 103 / single thread chain stitch type 103
Anschluss pneumatisch / pneumatic connection	6 bar
Luftverbrauch, Mittelwert / avarage air consumption	95 l / h
Stellfläche / foot print	0,5 m x 1,1 m
Arbeitsgeräusch / operating noise at 2200 min-1 nach DIN 45635-48-1 KL3	LpAm 71 dB(A)

3 Installation and putting into service

3.1 Unpacking

Strobel machines are supplied either as complete units with head, stand and motor, or head with motor only, or the head only.

Due to the high weight and to avoid damages during transport, complete units are packed in several smaller cartons.

Machine head is removed from the stand. Reel stand, rods and other accessories are packed into the stand packing.

Make sure that all accessories have been unpacked before throwing away any packing material.

3.2 Installation (Fig. 1 and Fig. 7)

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

Danger of bodily injuries or finger bruises through pulling in of garments or hairs!

The machine may not be operated without belt guards for head and motor.

The tape feeding device is mounted to the machine head according to Fig. 7 (screw (2)). The pneumatic devices are connected according to the given numbers. The 3-pole diode plug is connected to the 3-pole diode socket at the machine.

Make sure that all screws on the stand are tight and retighten them, if necessary.

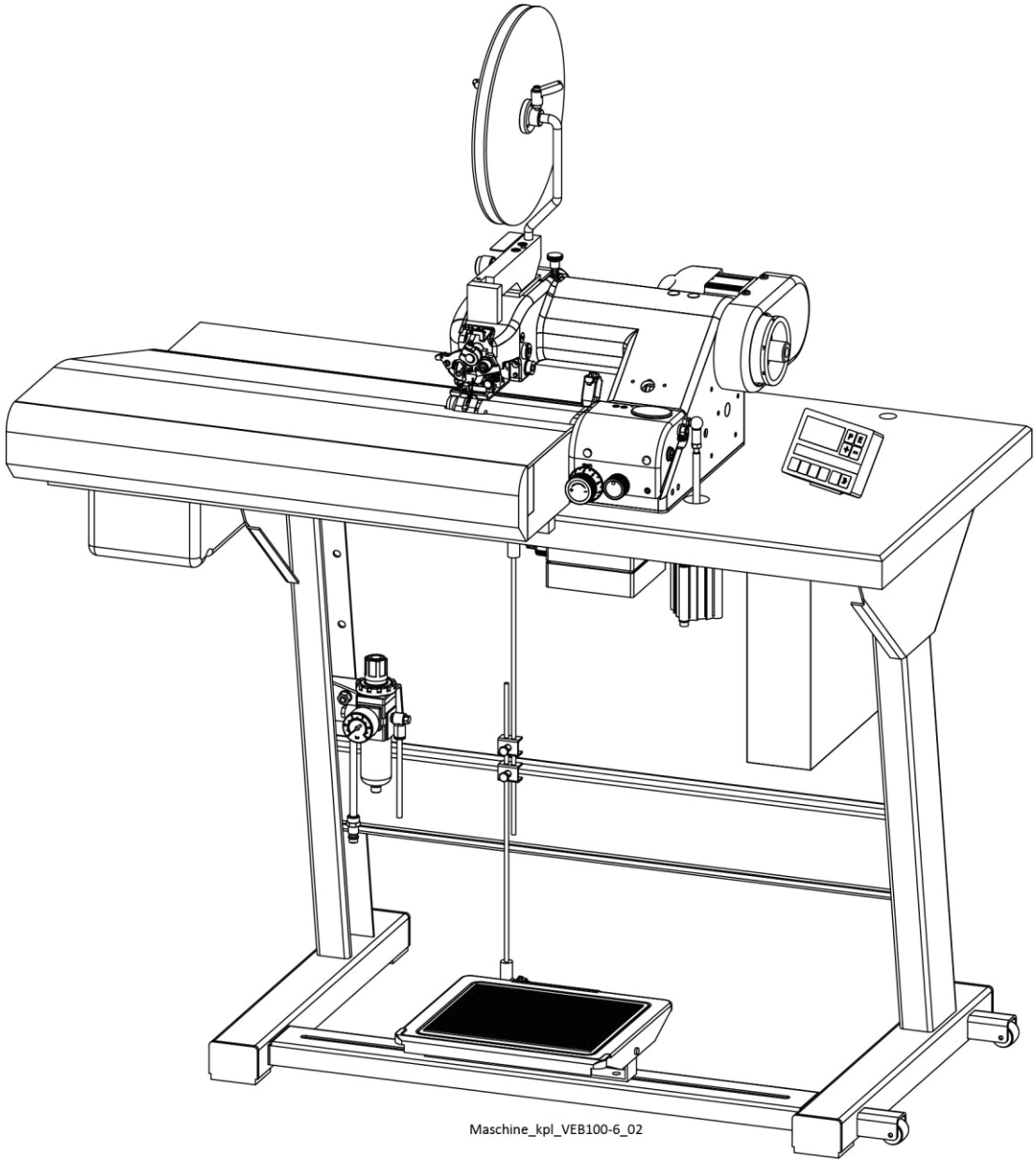
A T T E N T I O N !

Before putting the machine into service make sure that the electric connecting data on the sewing drive's name plate, mainly voltage and frequency, correspond to your electric network.

A T T E N T I O N !

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

Fig. 1



3.3 Sense of rotation

The correct sense of rotation of the handwheel is clockwise (clockwise rotation).

3.4 Motor drive via Toothed belts

3.4.1 Toothed belt tension (Fig. 2)

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

When checking the belt tension, switch off the machine at the mains. Do not operate the machine without the belt guard. Otherwise there is a **D A N G E R** of crushing fingers, of injuries to the body and of pulling in parts of clothing.

The machine may not be operated without belt guards for motor.

The toothed belt should not be too tight. It should give about 5 mm when slightly pressing with the thumb.

Too little or too tight toothed belt tensioning can impair the positioning of the machine and therefore impair the function sequence.

Tensioning the toothed belt (Fig. 2):

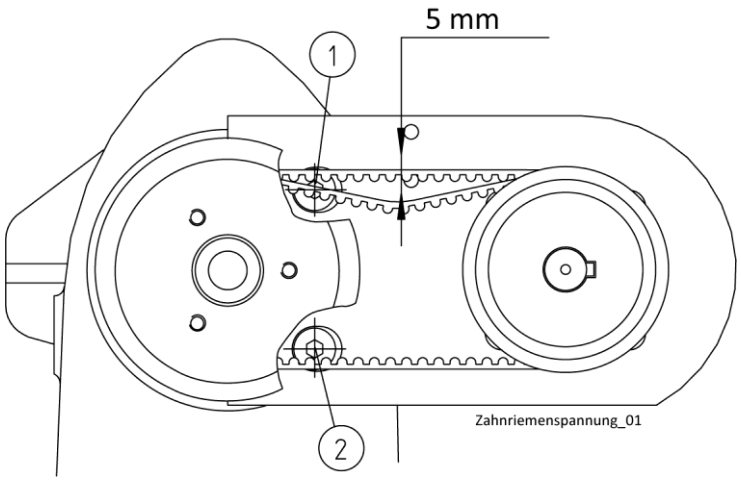
Release the upper and the bottom retaining screw (1), (2) at the upper part of the machine.

Pull out the motor slightly and tighten the bottom retaining screw (2) slightly.

Tension the toothed belt by swivelling the motor.

Tighten the upper and the bottom retaining screw (1), (2) again.

Fig. 2



3.4.2 Positions (Fig. 3, Fig. 4 und Fig. 5)

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

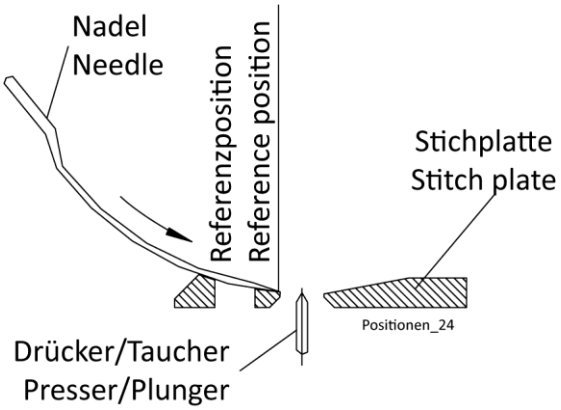
Danger of pulling in parts of clothing and of hair and **danger** of crushing fingers and stitching fingers with needles!
When checking positions with switched-on machine keep fingers and hands away from moving parts.

The machine requires a needle position and depending on the sewing drive, possibly also a reference position.

Reference position (Fig. 3):

The reference position must be set in such a way, that the point of the needle in direction of the insertion stitch closes with the right (inner) edge of the needle slide plate.

Fig. 3

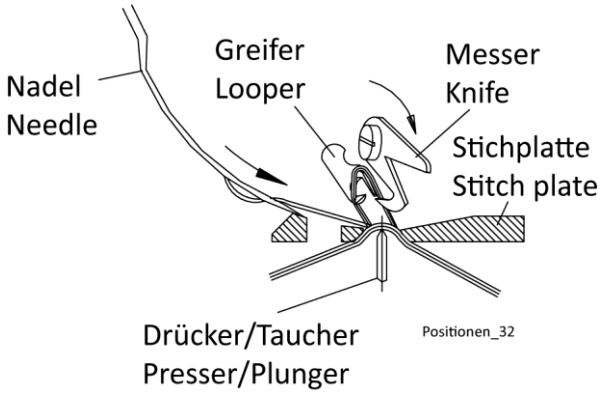


Needle position (with stop in and outside the seam (Fig. 4)):

The needle position must be set in such a way, that when the machine is stopped, the hook of the thread knife catches the thread loop lying over the looper securely without touching the looper.

Please check by manual activation of the thread trimmer afterwards.

Fig. 4

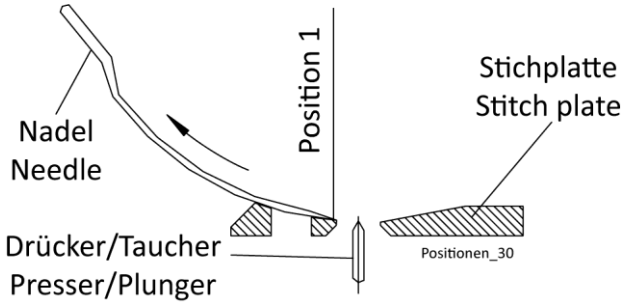


Notes for sewing drives which have two needle positions (Fig. 5):

The above mentioned needle position is position 2 at the sewing drive.

Position 1 must be set at the sewing drive in such a way, that the point of the needle (1) in the direction of stitch exit closes with the right (inner) edge of the needle slide plate. At the same time, the thread loop lies tensioned over the looper.

Fig. 5



4 Machine operation

4.1 Needles, threads and tapes

The sewing quality can be influenced to a considerable extent by choosing the most suitable needles and threads for the material to be sewn.

It is recommended to use controlled GROZ-BECKERT needles system 1669 EEO only.

The machine is supplied with size 90/14 needles.

NOTICE: A perfect needle is of great importance for a good sewing result. Damages of the needle point which often can be made visible under a magnifier only may deteriorate the sewing result. Replace the needle in time!

We recommend twisted polyester filament threads of size 120/2 respectively. Because of their high strength and ability to slide, combined with a low volume they are to be preferred over a spun thread.

For safety and function reasons, only common commercial coated attaching tapes between 15 and 25 mm width should be used according to the width of the tape device.

G u a r a n t e e d r e m a r k !

This machine has been set and sewn off with **genuine GROZ-BECKERT needles**.
No guarantee can be granted if the settings are modified for using different needle types.

4.2 Inserting the needle (Fig. 6)

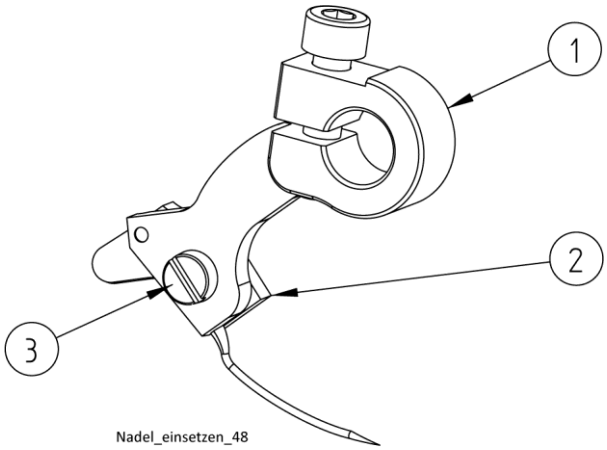
C A U T I O N ! Danger of Injury!

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 needle shape determines its position in the needle lever (1). Attention should be paid only to ensure that the needle piston is pushed to the stop in the channel of the needle lever and that the screw (3) Fig. 6 of the needle clamping plate (2) is tightened well.

Fig. 6



4.3 Threading and thread course (Fig. 7)

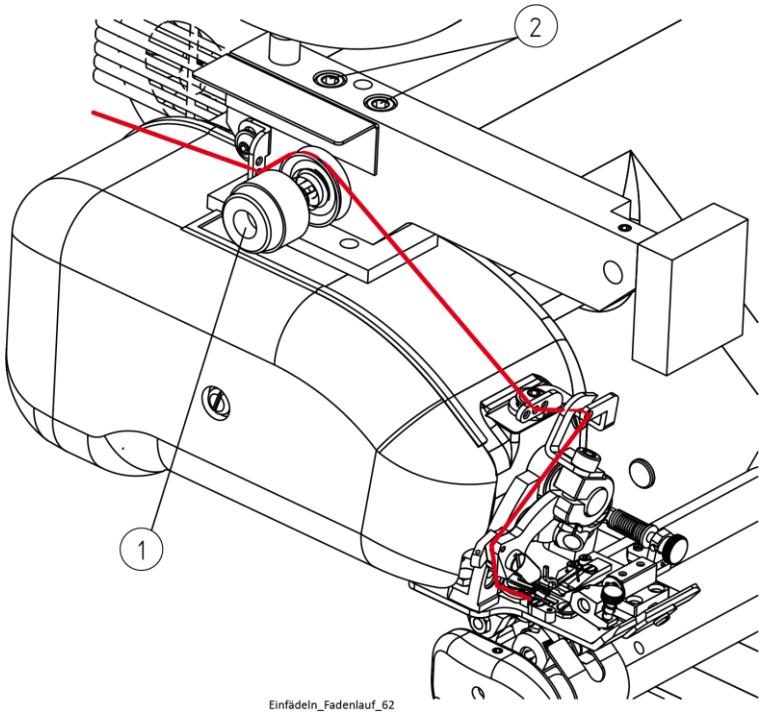
C A U T I O N ! Danger of Injury!

Switch off machine electrically and confirm that the machine is really in standstill position by operating the treadle for the motor control before threading.

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

Fig. 7 shows the correct thread course.

Fig. 7



4.4 Thread tension (Fig. 7)

Depending on thread and fabric quality, nature and thickness the thread tension is set by tension nut (1) (Fig. 7)

4.5 Tape course, inserting the tape and tape exchange

4.5.1 Tape course (Fig. 8 and Fig. 9)

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

Keep fingers and hands away from movable parts when inserting the tape with the machine switched on.

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

At factory the machine is set to a standard tape with of 15 mm. Modification to another tape (optional) width is possible.

After sewing on the ribbon with blind stitch, the blind stitch gives the looseness of the ribbon on the jacket front and after ironing, the coated upper side of the ribbon is fixed to the facing.

Fig. 8 shows the correct tape course.

After loosening clamping lever (2) Fig. 9 and removing tape roll plate (3) the tape roll can be pushed onto the roll (4). Then re-mount the tape roll plate (3).

PLEASE OBSERVE: The tape roll (4) should rotate easily, therefore please leave a corresponding distance between tape roll and tape roll plate (approx. 1 to 2 mm).

Fig. 8

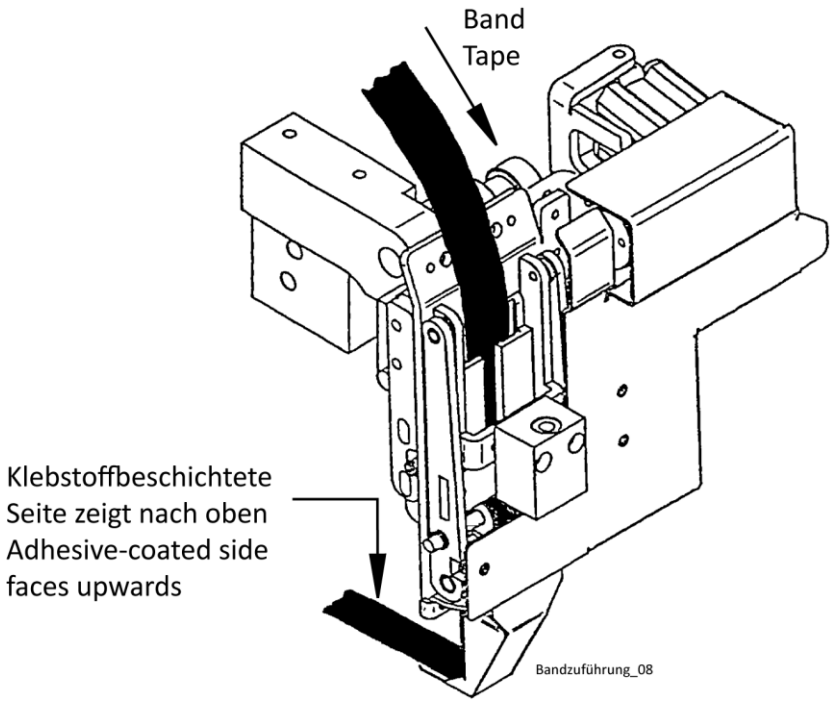
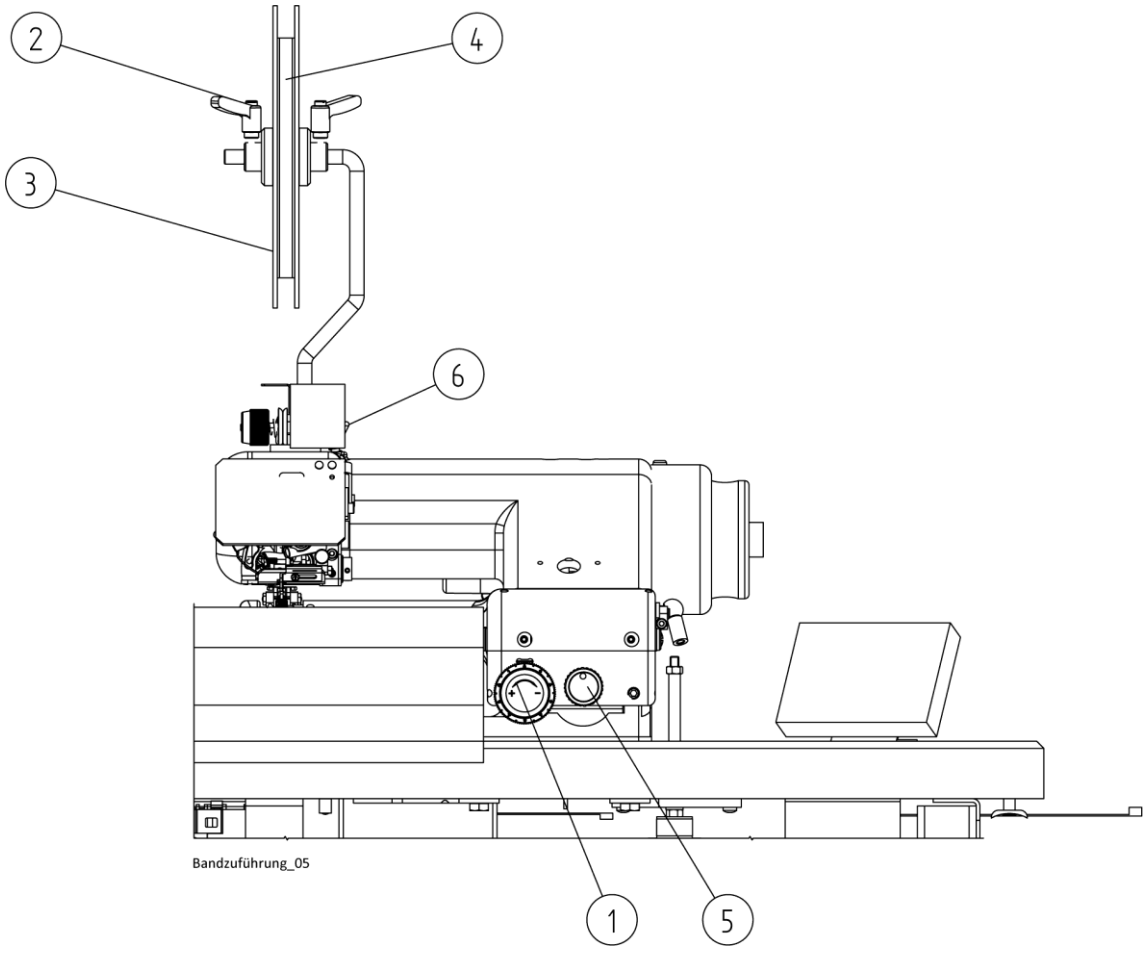

Band
Tape
Klebstoffbeschichtete
Seite zeigt nach oben
Adhesive-coated side
faces upwards
Bandzuführung_08

Fig. 9


2
4
3
6
Bandzuführung_05
1
5

4.5.2 Inserting the tape (Fig. 10)

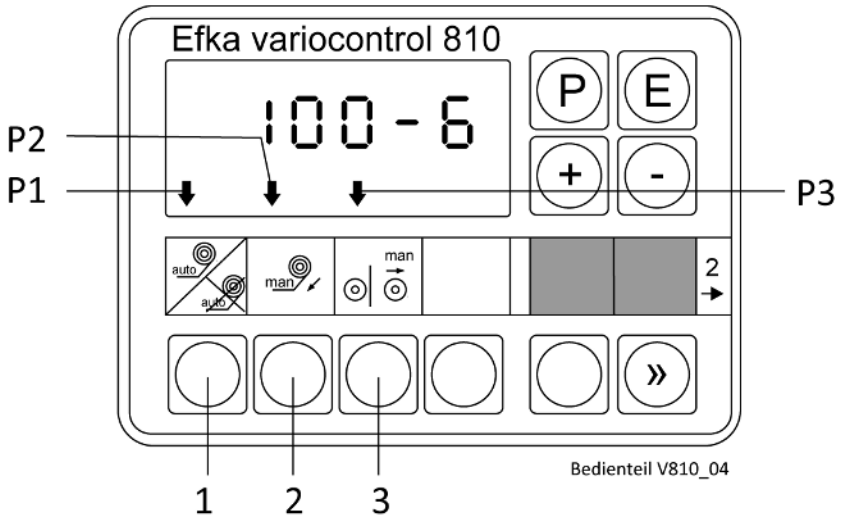
Proceed as follows to inserting the tape:

Sewing machine is away from the stitch in pos. 2, sewing with tape is switched on and the lifting is open:

- Manually insert the tape up to the tape transport into the tape clamp and hold lightly.
- Press button “2” and keep pressed until the tape is pulled along from the tape transport roll and transported under the stitch plate.

NOTES: It may be necessary to still push the tape a little by hand at the beginning until the tape is securely transported by the tape transport roller.

Fig. 10



Button 1	“Sewing with tape” function
P1	Indication whether “sewing with tape” function is ON/OFF.
Button 2	“Tape feed on” function
P2	Indication whether “Tape feed on” function is ACTIVE.
Button 3	“Open tape clamp” function
P3	Indication whether “Open tape clamp” function is ON/OFF.

4.5.3 Tape exchange (Fig. 10)

Proceed as follows to exchange the tape:

Sewing machine is away from the stitch in pos. 2, sewing with tape is switched on and the lifting is open:

- Press button “3” on the V810 operating control. Tape clamp is opened.
- Pull tape out of the tape clamp guide and exchange the tape roll.
- Manually insert the new tape up to the tape transport into the tape clamp and hold lightly.
- Press button “2” and keep pressed until the tape is pulled along from the tape transport roll and transported under the stitch plate.

NOTES: It may be necessary to still push the tape a little by hand at the beginning until the tape is securely transported by the tape transport roller.

4.6 Stitch depth regulation

4.6.1 General

By means of the stitch depth regulator you can adjust the distance between the upper edge of the plunger and the needle radius, i.e. the distance the plunger is lifted or lowered depending on the material thickness. This determines the depth the needle penetrates the fabric layers hold between plunger and cloth retainer. This value is called stitch depth.

A low stitch depth can result in skip stitches, if the stitch depth is too deep the needle can stitch through the material.

4.6.2 Setting the stitch depth (Fig. 9)

The stitch depth is set by means of the adjusting knob (1) at the front side of the machine (Fig. 9).

→ Turning the adjusting knob to the left (+) means deeper needle penetration.
→ Turning the adjusting knob to the right (-) means lower needle penetration.

4.7 Plunger limit stop

4.7.1 General (Fig. 11)

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

When carrying out settings in the area of the stitch plate, disconnect the machine from the mains, and ensure that the machine is actually switched off by pressing the motor pedal.

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

The stitch plate is upped with a cloth retainer (1) Fig. 11 which holds the fabric on the plunger during the time of needle penetration.

The cloth retainer in machines equipped with a springloaded plunger is combined with an adjusting screw (2) Fig. 11 which limits the cloth retainer's upwards stroke.

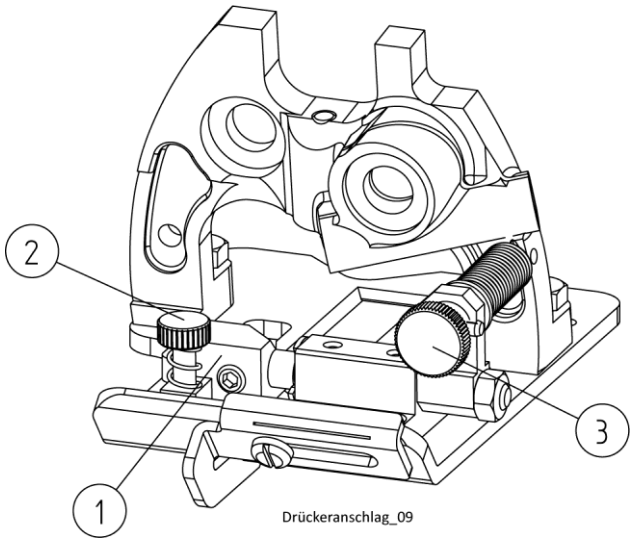
This combination is called plunger limit stop.

Plunger limit stop and the spring-loaded plunger prevent the needle from stitching through the material over cross seams and other thicker parts and avoid markings.

The cloth retainer is screwed to the bearing block and has to be set in a way that the material to be sewn is not displaced during the needle penetration.

The setting of the plunger limit stop has a considerable influence on the stitch quality.

Fig. 11



4.7.2 Setting the plunger limit stop for sewing over cross seams (Fig. 11)

The cloth retainer stroke is set by means of a knurled nut (2) Fig. 11 which serves as upper limit stop. To set the stroke place the material (a normal fabric layer without cross seam). Close the cloth support arm and turn the handwheel manually until the needle penetrates the fabric. In this position there should be nearly nospace between cloth retainer and fabric layer. If the setting is correct the automatic plunger should be springy over cross seams so that the needle does not penetrate the outer layer.

The pressure of the cloth retainer on the fabric layers or the hem edge can be adjusted through turning the knurled nut (3). The pressure should be as low as possible to avoid twist or marks resulting from the pressure between plunger and cloth retainer, mainly when sewing delicate fabrics as e.g. velvet.

However, the pressure should be high enough to keep the material between plunger and cloth retainer during the time of needle penetration.

The setting of the plunger limit stop has a considerable influence on the stitch quality.

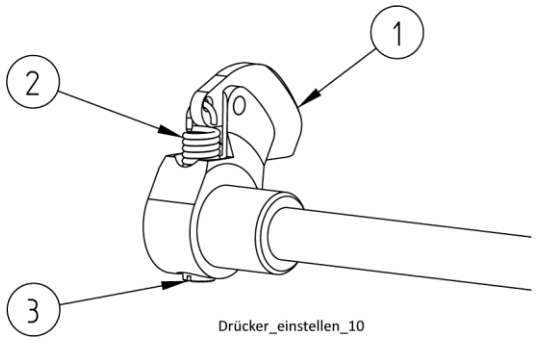
4.7.3 Setting the automatic plunger (Fig. 12)

Due to the different materials to be sewn it might become necessary to re-set the resistance of the spring pressure of the plunger disk (1) by modifying the pre-tension of the tension spring (2) Fig. 12 by means of the setting screw (3) which can be reached easily from the rear side of the cloth supporting arm.

Generally:

larger plunger disk resistance required	-	turn screw (3) to the right.
lower plunger disk resistance required	-	turn screw (3) to the left.

Fig. 12



4.8 Material feed

4.8.1 General

The fabric is fed by means of a rigid upper feed. The feed (stitch length) is adjustable in 4 steps from 3 to 7 mm. Standard equipment is a saw-teethed feed dog which can be replaced by a pyramid-teethed feed dog.

4.8.2 Setting the stitch length (Fig. 9)

A T T E N T I O N !

Switch off machine electrically and make sure that the machine is really in standstill position by operating the treadle for the motor control.

Press stitch adjusting knob (6) Fig. 9 and turn the handwheel until the adjusting knob catches.

Keep the stitch adjusting knob pressed and turn the handwheel to the front until the desired stitch length catches.

4.8.3 Setting the feed dog

After loosening the two fastening screws the feed dog can be adjusted in relation to the stitch plate. If the stitch length is modified considerably, e.g. from 7 to 3 the feed dog should be re-adjusted as well.

Also when the fabric thickness or quality changes it is recommended to readjust the feed dog.

4.9 Skip stitch

4.9.1 General

The machine is equipped with a switchable skip stitch 1:2.

The skip stitch principle bases on the repeated lowering of the plunger to an exactly set value (=skip-stitch depth).

If the skip stitch is switched on, the needle penetrates the outer fabric layer every second (third) stitch only, i.e. that also delicate fabrics can be provided with an elastic seam free of marks.

4.9.2 Actuating and adjusting the interval

The interval stroke (= lowering of plunger) defines the stitch depth during the “interval stitch”.

To switch on the interval for a correctly configured stitch depth, screw in the control knob ((5) Fig. 9) until the required interval stroke is achieved.

More stroke means a more shallow stitch and vice versa.

5 Operating the machine

5.1 General

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

Please observe the sewing area carefully during sewing.

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

5.2 Switching on

Connect the compressed-air conditioner to the compressed air supplier (10 bar) or to the compressor and set it to 6 bar.

Switch on main switch on the right hand side under the table top, control lamp lights.

The material support arm is open, the machine is ready to sew.

5.3 Placing and removing the material - handling

To make sure that the automatically fed tape under the stitch plate is not pulled backwards or displaced laterally, the material to be sewn has always to be inserted to the machine from the frontside backwards.

Put the fabric under the stitch plate while the cloth support arm is lifted and close the cloth support arm by operating the treadle to position "½". The machine is now ready to sew.

If the fabric is not placed correctly, the cloth support arm can be lifted again by treadle position ”-1” or “-2” (depending on the selected function).

After the sewing process the cloth support arm is either lifted automatically.

5.4 Operating modes

5.4.1 General

The following work procedures are possible during sewing:

“Sewing with tape“ and without “Stitch counting with tape“

“Sewing with tape“ and with “Stitch counting with tape“

“Sewing without tape“ and without “Stitch counting without tape“

“Sewing without tape“ and with “Stitch counting without tape“

“Sewing with tape“ and “Sewing without tape“ alternating

The following function sequences or their settings represent only a brief overview. For further settings for the described function sequences or for further function sequences it is essential you consult the operating instructions for the sewing drive.

5.4.2 “Sewing with tape“ and without “Stitch counting with tape“ (Fig. 10)

Function sequence:

- Sewing speed is dependant on the pedal, controllable up to the set maximum speed (parameter F-111) with pedal position “≥1“.
- Intermediate halt with pedal position “0“.
- Intermediate lifting with pedal position “-1“.
- Seam end with automatic lifting with pedal position “-2“.
- Then automatic tape cutting, sewing-in, thread cutting, plunger lifting and tape feed

Settings for the function sequence:

Parameter F-602	=	0	(stitch counting with tape)
“Sewing with tape“	=	On	(V810/key 1/left arrow on (Fig. 10))

5.4.3 “Sewing with tape“ and with “Stitch counting with tape“ (Fig. 10)

Function sequence:

- Sewing speed depends on pedal, controllable up to the set maximum speed (parameter F-111) with pedal position “≥1“.
- Intermediate halt with pedal position “0“.
- Intermediate lifting with pedal position “-1“
- Automatic seam end with lifting after reaching the seam length or with pedal position “-2“.
- Then automatic tape cutting, sewing-in, thread cutting, plunger lifting and tape feed

Settings for the function sequence:

Parameter F-602	=	1	(stitch counting with tape)
“Sewing with tape“	=	On	(V810/key 1/left arrow on (Fig. 10))

5.4.4 “Sewing without tape“ and without “Stitch counting without tape“ (Fig. 10)

Function sequence:

- Sewing speed dependent on pedal, controllable up to the set maximum speed (parameter F-111) with pedal position “≥1“.
- Intermediate halt with pedal position “0“.
- Intermediate lifting with pedal position “-1“.
- Seam end with automatic lifting with pedal position “-2“.
- Then automatic thread trimming and plunger lifting.

Settings for the function sequence:

Parameter F-601	=	0	(stitch counting without tape)
“Sewing with tape“	=	Off	(V810/key 1/left arrow off (Fig. 10))

5.4.5 “Sewing without tape“ and with “Stitch counting without tape“ (Fig. 10)

Function sequence:

- Sewing speed dependant on pedal, controllable up to the set maximum speed (parameter F-111) with pedal position “≥1“.
- Intermediate halt with pedal position “0“.
- Intermediate lifting with pedal position “-1“
- Automatic seam end with lifting after reaching the seam length or with pedal position “-2“.
- Then automatic thread trimming and plunger lifting.

Settings for the function sequence:

Parameter F-601	=	1	(stitch counting without tape)
“Sewing with tape“	=	Off	(V810/key 1/left arrow off (Fig. 10))

5.4.6 “Sewing with tape“ and “Sewing without tape“ alternating (Fig. 10)

For sewing tasks which require a constant changing of the working method from “Sewing with tape“ to “Sewing without tape“ and back, you can proceed as follows:

- Selecting the function sequence according to the working method “Sewing with tape“ (see “5.4.2 “Sewing with tape“ and without “Stitch counting with tape““ and “5.4.3 “Sewing with tape“ and with “Stitch counting with tape““)
- Selecting the function sequence according to the working method “Sewing without tape“ (see “5.4.4 “Sewing without tape“ and without “Stitch counting without tape““ and “5.4.5 “Sewing without tape“ and with “Stitch counting without tape““)

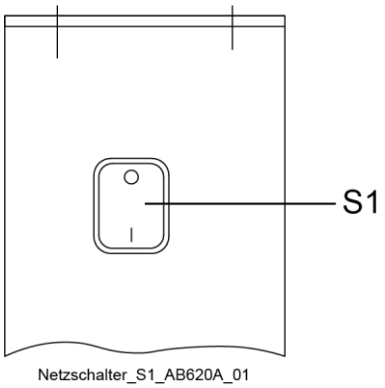
A switchover of the working method from “Sewing with tape“ to “Sewing without tape“ or back again can be carried out at any time by activating the key “1“ at the operating part V810 (Fig. 10), that is, outside the seam as well as in the seam.

6 Operating and function of the control

6.1 General

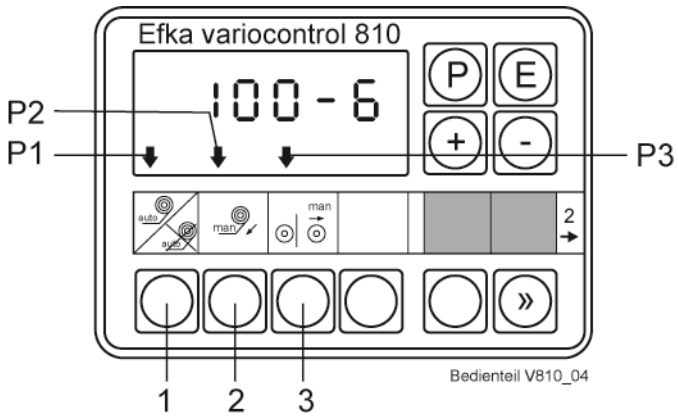
The control is switched on and off by the S1 power switch, which is located on the right side of the machine, below the tabletop (Fig. 13).

Fig. 13



Assignment and display of button functions on operating control V810 (Fig. 14)

Fig. 14



Button 1 "Sewing with tape" function

P1 Indication whether "sewing with tape" function is ON/OFF.

Button 2 "Tape feed on" function

P2 Indication whether "Tape feed on" function is ACTIVE.

Button 3 "Open tape clamp" function

P3 Indication whether "Open tape clamp" function is ON/OFF.

6.2 Switchable button functions

6.2.1 General

Switchable button functions can be changed by pressing a button. The switch status is saved and indicated by the assigned arrows over the respective button (refer to Fig. 14). The function is active until a renewed pressing of the button or an event changes the switch status.

Depending on the selection of the machine class, the various buttons are assigned different switchable functions.

6.2.2 Assignment of the switchable button functions on the operating control V810

Button	**Cl. VEB100-6**	
	Plug-in strip 2	Plug-in strip
"1"	*Sewing with tape* On/Off **Arrow P1 = on/off**	
"3"	*Open tape clamp* **Arrow P3 = on**	

6.2.3 Sewing with tape

Function with operating control	**Button (V810)**
Sewing with tape	1

The "sewing with tape" function is switched on or off by this function.

"Sewing with tape" function On ⇒ left arrow = On
"Sewing with tape" function Off ⇒ left arrow = Off

Switching the function on or off is possible inside as well as outside of the stitch.

The function is saved after "power off".

Explanation of the function:

Switching the function on/off outside of the stitch:

1. Switching the function on:

   Sewing machine is away from the stitch in pos. 2, sewing with tape is switched off and the lifting is open:

   - Press button “1” on the V810 operating control:
     - In the display the left arrow over the button 1 is switched on.
     - The control blocks the pedal, i.e. the sewing drive cannot be started by the pedal anymore.
     - The tape is transported under the stitch plate by the tape feed “u-forward” function.
     - The control releases the pedal and the sewing machine is ready for “sewing with tape”.

2. Switching the function off:

   Sewing machine is away from the stitch in pos. 2, sewing with tape is switched on and the lifting is open:

   - Press button “1” on the V810 operating control:
     - In the display the left arrow over the button 1 is switched off.
     - The control blocks the pedal, i.e. the sewing drive cannot be started by the pedal anymore.
     - The tape is transported back up to the blow funnel of the tape guide by the tape feed “u-backward” function.
     - The control releases the pedal and the sewing machine is ready for “sewing without tape”.

Switching the function on/off in the stitch:

1. Switching the function on:

   Sewing machine is in the stitch in pos. 2, sewing with tape is switched off and the lifting is open:

   - Press button “1” on the V810 operating control:
     - In the display the left arrow over the button 1 is switched on.
     - The stitch can be stitched to the end completely normally.
     - The tape is transported at the stitch end under the stitch plate by the tape feed “u-forward” function.
     - The sewing machine is ready for “sewing with tape”.

2. Switching the function off:

   Sewing machine is in the stitch in pos. 2 or is running, sewing with tape is switched on and the lifting is closed:

   - Press button “1” on the V810 operating control:
     - In the display the left arrow over the button 1 is switched off.
     - The stitch can be stitched to the end completely normally.
     - The tape is transported though at the stitch end by the tape feed “u-short” function only just to the end of the blow funnel, i.e. no longer to under the stitch plate.
     - The sewing machine is ready for “sewing without tape”.

6.2.4 Open tape clamp

Function with operating control	Button (V810)
Open tape clamp	3

The “Open tape clamp” function is switched on or off by this function.

“Open tape clamp” function On ⇒ left arrow = On
“Open tape clamp” function Off ⇒ left arrow = Off

Switching the function on or off is only possible when the “sewing with tape” function is switched on and the sewing machine is outside of the stitch.

If the “tape feed on” function is activated while the function is switched on,

or the “sewing with tape” function is switched off or “sew on”, then the function is switched off automatically.

The function is not saved after “power off”.

6.2.5 Tape feed on

Function with operating control	Button (V810)
Tape feed on	2

This function activates the “tape feed on” function.

“Tape feed on” function activated ⇒ left arrow = On
“Tape feed on” function deactivated ⇒ left arrow = Off

An activation is only possible when the “sewing with tape” function is switched on and the sewing machine is outside of the stitch.

With this function it is possible to transport the tape forward manually.

Explanation of the function:

Sewing machine is away from the stitch in pos. 2, sewing with tape is switched on and the lifting is open:

- Press and hold the “2” button:
  - In the display the left arrow (P2) over the button 2 is switched on.
  - The control blocks the pedal, i.e. the sewing drive cannot be started by the pedal anymore.
  - Tape blow device (BEV = “Bandeinblasvorrichtung”) is switched on.
  - Following the delay time “delay time tape feed motor (BVM = “Bandvorschubmotor”) (F-746) the tape feed motor (BVM) is switched on.
- Release button “2” again:
  - The tape feed motor and the tape blow device are switched on.
  - In the display the left arrow (P2) over the button 2 is switched off.
  - The control releases the pedal and the sewing machine is ready for “sewing with tape”.

Calling up the function several times is possible.

6.3 Programming at technician or supplier level

6.3.1 General

The parameter values can be changed at the technician or installer level only when a code number has been entered.

Code number at the technician level ⇒ 1907
Code number at the installer level ⇒ 3112

Parameter values changed at the technician or installer level are saved immediately upon exiting the programming level.

The parameter numbers shown in the illustrations may not be available in all modes. In such cases the next higher parameter number is displayed in the display.

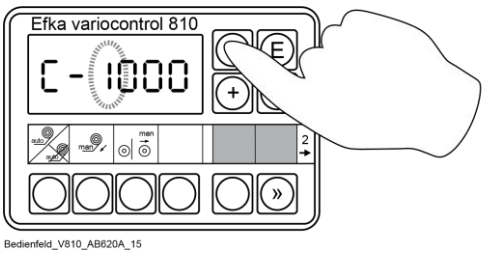
C A U T I O N !

Changing the parameter values at the technician or installer level has to be done very carefully because a faulty setting can damage the control or the sewing machine.

6.3.2 Programming the code number

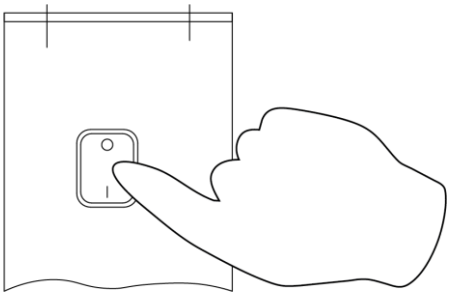
for example the code number “1907” for the technician level

1. Press the “P” button and the S1 power switch at the same time.
   Display is:

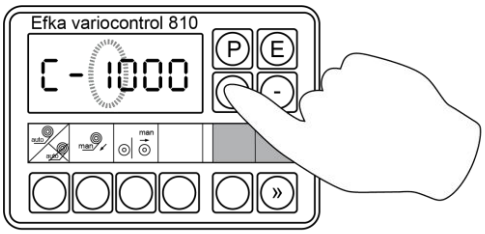


Bedienfeld_V810_AB620A_15

+

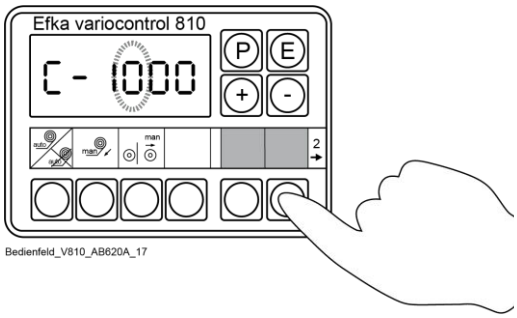

Netzschalter_ein_02

2. Press “+/-” button; in this case the “+” button.
   Numerical value of the digit is changed:



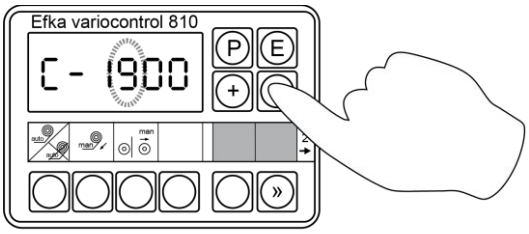
Bedienfeld_V810_AB620A_16

3. Press “>>” button.
   Second digit blinks:



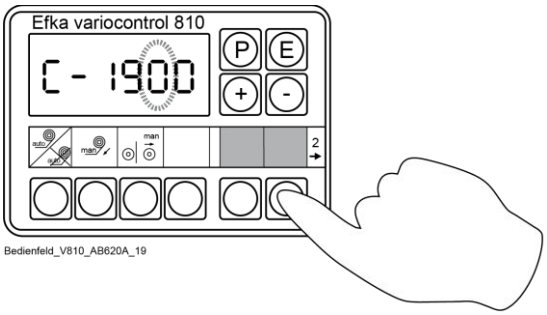
Bedienfeld_V810_AB620A_17

4. Press “+/-” button; in this case the “-” button.
   Numerical value of the digit is changed:



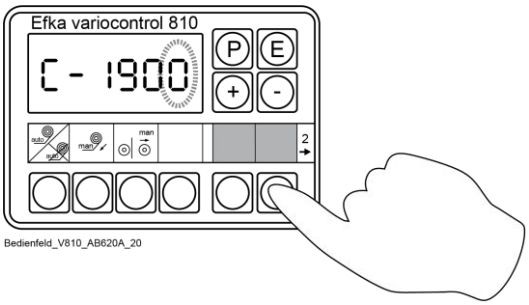
Bedienfeld_V810_AB620A_18

5. Press “>>” button.
   Third digit blinks:



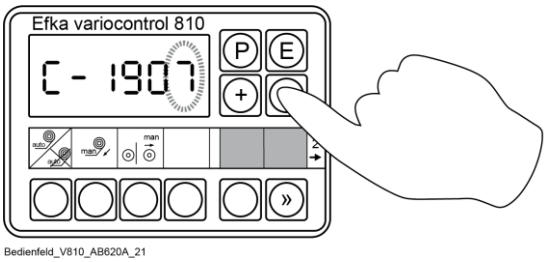
Bedienfeld_V810_AB620A_19

6. Press “>>” button.
   Forth digit blinks:



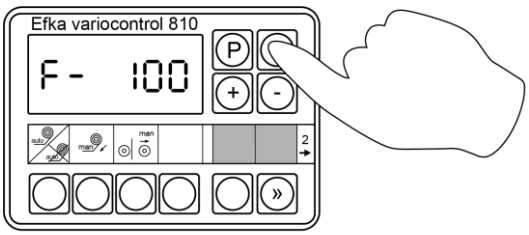
Bedienfeld_V810_AB620A_20

7. Press “+/-” button; in this case the “-” button
   3 times.
   Numerical value of the digit is changed:



Bedienfeld_V810_AB620A_21

8. Press “E” button.
   The first parameter at the technician level
   is displayed:

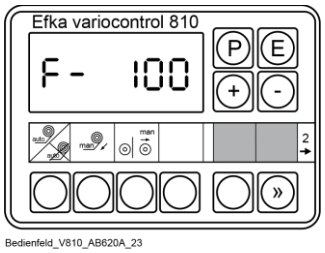


Bedienfeld_V810_AB620A_22

6.3.3 Calling up and changing parameters directly

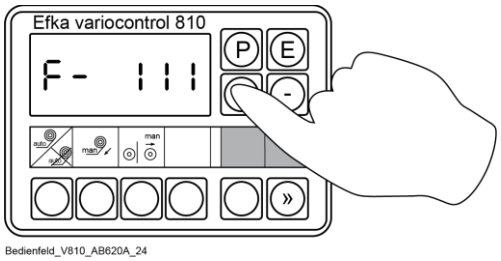
Using the example of the F-111 parameter whose value is changed from 2500 to 2000.

1. After entering the code number.
   First parameter is displayed:



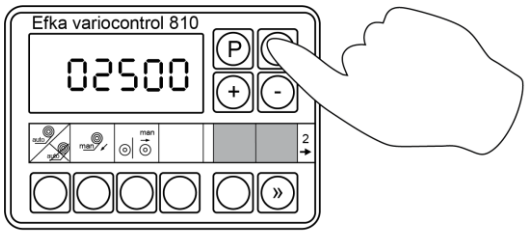
Bedienfeld_V810_AB620A_23

2. Press “+/-” (in this case, “+”) to select parameter until F-111 appears:



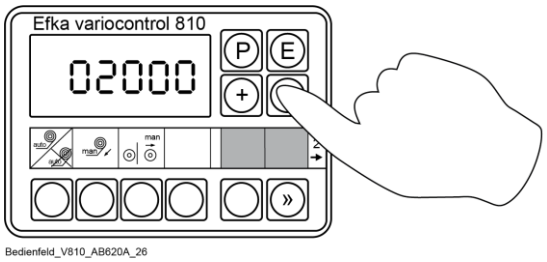
Bedienfeld_V810_AB620A_24

3. Press the “E” button.
   Parameter value is displayed:



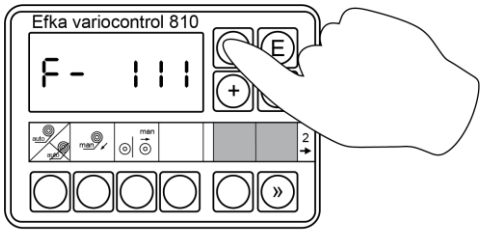
Bedienfeld_V810_AB620A_25

4. Press “+/-” (in this case, “-”) to adjust the parameter value until 2000 appears:



Bedienfeld_V810_AB620A_26

5. Press the “P” button.
   Parameter is displayed:

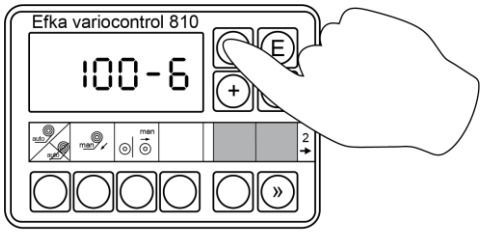


Bedienfeld_V810_AB620A_27

In this way all parameters can be called up at will and changed at the programming level.

After changing the last parameter value the programming at the programming level has to be exited as follows:

6. Press the “P” button again.
   The display then shows after 3 seconds:



Bedienfeld_V810_AB620A_28

6.4 Sewing with tape

6.4.1 Sew-up stitches, stitch end

The following functions have an influence on the sew-up stitches at the stitch end:

Function with operating control	Parameter
Number of stitches for sew-up stitches at stitch end	F-002

This function sets the number of stitches for a sew-up stitch at the stitch end.

Reducing or increasing the stitch number has the effect that the tape endis not sewed-up to the end or beyond the end.

Function with operating control	Parameter
Sew-up stitch speed	F-113

The sew-up stitch speed is the speed of the machine after completing the sew-up stitches at the stitch end.

6.4.2 Tape clamp

The tape clamp (BK) has the function of holding the tape tight.

The function is used:

- After power on
- Outside of the stitch when the “tape clamp open” is not switched on.
- At the beginning of the stitch after pedal position “≥ 1/2” and until the delay time tape clamp off has expired (parameter F-741).
- In the stitch after pedal position “-2” and the delay time tape clamp (parameter F-742)
- Generally when the “sewing with tape” function is switched off.

The following functions have an influence on the tape clamp:

Function with operating control	Parameter
Delay time, tape clamp (BK) “off”	F-741

This function sets a delay time for the tape clamp “off” that becomes effective after the pedal position “≥ 1/2” at the stitch start.
That means that the tape clamp is not opened until after this delay time.

Function with operating control	Parameter
Delay time, tape clamp (BK) “on”	F-742

This function sets a delay time for the tape clamp “on” that becomes effective after the pedal position “-2” at the stitch end.

That means that the tape clamp is not closed until after this delay time.

6.4.3 Tape cutter

The tape cutter (BS) have the function of cutting the tape in the stitch after pedal position “-2”.

The following functions have an influence on the tape cutter (BS):

Function with operating control	Parameter
Delay time, tape cutter (BS)	F-743

This function sets a delay time for the tape cutter that becomes effective after the pedal position “-2” at the stitch end.

Function with operating control	Parameter
On-time, tape cutter (BS)	F-744

This function sets the on-time for the tape cutter that becomes active after the tape cutter' delay time.

6.4.4 Tape feed

The tape feed has the function of transporting the tape under the stitch plate by means of the tape feed motor (BVM) and the tape blow device (BEV) when the “sewing with tape” function is switched on.

The following functions have an influence on the tape feed:

Function with operating control	Parameter
Delay time, tape blow device (BEV) “On”	F-745

This function sets a delay time for the tape blow device “on” that becomes effective after the positioning end at the stitch end.

Function with operating control	Parameter
Delay time, tape feed motor (BVM)	F-746

This function sets a delay time for the tape feed motor that becomes effective after the delay time of the tape blow device.

The delay time needs to be set so that the tape feed motor does not start with the tape feed until the tape blow device has reliably established the “air stream”.

Function with operating control	Parameter
On-time, tape feed motor (BVM) at tape feed “normal”	F-747

This function sets the on-time for the tape feed motor that becomes effective after the delay time of the tape feed motor.

The “normal” tape feed is active at stitch end when the “sewing with tape” function is switched on.

The on-time needs to be set at least so that the tape is securely caught by the machine's transporter when the lifting is closed.

An additional extension of the on-time has the effect that a certain tape length at the stitch beginning is not sewn up.

Function with operating control	Parameter
Delay time, tape blow device (BEV) “off”	F-748

This function sets a delay time for the tape blow device “off” that becomes effective after the on-time of the tape feed motor.

In addition to the normal tape feed at the stitch end, the tape feed also has the function of transporting the tape always to the right position when the “sewing with tape” function is switched on/off.

The following functions therefore also have an influence on the tape feed:

Function with operating control	Parameter
On-time, tape feed motor (BVM) at tape feed “u-short”	F-749

This function sets the on-time for the tape feed motor at a switch-off of the “sewing with tape” function in the stitch that becomes effective after the delay time of the tape feed motor.

The “u-short” tape feed is active at stitch end when the “sewing with tape” function in the stitch is switched off.

The on-time needs to be set at least so that the tape is just barely transported out of the blow funnel after the feed.

The upper limit of the setting range of the on-time is limited by the set parameter F-747.

Comment:

The parameter values or times for the corresponding blow device do not need to be entered separately. The values are determined automatically by the control.

If the “sewing with tape” function is off outside of the stitch, then the tape feed “u-backward” is activated and the tape is transported back so far so that the tape just barely looks out of the blow funnel.

Comment:

The parameter values or times for the “u-backwards” tape feed do not need to be entered separately. The values are determined automatically by the control as follows:

Tape feed “u-backwards” = tape feed “normal” – tape feed “u-short”

The blow device is not activated.

If the “sewing with tape” function is switched on again, then the tape feed “u-forwards” is activated and the tape is transported forward.

Comment:

The parameter values or times for the “u-forwards” tape feed do not need to be entered separately. The values are determined automatically by the control as follows:

Tape feed “u-forwards” = tape feed “u-backwards”

The parameter values or times for the corresponding blow device do not need to be entered separately. The values are determined automatically by the control.

Function with operating control	Parameter
Difference time tape feed “u-short” and tape feed “u-forwards” to tape feed “u-normal”	F-750

By this function a possible difference of the transported tape length can be evened out to the actual tape feed “normal” after a tape feed “u-short” and a tape feed “u-forwards”. This means that if the tape at tape feed “u-short” (when the “sewing with tape” function is switched off in the stitch) and tape feed “u-forwards” (when the “sewing with tape” function is switched on outside of the stitch) is transported too far to the actual tape feed “normal” (at stitch end during switched on “sewing with tape” function), then this difference tape length can be evened out by the difference time mentioned above.

The difference tape length can possibly vary depending on the tape material and thickness used.

Valid for the setting:

Setting value higher = The tape is not transported so far forward after the sequence of the individual functions.

Function with operating control	Parameter
Difference time tape feed “u-backwards” to tape feed “u-forwards”	F-751

By this function a possible difference of the transported tape length can be evened out after a tape feed “u-backwards” and a tape feed “u-forwards”.

This means that if the tape after a tape feed “u-backwards” (when the “sewing with tape” function is switched off outside the stitch) and a tape feed “u-forwards” (when the “sewing with tape” function is switched on out- or inside of the stitch) is transported too far, then this difference tape length can be evened out by the difference time mentioned above.

The difference tape length can possibly vary slightly depending on the tape material and thickness used.

Valid for the setting:

Setting value higher = The tape is not transported so far forward after the sequence of the individual functions.

Comment:

The “u-backwards” tape feed is active when the “sewing with tape” function in the stitch is switched off outside the stitch.

The parameter values or times for the “u-backwards” tape feed do not need to be entered separately. The values are determined automatically by the control as follows:

Tape feed “u-backwards” = tape feed “u-forwards”

Function with operating control	**Parameter**
Delay time, change of direction of rotation of tape feed motor (D-BVM)	F-752

This function sets a delay time that becomes effective after the change of direction of rotation of the tape feed motor.

6.5 Stitch count

6.5.1 General

There are two Strobel-specific stitch counts available:

Stitch count without tape: Stitch count when the “sewing with tape” function is switched off.

Stitch count with tape: Stitch count when the “sewing with tape” function is switched on.

During a switching on/off of the “sewing with tape” function the stitch count is automatically modified, that means for example that when both stitch counts are switched on, the stitch count is switched when the “sewing with tape” function is switched on/off.

The following functions have an influence on the “stitch count without tape” function as well as the “stitch count with tape” function:

Function with operating control	**Parameter**
Speed status for a stitching with stitch count	F-141

This function sets a certain speed characteristic for the “stitching with stitch count” sequence.

Explanation of the parameter values used:

F-141 = 0 pedal-dependant speed, controllable up to the set maximum speed (F-111).
An interruption can be done by pressing the pedal to pedal position “-2”.

F-141 = 3 fixed speed (F-118) once the pedal is briefly pressed, which means that the sequence runs automatically then.
An interruption can be done by pressing the pedal to pedal position “-2”.

Function with operating control	**Parameter**
Stitch count speed	F-118

The stitch count speed is the speed of the sewing machine after completing the stitch count.

Prerequisite:

Speed is activated by parameter F-141.

6.5.2 Stitch count without tape

The following functions have an influence on the stitch count without tape:

Function with operating control	Parameter
Stitch count without tape on/off	F-601

This function switches the stitch counting without tape on or off.

Function with operating control	Parameter
Stitch number of the stitch count without tape	F-701

This function sets the number of stitches for a stitch count without tape.

C A U T I O N !

For the switching on/off or for the stitch count without tape the Efka standard parameters F-015 and F-007 may not be used in any circumstances.

If the Efka standard parameter has been set faultily manually, then the sewing mode may malfunction.

6.5.3 Stitch count with tape

The following functions have an influence on the stitch count with tape:

Function with operating control	Parameter
Stitch count with tape on/off	F-602

This function switches the stitch counting with tape on or off.

Function with operating control	Parameter
Stitch number of the stitch count with tape	F-702

This function sets the number of stitches for a stitch count with tape.

C A U T I O N !

For the switching on/off or for the stitch count with tape the Efka standard parameters F-015 and F-007 may not be used in any circumstances.

If the Efka standard parameter has been set faultily manually, then the sewing mode may malfunction.

6.6 Problems during sewing and possible solutions

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

Switch off machine electrically and confirm that the machine is really in standstill position by operating the treadle for the motor control.

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

- **Thread tears**

  Possible reasons:

  - sharp edges or grooves in the needle guide, thread take-up, looper or needle eye after a long time of machine operation
  - looper or loop stroke are not set correctly, therefore the thread loop is not always caught
  - thread tension set too high
  - thread size does not correspond to needle size (thread is too thick)

  Solutions:

  - replace or polish the damaged parts
  - re-adjust looper and/or loop stroke
  - re-adjust thread tension, check thread course
  - choose the correct thread size

  PLEASE OBSERVE: thread course, thread, stitch plate with plunger and cloth retainer, needle and thread tension should always be set and chosen according to the material to be sewn.

- **Inexact needle penetration**

  Possible reasons:

  - Incorrect needle system
  - worn out or damaged needle
  - wrong pressure or setting of cloth retainer
  - wrong setting of stitch plate or needle guide
  - damaged or worn out needle glide plate
  - wrong needle size (too thin)
  - damaged plunger or wrong plunger setting

  Solutions:

  - replace damaged needle, choose suitable needle size
  - check settings and re-set, if necessary
  - replace needle glide plate

- **Unintended skip stitching**

  Possible reasons:

  - wrong looper setting
  - wrong setting of loop stroke/needle stroke, therefore insufficient loop formation (small/big)
  - chaining finger damaged or not correctly set
  - wrong setting of cloth retainer or cloth retainer pressure

  Solutions:

  - operate machine manually, check the looper motion
  - check the settings, re-set, if necessary, replace damaged parts
  - change thread feed through thread take-up, if necessary

- **Machine does not start, although the control lamp at the main switch lights**

  Possible reasons:

  - thread trimmer not in final position, microswitch locks
  - control error
  - mechanical damage, machine blocks

  Solutions:

  - switch machine off and on again, check the knives' basic position, check the programming
  - eliminate mechanical problem, call service, if necessary

- **The fabric is marked or damaged**

  Possible reasons:

  - unsuitable feed dog teeth
  - plunger shape unsuitable for the fabric to be sewn
  - pressure of cloth retainer too high
  - wrong setting of feed plates pressure
  - damaged sewing tools (lower side of stitch plate)
  - unsuitable needle or thread size

  Solutions:

  - replace feed dog or plunger (see “8 Variable sewing tools”)
  - check pressures, sewing tools and their functions, replace or repolish damaged parts
  - choose most suitable needles and threads

- **Material feed problems**
  (stitch length different from settings)

  Possible reasons:

  - feed dog setting is not correct, material cannot be caught sufficiently.
  - unsuitable feed dog toothing
  - different pressures on the left and right hand feed plates
  - feed plates lift is blocked
  - material accumulation in the stitch plate, mainly over cross seams
  - seam or loop are caught by the feed dog
  - unintended stitch length modification
  - spring-loaded plunger blocks in the cross seam area

  Solutions:

  - check feed dog setting and stitch length, replace feed dog, if necessary
  - set material support pressure correctly
  - check if lower side of stitch plate, feed or sewing parts are damaged and replace or repolish them, if necessary
  - choose correct stitch plate for thicker materials (see “8 Variable sewing tools” and “9 Optional extras”)
  - **only for machines with spring-loaded plunger:**
    check the functions of plunger and limit stop, re-adjust settings, if necessary

7 Machine maintenance

7.1 General

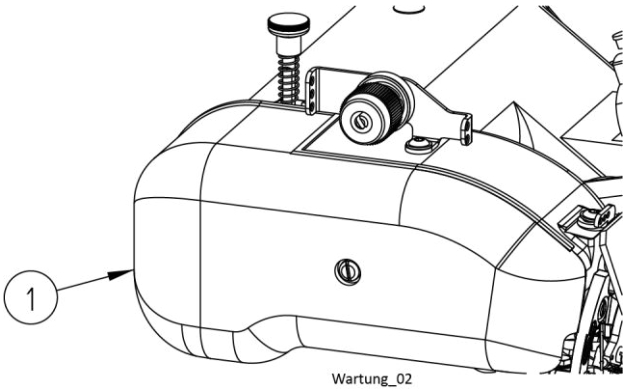
C A U T I O N ! Danger of Injury!

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** from crushing and needle punctures.

Control:
Check at regular intervals by removing the cover (1) Fig. 15 whether sewing dust, thread remnants etc. have accumulated and remove them.

Fig. 15



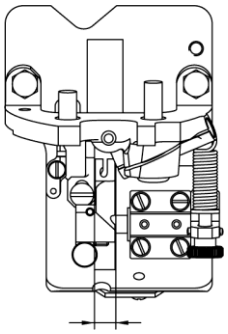
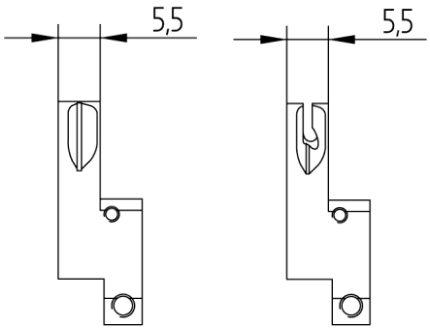
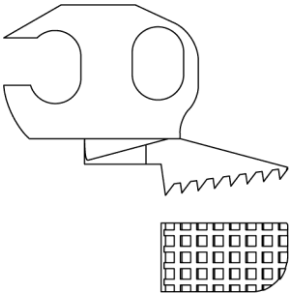
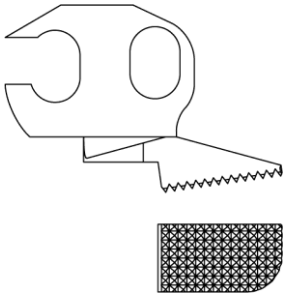
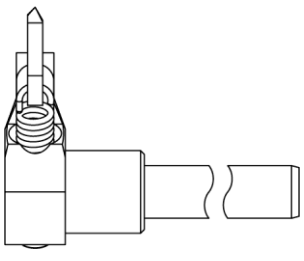
8 Variable sewing tools

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** from crushing and needle punctures.

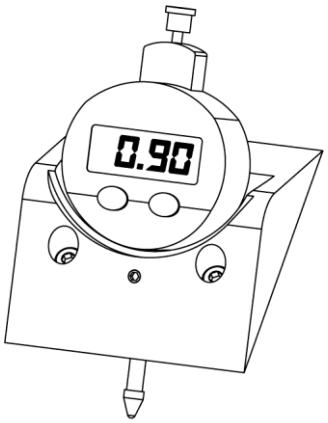
The following chart shows all sewing tools available.

Cl. VEB100-6		
Stitch plate	**Standard** 580.0286  6,0 mm opening	
Cloth retainer	**Standard** 288.0246 288.0243 	
Feed dog	**Standard** 182.0331 	**Optional** 182.0332 
Plunger shaft	**Standard** 381.0084 	

9 Optional extras

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

9.1 Digital display 392.0637



Digitalanzeige_02

Und wir können noch mehr für Sie tun!

Unser Lieferprogramm bietet für jede Branche und jegliche Anforderung genau die richtige Problemlösung.

And we can do a lot more for you!

Our range offers the correct problem solution for every branch and for all requirements.

Für die Bekleidungsindustrie:

Ein- und Zweifaden-Hochleistungs-Saummaschinen

Doppelblindstich-Saummaschinen

Zweifaden-Blindstich-Staffiermaschinen

Roll- und Flachpikiermaschinen

Pikier-Automat

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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