For the professional user

Operating Instructions

Für den professionellen Anwender

Betriebsanleitung

Class: **VEB100-3**
Klasse:

Model: **2**
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

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D-82178 Puchheim
Tel.: 089/ 80096 - 0
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Garantiekarte/ Warranty Sheet

Maschinenklasse/ Machine Class: _____

Serien-Nr./ Serial No: _____

Auftrags-Nr./ Order Confirmation No: _____

Lieferdatum/ Delivery Date: _____

Rechnungs-Nr./ Invoice No: _____

Rechnungsdatum/ Invoice Date: _____

Beanstandung/ Complaint: _____

_____

_____

_____

_____

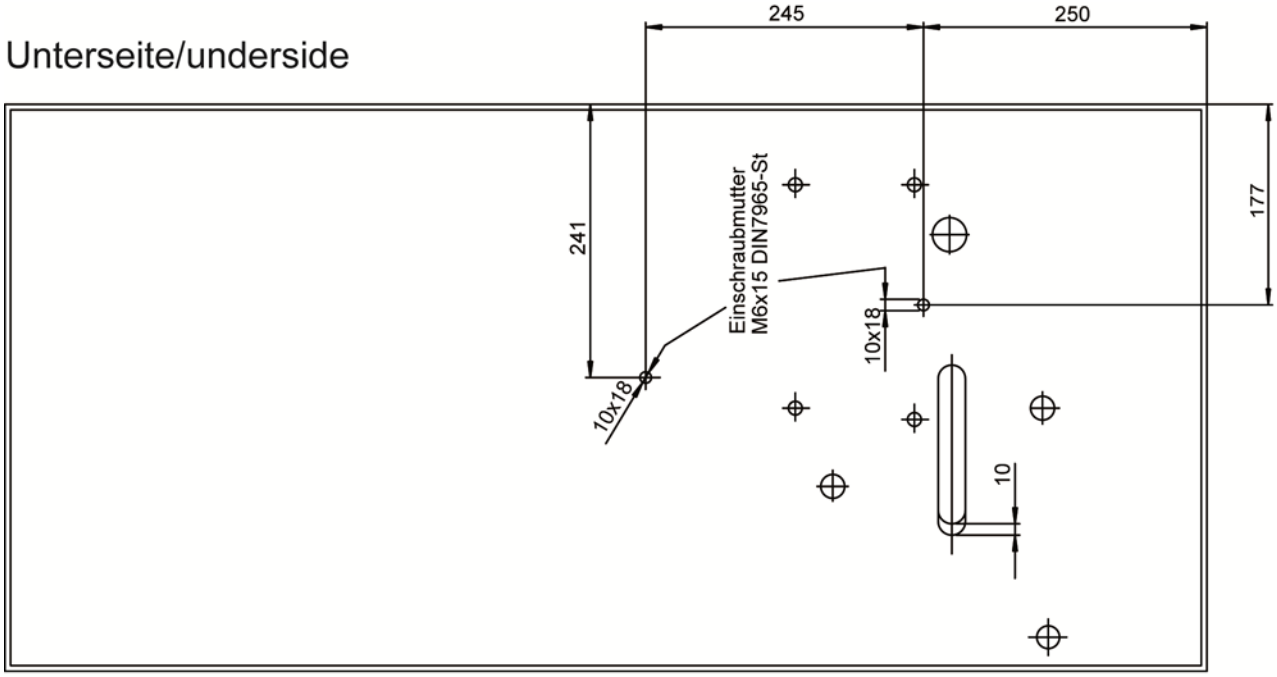
_____ _____

Datum/ Date Unterschrift/ Signature

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

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

Unterseite/underside



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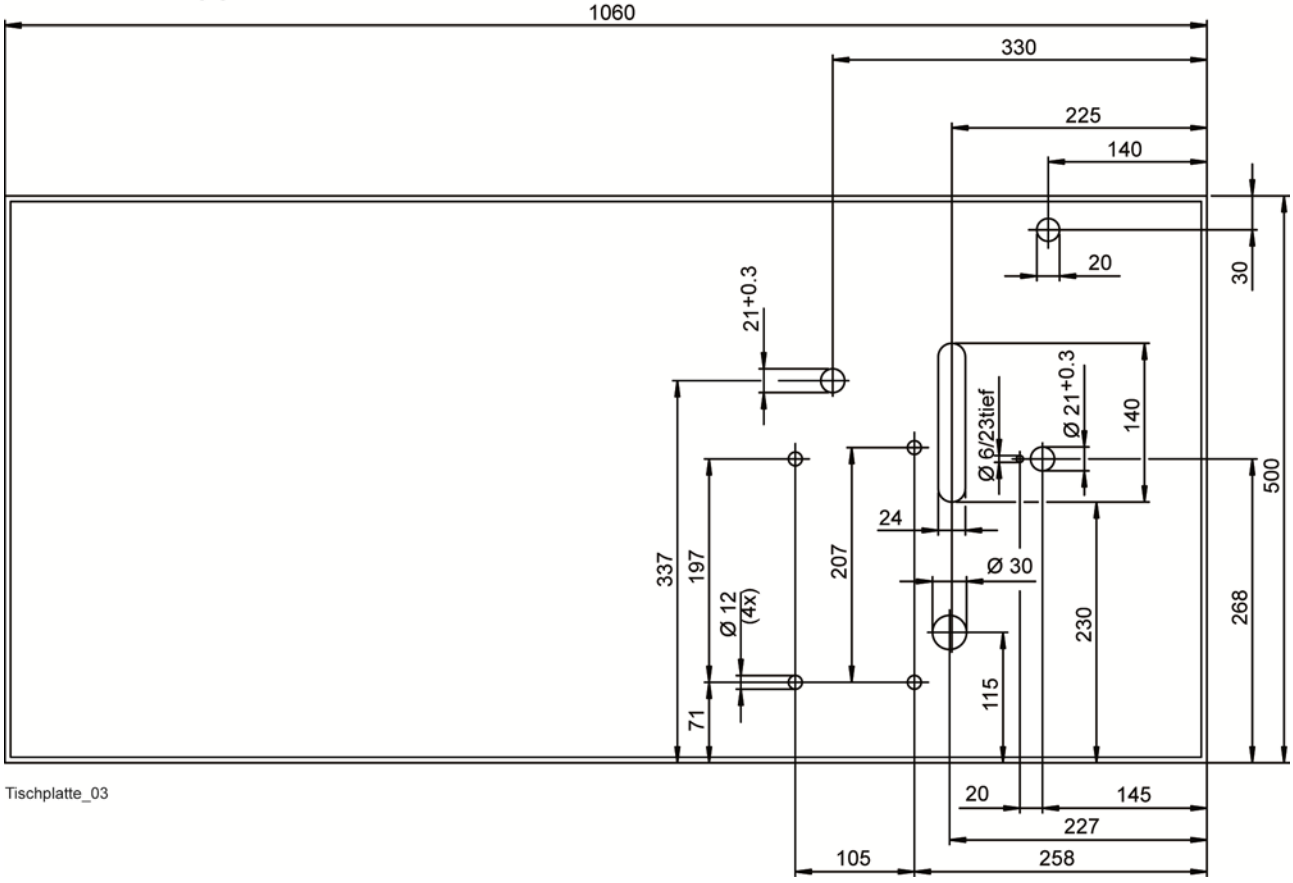

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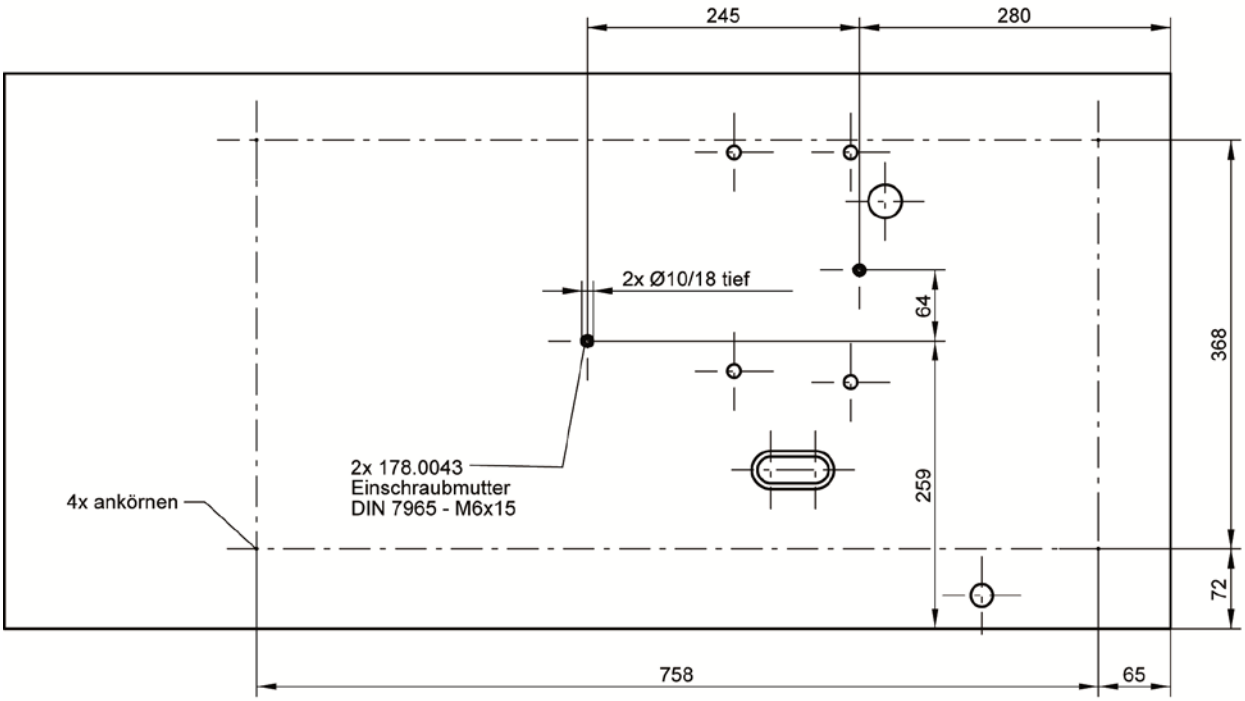

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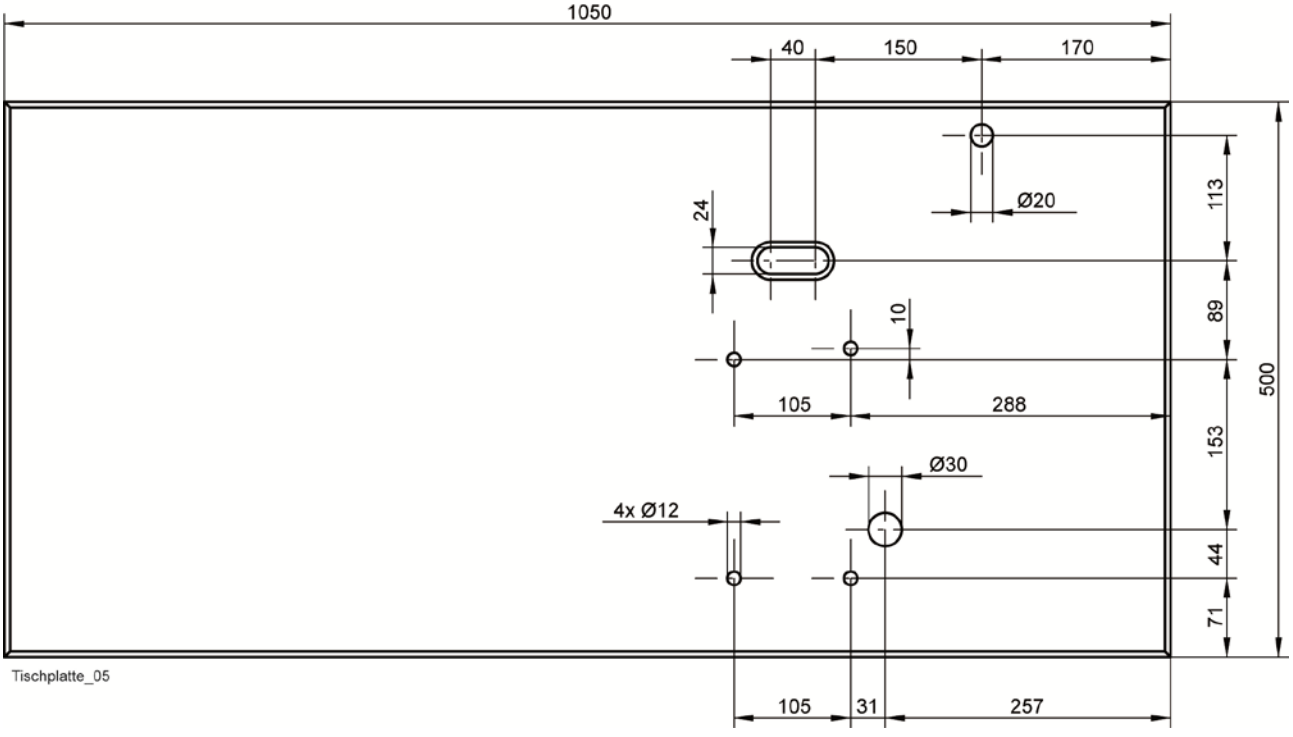


Tischplatte_05

STROBEL

Operating instructions
STROBEL Class VEB100-3

Contents

Subject to change without prior notice

1 General notes on safety

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 bodily injury 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 reels, exchanging sewing tools such as needle, gripper, needle plate, transport devices, possibly cutter 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. Please open the illustrations at the beginning of these operating instructions, so you can follow the illustrations step by step while reading the instructions.

2.2 Class identification, serial number and orientation of the machine

The operating side of the machine is the basis for descriptions referring to sides. The class identification (type) as well as serial and model number (after the dash) is located on the rear side of the housing.

2.3 Range of applications

Class VEB100-3 is suitable for attaching waistbands linings on trousers, also for waistbands with belt loops attached.

Exchanging the variable sewing tools, i.e., can extend the range of applications of the different machines that other fabric qualities than the above mentioned ones could be sewn as well.

Variable sewing tools please see point 7.

2.4 Technical data

Number of stitches: Max mechanically admissible Recommended rated speed:	 3000 min^{-1} 2200 min^{-1}
Machine pulley diameter	dw 80 mm
Min. motor power	550 W
V-belt profile	10 x 6 mm
Toothed belt pulley/machine	Z=38
Toothed belt profile	HTD 5M-9
Stitch length-upper feed	5 - 8 mm (depend on fabric)
Kind of stitch:	single thread chain stitch blind stitch
Stitch type	103
Needle system	GROZ-BECKERT 1669 EEO
Needle size	90
Thread	polyester continuous filament
Thread size	120/2
Pneumatic connection	6 bar
Average air consumption	depending on the equipement
Required space	0.5 m x 1.1 m
Noise: Average noise level at a speed of n = 2200 min-1:	 LpAm 71 dB (A) Noise test according to DIN 45635-48-1 KL3

3 Installation and putting into service

3.1 Unpacking the machine

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

Reel stand, rods and other accessories are packed into the packing.

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

3.2 Installation

ATTENTION!

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.

If the machine head is supplied without stand and motor first make the borings into the table top as shown in the drawing. Mount rods and treadles and electric connections according to the connecting diagram.
Mount the motor. Electric connection as per connecting diagram shown in the motor's operating instructions.

The upper component must be fastened to the provided rubber plate on the table top. The belt guard must be installed after inserting the V-belt.
Mount the V-belt and tense it according to “3.4.1 Tensioning the V-belt“.
Mount the belt guard.

Mount the lifting and motor operating rods.

Using a compact motor means to assemble the control box and speed controller under the table. Also the operating rod between speed controller and pedal has to be connected.

After assembling the single parts of the reel stand mount it to the right hand side of the tabletop.

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

Mount the synchronizer and set it as described under “3.4.2 Positions of the machine“.

ATTENTION!

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

All rust protection agents, such as Vaseline and similar agents have to be wiped off carefully from the sewing tools before putting the machine into service.

3.3 Sense of rotation

The correct sense of rotation of the hand wheel is clockwise in line of vision on the hand wheel.

3.4 Motor drive via V-belts

3.4.1 Tensioning the V-belt

C a u t i o n ! Danger of injury!

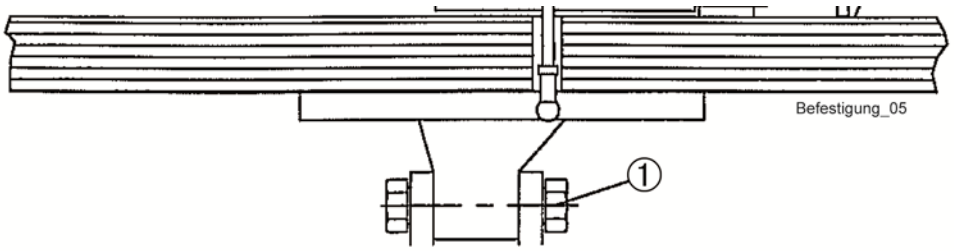
When checking the belt tension, switch off the machine at the mains. Do not operate the machine without the belt guard. Otherwise there is a **D A N G E R** of crushing fingers, of injuries to the body and of pulling in parts of clothing.

The tensioning of the V-belt is carried out by swivelling the motor underneath the table plate after releasing the retaining nut with SW 24, **(1)** in **Fig. 1**.

The V-belt must not be tensioned too much, especially with the stop motor. You should be able to compress it with light thumb pressure by about 2 cm.

Too little V-belt tensioning can impair the positioning of the machine and therefore impair the function sequence.

Fig. 1



3.4.2 Positions of the machine

C a u t i o n ! Danger of injury!

Danger of crushing fingers and needle through stitching as well as pulling in of parts of clothing.

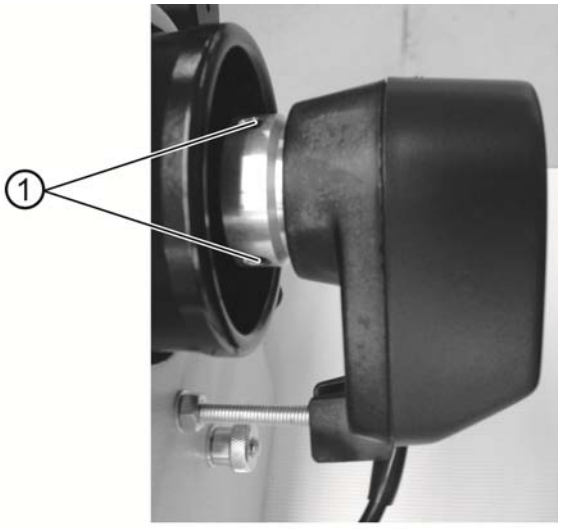
Keep fingers and hands away from moving parts when setting the position generator and checking the positions with switched-on machine.

General:

Stop motors require a position generator, which takes the mechanical setting of the machine from the main screw and transmits this to the control of the motor. With this, for instance, the thread cutter can always be electrically approached in exactly the same needle looper position. **(Fig. 2)**

The correct position of the position generator to the flange is marked with a spot of paint.
To adjust or to remove, release the two clamping screws **(1)**, **Fig. 2**. tighten these firmly prior to commissioning.

Fig. 2



Impulsgeber_05

With positioning with plunger reset, the motor reverses after thread cutting for a certain value, to facilitate the insertion of the sewing matter. This does not affect the setting of the position generator.

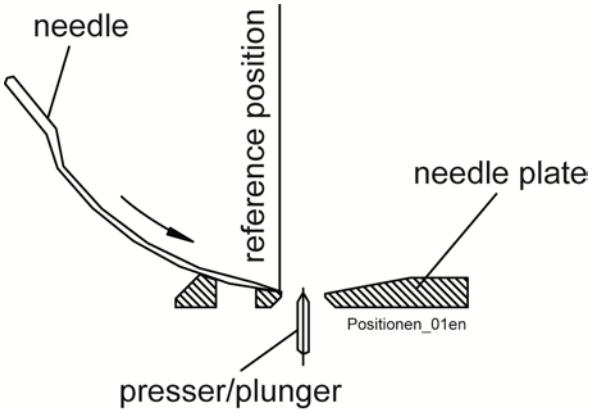
Machine with or without thread cutter:

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 the direction of the insertion stitch closes with the right (inner) edge of the needle slide plate.

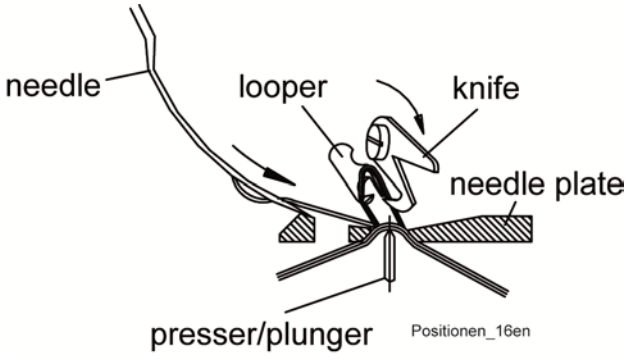
Fig. 3



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

The needle position must be set in such a way, that with the machine stopped,the hook of the thread knife catches the thread loop lying over the looper securely without touching the looper.
Afterwards check by manually activating the thread cutter.

Fig. 4



Notes for sewing drives which have two needle positions:

The above mentioned needle position is position 2 at the sewing drive. It is essential that position 1 is set with consultation of the operating instructions of the sewing drive.

3.5 Motor drive via Toothed belt

3.5.1 Tensioning the Toothed belt (Fig. 5)

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

Switch off the machine at the mains when checking the belt tension. Do not operate the machine without belt guard. Otherwise **DANGER** of crushing fingers, of injuries to the body or of pulling in of part of clothing.

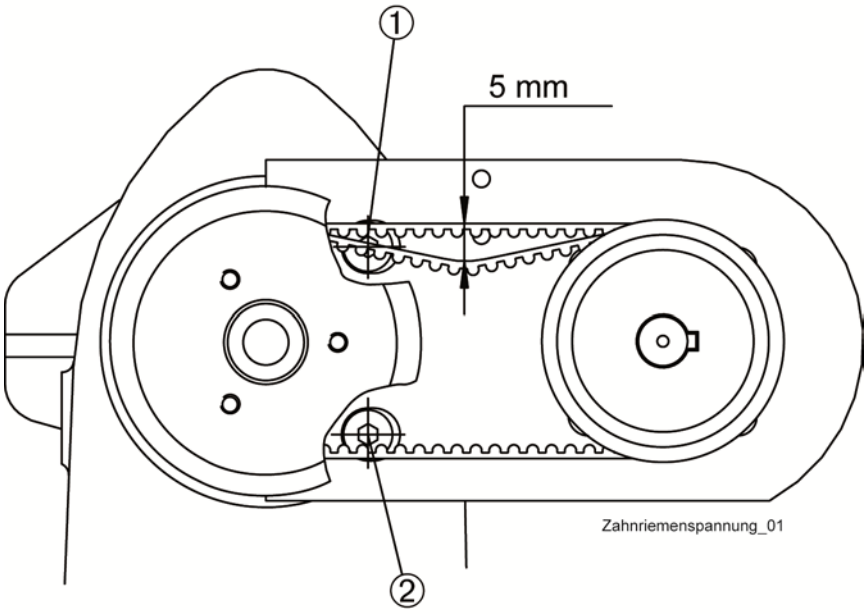
The toothed belt should not be tensioned too much. You should be able to compress it with light thumb pressure by about 5 mm.

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. 5)**:

- 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. 5



3.5.2 Positions of the machine

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.

Machine with or without thread cutter:

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.

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.

Notes for sewing drives which have two needle positions:

The above mentioned needle position is position 2 at the sewing drive.
It is essential that position 1is set with consultation of the operating instructions of the sewing drive

4 Instructions for use

4.1 Needles and threads

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 needles. There are also size 90 available.

Notice: A perfect needle is of great importance for a good sewing result. Damages of the needlepoint, 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.

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 other needle types.

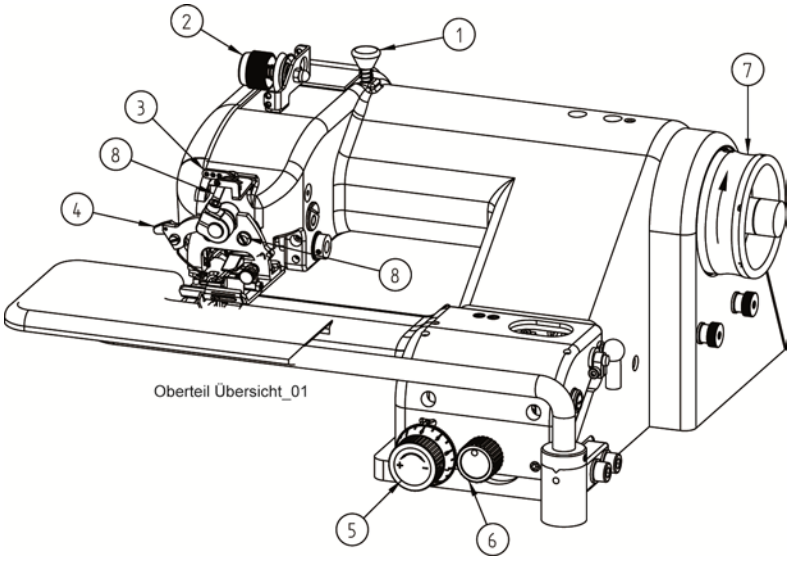
4.2 Inserting the needle

A T T E N T I O N !

Switch off machine electrically and confirm that the machine is really in standstill position by operating the treadle for the motor control before changing the needle. Otherwise danger of finger bruises and needle through stitches.

The curved needle shape determines its position in the needle lever. 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 **(4) (Fig. 6)** of the needle clamping plate is tightened well.

Fig. 6



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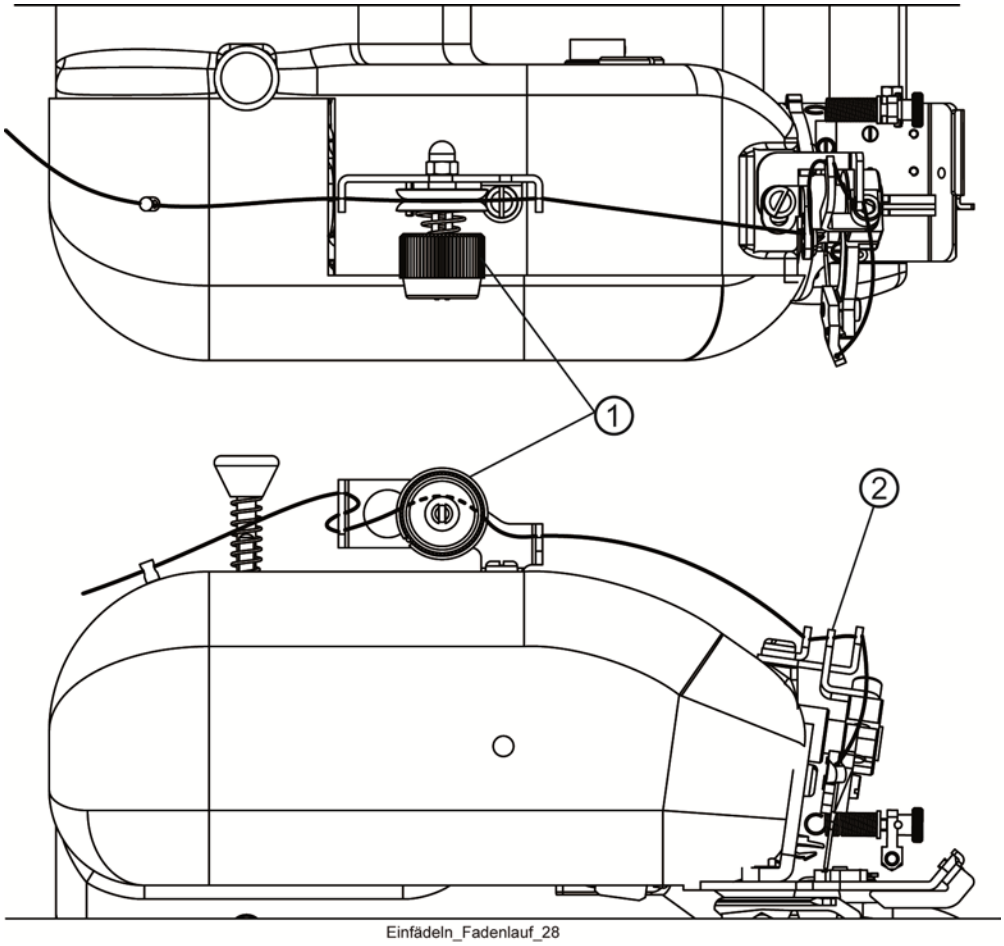
4.3 Threading and thread course

ATTENTION! Danger of bodily injuries
Switch off machine electrically and confirm that the machine is really in standstill position by operating the treadle for the motor control before threading.

Fig. 7 shows the correct threading by using the thread take-up.

Fig. 7



4.4 Thread tension

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

4.5 Thread take-up lever

The thread take-up lever **(2) (Fig. 7)** avoids thread twist and turning over of the loop, thus enabling a secure taking up of the loop by looper and needle. There is a uniform stitch formation and the hem edge is free of pucker.

The function of the thread take-up lever is influenced by the thread course (choice of the eyelet).

4.6 Stitch depth control

By means of the stitch depth control 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.

4.6.1 Setting the stitch depth

The stitch depth is set using the control button **((5) Fig. 6)** and is located on the front side of the machine.

⇨ Turn the control button to the left (+) to create a deeper stitch.

⇨ Turn the control button to the right (-) to create a less stitch depth insertion.

4.7 Cloth retainer (Fig. 8)

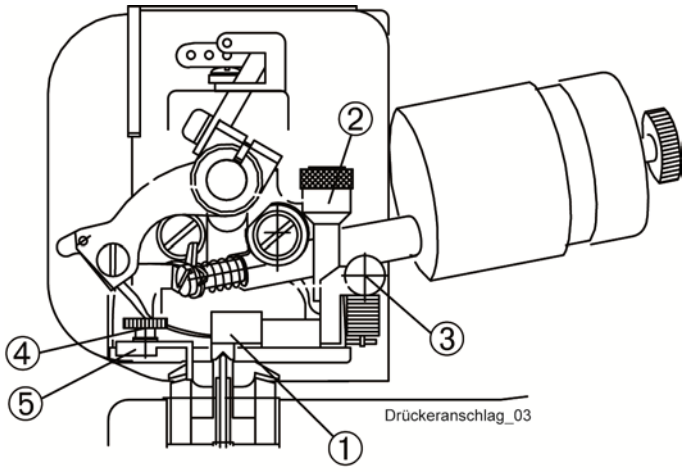
ATTENTION!

Danger of finger bruises through unintended actuation of the treadle during setting works in the needle plate area.

The needle plate is upped with a cloth retainer **(1) Fig. 8** which holds the fabric on the plunger during the time of needle penetration.

The cloth retainer in machines equipped with a spring-loaded plunger is combined with an adjusting screw which limits the cloth retainer's upwards stroke. **(2) Fig. 8**
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.

Fig. 8



4.7.1 Setting the plunger limit stop for sewing over cross seams (Fig. 8)

The cloth retainer stroke is set by means of a knurled nut **(2)**, 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 hand wheel manually until the needle penetrates the fabric. In this position there should be nearly no space between cloth retainer and fabric layer. If the setting is correct the automatic plunger should be compensating the 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.

4.7.2 Setting the automatic plunger

The spring pressure of the automatic plunger is set at works and usually needs not to be altered. If the plunger limit stop is set correctly over cross seams the needle should not penetrate the outer fabric layers.

For plunger settings please refer to the mechanic's instructions.

4.8 Material feed

The machine transports the sewing material with a fixed top transport and with a bottom tape feed dog. The feed (stitch length) can be set from 5-8 mm in 4 steps. Serially, a saw-toothed feed dog is mounted (see point „7 Variable sewing tools“).

4.8.1 Setting the stitch length

ATTENTION!

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 **(1) (Fig. 6)** and turn the hand wheel until the adjusting knob catches. The set stitch length corresponds to the figure shown on the hand wheel in the highest position. Keep the stitch-adjusting knob pressed and turn the hand wheel to the front until the desired stitch length catches.

4.8.2 Setting the top feed

The feed dog can be adjusted in its intrusion depth to the needle plate by loosening the two fastening screws. If the stitch length is adjusted across a greater range, e.g. from 8 to 5, then the feed dog should be readjusted.

Also when the fabric thickness or quality changes it is recommended to re-adjust the feed dog.

Please refer to the mechanic's instructions.

4.8.3 Tighten feeding Belts

During feeding the presser plates have to be parallel to the stitch plate. If the plates tip over to the front, the belts are tighten too much.

There are two way’s to adjust the belt tension,

a) Turning set collar 246.0204 on the shaft 130.0436.

b) Sliding the bearing stand 114.0903 on bearing stand 114.0981.

Warning: Avoid excessive tension of the belts, otherwise tilt the feed dog brackets to the front.

4.9 Motor

General:

A stop motor (DC1200) is available for driving the sewing machine.

A needle positioning motor is needed for an exact machine positioning and to operate the electromechanical thread trimmer and pneumatic lifting.

Please observe the operating instructions of the sewing drive supplied with the machine where you will find instructions to program the control and the motor speed.

4.10 Seam lock (version RF)

4.10.1 General

The class VEB100-3 can be equipped with seam lock and than they are named: VEB100-3RF.

4.10.2 Switching on the seam lock

The parameter F-10 must be set from 0 to 1.

CAUTION!

Under no circumstances may the LED 4 light up during sewing operation.

4.10.3 Seam lock

The "double" backtack sequence is used for technical control in this machine class.

Sequence:

The seam lock is created at the end of the stitch by an air stitch.

The sequence is as follows:

1. The machine stops in position 1 after the sewing; pedal is in 0-position. (Fig. 9)
2. Step pedal back (position -2). Plunger lowering is switched on.
3. The machine makes one air stitch at slow speed and then moves to position 1. Plunger lowering is switched off.
4. The machine then makes another stitch at slow speed and then moves to position 2 and the thread trimmer is switched on.

4.10.4 Thread tension at seam lock

The additional thread tension should pull close the loop of the seam lock when switched on.
During normal sewing it is lifted by a pneumatic cylinder and is out of operation.

4.10.5 Feed dog at seam lock

The feed dog is lifted up by a pneumatic cylinder at the seam lock. It now glides gently over the sewing material during the transport movement without transporting it further.

4.10.6 Plunger lowering at seam lock

The lowering of the plunger at the seam lock prevents a punctuation of the outer fabric.
By turning the knurled screw at the pneumatic cylinders under the table top the height of the lowering can be changed.

Turn to right Thick sewing material	-	:	Lowering is increased Stitch depth becomes less
Turn to left Thin sewing material	+	:	Lowering is reduced Stitch depth becomes greater

4.10.7 Switching off the seam lock

The parameter F-10 must be set from 1 to 0.

5 Operating the machine

It is recommended to equip the machine with a pneumatic lifting device to facilitate machine handling (please see “8.3 Pneumatic lifting”).

A T T E N T I O N !

Please observe the sewing area carefully during sewing. Otherwise danger of finger bruises and needle through stitches.

5.1 Switching on

Connect the compressed-air conditioner to the compressed air supplier (max. 10 bar) or to the compressor and set it to 6 bars. Switch on main switch on the right hand side under the table top, control lamp in the "OFF" switch lights red. On machines with pneumatic lifting now the material support arm is open, the machine is ready to sew.

5.2 Placing and removing the fabric - sewing process

a) **treadle lifting**

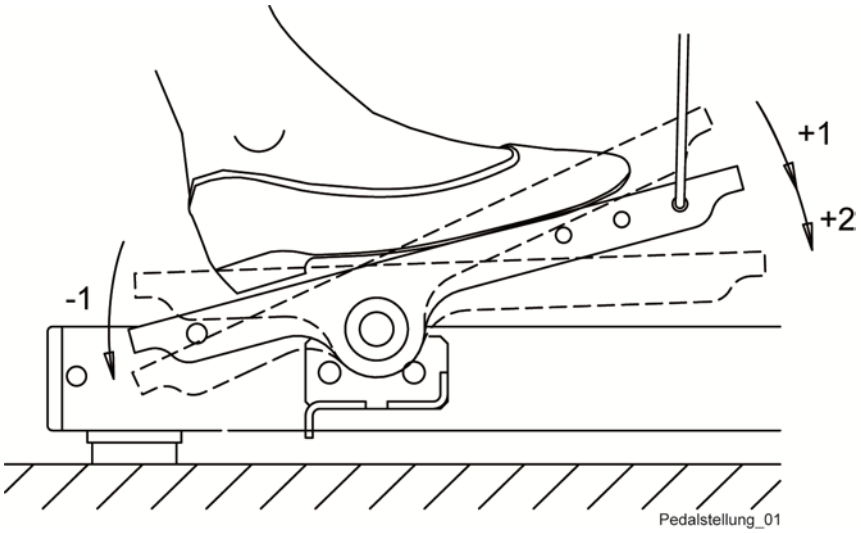
By pressing the left hand treadle the cloth support arm is lifted.
Place material under the needle plate and leave the left hand treadle. The machine starts sewing by operating the right hand treadle.
The machine runs at maximum speed when the right hand treadle is completely pressed down (please see “4.9 Motor“).

b) **pneumatic lifting (optional extra)**

Fig. 9 shows the treadle's switching functions when the machine is equipped with pneumatic lifting. Place the fabric under the needle plate while the cloth support arm is lifted and close the arm by slightly pressing the treadle (+1).

The machine is now ready to sew.
If the fabric is not placed correctly, the cloth support arm can be lifted again by heeling the treadle back into its initial position. At the end of the sewing process the thread trimmer (optional extra) is operated and the cloth support arm is lifted by heeling the treadle (-1).

Fig. 9



5.3 Sewing

The machines of the 103 series are mainly designed for blind stitch hemming. The special applications of the corresponding subclasses are described under “2.3 Range of applications“.

The sewing result should be an elastic seam free of marks. Depending on fabric quality the sewing requires a certain skill. The following instructions will help the operator to obtain this skill.

5.3.1 Blind stitch hemming

If there are no former values available, proceed as follows:

1. Set the desired stitch length. **Fig. 10** shows the resulting seam according to the stitch length.
2. Set the stitch depth.
3. Check the pressure of the cloth retainer and readjust it, if necessary.
4. Set the limit stop of the plunger.
5. Set the material guide by loosening screw **(4) (**Fig. 8**)** and displacing the material guide **(5)** to get the corresponding limit stop for the hem edge. You can sew at the hem edge or on the hem. See **Fig. 11**.
6. Check the stitch length and readjust the feed dog, if necessary.
7. Set the thread tension. The seam should lie loosely on the hem.
8. Switch on the skip stitch, if needed, and set skip stitch stroke according to the material thickness.
9. Re-thread to obtain a better seam appearance.

Place the material and make sure that the feed dog can catch the beginning of the seam after the first stitch.
Operate the treadle briefly. Go on sewing or, if necessary, change a.m. settings until you get the desired result.
Readjust the stitch depth regulation if the stitches show through on the outer fabric side.

Sometimes certain "marks" caused by the needle penetration on the outside of the fabric cannot be avoided when the fabric is extremely thin or hard.

Make sure that during sewing the hem edge is always guided along the material guide. Avoid sudden treadle operations since speed changes during the sewing process may influence the needle penetration.

Fig. 10

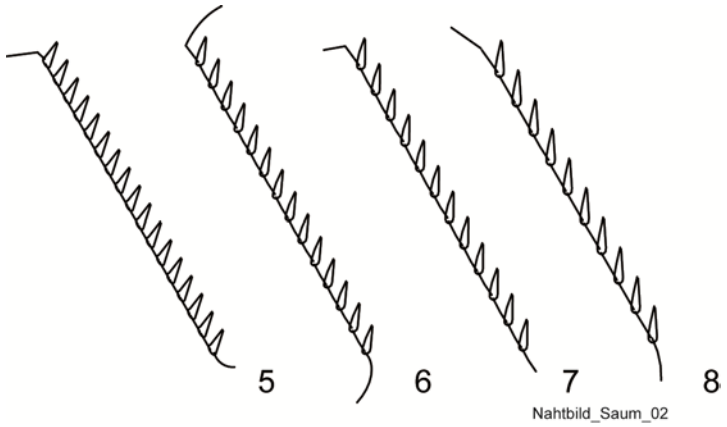
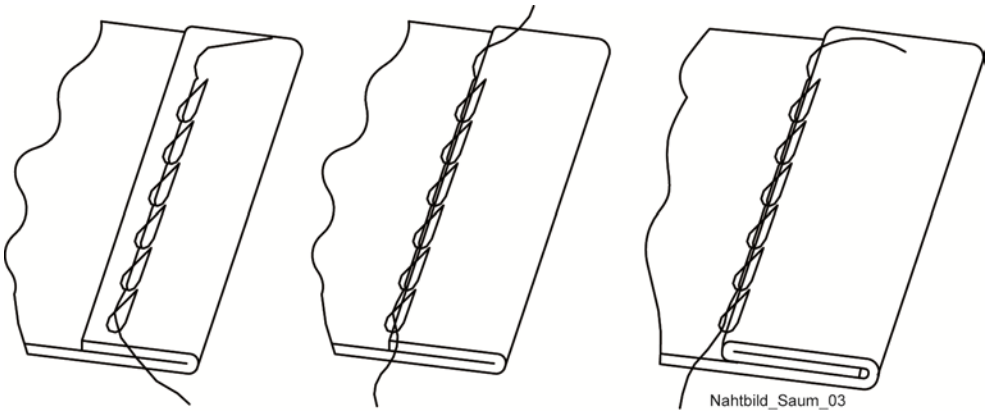


Fig. 11



5.3.2 Attaching the trouser waistband lining (Fig. 12)

For this operation a needle plate with wide opening is recommended since usually different fabric layers have to be sewn.

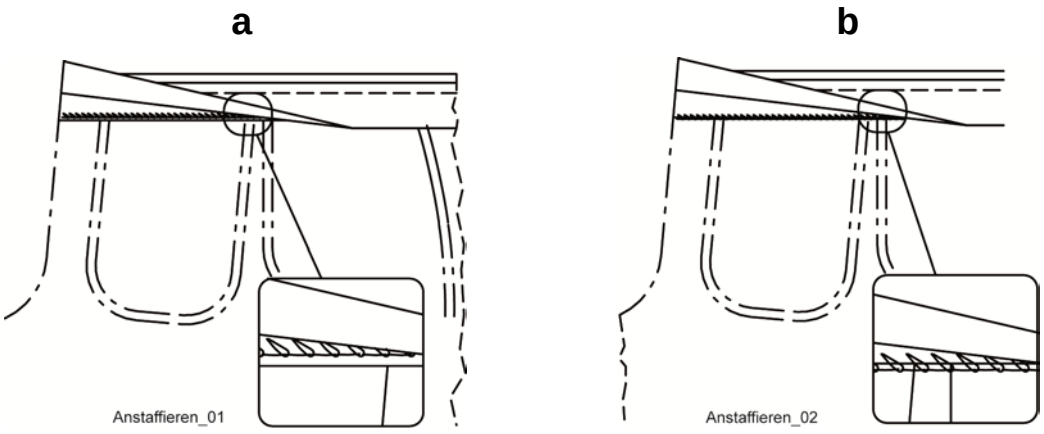
Recommended needle sizes: 80, 90

There are two different types of operations **(Fig. 12a and Fig. 12b)**:

a) sewing the waistband on the lining

b) sewing the waistband on the edge

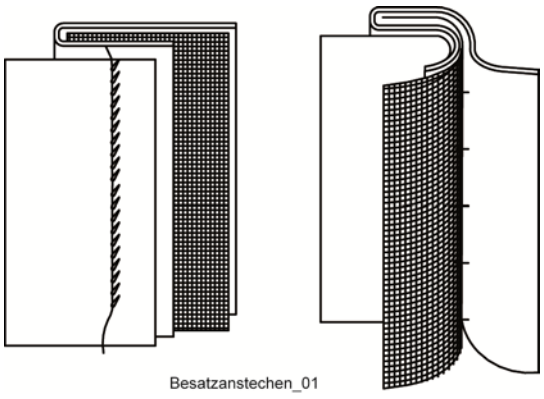
Fig. 12



5.3.3 Attaching facings

This operation is shown in **Fig. 13**.

Fig. 13



5.4 Problems during sewing and possible solutions

Attention! Switch off machine electrically and confirm that the machine is really in standstill position by operating the treadle for the motor control.
Otherwise danger of finger bruises and needle through stitches.

- **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, needle 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:

  - worn out or damaged needle
  - wrong pressure or setting of cloth retainer
  - wrong setting of needle 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, micro switch locks
  - control error
  - mechanical damage, machine blocks

  Solutions:

  - switch machine off and on again, check the knives' cutting 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 needle plate)
  - unsuitable needle or thread size

  Solutions:

  - replace feed dog or plunger (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 needle 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
  - wrong tension of the belts from the bottom feed

  Solutions:

  - check feed dog setting and stitch length, replace feed dog, if necessary
  - set material support pressure correctly
  - check if lower side of needle plate, feed or sewing parts are damaged and replace or repolish them, if necessary
  - choose correct needle plate for thicker materials (see “7 Variable sewing tools“, “8 Optional extras“)
  - **only for machines with spring-loaded plunger:**
    check the functions of plunger and limit stop, re-adjust settings, if necessary
  - adjust the correct belt tension

6 Machine maintenance

Most of the bearings of the machine are maintenance free. Apply one drop of sewing machine oil (oil is supplied wit the accessories) every 20 operating hours or at least once a week to the red marked points and oil borings.

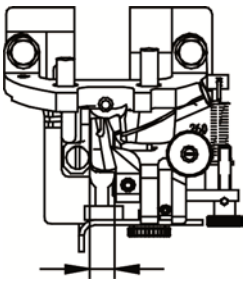
Release the machine head's slotted pan-head screw and remove cover 112.0504 to lubricate looper link 430.0151 and the feed crank.

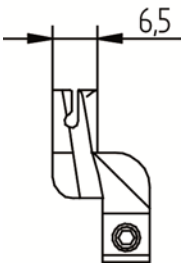
Clean all movable parts regularly from fabric fibres.

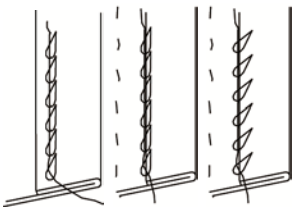
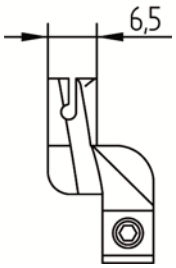
7 Variable sewing tools

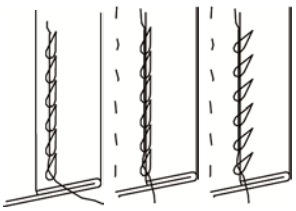
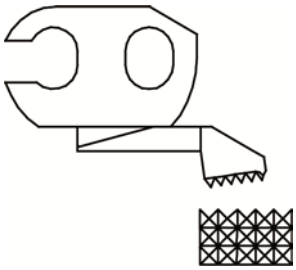
Attention!

Switch off machine electrically and confirm that the machine is really in standstill position by operating the treadle for the motor control.
Otherwise danger of finger bruises and needle through stitches.

<table>
<tr><th colspan="3">Cl. VEB100-3</th></tr>
<tr><td>Needle plate</td><td colspan="2">Standard
380.0260
 
7,0 mm opening</td></tr>
<tr><td rowspan="2">Cloth retainer

Stitch formation</td><td>Standard
288.0233
 

  </td><td>Optional
288.0217
 

  </td></tr>
<tr><td colspan="2">Standard
182.0151
  </td></tr>
<tr><td>Feed dog</td></tr>
</table>

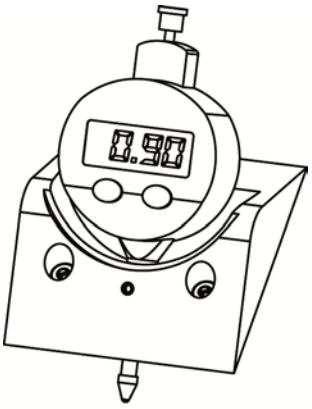
8 Optional extras

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

8.1 Thread trimmer

798.0496 electromechanical thread trimmer
Prerequisite here is use of the
EFKA Kompakt DC1200

8.2 Digital display 392.0637



Digitalanzeige_02

8.3 Table extension

8.4 Pneumatic lifting

The use of a pneumatic lifting is only recommended if the machine is equipped with a needle positioning motor.

8.5 Seam lock

8.6 Compact drive

8.7 Stand set

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Für Heimtextilien:

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Für die Polsterverarbeitung:

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Ein- und Zweifaden-Blindstichmaschinen

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Single and two thread blind stitch machines

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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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