

Parameter Nr.	Benennung	*	Einstellbereich		Preset 1000R	768-	768-	367-	367-	381	327-	367-			
			min	max		274-FLP-HP R374-FLP-HP	FA-...	170315 180315	170115 180115	382	170115 180115	170010 180010			
deutsch * T = Technikerebene, A = Ausrüsterebene, B= Bedienererebene															
F-290	=Parameter!C283	A	1	100	0	6	7	8	9	10	11	12			
Nachfolgende Parameterwerte sind mit F-290 eingestellt:															
F-013	Fadenabschneider EIN/AUS	B	OFF	ON	OFF	1	1	1	1	1	1	1			
F-111	obere Grenze der Maximaldrehzahl	T	(P-121)	6000	1000	2400	2400	3200	3000	2500	3500	2800			
F-112	Anfangsriegeldrehzahl	T	200	6000	1200	=	800	=	=	=	=	=			
F-113	Endriegeldrehzahl	T	200	6000	1200	=	800	=	=	=	=	=			
F-114	Drehzahl nach Lichtschrankenerkennung	T	200	6000	1200	=	800	=	=	=	=	=			
F-117	Drehzahl Hubverstellung = Drehzahlbegrenzung (DB2000)	T	400	6000	2000	1600	1600	1800	1800	=	1800	1800			
F-123	Riegelsynchronisationszeit für Endriegel	T	0	500	40	=	=	50	50	=	50	50			
F-124	Riegelsynchronisationsdrehzahl für Endriegel	T	200	3000	500	=	400	400	400	=	400	400			
F-136	Schneidstich rückwärts/vorwärts	T	0	4	0	=	2	2	1	=	1	1			
F-153	Haltekraft im Maschinenstillstand	T	0	50	6	=	=	20	20	=	20	20			
F-170	Referenzpunkt (EP = Eintauchpunkt Nadel in Stichplatte)	T	0	0	*EP	=	=	=	=	=	=	=			
F-171	Nadelposition 1 = einlaufende Flanke (Pos.1)	T	0	359	42	=	37	21	21	102	21	21			
	Nadelposition 1a = auslaufende Flanke	T	0	359	140	=	=	=	=	=	=	=			
	Nadelposition 2 = einlaufende Flanke (Pos.2)	T	0	359	326	252	=	=	=	322	=	=			
	Nadelposition 2a = auslaufende Flanke	T	0	359	357	3	=	3	3	=	3	3			
F-180	Anzahl der Rückdrehschritte	T	0	359	63	=	42	42	42	=	42	42			
F-182	Rückdrehen ON / OFF	T	OFF	ON	OFF	=	1	1	1	=	1	1			
F-186	Stiche bis zum Absenken der Transportwalze	T	0	254	0	=	=	10	10	=	10	10			
F-190	Einschaltwinkel des Fadenabschneiders	T	0	359	56	=	119	161	161	210	161	161			
F-191	Ausschaltverz. der Fadenspannungslüftung	T	0	990	50	=	=	=	=	100	=	=			
F-192	Einschaltverz. der Fadenspannungslüftung	T	0	359	182	=	140	231	231	70	231	231			
F-193	Stoppzeit für Fadenabschneider	T	0	500	30	=	0	=	=	=	=	=			
F-194	Einschaltverzögerung für Fadenabschneider	T	0	359	0	=	=	105	105	=	105	105			
F-196	Funktion der beiden Fadenspannungen bei Nähfußlüftung	T	0	3	0	2	2	2	2	=	2	1			
F-197	Funktion der 2. Fadenspannung mit HP und Speedomat	T	0	3	0	1	1	1	=	=	=	=			
F-210	Stoppzeit bei Zierstichriegel	A	0	500	100	=	200	=	=	=	=	=			
F-242	Eingangsfunktion A/6 für Eingang 3	A	0	88	2	1	1	=	=	=	=	=			
F-261	Funktionen der Transportwalze / Mittenführung (NFL/RA)	A	0	3	1	3	3	=	=	=	=	=			
F-269	Versatz der Positionierung	A	0	100	40	15	15	15	15	=	15	15			
F-270	Auswahl Positionssensor	A	0	6	0	6	6	6	6	=	6	6			
F-272	Übersetzung der Motorwelle zur Maschine	A	150	9999	1000	558	558	800	800	704	900	800			
F-275	Funktionsmodule für Ausgang C an Buchse A/15 und Eingang C an Buchse	A	0	17	17	=	=	=	=	5	=	=			
F-288	Drehzahlbegrenzung für Zierriegel manuell	A	200	3000	1200	=	2400	=	=	=	=	=			

Parameter No.	Designation	*	Limits		Preset 1000R	768-	768-	367-	367-	381	327-	367-			
			min	max		274-FLP-HP R374-FLP-HP	FA-...	170315 180315	170115 180115	382	170115 180115	170010 180010			
english		* T = Technician level, A = Supplier level		(=) same as preset											
F-290	Mode "machine class"	A	1	100	0	6	7	8	9	10	11	12			
Following parameters are adjusted with parameter F-290															
F-111	Upper limit of maximum speed	T	(P-121)	6000	1000	2400	2400	3200	3000	2500	3500	2800			
F-112	Start backtack speed	T	200	6000	1200	=	800	=	=	=	=	=			
F-113	End backtack speed	T	200	6000	1200	=	800	=	=	=	=	=			
F-114	Speed after light barrier sensing	T	200	6000	1200	=	800	=	=	=	=	=			
F-117	High lift walking speed = speed limitation DB2000	T	400	6000	2000	1600	1600	1800	1800	=	1800	1800			
F-123	Backtack synchronization time for end backtack	T	0	500	40	=		50	50	=	50	50			
F-124	Backtack synchronization speed for end backtack	T	200	3000	500	=	400	400	400	=	400	400			
F-136	Trimming stitch backward	T	0	4	0	=	2	2	1	=	1	1			
F-153	Braking power at machine standstill	T	0	50	6	=		20	20	=	20	20			
F-170	Setting the reference position (EP = needle goes into needle plate)	T	0	0	*EP	=	=	=	=	=	=	=			
F-171	Needle position 1 = needle behind the bottom dead center	T	0	359	42	=	37	21	21	102	21	21			
	Needle position 1A = internal switching point	T	0	359	140	=	=	=	=	=	=	=			
	Needle position 2 = thread lever before the upper dead center	T	0	359	326	252	=	=	=	=	322	=	=		
	Needle position 2A = internal switching point	T	0	359	357	3	=	3	42	=	3	3			
F-180	Number of reversion increments	T	0	359	63	=	42	42	1	=	42	42			
F-182	Reversion ON / OFF	T	OFF	ON	OFF	=	1	1	1	=	1	1			
F-186	Stitches up until the roller is lowered		0	254	0	=	=	10	10	=	10	10			
F-190	Activation angle of thread trimmer	T	0	359	56	=	119	161	161	210	161	161			
F-191	Switch-off delay of thread tension release		0	990	50	=	=	=	=	100	=	=			
F-192	Activation angle of thread tension release	T	0	359	182	=	140	231	231	70	231	231			
F-193	Stop time for thread trimmer		0	500	30	=	0	=	=	=	=	=			
F-194	Activation delay of thread trimmer	T	0	359	0	=	=	105	105	=	105	105			
F-196	Functions of both thread tension release with presser foot lifting	T	0	3	0	2	2	2	2	=	2	1			
F-197	Functions of 2. thread tension with HP and Speedomat	T	0	3	0	1	1	1	=	=	=	=			
F-210	Stop time for ornamental backtack		0	500	100	=	200	=	=	=	=	=			
F-242	Input A6/ Input 3 (needle up/down)	A	0	88	2	1	1	=	=	=	=	=			
F-261	Functions of feed roller and seam centering guide (NFL/RA)	A	0	3	1	3	3	=	=	=	=	=			
F-269	Positioning shift		0	100	40	15	15	15	15	=	15	15			
F-270	Selection according to the position sensors	A	0	6	0	6	6	6	6	=	6	6			
F-272	Transmission ratio between motor shaft to machine shaft	A	150	9999	1000	558	558	800	800	704	900	800			
F-275	Seam suppression when 0 stitches have been set	A	0	17	17	=	=	=	=	5	=	=			
F-288	Speed limitation for manual ornamental backtack	A	200	3000	1200	=	2400	=	=	=	=	=			