



MODEL LOCKWELT 7000

LOCKSTITCH POCKET WELT
MACHINE

PARTS AND SERVICE MANUAL

PART NUMBER 97. 6900.0.001

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SAFETY

1. INSTRUCTIONS

- o This machine has been produced in accordance with European Union directives mentioned on Compliance and Manufacturer's Declaration.
- o Do not neglect to consider general laws and other rules in force – also in the country of operator – as well as law decrees and valid environment protection directives!
- o Always observe valid provisions of local professional organizations and other inspection authorities.

2. GENERAL SAFETY WARNINGS

- o Machine may only be used by operators and technical specialists trained accordingly!
- o Safety rules and operating directions shall be read prior to operating the machine!
- o Danger and safety warnings about machine shall be taken into consideration!
- o Machine may only be operated in accordance with instruction and after taking protection measures with this regard; in addition, all safety rules shall be taken into consideration.
 - o While changing parts (for example needle, sewing foot and spool), inserting thread and leaving the premises and during maintenance of machine, main switch of the machine shall be shut down and unplugged!
 - o Daily maintenance may only be performed by trained individuals!
 - o During maintenance and repair regarding pneumatic hardware, machine shall be disconnected from pneumatic power network! Exceptions are only valid for trained specialist staff during adjustment and function control works!
 - o Repair and special maintenance works may only be performed by specialist personnel or trained personnel.
 - o Works regarding electrical installations may only be performed by qualified specialists!
 - o No operation may be performed on parts and hardware under tension! Exceptions are according to directives regarding EN 50110.
 - o Modifying the form of machine or other changes shall be made in accordance with safety instructions.
- Please use spare parts provided by AMF Reece for repair work! In cases where spare parts and accessories other than provided ones are used, machine will not be guaranteed by our AMF Reece. Installation and/or use of such products may affect the formal specifications of machine in some cases. No responsibility is accepted due to any damage arising from non original parts.

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SAFETY

3. SAFETY SYMBOLS



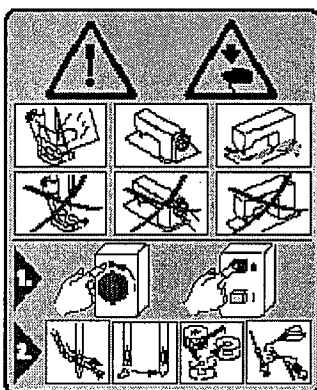
Dangerous Part!
Points to especially pay attention!



Danger of injury for user or specialized personnel!



Dangerous part due to laser beam!



Warning! Do not put your hand under mechanism and do not operate without safety equipments. Switch off the main switch before inserting thread, changing reel, changing and cleaning needle and etc.

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SAFETY

4. POINTS TO BE ESPECIALLY CONSIDERED BY OWNER

- o This handbook is an integral part of the machine and must be easily accessible by user personnel.
- o Handbook must be read before commissioning the machine for the first time.
- o User staff members and specialized personnel shall be trained about protection equipments of machine and safe working methods.
- o Owner shall only be obliged to completely operate the machine.
- o Owner shall ensure that no safety equipment is taken away or made inoperative.
- o Owner shall pay attention to employ only authorized individuals to work on the machine.
- o Other detailed information is available at authorized dealer.

5. MAINTENANCE PERSONNEL AND SPECIAL IZED PERSONNEL

- o Maintenance personnel
- o Maintenance personnel consists of individuals who are responsible from preparing the machine for use, operating and cleaning the machine.
- o Maintenance personnel are obliged to observe the following points:
 - o Safety measures in instructions manual shall be observed in all operations!
 - o All kinds of operation modification which damage safety of machine shall be avoided!
 - o Only authorized individuals shall be allowed to work on the machine!
 - o Any change that may affect the safety of machine shall immediately be informed to the owner!

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SAFETY

6. SPECIAL IZED PERSONNEL

- o Any individual professionally trained in Electrics/Electronics and Mechanics are considered as specialized personnel. Such individuals are responsible for lubricating, maintaining, repairing and adjusting the machine.
- o Specialized personnel shall be obliged to observe the following points:
- o He/she observe safety measures in instructions manual for all operations!
- o He/she switch off the main switch prior to adjustment and repair and shall take all safety measures against switching on of the machine!
- o Operation with parts and equipments under tension shall be prohibited!
- o Exceptions are regulated by EN 50110 instructions.
- o Protection cover shall closed after repair and maintenance works!

7. PROPER USE

- o This machine is intended to be used for pocket stitching production in garment industry.
- o Any use unauthorized by manufacturer shall be deemed as improper use.
- o Manufacturing company is not responsible from any damage which arises from improper use!
- o Proper use includes use, maintenance, adjustment and repair measures defined by the manufacturer!

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SAFETY

8. TECHNICAL SPECIFICATIONS

Speed	: 2100 min.-1
Stitch Length	: 19 cm
Stitch Type	: 301
Needle System	: 134-35 (R)
Needle Height	: 80-110 Nm
Stitching Motor	: See motor instructions manual
Electrical Voltage	: 230 V, 50 – 60 Hz alternate current
Power requirement	: 1,2 kW
Air pressure in operation	: minimum 5.5 bar – maximum 6 bar
Air Consumption	: about 5 3/times

Information about noise:

Pressure level for noise emission is 2000 minutes-1 1 stitch number at factory... LpA=74 dB (A)

(noise measures according to DIN 45 635-48-A-1; ISO 11204, ISO 3744, ISO 4871)

Sizes of machine:

Length: about: 1300 mm
Width: about: 1000 mm
Height: about: 1300 mm
Counter height: 850 mm

Net weight: 234 kg

- Technical modifications have been reviewed.
- KpA = 2,5 dB

9. MEASURES TO BE TAKEN IN CASE MACHINE IS SCRAPED

Measures to be taken in case machine is scraped

- The customer shall be liable from scraping the machine properly.
- The materials used in producing the machine consist of steel, aluminum, brass and various plastics.
- Electrical installation consists of plastic and copper.
- The machine is scraped in accordance with current environment protection laws in territory and probably with the help of a privately held company.
- Lubricated parts shall be disposed in accordance with local environment protection directives.

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SAFETY

10. TRANSPORT, PACKING AND STORING

- o **Transport in delivery of machine to customer**
- o Transport in delivery of machine to customer is not included in manufacturer's warranty.
- o Please ensure that machine is only transported in straight form.

- o **Disposal of Packing**

- o Packing of machine consists of wooden crate, paper, cardboard and nylon.
- o Customer is responsible from proper disposal.

- o **Storing**

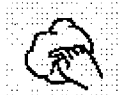
- o Machine may stored up to 6 months when not used. Machine shall be stored away from dirt and humidity.

11. WORK SYMBOLS

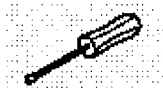
- o Detailed operations or important information are emphasized with symbols herein. Symbols used herein shall have the following meanings:



Information



Maintenance



Maintenance, Repair, Adjustment,
(to be performed only by specialized personnel)


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ASSEMBLY

1. ASSEMBLING AND PREPARING FOR FIRST OPERATION

- o After unpacking the machine, check if there is any damage due to transportation. Please notify transporter and ROBOTECH A.G representative of any possible damage.
- o  Machine must be assembled and operated by only qualified personnel! All relevant safety regulations specified herein shall be strictly observed!

2. ASSEMBLY

- o Please ensure that convenient electricity and supply connections for compressed air are available at the assembly place of machine (please refer to Technical Data, Section 3).
- o Machine should be lifted by forklift machine from transport pallet.
- o Machine shall be lifted horizontally from the ground and shall be placed in the place of assembly in a balanced manner on its four legs.

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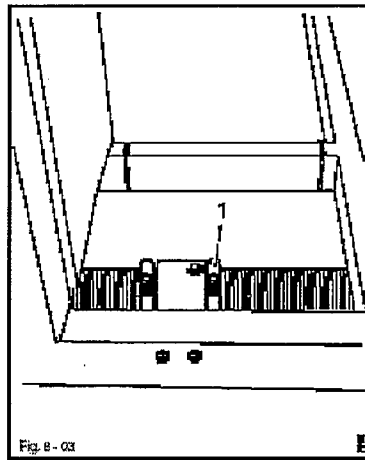
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ASSEMBLY

4. INSTALLING VACUUM (ABSORPTION) CONNECTION

- o Vacuum (absorption) connection;
- o Is inserted into hose bearings supplied with absorption and is fixed with clamp nr.1.
- o (This system is available in machines requiring vacuum installation).



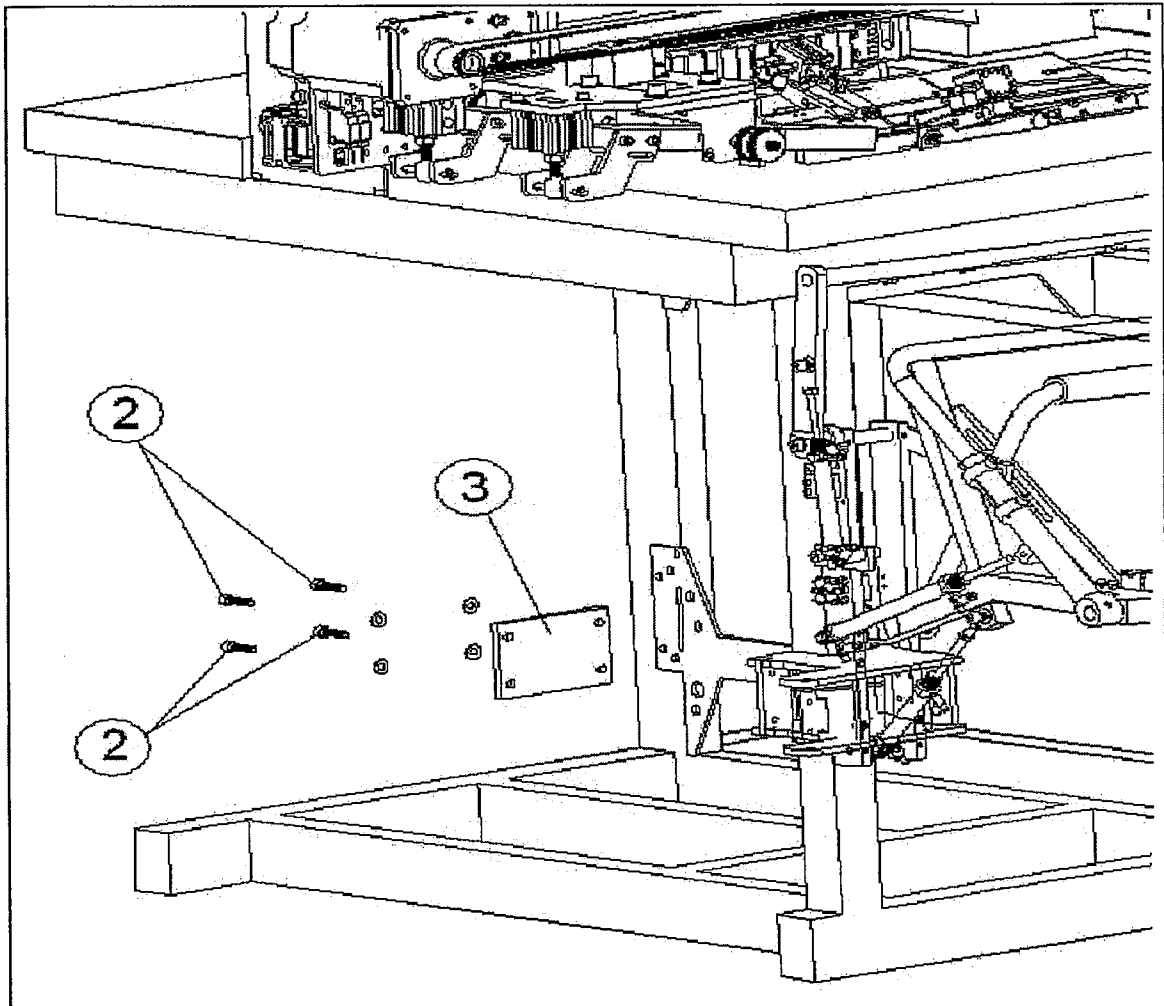
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ASSEMBLY

4. INSTALLATION OF STOWAGE MODULE



- Stowage module is connected to installation position on machine stand foot with parts numbered 3 and screw numbered 2.
- Pneumatic hoses are connected according to connection scheme

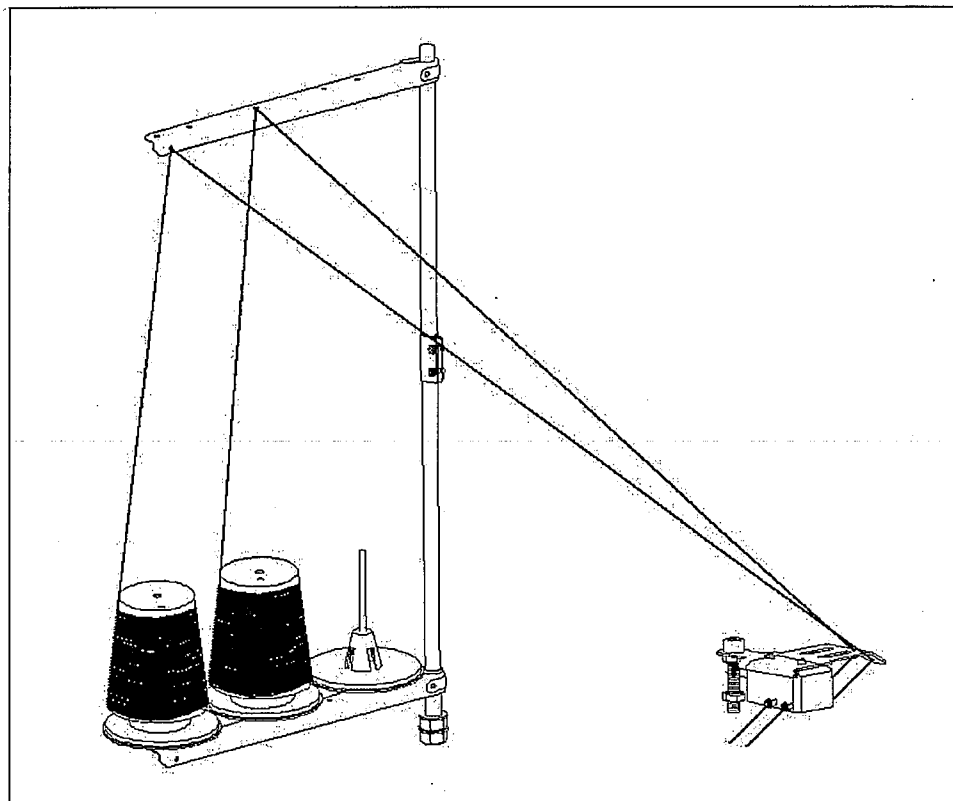
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ASSEMBLY

5. INSTALLING SEWING THREAD PATH



- o Rod of sewing thread spool is installed as shown in the figure.
- o Attach properly the thread reels to sewing thread spool.

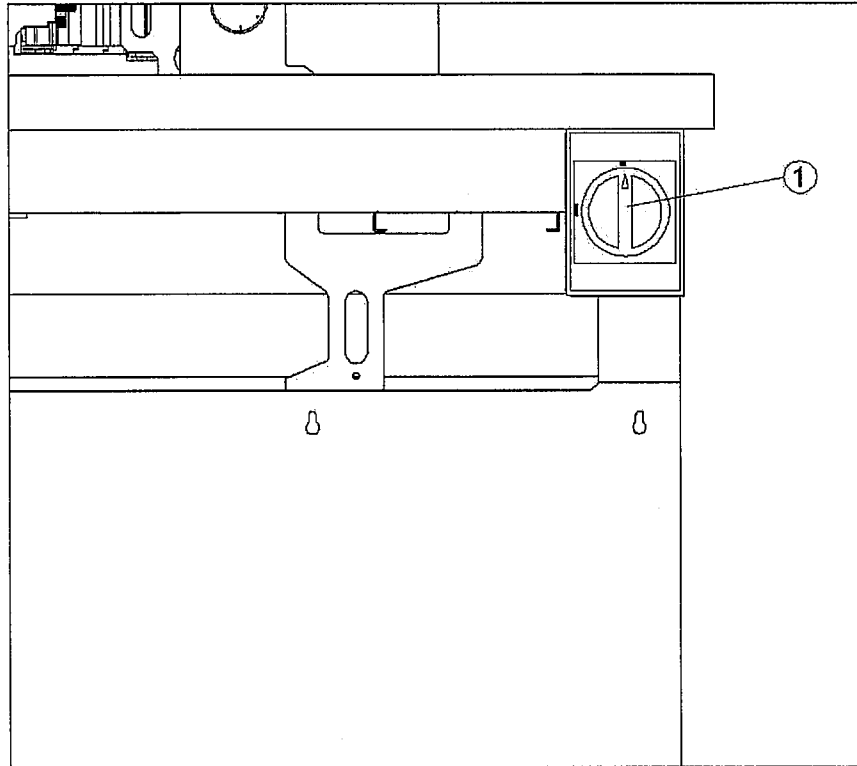
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FIRST OPERATION

- Switch on and off switch numbered 1 .



- Thoroughly clean the machine and check electrical cables and pneumatic hose connections for any damage.
- Check if current voltage is the same with the connection voltage of machine (see Machine Technical Specifications)
- Do not operate the machine in case of any conflict
- Allow only specialists to connect the machine to electricity network
- Lubricate the machine or put oil into machine (see Related Maintenance and Cleaning Section 1)
- Connect machine to compressed air system
- Nanometer on machine should read 6 bars
If necessary, adjust the value (see Related air pressure control/adjustment section)

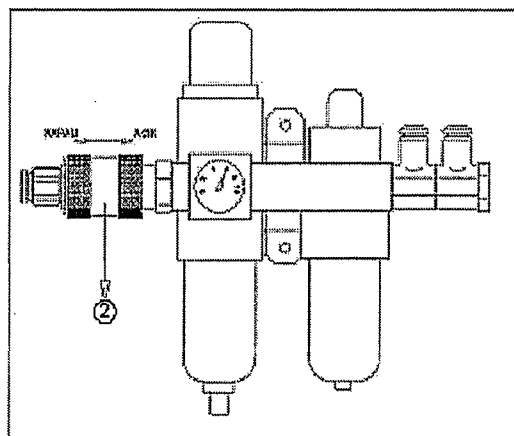
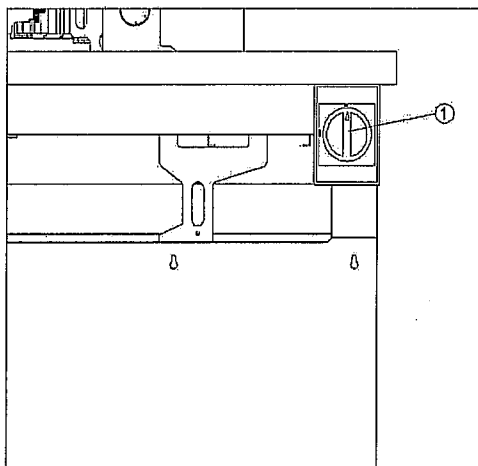
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FIRST OPERATION

1. SWITCHING ON/OFF THE MACHINE



- Open main air inlet nr. 2
 - Check air pressure and adjust if necessary
 - Adjust air pressure to at least 6 bars
 - Turn main electrical switch of machine (as in figure nr.1) to position "I".
-
- Motor switch indicated should be in on (I position) at all times.
 - Move main switch to "0" position to switch off the machine and main air inlet (figure nr.2) should be in off position.

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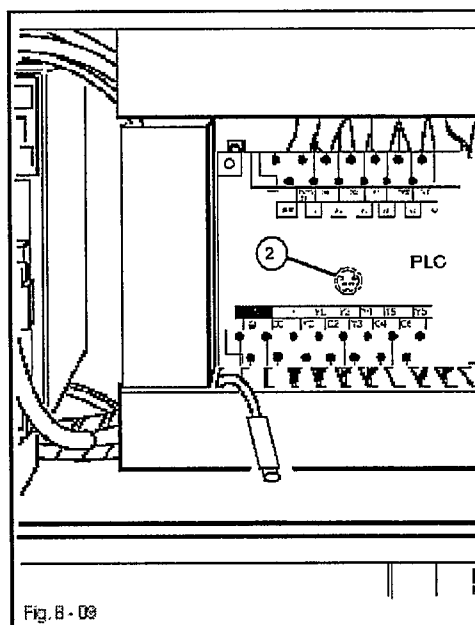
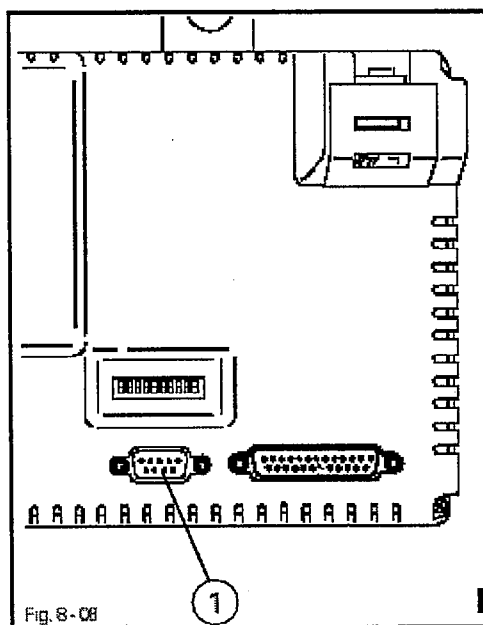
1-12

FIRST OPERATION

2. PANEL CONNECTION CONTROL

- If panel cable and pic cables are not plugged in (socket nr.1 – socket nr.2) they should be installed and screwed as below.

(One end of connection cables should be connected to COM1 socket and the other one to connection socket inside electronic control box)



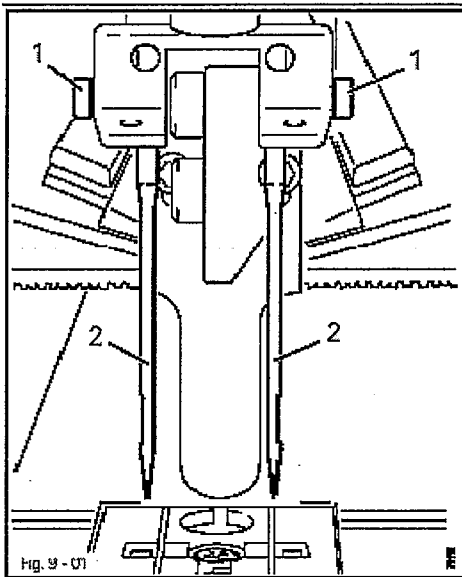
FIRST COMMISSIONING

3. PREPARING MACHINE FOR SEWING



All preparation work must only be performed by authorized personnel!

4. INSERTING THE NEEDLE



- Shut down the machine! (Danger of injury in case of sudden operation of machine!)
- Only use 134 DP 5 system needles!
- Carrier Clamp Carriage must be placed at the back
- Loosen screw nr. 1
- Mount the part nr. 2 (needle) until the lowest part in its housing.
- Groove of needles must be installed to face bobbin case.
- Properly tighten screws nr.1.

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1-14

FIRST COMMISSIONING

5. WINDING (REELS OF) LOWER THREAD/ TENSION ADJUSTMENT OF LOWER THREAD

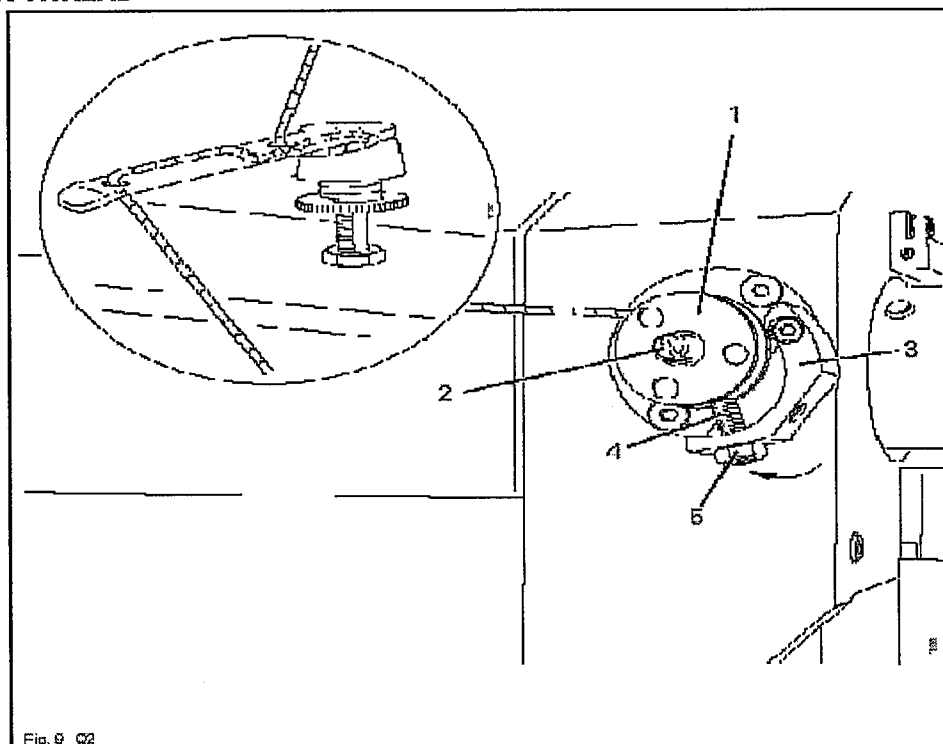


Fig. 9 C2

- Insert empty bobbins (part nr.1) into bobbin housing.
- Insert thread into thread path as shown in the magnified figure and wind clockwise for
once on bobbin
- Press arm (part nr.3) and operate the bobbin in direction of arrow.
- Bobbin (part nr.1) is automatically filled during sewing.
- Once bobbin is sufficiently filled (part nr.1), it automatically stops.
- Filling quantity of bobbin may be changed according to the adjustment of screw (part nr.4) but the screw head (part nr.5) must be loosened for this.
- After adjusting, screw head (part nr.5) must be tightened again.

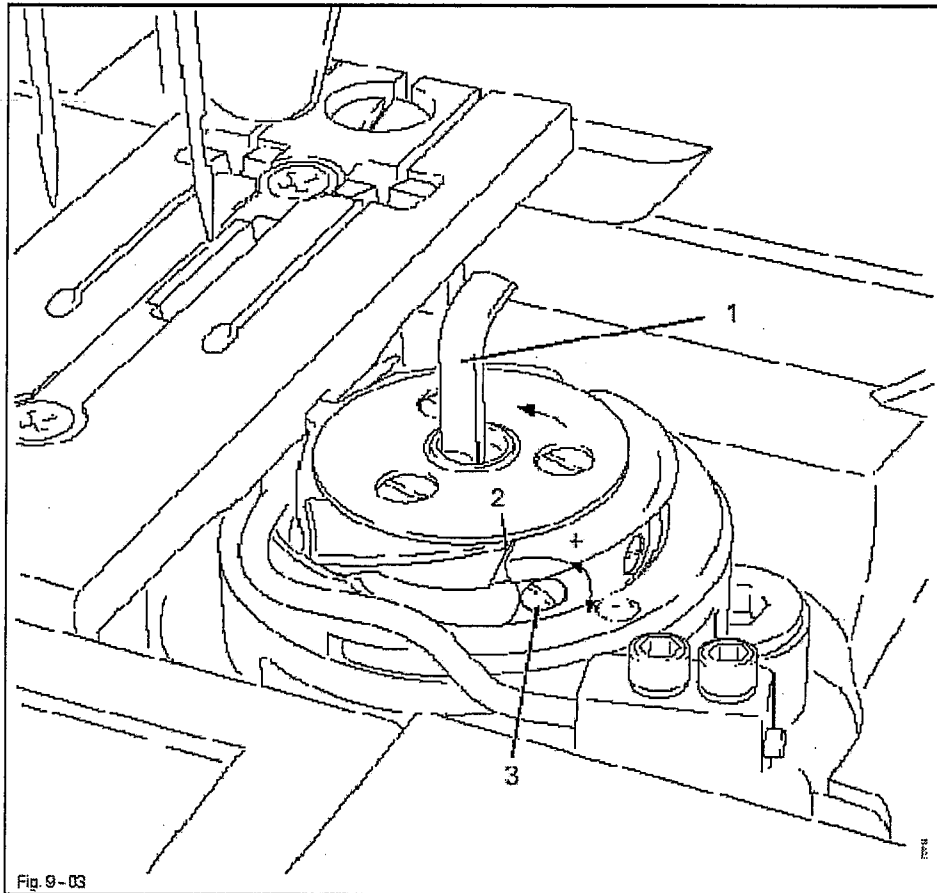
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FIRST COMMISSIONING

6. INSTALLING BOBBIN CASE & TENSION ADJUSTMENT OF LOWER THREAD



- Shut down the machine to check and replace the bobbin case.
- Pull bedplate to left and you will see the bobbin underneath.
- Lift the arm (part nr. 1) upwards and remove the empty bobbin case.
- Attach filled bobbin case to looper so that thread pulls off in the direction of arrow.
- Close the arm (part nr.1)
- Place the thread first to groove of bobbin case capsule (place nr.2) and then underneath the thread spring.
- Tension of lower thread is adjusted by turning the screw (screw nr.3).
- Pull (close) bedplate sheet to left.

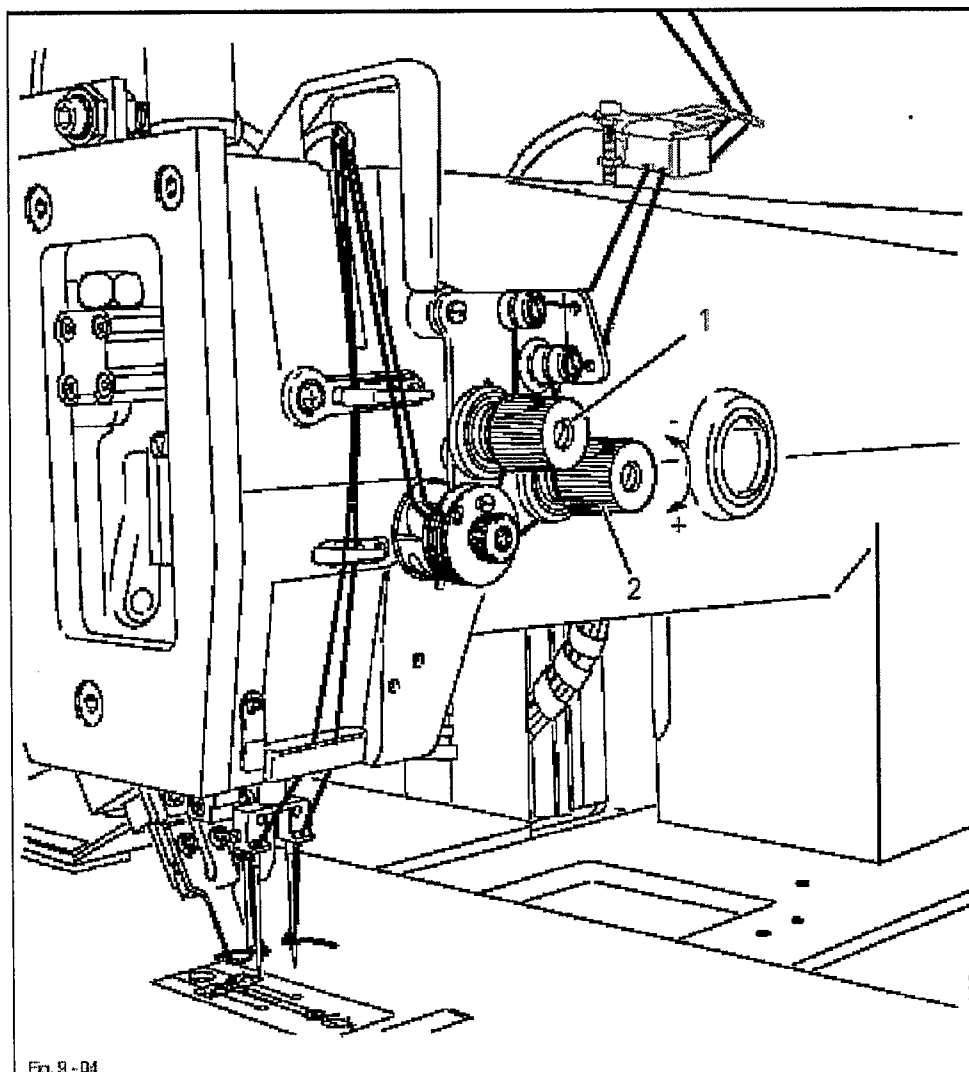
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FIRST COMMISSIONING

7. ATTACHING UPPER THREAD / TENSION ADJUSTMENT OF UPPER THREAD



- Switch of the machine.
- Push bedplate sheet to left.
- Insert completely both upper threads according to the graphic above.
- Tension of upper thread is adjusted by turning knurl screws (parts nr. 1 and 2).

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1-17

FIRST COMMISSIONING

8. REPLACING TAPE FLEECE BAND

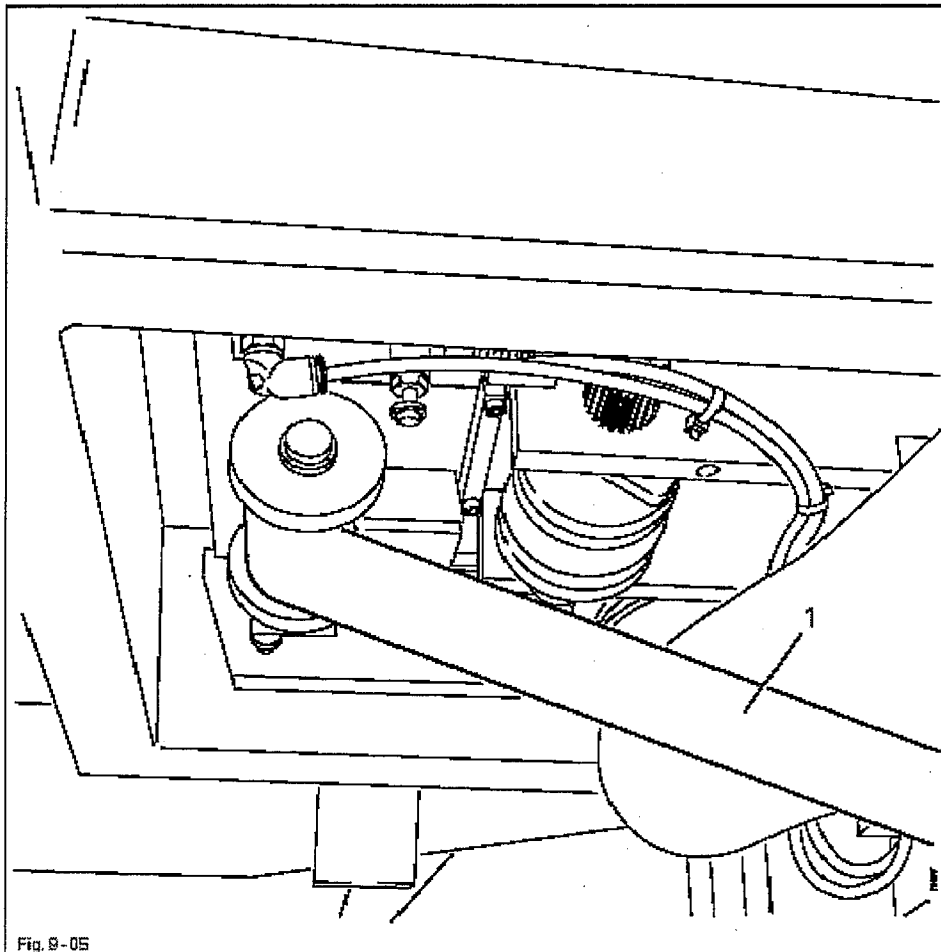


Fig. 9-05

- Insert tape fleece band as shown in figure 9-05.
- Operate the machine.
- Find 'cut and drive fleece band' in any pocket program as shown in figure below:



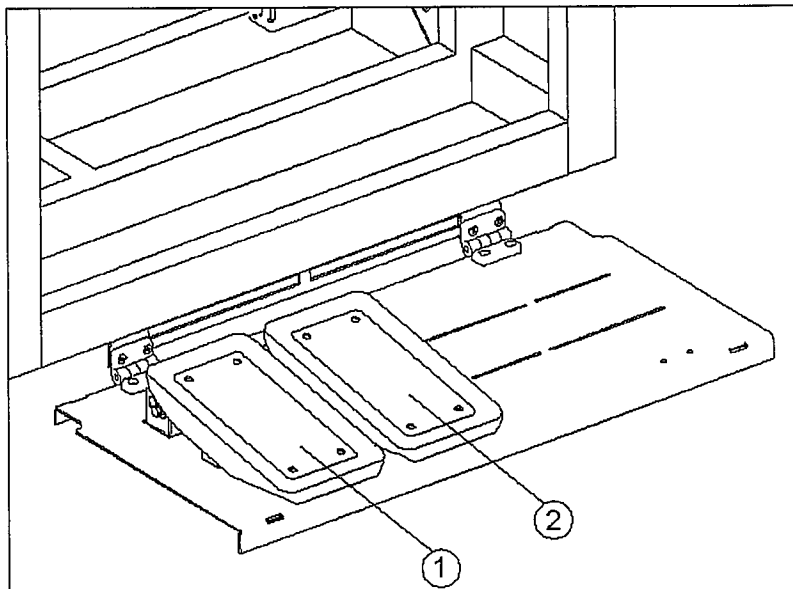
Press the button 'drive/cut tape functions' (as shown in the figure above).
Tape is driven and cut.

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1-18

PEDAL BUTTONS AND FUNCTIONS



1. FOOT PEDAL FUNCTIONS

Function of foot pedal nr. 1:

- Prepares the machine according to the settings and stitching program selected on panel.
- If trolley is behind, then trolley comes forward when foot pedal nr.1 is pressed on.

Function of foot pedal nr. 2:

- Cancels operations made with foot pedal nr. 1.
- If pedal nr.2 is pressed after starting to stitch, stitching machine immediately stops, and if pedal nr.2 is pressed again, the operation resumes.

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2. STANDARD FUNCTIONS OF FOOT PEDAL NR. 1

Operating Foot Switch:

1. Fabric Tension rot or vacuum motor runs according to the position preferred on control indicator of machine.
2. trolley comes from backwards to forwards.
3. Clamps (according to the position preferred on control indicator of machine: clamps automatically or first from right to left and left to right) descends downwards.
4. Front folding level lowers and folding plates run.
5. Cover holder lever runs (according to the position preferred on control indicator of machine)
6. Stitching starts.

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MACHINE CLEANING & LUBRICATING

MACHINE CLEANING & LUBRICATING

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MACHINE CLEANING & LUBRICATING

Cleaning entire machine	Weekly
Cleaning bobbin case section	several times per day
Checking oil level	prior to operation everyday
Lubricating latch levers	once a month
Checking air pressure	prior to operation everyday
Cleaning maintenance unit air filter	whenever necessary



Time intervals for maintenance have been calculated according to average working time of machine at a single shift factory. In case machine is operated for more, it is highly recommended to keep maintenance intervals more frequent.

1. CLEANING THE MACHINE

Time interval necessary for cleaning and lubricating the machine depends on the following Factors:

- Single or multiple shift operation
- Possibility of sewn material to get dusty

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3-2

MACHINE CLEANING & LUBRICATING

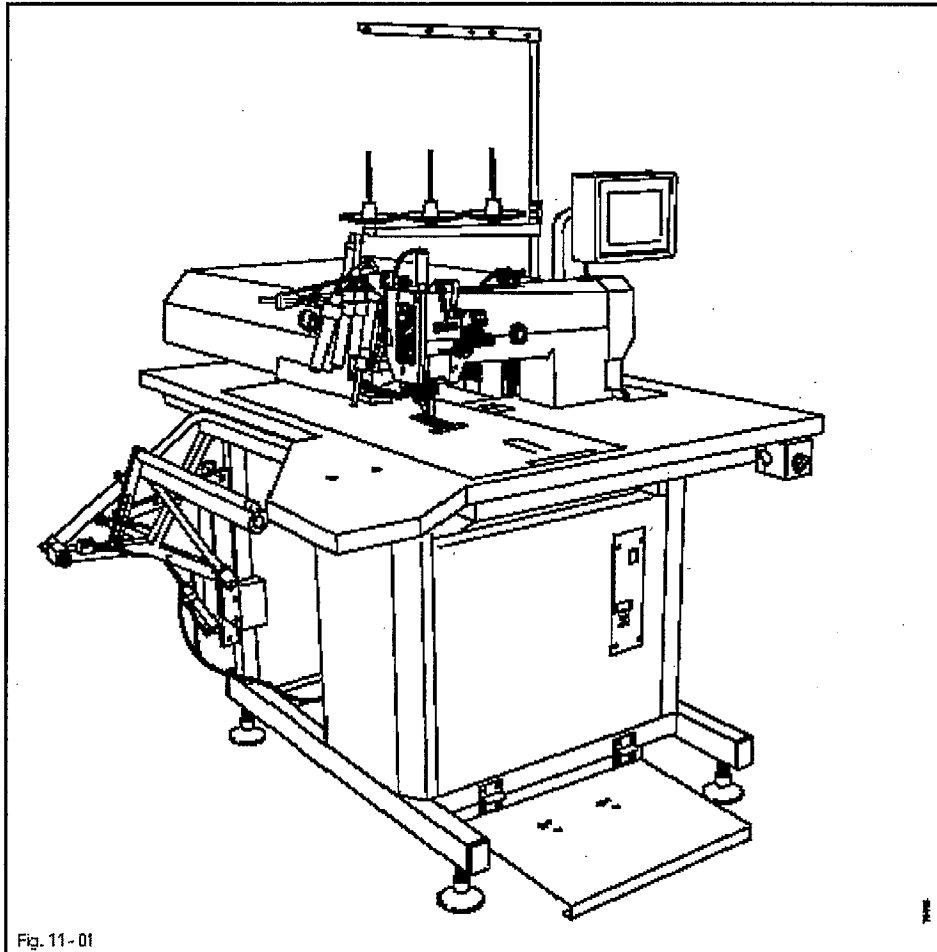


Fig. 11-01

It is recommended to carry out the following cleaning processes in order to prevent any operative failures in single shift operations:

The entire machine must be cleaned for at least once a week.

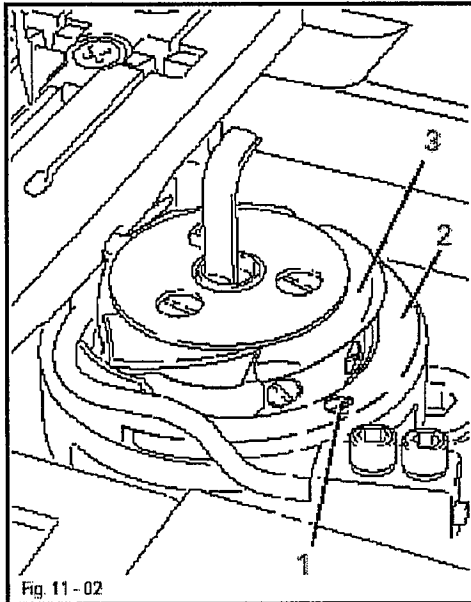
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3-3

MACHINE CLEANING & LUBRICATING

2. CLEANING THE HOOK AND BASE



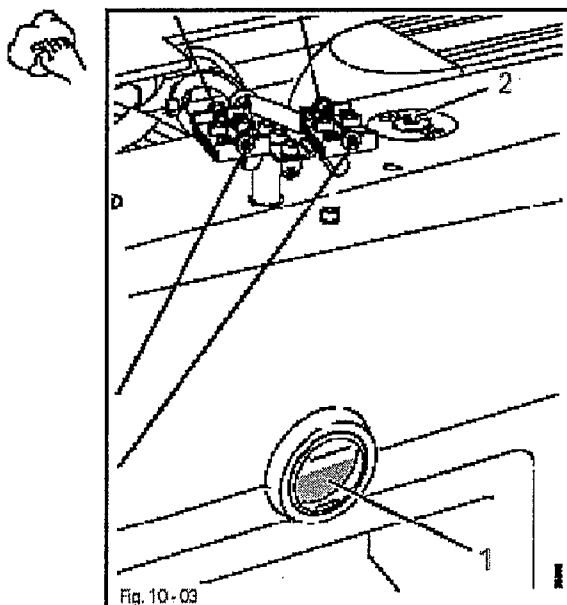
Bobbin case section and needle part must be cleaned for several times per day.

- Switch off the machine!
- Turn of air pressure!
- Remove screws nr.1
- Remove base retainer nr.2
- Turn hand pulley of head until base side stops horizontally at capsule ventilator.
- Remove base nr.3
- Clean hook and base.
- And lubricate thoroughly.
- Insert spool capsule nr. 3.
- Remove base retainer nr. 3.

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MACHINE CLEANING & LUBRICATING**3. CHECKING OIL LEVEL**

- Switch off the machine!
- Check oil level from window (figure nr.1) prior to operation every day.
- If oil is at lower level, it must be refilled until 1 oil level reaches between upper and lower level on windows.



- Use only 22,0 mm²/s oil with medium center viscosity at 40°C and density of 0,865 g/cm³ at 40°C!

4. AIR PRESSURE SETTING OF MACHINE AND CLEANING PRESSURE TUBE**Air pressure setting of machine:**

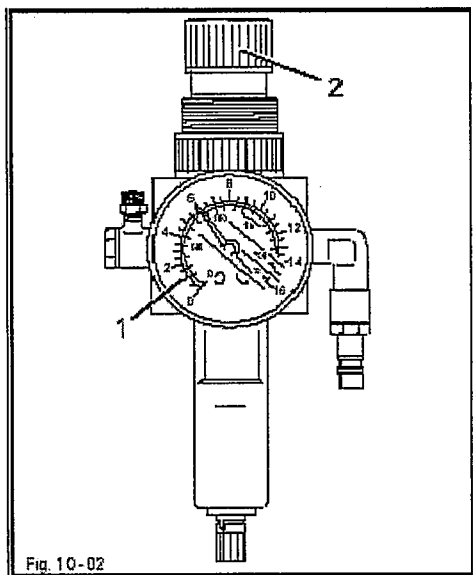
- Air pressure must be checked with manometer prior to each operation of machine.
- Manometer shall be adjusted according to air pressure of 6 bars. (Button nr.1 is pulled upwards and turned until manometer reads pressure of 6 bars and button nr.2 is pressed and fixed in place. Please see figure below).

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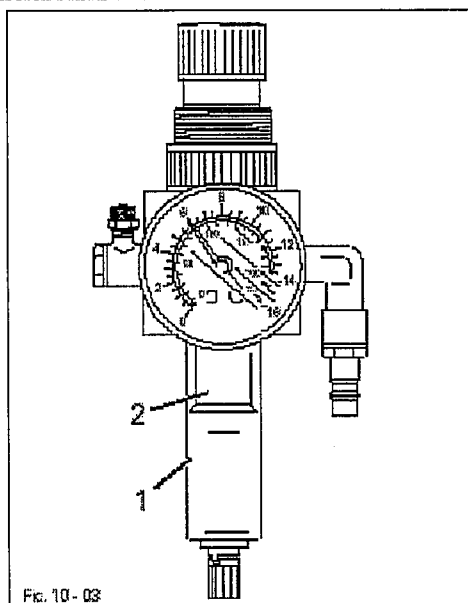
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MACHINE CLEANING & LUBRICATING



E. CLEANING MAINTENANCE UNIT AIR FILTER



- ⌘ Switch off the machine!
- ⌘ Remove compressed air pipe on maintenance unit.
- ⌘ Water container (figure nr. 1) is discharged.
- ⌘ Water container nr.1 is automatically discharged after removing maintenance unit compressed air pipe.

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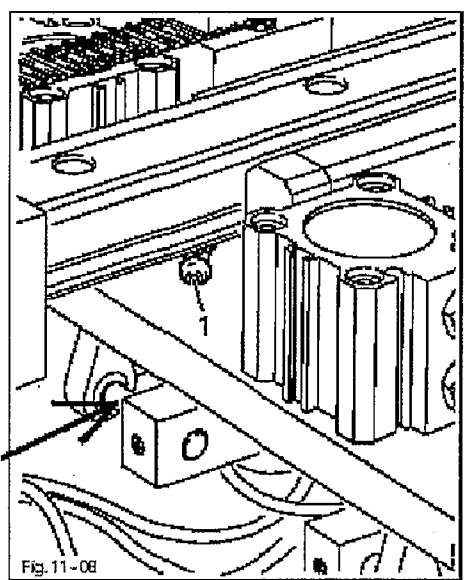
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MACHINE CLEANING & LUBRICATING

Cleaning Filter 2:

- ⌘ Water container nr.1 is removed.
- ⌘ Filter nr.2 is removed.
- ⌘ Filter nr.2 is cleaned with compressed air or isopropyl alcohol.
- ⌘ Filter nr.2 is turned and assembled and water container nr.1 is turned and assembled.



- Switch off the machine
- And prevent it from running again.
- Send clamp carriage mechanism backwards.
- Zone indicated with arrow nr.1 must be lubricated with permanent grease pump.
- This lubrication shall be performed once every two months for single shift operations and once a month for two shift operations.
- After cleaning the zone indicated with arrow
- It must be lubricated with lubricating oil once a month.

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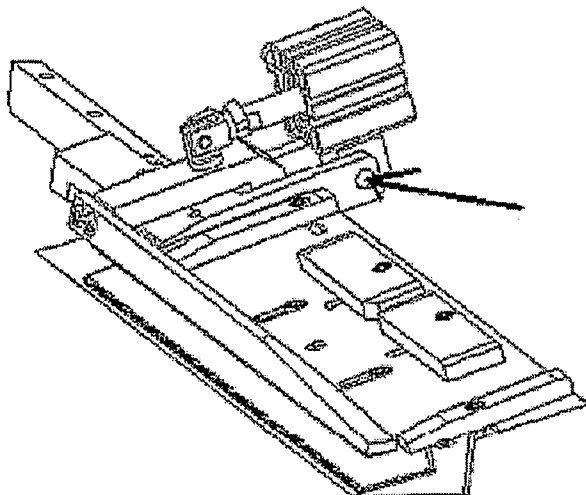
3-7

MACHINE CLEANING & LUBRICATING

6. LUBRICATING CLAMP FEET



Clamp feet must be cleaned with air everyday and the zone indicated must be lubricated with machine oil once a week.



7. LUBRICATING AND CLEANING THE MECHANISMS ON SEWING MACHINE



All lubricating holes on sewing machine and zones indicated with arrow must be properly wiped and cleaned once a week and must be regularly lubricated.

Zones on sewing head must also be lubricated.

Upper thread cutting equipment must also be cleaned several times per day.



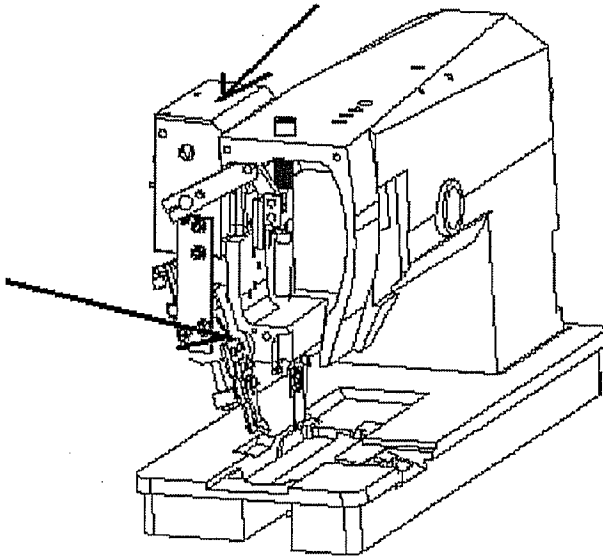
Touch 'cut and hold thread' sign on pocket programs, and clean waste thread parts accumulated at the mouth of upper thread cutting mechanism.

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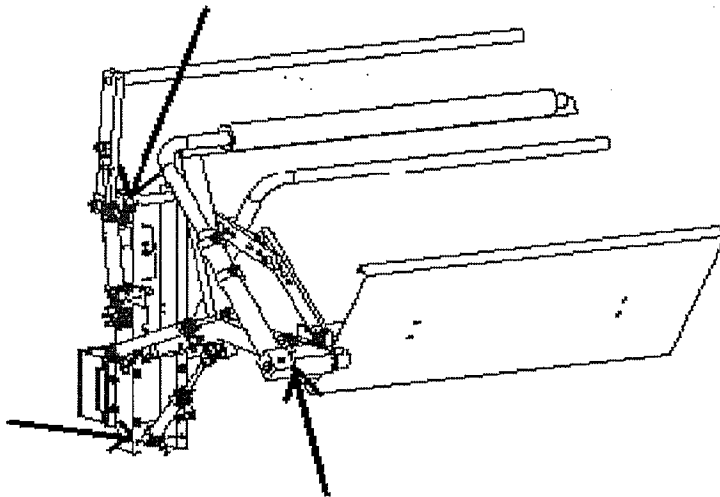
MACHINE CLEANING & LUBRICATING



8. LUBRICATING ALL JOINTS AND MOVING PARTS ON STACKING MACHINE



All joints and moving parts on stacking machine must be properly cleaned with air everyday and lubricated with machine oil for once a week.



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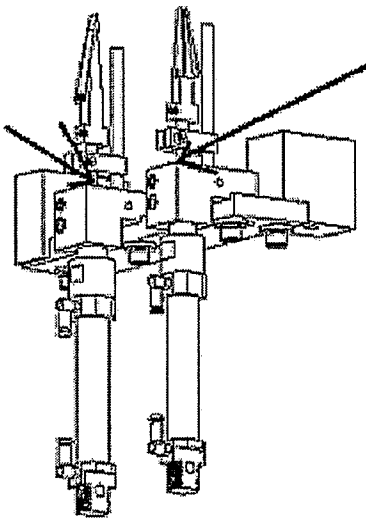
3-9

MACHINE CLEANING & LUBRICATING

9. LUBRICATING CORNER KNIFE MECHANISM

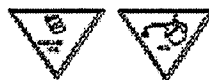
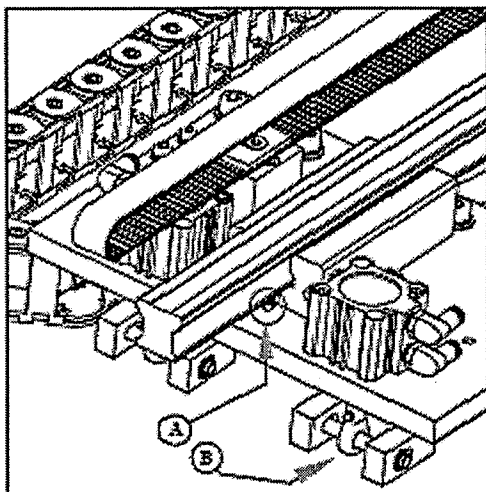


Corner knife mechanism must be cleaned with air everyday and spindles and moving parts must be lubricated with machine oil once a week.



10. PERIODICAL LUBRICATION OF MACHINE

Clamp Carrier and Clamps



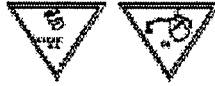
- A -** You need to make oiling in 6 month periods with grease oil.
- B -** It is necessary first to clean and then to make normal oiling in 3 month periods.

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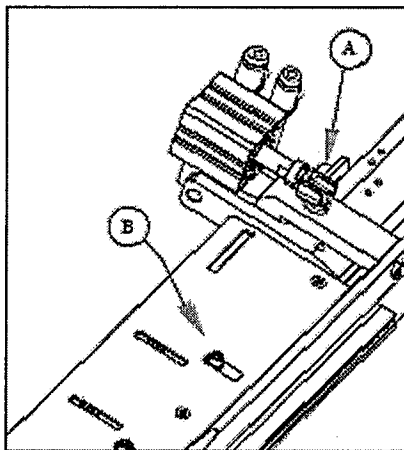
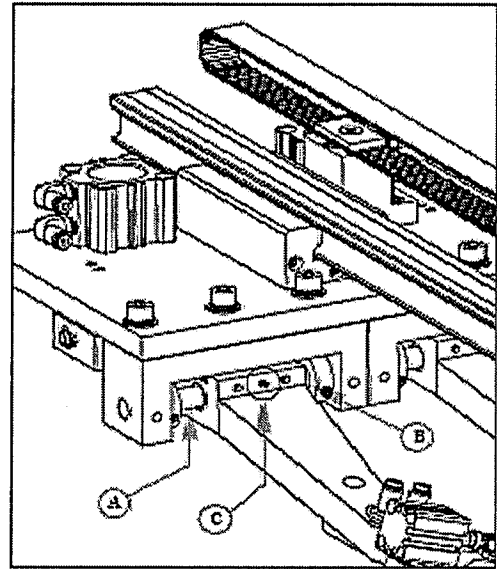
3-10

MACHINE CLEANING & LUBRICATING



A & B- It is necessary first to clean and then to make normal oiling in 3 month periods.

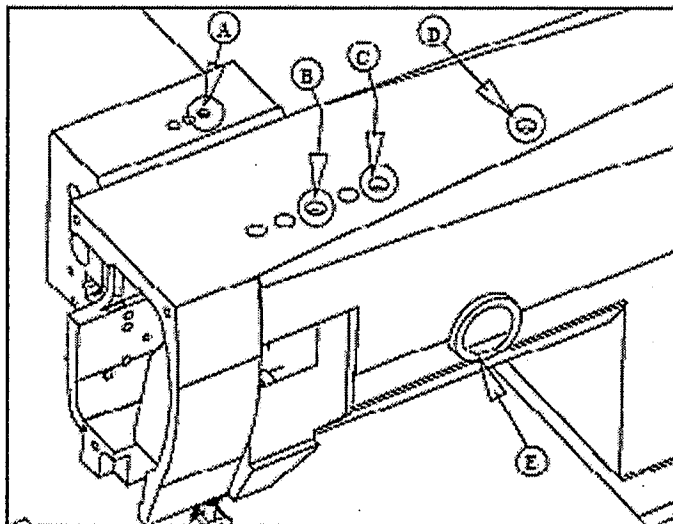
C- You need to make oiling in 6 month periods with grease oil.



A- It is necessary first to clean and then to make normal oiling in 3 month periods.

B- It is necessary to continuously clean in 1 month periods and to make normal oiling in 3 month periods.

Oil Inlets and Front of Section



A- It is necessary to make oiling in 1 month periods.

B & C- It is necessary to make oiling in 3 month periods.

D- The oilbox "E" on top of the machine head is the place I which normal oil is added. When the oil level in the Oilbox becomes lower than the minimum required level, add oil to the oilbox from the "D" point.

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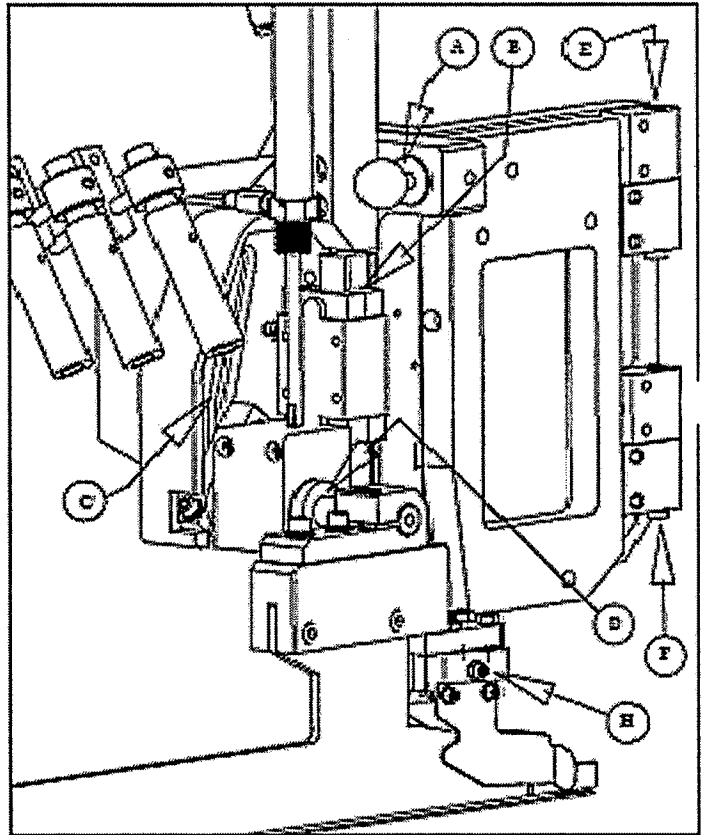
3-11

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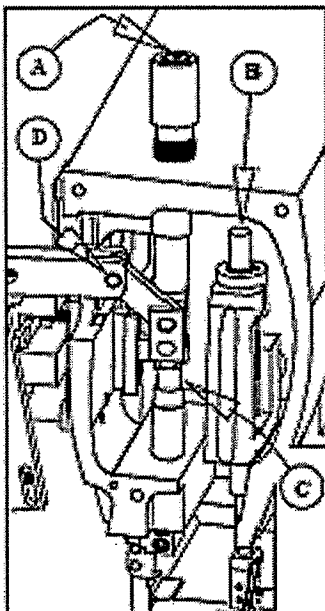
MACHINE CLEANING & LUBRICATING



- A -** It is necessary to clean in 1 month periods and to make normal oiling in 3 month periods.
- B -** It is necessary first to clean and then to make normal oiling in 6 month periods.
- C -** It is necessary first to clean and then to make normal oiling in 6 month periods.
- D -** It is necessary first to clean and then to make normal oiling in 6 month periods.
- E & F -** It is necessary first to clean and then to make normal oiling in 6 month periods.



Clamp Carrier and Clamps



- A -** It is necessary first to clean and then to make normal oiling in 3 month periods.
- B -** It is necessary first to clean and then to make normal oiling in 3 month periods.
- C -** It is necessary first to clean and then to make normal oiling in 3 month periods.
- D -** It is necessary first to clean and then to make normal oiling in 3 month periods.

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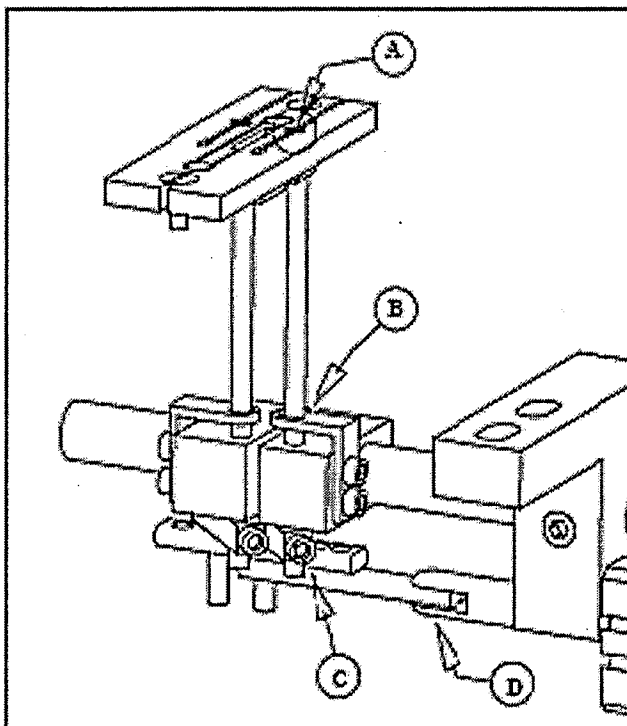
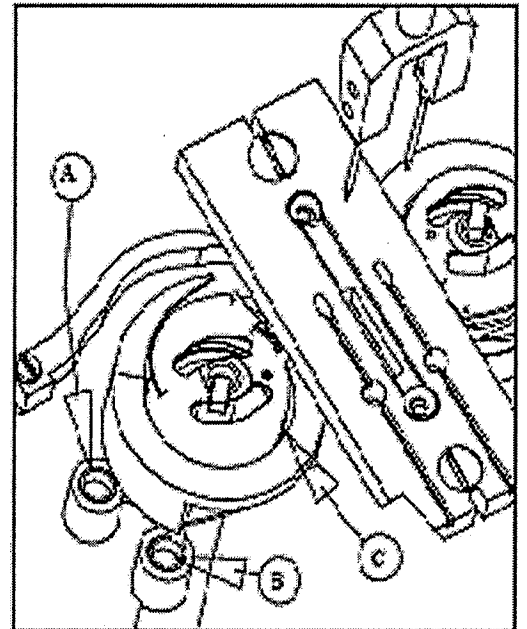
MACHINE CLEANING & LUBRICATING

A & B -

It is necessary first to clean in one week periods and then to make normal oiling carefully.

C -

It is necessary first to clean in one week periods and then to make normal oiling carefully.



A -

It is necessary to clean in weekly periods carefully.

B -

It is necessary first to clean and then to make normal oiling in 3 month periods.

C -

It is necessary first to clean and then to make normal oiling in 3 month periods.

D -

It is necessary first to clean and then to make normal oiling in 3 month periods.

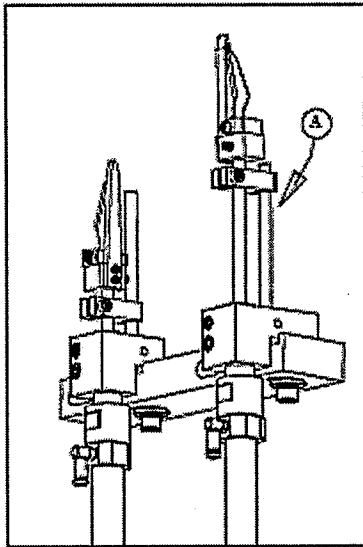
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MACHINE CLEANING & LUBRICATING

Corner Knife , Top Thread Trimmer and Arm Thread Guide



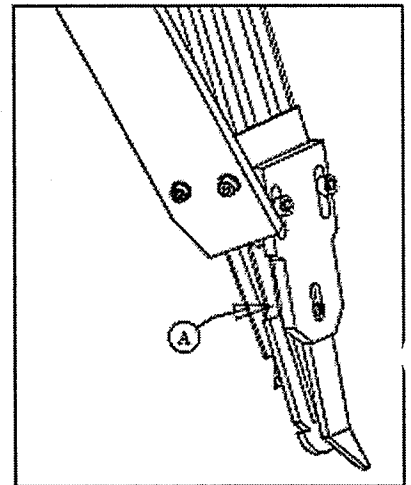
A -

It is necessary to clean very well in 1 month periods and then make normal oiling very carefully.



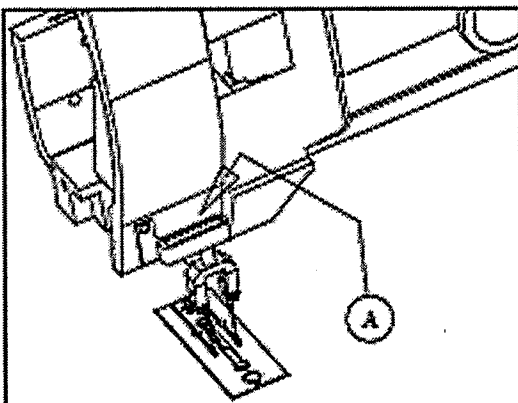
A -

It is necessary to clean in weekly periods and to make normal oiling in 1 month periods.



A -

You need to make oiling with special silicone oil in 1 Month periods and replace the thread bag every Month.



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