

# Technical Specifications Lockwelt Series

	LW 7000	LW 7000 AP
<b>Sewing Head</b>	Twin Needle Single Needle Bar	Twin Needle Split Needle Bar
<b>Stitch Type</b>	301 Lockstitch	
<b>Sewing Speed</b>	1,500-3,000 spm	
<b>Needle Bite Size</b>	12 mm standard 10 to 24 mm options	10, 12, 14 mm
<b>Welt Length</b>	20 - 190 mm (240 mm optional)	
<b>Stitch Density</b>	Start and Finish 2,5-20, Center 1,5-5 stitches per cm	
<b>Start and End Speed</b>	Programmable	
<b>Back Tacking</b>	Programmable 3 - 15 mm	
<b>Control System</b>	PLC controller with Touch Screen interface	
<b>Memory</b>	54 Pocket Styles	
<b>Cycle Sewing</b>	Up to 5 Pocket Styles	
<b>Welt Styles</b>	Single, Double, Offset with or without flap	
<b>Flap Sewing</b>	Photocell for flap length sensing both the start and end of flap: right, left or alternating combinations selectable from control panel: independent left right clamping.	
<b>Feed System</b>	EFKA DC Motor Controlled Drop Feed (Needle Feed Optional)	
<b>Carriage Drive</b>	AC Servo Motor (Step Motor Optional)	
<b>Tab Knives Drive</b>	Stationary Tab Knives System (Step Motor Optional)	
<b>Folding Station</b>	Swing out System	
<b>Quick Change Kit</b>	Standard	
<b>Bobbin Thread Indicator</b>	Standard	
<b>Needle Thread Monitor</b>	Standard	
<b>Thread Trimming</b>	Pneumatic	
<b>Laser Marking Lamps</b>	3 Standard and 5 Optional	
<b>Cycle Counter</b>	Standard	
<b>Diagnostics</b>	Standard	
<b>Operator Position</b>	Sitting	
<b>Electrical Requirements</b>	230 V 1 Phase 50/60 Hz	
<b>Crated Dimensions</b>	1350 mm (L) x 1005 mm (W) x 1500 mm (H); Table working height 850 mm	
<b>Weight</b>	225 kg	
<b>Applications</b>	Formal, informal men's/ladies'/kid's wear (suits, trousers, jackets, coats, skirts, vests), leather jackets, sportswear, workwear, ladies' handbags' zip-pockets	

## Common Features

**Stationary Tab Knives** combined with the AC Servo motor controlled carriage movement ensures high quality corner cutting on all kinds of fabric. (Please see optional mechanisms)

**Servo motor** controlled carriage movement ensures very accurate feeding of fabric for cutting operations.

**Automatic Flap Sewing**, on left or right welts, is possible with the help of a photocell system fitted as standard on the machine. Independent clamping can be activated if the operator prefers to spread the fabric before sewing operation.

**Centre Knife (1)** is controlled by an independent DC motor that is fixed on the machine sewing head.

**Clamp Feet position** (lateral distance, in or out) and clamp feet pressure can be simply adjusted especially when sewing on difficult materials.

**Cycle Sewing** allows the sewing of different types of welts in alternating combinations. Up to 5 pocket styles can be selected from the control panel for cycle sewing.

**Quick Change Kit** as a standard accessory allows the operator to sew either single or double welts by a simple change of the patch guide.

**Single and Double Welt Folders** are supplied as standard with the machine.

**Top Thread Monitor (2)** is fitted as standard and stops the machine when a thread break occurs.

**Bobbin Winder** is located on the sewing head minimizing down time when changing bobbins.

**Laser Lights (3)** are supplied as standard (3 sets) for easy placement of the fabric panel. These eliminate the need for manual marking on both trouser and jacket welting operations.

**Pocket Bag Clamp** is used for securing the pocket bag material while the operator loads the panel.

**Eight Bites Sizes** are available as options from 8-24 mm in 2 mm increments (the bite size must be specified at time of order).

**Swing out Folding Station (4)** can be opened for easy access in case of re-threading and bobbin changes.

**Tilt Back Sewing Head** allows easy maintenance.

## Optional Accessories

**Auto Tape Feeder (5)** is available for automatic loading and cutting of interfacing.

**A Vacuum System (6)** is recommended to be used for sewing welts into the back panels of trousers which have a dart seam. The system can be used with its own independent vacuum motor or hooked up to the existing plant vacuum system.

**Dart Stretcher** is used for eliminating fabric fullness before clamping and sewing.

**Universal and Trouser Stackers (7)** are available to remove the panels from the machine to increase productivity.

**Work Remover** should be used for shorter panels.

**The Automatic Patch and Flap Loader** allows the operator to utilize the sewing time by pre-loading the patch and flap ready for the next cycle.

**A Welt Notching Device** automatically cuts a slit or notch in the welt material which reduces and distributes the thickness evenly in the finished welt ends.

**Sandwich Clamp Kit (8)** is recommended for lightweight fabrics not to slip during sewing cycle. This device uses clamp arms lower support plate that is attached to the carriage. The support plate travels back and forth with the carriage, aiding in the transport of material and preventing puckering during the sew cycle.

**Zipper Attachment (9)** allows two sides of the endless plastic zipper to be inserted automatically from a roll above the machine into the welt during the sewing cycle. At the end of the sewing cycle, the zipper is cut (10) to the exact length. Only plastic zippers can be used

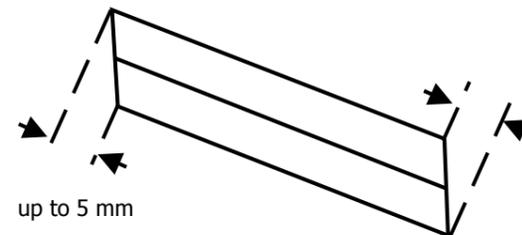
**Needle-Feed Mechanism** ensures that the material moves while the needle is in the material. This is especially advantageous when sewing on difficult materials such as slippery, thin, elastic fabrics etc.

The LW-7000 machine can be equipped with **step motor controlled tab knife system** in combination with a step motor fabric feed as opposed to stationary tab knives and servo motor feed which is the standard version. The step motor control system is optional and needs to be specified when ordering the machine.

## AP Models

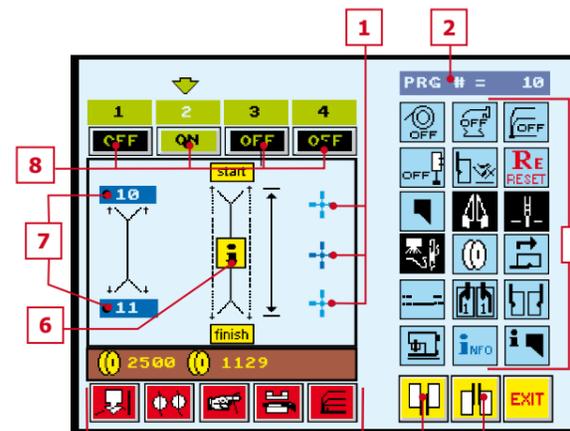
The AP versions include all of the features of the standard machine plus the added capability of making true slanted welts. The two independently driven needle bars (11) can start and finish sewing offset by up to 5 mm (see below the diagram) thanks to use of a split needle sewing head. This allows the machine to sew either straight or angle welts with and without pocket flap insertion.

The AP model uses 3 sets of tab knives (12) providing accurate corner cutting in all applications. The machine can automatically alternate between left and right side pockets or sew all the welts both inside and outside of a garment in sequence.



## Touch Screen Display

All pocketwelting machines are equipped with 5,7" graphic touch screen display that provides the operator with a user friendly working environment and with icons for every operation required to sew the perfect pocketwelt. It is possible to program 10 different pocket styles with individual sewing functions and parameters assigned. Optionally, the LW-7000 machine can be equipped with a full-color touch screen display using the same icons.



1. Sewing Position Selection
2. Pocketwelt Program Selection
3. Optional Adjustments and Functions
4. Carriage Position Selection
5. Function Buttons for Thread Tension; Stacker, Auto Tape, Thread Trimmer
6. Pocketwelt Adjustments
7. Tab Knife Adjustments
8. Cycle Mode (Pocketwelt ON/OFF)

