

***POWER*Line**

**2235**

**2545**

**2546**

SET-UP INSTRUCTIONS

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**PFAFF Industriesysteme  
und Maschinen AG**

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## 1 General Notes



The machine may only be set-up and commissioned by qualified personnel!  
All notes in Chapter 1 Safety of the Instruction Manual must be observed!



There must be suitable electrical connections at set-up site, see Chapter 3 **Specifications** of the Instruction Manual. A firm, level surface and adequate lighting must also be available at the set-up site.



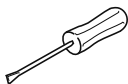
If the machine was delivered without a table, both the stand and the table top intended for use must be constructed for a weight of at least **100 kilos**.

### 1.01 Explanation of the symbols

In these Set-Up Instructions, symbols emphasize operations to be carried out or important information. The symbols used have the following meaning:



Note, information



Service, repair, adjustment, maintenance  
(work to be carried out by qualified staff only)

#### Safety symbols



Danger!  
Points to be observed.



Danger of injury for operating and specialist personnel!

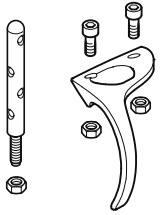
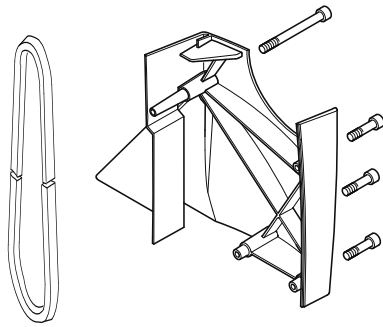

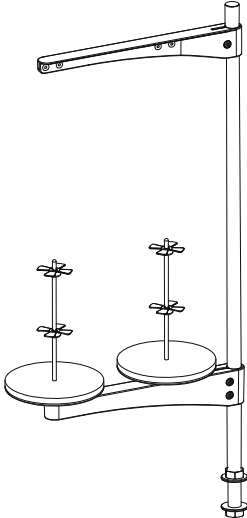
2 Scope of delivery

The scope of delivery of the machine **depends on the order**.

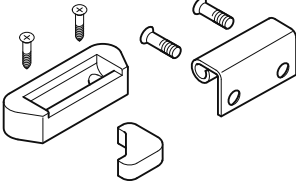

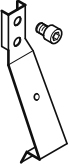
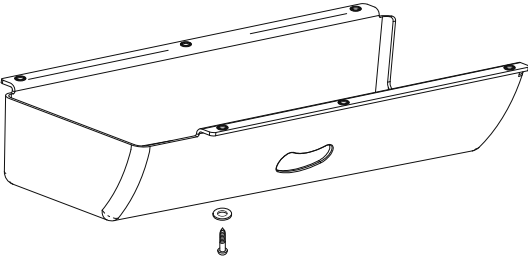
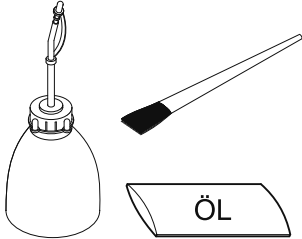
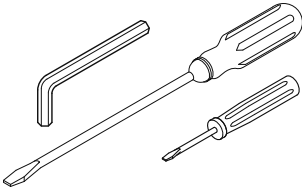
Before setting up the machine, check whether all the required parts have been included.


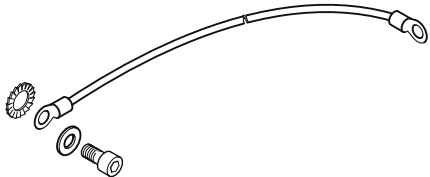
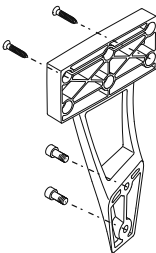
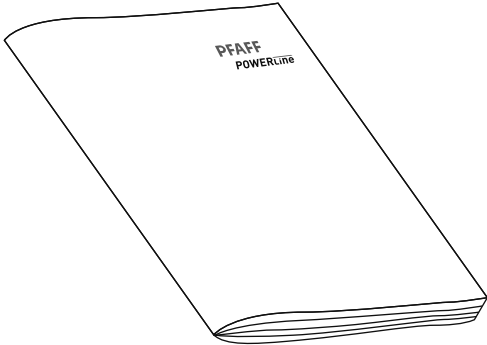
The following description only applies to one special sewing machine, for which all individual components have been delivered by the "PFAFF Industriesysteme und Maschinen AG".

2.01 Sewing machine accessories

Sewing machine accessories	Description / No. of pieces
	<p>Thread guide and take-up lever guard with screws and nuts (1x)</p>
	<p>V-belt and belt guard with screws (1x)</p>
	<p>Bobbin (5x)</p>
	<p>Reel stand complete (1x)</p>

## Scope of delivery

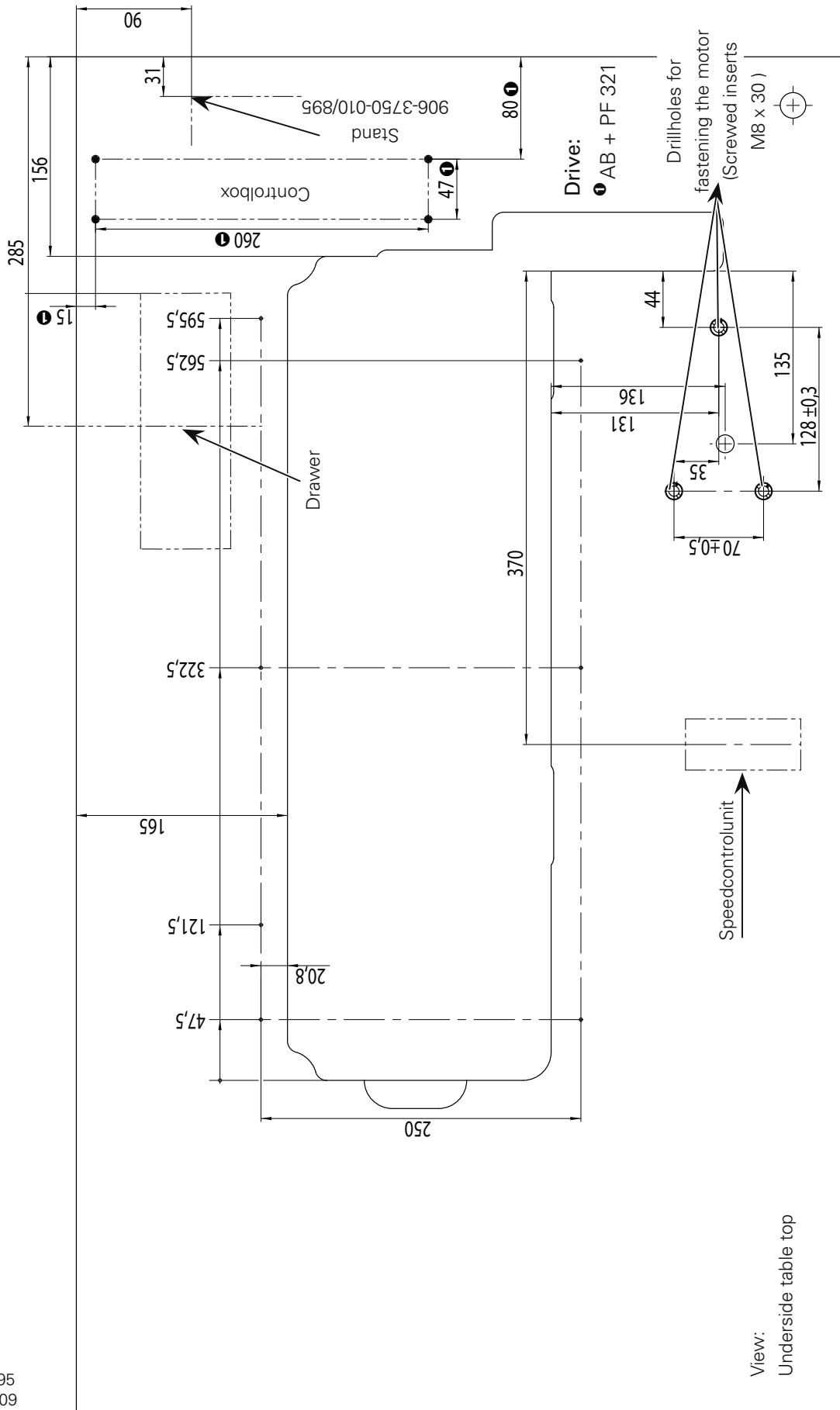
Sewing machine accessories	Description / No. of pieces
	<p>Rear rubber pads with screws (2x)            Front rubber pads (2x)            Hinge with screws (2x)</p>
	<p>Sewing head support</p>
	<p>Tilt lock (1x)            (only on the PFAFF 2545 and 2545)</p>
	<p>Oil pan with 6 screws and washers</p>
	<p>Oilcan (1x),            Sachet with 80 ml oil,            Dusting brush (1x)</p>
	<p>Allan key 3 mm (1x),            Screwdriver large (1x),            Screwdriver small (1x)</p>

Sewing machine accessories	Description / No. of pieces
	<p>Sewing head protective cover</p>
	<p>Earth cable 2235 (2x), 2545 (3x) , Screw and washers</p>
	<p>Control panel bracket with fastening screws</p>
	<p>Set-up instructions and instruction manual for the machine</p>





3.02 Assembly drawing for the table top



View:  
Underside table top

# Stand and table top

## 3.03 Assembling the stand and table top

- Assemble the stand (part no. 906-3750-010/895) and table top as shown in the following illustration.



The stand and table top must be constructed for a weight of at least 100 kg.

- When assembling the table top, please observe the assembly drawing (Chapter 3.02).

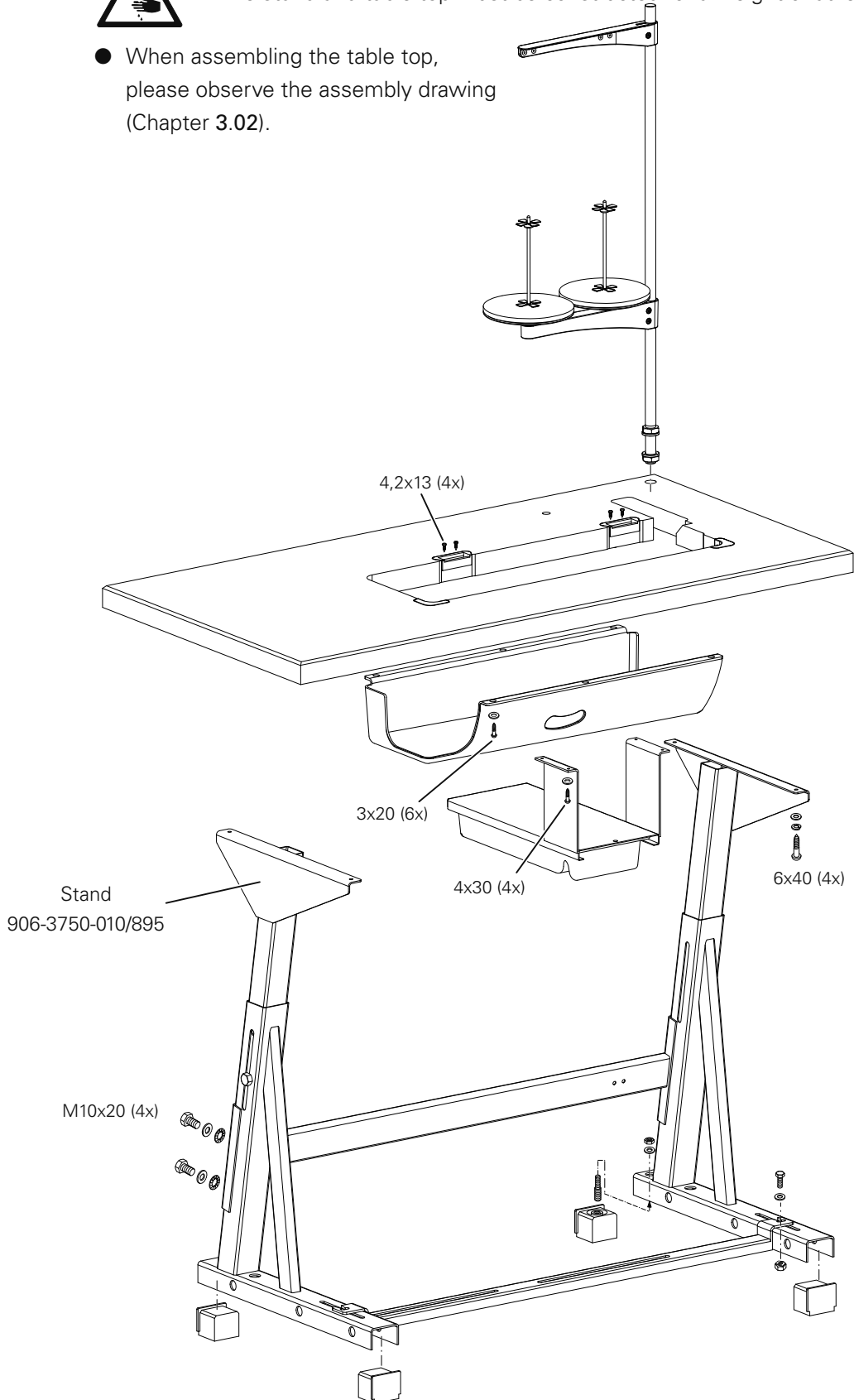
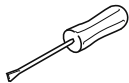
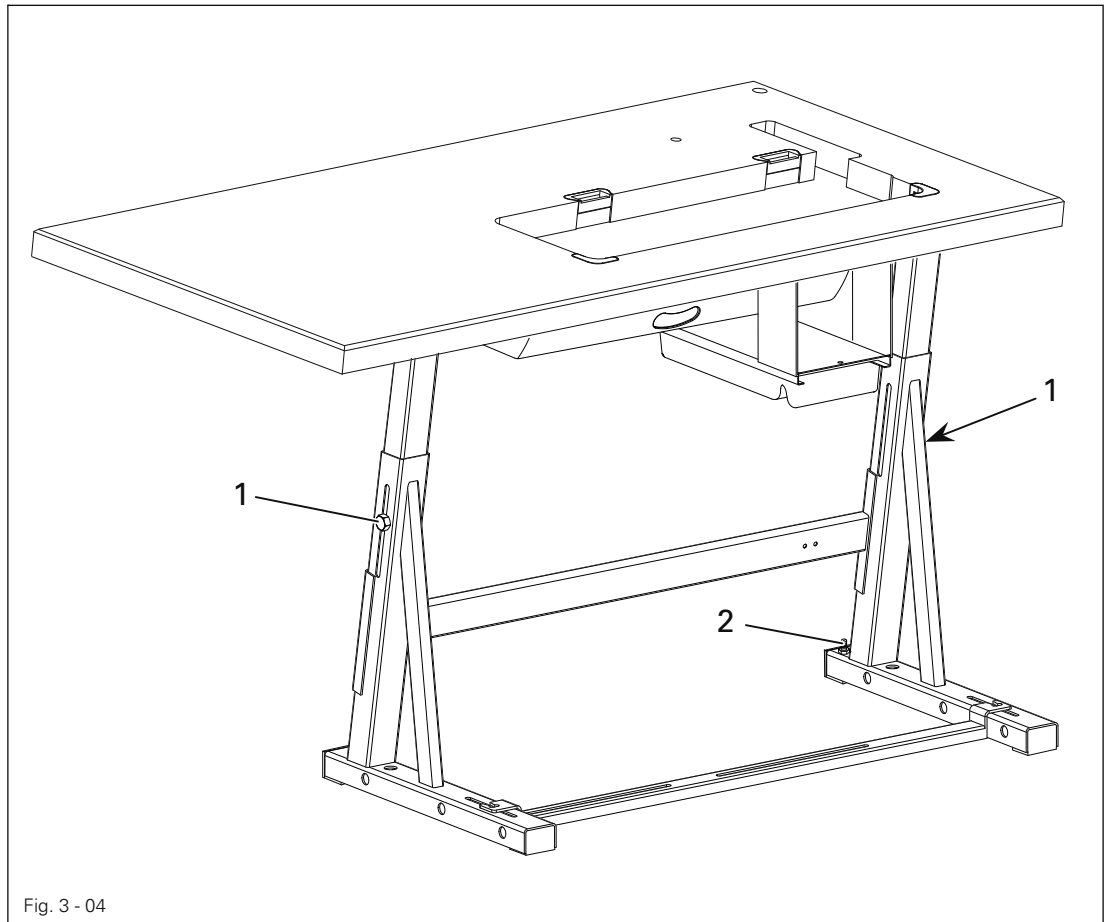


Fig. 3-03

## 3.04 Adjusting the table-top height



- Loosen screw 1.
- Adjust the table top to the required working height by increasing or reducing the height of the stand and then level the table-top horizontally.



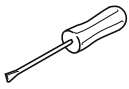
To avoid the stand tilting, adjust it evenly on both sides.

- To guarantee that the stand is standing securely, it must be positioned securely on the ground with all four legs.
- The height can be adjusted with screw 2.

## Sewing machine drive

### 4 Assembling the sewing machine drive

#### 4.01 Assembling the motor



- Mount the motor bracket, motor, belt guard bracket and pulley in accordance with the instructions in the instruction manual for the drive.

#### 4.02 Assembling the motor, speedcontrolunit and controlbox

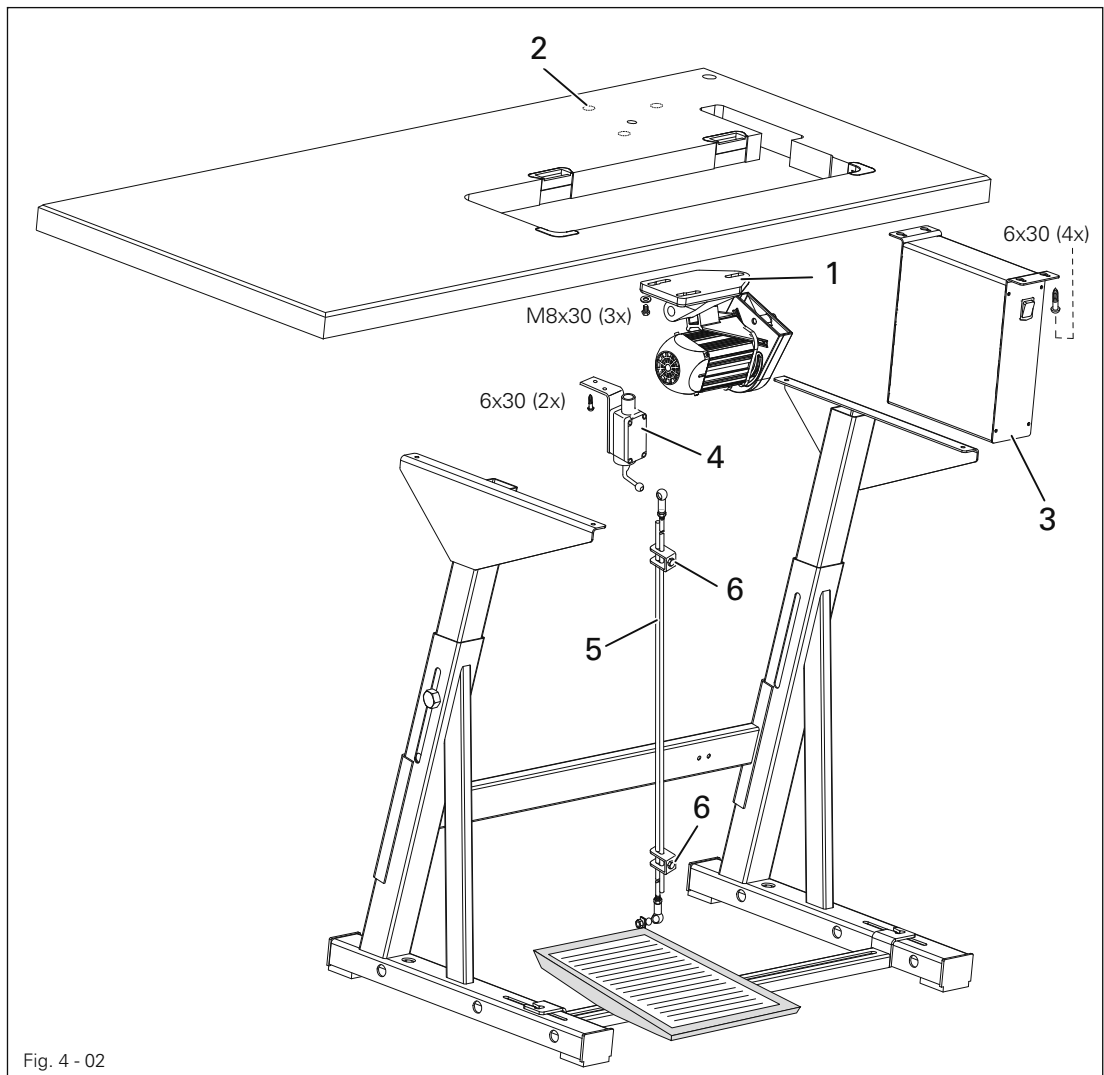
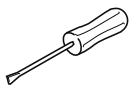


Fig. 4 - 02



- Fasten the motor mounting 1 with motor to the screwed inserts 2 of the table top with three hexagon bolts M8 x 30.
- Fit the control box 3 to the table top with four screws 6x30.
- Screw the mains cable of the control box 3 to the table top with a mains lead cleat.
- Assemble the speed control unit 4 and attach it to the table top with two screws 6x30.
- Mount the pedal on the stand's cross-bar, aligning the middle of the pedal with the centre of the needle.
- Fit connection rod 5 to speed control unit 4 and to the pedal.
- The slant of the pedal can be adjusted after loosening screw 6 (slant angle approx. 10°).

## 5 LED-Lamp (optional)

## 5.01 Assembling the LED lamp

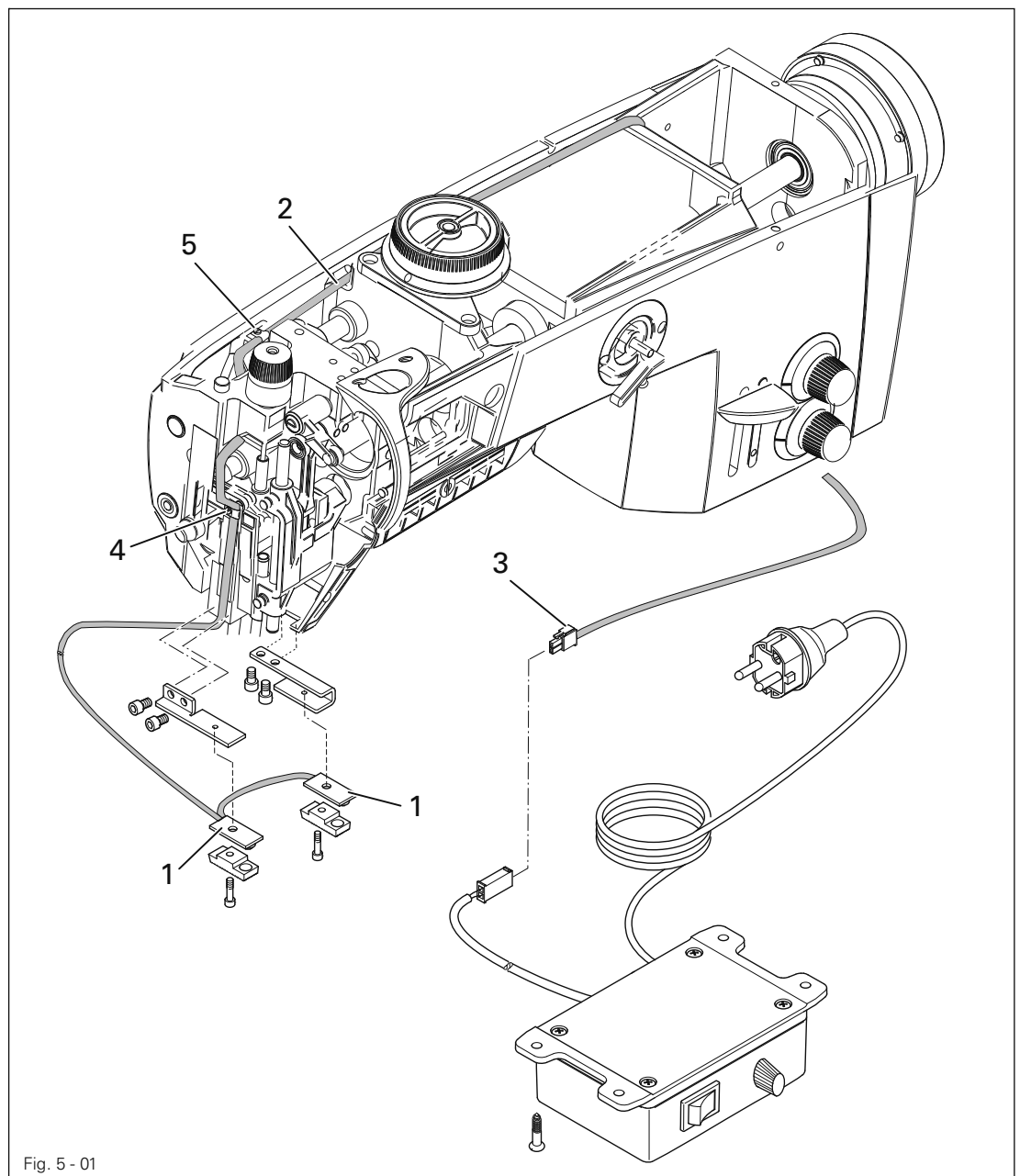
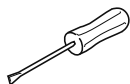
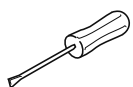
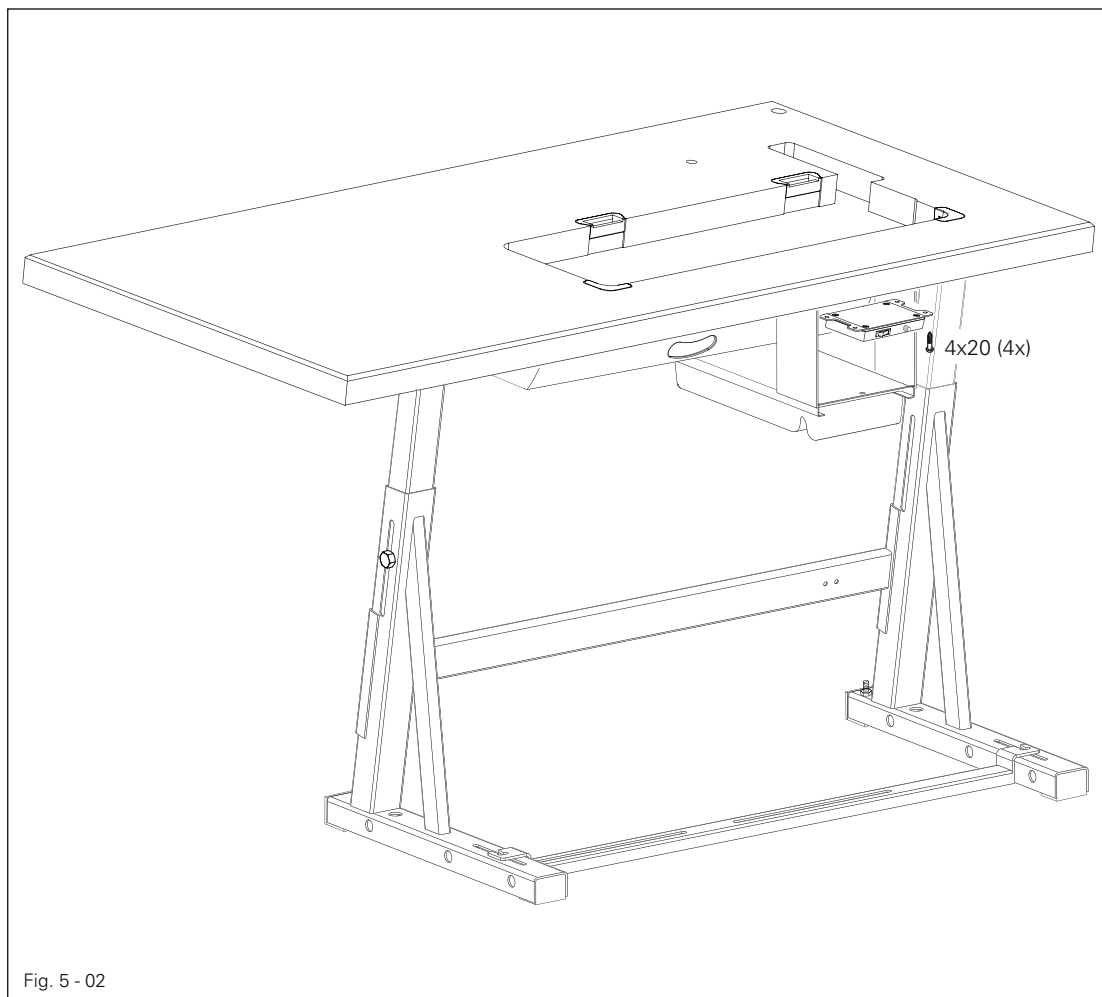


Fig. 5 - 01



- Unscrew the head and arm cover.
- Remove the complete voltage mounting plate.
- Assemble the LED lamps 1 as shown in Fig. 5-01.
- Install cable 2 in the recess of the machine arm and lead plug 3 down through the machine.
- Secure cable 2 with clamps 4 and 5 and the corresponding available screw.
- Reattach the voltage mounting plate and head and arm cover.

## 5.02 Fitting the transformer to the LED lamp



- Attach transformer 1 to the table top with four screws 4 x 20.
- Screw the power line with clamps and main leads cleat to the table top.
- Connect the cable to the LED lamp with a connector.

6 Installation

6.01 Setting the sewing machine into the stand

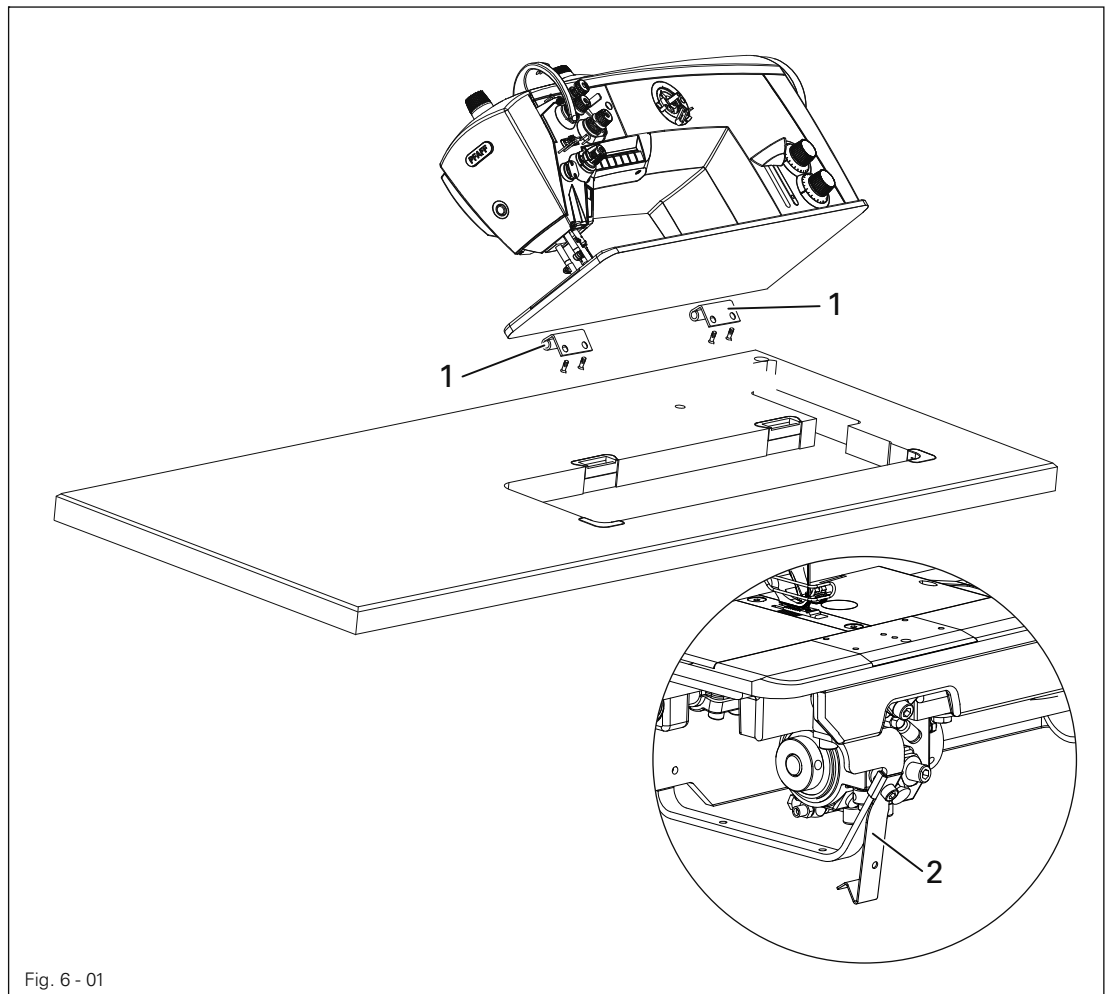
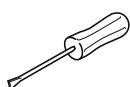


Fig. 6 - 01



- Attach each of the hinges 1 to the sewing head with two screws M6 x 16.
- On the PFAFF 2545 attach tilt lock 2 with a M5 x 6 screw (on the PFAFF 2235 the tilt lock is already attached)
- Set the sewing machine into the table top.

6.02 Fitting the V-belt and assembling the bottom belt guard

- Fit the V-belt to the balance wheel and the motor pulley.
- The V belt is tensioned by turning the motor bracket.
- Mount the lower belt guard in accordance with the instruction manual for the drive.

## 6.03 Assembling the thread guide and take-up lever guard

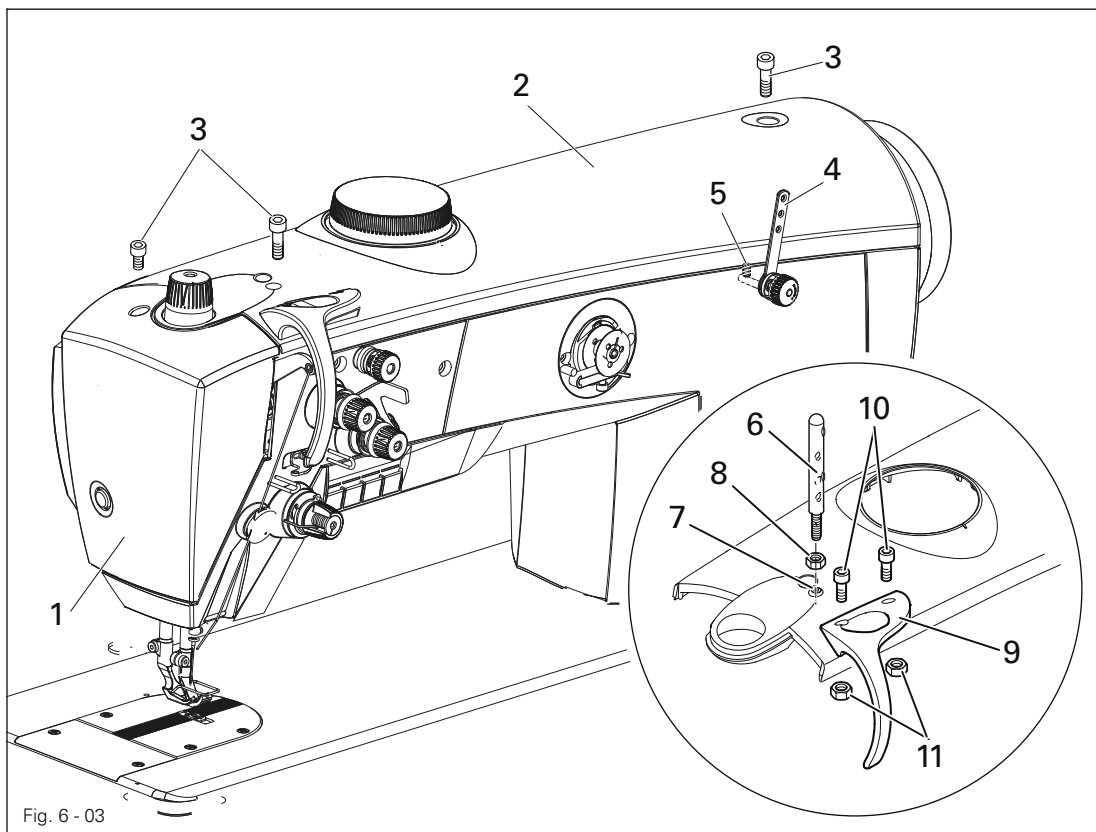


Fig. 6 - 03

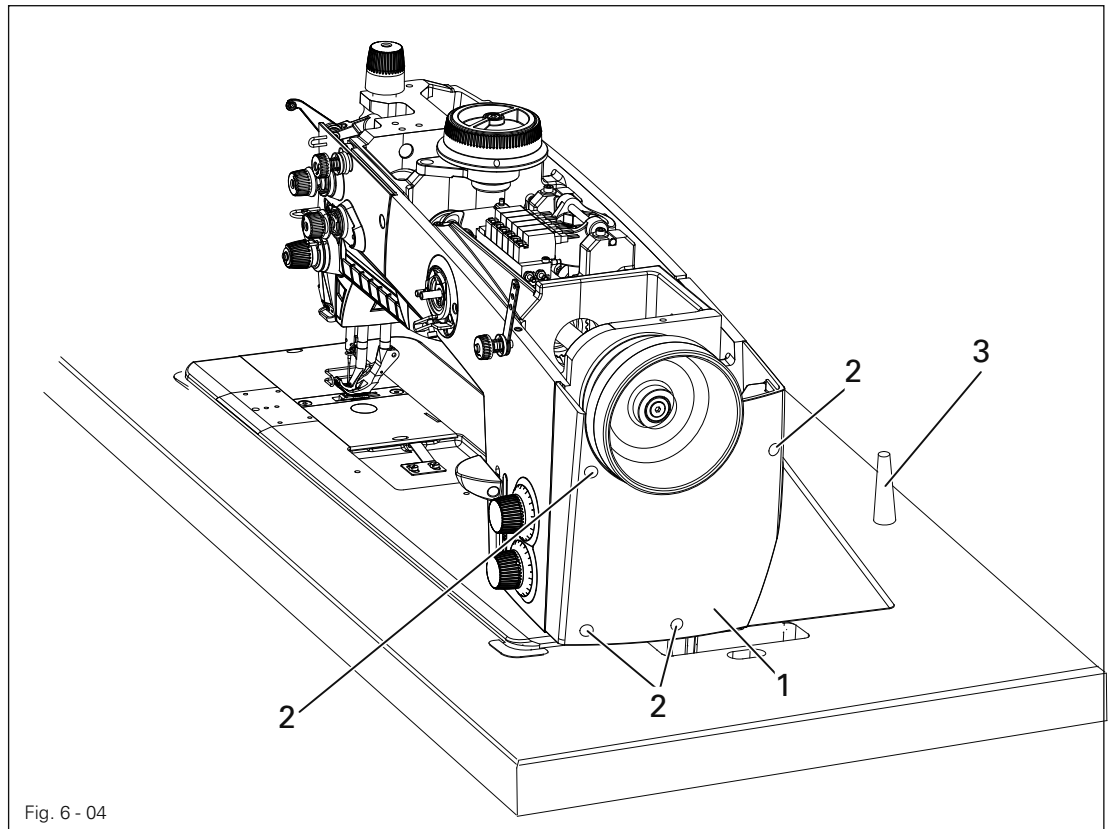
- Remove face plate 1 and arm cover 2 (screws 3).
- Adjust thread guide 4 (screw 5) as shown in Fig. 6 - 03.
- Insert thread guide 6 in hole 7, and fasten with nut 8 from below.
- Attach take-up lever guard 9 with bolts 10 (M4 x 10) and nuts 11 to arm cover 2.



Leave face plate and arm cover unscrewed for the next assembly steps.



6.04 Assembling the top V-belt guard and sewing head support



- Attach guard belt 1 with screws 2.
- Insert sewing head support 3 into the hole in the table top.



Do not operate the machine with support 3! Danger from top-heavy sewing head! Machine cannot fall over when tilted backwards!

## 6.05 Mounting the control panel

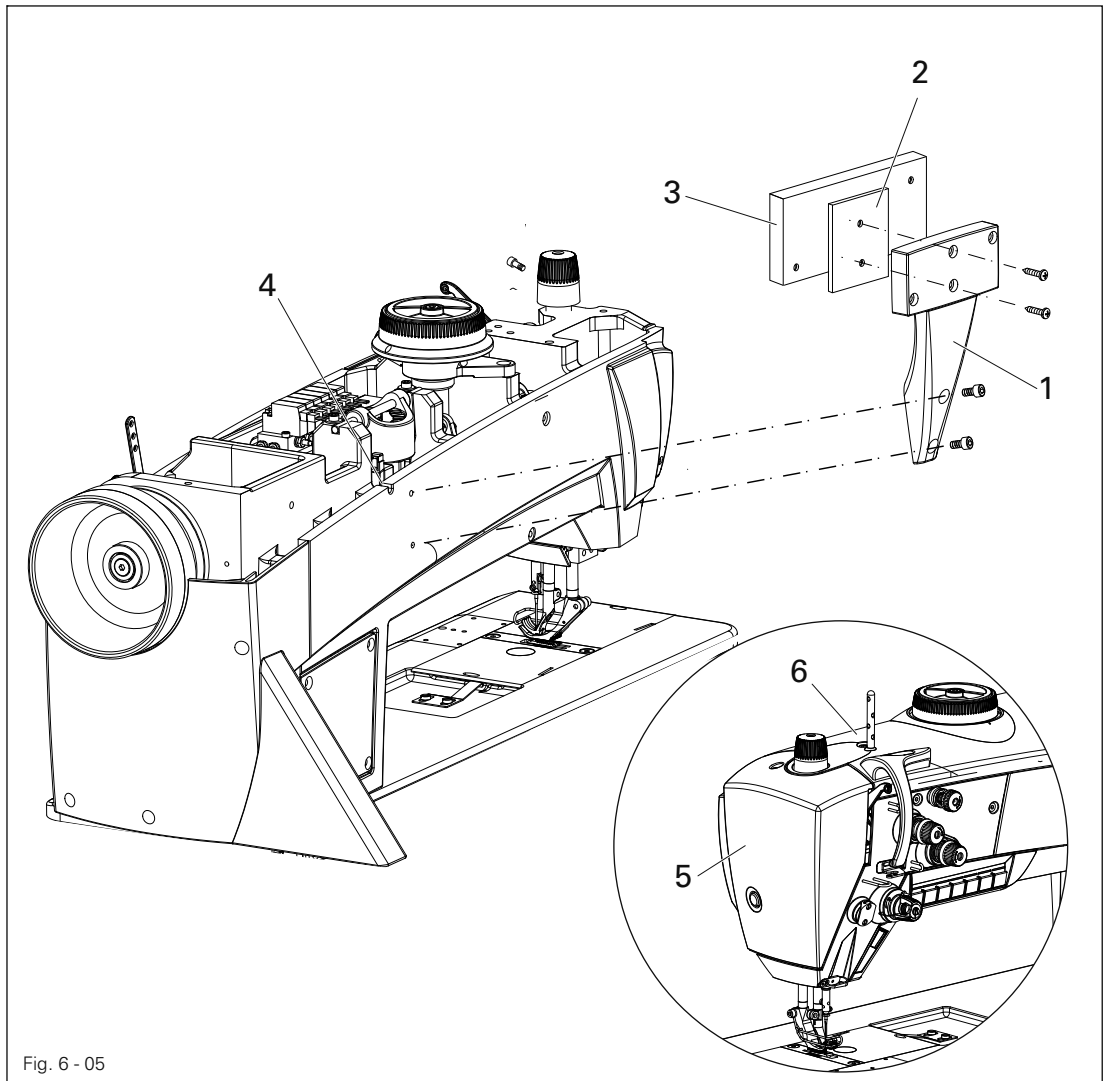


Fig. 6 - 05

- Attach the control panel bracket 1 with two screws **M5 x 12** to the machine.
- Attach spacer plate 2 with one screw **M5 x 12** to the control panel 3.
- Attach control panel 3 to bracket with two screws **5 x 10**.
- Lead the control panel cable through hole 4 in the case.
- Connect the control panel plug with the connector provided for the control panel in the arm of the machine.
- Reattach face plate 5 and arm cover 6.

6.06 Connecting the plug-in connections and earth cables

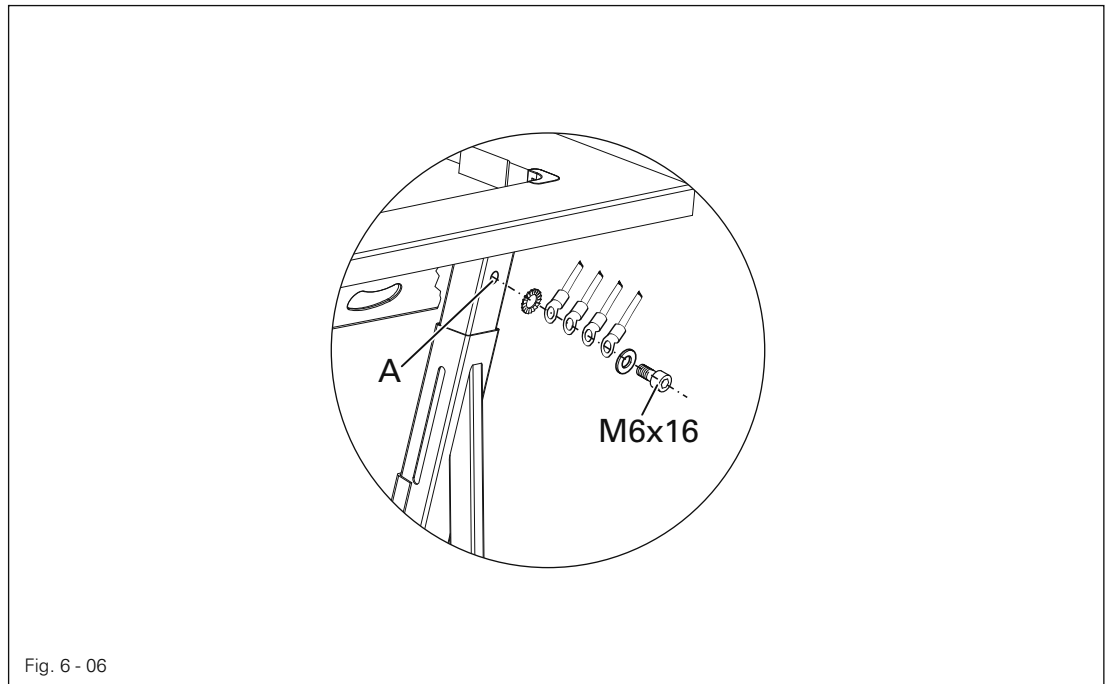
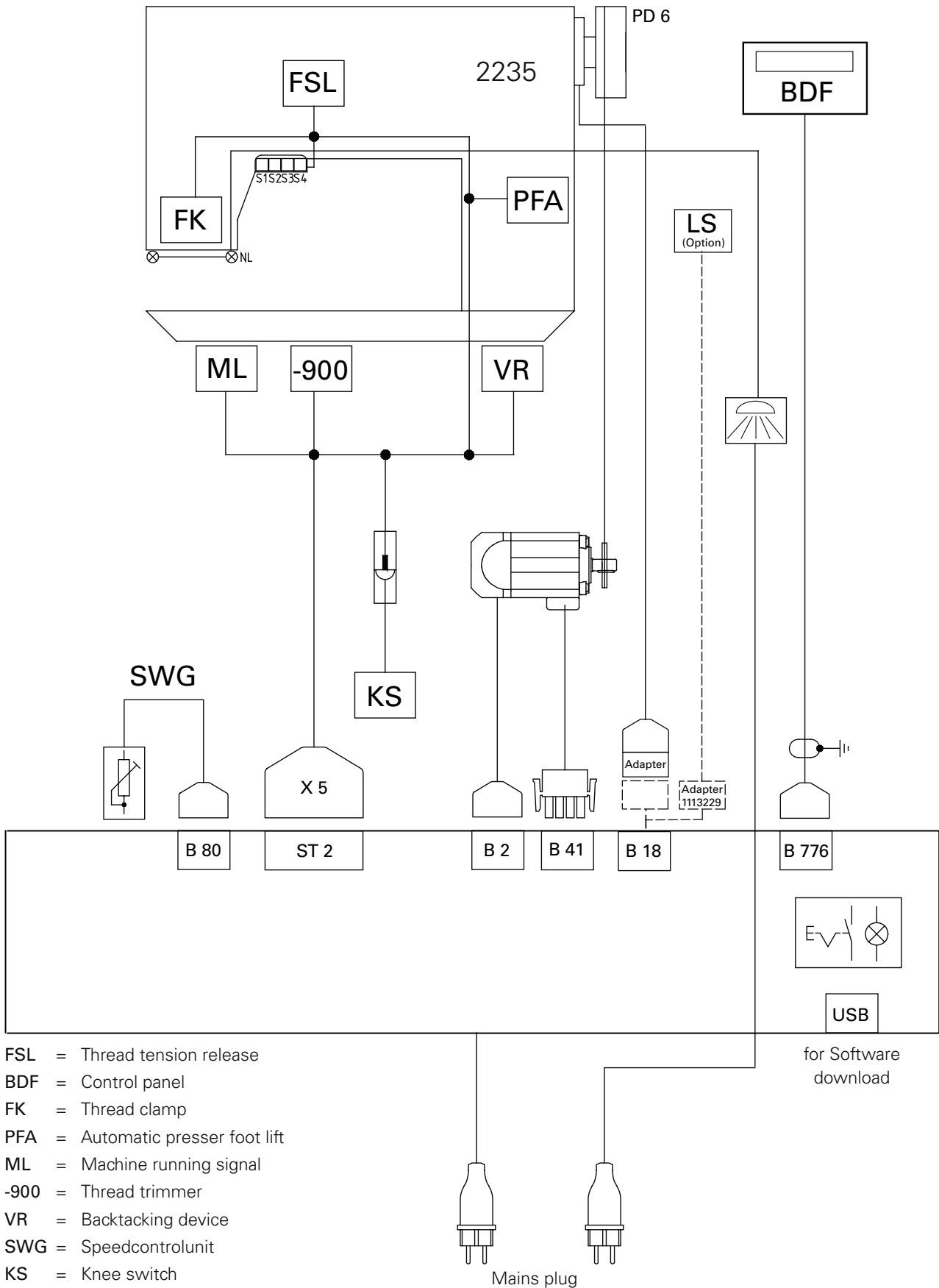


Fig. 6 - 06

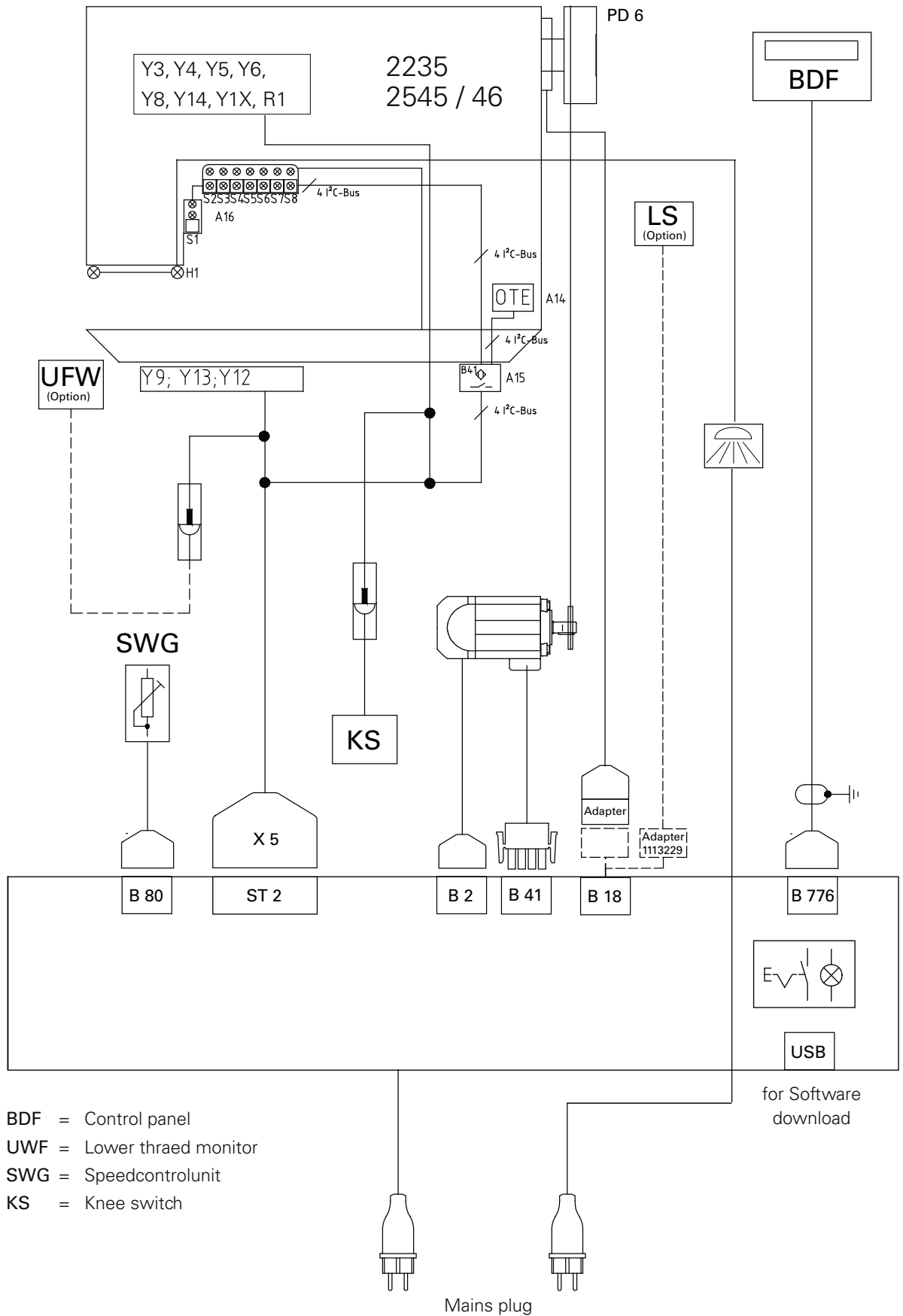
- Connect all connectors to the control unit **1** as shown in the block diagram (see chapter **6.07**).
- The following ground cables must be attached in order to discharge static electricity.
- Securely attach the ground cables for the machine to ground point **A**.
- Connect the ground point on the motor base and on the control unit by way of a ground cable to ground point **A**.

# Installation

6.07 Block diagram  
 6.07.01 PFAFF 2235 with AB 321

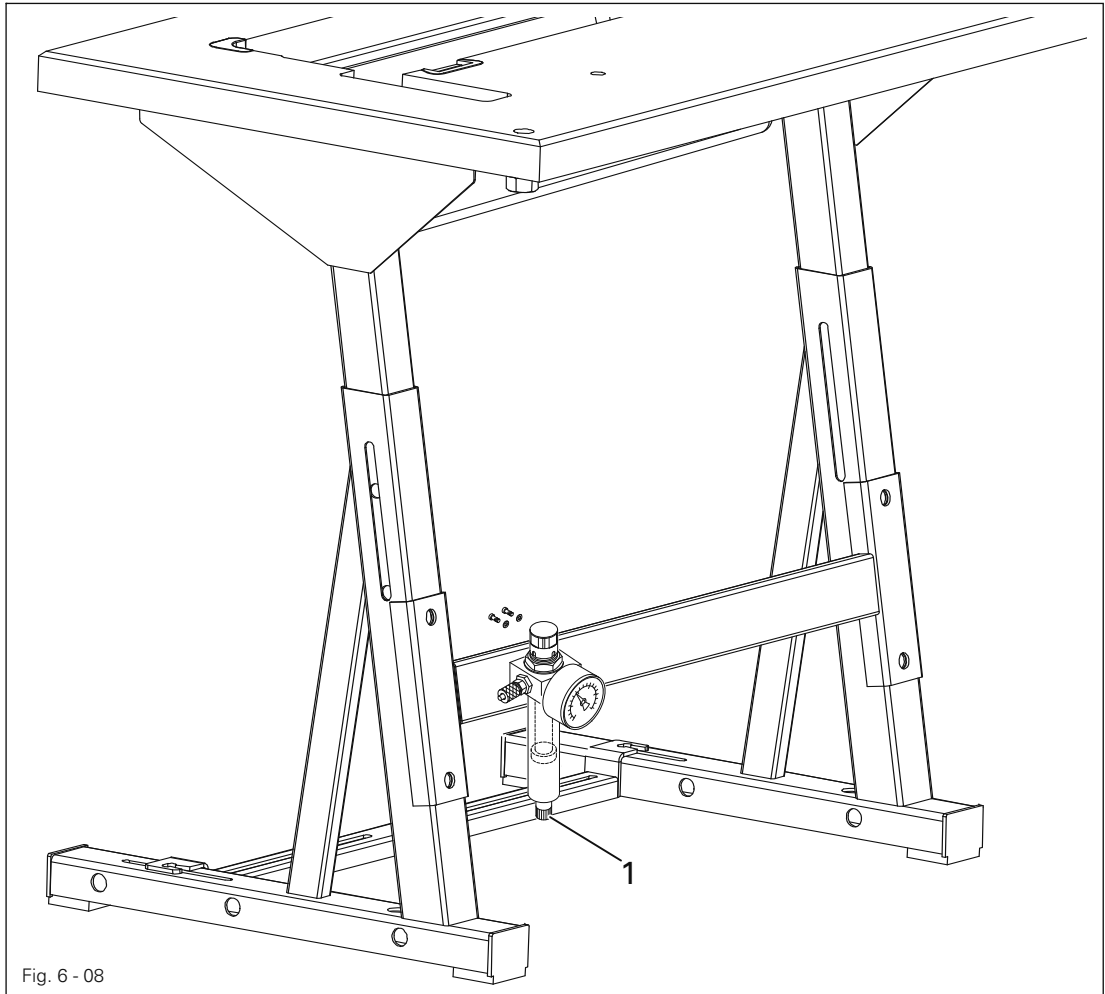


6.07.02 PFAFF 2235 and PFAFF 2545/46 with PF 321



- BDF = Control panel
- UFW = Lower threaded monitor
- SWG = Speedcontrolunit
- KS = Knee switch

## 6.08 Mounting / connecting the maintenance unit



- Attach maintenance unit 1 to the stand with two screws M6 x 25.
- Connect the maintenance unit to the machine's pneumatic tube.



To ensure the perfect functioning of all pneumatic devices, there must be a supply system pressure of between **8** and **10** bar.  
The operating pressure is **6** bar (also see Chapter 9 Care and Maintenance of the Service Manual).

## 7 Commissioning



Before commissioning the machine, it must be thoroughly cleaned and then oiled., see chapter 9 **Care and maintenance** in the instruction manual.

- Check the machine, particularly its electrical wiring and pneumatic tube connections, for any damage.
- Have skilled personnel check if the machine can be operated with the available mains voltage.



Do not operate the machine if there is any discrepancy.



The machine may only be connected to an earthed socket!

- In the case of machines with **AB + PF 321** control unit, have specialists check the basic position of the machine drive before commissioning the machine (see Chapter 7.02 **Basic position of the machine drive**).

### 7.01 Switching the machine on/off

- Switch the machine on (see Chapter 7.01, **On/off switch** in the instruction manual).

## 7.02 Machine drive home position

### 7.02.01 With model PFAFF 2235 and drive AB 321

- Press button "P" on the control panel, while simultaneously switching the machine on.
- Enter code **3112** via the numbered keys and confirm by pressing "E".
- Enter parameter **290** via the numbered keys and confirm by pressing "E".
- Select mode **42** by pressing the +/- buttons.
- Press "P" twice to quit the input level.
- The new values are taken over when sewing is started, and these are maintained even after the machine is switched off.

### 7.02.02 With models PFAFF 2235, 2545 / 46 and drive PF 321

- Press button "P" on the control panel, while simultaneously switching the machine on.
- Enter code **3112** via the numbered keys and confirm by pressing "E".
- Enter parameter **290** via the numbered keys and confirm by pressing "E".
- Press the +/- buttons for mode **00** for model **2235**, and mode **01** for models **2545 / 46**.
- Press "P" twice to quit the input level.
- The new values are taken over when sewing is started, and these are maintained even after the machine is switched off.







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