PFAFF® Industrial

Excellence in seaming

3686
Automatic short seamer
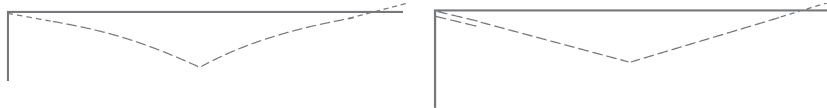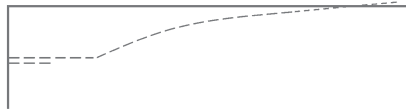## for darts and waistband pleats
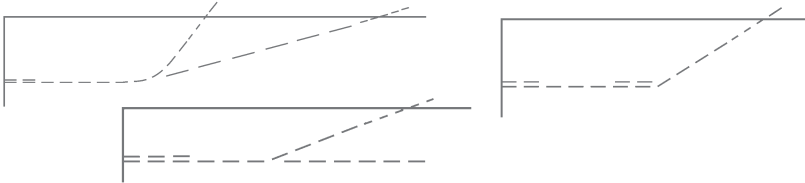
PFAFF 3686

Darts and waistband pleats play an important role both for the fit and for the overall visual appearance of trousers, skirts and blouses. The main demand on the manufacturer is to guarantee consistent quality and economic processing on a machine that is easy to operate. The PFAFF 3686 short seam automatic sewing machine meets this requirement. The PFAFF 3686 for darts and waistband pleats is the most versatile and efficient short seam automati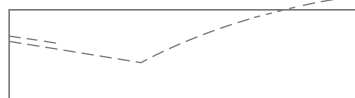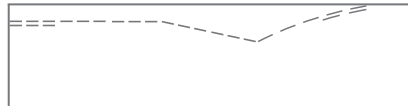c sewing machine on the market. Efficiency, flexibility, performance and price are the deciding advantages of the PFAFF 3686. Within 8 hours you can sew for example 650 pairs of trousers with 4 darts and 4 waistband pleats (without basted seam). The versions 3686-25/11 + 3686-25/12 realize double-pointed darts up to 490 mm inside of the fabric (not on the edge), e.g. darts on the front of a shirt or darts on the back of a blouse.

Wide range of application:

Highest flexibility - A wide range of seam designs are available

Darts and waistbands (styles)	Machine subclass				
	-22/12	-23/11	-23/12	-25/11	-25/12
1: Single-pointed darts	x	x	x	x	x
2: Double-pointed darts			x	x	x
3: Shaped darts for skirts with integrated waistband	x	x	x	x	x

Darts and waistbands (styles)	Machine subclass				
	-22/12	-23/11	-23/12	-25/11	-25/12
4: Skirt pleats with and without angular seam (illustration: without)	x	x	x	x	x
5: Waist pleats with basted seam to better iron out the pleats	x	x	x	x	x
6: Short seam to run stitch the seam that is to be worked into the waistband*	x	x	x	x	x
7: Waistband pleats	x	x	x	x	x
8: Shaped darts for ladies' trousers	x	x	x	x	x
9: Double-pointed darts with a straight			x	x	x

* Thus no loss of time when sewing the waistband with a consistently exact pleat depth

PFAFF 3686 for TROUSERS with up to 290 mm seam length

Features:

- Excellent quality; high repeating accuracy; seams and pleats with exact measurements. Only brief instructions required due to the simple and operator-friendly handling
- Darts are sewn from the pocket opening to the point. This ensures a slim, neat point with no untidy "dimples"
- The patented material take-over station assures exact seams
- Loading table for exact positioning of the workpieces and their insertion during sewing. This partially overlapping work method enables the economic use of the machine (from -23/xx: positioning via laser pointer)
- Conversion independent of guide rails / pre-programmed seam contours enable a change of operations in a matter of seconds
- Start backtacks, condensed stitches at end of the seam
- Identical dart depths for identical material thickness; even when switching the material and thus varying material thicknesses the desired dart depth may be exactly maintained by using a "correction key"
- Clamping unit for trousers or skirts darts and other small parts (option)
- Upper thread monitor (standard)
- Special application for -22/12: Sewing of pleats on strip curtains

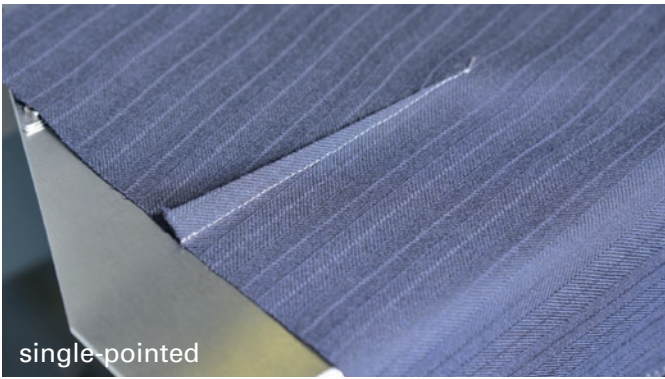| Versions	Application	max. dart depth	max. waistband pleat depth
3686-22/12	Single-pointed darts up to **250 mm** seam length	30 mm 37 mm*	70 mm
3686-23/11	Single- and double-pointed darts up to **290 mm** seam length without vacuum table	20 mm 37 mm*	70 mm

* > approx. 80 mm darts length

Larger feed table for double-pointed darts
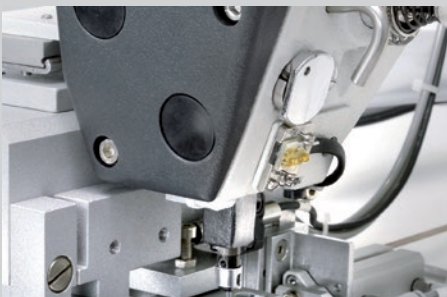(Option on -23/11, -23/12)

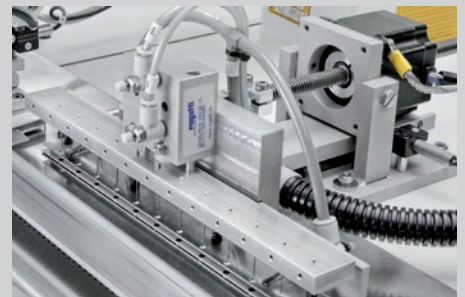Bundle clamp
(Option on -22/12, -23/11, 23/12)

single-pointed
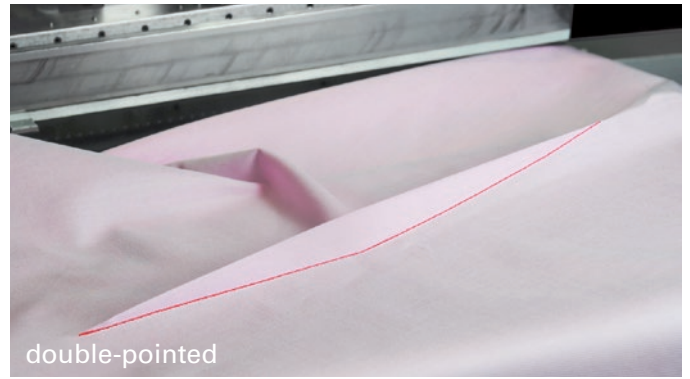
double-pointed

Upper thread monitor (standard on all machines)
Thread clamp (standard: -25/xx, option: -23/12)

Patented material take-over station

PFAFF 3686 for SHIRTS with up to 490 mm seam length

Features:

- All features of the "standard" machine
- Unique quality and process stability when processing long darts, e.g. on slimline shirts
- Start backtacks, condensed stitches or bartacks at end of the seam
- Large feeding table (823 x 340 mm)
- Device for a „neat seam start" + suction device for thread rests (option)
- Clean-cut at end of the seam (< 5mm) –> only on -25/11
- LED pointer for positioning of the material
- Roll tension for pucker-free seams (standard: -25/xx, option: -23/12)
- Upper thread monitor
- Thread clamp (standard: -25/xx, option: -23/12)
- Special stacker (option for -25/xx)
- Feeding table with vacuum (option)
- Clamp device for the bust darts, fixed on the feeding table (option)
- Material stop on feeding table for the positioning of the fabric (option for -25/11)
- Foot pedal + transport rolls (option for -25/11)

| Version	Application	max. dart depth	max. waistband pleat depth
3686-23/12	Double-pointed darts on shirts and blouses up to **290 mm** seam length with special vacuum table	20 mm	22 mm
3686-25/11	Double-pointed darts up to **490 mm** seam length <u>with</u> thread trimmer for short thread ends (< 5mm)	20 mm	20 mm
3686-25/12	Double-pointed darts up to **490 mm** seam length <u>without</u> thread trimmer for short thread ends (< 5mm)	20 mm	20 mm

LED pointer

Special stacker (Option for -25/xx)

for darts / 490 mm

Suction device (Option)

Clean-cut at end of the seam (< 5mm)

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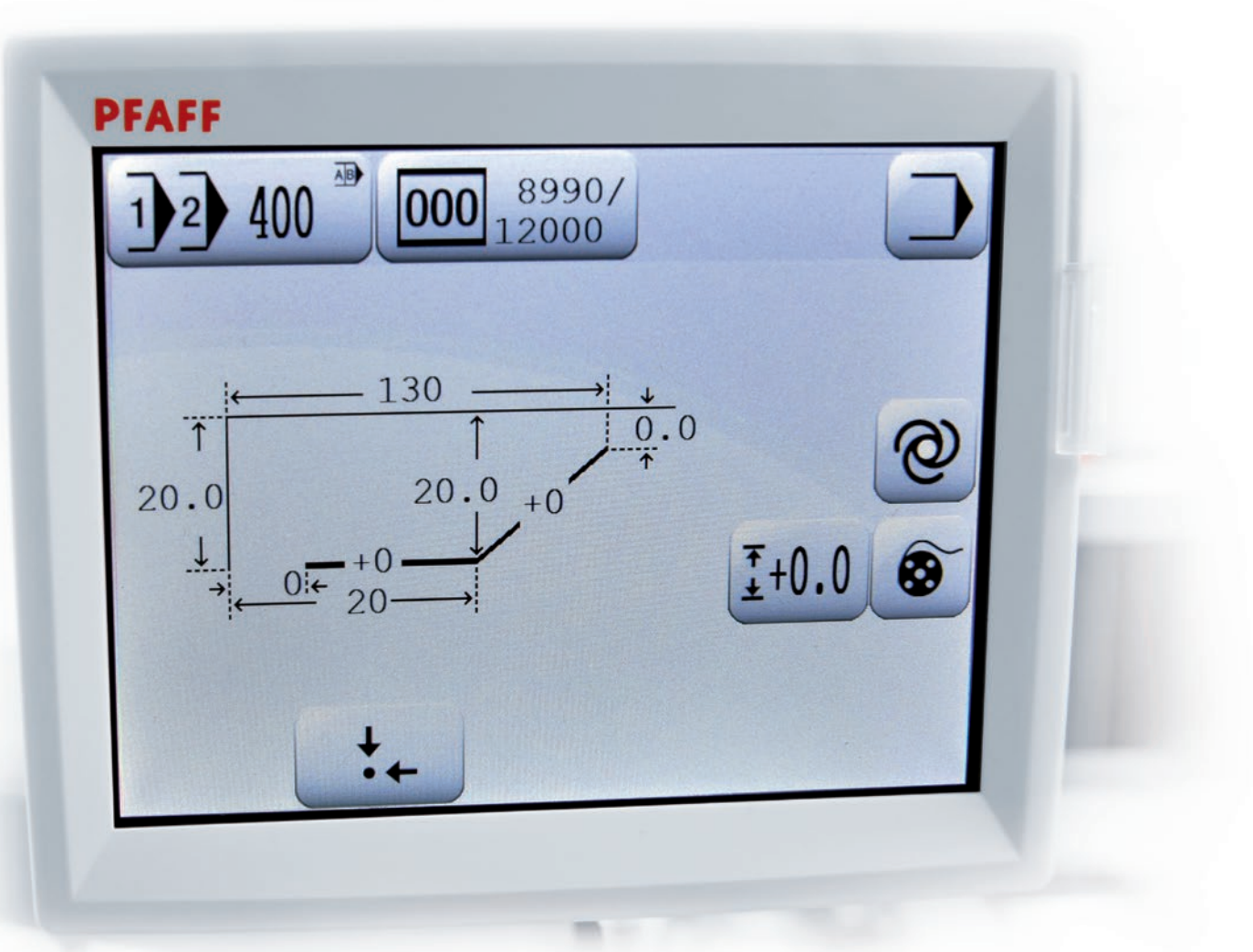
The control panel **P1:**

- The P1 are user friendly control panels with many service functions and different user levels

- The desired measurements may be directly entered via the P1 operator panel of the touch screen (see examples on the next pages). Pre-defined standard seams are quickly edited / modified with ease.

- Sewing of up to 8 different seam types in any desired sequence, so e.g. different darts and waistband pleats can be set and produced mirror-imaged

- Program data may be saved to a SD-card, USB-stick or multi-card reader and recorded to other machines. The software may also be updated via the SD-card, USB-stick or multi-card reader

- Customized seam configurations may be individually created in the teach-in mode

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Programming examples:
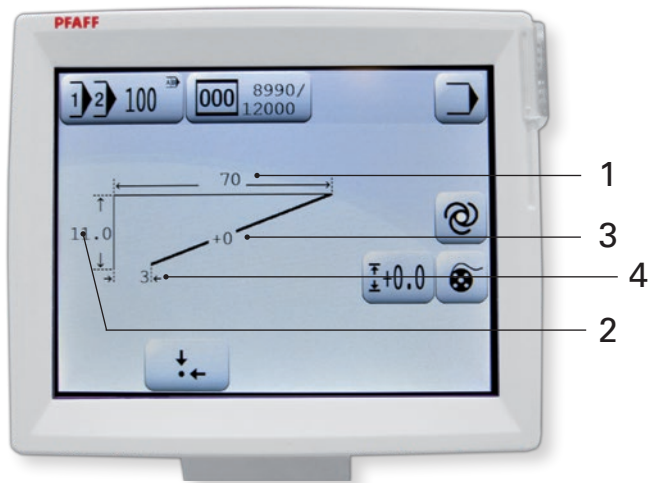
Single-pointed dart

Dart length
The dart length may be adjusted via function 1.

Dart depth
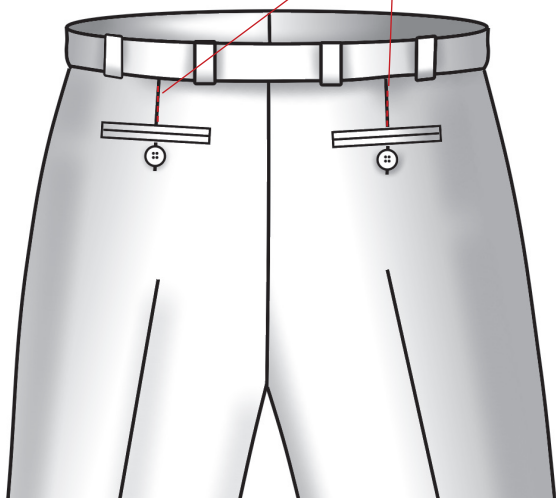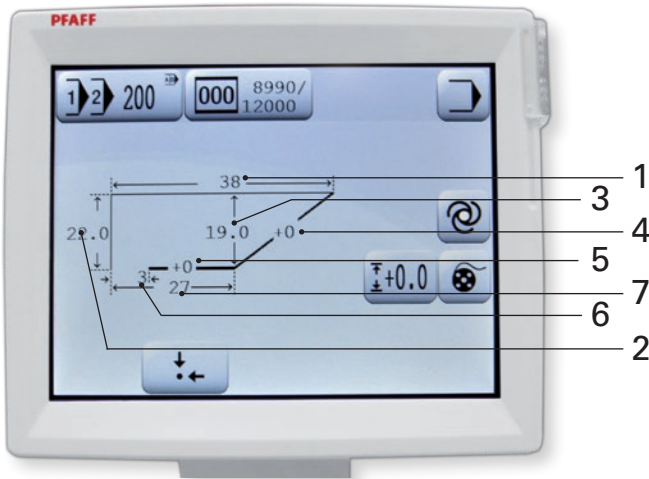The value for the dart depth may be adjusted via function 2.

Curve
The value for the curve may be adjusted via function 3.

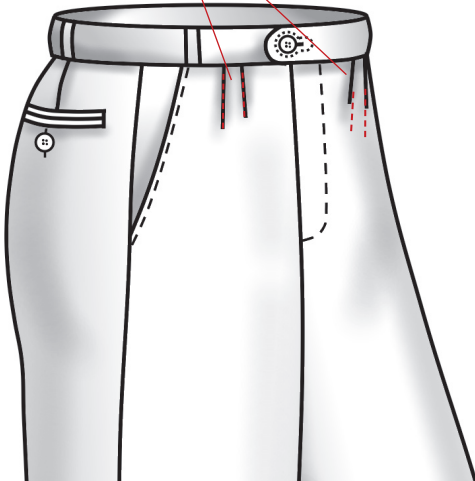**Shifting of the starting point**
The value to shift the starting point may be adjusted via function 4.

e. g. darts on men's trousers

e. g. waistband pleats on men's trousers

Waistband pleat

Waistband length
The value for the waistband length may be adjusted via function 1.

Waistband depth
The value for the waistband depth may be adjusted via function 2.

Waist depth
The value for the waist depth may be adjusted via function 3.

Curve
The values for the curve may be adjusted via functions 4 and 5.

Shifting of the starting point
The value to shift the starting point may be adjusted via function 6.

Waist length
The value for the waist length may be adjusted via function 7.

Specifications:

Stitch type:
301

Max. sewing speed:
4,500 s.p.m.

Max stitch length:
1.0 - 3.0 mm

Needle system:
134 KK

Needle size in $^1/_{100}$ mm:
70 - 100

Stitch length basting seam:
6.0 - 9.0 mm

Working height:
760 - 1,140 mm (-22/12 and -23/xx)
990 - 1,200 mm (-25/11)

Motor speed:
200 - 4,500 r.p.m.

Power requirement:
0,25 kw
1,0 kw (-25/xx with vacuum)

Connection voltage:
E 230 V, 50/60 Hz

Working air pressure:
min. 6 bar

Machine dimensions:

Length:

3686-22/12	1,250 mm
3686-23/..	1,285 mm
3686-25/..	1,835 mm

Width:

3686-22/12, -23/..	900 mm
3686-25/..	1,240 mm

Height (without thread reel stand):

3686-22/12, -23/..	1,040 - 1,420 mm
3686-25/..	1,210 - 1,480 mm

Weight:

3686-22/12, -23/..	190 kg
3686-25/..	260 kg

BLUECOMPETENCE
Alliance Member
Partner of the Engineering Industry
Sustainability Initiative

Made in Germany by PFAFF