

**PFAFF**<sup>®</sup> Industrial

# P40CD

Parameterlist

4509

This Parameter list applies to machines from the following software version 79-0011 **0435/006** onwards.

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## Table of Contents

1	Parameter .....	5
1.1	Operator level .....	5
	Bobbin stitch counter/ remaining thread monitor/piece counter .....	5
	Needle cooling/fan .....	6
	Light barrier .....	6
1.2	Technician level .....	7
	Thread clamp (TC).....	10
	Thread cutter (FA).....	12
	Sewing foot lift (FL) .....	13
	Soft start .....	14
	Remaining thread monitor/bobbin rotation monitor/skip stitch detector.....	14
	Needle thread monitor up .....	14
	Needle thread monitor down .....	14
	Seam paths.....	15
	Motor.....	15
	Thread tension .....	17
	Stroke adjustment .....	19
	Function module .....	20
	Reversal.....	23
	Needle cooling/fan .....	23
	Carrier roller/puller/seam middle guide .....	24
	Edge cutter .....	25
	Light barrier.....	26
	Electronic handwheel.....	26
	Stacker.....	27
	Zigzag .....	27
	Thread wiper .....	27
	Step cutting/contour guide .....	27
	Outfeed roller .....	27
	Hook lubrication .....	28
	Stitch loosening device .....	28
	Differential transport.....	28
	Stitch length switching .....	28
	Stitch shortening .....	29
	Operation lock.....	29
	Control, other .....	29
	OP1000.....	35

1.3	Developer level .....	37
	Thread cutter (FA).....	37
	Seam paths.....	37
	Motor.....	37
	Thread tension.....	38
	Top puller.....	38
	Bottom puller.....	39
	Control, other .....	40
2	Error, warning and information messages .....	41

# 1 Parameter

The parameter list helps the user quickly locate and change a parameter. The structure of the parameter list has already been explained in the instructions for use. Some parameters have been grouped into categories which can be found on several levels and reflect their importance and their resulting minor or major effect on the sewing behavior of the machine.

## 1.1 Operator level

	C	P	Min	Max	Preset value	Unit	Description
<b>Bobbin stitch counter/ remaining thread monitor/piece counter</b>							
o	06	00	0	4	0	-	Bobbin stitch counter / remaining thread monitor 0 = Off; 1 = Bobbin stitch counter A; 2 = Bobbin stitch counter B; 3 = Bobbin stitch counter C; 4 = Remaining thread monitor
o	06	01	1	9999	3000	x o0604	Reset value of bobbin stitch counter A
o	06	02	1	9999	2000	x o0604	Reset value of bobbin stitch counter B
o	06	03	1	9999	1000	x o0604	Reset value of bobbin stitch counter C
o	06	04	1	255	10	x stitches	Factor of bobbin stitch counters A, B and C
o	06	05	0	9999	0	Stitches	Number of stitches for the remaining thread monitor
o	06	06	0	1	0	-	Stop sewing motor when the counter reaches 0 0 = Off; 1 = On
o	06	07	0	1	0	-	Sewing foot stays down after thread cutting 0 = Off; 1 = On
o	06	08	0	1	0	-	When a counter has elapsed, a reset must occur after thread cutting 0 = Off; 1 = On
o	06	10	0	1	0	-	Display of the piece counter 0 = Off; 1 = On
o	06	20	0	1	0	-	Needle thread monitor up 0 = Off; 1 = On

	C	P	Min	Max	Preset value	Unit	Description
o	06	30	0	1	0	-	Needle thread monitor down 0 = Off; 1 = On
<b>Needle cooling/fan</b>							
o	13	00	0	1	1	-	Needle cooling 0 = Off; 1 = On
<b>Light barrier</b>							
o	16	00	0	255	0	Stitches	Equalizing stitches for normal stitch length
o	16	01	0	255	0	Stitches	Equalizing stitches for long stitch length
o	16	10	1	255	1	Seams	Number of light barrier seams
o	16	20	0	255	0	Stitches	Equalizing stitches for knitted garment filter

## 1.2 Technician level

	C	P	Min	Max	Preset value	Unit	Description
<b>Bartack</b>							
t	00	00	300	6000	1800	rpm	Start bartack speed
t	00	01	0	254	28	10°	Feed-forward angle when the bartack magnet is switched on (Switching from forward to backward during bartacking)
t	00	02	0	254	28	10°	Forward-feed angle when the bartack magnet is switched off (Switching from backward to forward during bartacking)
t	00	03	0	1	0	-	Start bartack can be interrupted by setting pedal to 0 position 0 = Off; 1 = On
t	00	04	0	2	0	-	Mode for end of start bartack 0 = Sewing continues after end; 1 = Machine stops and must be restarted using the pedal; 2 = Thread cutting after start bartack
t	00	05	0	1	0	-	Pedal release only after additional A path 0 = Off; 1 = On
t	00	06	0	500	0	ms	Delay time to speed release after start bartack
t	00	07	0	255	0	ms	Fall time of bartack magnet
t	00	09	0	1	0	-	Additional forward path at start bartack with the number of backward stitches 0 = Off; 1 = On
t	00	10	300	6000	1800	rpm	End bartack speed
t	00	11	0	254	28	10°	Feed-forward angle when the bartack magnet is switched on (Switching from forward to backward during bartacking)
t	00	12	0	254	34	10°	Forward-feed angle when the bartack magnet is switched off (Switching from backward to forward during bartacking)

	C	P	Min	Max	Preset value	Unit	Description
t	00	13	0	1	0	-	Bartack magnet stays switched on during the last backward path (simple end bartack and multiple end bartack) until position 2 has been reached 0 = Off; 1 = On
t	00	19	0	1	0	-	Additional forward path at end bartack with the number of backward stitches 0 = Off; 1 = On
t	00	20	300	6000	2800	rpm	Multiple start bartack speed (only during darning program)
t	00	21	0	254	33	10°	Feed-forward angle when the bartack magnet is switched on (Switching from forward to backward during bartacking) (only during darning program)
t	00	22	0	254	40	10°	Forward-feed angle when the bartack magnet is switched off (Switching from backward to forward during bartacking) (only for darning program)
t	00	23	0	1	0	-	Multiple start bartack as darning program 0 = Off; 1 = On
t	00	24	0	1	0	-	Pedal-dependent speed for darning program 0 = Off; 1 = On
t	00	25	0	1	0	-	First path with different number of stitches (C) in multiple start bartack 0 = Off; 1 = On
t	00	26	0	1	0	-	Last path with different number of stitches (B) in multiple end bartack 0 = Off; 1 = On
t	00	30	0	1	0	-	Ornamental-stitch bartack 0 = Off; 1 = On
t	00	31	0	2500	1200	rpm	Speed of ornamental-stitch bartack
t	00	32	0	1000	100	ms	Ending time during ornamental-stitch bartack



Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	00	35	0	1	0	-	Speed decrease when feed dog is repositioned 0 = Off; 1 = On
t	00	36	0	6000	2000	rpm	Level to which the speed is supposed to be reduced when the feed dog is repositioned
t	00	40	0	2	1	-	Type of start bartack when the bartack activation switch is engaged 0 = Simple start bartack; 1 = Double start bartack; 2 = Multiple start bartack
t	00	41	0	2	1	-	Type of end bartack when the bartack activation switch is engaged 0 = Simple end bartack; 1 = Double end bartack; 2 = Multiple end bartack
t	00	44	0	3	0	-	Handling of manual bartack 0 = Manual bartack engages immediately; 1 = Manual bartack engages depending on parameters t 00 45 and t 00 46; 2 = During manual bartacking, the drive stops in the position set under parameters t 00 45 and t 00 46; 3 = During manual bartacking, the drive stops in the position set under parameters t 00 45 and t 00 46 (only if parameter t 00 30 = 1)
t	00	45	0	1	0	-	Switch on the manual bartack 0 = Needle down; 1 = Needle up
t	00	46	0	1	0	-	Switch off the manual bartack 0 = Needle down; 1 = Needle up
t	00	47	0	3	0	-	Speed limit for manual bartack 0 = Off; 1 = Limit to DB3000 if t 00 44 = 0 – 1 2 = Limit to ornamental-stitch bartack speed if t 00 44 = 2 – 3

	C	P	Min	Max	Preset value	Unit	Description
t	00	50	0	999	100	ms	Activation time of bartack magnet in period t1
t	00	51	5	100	100	%	Duty cycle in period t1
t	00	52	0,0	600,0	0,0	s	Activation time of bartack magnet in period t2 (if 0, the bartack magnet remains continuously switched on)
t	00	53	5	100	100	%	Duty cycle in period t2
t	00	54	0	1	1	-	Increase in $U_{mag}$ when the bartack magnet is activated 0 = No; 1 = Yes
t	00	60	0	359	66	°	Angle at which the feed dog repositioner is to supposed switch
t	00	61	0	200	14	ms	Switch on inertia
t	00	62	0	200	16	ms	Switch off inertia
t	00	63	0	1	0	-	Switch feed dog repositioner depending on angle 0 = No; 1 = Yes
t	00	70	0	255	0	Stitches	Catch Backtack forward
t	00	71	0	255	0	Stitches	Catch Backtack backward
<b>Thread clamp (TC)</b>							
t	01	00	0	10	0	-	Mode of thread clamp 0 = TC switch-on angle = t 01 01, TC switch-off angle = t 01 02, Without FL; 1 = TC switch-on angle = 108°, TC switch-off angle = 268°, Without FL; 2 = TC switch-on angle = 49°, TC switch-off angle = 110°, Without FL; 3 = TC switch-on angle = 49°, TC switch-off angle = 190°, Without FL; 4 = TC switch-on angle = 108°, TC switch-off angle = 268°, FL switch-on angle = 108°, FL switch-off angle = 154°; 5 = TC switch-on angle = 108°, TC switch-off angle = 268°, FL switch-on angle = 44°, FL switch-off angle = 154°;

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
							<p>6 = TC switch-on angle = 75°, TC switch-off angle = 215°, FL switch-on angle = 60°, FL switch-off angle = 120°, FL switch-off angle, additionally stroke-dependent;</p> <p>7 = Without TC, FL switch-on angle = t 01 11, FL switch-off angle = t 01 12,</p> <p>8 = TC switch-on angle = t 01 01, TC switch-off angle = t 01 02, FL switch-on angle = t 01 11, FL switch-off angle FL = t 01 12;</p> <p>9 = Without TC, FL switch-on angle = t 01 11, FL switch-off angle = t 01 12, FL switch-off angle, additionally stroke-dependent;</p> <p>10 = TC switch-on angle = t 01 01, TC switch-off angle = t 01 02, FL switch-on angle = t 01 11, FL switch-off angle = t 01 12, FL switch-off angle, additionally stroke-dependent;</p>
t	01	01	0	359	75	°	Switch-on angle of thread clamp
t	01	02	0	359	215	°	Switch-off angle of thread clamp
t	01	11	0	359	53	°	Switch-on angle of sewing foot lift
t	01	12	0	359	110	°	Switch-off angle of sewing foot lift
t	01	13	0	100	35	%	Duty cycle of sewing foot lift in mode 4-8

	C	P	Min	Max	Preset value	Unit	Description
t	01	20	0	3	0	-	Thread clamp options 0 = Thread clamp only at seam beginning; 1 = Thread clamp at seam beginning and during reverse; 2 = Thread clamp at seam beginning and during sewing foot lift; 3 = Thread clamp at seam beginning and during reverse and sewing foot lift
t	01	30	0	1	0	-	Neat seam beginning (NSB) 0 = Off; 1 = On when thread clamp is active
t	01	31	0	359	92	°	Switch-on angle of additional thread clamp
t	01	32	0	359	201	°	Switch-off angle of additional thread clamp
t	01	33	0	359	105	°	Switch-on angle of thread advancing device
t	01	34	0	359	203	°	Switch-off angle of thread advancing device
t	01	35	0	359	62	°	Switch-on angle of thread tension lift
t	01	36	0	359	94	°	Switch-off angle of thread tension lift
t	01	50	0	999	100	ms	Activation time of thread clamp in period t1
t	01	51	5	100	100	%	Duty cycle in period t1
t	01	51				%	Duty cycle in period t1
t	01	52	0,1	120,0	30,0	s	Activation time of thread clamp in period t2 (if 0, the thread clamp remains continuously switched on)
t	01	53	5	100	100	%	Duty cycle in period t2
t	01	54	0	1	1	-	Increase in $U_{mag}$ when the thread clamp is activated 0 = No; 1 = Yes
<b>Thread cutter (FA)</b>							
t	02	00	50	750	180	rpm	Speed when cutting the thread
t	02	01	0	1	0	-	Pedal position for initiating the cutting process 0 = Position -2; 1 = Position -1

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	02	02	0	1	0	-	Initiate seam end at seam beginning (with single stitch functions activated) 0 = No; 1 = Yes
t	02	10	0	359	191	°	Switch-on angle t 08 12 ≤ t 02 10 < t 02 11
t	02	11	0	359	276	°	Switch-off angle t 02 10 < t 02 11 ≤ t 08 13
t	02	20	0	255	0	ms	Delay time for repeated switch-on of thread cutting magnet
t	02	21	0	255	0	ms	Delay time for switch-off of thread cutting magnet
t	02	50	0	999	500	ms	Activation time of thread cutter in period t1
t	02	51	5	100	100	%	Duty cycle in period t1
t	02	52	0,1	120,0	0,5	s	Activation time of thread cutter in period t2 (if 0, the thread clamp remains continuously switched on)
t	02	53	5	100	10	%	Duty cycle in period t2
t	02	54	0	1	1	-	Increase in U <sub>mag</sub> when thread cutter is activated 0 = No; 1 = Yes
t	02	55	0	359	0	°	Angle at which duty cycle 2 is activated (0 = deactivated)
<b>Sewing foot lift (FL)</b>							
t	03	00	0	1	1	-	Sewing foot lift 0 = Off; 1 = On
t	03	10	0	255	80	ms	Startup delay of machine after sewing foot lift is switched off
t	03	11	0	255	40	ms	Activation delay of sewing foot lift during a machine standstill
t	03	12	0,0	9,999	0,150	s	Activation delay of sewing foot lift at seam end
t	03	50	0	999	100	ms	Activation time of sewing foot lift magnet in period t <sub>1</sub>
t	03	51	5	100	100	%	Duty cycle in period t <sub>1</sub>
t	03	52	0,0	600,0	0,0	s	Activation time of sewing foot lift magnet in period t <sub>2</sub> (if 0, the sewing foot lift magnet remains continuously switched on)
t	03	53	5	100	100	%	Duty cycle in period t <sub>2</sub>

	C	P	Min	Max	Preset value	Unit	Description
t	03	54	0	1	1	-	Increase in $U_{mag}$ when sewing foot lift magnet is activated 0 = No; 1 = Yes
<b>Soft start</b>							
t	05	00	120	1000	800	rpm	Soft start speed
t	05	01	1	99	2	Stitches	Number of soft start stitches
<b>Remaining thread monitor/bobbin rotation monitor/skip stitch detector</b>							
t	06	00	0	2	0	-	Activation of the remaining thread monitor 0 = Off; 1 = Right; 2 = Left & right;
t	06	01	0	1	0	-	Remaining thread monitor mode 0 = Dynamic; 1 = Static;
t	06	02	0,0	3,300	0,0	V	Threshold right
t	06	03	0,0	3,300	0,0	V	Intensity right
t	06	04	0,0	3,300	0,0	V	Threshold left
t	06	05	0,0	3,300	0,0	V	Intensity left
t	06	10	0	1	0	-	Skip stitch detector (Not if t 06 00 = 2) 0 = Off; 1 = On
t	06	11	0	1	0	-	Bobbin rotation monitor (Not if t 06 00 = 2) 0 = Off; 1 = On
t	06	12	0	255	0	Stitches	Number of stitches at which the bobbin rotation monitor is activated
<b>Needle thread monitor up</b>							
t	06	20	0	1000	180	rpm	Speed at which the monitor is activated
t	06	21	0	255	2	Stitches	Number of stitches at which the monitor is activated
t	06	22	0	1000	3	ms	Debouncing
<b>Needle thread monitor down</b>							
t	06	30	0	1000	180	rpm	Speed at which the monitor is activated
t	06	31	0	255	2	Stitches	Number of stitches at which the monitor is activated
t	06	32	0	1000	3	ms	Debouncing

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
<b>Seam paths</b>							
t	07	00	0	2	0	-	Handling of position -2 for seam paths 0 = Cancellation of the seam. The next seam path is sewn; the last seam of the program is canceled with thread cutting; 1 = Termination of the seam with thread cutting (even if not active). The next seam procedure is a free seam; 2 = Termination of the seam with thread cutting (even if not active). Seam program is canceled
t	07	01	0	1	1	-	Automatic mode 0 = Off; 1 = On
t	07	02	0	1	0	-	Signal on switch of path 0 = Off; 1 = On
t	07	03	0	1	0	-	Repair mode 0 = Off; 1 = On
<b>Motor</b>							
t	08	00	500	9999	4500	rpm	Maximum speed
t	08	01	10	400	180	rpm	Minimum speed
t	08	02	10	1000	180	rpm	Positioning speed
t	08	03	1	100	40	rpm/ms	Acceleration ramp
t	08	04	1	100	40	rpm/ms	Deceleration ramp
t	08	05	0	1	0	-	Direction of rotation of motor 0 = Left; 1 = Right
t	08	06	0	2	0	-	Motor brake during normal stop 0 = Braking for period of t 08 09; 1 = Brake continuously active when stopped; 2 = Position is continuously maintained
t	08	07	0,1	6,0	0,4	A	No-damage current when machine down
t	08	08	0	255	20	-	Response time to changes in position
t	08	09	0	999	200	ms	Duration of motor brake
t	08	10	-	-	-	-	Reference position

	C	P	Min	Max	Preset value	Unit	Description
t	08	11	-	-	-	-	Needle positions
t	08	12	0	359	67	°	Needle in the low position (bottom dead center) (position 1)
t	08	13	0	359	323	°	Thread lever at top dead center (position 2)
t	08	14	0	359	350	°	Point position
t	08	15	0	359	282	°	Threading position (needle thread)
t	08	19	1	9999	1000	-	Transmission ratio = (motor diameter / machine diameter) * 1000
t	08	20	-	-	-	-	Calibrate pedal
t	08	21	1	64	24	Levels	Number of speed levels of pedal
t	08	22	0	7	3	-	Speed curve
t	08	23	1	255	90	ms	Debouncing of position -1
t	08	24	1	255	15	ms	Debouncing of position -2
t	08	25	0	1	1	-	Selection of pedal 0 = Analog; 1 = Digital
t	08	26	0	1	0	-	Inverting signals of the digital pedal 0 = No; 1 = Yes (Efka pedal with adapter)
t	08	27	0	1	0	-	Handling of position -1 (only with digital pedal) 0 = Not stored; 1 = Stored
t	08	28	40	70	60	-	Factor of position -1 This parameter can be used to adjust the response between -1 and 0
t	08	29	20	70	49	-	Factor of position -2 This parameter can be used to adjust the response between -2 and 0
t	08	30	0	1	0	-	Display of speed 0 = Off; 1 = On
t	08	31	0	1	0	-	Display of current position 0 = Off; 1 = On
t	08	32	0	1	0	-	After power-on and a tap on the pedal, the needle is moved to the "Needle up" position 0 = No; 1 = Yes



Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	08	33	0	6	0	-	Output of position signals (signal to X1.21 and X1.26) 0 = No signals are output; 1 = Pos. 1; 2 = Pos. 2; 3 = Pos. 1 & Pos. 2; 4 = Motor operation signal; 5 = Motor operation signal & Pos. 1; 6 = Motor operation signal & Pos. 2
t	08	34	0	255	75	°	Angle for the length of the Pos. 1 signal
t	08	35	0	255	75	°	Angle for the length of the Pos. 2 signal
t	08	36	10	9999	10	rpm	Speed at which the motor operation signal is activated
t	08	40	150	9999	3000	rpm	Speed limit DB3000
t	08	41	150	9999	2000	rpm	Speed limit DB2000
t	08	44	1	255	40	ms	Debouncing of position 0
t	08	50	10	500	500	rpm	Preset speed value for single stitch functions (half or full stitch, etc.)
t	08	51	1	6000	180	rpm	Speed for manual sewing per push button
t	08	52	0	1	0	-	Sewing functions via push button also in manual mode 0 = No; 1 = Yes
t	08	60	0	64	0	Level	Shifting of position 1 Number of speed levels is reduced
<b>Thread tension</b>							
t	09	00	0	3	0	°	Mode of thread tension and thread tension reduction when sewing foot lift is active 0 = no thread tension lift; 1 = Thread tension lift in the seam; 2 = Thread tension lift after thread cutting; 3 = Thread tension lift in the seam and after thread cutting
t	09	01	0	1	1	°	Thread tension with threader (needle thread) lifted 0 = No; 1 = Yes

	C	P	Min	Max	Preset value	Unit	Description
t	09	02	0,0	2,55	0,0	s	Activation delay of thread tension lift after thread cutting when sewing foot is lifted (only active if t 09 00 = 2 or 3)
t	09	03	0	2	0	°	Coupling of additional thread tension with quick stroke adjustment 0 = no coupling; 1 = Additional thread tension during quick stroke adjustment; 2 = Additional thread tension when quick stroke adjustment speed is reached
t	09	10	0	359	211	°	Switch-on angle t 08 12 <= t 09 10 < t 09 11 during cutting process
t	09	11	0	359	323	°	Switch-off angle t 09 10 < t 09 11 <= t 08 13 during cutting process
t	09	20	0	255	0	ms	Delay time for repeated switch-on of thread tension magnet during cutting process
t	09	21	0	255	40	ms	Delay time for switch-off of thread tension magnet
t	09	30	0	1	0	-	Open additional thread tension during start bartacking 0 = No; 1 = Yes;
t	09	31	0	1	0	-	Open additional thread tension during end bartacking 0 = No; 1 = Yes;
t	09	32	0	1	0	-	Open additional thread tension during manual bartacking 0 = No; 1 = Yes;
t	09	33	0	1	0	-	Open additional thread tension for thread clamp 0 = No; 1 = Yes;
t	09	34	0	1	0	-	Open additional thread tension during soft start 0 = No; 1 = Yes;
t	09	35	0	1	0	-	Open additional thread tension during stitch shortening 0 = No; 1 = Yes;

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	09	36	0	1	0	-	Open additional thread tension during quick stroke adjustment 0 = No; 1 = Yes;
t	09	37	0	1	0	-	Open additional thread tension during single stitch functions 0 = No; 1 = Yes;
t	09	50	0	999	80	ms	Activation time of thread tension magnet in period $t_1$
t	09	51	5	100	100	%	Duty cycle in period $t_1$
t	09	52	0,0	600,0	60,0	s	Activation time of thread tension magnet in period $t_2$ . (if 0, the thread tension magnet remains continuously switched on)
t	09	53	5	100	70	%	Duty cycle in period $t_2$
t	09	54	0	1	0	-	Increase in $U_{mag}$ when the thread tension magnet is activated 0 = No; 1 = Yes
<b>Stroke adjustment</b>							
t	10	00	0	1	0	-	Stroke adjustment 0 = No; 1 = Yes
t	10	01	0	9999	1800	rpm	Stroke adjustment speed
t	10	02	1	21	10	Level	Lower threshold
t	10	03	1	21	19	Level	Upper threshold
t	10	04	-	-	-	-	Display of current level and corresponding speed, e. g. 3: 2800 3: = current level 2800 = corresponding speed
t	10	06	0	1	0	-	Speed limit during quick stroke adjustment 0 = Limitation of speed to stroke adjustment speed for 500 ms; 1 = Continuous limitation of speed to stroke adjustment speed
t	10	07	0,0	2,55	0,0	s	Stopping time of stroke adjustment speed
t	10	08	0	255	0	Stitches	Number of stitches for automatic switch-off of quick stroke adjustment (when 0, quick stroke adjustment is deactivated)

	C	P	Min	Max	Preset value	Unit	Description
t	10	09	0	1	0	-	Type of quick stroke adjustment potentiometer 0 = 9880 867105; 1 = 9880 867119
t	10	10	0	9999	0	rpm	Automatic of activation/deactivation of quick stroke adjustment Quick stroke adjustment activated ⇔ n < t 10 11 Quick stroke adjustment deactivated ⇔ n >= t 10 11 Stored stroke adjustment is deactivated
<b>Function module</b>							
t	11	00	0	16	0	-	Function of function module 1 (X1.30) 0 = No function; 1 = Additional thread tension; 2 = Stitch length switching; 3 = Single stitch with stitch length switching; 4 = Single backward stitch with stitch length switching; 5 = Raise/lower carrier roller/seam middle guide/puller; 6 = Raise/lower edge stop; 7 = Raise/lower edge cutter; 8 = Stitch length switching (Triflex) with DB2000 speed limit and bartack suppression; 9 = Fullness with DB3000 speed limit; 10 = Fullness without DB3000 speed limit; 11 = Step cutting; 12 = Contour guide; 13 = Stacker; 14 = Output function
t	11	01	0	1	0	-	Invert output of function module 1 (X1.30) 0 = No; 1 = Yes
t	11	02	1	3	1	-	Condition of function module 1 (X1.30) after thread cutting 1 = Unchanged; 2 = Deactivated; 3 = Activated

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	11	03	1	3	1	-	Condition of function module 1 (X1.30) after power on 1 = Unchanged; 2 = Deactivated; 3 = Activated
t	11	04	0	1	0	-	Function module stored (only if t 11 00 = 14) 0 = Stored; 1 = Not Stored
t	11	05	0	2	0	-	Type of activation delay of function module 1 (X1.30) (only if t 11 00 = 14) 0 = Time 1 = Stitches 2 = Bracket
t	11	06	0	9999	0	s or stitches or °	Activation delay
t	11	07	0	2	0	-	Type of switch-off delay of function module 1 (X1.30) 0 = Time 1 = Stitches 2 = Bracket
t	11	08	0	9999	0	s or stitches or °	Switch-off delay
t	11	30	0	16	0	-	Function of function module 2 (X1.20) For function see t 11 00
t	11	31	0	1	0	-	Invert output of function module 2 (X1.20) 0 = No; 1 = Yes
t	11	32	1	3	1	-	Condition of function module 2 (X1.20) after thread cutting 1 = Unchanged; 2 = Deactivated; 3 = Activated
t	11	33	1	3	1	-	Condition of function module 2 (X1.20) after power on 1 = Unchanged; 2 = Deactivated; 3 = Activated
t	11	34	0	1	0	-	Function module stored (only if t 11 30 = 14) 0 = Stored; 1 = Not Stored

	C	P	Min	Max	Preset value	Unit	Description
t	11	35	0	2	0	-	Type of activation delay of function module 1 (X1.20) (only if t 11 30 = 14) 0 = Time 1 = Stitches 2 = Bracket
t	11	36	0	9999	0	s or stitches or °	Activation delay
t	11	37	0	2	0	-	Type of switch-off delay of function module 1 (X1.20) 0 = Time 1 = Stitches 2 = Bracket
t	11	38	0	9999	0	s or stitches or °	Switch-off delay
t	11	60	0	16	0	-	Function of function module 3 (X1.15) For function see t 11 00
t	11	61	0	1	0	-	Invert output of function module 3 (X1.15) 0 = No; 1 = Yes
t	11	62	1	3	1	-	Condition of function module 3 (X1.15) after thread cutting 1 = Unchanged; 2 = Deactivated; 3 = Activated
t	11	63	1	3	1	-	Condition of function module 3 (X1.15) after power on 1 = Unchanged; 2 = Deactivated; 3 = Activated
t	11	64	0	1	0	-	Function module stored (only if t 11 60 = 14) 0 = Stored; 1 = Not Stored
t	11	65	0	2	0	-	Type of activation delay of function module 1 (X1.15) (only if t 11 60 = 14) 0 = Time 1 = Stitches
t	11	66	0	9999	0	s or stitches or °	Activation delay

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	11	67	0	2	0	-	Type of switch-off delay of function module 1 (X1.15) 0 = Time 1 = Stitches 2 = Bracket
t	11	68	0	9999	0	s or stitches or °	Switch-off delay
t	11	90	0	999	100	ms	Activation time of output FF3 in period $t_1$
t	11	91	5	100	100	%	Duty cycle in period $t_1$
t	11	92	0,0	600,0	0,0	s	Activation time of output FF3 in period $t_2$ (if 0, output FF3 remains continuously switched on)
t	11	93	5	100	35	%	Duty cycle in period $t_2$
t	11	94	0	1	0	-	Increase in $U_{mag}$ when output FF3 is activated 0 = No; 1 = Yes
<b>Reversal</b>							
t	12	00	0	1	0	-	Reversal 0 = No; 1 = Yes
t	12	01	10	180	10	°	Reversal angle
t	12	02	10	255	20	ms	Waiting time until reversal
t	12	03	0	1	0	-	Reverse before seam beginning 0 = No; 1 = Yes
t	12	04	10	180	10	°	Reversal angle at seam beginning
<b>Needle cooling/fan</b>							
t	13	00	0	1	0	-	Needle cooling mode 0 = Normal needle cooling; 1 = Speed-dependent needle cooling
t	13	01	0,0	9,999	0,100	s	Switch-off delay of needle cooling
t	13	02	100	9999	1000	rpm	Speed for switching on needle cooling
t	13	03	0	1	0	-	Needle cooling during sewing foot lift 0 = No; 1 = Yes

	C	P	Min	Max	Preset value	Unit	Description
<b>Carrier roller/puller/seam middle guide</b>							
t	14	00	0	3	0	-	Mode for automatic raising of the carrier roller 0 = Do not raise; 1 = With sewing foot lift; 2 = During bartacking; 3 = During bartacking and when sewing foot is lifted
t	14	01	0	1	0	-	Raise carrier roller when stroke adjustment switched on 0 = No; 1 = Yes
t	14	02	0	1	0	-	Stitch count delay after sewing foot lift (t 14 03) 0 = No; 1 = Yes
t	14	03	0	255	0	Stitches	Number of stitches until carrier roller is lowered
t	14	10	0	2	0	-	Number of active pullers (Output X1.26 is configured for pressure switch-off) 0 = No puller; 1 = Puller from above; 2 = Puller from above and below
t	14	11	0	1	0	-	Puller feeding type 0 = Continual; 1 = Intermittent
t	14	12	0	359	30	°	Start feed angle
t	14	13	0	359	150	°	End feed angle
t	14	14	0	2	0	-	Puller without pressure (output X1.26 is used for this) 0 = With pressure; 1 = During quick stroke adjustment without pressure; 2 = Continuously without pressure
t	14	15	0	1	0	-	Puller is powered off when sewing stops 0 = No; 1 = Yes
t	14	16	0	1	0	-	Puller active even if no carrier roller is active 0 = No; 1 = Yes
t	14	17	10	150	90	mm	Maximum feed length
t	14	20	0,1	65,00	1,00	-	Transmission ratio, top puller
t	14	21	1	200	50	-	Material correction, top puller, when feed length is 5 mm



Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	14	22	0,1	5,00	3,50	A	Set current, top puller
t	14	23	0,1	3,00	1,00	A	No-damage current, top puller
t	14	24	1	9999	50	mm	Diameter of top carrier roller
t	14	25	0	1	0	-	Direction of rotation 0 = Right; 1 = Left
t	14	26	-10,0	10,0	1,0	mm	Feed length during short stitch, top puller
t	14	30	0,1	65,00	1,00	-	Transmission ratio of bottom puller
t	14	31	1	200	50	-	Material correction, bottom puller, when feed length is 5 mm
t	14	32	0,1	5,00	3,50	A	Set current, bottom puller
t	14	33	0,1	3,00	1,00	A	No-damage current, bottom puller
t	14	34	1	9999	49	mm	Diameter of bottom carrier roller
t	14	35	0	1	0	-	Direction of rotation 0 = Right; 1 = Left
t	14	36	-10,0	10,0	1,0	mm	Feed length during short stitch, bottom puller
<b>Edge cutter</b>							
t	15	00	0	7	0	-	Mode for automatic raising of the edge cutter 0 = Do not raise; 1 = With sewing foot lift; 2 = After cutting or after stitch counting (t 15 04); 3 = After cutting or after stitch counting and when sewing foot is lifted; 4 = During bartacking; 5 = During bartacking and when sewing foot is lifted; 6 = After cutting or after stitch counting and during bartacking; 7 = After cutting or after stitch counting, during bartacking and when sewing foot is lifted
t	15	03	0	255	0	Stitches	Number of stitches until edge cutter is lowered
t	15	04	0	255	0	Stitches	Number of stitches until edge cutter is lifted (t 15 00 = 2 or 3)

	C	P	Min	Max	Preset value	Unit	Description
t	15	05	0	1	0	-	Deactivate edge cutter when sewing foot is lifted 0 = No; 1 = Yes
t	15	10	0	1	0	-	Electric edge cutter 0 = No; 1 = Yes
t	15	11	0	1	0	-	Electric edge cutter when sewing stops 0 = No; 1 = Yes
t	15	12	0	100	50	%	Minimum PWM for edge cutter
t	15	13	0	100	95	%	Maximum PWM for edge cutter
t	15	14	0	9999	1500	rpm	Maximum speed at which maximum PWM is to be reached
t	15	15	0,0	2,55	0,0	s	Delay for switching off the edge cutter motor
<b>Light barrier</b>							
t	16	00	50	9999	1000	rpm	Speed for light barrier equalizing stitches
t	16	01	1	3	3	-	Light barrier mode 1 = Seam beginning detection; 2 = Seam end detection; 3 = Seam beginning & seam end detection
t	16	02	0	1	0	-	Mode for seam beginning 0 = Release via light barrier; 1 = Start via front pedal and light barrier
t	16	03	0	1	0	-	Knitted garment filter 0 = Off; 1 = On
t	16	04	0	1	1	-	Light barrier detection 0 = Bright; 1 = Dark
t	16	05	0	1	0	-	Light barrier automatic mode (only if t 16 01 = 2 or 3) 0 = Off; 1 = On
<b>Electronic handwheel</b>							
t	17	00	0	1	0	-	Electronic handwheel 0 = No; 1 = Yes (t 51 32 and t 51 33 = 0)
t	17	01	1	255	6	-	Step width for electronic handwheel

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	17	02	0	1	0	-	Direction of rotation of electronic handwheel 0 = Right; 1 = Left
<b>Stacker</b>							
t	18	00	0	1	0	-	Stacker 0 = Off; 1 = On
t	18	01	0,0	2,55	0,10	s	Activation delay stacker
t	18	02	0,0	2,55	0,10	s	Time when stacker starts clamping
t	18	03	0,0	2,55	0,10	s	Duty cycle of the stacker
<b>Zigzag</b>							
t	19	00	0	359	108	°	Switch position for zigzag
t	19	01	4	6	6	Stitches	Number of stitches for zigzag
<b>Thread wiper</b>							
t	20	00	0	1	1	-	Thread wiper 0 = Off; 1 = On
t	20	01	10	255	100	ms	Switch-on period for thread wiper
<b>Step cutting/contour guide</b>							
t	21	00	0,0	2,55	0,50	s	Delay after switching off edge cutter for step cutting
t	21	01	0,0	2,55	0,50	s	Delay for extension of stepped cylinder
t	21	02	0,0	2,55	0,50	s	Duration of impulse blowing during extension of stepped cylinder
t	21	03	0,0	2,55	0,50	s	Delay for switching off blowing when sewing stops
t	21	04	0,0	2,55	0,50	s	Delay for switching on edge cutter after switching step cutting on/off
<b>Outfeed roller</b>							
t	22	00	0	3	0	-	Outfeed roller mode 0 = Off; 1 = Seam end; 2 = Seam beginning; 3 = Seam beginning & seam end;
t	22	03	0	255	0	Stitches	Number of stitches until outfeed roller is lowered at seam beginning
t	22	04	0	255	0	Stitches	Number of stitches until outfeed roller is lifted at seam beginning
t	22	05	0,0	99,99	0,50	s	Activation delay of the outfeed roller

	C	P	Min	Max	Preset value	Unit	Description
t	22	06	0,0	99,99	0,50	s	Duty cycle of outfeed roller at seam end
t	22	07	0,0	20,0	5,0	kHz	Speed of outfeed roller at seam end
<b>Hook lubrication</b>							
t	23	00	0	9999	0	Stitches	Number of stitches until hook lubrication is activated
t	23	01	0,0	99,99	0,0	s	Duration of hook lubrication
<b>Stitch loosening device</b>							
t	25	00	0	3	0	-	Mode of automatic stitch loosening device 0 = Only stitch loosening; 1 = Stitch loosening and 2nd stitch length; 2 = Stitch loosening, 2nd stitch length, and quick stroke adjustment; 3 = Stitch loosening, 2nd stitch length, quick stroke adjustment, and 2nd thread tension;
t	25	03	0	1	0	-	Automatic sewing material thickness detection 0 = Off; 1 = On
t	25	05	0	1	1	-	Speed reduction during stitch loosening 0 = Off; 1 = On
t	25	06	0	2500	800	rpm	Level to which speed will be reduced
<b>Differential transport</b>							
t	26	00	0	1	0	-	Direction of differential transport 0 = Minus; 1 = Plus
<b>Stitch length switching</b>							
t	30	00	0	2	2	-	Speed limit if stitch length is long 0 = Off; 1 = Speed limit DB2000; 2 = Speed limit DB3000
t	30	01	0	2	0	-	Stitch length during bartacking 0 = Preset stitch length (Long/Normal); 1 = Normal stitch length; 2 = Long stitch length
t	30	02	0	2	0	-	Stitch length after thread cutting 0 = Selected stitch length is retained; 1 = Normal stitch length; 2 = Long stitch length

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
<b>Stitch shortening</b>							
t	31	00	0	255	0	Stitches	Stitch shortening at seam beginning
t	31	01	0	255	0	Stitches	Stitch shortening during thread cutting
<b>Operation lock</b>							
t	50	00	0	1	0	-	Operation lock 0 = Off; 1 = On
t	50	01	0	1	0	-	Method of operation of operation lock switch 0 = Closed contact (NC); 1 = Open contact (NO)
t	50	02	0	1	1	-	Behavior of the motor 0 = Emergency cut-off; 1 = Positioning
<b>Control, other</b>							
t	51	00	-	-	-	-	Display software version
t	51	01	-	-	-	-	Display control serial number
t	51	02	0	1	0	-	Display analog values (see t 51 12) during the sewing process 0 = No; 1 = Yes
t	51	04	-	-	-	-	Display class and subclass
t	51	05	-	-	-	-	Display operating hours
t	51	06	-	-	-	-	Display operating stitches
t	51	07	-	-	-	-	Display piece counters
t	51	08	0	1	-	-	M2M 0 = Off; 1 = On
t	51	09	-	-	-	-	Enter/display M2M Customer ID
t	51	10	0	5	-	-	Import data to control 0 = None; 1 = Parameter settings from DA dongle; 2 = Parameter settings from backup area; 3 = Seam paths from DA dongle; 4 = Master reset; 5 = Reset seam paths
t	51	11	0	3	-	-	Saving of parameters 0 = None; 1 = Parameter settings onto DA dongle; 2 = Parameter settings into backup area; 3 = Seam paths to the DA dongle

	C	P	Min	Max	Preset value	Unit	Description
t	51	12	-	-	-	-	<p>Hardware test</p> <p>Inputs and outputs in <b>bold</b> are only present in the DAC classic.</p> <p>1. Analog</p> <p>Um: Mains voltage in V</p> <p>U24: power supply outputs in V</p> <p>Imo: current of 24 V power supply</p> <p>PAn: analog value of pedal</p> <p>Nre: X1.4 analog input</p> <p><b>Ian</b>: X1.1 analog input</p> <p>Pst: digitized pedal position</p> <p>I2T: I<sup>2</sup>T of the motor (caution: pedal and motor are active!)</p> <p>2. Input</p> <p>X1.5: Manual Backtack</p> <p>X1.6: Needle up/down</p> <p>X1.7: Input function module 2</p> <p>X1.8: Input function module 1</p> <p><b>X1.9</b>: No Function</p> <p><b>X1.10</b>: No Function</p> <p>X1.11: Machine run blockage</p> <p><b>X1.12</b>: No Function</p> <p>X1.13: Light barrier</p> <p>X1.14: Backtack suppression/recall</p> <p><b>X2.1</b>: No Function</p> <p><b>X2.2</b>: No Function</p> <p><b>X2.3</b>: No Function</p> <p><b>X2.4</b>: No Function</p> <p><b>X2.6</b>: No Function</p> <p><b>X2.7</b>: No Function</p> <p>3. Output</p> <p><b>X1.15</b>: No Function</p> <p>X1.17: POS2 signal</p> <p><b>X1.18</b>: No Function</p> <p>X1.20: No Function</p> <p>X1.21: No Function</p> <p><b>X1.22</b>: No Function</p> <p><b>X1.23</b>: No Function</p> <p>X1.24: LED Backtack suppression/recall</p> <p><b>X1.25</b>: No Function</p> <p>X1.26: POS1 signal</p> <p>X1.27: Thread clamp</p> <p><b>X1.28</b>: Needle cooling</p> <p>X1.29: LED function module 1</p> <p>X1.30: Function module 1</p> <p>X1.31: LED function module 2</p> <p><b>X1.32</b>: Function module 2</p>

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
							X1.34: Backtacking X1.35: Sewing foot lifting X1.36: Thread tension X1.37: Thread trimmer 4. Flash
t	51	13	-	-	-	-	Display last 10 error messages 1 = most recent error 10 = first error
t	51	14	0	1	-	-	Reset maintenance counter 0 = No; 1 = Yes
t	51	15	0	1	-	-	Automatic reset of M2M counters after power-on 0 = No; 1 = Yes
t	51	16	0	1	-	-	Reset of M2M counters 0 = No; 1 = Yes
t	51	20	0	50	3	-	Set input function for bartack input (machine connector Pin 5) 0 = No function; 1 = Threader; 2 = Bartack suppression/activation; 3 = Manual bartack; 4 = Half stitch; 5 = Whole stitch; 6 = Point position; 7 = Reversal; 8 = Function module 1 input (see t 11 00); 9 = Function module 2 input (see t 11 30); 10 = Function module 3 input (see t 11 60); 11 = Needle high; 12 = Ornamental-stitch bartack; 13 = Needle cooling; 14 = Thread wiper; 15 = Normal stitch length during bartacking; 16 = Operation lock when contact open (NO); 17 = Operation lock when contact closed (NC); 18 = Quick stroke adjustment (not stored); 19 = Quick stroke adjustment (stored); 20 = Speed limit DB2000;

	C	P	Min	Max	Preset value	Unit	Description
							21 = Speed limit DB3000; 22 = Light barrier; 23 = Puller feeding type (contin- ual/intermittent); 24 = Sewing foot lift with pedal in position 0; 25 = Release for new seam; 26 = Manual bartack stored; 27 = Move to zigzag position; 28 = Zigzag synchronization; 29 = Stacker on/off; 30 = Manual stacking 31 = Function module 1 input on (see t 11 00); 32 = Function module 1 input off (see t 11 00); 33 = Function module 2 input on (see t 11 30); 34 = Function module 2 input off (see t 11 30); 35 = Function module 3 input on (see t 11 60); 36 = Function module 3 input off (see t 11 60); 37 = Service Call (only with M2M); 38 = Stitch loosening; 39 = Differential transport 40 = Direction of differential transport; 41 = Reverse at seam beginning; 42 = Sewing foot lift after thread cutter; 43 = Manual sewing 44 = Seam end man- ual/automatic sewing; 45 = Automatic sewing
t	51	21	0	50	27	-	Set input function for bartack toggle input (machine connector Pin 14) For function see t 51 20
t	51	22	0	50	1	-	Set input function for needle high/low input (machine connec- tor Pin 6) For function see t 51 20
t	51	23	0	50	8	-	Set input function for input FF1 (machine connector Pin 8) For function see t 51 20



Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	51	24	0	50	28	-	Set input function for input FF2 (machine connector Pin 7) For function see t 51 20
t	51	25	0	50	0	-	Set input function for input FF3 (machine connector Pin 9) For function see t 51 20
t	51	26	0	50	0	-	Set input function for input (machine connector Pin 10) For function see t 51 20
t	51	27	0	50	0	-	Set input function for light barrier input (machine connector Pin 13) For function see t 51 20
t	51	28	0	50	0	-	Set input function IN_EXT1 (additional input interface Pin 1) For function see t 51 20
t	51	29	0	50	0	-	Set input function IN_EXT2 (additional input interface Pin 2) For function see t 51 20
t	51	30	0	50	0	-	Set input function IN_EXT3 (additional input interface Pin 3) For function see t 51 20
t	51	31	0	50	0	-	Set input function IN_EXT4 (additional input interface Pin 4) For function see t 51 20
t	51	32	0	50	0	-	Set input function IN_EXT5 (additional input interface Pin 6) For function see t 51 20
t	51	33	0	50	0	-	Set input function IN_EXT6 (additional input interface Pin 7) For function see t 51 20

	C	P	Min	Max	Preset value	Unit	Description
t	51	50	0	35	0	-	Set output function for output (machine connector Pin 18) 0 = No function; 1 = Thread clamp; 2 = Locking; 3 = Sewing foot lift; 4 = Thread tension; 5 = Auxiliary thread tension; 6 = Second stitch length; 7 = Carrier roller; 8 = Edge stop; 9 = Edge cutter; 10 = Fullness with DB3000; 11 = Fullness without DB3000; 12 = Step cutting; 13 = Contour guide; 14 = Stacker; 15 = Thread cutter; 16 = Quick stroke adjustment; 17 = Needle cooling; 18 = Stitch shortening; 19 = Pulse step cutting; 20 = Open step cutting; 21 = Thread clamp NSB; 22 = Thread puller NSB; 23 = Carrier roller pressure; 24 = Sewing foot pressure; 25 = Ready for sewing start; 26 = Pos. 1; 27 = Pos. 2; 28 = Motor operation; 29 = In the seam; 30 = Outfeed roller; 31 = Transport unit; 32 = Hook lubrication; 33 = Thread wiper
t	51	51	0	35	0	-	Set output function for output (machine connector Pin 21), For function see t 51 50
t	51	52	0	35	0	-	Set output function for output (machine connector Pin 22), For function see t 51 50
t	51	53	0	35	0	-	Set output function for output (machine connector Pin 26), For function see t 51 50
t	51	54	0	35	0	-	Set output function for output (machine connector Pin 27), For function see t 51 50

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
t	51	55	0	35	0	-	Set output function for output (machine connector Pin 28), For function see t 51 50
t	51	56	0	35	0	-	Set output function for output (machine connector Pin 32), For function see t 51 50
<b>OP1000</b>							
t	52	00	0	15	4	-	Display contrast of OP1000
t	52	01	0	1	0	-	Button tones 0 = Off; 1 = On
t	52	20	0	50	12	-	Set input function for F button of OP1000 0 = No function; 1 = Threader; 2 = Bartack suppression/activation; 3 = Manual bartack; 4 = Half stitch; 5 = Whole stitch; 6 = Point position; 7 = Reversal; 8 = Function module 1 input (see t 11 00); 9 = Function module 2 input (see t 11 30); 10 = Function module 3 input (see t 11 60); 11 = Needle high; 12 = Ornamental-stitch bartack; 13 = Needle cooling; 14 = Thread wiper; 15 = Normal stitch length during bartacking; 16 = Operation lock when contact open (NO); 17 = Operation lock when contact closed (NC); 18 = Quick stroke adjustment (not stored); 19 = Quick stroke adjustment (stored); 20 = Speed limit DB2000; 21 = Speed limit DB3000; 22 = Light barrier; 23 = Puller feeding type (continual/intermittent); 24 = Sewing foot lift with pedal in position 0;

	C	P	Min	Max	Preset value	Unit	Description
							25 = Release for new seam; 26 = Manual bartack stored; 27 = Move to zigzag position; 28 = Zigzag synchronization; 29 = Stacker on/off; 30 = Manual stacking 31 = Function module 1 input on (see t 11 00); 32 = Function module 1 input off (see t 11 00); 33 = Function module 2 input on (see t 11 30); 34 = Function module 2 input off (see t 11 30); 35 = Function module 3 input on (see t 11 60); 36 = Function module 3 input off (see t 11 60); 37 = Service Call (only with M2M); 38 = Stitch loosening; 39 = Differential transport 40 = Direction of differential transport; 41 = Reverse at seam beginning; 42 = Sewing foot lift after thread cutter; 43 = Manual sewing 44 = Seam end man- ual/automatic sewing; 45 = Automatic sewing
t	52	40	0	1	0	-	Button lock for start bartack buttons 0 = Off; 1 = On
t	52	41	0	1	0	-	Button lock for end bartack buttons 0 = Off; 1 = On
t	52	42	0	1	0	-	Button lock for thread buttons 0 = Off; 1 = On
t	52	43	0	1	0	-	Button lock for button group seam program 0 = Off; 1 = On
t	52	44	0	1	0	-	Button lock for button group programming 0 = Off; 1 = On

### 1.3 Developer level

	C	P	Min	Max	Preset value	Unit	Description
<b>Bartack</b>							
d	00	01	0	359	75	°	Mechanical switch-over angle for bartack
<b>Thread cutter (FA)</b>							
d	02	00	10	359	30	-	Angle at which thread cutting speed is to be reached before magnets are switched on
d	02	01	0	1	0	-	Chainstitch mode 0 = No; 1 = Yes
<b>Seam paths</b>							
d	07	00	150	9999	1500	rpm	Speed limit for seam paths
d	07	01	1	20	6	Stitches	Number of stitches for seam path speed limit
<b>Motor</b>							
d	08	00	1	9999	5500	rpm	Maximum motor speed
d	08	01	1	100	60	rpm/ms	Maximum acceleration or deceleration
d	08	02	0	50	4	Kgcm <sup>2</sup>	Machine inertia
d	08	04	0	255	100	Inc	Extension of deceleration ramp
d	08	05	0	1	0	-	Acceleration and deceleration ramp halved when I <sup>2</sup> t increases to over 70 % 0 = No; 1 = Yes
d	08	10	0,1	100,0	3,0	Ohm	Stator resistance
d	08	11	1	200	5	mH	Stator inductance
d	08	12	0,1	200,0	19,7	V/1000 rpm	EMF
d	08	13	0,1	15,00	10,00	A	Maximum stator current
d	08	14	1	10	2	-	Number of pole pairs
d	08	20	0	255	48	-	K <sub>pn</sub> factor of PID speed controller
d	08	21	0	255	33	-	K <sub>in</sub> factor of PID speed controller
d	08	22	0	255	0	-	K <sub>dn</sub> factor of PID speed controller
d	08	23	0	255	24	-	Feed-forward of speed control in deceleration process
d	08	30	0	255	0	-	K <sub>ps</sub> factor of PID distance controller
d	08	31	0	255	0	-	K <sub>is</sub> factor of PID distance controller
d	08	32	0	255	0	-	K <sub>ds</sub> factor of PID distance controller

	C	P	Min	Max	Preset value	Unit	Description
d	08	40	0	255	38	-	K <sub>px</sub> factor of PID position controller
d	08	41	0	255	38	-	K <sub>dx</sub> factor of PID position controller
d	08	42	0	255	32	Inc	Increments for activation of PID position controller
d	08	43	0	1000	0	2.857°	Angle for positioning
d	08	44	0	1000	32	Inc	Increments for duration of activation of positioning speed
d	08	45	10	100	50	rpm	Increase in speed for position controller during thread cutting
d	08	46	0	200	0	Inc	Increase increments for the position controller during thread cutting
d	08	51	0	1	0	-	Continuous operation 0 = No; 1 = Yes
d	08	52	0,0	99,99	5,00	s	Motor on duration
d	08	53	0,0	99,99	5,00	s	Motor off duration
d	08	54	1	9999	900	s	Duration of continuous operation
d	08	55	0	2000	180	rpm	Speed for reference run
<b>Thread tension</b>							
d	09	01	5	100	40	%	Duty cycle for threader
<b>Top puller</b>							
d	14	00	0,1	20,00	6,00	kHz	Maximum frequency
d	14	01	1	500	200	rpm/ms	Acceleration ramp
d	14	02	1	500	200	rpm/ms	Deceleration ramp
d	14	03	1	9000	2000	Hz	Start frequency
d	14	04	1	9000	2000	Hz	Stop frequency
d	14	05	1	1000	500	Lines	Encoder lines
d	14	06	1	9000	2000	Steps	Microsteps per turn
d	14	07	0	1	1	-	Encoder 0 = No; 1 = Yes
d	14	10	0,1	9,000	1,100	Ohm	Stator resistance
d	14	11	0,1	9,000	2,200	mH	Stator inductance
d	14	12	0	1000	0	-	EMF factor
d	14	13	0,1	10,00	3,50	A	Maximum stator current
d	14	14	1	100	50	-	Number of pole pairs

Parameter list P40CD

	C	P	Min	Max	Preset value	Unit	Description
d	14	15	0,1	10,00	2,00	A	Maximum no-damage current
d	14	20	0	9999	0	-	$K_{pn}$ factor of PID speed controller
d	14	21	0	9999	0	-	$K_{in}$ factor of PID speed controller
d	14	22	0	9999	0	-	$K_{dn}$ factor of PID speed controller
d	14	30	0	9999	1500	-	$K_{ps}$ factor of PID distance controller
d	14	31	0	9999	50	-	$K_{is}$ factor of PID distance controller
d	14	32	0	9999	0	-	$K_{ds}$ factor of PID distance controller
d	14	40	0	9999	1500	-	$K_{px}$ factor of PID position controller
d	14	41	0	9999	0	-	$K_{ix}$ factor of PID position controller
d	14	42	0	9999	100	-	$K_{dx}$ factor of PID position controller
<b>Bottom puller</b>							
d	14	50	0,1	20,00	6,00	kHz	Maximum frequency
d	14	51	1	500	200	rpm/ms	Acceleration ramp
d	14	52	1	500	200	rpm/ms	Deceleration ramp
d	14	53	1	9000	2000	Hz	Start frequency
d	14	54	1	9000	2000	Hz	Stop frequency
d	14	55	1	1000	500	Lines	Encoder lines
d	14	56	1	9000	2000	Steps	Microsteps per turn
d	14	57	0	1	1	-	Encoder 0 = No; 1 = Yes
d	14	60	0,1	9,000	1,100	Ohm	Stator resistance
d	14	61	0,1	9,000	2,200	mH	Stator inductance
d	14	62	0	1000	0	-	EMF factor
d	14	63	0,1	10,00	3,50	A	Maximum stator current
d	14	64	1	100	50	-	Number of pole pairs
d	14	65	0,1	10,00	2,00	A	Maximum no-damage current
d	14	70	0	9999	0	-	$K_{pn}$ factor of PID speed controller
d	14	71	0	9999	0	-	$K_{in}$ factor of PID speed controller
d	14	72	0	9999	0	-	$K_{dn}$ factor of PID speed controller
d	14	80	0	9999	1500	-	$K_{ps}$ factor of PID distance controller

	C	P	Min	Max	Preset value	Unit	Description
d	14	81	0	9999	50	-	$K_{Is}$ factor of PID distance controller
d	14	82	0	9999	0	-	$K_{ds}$ factor of PID distance controller
d	14	90	0	9999	1500	-	$K_{px}$ factor of PID position controller
d	14	91	0	9999	0	-	$K_{Ix}$ factor of PID position controller
d	14	92	0	9999	100	-	$K_{dx}$ factor of PID position controller
<b>Control, other</b>							
d	51	00	1	255	100	ms	Time duration for raising $U_{mag}$ to 33 V
d	51	01	1	255	5	ms	Duration for DeEnergizer process
d	51	02	0,1	16,00	16,00	kHz	Set PWM frequency
d	51	03	-	-	-	-	Display machine serial number
d	51	04	-	-	-	-	Display production date
d	51	10	0	9999	0	x d5111	Reset value of maintenance counter (counter is deactivated at 0)
d	51	11	1	255	1	x 10000St	Factor of maintenance counter
d	51	12	1	255	1	x d5111	Error message repeated



## 2 Error, warning and information messages

Code	Type	Possible cause	Remedial action
1000	Error	Sewing motor encoder plug (Sub-D, 9-pin) not connected	- Connect encoder cable to the control, use correct connection
1001	Error	Sewing motor error: Sewing motor plug (AMP) not connected	- Check connection and plug in, if necessary - Test sewing motor phases (R= 2.8 Ω, high impedance to PE) - Replace the encoder - Replace the sewing motor - Replace the control
1002	Error	Sewing motor insulation error	- Check motor phase and PE for low-impedance connection - Replace the encoder - Replace the sewing motor
1004	Error	Sewing motor error: Incorrect sewing motor direction of rotation	- Replace the encoder - Check plug assignment and change, if necessary - Check wiring in machine distributor and change it, if necessary - Test motor phases and check for correct value
1005	Error	Motor blocked	- Eliminate stiff movement in the machine - Replace the encoder - Replace the motor
1006	Error	Maximum speed exceeded	- Replace the encoder - Perform reset - Check class (t 51 04)
1007	Error	Error in the reference run	- Replace the encoder - Eliminate stiff movement in the machine
1008	Error	Encoder error	- Replace the encoder
1010	Error	External synchronizer plug (Sub-D, 9-pin) not connected	Connect cable of external synchronizer to control, use correct connection (Sync) - Only required for machines with transmission!
1011	Error	Encoder Z pulse missing	- Switch off the control. Turn handwheel and switch on the control again - If error is not corrected, check encoder
1012	Error	Synchronizer fault	- Replace the synchronizer

Code	Type	Possible cause	Remedial action
1052	Error	Sewing motor overcurrent, internal current increase >25 A	<ul style="list-style-type: none"> <li>- Check selection of class</li> <li>- Replace the control</li> <li>- Replace the sewing motor</li> <li>- Replace the encoder</li> </ul>
1053	Error	Sewing motor overvoltage	<ul style="list-style-type: none"> <li>- Check selection of class</li> <li>- Replace the control</li> </ul>
1054	Error	Internal short circuit	<ul style="list-style-type: none"> <li>- Replace the control</li> </ul>
1055	Error	Sewing motor overload	<ul style="list-style-type: none"> <li>- Eliminate stiff movement in the machine</li> <li>- Replace the encoder</li> <li>- Replace the sewing motor</li> </ul>
1203	Information	Position not reached (during thread cutting, reversal, etc.)	<ul style="list-style-type: none"> <li>- Check and, if necessary, change controller settings.</li> </ul> <p>Mechanical changes to the machine. (e. g. thread cutting setting, belt tension, etc.)</p> <ul style="list-style-type: none"> <li>- Check position (thread lever at top dead center)</li> </ul>
2020	Information	DACextension box not responding	<ul style="list-style-type: none"> <li>- Check connection cables</li> <li>- Check LEDs of DACextension box</li> <li>- Software update</li> </ul>
2021	Information	Sewing motor encoder plug (Sub-D, 9-pin) not connected to DACextension box	<ul style="list-style-type: none"> <li>- Connect encoder cable to DACextension box using the correct connection</li> </ul>
2101	Error	DA stepper card 1 reference run timeout	<ul style="list-style-type: none"> <li>- Check reference sensor</li> </ul>
2103	Error	DA stepper card 1 step losses	<ul style="list-style-type: none"> <li>- Check for stiff movement</li> </ul>
2120	Information	DA stepper card 1 not responding	<ul style="list-style-type: none"> <li>- Check connection cables</li> <li>- Check LEDs of DACextension box</li> <li>- Software update</li> </ul>
2121	Information	DA stepper card 1 encoder plug (Sub-D, 9-pin) not connected	<ul style="list-style-type: none"> <li>- Connect encoder cable to the control, use correct connection</li> </ul>
2122	Information	DA stepper card 1 flywheel position not found	<ul style="list-style-type: none"> <li>- Check connection cables</li> <li>- Check stepper motor 1 for stiff movement</li> </ul>
2155	Error	DA stepper card 1 overload	<ul style="list-style-type: none"> <li>- Check for stiff movement</li> </ul>
2201	Error	DA stepper card 2 reference run timeout	<ul style="list-style-type: none"> <li>- Check reference sensor</li> </ul>
2203	Error	DA stepper card 2 step losses	<ul style="list-style-type: none"> <li>- Check for stiff movement</li> </ul>
2220	Information	DA stepper card 2 not responding	<ul style="list-style-type: none"> <li>- Check connection cables</li> <li>- Check LEDs of DACextension box</li> <li>- Software update</li> </ul>

## Parameter list P40CD

Code	Type	Possible cause	Remedial action
2221	Information	DA stepper card 2 encoder plug (Sub-D, 9-pin) not connected	- Connect encoder cable to the control, use correct connection
2222	Information	DA stepper card 2 flywheel position not found	- Check connection cables - Check stepper motor 2 for stiff movement
2255	Error	DA stepper card 2 overload	- Check for stiff movement
3100	Error	AC-RDY timeout, intermediate circuit voltage did not reach the defined threshold in the specified time	- Check the mains voltage - If the mains voltage is OK, replace the control
3101	Error	High voltage fault, mains voltage, longer duration >290 V	- Check mains voltage, if nominal voltage is continuously exceeded, stabilize it or use a generator
3102	Error	Low voltage failure (2nd threshold) (mains voltage < 150 V AC)	- Check the mains voltage - Stabilize mains voltage - Use generator
3103	Information	Low voltage warning (1st threshold) (mains voltage < 180 V AC)	- Check the mains voltage - Stabilize mains voltage - Use generator
3104	Warning	Pedal is not in position 0	When switching the control on, take your foot off the pedal
3105	Error	U24 V short circuit	- Disconnect 37-pin plug; if error persists, replace control - Test inputs/outputs for 24 V short circuit
3106	Error	U24 V (I <sup>2</sup> T) overload	- One or more magnets defective
3107	Error	Pedal not connected	- Connect analog pedal
3108	Information	Speed limited due to insufficient mains voltage	- Check the mains voltage
3109	Warning	Operation lock	- Check tilt sensor on machine
3150	Information	Maintenance necessary	- For information on lubricating the machine, see the service instructions for the machine
3151	Warning	Maintenance necessary (operation cannot continue unless parameter t 51 14 is reset, see the operating instructions of the machine)	- Service is urgently required, see service instructions for the machine
3155	Information	No release for sewing process	- Parameter t 51 20 – t 51 33 = 25 - Input signal for sewing process release required

Code	Type	Possible cause	Remedial action
3160	Information	Stitch loosening device	- Stitch loosening cannot be performed
3215	Information	Bobbin stitch counter (info value 0 reached)	- Change bobbin, set counter value - press counter reset button
3216	Information	Remaining thread monitor left	- Change left bobbin
3217	Information	Remaining thread monitor right	- Change right bobbin
3218	Information	Remaining thread monitor left and right	- Change left and right bobbin
3223	Information	Skip stitch detected	-
3224	Information	Bobbin failed to rotate	-
6353	Error	Internal EEPROM communication error	- Switch off the control, wait until the LEDs are off and then switch on again
6354	Error	External EEPROM communication error	- Switch off the control, wait until the LEDs are off, check connection for machine ID, switch on control again
6360	Information	No valid data on external EEPROM (internal data structures are not compatible with the external data storage device)	- Software update
6361	Information	No external EEPROM connected	- Connect machine ID
6362	Information	No valid data on internal EEPROM (internal data structures are not compatible with the external data storage device)	- Check machine ID connection - Switch off the control, wait until the LEDs are off and then switch on again - Software update
6363	Information	No valid data on internal and external EEPROM (Software version is not compatible with the internal data storage device, emergency operating features only)	- Check machine ID connection - Switch off the control, wait until the LEDs are off and then switch on again - Software update
6364	Information	No valid data on internal EEPROM and external EEPROM not connected (the internal data structures are not compatible with the external data storage device, emergency operating features only)	- Check machine ID connection - Switch off the control, wait until the LEDs are off and then switch on again - Software update
6365	Information	Internal EEPROM defective	- Replace the control

Parameter list P40CD

Code	Type	Possible cause	Remedial action
6366	Information	Internal EEPROM defective and external data not valid (emergency operating features only)	- Replace the control
6367	Information	Internal EEPROM defective and external EEPROM not connected (emergency operating features only)	- Replace the control
7202	Information	DACextension box boot error	- Check connection cables - Software update - Replace DACextension box
7203	Information	Checksum error during update	- Check connection cables - Software update - Replace DACextension box
7212	Information	DA stepper card 1 boot error	- Check connection cables - Software update - Replace DACextension box
7213	Information	Checksum error occurred while updating DA stepper card 2	- Check connection cables - Software update - Replace DACextension box
7222	Information	DA stepper card 2 boot error	- Check connection cables - Software update - Replace DACextension box
7223	Information	Checksum error occurred while updating DA stepper card 2	- Check connection cables - Software update - Replace DACextension box
7801	Information	Software version error (DAC classic only; only the functions of the DAC basic will remain available)	- Software update - Replace the control
7802	Information	Software update error (DAC classic only; only the functions of the DAC basic will remain available)	- Another software update - Replace the control
7803	Information	Communication error (DAC classic only; only the functions of the DAC basic will remain available)	- Restart of the control - Software update - Replace the control
8401	Error	Watchdog	- Software update - Machine ID reset - Replace the control
8402 - 8405	Error	Internal error	- Software update - Machine ID reset - Replace the control

<b>Code</b>	<b>Type</b>	<b>Possible cause</b>	<b>Remedial action</b>
8406	Error	Checksum error	- Software update - Replace the control
8501	Error	Software protection	- the DA tool must always be used for software updates



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