

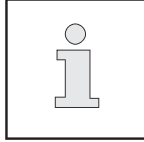


MA 1245

MA 1246

Instruction Manual

This manual applies to all machines of the mentioned type from the following serial number onward: **#1000011 →**



This Instruction Manual is valid for all models and subclasses listed in the chapter "Specifications".

For further information, please visit us on **www.mauser-spezial.com**
or contact us via: **info@mauser-spezial.com**

Mauser Spezial

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Contents	Page
1. Safety	5
1.01. Directives	5
1.02. General notes on safety	5
1.03. Safety symbols	6
1.04. Important points for the user	6
1.05. Operating and specialist personnel	7
1.05.01. Operating personnel	7
1.05.02. Specialist personnel	7
1.06. Danger warnings	8
2. Proper use	9
3. Specifications	10
3.01. MA 1245, MA 1246	10
3.02. Possible models and subclasses	11
3.03. Max number of stitches/min-1 for the MA 1245	11
3.04. Max number of stitches/min-1 for the MA 1246	11
4. Disposal of Machine	12
5. Transportation, packing and storage	13
5.01. Transportation to customer's premises	13
5.02. Transportation inside the customer's premises	13
5.03. Disposal of packing materials	13
5.04. Storage	13
6. Explanation of symbols	14
7. Controls	15
7.01. On/off switch	15
7.02. Pedals (on machines with subclass -910/01)	15
7.03. Pedal (on machines with automatic presser-foot lifter)	16
7.04. Key on the machine head (for machines with backtacking mechanism -911/97)	16
7.05. Lever for lifting the presser foot	17
7.06. Feed regulator / reverse sewing	17
7.07. Feed regulator (on machines with backtacking mechanism -911/97)	18
7.08. Adjustment nut for the top-feed stroke	18
7.09. Control panel (only on machines with Mauser-Eco drive)	18
8. Installation and commissioning	19
8.01. Installation	19
8.01.01. Adjusting the table-top height	19
8.01.02. Assembling the motor (only on machines with Mauser-motor)	20
8.01.03. Tightening the V-belt	20
8.01.04. Mounting the bottom V-belt guard	21
8.01.05. Mounting the upper V-belt guard	22
8.01.06. Fitting the synchronizer	22
8.01.07. Fitting the tilt lock	23
8.01.08. Fitting the reel stand	23

Contents	Page
8.02. Connecting the plug-in connections and earth cables	24
8.03. Commissioning	25
8.04. Switching the machine on/off	25
8.05. Basic position of the machine drive unit	26
9. Setting up	27
9.01. Inserting the needle	27
9.02. Winding the bobbin thread, regulating the winder tension	28
9.03. Removing/Threading the bobbin case	29
9.04. Threading the bobbin thread and regulating the bobbin thread tension	29
9.05. Threading needle thread/adjusting needle thread tension on the MA 1245	30
9.06. Threading needle thread/adjusting needle thread tension on the MA 1246	31
9.07. Adjusting the stitch counter for the bobbin thread control	31
10. Care and maintenance	32
10.01. Servicing and maintenance intervals	32
10.02. Cleaning	32
10.03. General lubrication	33
10.04. Lubricating the hook	34
10.05. Lubricating the head	35
10.06. Lubricating the top-feed drive eccentric	35
10.07. Checking/regulating the air pressure	36
10.08. Emptying/cleaning the water bowl of the air filter/regulator	36
10.09. Parameter settings	37
10.09.01. Parameter list	37
11. Mounting the table top and circuit diagrams	38
11.01. Table top cutout	38
11.02. Mounting the table top	39
11.03. Circuit diagrams	40
12. Wearing parts	44

1 Safety

1.01 Directives

This machine is constructed in accordance with the European regulations contained in the conformity and manufacturer's declarations.

In addition to this Instruction Manual, also observe all generally accepted, statutory and other regulations and legal requirements and all valid environmental protection regulations! The regionally valid regulations of the social insurance society for occupational accidents or other supervisory organizations are to be strictly adhered to!

1.02 General notes on safety

- This machine may only be operated by adequately trained operators and only after having completely read and understood the Instruction Manual!

- All Notes on Safety and Instruction Manuals of the motor manufacturer are to be read before operating the machine!

- The danger and safety instructions on the machine itself are to be followed!

- This machine may only be used for the purpose for which it is intended and may not be operated without its safety devices. All safety regulations relevant to its operation are to be adhered to.

- When exchanging sewing tools (e.g. needle, roller presser, needle plate and bobbin), when threading the machine, when leaving the machine unattended and during maintenance work, the machine is to be separated from the power supply by switching off the On/Off switch or by removing the plug from the mains!

- Everyday maintenance work is only to be carried out by appropriately trained personnel!

- Repairs and special maintenance work may only be carried out by qualified service staff or appropriately trained personnel!

- Work on electrical equipment may only be carried out by appropriately trained personnel!

- Work is not permitted on parts and equipment which are connected to the power supply! The only exceptions to this rule are found in the regulations EN 50110.

- Modifications and alterations to the machine may only be carried out under observance of all the relevant safety regulations!

- Only spare parts which have been approved by us are to be used for repairs! We expressly point out that any replacement parts or accessories which are not supplied by us have not been tested and approved by us. The installation and/or use of any such products can lead to negative changes in the structural characteristics of the machine. We are not liable for any damage which may be caused by non-original parts.

1.03

Safety symbols

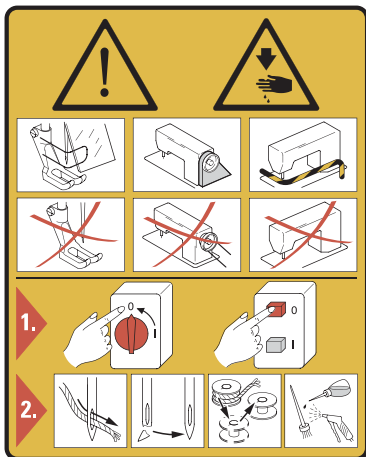


Danger!

Points to be observed..



Danger of injury for operating and specialist personnel!



Caution

Do not operate without finger guard and safety devices.
Before threading, changing bobbin and needle, cleaning
etc. switch off main switch.

1.04

Important points for the user

- This Instruction Manual is an integral part of the machine and must be available to the operating personnel at all times.
- The Instruction Manual must be read before operating the machine for the first time.
- The operating and specialist personnel is to be instructed as to the safety equipment of the machine and regarding safe work methods.
- It is the duty of the user to only operate the machine in perfect running order.
- It is the obligation of the user to ensure that none of the safety mechanisms are removed or deactivated.
- It is the obligation of the user to ensure that only authorized persons operate and work on the machine.

Further information can be obtained from your Mauser Spezial Agent
or via www.mauser-spezial.com

1.05 **Operating and specialist personnel**

1.05.01 **Operating personnel**

Operating personnel are persons responsible for the equipping, operating and cleaning of the machine as well as for taking care of problems arising in the sewing area.

The operating personnel is required to observe the following points and must:

- always observe the Notes on Safety in the Instruction Manual!
- never use any working methods which could adversely affect the safety of the machine!
- not wear loose-fitting clothing or jewelry such as chains or rings!
- also ensure that only authorized persons have access to the potentially dangerous area around the machine!
- always immediately report to the person responsible any changes in the machine which may limit its safety!

1.05.02 **Specialist personnel**

Specialist personnel are persons with a specialist education in the fields of electrics, electronics and mechanics. They are responsible for the lubrication, maintenance, repair and adjustment of the machine.

The specialist personnel is obliged to observe the following points and must:

- always observe the Notes on Safety in the Instruction Manual!
- switch off the On/Off switch before carrying out adjustments or repairs, and ensure that it cannot be switched on again unintentionally!
- wait until the luminous diode on the control box is no longer blinking or on before beginning adjustment or repair work.
- never work on parts which are still connected to the power supply! Exceptions are explained in the regulations EN 50110.
- replace the protective coverings and close the electrical control box after all repairs or maintenance work!

1.06

Danger warnings



A working area of 1 m must be kept free both in front of and behind the machine, so that easy access is possible at all times.



Never put your hands or fingers in the sewing area during sewing!
Danger of injury by the needle!



While setting or adjusting the machine do not leave any objects on the table nor in the needle plate area! Objects may be trapped or flung out of the machine!

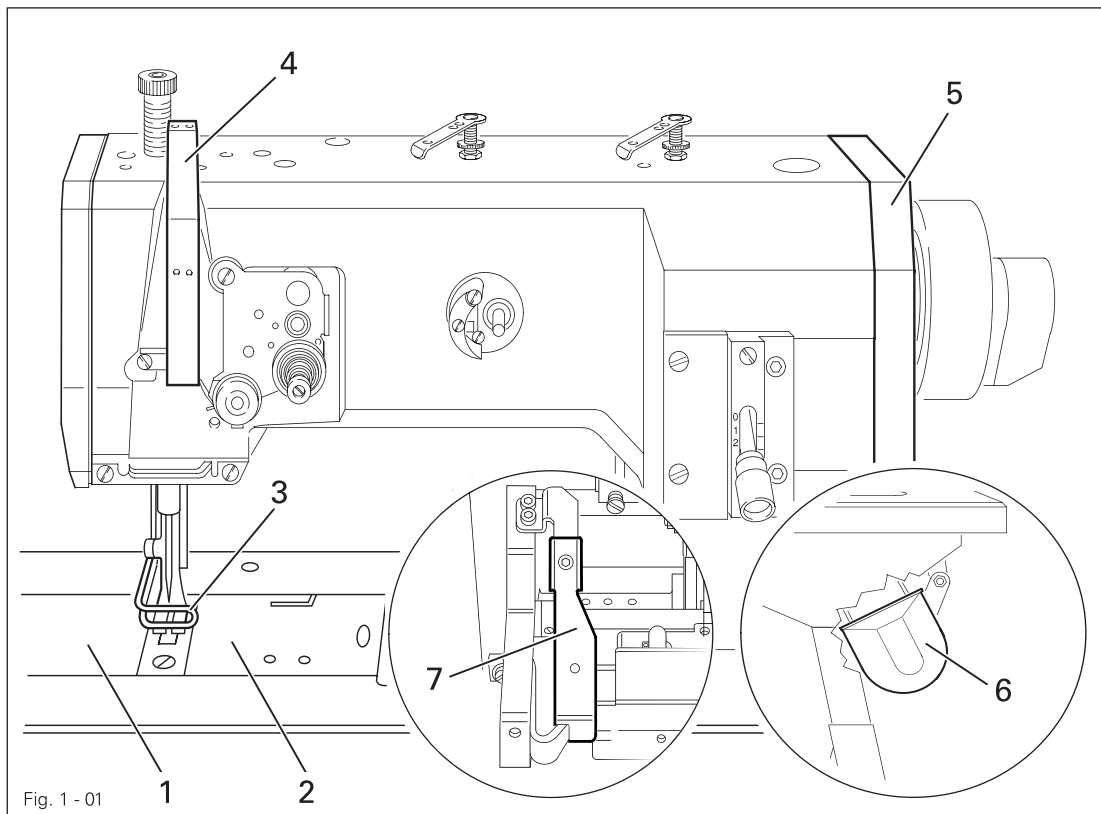


Fig. 1 - 01



Only operate the machine with covers 1 and 2 closed!
Danger of injury from the rotating hook!



Do not run the machine without finger guard 3!
Danger of injury by up and down movement of needle!



Do not run the machine without take-up lever guard 4!
Danger of injury by moving take-up lever!



Do not run the machine without belt guards 4 and 5!
Danger of injury by rotating v-belt!



Do not operate the machine without tilt lock 6!
Danger of crushing between sewing head and table!

Proper use

MA 1245

The MA 1245 is a single needle, flatbed sewing machine with bottom, top and needle feeds as well as a large vertical hook for sewing lockstitch seams. The machine is designed for commercial use (industry).

MA 1246

The MA 1246 is a two-needle, flat bed sewing machine with bottom, top and needle feed as well as vertical sewing hook for lockstitch seams. The machine is intended for commercial (industrial) use only.



Any and all uses of this machine which have not been approved of by the manufacturer are considered to be inappropriate! The manufacturer cannot be held liable for any damage caused by the inappropriate use of the machine!

The appropriate use of the machine includes the observance of all operational, adjustment, maintenance and repair measures required by the manufacturer!

3 Specifications

3.01 MA 1245, MA 1246 ♦

Stitch type: 301 (lockstitch))

Needle system: 134 - 35

Needle sizes in 1/100 mm:

Version BN: 80 - 100

Version CN: 110 - 140

Max. thread size max. (Synthetiks \square):

Version BN: 40/3

Version CN: 20/3

Max. stitch length:

Version BN und CN: 6,0 mm

Version CN 8: 8,0 mm

Handwheel eff. dia.: 80 mm

Dimensions of machine:

Length 1245 / 1246: approx. 530 / 570 mm

Width: approx. 177 mm

Height: approx. 410 mm

Clearance width: 265 mm

Clearance height: 115 mm

Fabric clearance (presser foot raised): 14 mm

Net weight (machine head): approx. 40 kg

Motor data: see motor specification plate

Working air pressure: 6 bar

Air consumption per working cycle: ~0,8 l

Noise data:

Emission sound level at the workplace at appropriate speed

(Noise measurement in accordance with DIN 45 635-48-A-1, ISO 11204, ISO 3744, ISO 4871)

MA 1245 at a speed of 2300 spm.: LpA = 82 dB(A) \square

MA 1246 at a speed of 2200 spm.: LpA = 82 dB(A) \square

♦ Subject to alterations

▲ synthetic, or other sizes of comparable thread types

▪ K_{pA} = 2,5 dB

3.02 Possible models and subclasses

Versions:

MA 1245

CN 8 : For processing medium-heavy materials

MA 1246

BN:For processing medium materials

CN; CN 8 : For processing medium-heavy materials

Additional equipment:

Subclass -900/56..... Thread trimmer

Subclass -911/97 Automatic presser-foot lifter with bartacker

3.03 Max. number of stitches/min-1 for the MA 1245

Top feed lift	Max. number of stitches/min-1 for stitch lengths up to 6 mm	Max. number of stitches/min-1 for stitch lengths from 6 mm to 8 mm
less than 3,5 mm	2800	2600
from 3,5 to 5,5 mm	2500	2500
from 5,5 to 7 mm,0	2000	2000

3.04 Max. number of stitches/min-1 for the MA 1246

Top feed lift	Max. number of stitches/min-1 for stitch lengths up to 6 mm and needle gauge of up to 10 mm	Max. number of stitches/min-1 for stitch lengths up to 6 mm and needle gauge of more than 10 mm	Max. number of stitches/min-1 for stitch lengths from 6 mm to 8 mm and needle gauge of up to 10 mm	Max. number of stitches/min-1 for stitch lengths up to 6 mm to 8 mm and needle gauge of more than 10 mm
less than 3,5 mm	2700	2500	2500	2300
from 3,5 to 5,5 mm	2400	2200	2400	2100
from 5,5 to 7 mm,0	1900	1700	1900	1600

4 Disposal of Machine

- Proper disposal of the machine is the responsibility of the customer.
- The materials used for the machine are steel, aluminium, brass and various plastic materials. The electrical equipment comprises plastic materials and copper.
- The machine is to be disposed of according to the locally valid pollution control regulations; if necessary, a specialist is to be commissioned.



Care must be taken that parts soiled with lubricants are disposed of separately according to the locally valid pollution control regulations!

5 Transportation, packing and storage

5.01 Transportation to customer's premises

The machines are delivered completely packed.

5.02 Transportation inside the customer's premises

The manufacturer cannot be made liable for transportation inside the customer's premises nor to other operating locations. It must be ensured that the machines are only transported in an upright position.

5.03 Disposal of packing materials

The packing materials of this machine comprise paper, cardboard and VCE fibre. Proper disposal of the packing material is the responsibility of the customer.

5.04 Storage

If the machine is not in use, it can be stored as it is for a period of up to six months, but It should be protected against dust and moisture.

If the machine is stored for longer periods, the individual parts, especially the surfaces of moving parts, must be protected against corrosion, e.g. by a film of oil.

Explanation of symbols

6 Explanation of symbols

In this instruction manual, work to be carried out or important information is accentuated by symbols. These symbols have the following meanings:



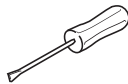
Note, information



Cleaning, care



Lubrication



Maintenance, repairs, adjustment, service work
(only to be carried out by technical staff)

7 Controls

7.01 On/off switch

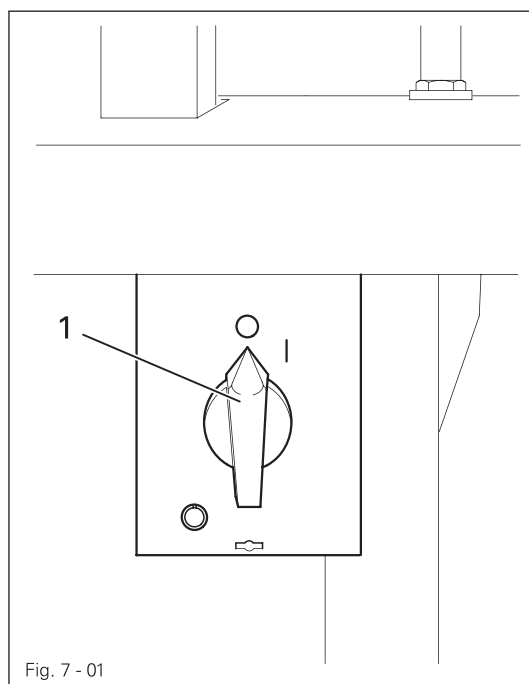


Fig. 7 - 01

- The power supply to the machine is switched on or off by turning switch 1.



The illustrated on/off switch is fitted to machines with Mauser motors. If other motors are used, a different switch may be fitted.

7.02 Pedals (on machines with subclass -910/01)

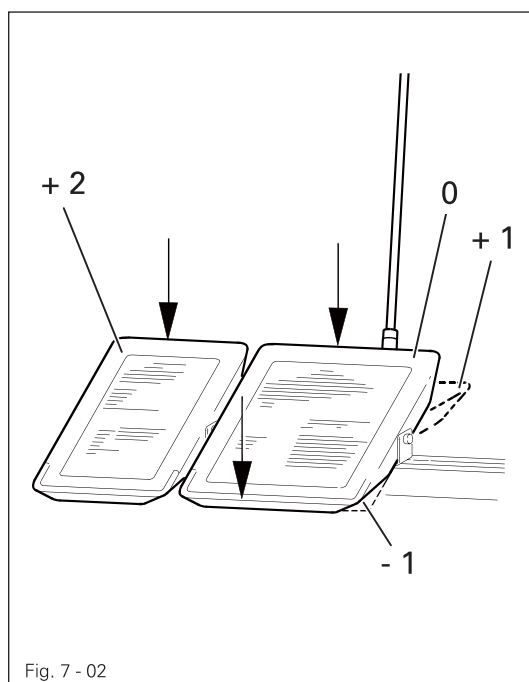


Fig. 7 - 02

- With the on/off switch on
 - 0 = Machine stop
 - +1 = Sew
 - 1 = Trim thread (on machines with thread trimmer)
 - +2 = Raise presserfoot

7.03 Pedal (on machines with automatic presser-foot lifter)

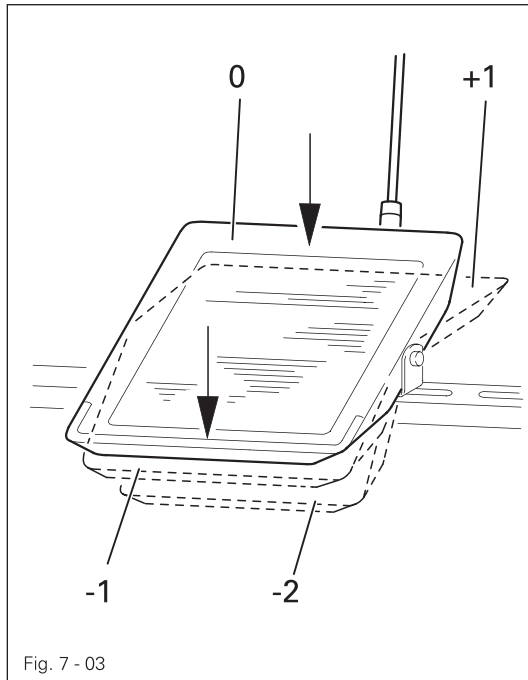


Fig. 7 - 03

- With the on/off switch on
 - 0 = Machine stop
 - +1 = Sew
 - 1 = Raise presserfoot
 - 2 = Trim thread (on machines with thread trimmer)

7.04 Key on the machine head (for machines with backtacking mechanism -911/97)

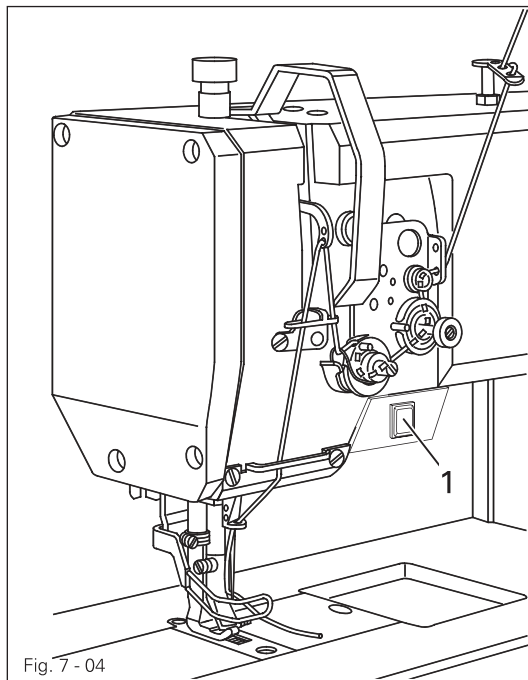
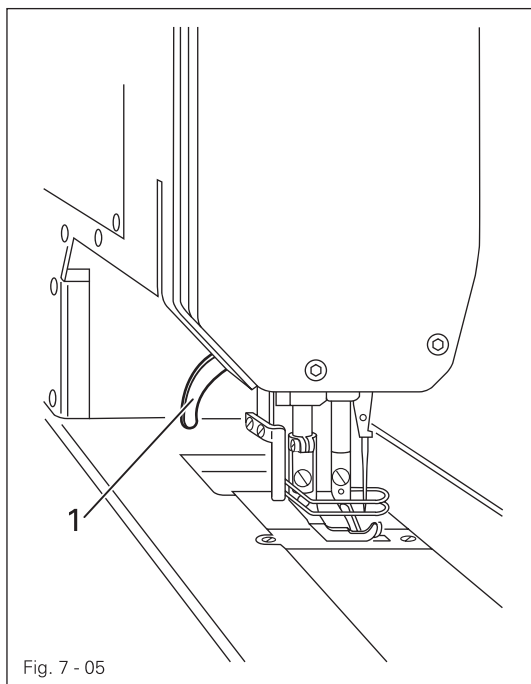


Fig. 7 - 04

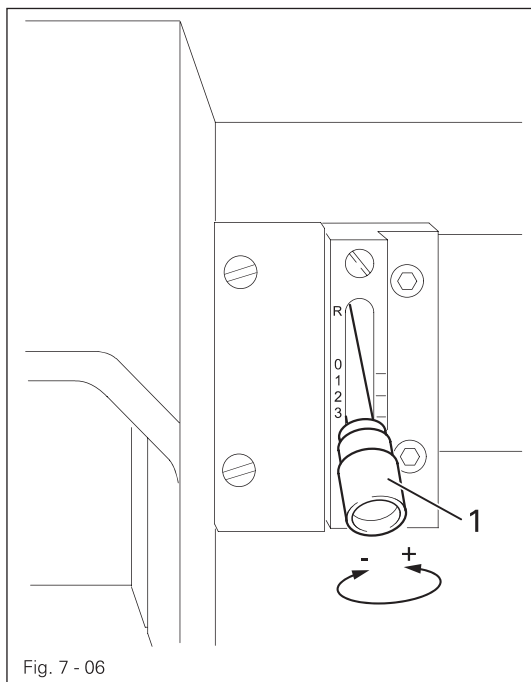
- Switch to reverse sewing by pressing key 1 while sewing.

7.05 Lever for lifting the presser foot



- The sewing foot can be lifted by raising lever 1.

7.06 Feed regulator / reverse sewing

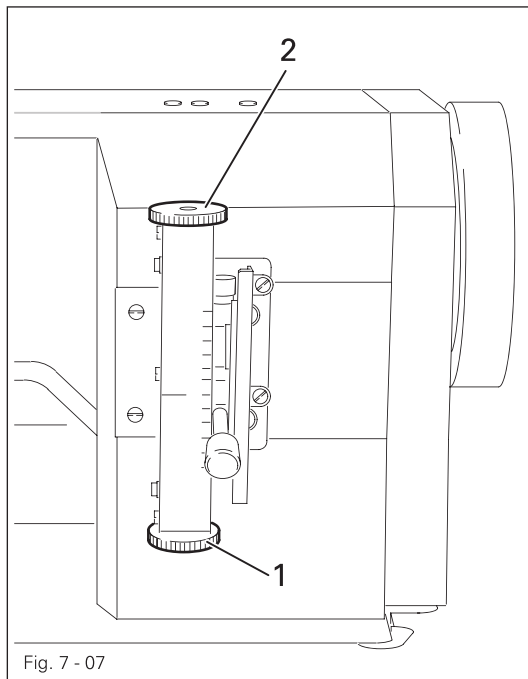


- Adjust the stitch length by turning the knurled nut 1 accordingly.

Reverse sewing

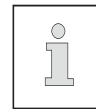
- Press knurled nut 1 upwards as far as possible (position "R")

7.07 Feed regulator (on machines with backtacking mechanism -911/97)



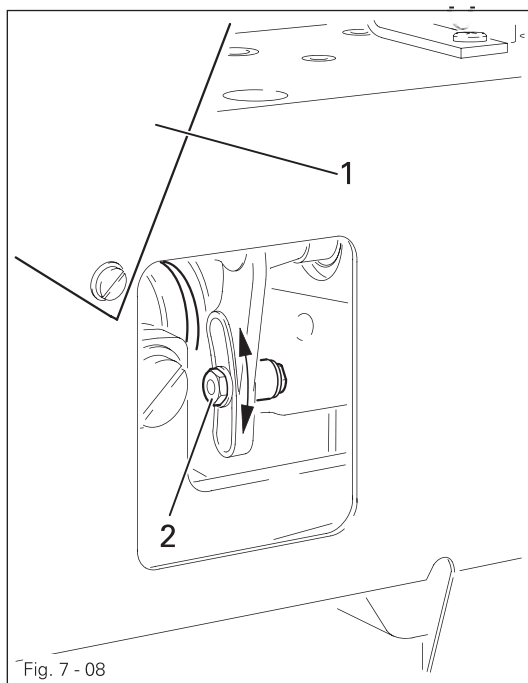
You can set the length of the reverse stitch as large as is required, independent of the forward stitch.

- The forward stitch is set with knurled screw 1 and the reverse stitch with knurled screw 2.



The options for setting the automatic start and end bartacks are to be found in the instruction manual of the motor.

7.08 Adjustment nut for the top-feed stroke



Switch the machine off!
Danger due to unintentional starting of the machine!

- Open cover 1 on the back of the machine, loosen screw 2 and move as required.

7.09 Control panel (only on machines with Mauser-Eco drive)

The description can be found in the separate instruction manual for the control panel.

8 Installation and commissioning

The machine must only be mounted and commissioned by qualified personnel!
All relevant safety regulations are to be observed!



If the machine is delivered without a table, it must be ensured that the frame and the table top which you intend to use can hold the weight of the machine and the motor. It must be ensured that the supporting structure is sufficiently sturdy, including during all sewing operations.

8.01 Installation

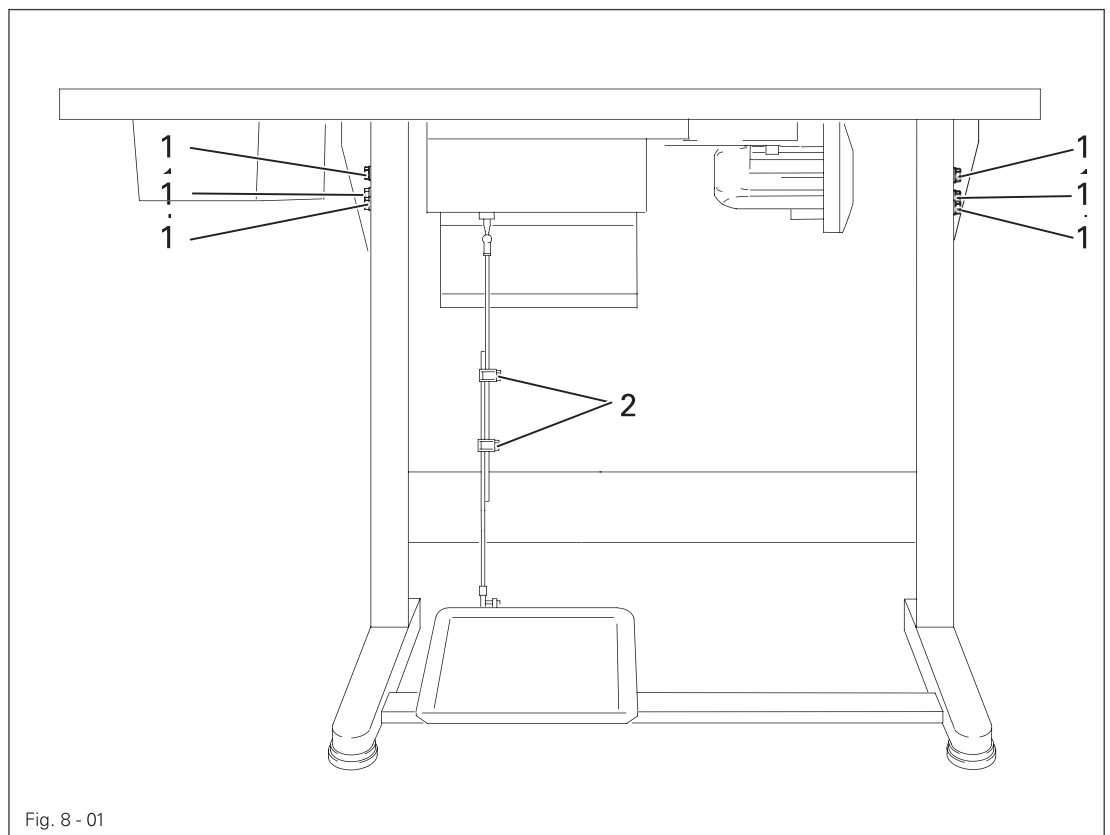
The site where the machine is installed must be provided with suitable connections for the electric current, see Chapter 3 Specifications.

It must also be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided.



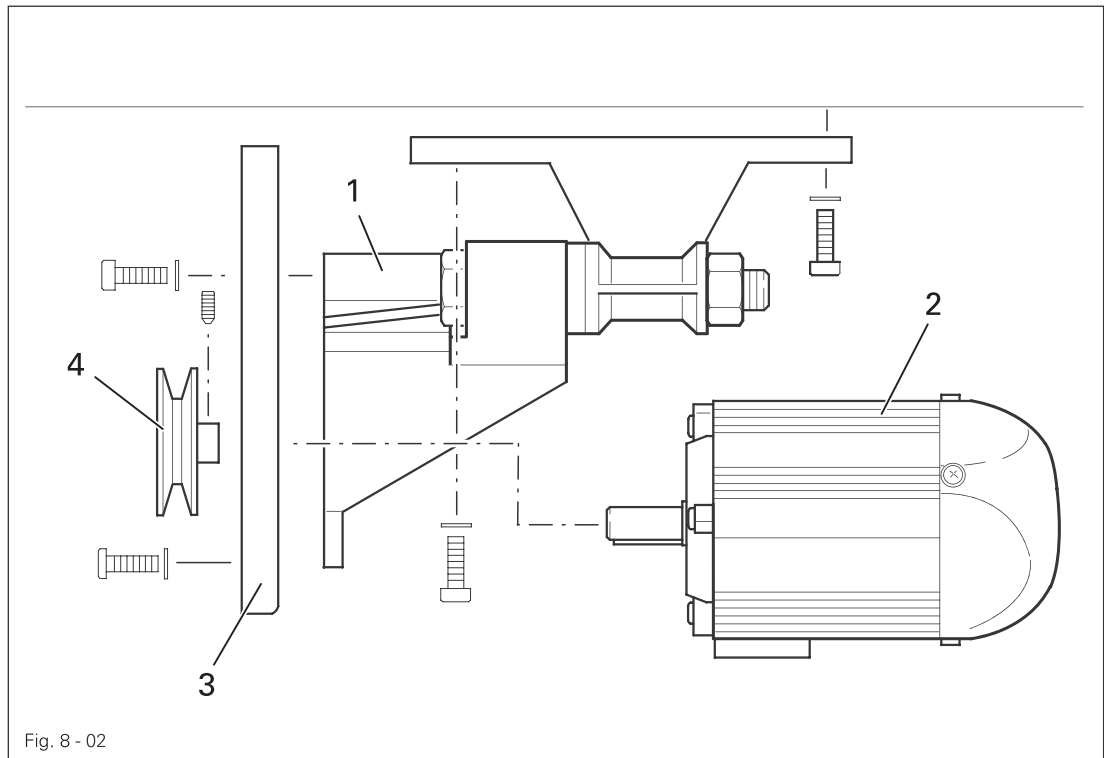
The method of packaging used requires that the table top be lowered for transport. The following is a description of how to adjust the height of the table top.

8.01.01 Adjusting the table-top height



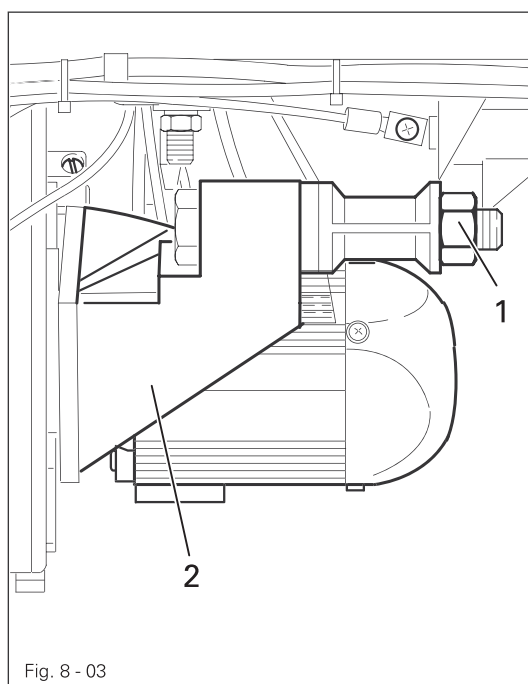
- Loosen screws 1 and 2 and set the desired table-top height
- Tighten screws 1 well.
- Adjust the position of the pedal so that you can operate it comfortably and tighten screw 2.

8.01.02 Assembling the motor (only on machines with Mauser-motor)



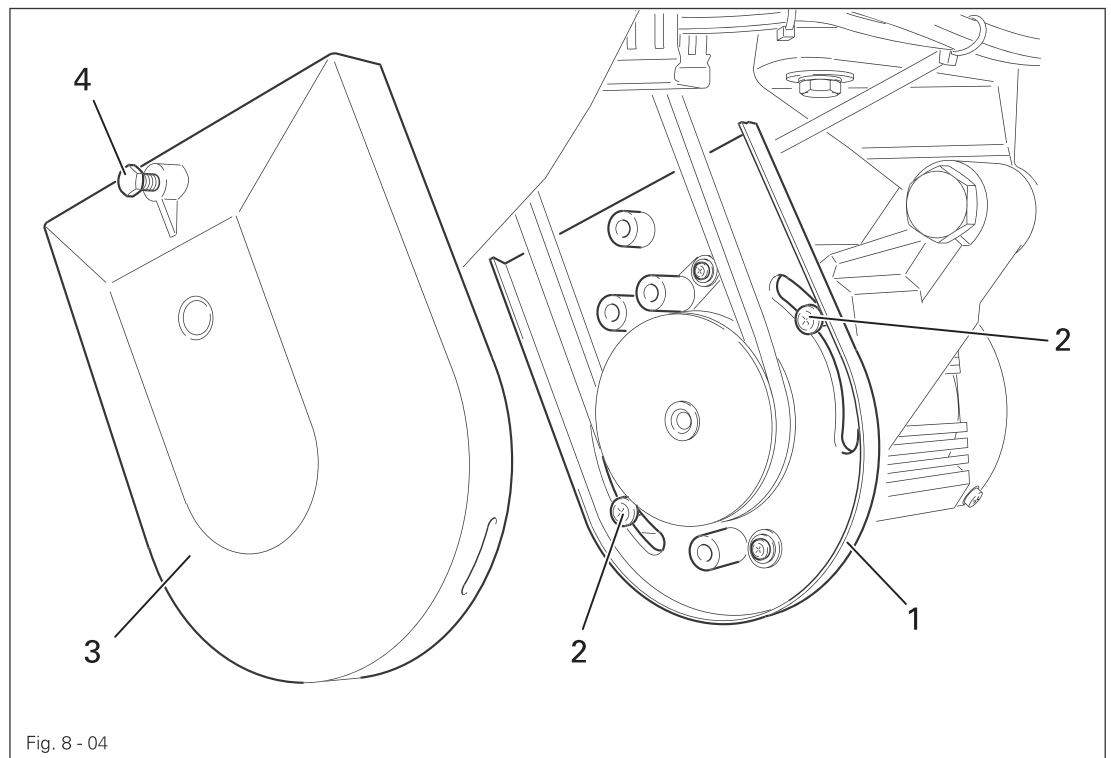
- Assemble motor mounting 1, motor 2, belt guard support 3 and belt pulley 4 as shown in Fig. 8-02.

8.01.03 Tightening the V-belt



- Fit the V-belt.
- Loosen nut 1 and tighten the V-belt by turning motor mounting 2.
- Tighten nut 1.

8.01.04 Mounting the bottom V-belt guard

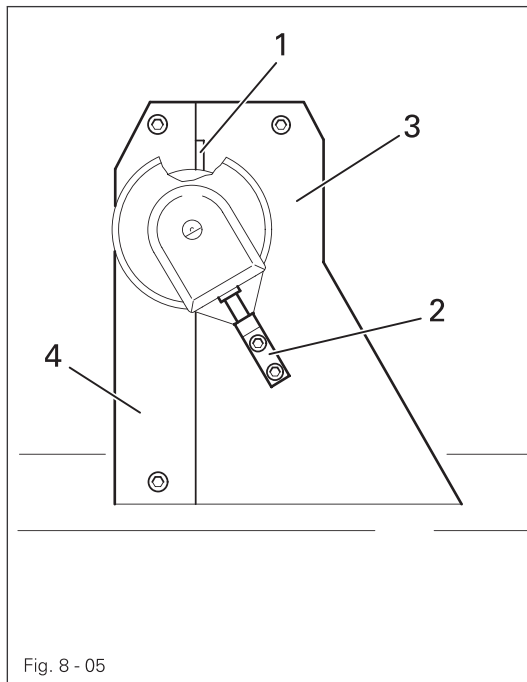


- Loosen screws 2 and adjust belt guard support 1 so that the motor pulley and V-belt run freely.
- Tighten screws 2.
- Fasten belt guard 3 with screw 4.



Fig. 8-04 shows a Mauser-motor. If a different motor is used, follow the instructions of the Motor Instruction Manual.

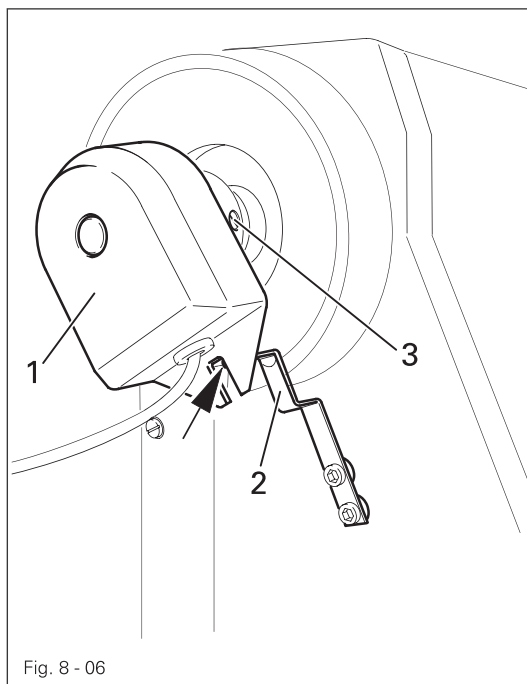
8.01.05 Mounting the upper V-belt guard



If a large balance wheel is used, the corner 1 of the belt guard 3 must be broken out.

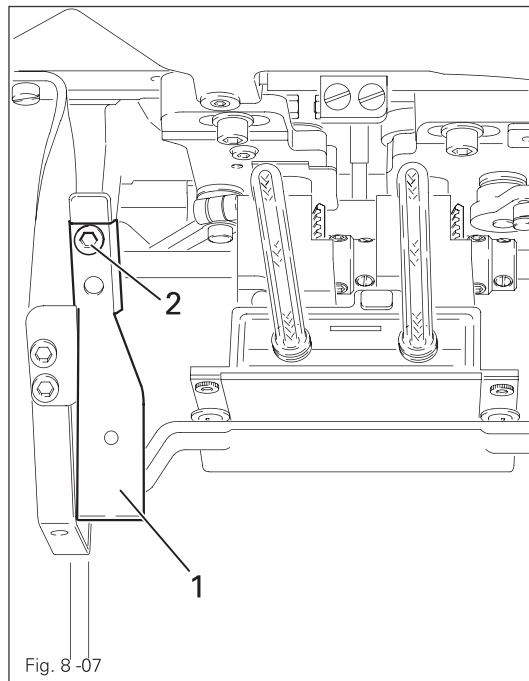
- Screw position stop 2 to the belt guard section 3.
- Attach belt guard section 3.
- Attach belt guard section 4.

8.01.06 Fitting the synchronizer



- Push synchronizer 1 onto the shaft so that stop 2 is standing in the slot on the synchronizer (see arrow)
- Tighten screws 3.
- Connect the synchronizer plug to the control box.
- Connect the synchronizer plug to the adapter (see Chapter 8.02 Connecting the plug connections and earth cables).
- Adjust the synchronizer, see Chapter 8.05 Basic position of the machine.

8.01.07 Fitting the tilt lock



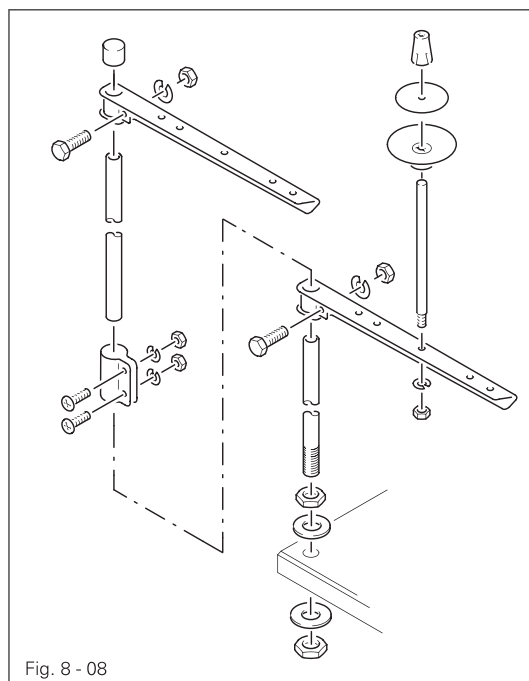
Switch off the machine!
Danger of injury due to unintentional starting of the machine!

- Screw on tilt lock 1, provided in the accessories, using screw 2.



Do not operate the machine without tilt lock 1!
Danger of crushing between sewing head and table top!

8.01.08 Fitting the reel stand



- Fit the reel stand as shown in Fig. 8 - 08.
- Afterwards insert the stand in the hole in the table top and secure it with nuts provided.



Table top mounting and circuit diagrams
(see Chapter 11)

8.02 Connecting the plug-in connections and earth cables

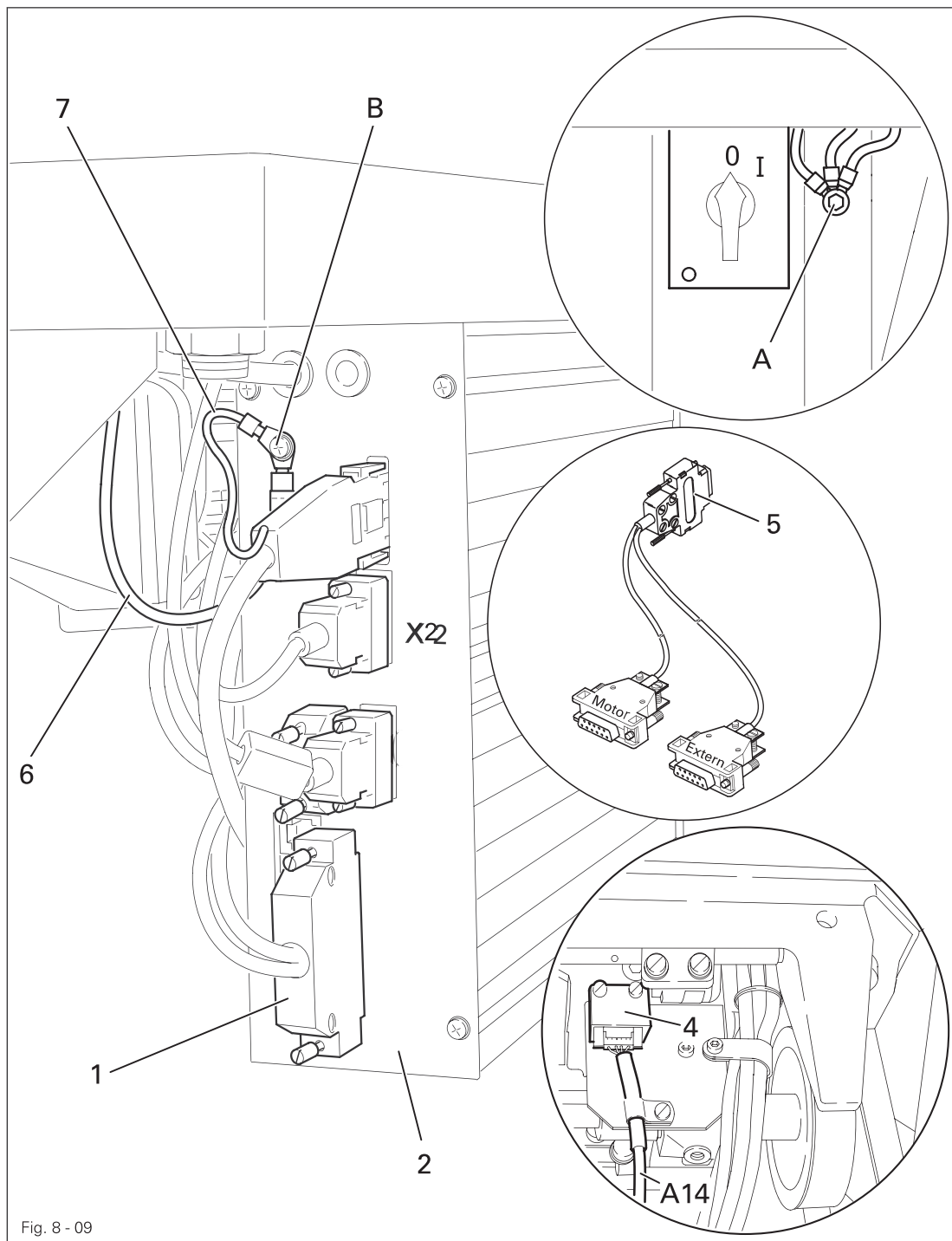


Fig. 8 - 09

- Plug adapter cable 1 into control box 2.
- Plug the cable coming from the machine to adapter cable 1 as marked.
- Plug the cable A14 coming from adapter 1 to the sewing head recognition unit 4.
- Insert plug 5 from the adapter cable to bush X 2.
- Connect the motor to the "motor" plug and the synchronizer to the "external" plug.
- Screw the earth cable from the sewing head and the main switch to earth point A.
- Connect earth point A to earth point B with earth cable 6.
- Screw the earth cable 7 from the motor to earth point B.

8.03 Commissioning

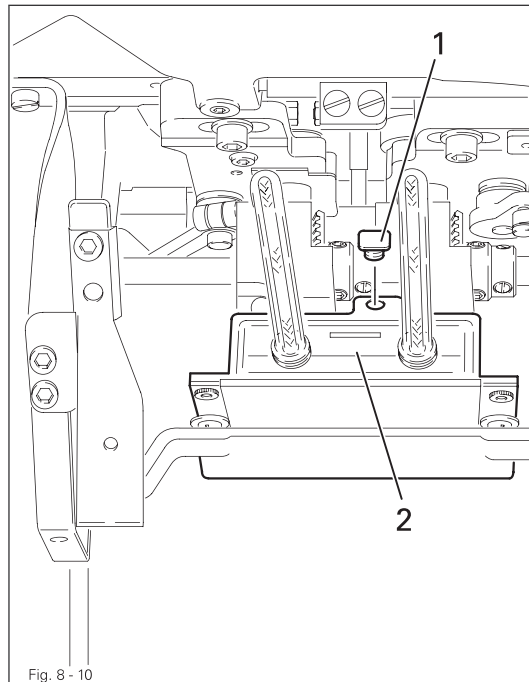


Fig. 8 - 10

- Check the machine, particularly its electrical wiring and pneumatic tube connections, for any damage.
- Remove pin 1 of the oil reservoir 2 (Fig. 8 - 10). The pin serves only to protect the machine from damage during transport and must not be used when sewing.
- Clean the machine thoroughly and oil it (see chapter 10 Care and maintenance).
- 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.



Before commissioning the machine, have specialized personnel check whether the parameter 799 (machine class) is set at "2" and the parameter 800 (sewing direction) is set at "1". If necessary, have the adjustment carried out (see Chapter 8.05 Basic position of the machine drive unit).



The machine may only be connected to an earthed socket!

- Connect the machine to the compressed air supply. When it is connected, the gauge should show a pressure of approx. 6 bar. If necessary, have this reading correctly set (see Chapter 10.08, Checking/adjusting the air pressure).

8.04 Switching the machine on/off

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

8.05 Basic position of the machine drive unit

(only on machines with Mauser-EcoDrive and control unit P40ED)

- Switch on the machine.
- Press the TE/speed key twice to select the input mode.
- Select parameter "798" by pressing the corresponding + /- key, and select service level C, see Chapter **Selecting the user level** in the instruction manual for the control panel.
- By pressing the corresponding + /- key select the parameter "799" (Selecting the machine class).
- Check whether value "2" is set, and correct it if necessary.



If the parameter has to be altered, operate the TE/Speed key and then switch off the machine and switch it on again. Then select service level C again as described above.

- By pressing the corresponding + /- key, select parameter "800" (selecting the sewing direction).
- By pressing the corresponding + /- key, select the value for the parameter at "1".
- By pressing the corresponding + /- key, select parameter "700".
- Sew a stitch by operating the pedal.
- Turn the balance wheel in the sewing direction until the descending needle is level with the top edge of the needle plate.
- Then check the parameter values listed in the parameter list (see Chapter **10.09 Parameter Settings**) and adjust them if necessary.
- Conclude the adjustment of the sewing motor by pressing the TE/Speed key.

9

Setting up



All instructions and regulations in this instruction manual must be observed.
Special attention must be given to all safety regulations!



All setting-up work must only be done by personnel with the necessary training. For all setting-up work the machine must be isolated from its power supply by turning off the on/off switch or removing the machine plug from the electric power socket!

9.01

Inserting the needle

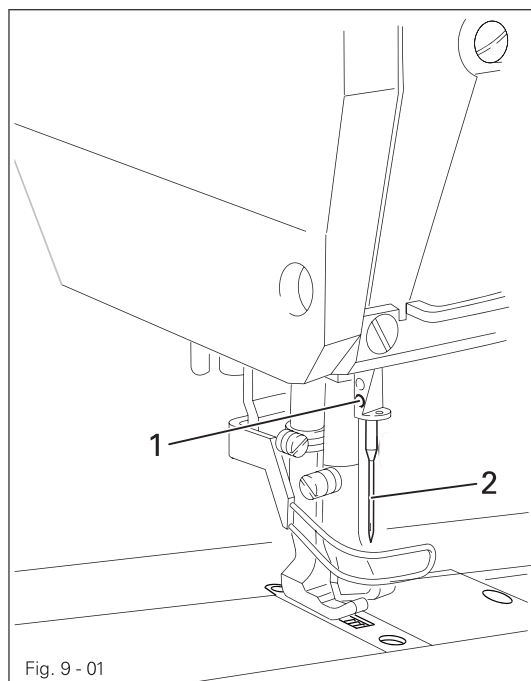


Fig. 9 - 01

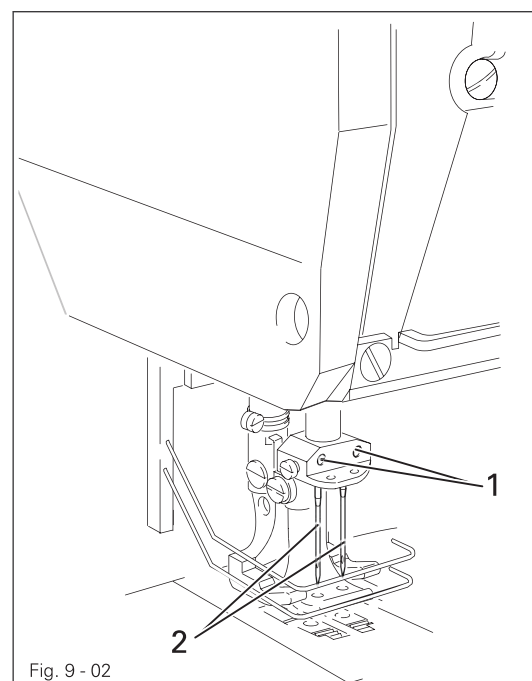


Fig. 9 - 02



Switch the machine off!
Danger due to unintentional starting of the machine!



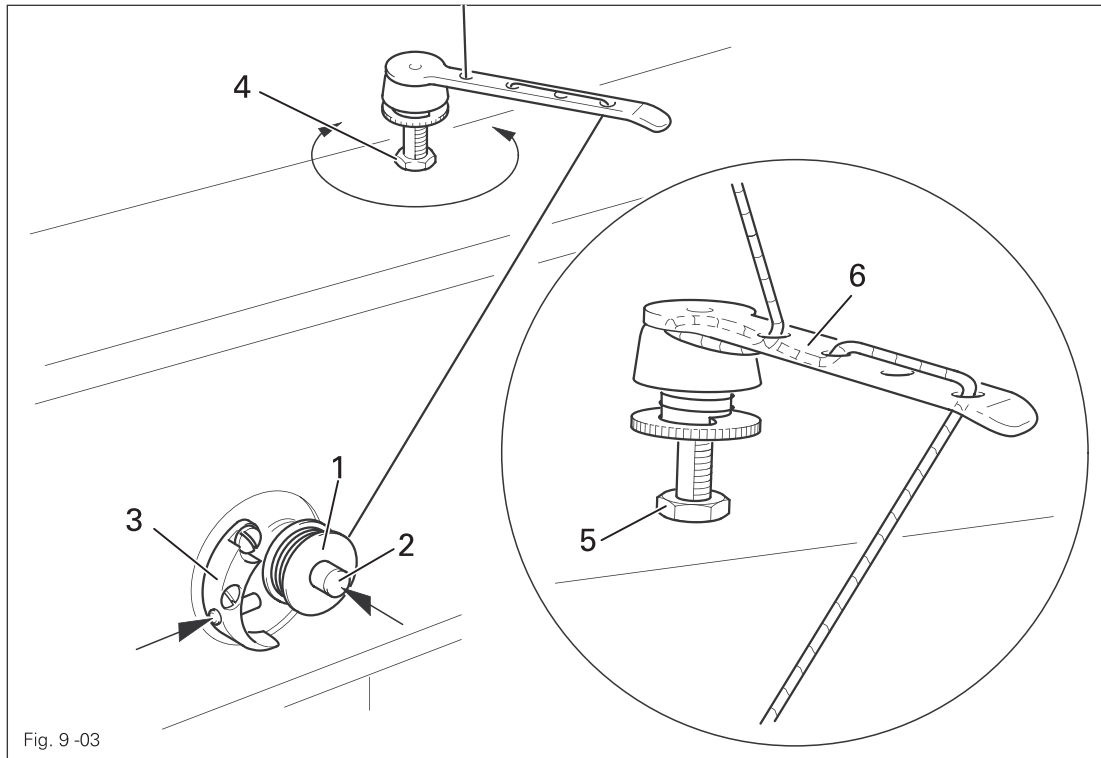
Only use needles from the system intended for the machine, see Chapter 3 Specifications.

MA 1245

- Set needle bar at top position and loosen screw 1.
- Insert the needle as far as possible (the long needle-groove must be facing left).
- Tighten needle retaining screw 1.

MA 1246

- Set needle bar at top position and loosen screws 1.
- Push needles 2 fully in (the long groove of the left needle must face to the right and that of the right needle to the left).
- Tighten screws 1 again.



- Place an empty bobbin 1 on winder spindle 1.
- Thread up as shown in Fig. 9-03 and wind the thread a few times clockwise around bobbin 1. Engage the bobbin winder by pressing spindle 2 and lever 3 simultaneously



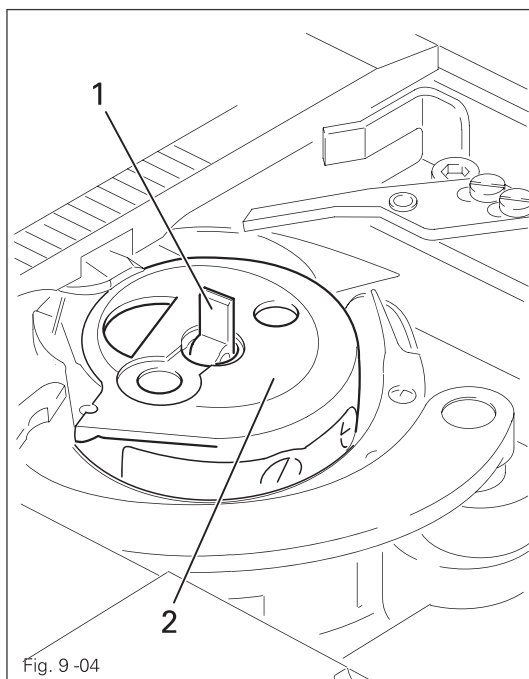
The bobbin is wound during sewing.

- The tension of the thread wound onto bobbin 1 is set on knurled screw 4.
- The bobbin winder will stop when sufficient thread is wound onto bobbin 1.

If the thread is wound on unevenly:

- Loosen nut 5.
- Turn thread guide 6 as required.
- Tighten nut 5 again.

9.03 Removing/Threading the bobbin case



Switch the machine off!
 Danger due to unintentional starting of the machine!

Removing the bobbin case:

- Open the bed slide.
- Raise latch 1 and remove bobbin case 2.

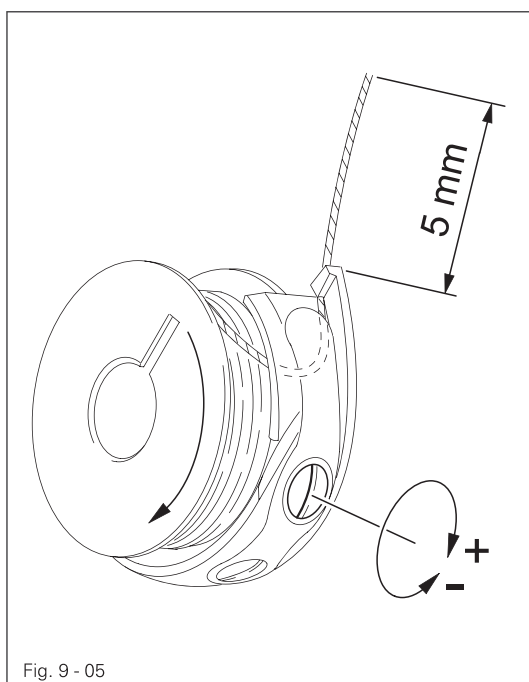
Inserting the bobbin case.

- Insert bobbin case 2 so that it clicks into place.
- Close latch 1 and close the bed slide.



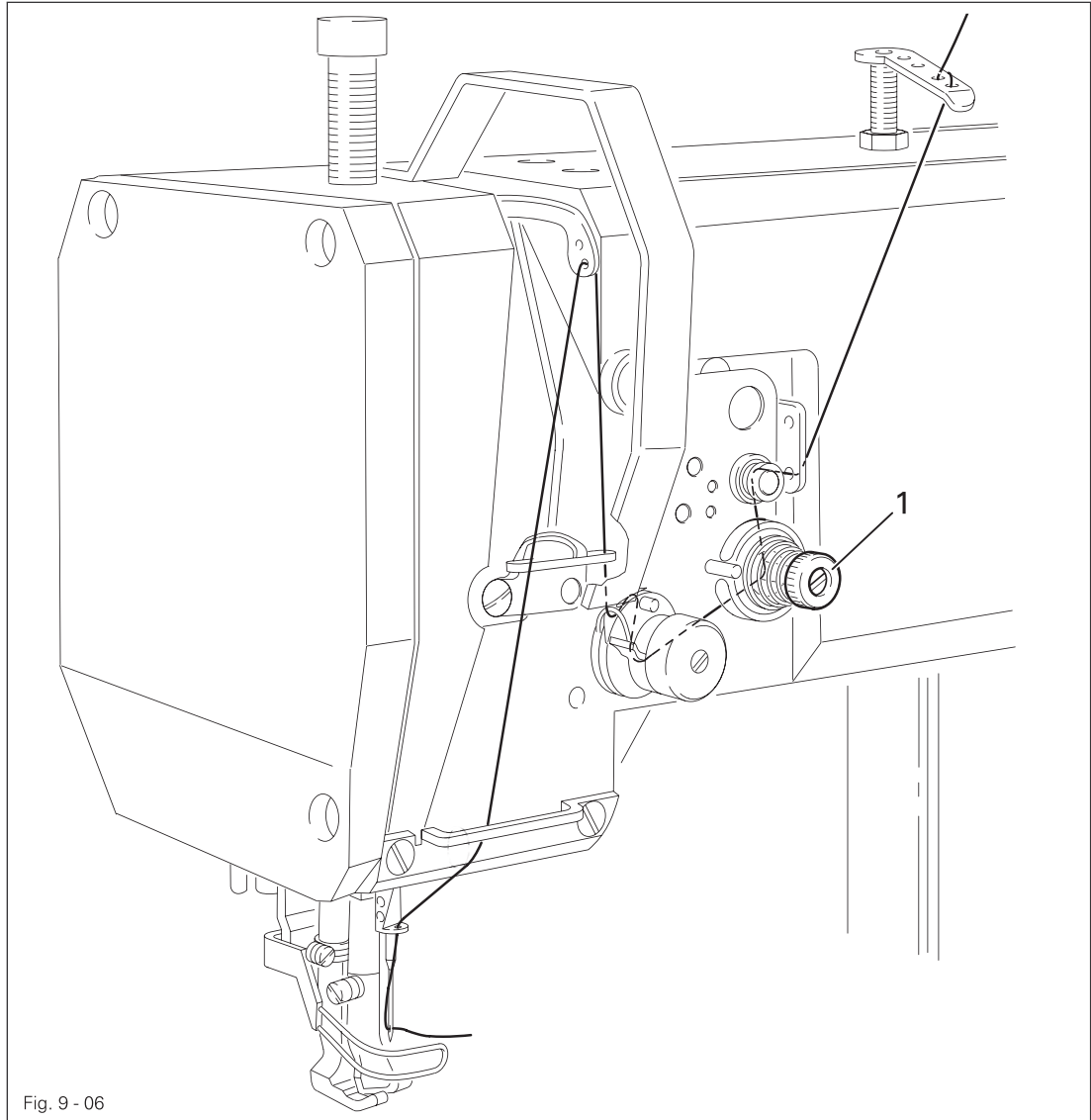
Do not operate the machine when the hook compartment cover is open!
 Danger of injury from moving parts!

9.04 Threading the bobbin thread and regulating the bobbin thread tension



Switch the machine off!
 Danger due to unintentional starting of the machine!

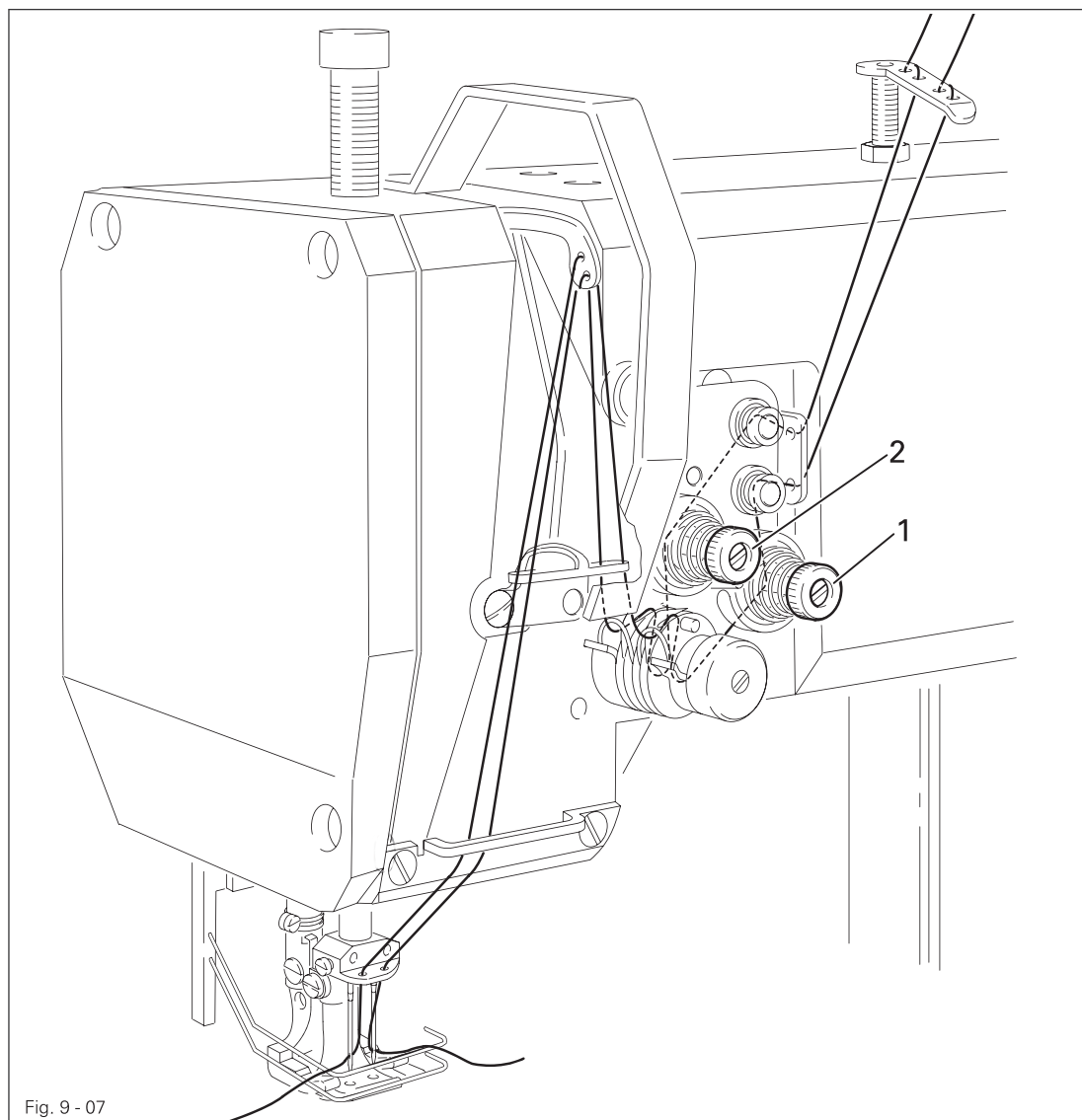
- Thread the bobbin as shown in Fig. 9-05.
- When the thread is pulled, the bobbin must rotate as shown by the arrow.
- Regulate the bobbin thread tension on screw 1.



Switch the machine off!
Danger due to unintentional starting of the machine!

- Thread the machine as shown in Fig. 9 - 06. Take note that the needle is threaded from the left (see arrow).
- Adjust the needle thread tension by turning knurled screw 1.

9.06 Threading needle thread/adjusting needle thread tension on the MA 1246



Switch the machine off!
Danger due to unintentional starting of the machine!

- Thread the machine as shown in Fig. 9 - 06. Care must be taken that the left-hand needle is threaded from the right and the right-hand needle is threaded from the left.
- Adjust the needle thread tension by turning knurled screws 1.

9.07 Adjusting the stitch counter for the bobbin thread control (only on machines with Mauser Motor and P40 (ED) control unit)

Please see the description in the separate control panel instruction manual.

10 Care and maintenance

10.01 Servicing and maintenance intervals

Clean the hook compartment	daily, more often if in continuous operation
Check the air pressure	daily before use
Check the water container of the air filter.....	daily before use
Check the hook oil-container	once a week
Clean the hook	once a week
General lubrication	twice a week
Lubricate the front parts	twice a week
Lubricate the top-feed drive eccentric	Annually



These maintenance intervals are calculated for the average running time of a single shift operation. If the machine is operated more than this, shorter intervals are recommended.

10.02 Cleaning

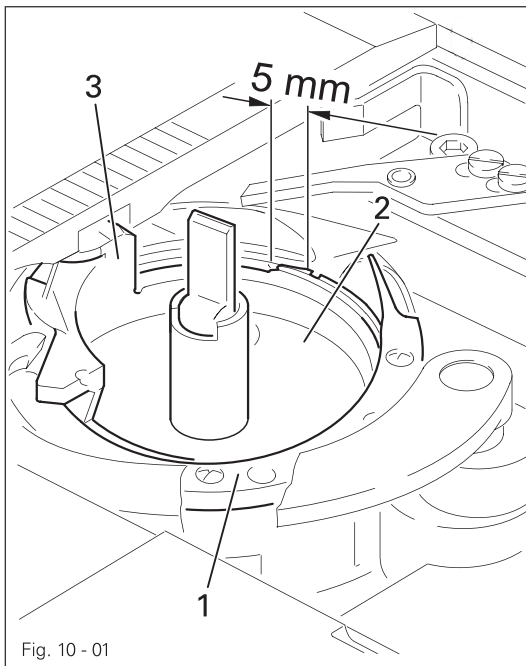


Fig. 10 - 01



Switch off the machine!
Danger of injury due to unintentional starting of the machine!

- Clean hook area with a brush daily, in continuous operation several times daily.
- Clean the hook thoroughly once a week.
- Open post cover.
- Set needle bar at its highest position.
- Remove top of bobbin case together with bobbin
- Unscrew and remove hook gib 1.
- Turn balance wheel until point of bobbin case 2 has entered into the groove of the hook race by about 5 mm.
- In this position remove bobbin case 2.
- Clean hook race with petroleum spirit.
- When inserting the bobbin case, make sure that bobbin case position finger 3 enters the slot in the needle plate.
- Screw on hook gib 1.
- Insert bobbin case and close post cover.

10.03 General lubrication

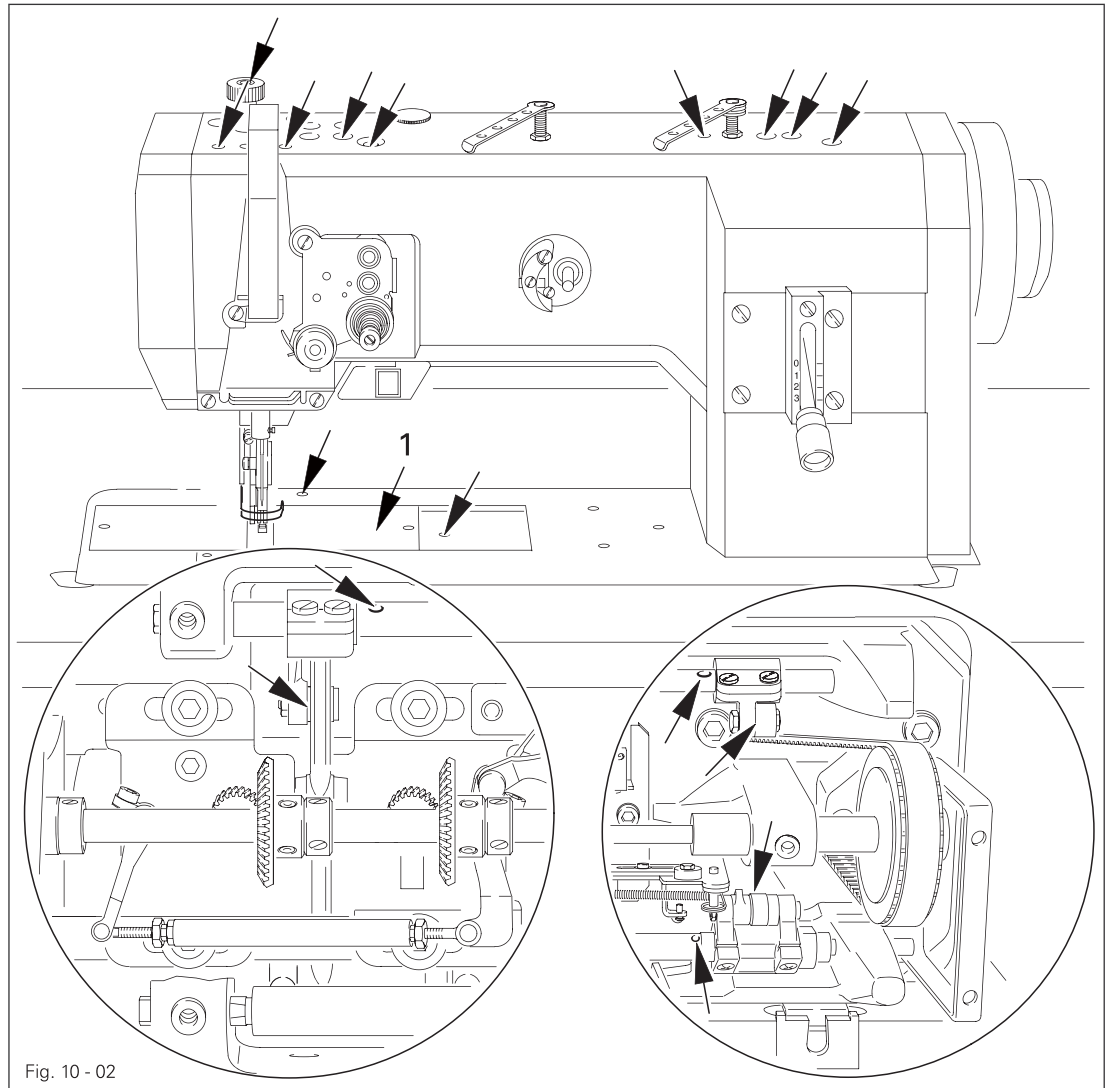


Fig. 10 - 02



Switch off the machine!
 Danger of injury due to unintentional starting of the machine!

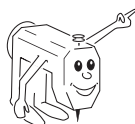


Only use oil with a medium viscosity of 22.0 mm²/s at 40° C and a density of 0.865 g/cm³ at 15° C!

- Lubricate all bearings marked in Fig. 10.02 twice a week (see arrows).
 Open the bed slide to gain access to oiling point 1.
- Tilt the machine backwards.
- Lubricate all bearings marked in Fig. 10.03 twice a week (see arrows).



Set the machine upright with both hands!
 Danger of crushing between sewing head and table!



We recommend Mauser Spezial sewing-machine oil, part No. 280-1-120 144.

10.04 Lubricating the hook

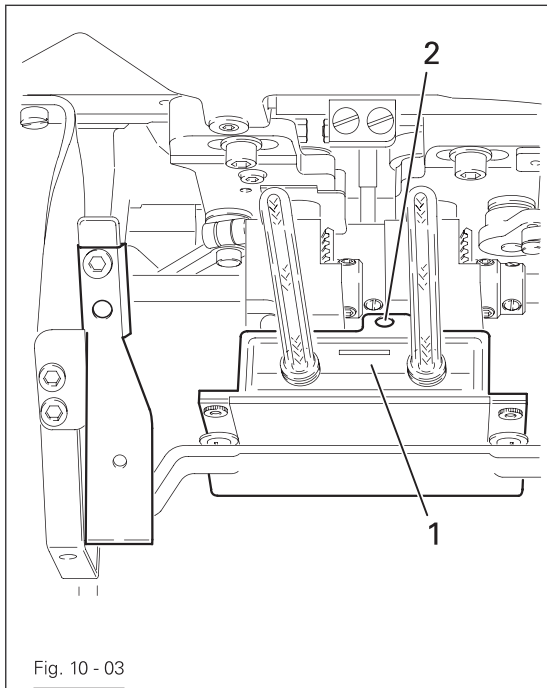


Fig. 10 - 03



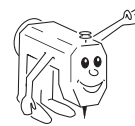
Switch off the machine!

Danger of injury due to unintentional starting of the machine!

- Tilt the machine backwards.
- Fill oil reservoir 1 through hole 2 up till the topmost marking.



Only use oil with a medium viscosity of $22.0 \text{ mm}^2/\text{s}$ at 40°C and a density of $0.865 \text{ g}/\text{cm}^3$ at 15°C !

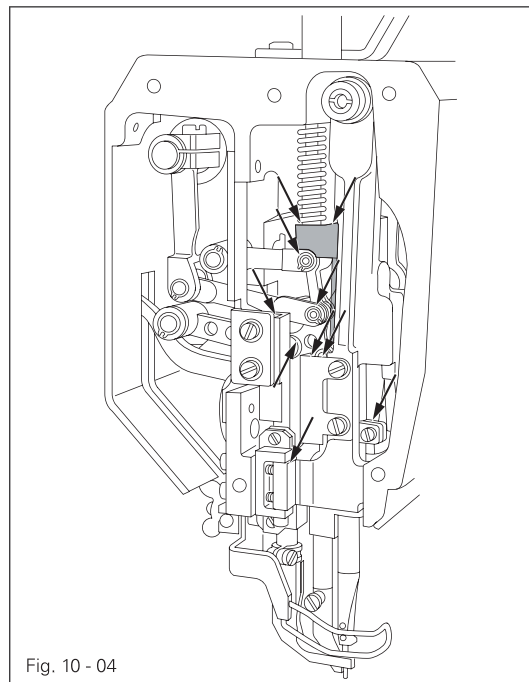


We recommend Mauser Spezial sewing-machine oil, part No. 280-1-120 144.



Use both hands to set the sewing head upright!
Danger of crushing between the sewing head and the table top!

10.05 Lubricating the head



Switch off the machine!
 Danger of injury due to unintentional starting of the machine!

- Unscrew the face plate.
- Lubricate all bearings and moving parts marked in Fig. 10 - 04 twice a week.
- Screw the face plate back on.

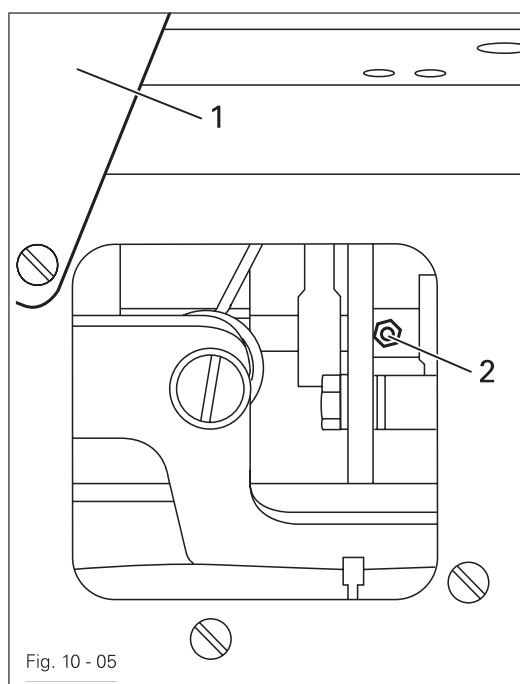


Only use oil with a medium viscosity of 22.0 mm²/s at 40° C and a density of 0.865 g/cm³ at 15° C!



We recommend Mauser Spezial sewing-machine oil, part No. 280-1-120 144.

.06 Lubricating the top-feed drive excentric

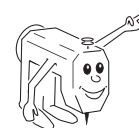


Switch off the machine!
 Danger of injury due to unintentional starting of the machine!

- Open cover 1 on the back of the machine.
- Grease nipple 2 at least once a year (use grease gun).
- Screw cover 1 back on.

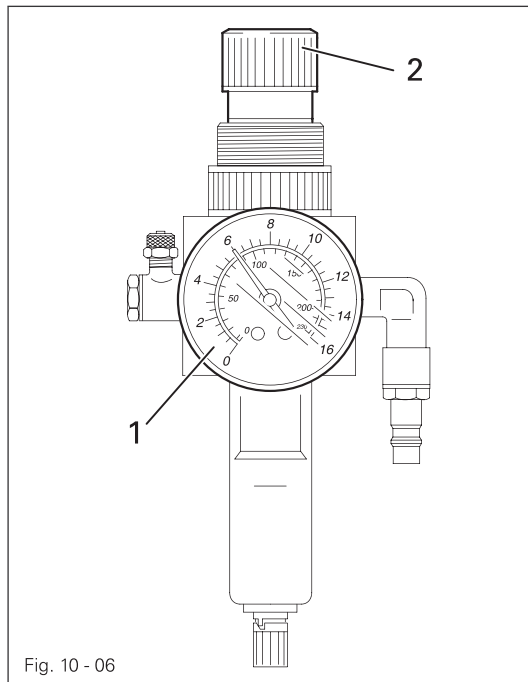


Only use lithium base grease with a dripping point of 185° C and a worked penetration of 22-25 mm at 25° C.



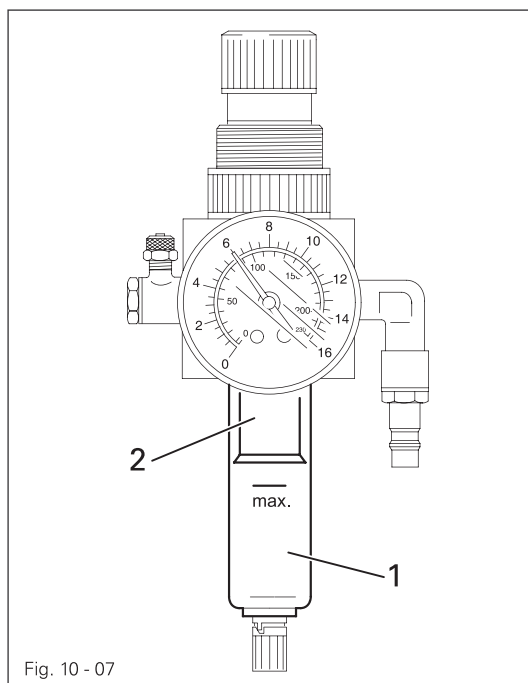
We recommend Mauser Spezial sewingmachine grease Part no. 280-1-120 247.

10.07 Checking/regulating the air pressure



- Check the air pressure on gauge 1 every time before operation.
- Gauge 1 must show a pressure of 6 bar.
- Regulate this pressure if required.
- To do so, pull knob 2 up and turn it accordingly.

10.08 Emptying/cleaning the water bowl of the air filter/regulator



Switch off the machine.
Disconnect the air hose at the
air filter/regulating unit.

Emptying the water bowl

- Water bowl 1 empties itself automatically when the air hose is disconnected from the air filter/regulator.

Cleaning the filter

- Unscrew water bowl 1 and take out filter 2.
- Clean the filter with compressed air or with isopropyl-alcohol, part number 95-665735-91.
- Screw in filter 2 and screw on water bowl 1.

10.09 Parameter settings

(only on machines with Mauser-EcoDrive and control unit P40ED)

- The selection of the user level and the alteration of parameters is described in the separate instruction manual for the drive unit.

10.09.01 Parameter list

	Parameter	Description	User level	Setting range	Set value
1	105	Speed for start backtack	B, C	300 - 2000	800
	110	Speed for end backtack	B, C	300 - 2000	1000
6	607	Speed max.	B, C	300 - 2000	▲
	609	Cutting speed 1	B, C	60 - 300	180
7	700	Needle position 0 (needle reference position)	B, C	0 - 255	*
	702	Needle position 1 (needle lowered)	B, C	0 - 255	85
	703	Needle position 2 (take-up lever raised)	B, C	0 - 255	225
	705	Needle position 5 (end cutting signal 1)	B, C	0 - 255	100
	706	Needle position 5 (start cutting signal 2)	B, C	0 - 255	85
	707	Needle position 9 (start thread tension release/start thread catcher)	B, C	0 - 255	195
	722	Acceleration ramp	B, C	0 - 255	50
	723	Brake ramp	B, C	0 - 255	40
	734	Tact output A2 (thread trimming)	B, C	001 - 009	0
	760	Multiplier for the fixed value (200) stitch count	A,B, C	0 - 250	5
799	Selected machine class	C	1-4	2	
8	800	Rotating direction of the motor	C	0-1	1
	884	Proportional sensitivity of the speed control unit	B,C	03 - 24	12
	897	Variant mini-motor, 1 = long, 2 = short	C	0-1	1
9	900	Additional P- sensitivity of the speed control unit	B,C	1 - 24	10

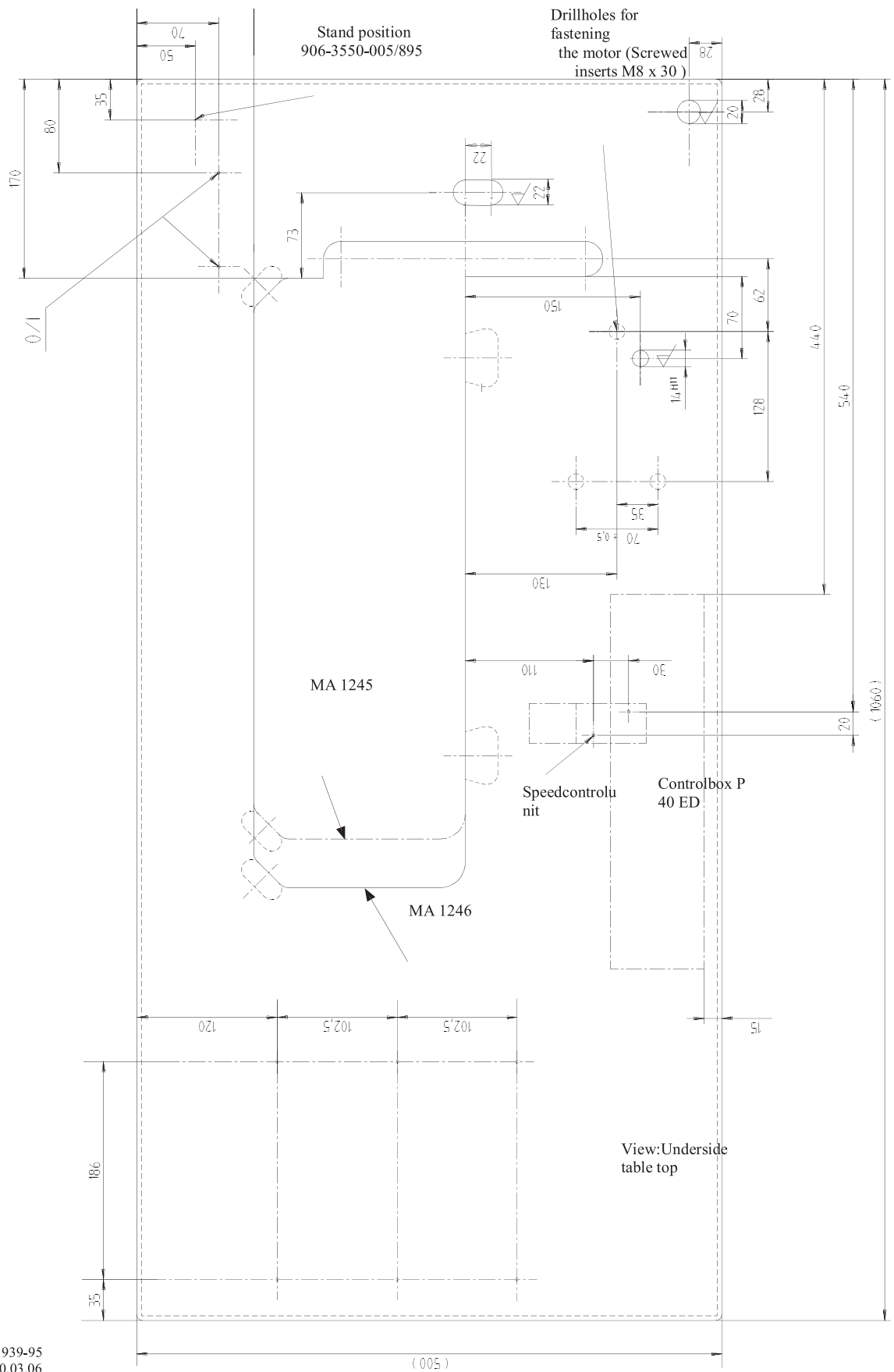
▲ See Chapter 3 Specifications

* Adjustment see Chapter 8.05 Basic position of the machine drive unit.



Further parameters and the description for an internet update of the machine software and reset /cold start of the machine can be found in the instruction manual for the control panel.

11.02 Mounting the table top

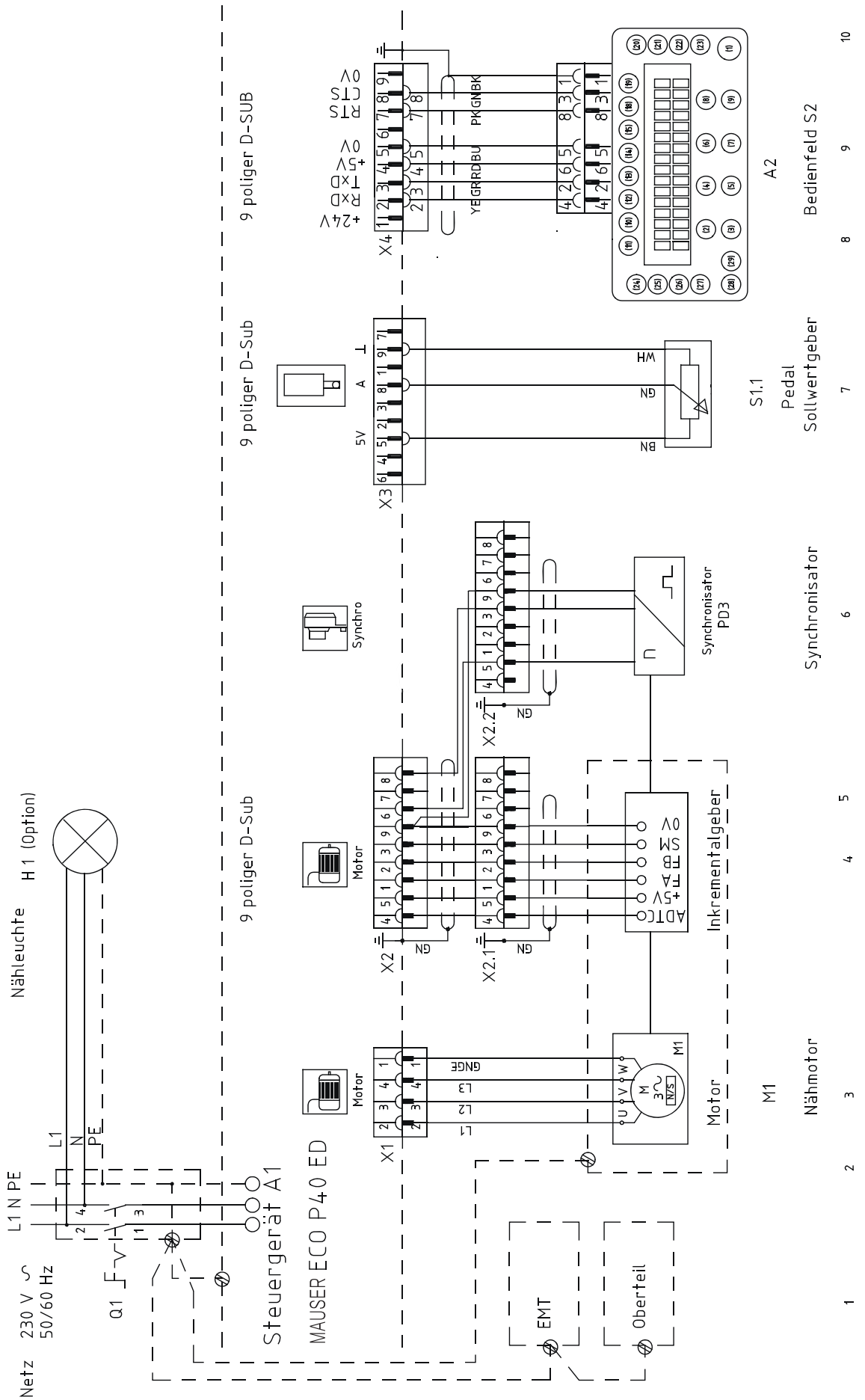


91-141 939-95
Vers. 30.03.06

11.03 Circuit diagrams

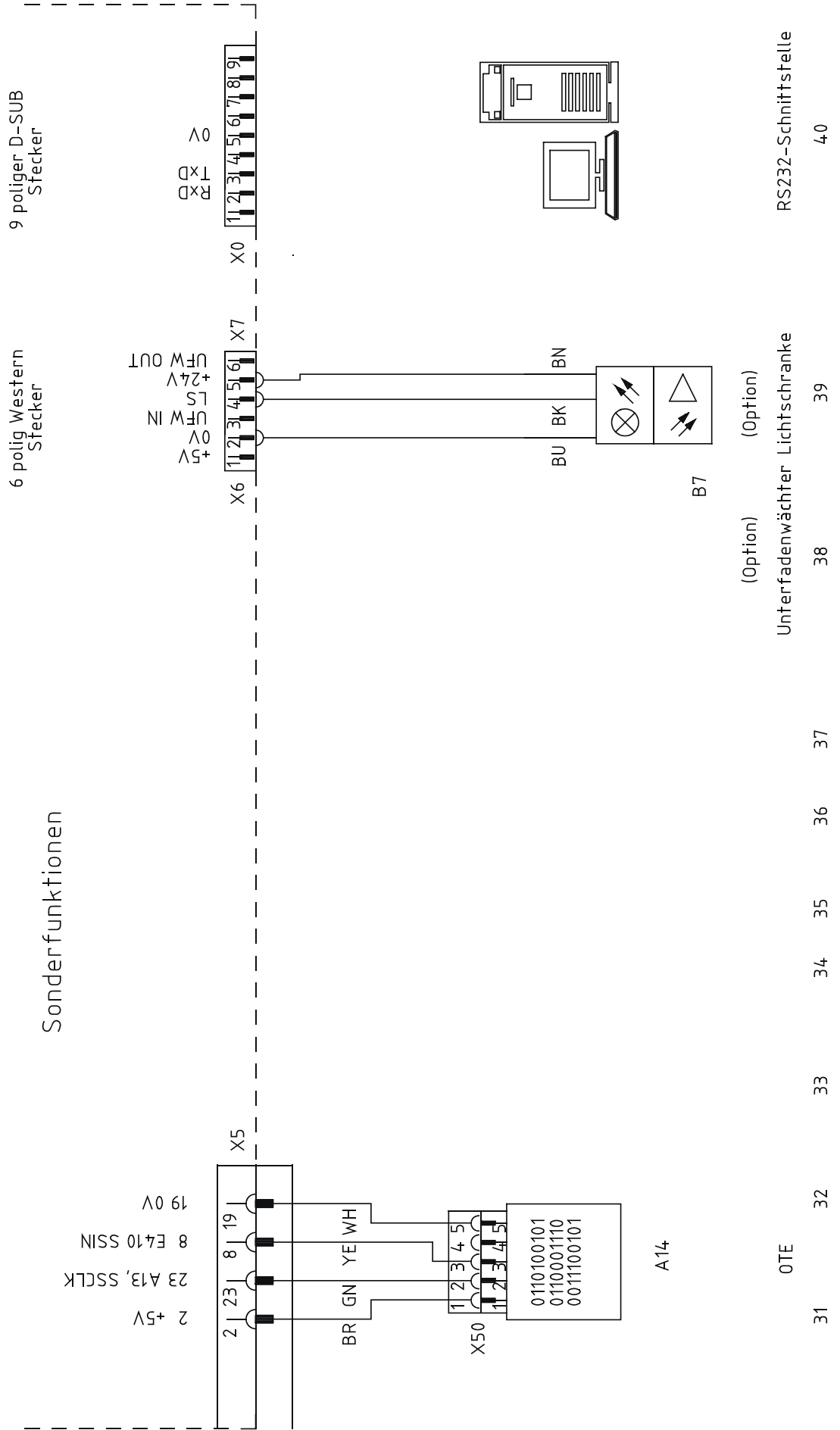
Reference list for the Circuit diagrams

A1	Control unit Mauser P40 ED
A2	Control panel BDF S2
A14	Sewing head recognition system (OTE)
H1	Sewing lamp (optional)
H10	LED stitch counter
M1	Sewing motor
Q1	Main switch
S1	Manual backtacking key
S1.1	Pedal speed control unit
S2	Needle position change key
S3	Single stitch key
S6	Start inhibitor (E6 stop)
X0	PC-interface (RS 232)
X1	Motor
X2	Incremental transducer
X2.1	Incremental transmitter adapter
X2.2	Synchronizer adapter
X2.3	Y5-911/.. backtacking device
X3	Speed control unit
X3.1	Y2-900/.. thread trimmer (FS)
X4	A2 control panel plug BDF S2
X4.1	Y4 -910/.. automatic foot lift
X5	Out-/input
X6	Bobbin thread monitor (optional)
X6.1	Y8 Thread tension release
X7	Photoelectric barrier (optional)
X22	Y2 -900/.. thread trimmer (FS)
X24	Y4 -910/.. automatic foot lift
X25	Y5 -911/.. backtacking device
X28	Y8 Thread tension release
X40	S1-3 Control panel
X50	A14 Sewing head recognition system (OTE)
Y2	-900/.. thread trimmer
Y4	-910/.. automatic foot lift
Y5	-911/.. backtacking device
Y8	Thread tension release



Steuergerät A1 MAUSER P40 ED

Sonderfunktionen

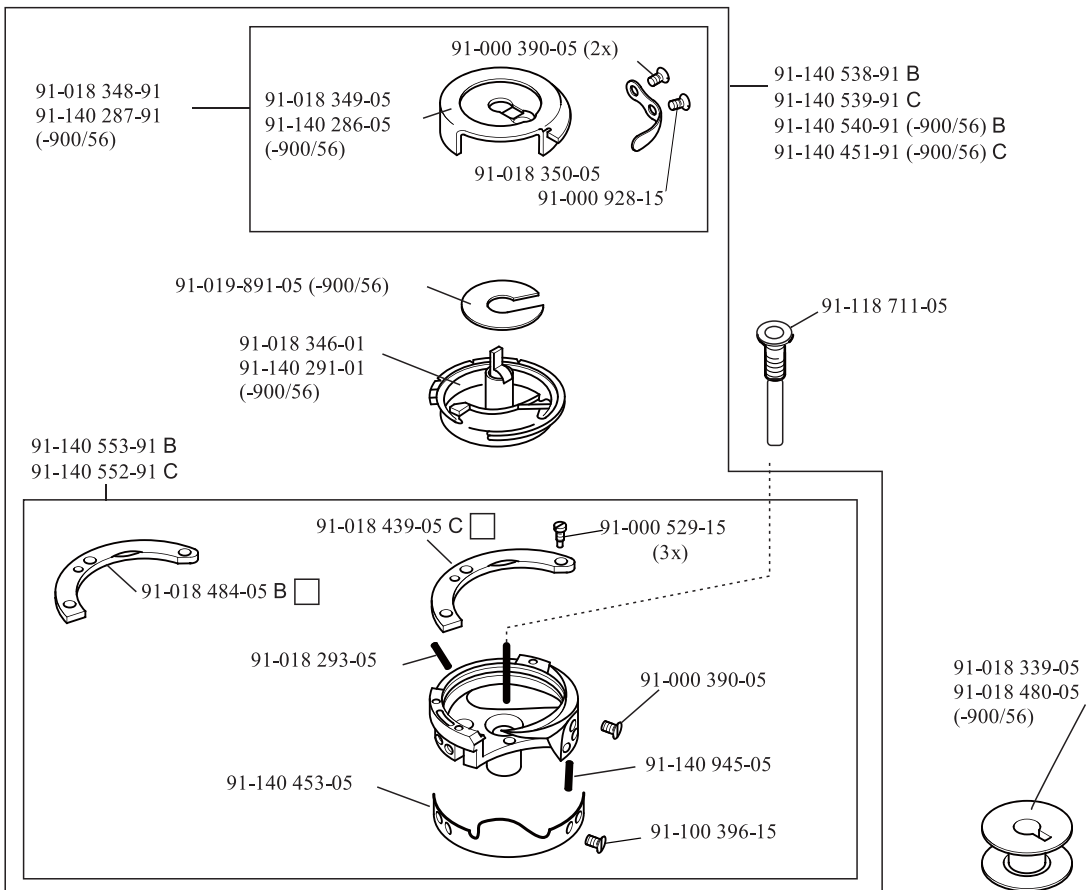
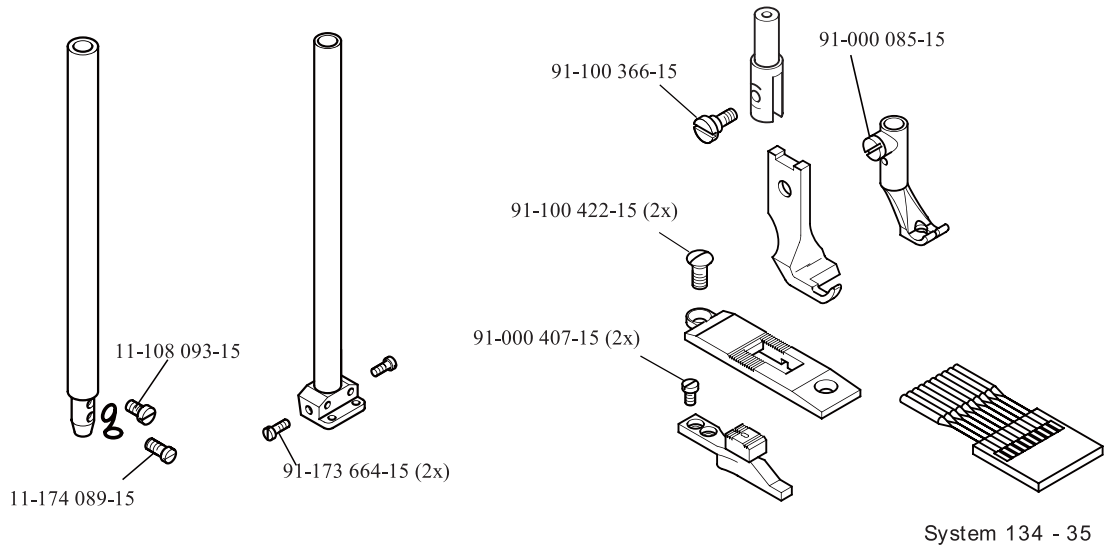


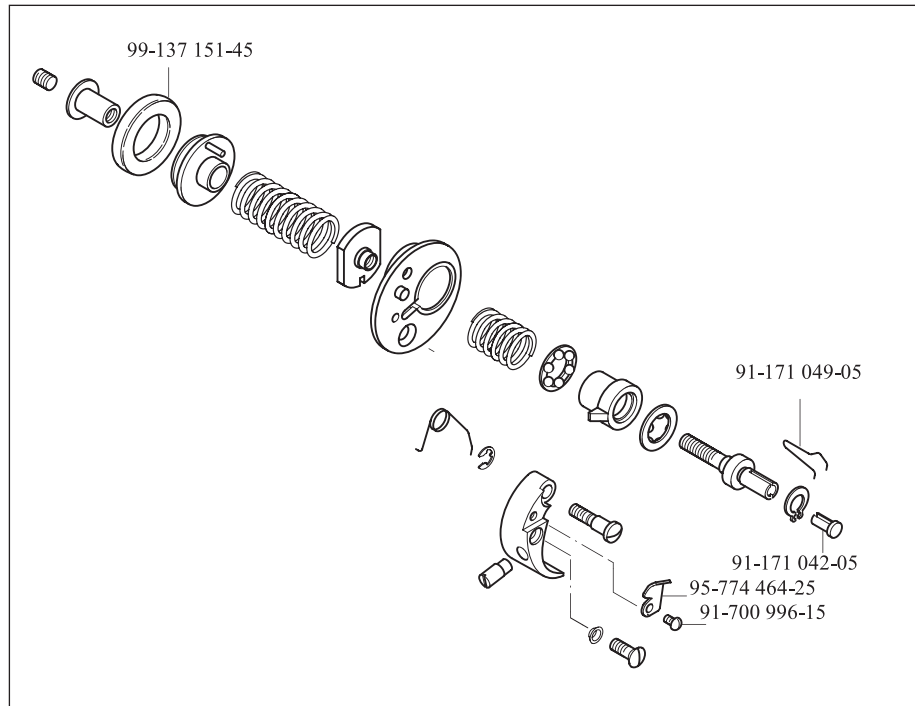
This is a list of the most important wearing parts.

A detailed parts list for the complete machine is included with the accessories.
In case of loss, the parts list can be downloaded from the internet address
www.mauser-spezial.com

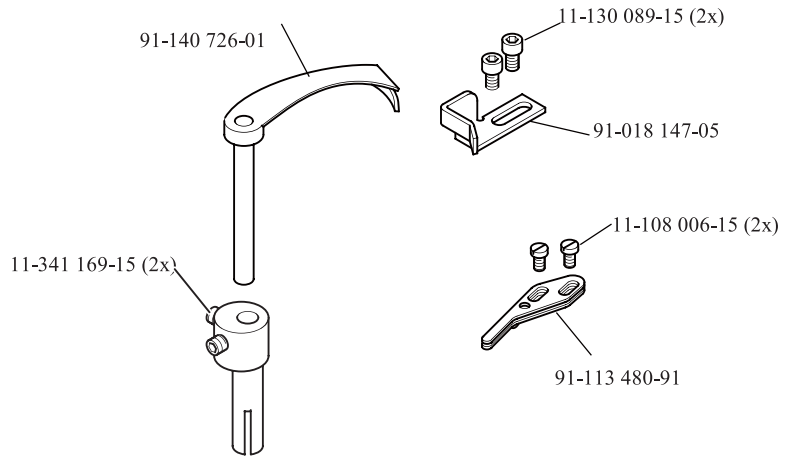


As an alternative to the internet download the parts lists can also be ordered in book form under part no. 296-12-18 598 .

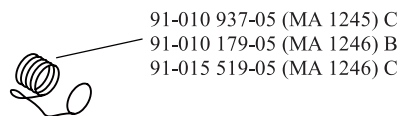




Subclass -900/56



MA 1245; 1246



MA 1245-900/56; 1246-900/56





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