

For the professional user

Mechanic's Instructions

Für den professionellen Anwender

Mechanikeranleitung

Class:	141-23EV	Ausf. 10
<i>Klasse:</i>	141-30	Ausf. 6
	141-40	Ausf. 7
Model:	141-50	Ausf. 3
<i>Ausführung:</i>	142-30	Ausf. 6
	142-40	Ausf. 5
Machine number:	142-40	Ausf. 5
<i>Maschinen-Nr.:</i>		

Dated:
Stand:

The sign of quality



You find the Strobel trademark on every Strobel machine leaving our works. And with good reason. This symbol is a guarantee of the high quality of our products. Quality which creates trust – trust in our technology, our service and, not least of all, in our good name.

Im Zeichen der Qualität

Sie finden die Strobel-Schutzmarke auf jeder Strobel-Maschine, die unser Werk verlässt. Und das aus gutem Grund. Denn dieses Zeichen garantiert Ihnen die hohe Qualität unserer Produkte. Qualität, die Vertrauen schafft – in unsere Technik, unseren Service und nicht zuletzt in unseren guten Namen.

Strobel clients know that they can expect a particularly high standard of performance from our company and our machines. Now you have settled for one of our products. For us this is a source of encouragement and of obligation to Justify your trust.

If you wish to profit from the performance and efficiency of your Strobel machine as long as possible, exact handling and thorough care is necessary. For this reason we kindly request that you read the operating instructions closely. It provides all the information you need for trouble free operation.

And if you do happen to need a spare part the enclosed spare parts list gives a complete overview. It is clearly classified according to components so that you can find the required part quickly and easily. In order to avoid errors we request you to quote machine class, machine number and part number completely on your spare part order.

We wish you lots of success in your work with your new Strobel machine.

STROBEL
Spezialmaschinen GmbH

Mechanic's instructions **STROBEL Classes 141-23EV, -30, -40, -50, 142-30, -40**

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Circuit diagrams

Connecting the sewing machine:

259.00.16	Pneumatic circuit diagram Cl. 142
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Connecting digital display:

258.21.27	Electric connection diagram Cl. 141 – digital display
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Subject to change without prior notice

STROBEL

1 General notes on safety

The non-compliance with the following notes on safety can lead to bodily injuries or to damages of the machine.

1. The machine must only be operated by persons familiar with the relevant operating instructions and who have been instructed accordingly.
2. Before commissioning also read the notes on safety and the operating instructions of the sewing drive manufacturer.
3. The machine must only be operated according to its designation and not without the appropriate guards; all explicit safety regulations must also be observed.
4. For threading, for changing the reels, for exchanging sewing tools such as needles, grippers, stitch plate, transport devices, if necessary cutter and cutting block, for cleaning, when leaving the workplace and for maintenance work, switch off main switch or pull mains plug. With a mechanically operated coupling motor without activation lock, wait until the motor has stopped.
5. General maintenance work must only be carried out by appropriately instructed persons in accordance with the operating instructions.
6. Repair, modification and maintenance work must only be carried out by qualified staff or by appropriately instructed persons.
7. During maintenance and repair work at pneumatic devices, the machine must be disconnected from the pneumatic supply network. Exceptions are only admissible during adjusting work and function test by appropriately instructed qualified staff.
8. Work at the electrical equipment must only be carried out by qualified staff.
9. Work at parts and devices under voltage is not allowed. Exceptions are regulated by the regulation EN50110 (DIN VDE0105).
10. Modification or alteration at the machine must only be undertaken under consideration of all explicit safety regulations.
11. Only spare parts released by us for use are to be used during repairs.
12. The commissioning of the upper part is prohibited until it has been determined that the entire sewing unit complies with the regulations of the EC guidelines.

13. Warning notes in the operating instructions of the machine, which point out special points of danger, are marked at the appropriate positions with the safety symbol.



Warning notes in the operating instructions of the machine which point out special dangers of injury for operating or qualified staff, are marked at the appropriate positions with the symbol



It is essential that you observe and follow these notes as well as the generally valid safety regulations.

2 General

2.1 Operating instructions

Any person involved in the installation, operation, maintenance and repair of the machine must have read and understood the operating instructions and mainly the safety instructions before starting the machine. Please open the illustrations at the beginning of these operating instructions, so you can follow the illustrations step by step while reading the instructions.

2.2 Class identification, serial number and orientation of the machine

The operating side of the machine is the basis for descriptions referring to sides. The class identification (type) as well as serial and model number (after the dash) are located below the left handwheel. These data are also shown on the front page of the operation instructions.

2.3 Range of application and intended use

Class 141-23EV

Single Thread Overseaming Machine with gathering device for sewing insoles to uppers of heavy weight textile and leather shoes up to total thickness of 7 mm.

With appropriate optional features also suitable for "string lasting" and California processing.

Class 141-30

Single Thread Overseaming Machine for sewing fur facings, heavy furs such as lambskin, imitated furs and polishing wheels.

Class 141-40

High Speed Single Thread Overseaming Machine for fine fur stranding (let-out) and general sewing operations.

Class 141-50

High Speed Single Thread Overseaming Machine for very fine stranding (let-out) operations at fur.

Class 142-30

Two Thread Cup Seaming Machine for sewing and overedging soft rubber foam. Material thickness compressed state up to 4 mm. Also suitable for clothing quilts and for decorative stitches of fur and leather garments.

Special version Class 142-30N

Two Thread Cup Seaming Machine for sewing of coated material for diving and surfing suits (e.g. neoprene) for material thickness of 4 – 7 mm.

Class 142-40

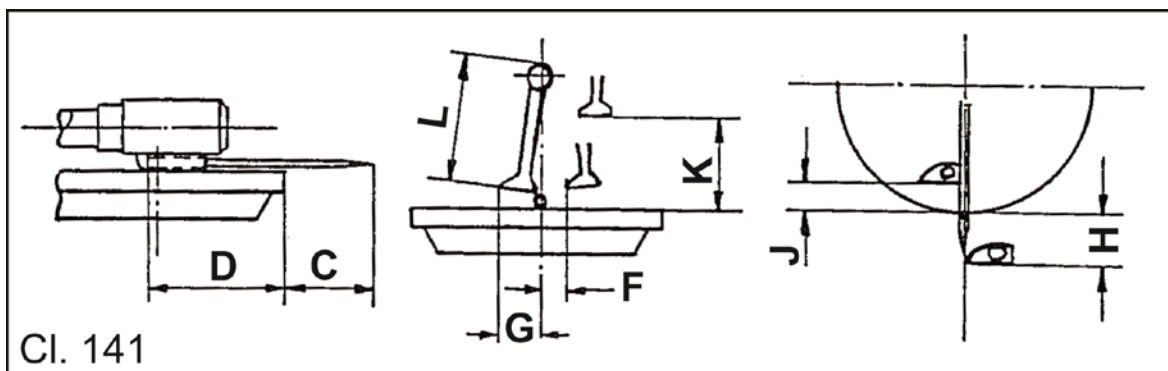
Two Thread Cup Seaming Machine for sewing and overedging soft rubber foam. Material thickness compressed state up to 2 mm. Also suitable for clothing quilts and for decorative stitches of fur and leather garments.

2.4 Technical Data

	141-23EV	141-30	141-40	141-50	142-30	142-30N	142-40
Number of stitches Max mechanically admissible min ⁻¹ Recommended rated speed min ⁻¹	2300 1800	2800 2300	4200 3600		2800 2300		2800 2400
Machine pulley diameter Machine	dw 80						
V-belt profile	10 x 6 mm						
Stitch length (adjustable in mm)	3 - 6.5	3 - 6	0.6 - 2.5		3 - 6		1 - 4
Kind of stitch: Overseam	Single thread				Two thread		
Needle system	134	459R			1738		
Needle size	140	110 - 130	40 - 120		90, 100		55
Recommended thread	Twisted Polyester filament						
Recommended thread size	40 - 20	50 - 10	130 - 80 40 - 10		40 - 20		120/2
Stitch type	501				502		
Kind of feed	Back plate transport						
Pneumatic connection	10 bar						
Operating pressure	5 - 6 bar						
Required space	0.6 x 1.06 m						
Noise: Average noise level at a speed of number of stitches n min ⁻¹	LpAm 73 dB 1800	LpAm 84 dB 2300	LpAm 85 dB 3200		LpAm 76 dB 2300		

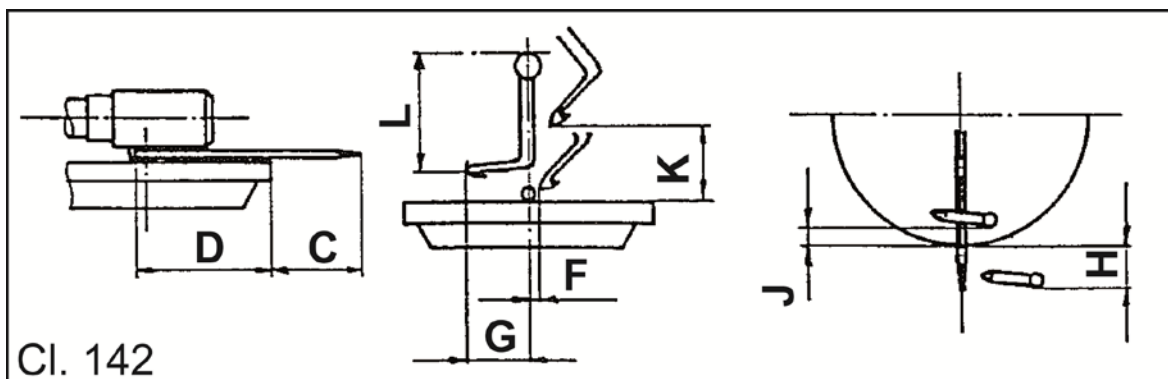
2.5 Brief setting instructions

Setting data Class		141-23EV	141-30	141-40	141-50	142-30 142-30N	142-40
A	Stitch length	3 - 6.5	3 - 6	0.7 - 2.7	0.6 - 2.5	2.3 – 5.3	1 - 4
B	Stroke of loop	4.7	4.5 - 5	3.5	3.5	4.2	4.5
C	Needle point front measured from cup edge	22.6	20.5	18.5	16.8	18.8	17
L	Looper height inclusive shaft	37	30.5	31.5	30.8	28.3	31
H	Looper front position measured from cup edge	11.5	8.2	7.5	5.5	11.5	9.7
K	Looper movement	9.5	9	5.3	4.8	8.2	6.7
H + J	Total looper travel	17.7	12.7	11	10.1	12.5	11.3
F	Looper movement to the right from needle center to looper point	5.5	3	4.2	3.2	2.8	5.9



Einstellwerte_07en

The clearance between the feed cups amount 12 – 14 mm.



Einstellwerte_08en

3 Disassemble the machine

3.1 Disassemble the main shaft (Fig. 1 and Fig. 2)

Before disassembling the main shaft, it is advisable to mark the exact position of each part or screw, and to take the measures of both bearing support blocks by means of a gauge, measuring from the front edge of the machine column. (Measures a + b).

This will save you a lot of time when you assemble and adjust the machine. (Fig. 1)

Not until now should the screws of the parts attached to the shaft be loosened and the right handwheel be removed and the shaft, too, be pushed out to the left by a withdrawal device.

Loosen the screws of the parts. Take off the right hand wheel. Pull the shaft about 20 to 30 mm to the left and remove the remaining glue without displacing the ball bearings. Then take off shaft.

The left handwheel with the stitch-regulating eccentric bolt does not need to be removed. **Be sure** that the set screws 176.0632 located on both sides of the regulating eccentric bolt (A) 132.0074 are removed; on machines that were built before 1986, the screws 176.0620, 176.0619, and the setbolts 135.0078. (Fig. 1 and Fig. 2)

NOTE! If not done yet, mark the position of guide disc 153.0031 and regulating eccentric 132.0074.

The remaining glue can easily be removed from the shaft by using a cleanser, e. g. Clorothene.

Fig. 1

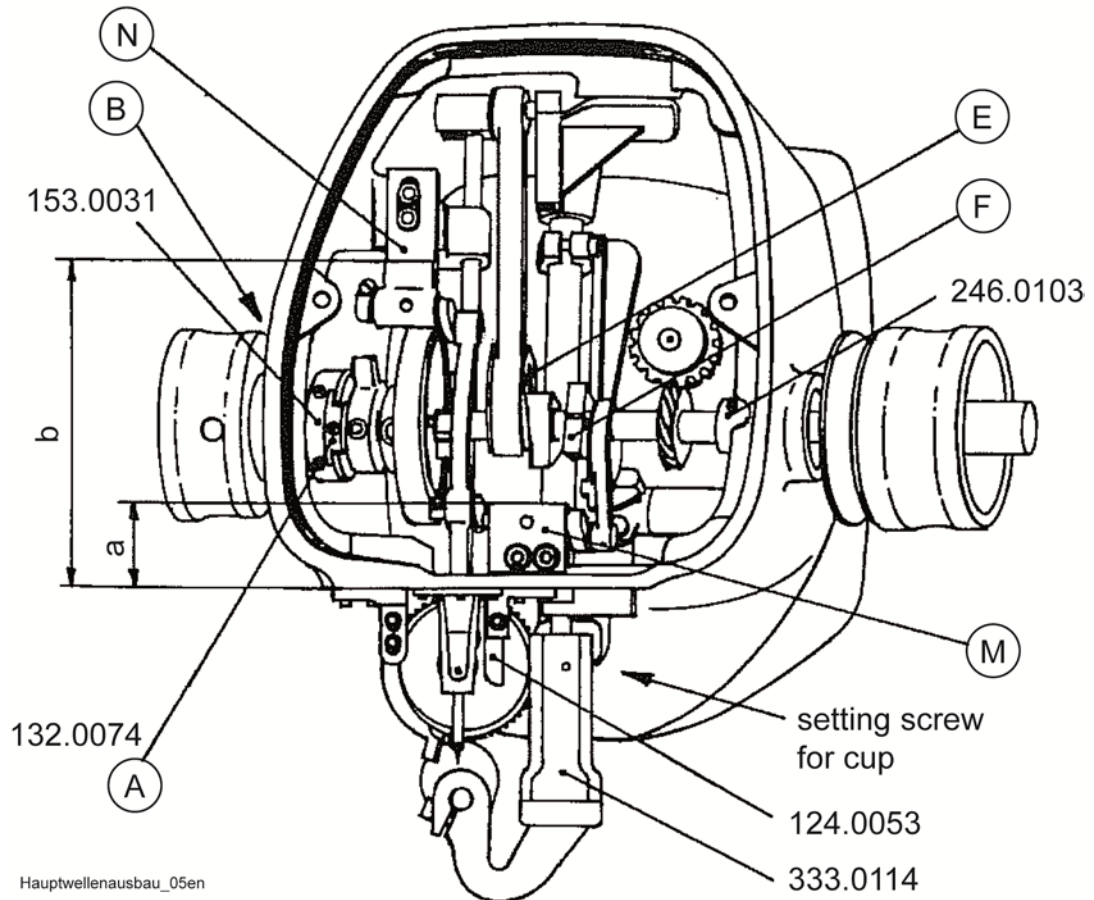
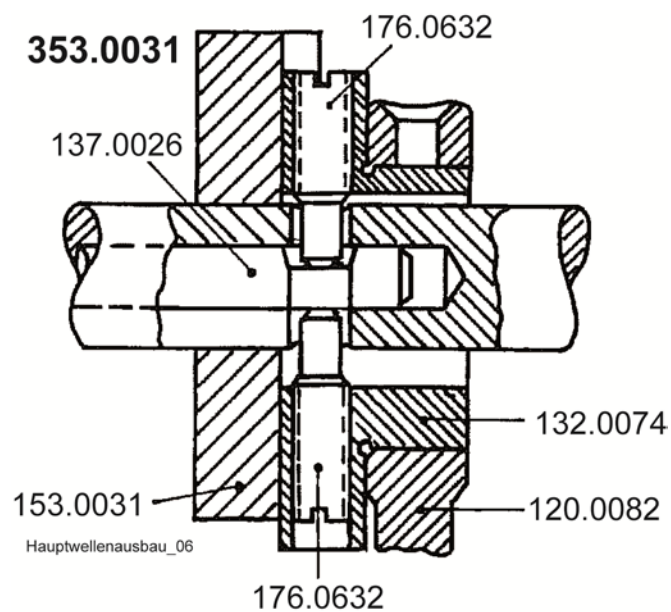


Fig. 2



4 Assemble the Machine

4.1 Mount the shaft (Fig. 1)

First, remove any grease from the shaft. Mount the parts in correct order onto the shaft and put it into the machine column so that it sticks out about 30 mm on the left. Then put a drop of “Loctite” on either end of the shaft, that is, on the left end sticking out from the column, and on the ball bearing on the right. (Loctite, Kapillar 290)

NOTE! The surfaces to be joined must be absolutely clean. Only then you may fit the shaft completely into the machine column. Turn it slightly, so that the glue on the ball bearing is evenly absorbed. Fix stitch regulating eccentric (A) (fig.1). See chapter “4.2 Mount stitch regulating eccentric 353.0031”. Push the shaft to the left up to the stop, and fasten setting ring 246.0103 on the right of the shaft in order to eliminate any axial play.

About an hour later when the glue (Loctite, Kapillar 260) is hard, you may continue to assemble and adjust the machine. When assembling after a repair, it is not necessary to take off the left hand wheel.

4.2 Mount stitch regulating eccentric 353.0031

Fit the left handwheel onto the shaft so that the first screw in direction of sewing fits into the drill hole on the left of the shaft and point upwards.

Turn guide disc 153.0031 so that you can easily slide down set eccentric 132.0074. Then screw the first screw 176.0632 into the regulating eccentric, but ensure that regulating bolt 137.0026 can still freely be turned in the shaft. Then turn hand wheel with shaft by 180 degrees. Screw second screw 176.0532 into the regulating eccentric right to the stop. Fasten guide disc 153.0031.

Push the shaft to the left up to the ball bearing, slide set collar 246.0103 on the right shaft side all the way to the ball bearings, and tighten. The shaft is now fastened.

Let stitch-regulating eccentric 137.0014 level out and tighten.

Fix two lubricated springs 161.0063 and bolts 135.0062 into the drill hole of the hand wheel (Fig. 2, Fig. 3 und Fig. 4).

Fig. 3

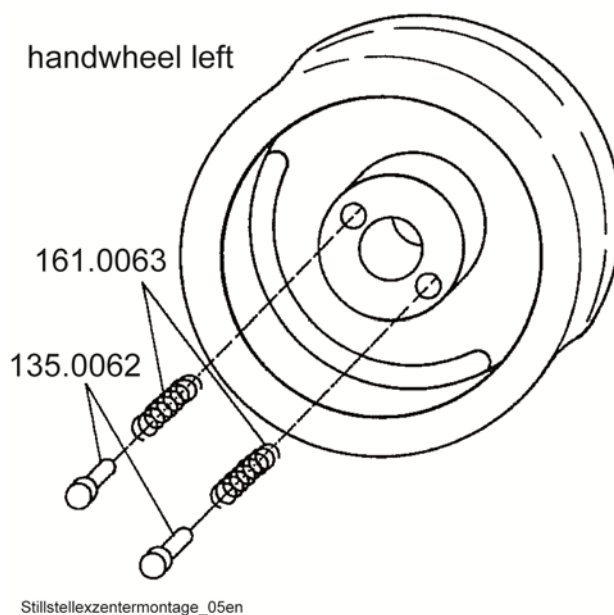
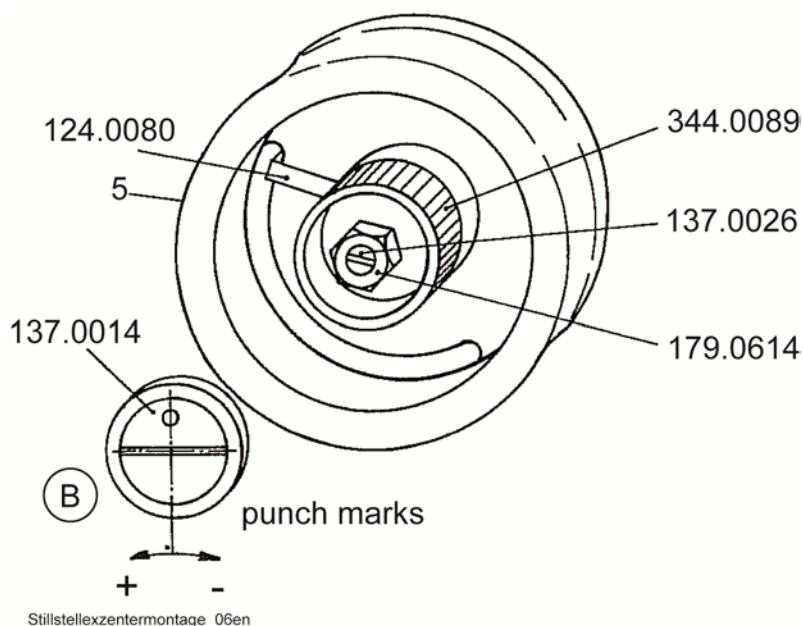


Fig. 4



Screw knob 344.0089 onto regulating bolt 137.0026 until it touches the hand wheel. Then hold the knob while screwing out the regulating bolt until index 124.0080 stops at the knob (mark 5) long stitch, (Fig. 4) and easily visible between handwheel and stand.

When properly adjusted, you can easily turn the regulation knob from the fixed stop "long stitch" to the fixed stop "short stitch".

Regulating eccentric 132.0074 must be set to the upper dead point, the index at the hand wheel to mark 5. Finally, screw in lock nut 179.0614. (Fig. 4)

4.3 Adjust stitch regulating bolt 137.0014 for stitch adjustment

Eccentric (A) 353.0031 (Fig. 1) and bolt (B) 137.0014 (Fig. 4) have to be adjusted to the specific stitch length required for each machine (See chart). Make sure that wing 223.0045 and rod 120.0082 are correctly set. Bolt 137.0014 must be mounted with the grain mark facing upwards because this mark indicates the stitch length; in other words, it moves - in direction of arrow - to the right (-) when at its smallest, and to the left (+) when the longest stitch is being formed. (Fig. 4 and Fig. 5)

4.4 Adjust needle- and feed motion

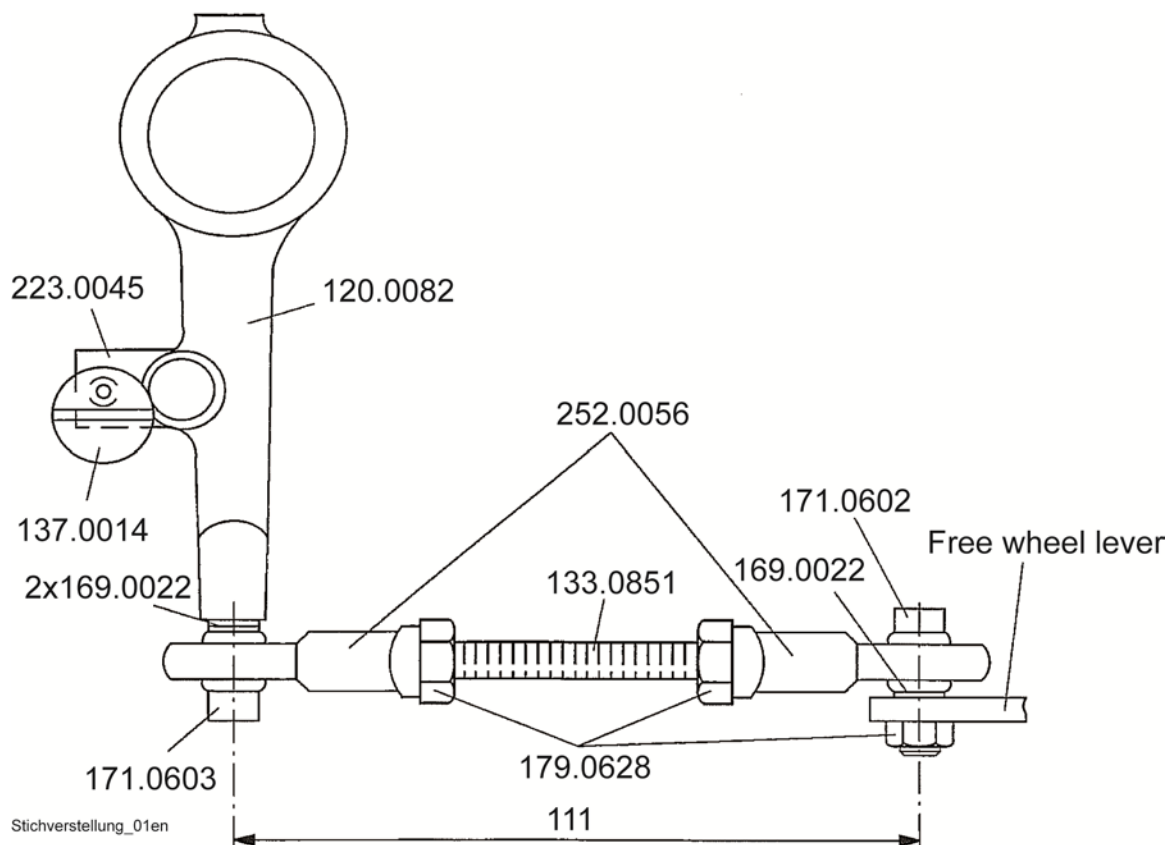
If the machine is set to produce the longest stitch (see chart), the feed motion stops when the point of the needle placed approx. 1.5 mm within the cup edge before penetrating the fabric.

The feed motion starts when the needle is placed approx. 1 mm behind the cup edge.

Needle- and feed motion are adjusted at needle bar eccentric (E) (Fig. 1), note the foremost needle position (table).

When adjusting the needle bar, make sure that the needle clamp device at the needle bar head stands exactly rectangular to the rear feed cup.

Fig. 5



4.5 Looper motion

The looper motion is determined by the stroke of the looper eccentric (F) (Fig. 1 and Fig. 6), by the crank distance, and by the distance between drill holes in the clamp lever. These parts are different for each machine class. The looper motion must start and end at the same time as the needle bar motion.

The lateral looper movement is determined by the control cam and must be in accordance with the needle motion.

The looper shaft must be mounted exactly in the center of the needle bar.

We recommend to fit the parts onto the shaft so that they can still be moved, and to fasten them tightly only after the final adjustment.

4.5.1 Adjust the looper motion

Mark the upper dead point of needle bar eccentric (E) (Position 1).

Find and mark the top dead centre of the needle bar eccentric (equals position "1"). (E)

The top dead centre of the needle bar eccentric is equal to the bottom dead centre of the gripper eccentric offset by 180° (see chapter "4.5.2 Adjust the looper eccentric (on single thread machines)").

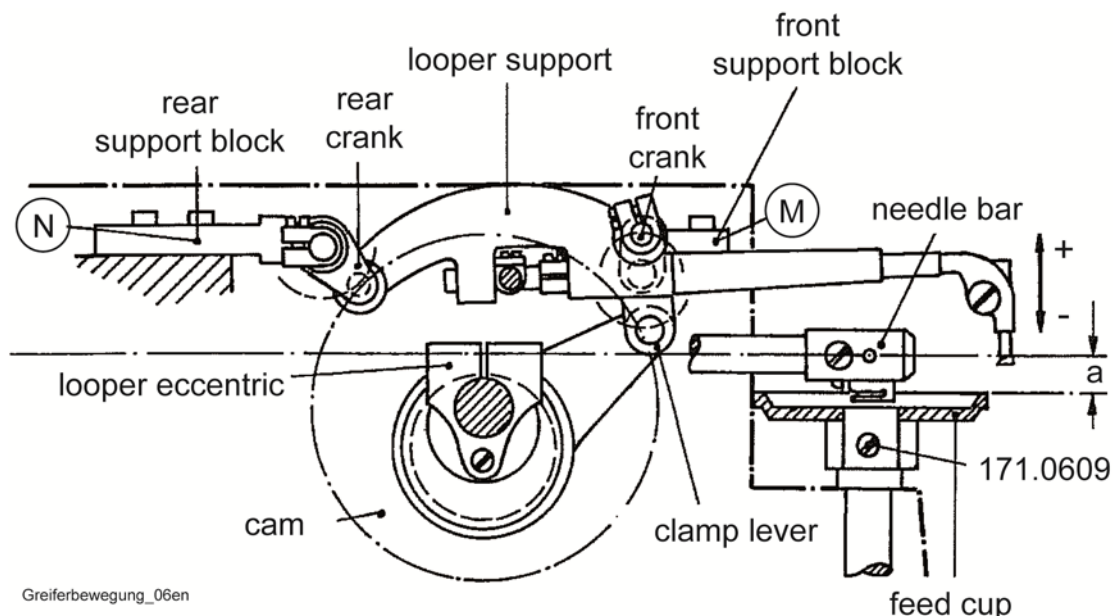
In this position, turn the control cam until the looper – moving to the right – takes up the loop and reaches the turning point.

Make sure that a play of approx. 1 mm remains between control cam and setting ring at the looper shaft, because a lateral displacement of the cam also influences the looper movement.

If the distance is enlarged, the deflection of the gripper to the right is reduced.

The total path of the gripper hardly changes.

Fig. 6



4.5.2 Adjust the looper eccentric (on single thread machines)

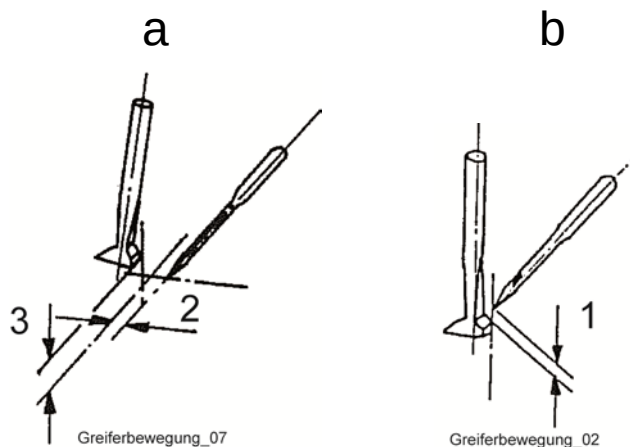
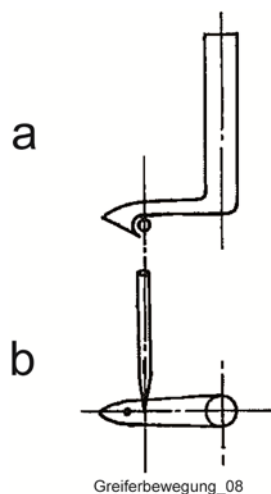
Set looper eccentric (in position 1) so that its surface stands horizontally (Fig. 6). For setting the needle in its utmost rear position, turn the hand wheel about 100 degrees (position 2). In this position, the looper is set about 2 mm on the left of and about 3 mm above the needle, but this varies according to stroke of loop (Fig. 7a). When the needle has moved forth to the looper's right hand edge, its point moves past the looper approx. 1 mm above it (Fig. 7b). At the utmost dead point of the looper's lateral and longitudinal movement, the point of the needle is at 1 to 3 mm within the feed cup, which depends on how the stroke of loop had been adjusted.

4.5.3 Adjust the looper eccentric (on two tread machines)

Set looper eccentric (in position 1) so that its surface stands horizontally (Fig. 6). For setting the needle in its utmost rear position, turn the hand wheel about 100 degrees (position 2). In this position, the looper is placed in front of and above the needle; the distance varies according to looper motion and stroke of loop. (See chart)

When moving forth, the needle moves closely below the looper without actually touching it (Fig. 8a) and takes up the thread from the looper's groove. The looper motion stops when the point of the needle reaches its center (Fig. 8b).

When the needle has taken up the thread and is about to penetrate the sewing material (approx. 2 mm in front of the cup edge), the looper moves about 0.7 mm to the left, then past the sewing material to the front turning point (stroke of loop) on the right. (See chart)

Fig. 7**Fig. 8****4.5.4 Adjust the front crank**

Set the front crank (131.0010, 131.0019, according to machine class) vertically in position "1".

The regulation of the front crank influences the looper's upwards movement. In its front position, the looper moves upwards, and should move very closely over the needle (0.1 to 0.15 mm) to ensure that the loop is properly taken up. You also have to consider the different needle sizes. In its utmost rear position, the looper is placed below the needle, and the needle about 1 mm above the looper's bevelled edge. (Fig. 7b)

4.5.5 Set the looper in its front position to the feed cup

The looper reaches its utmost front position on moving approx. 45 degrees opposite to direction of sewing. To be set as per measures (H) – see chart. It is important that the height of looper and shaft is properly adjusted. (See chart)

It has to be controlled if measure (L) considers with looper shaft set as described at chart page 30 and 31, readjust, if necessary.

4.5.6 Adjust stroke of loop

Each machine requires a certain stroke of loop (B) (see chart), which is regulated by turning the control cam and the looper eccentric; measured from the needle's front dead point to the point where the looper stands above the center of the needle.

To obtain a large stroke of loop - turn cam and looper eccentric opposite to the machine's direction of sewing.

To reduce the stroke of loop - turn cam and looper eccentric in direction of sewing.

Then the looper takes up the loop and puts it – as straight as possible – backwards on the sewing material.

4.5.7 Adjust the front bearing block

The height of the front bearing block (M) (Fig. 1 and Fig. 6) is specifically set for each machine. The looper motion depends on the control cam and can be altered as follows: To increase the looper motion to the right, put a distance plate under the bearing block. To reduce it, take off the distance plate.

4.5.7.1 Basic dimensions for front and rear bearing block

Manufacturing constructs the machine housing to a certain dimension. To get to a different basic dimension for the various sub-classes, spacer plates of the required thickness are placed underneath the bearing block when necessary.

4.5.8 Adjust the rear bearing block

The looper movement may be altered in the final positions by shifting the rear bearing block (N) (Fig. 1 and Fig. 6). On its return movement, the looper gets close to the needle in its vertical- and front position, without essentially changing its height in the rear position. (Ratio approx. 10:1). When moving forth, the distance between looper and needle increases.

4.6 Adjust height of rear feed cups

Fit bushings 150.0170 and 150.0281 so that the lower bushing is on a level with the surface on which the free wheeling is screwed, that the bottom socket is 4 mm within the bolting surface for the free wheel; the top socket needs to provide the distance for the transport plate. In the mounted state with the transport shaft head the distance between needle shaft middle and transport plate top edge is the measurement "a" from Fig. 6.

4.7 Mount the front feed cup

When mounting the front feed cup onto the machine, make sure to fix it horizontally and 0.1 mm lower than the rear feed cup. If the machine is equipped with a needle guard, the needle groove must be another 0.1 mm below the upper edge of the front feed cup.

4.8 Length adjustment of bar 133.0851 between stitch regulation rod and free wheeling

The distance between the two drill holes $\varnothing 6$ must be 111 mm. (Fig. 5)

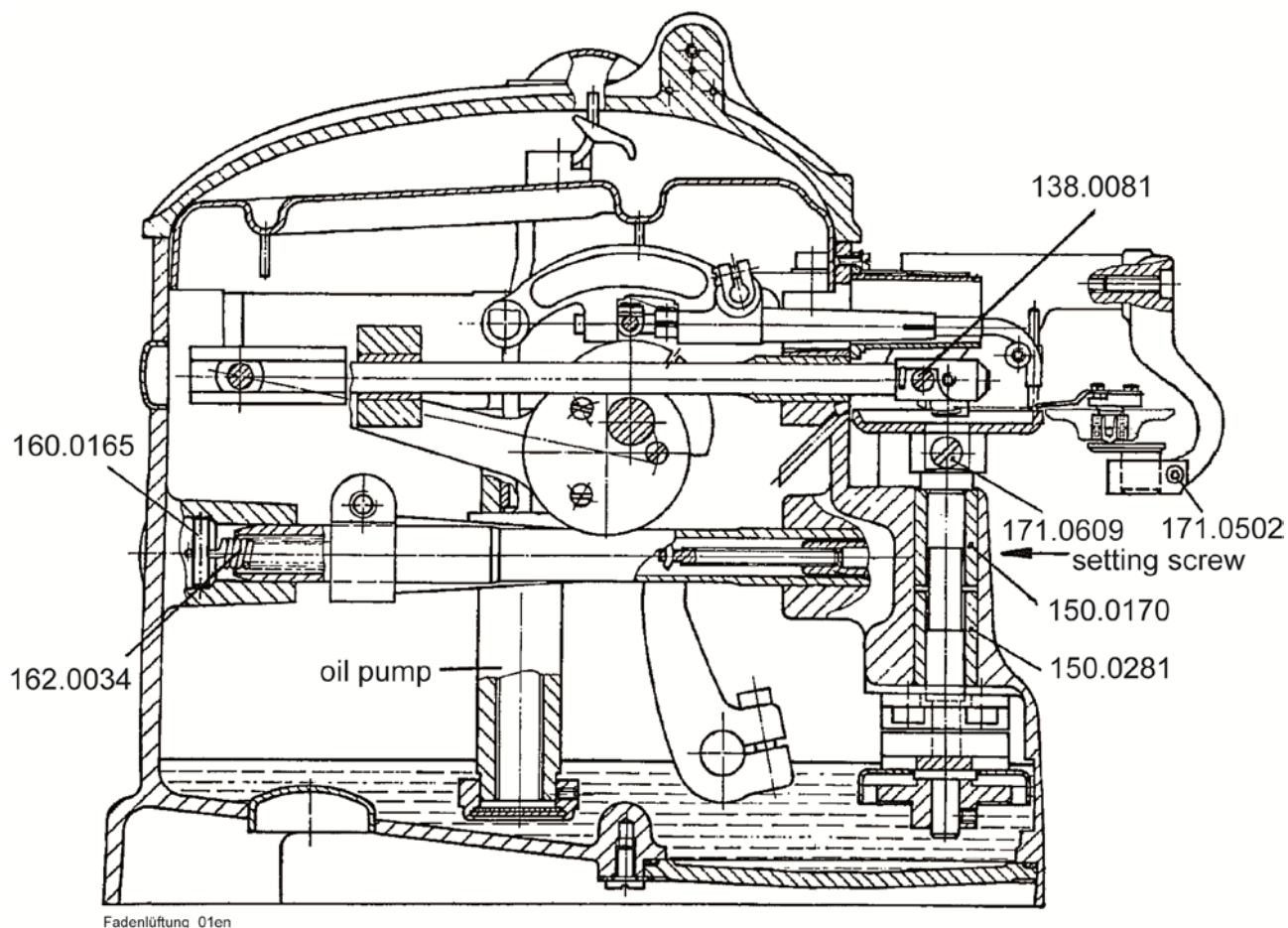
4.9 Thread lifting mechanism at needle bar head

Class 141: Adjust lifting bar 124.0053 so that the thread is lifted – on the needle's backwards movement – when the looper is placed vertically above the needle and has taken up the loop. Then – while the needle moves forth – until the looper's point reaches the center of the needle. (Fig. 1)

The same applies to class 142. In other words, the thread must be loose (without tension) from the moment the looper takes it up until the looper's right hand turning point. Make sure that thread clamping bolt 138.0081 at the needle bar head releases the thread just about 0.3 mm. You should also consider that threads vary according to machine class and application. (Fig. 9)

The thread drag on the needle bar is 0.35 - 0.4 N.

Fig. 9



Fadenlüftung_01en

4.10 Spring tension at feed cup support arm 333.0114

The tension of spring 162.0034 should be adapted to each specific fabric. For diver's suits, it is approx. 70 N, for shoes up to 200 N. (Fig. 1 and Fig. 9)

4.10.1 Plate arm lifting

The plate arm lifting is about 12 - 14 mm for all machines. Lever 221.0194 and lever 121.0033 have to be appropriately adjusted to each other (Fig. 9)

4.11 Needle setting

Concerning the setting of the needle bar, refer to table containing setting data.

4.11.1 Adjusting needle height (Fig. 10 and Fig. 11)

A special device permits needle height adjustment, a feature particularly advantageous if needles of different sizes are used. Turn the eccentric 132.0069, provided with a slit, and placed on front of the head of the needle bar. Make sure that the needle of the respective thickness always goes with a distance of about 0.1 mm over the transport plate. Loosen screw 171.0407 of the needle set plate 285.0054 (or 285.0055, 285.0147, or 285.0159, different depending on class), adjust height of needle and retighten screw 171.0407.

Fig. 10

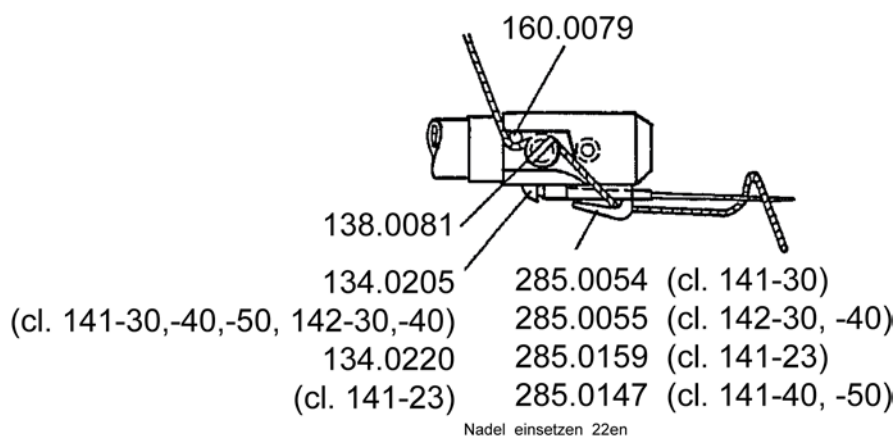
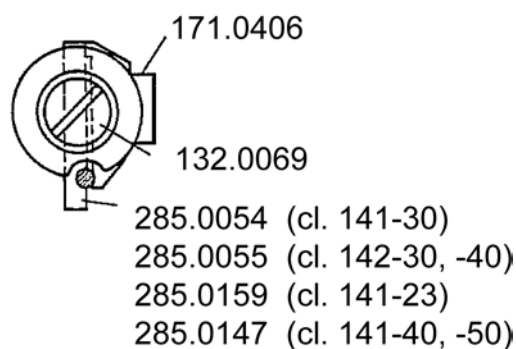


Fig. 11



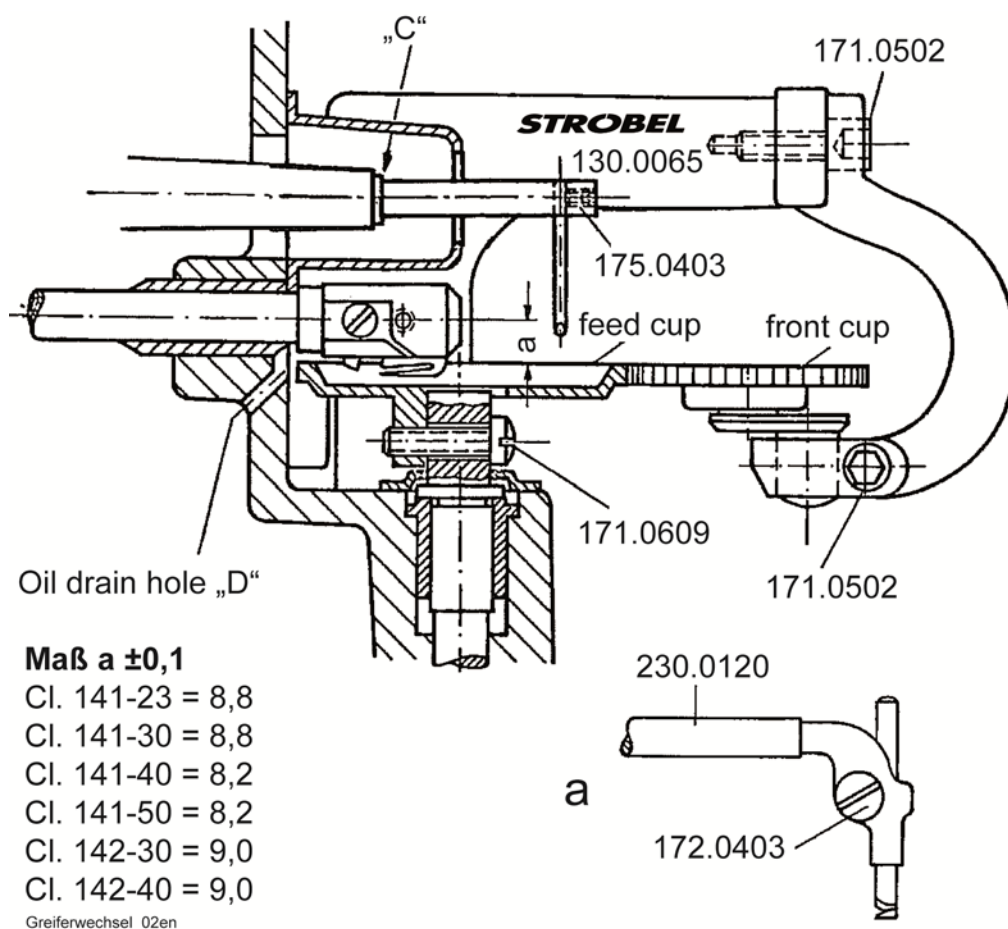
4.12 Chaniging the looper

The looper can be removed after loosening clamping screw 175.0403 (Cl. 141-40/-50) (Fig. 12) and 172.0403 (Cl. 141-23/-30 and 142-30/-40) (Fig. 12a) respectively, at looper shaft head.

Upon mounting a new looper, take care that it touches the needle neither in its front position nor in its rear position. (Also refer to setting data)

The wide gripper back should be standing as parallel as possible to the needle.

Fig. 12



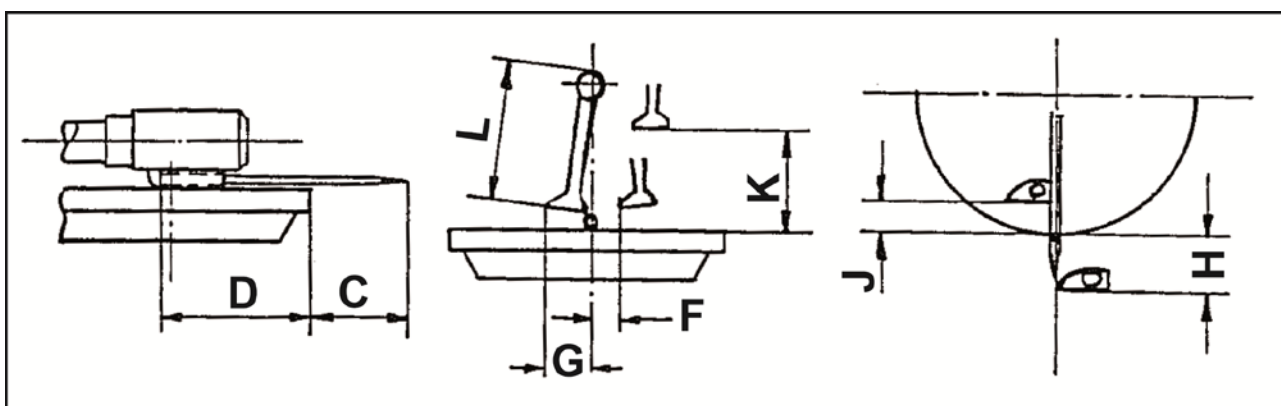
4.13 Maintenance

Since the machines feature fully automatic lubrication, they need no maintenance in this regard. Never the less, we would recommended an oil change approx. every six months, which depends on how many hours the machine is used per day, and on its degree of soiling. You should use approx. $\frac{3}{4}$ of a litre of oil with a viscosity of 46 cSt (Recommended oil: Shell Voltol 46)

4.14 General Data

All further informations – technical data, application and operating instructions – are included in the manual we provide with each machine.

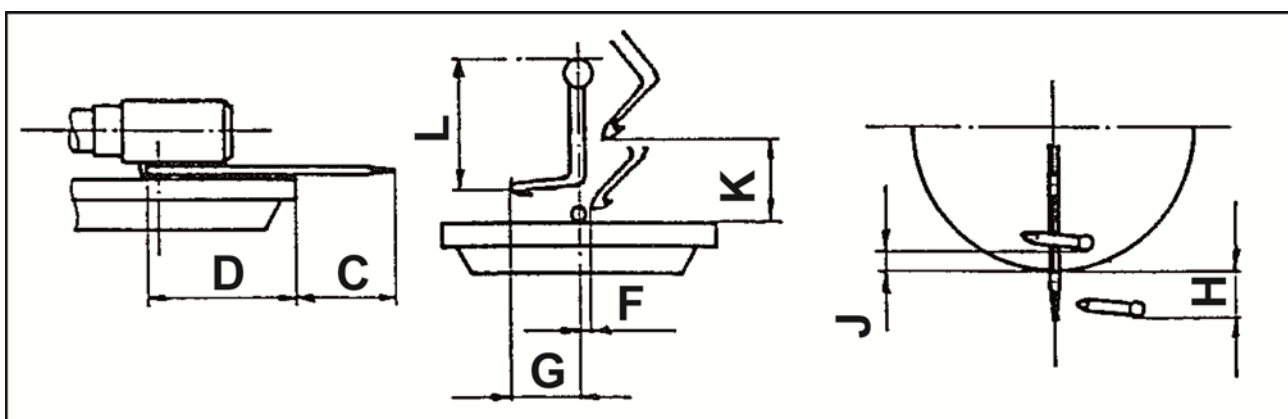
Setting data for Single Thread Overseaming machines					
Class	Dim.	141-23	141-30	141-40	141-50
Needle type		134	459R	459R	459R
Needle size		120- 140	90-130	40-55	40-55
Stitch length	A	3.5-6.5	3.6	0.7-2.7	0.6-2.5
Stroke of loop	B	4.7	4.5-5	3.5	3.5
Needle point front measured from cup edge	C	22.6	20.5	18.5	16.8
Needle stop at needle bar until cup edge	D	20.5	19	21	22.7
Stroke of needle bar eccentric	E	32.4	30.4	25	24
Looper movement to the right from needle center to looper point	F	5.5	3	4.2	3.2
Looper movement to the left	G	10.2	9	8.2	8
Looper front position measured from cup edge	H	11.5	8.2	7.5	5.5
Looper rear position	J	6.2	4.5	3.5	4.6
Looper movement	K	9.5	9	5.3	4.8
Looper height inclusive shaft	L	37	30.5	31.5	30.8



Einstellwerte_05

Setting data for Two Thread Overseaming machines

Class	Dim.	142-30	142-40		
Needle type		1738	1738		
Needle size		55 - 100	55		
Stitch length	A	2.3 – 5.3	1-4		
Stroke of loop	B	4.2	4.5		
Needle point front measured from cup edge	C	18.8	17		
Needle stop at needle bar until cup edge	D	19	21		
Stroke of needle bar eccentric	E	28	24		
Looper movement to the right from needle center to looper point	F	2.8	5.9		
Looper movement to the left	G	8	6.8		
Looper front position measured from cup edge	H	11.5	9.7		
Looper rear position	J	1	1.6		
Looper movement	K	8.2	6.7		
Looper height inclusive shaft	L	28.36	31		



Einstellwerte_06

5 Notes on repair and adjustment

5.1 Transport plate assembly

Refer to the table for the transport and pressure plates needed for the various classes.

In addition to the transport and pressure plates featured in the normal models, optional transport and pressure plates with appropriate teeth and edge heights are offered to handle various materials to be processed.

5.2 Exchanging the transport plate

Exchanging the transport plate is done by loosening the screw 171.0609. (Fig. 12)

If a pressure plate needs to be exchanged, loosen screw 171.0502, which holds the whole plate set in the bearing arm. Make sure when inserting each pressure plate that the edge of the pressure plate is always about 0.1 mm lower than the edge of the transport plate so that the needle can move over the edge of the pressure plate without hitting it. (Fig. 12)

5.3 Mounting and setting instructions for STROBEL gathering device No. 314.0399

(see operating instructions – Working instructions)

The gathering device EV (Fig. 14) is fixed to the machine housing by two screws 171.0607. In the housing you will find two threads which are closed by two blind screws if the EV is not used.

When mounting EV note, that, after swivelling down guide 186.0195, this must stop abt. 1 mm below the cup edge and abt. 5 – 6 mm on the right side of the needle.

When mounting the EV to a machine originally supplied without EV, drill a 24 dia. boring for rod 133.0286 in the table top, according to Fig. 13.

Fig. 13

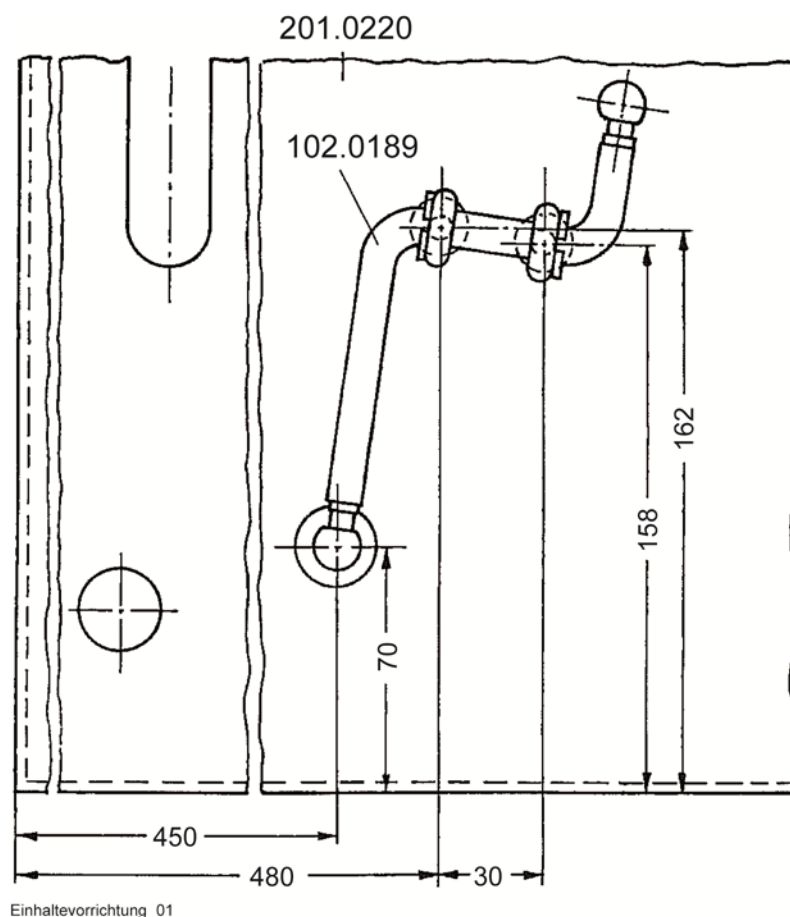
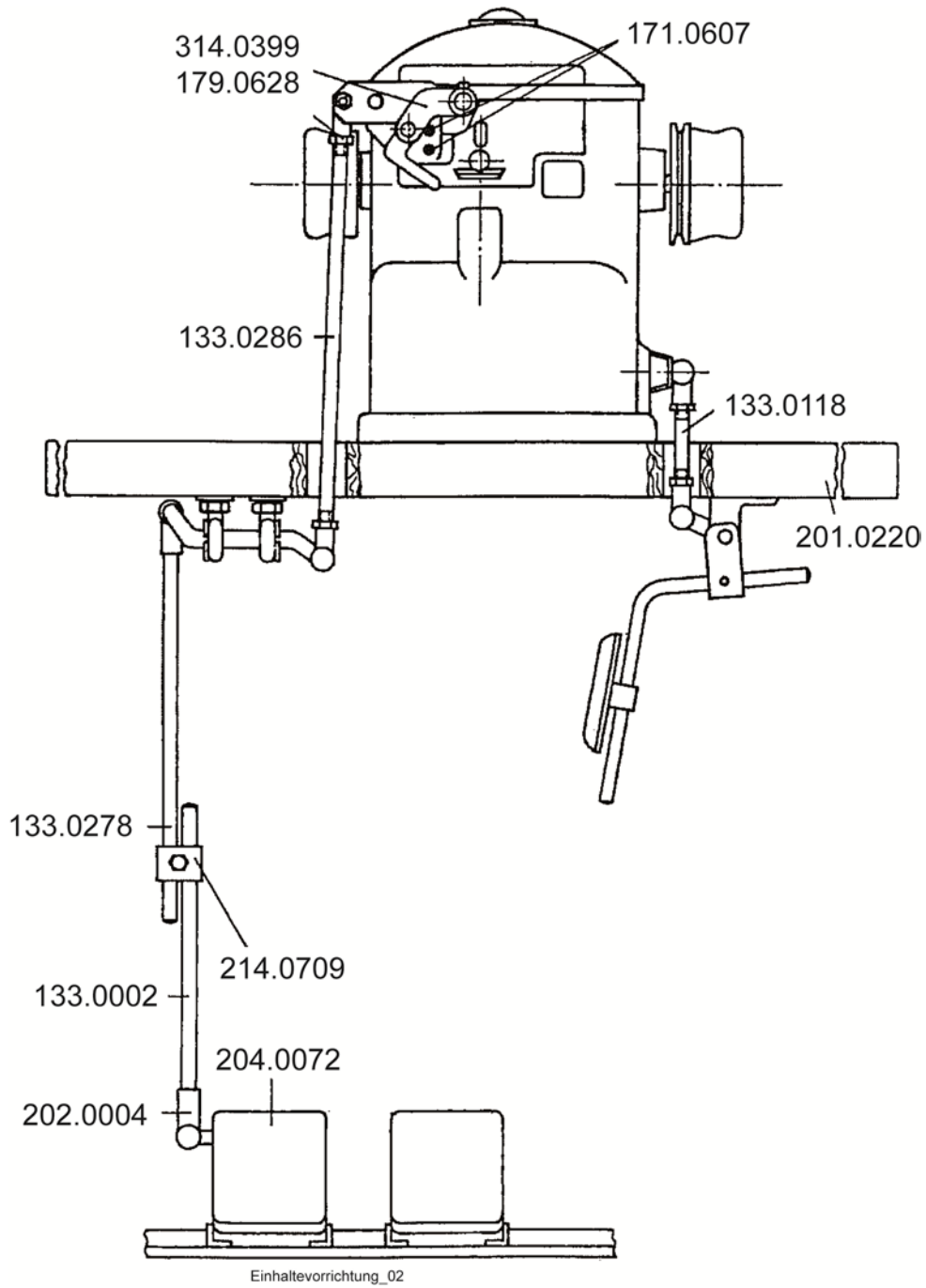
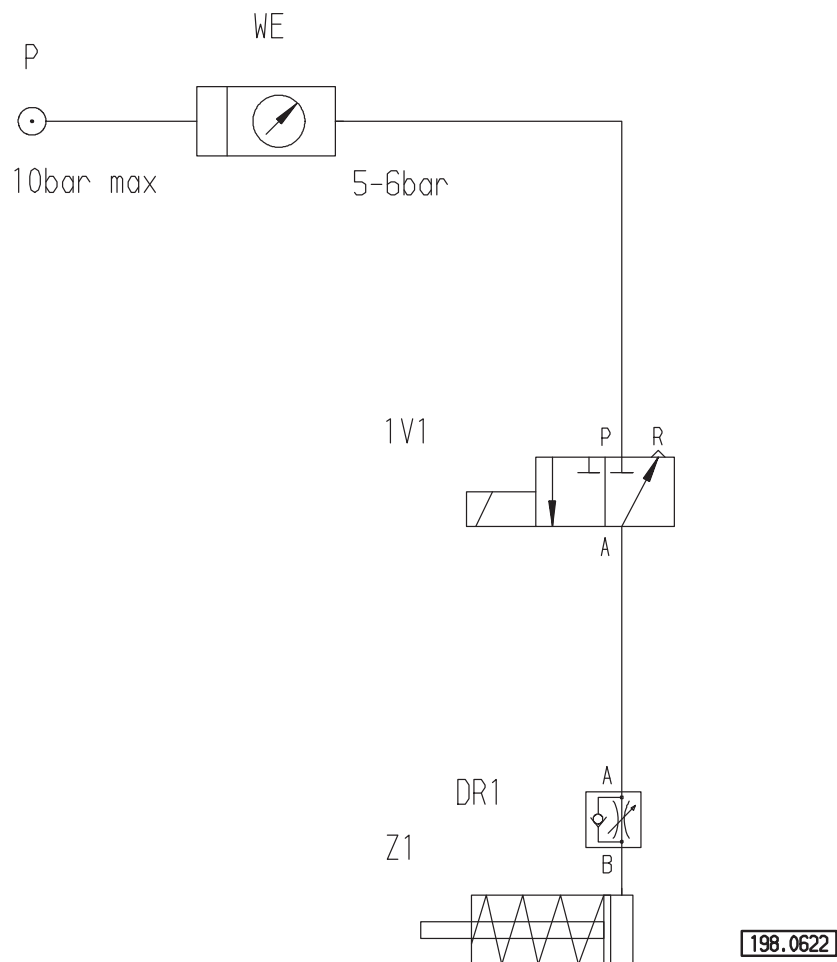


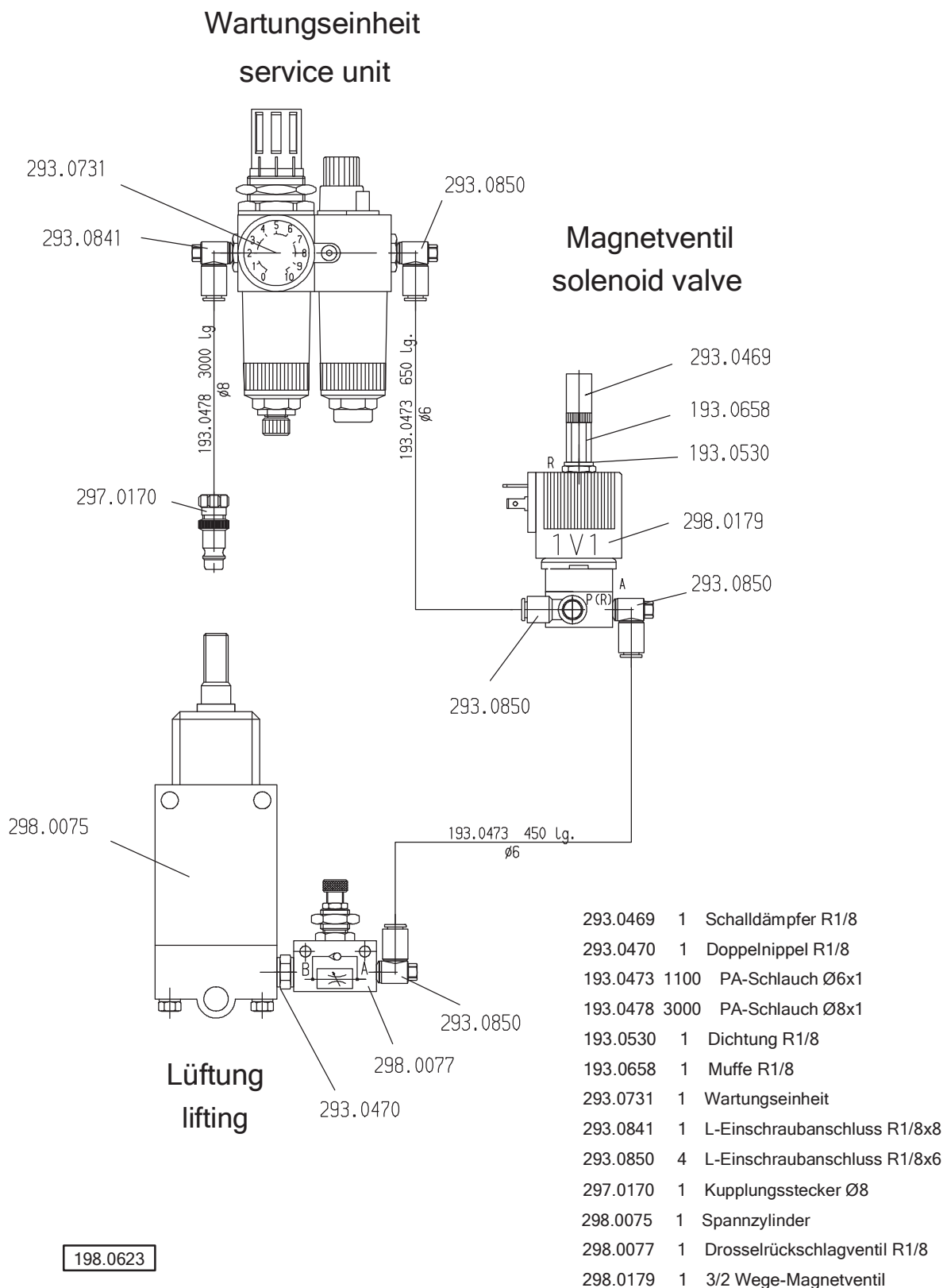
Fig. 14



Pneumatic circuit diagram cl. 142

DR1	One-way flow restrictor for lifting
MV1	3/2-solenoid-way valve
Z1	Cylinder for lifting (LÜ)
WE	Service unit

Pneumatic construction circuit diagram cl. 142



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