

571

574

INSTRUCTION MANUAL

591

This instruction manual applies to machines from the following serial numbers onwards: **7 278 349** and software version **0435/002**.



This instruction manual applies for all of the designs and subclasses listed in **Chapter 3 Technical Data**.



The settings manual for the machine can be downloaded at no charge under www.pfaff-industrial.de/de/service-support/downloads/technical. As an alternative to the Internet download, the settings manual can also be ordered as a hard copy under order no. **296-12-19 399/002**.

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1 Safety

1.01 Directives

The machine was built in compliance with the European regulations specified in the declaration of conformity and declaration of incorporation.

As a supplement to this instruction manual, please also observe the generally applicable, legal and other regulations and legislation – also in the country of use – and the valid environmental protection regulations! Always comply with the locally applicable regulations of the professional associations and other supervisory authorities!

1.02 General safety instructions

- The machine may only be operated after you have become acquainted with the associated instruction manual and only by operating personnel who have received appropriate training!
- Always read the safety instructions and the instruction manual of the motor manufacturer before starting up the machine!
- Always follow the hazard and safety instructions attached to the machine!
- The machine may only be operated for its intended purpose and only with the associated safety covers, while adhering to all the relevant safety requirements.
- The machine must always be disconnected from the power supply by pressing the main switch or pulling out the mains plug when sewing tools are replaced (such as the needle, sewing foot, needle plate and bobbin) and when threading, leaving the workstation, or performing maintenance!
- The daily maintenance work may only be carried out by suitably qualified personnel!
- Repairs and special maintenance work may only be carried out by technical staff or people with appropriate training!
- Work on electrical equipment may only be carried out by qualified technical staff!
- Work on parts and equipment under voltage is not permitted!
- Exceptions are regulated by the EN 50110 standards.
- Modifications and changes to the machine may only be made in compliance with all of the relevant safety requirements!
- Only those replacement parts approved by us for usage may be used for repairs! We warn you expressly that spare parts and accessories that are not supplied by us are also not tested and approved by us.
Fitting or using these products may therefore have negative effects on features which depend on the machine design. We are not liable for any damage caused by the use of non-Pfaff parts.

1.03

Safety symbols



Hazard point!
Special points of attention.



Risk of injury to operating personnel or technical staff!



Electric voltage!
Danger to operating personnel or technical staff



Danger of hands being crushed!
Danger to operating personnel or technical staff



Caution!

Do not operate without finger guard and safety covers!
Turn off the main switch before threading, changing the bobbin or needle, cleaning, etc.!

1.04

Special points of attention for the owner-operator

- This instruction manual is a part of the machine and must be made available to the operating personnel at all times. The instruction manual must have been read before the initial start-up.
- The operating personnel and technical staff must be instructed about the machine's safety covers and about safe working methods.
- The owner-operator may only operate the machine in a flawless condition.
- The owner-operator must ensure that no safety covers are removed or disabled.
- The owner-operator must ensure that only authorised persons work on the machine.

Additional information can be requested from the responsible sales centre.

1.05 Operating personnel and technical staff

1.05.01 Operating personnel

Operating personnel are persons responsible for equipping, operating and cleaning the machine and for fault clearance in the sewing area.

The operating personnel are obligated to comply with the following points:

- The safety instructions provided in the instruction manual must be followed for all work!
- Any work method jeopardising machine safety must be refrained from!
- Tight-fitting clothing must be worn. The wearing of jewellery such as chains and rings is prohibited!
- Care must be taken to ensure that no unauthorised persons are located in the machine's hazard zone!
- Any changes occurring on the machine which impair its safety must be reported to the owner-operator immediately!

1.05.02 Technical staff

Technical staff are persons with technical training in electricity/electronics and mechanics. They are responsible for lubricating, servicing, repairing and adjusting the machine.

The technical staff are obligated to comply with the following points:

- The safety instructions provided in the instruction manual must be followed for all work!
- Turn off the main switch and secure it against reactivation before starting any adjustment and repair work!
- Never work on live parts and equipment!
Exceptions are regulated by the EN 50110 standards.
- Reattach the safety covers following repair and maintenance work!

1.06

Danger warnings



A work area of **1 m** must be kept free in front of and behind the machine to ensure unobstructed access at all times.



Do not reach into the needle range during the sewing operation!
Risk of injury from the needle!



Do not allow any objects to be placed on the table during the adjustment work!
The objects could become jammed or be slung away!
Risk of injury from parts flying around!

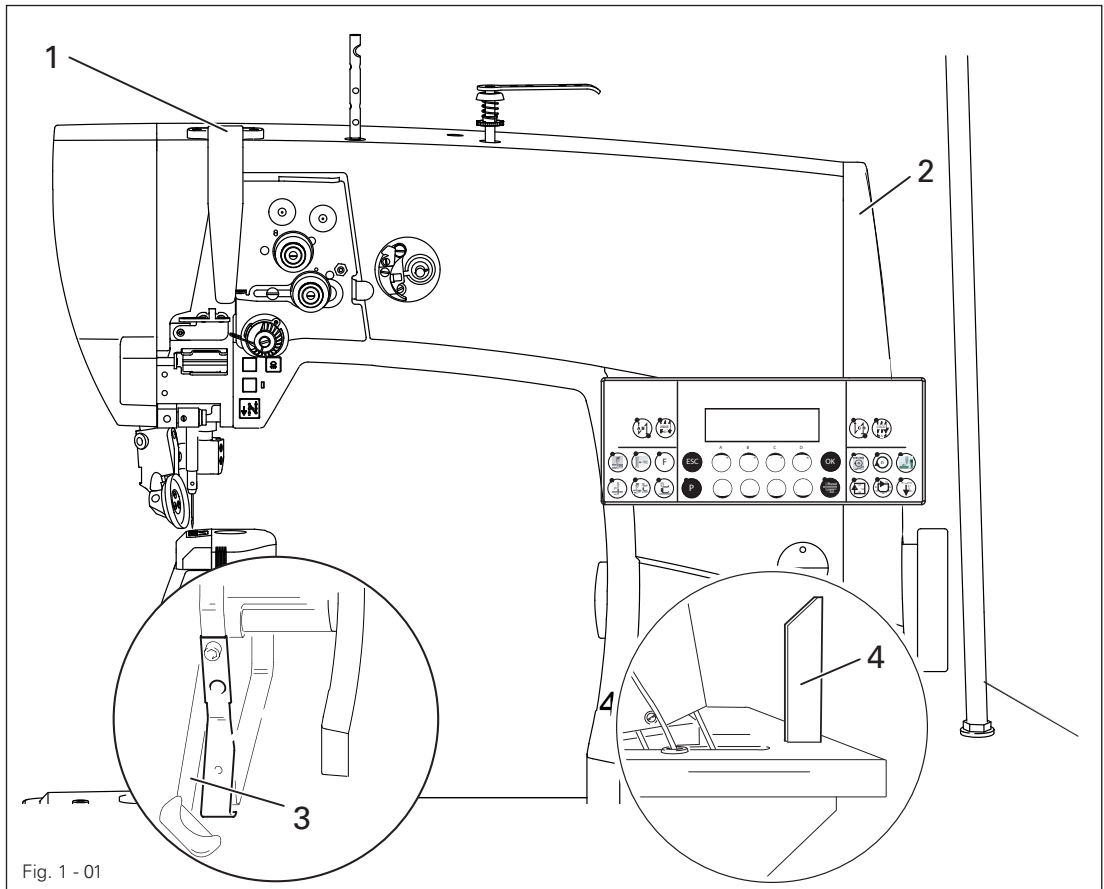


Fig. 1 - 01



Do not operate the machine without the take-up lever guard **1!**
Risk of injury due to the motion of the take-up lever!



Do not operate the machine without the belt guard **2!**
Risk of injury due to the rotating driving belt!



Do not operate the machine without the anti-tipping device **3!**
Risk of injury by crushing between the sewing head and the table top!



Do not operate the machine without the support **4!** Risk of damage due to the top-heavy sewing head!
Machine can tip over backwards when moving it!

2 Proper Use

The **PFAFF 571** is a single needle post-bed sewing machine (post is positioned to the left of the needle) with powered feed wheel and roller presser plus feed-synchronised needle.

The **PFAFF 574** is a two-needle post-bed sewing machine with powered feed wheel and roller presser.

The **PFAFF 591** is a single needle post-bed sewing machine (post is positioned to the right of the needle) with powered feed wheel and roller presser plus feed-synchronised needle.

The machines are used to create double lock stitch seams in the leather and upholstery industries.



Any usage not approved by the manufacturer is deemed misuse!
The manufacturer shall assume no liability for damage caused by misuse!
Proper use also includes compliance with the operating, maintenance, adjustment and repair measures specified by the manufacturer!

3 Technical Data ▲

3.01 PFAFF 571

Stitch type:.....301 (lock stitch)

Needle system :..... 134

Design BN5:..... for the machining of medium-weight materials

Design CN5:..... for the machining of medium-heavy materials

Needle size in 1/100 mm:

Model BN5:..... 80 -100

Model CN5:..... 110 - 140

Stitch length max:5.0 mm

Speed max.:

Model BN5..... 3000 stitches/min ♦

Model CN5..... 2000 stitches/min ♦

Clearance beneath the roller presser:7 mm

Passage width:.....245 mm

Clearance height: 115 mm

Post height..... 180 mm

Bed plate dimensions:518 x 177

Sewing head dimensions:

Length:..... approx. 562 mm

Width: approx. 250 mm

Height (above table): approx. 505 mm

Motor data: see motor specification plate

Noise data:

Emissions sound pressure level in the workplace at $n = 2400 \text{ min}^{-1}$: $L_{pA} = 79 \text{ dB(A)}$ ■

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

Net weight of sewing head:..... approx. 62 kg

Gross weight of sewing head: approx. 70 kg

▲ Subject to alterations.

♦ Depending on the material, workstep and stitch length.

■ $K_{pA} = 2,5 \text{ dB}$

3.02 PFAFF 574

Stitch type:	301 (lock stitch)
Needle system :	134-35
Design BN3.6:	for the machining of medium-weight materials
Design CN:3.6:	for the machining of medium-heavy materials
Needle size in 1/100 mm:	
Model BN3.6:	80 -100
Model CN3.6:	110 - 140
Stitch length max:	3.6 mm
Speed max.:	
Model BN3.6:	3000 stitches/min ♦
Model CN3.6:	2000 stitches/min ♦
Clearance beneath the roller presser:	7 mm
Passage width:	245 mm
Clearance height:	115 mm
Post height:	180 mm
Bed plate dimensions:	518 x 177
Sewing head dimensions:	
Length:	approx. 562 mm
Width:	approx. 250 mm
Height (above table):	approx. 505 mm
Motor data:	see motor specification plate
Noise data:	
Emissions sound pressure level in the workplace at n = 1600 min ⁻¹ :	L _{pA} = 75 dB(A) ■
(Noise measurement in accordance with DIN 45 635-48-A-1, ISO 11204, ISO 3744, ISO 4871)	
Net weight of sewing head:	approx. 71 kg
Gross weight of sewing head:	approx. 79 kg

- ▲ Subject to alterations.
- ♦ Depending on the material, workstep and stitch length.
- K_{pA} = 2,5 dB

3.03 PFAFF 591

Stitch type:.....301 (lock stitch)
Needle system :..... 134
Design BN5:..... for the machining of medium-weight materials
Design CN7:..... for the machining of medium-heavy materials

Needle size in 1/100 mm:

Model BN5:..... 80 - 100
Model CN7:..... 110 - 140

Stitch length max

Model BN5:.....5.0 mm
Model CN7..... 7.0 mm

Speed max.:

Model BN5..... 3000 stitches/min ♦
Model CN7..... 2000 stitches/min ♦

Clearance beneath the roller presser:.....7 mm
Passage width:.....245 mm
Clearance height: 115 mm
Post height..... 180 mm

Bed plate dimensions:518 x 177

Sewing head dimensions:

Length:..... approx. 530 mm
Width: approx. 177 mm
Height (above table):..... approx. 440 mm

Motor data: see motor specification plate

Noise data:

Emissions sound pressure level in the workplace at $n = 1600 \text{ min}^{-1}$: $L_{pA} = 73 \text{ dB(A)}$ ■
(Noise measurement in accordance with DIN 45 635-48-A-1, ISO 11204, ISO 3744, ISO 4871)

Net weight of sewing head:..... approx. 69 kg

Gross weight of sewing head: approx. 77 kg

- ▲ Subject to alterations.
- ♦ Depending on the material, workstep and stitch length.
- $K_{pA} = 2,5 \text{ dB}$

4 Disposal of the Machine

- It is up to the customer to dispose of the machine properly.
- The materials used for the machine include steel, aluminium, brass and various plastics. The electrical equipment consists of plastics and copper.
- The machine must be disposed of in accordance with the locally valid environmental protection regulations, with a specialised company being contracted if necessary.



Please ensure that parts coated with lubricants are disposed of separately in accordance with the locally valid environmental protection regulations!

5 Transport, Packaging and Storage

5.01 Transport to the customer's premises

All machines are completely packed for delivery.

5.02 Transport within the customer's premises

The manufacturer assumes no liability for transports within the customer's premises or to the individual usage sites. Please ensure that the machines are only transported in a vertical position.

5.03 Disposal of the packaging materials

The packaging materials of these machines consists of paper, cardboard and VCI fleece. It is up to the customer to dispose of the packaging properly.

5.04 Storage

The machine can be stored for up to **6** months when not in use. It must then be protected from dirt and moisture. For longer storage periods, the machine's single components, especially its sliding surfaces, must be protected against corrosion, e.g. by an oil film.

6 **Work Symbols**

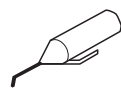
Activities to be performed or important information in this instruction manual are emphasised by symbols. The symbols used have the following meaning:



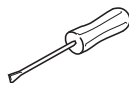
Note, information



Cleaning, care



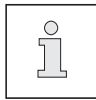
Lubrication



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

7 Operating Controls

7.01 Main switch



Before switching on the machine, raise the take-up lever as far as possible.

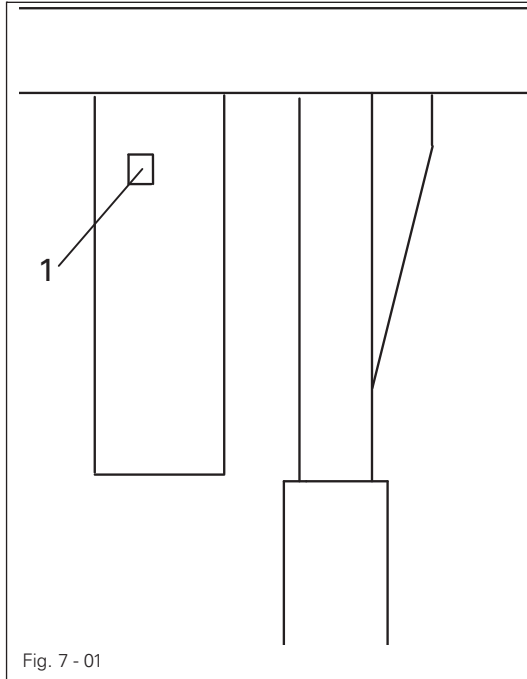


Fig. 7 - 01

Machines without -725/04

- Operating the master switch 1 switches the machine on and off.

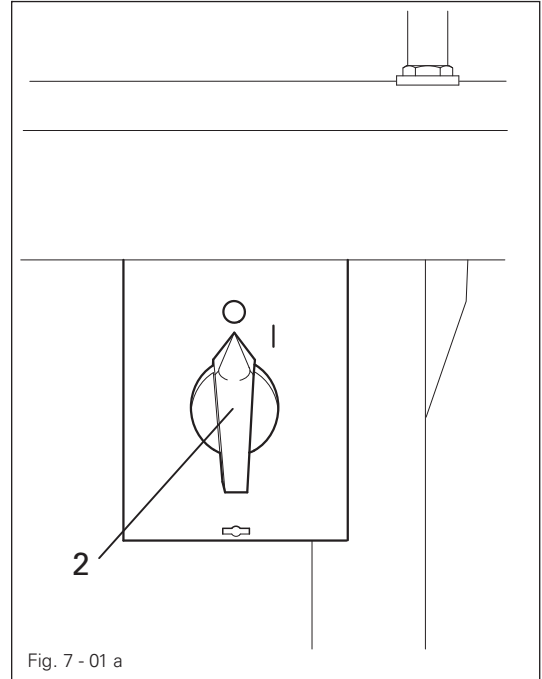


Fig. 7 - 01 a

Machines with -725/04

- Turning the main switch 1 switches the machine on and off.

7.02 Buttons on the machine head (only in machines with backtacking system -911/..)

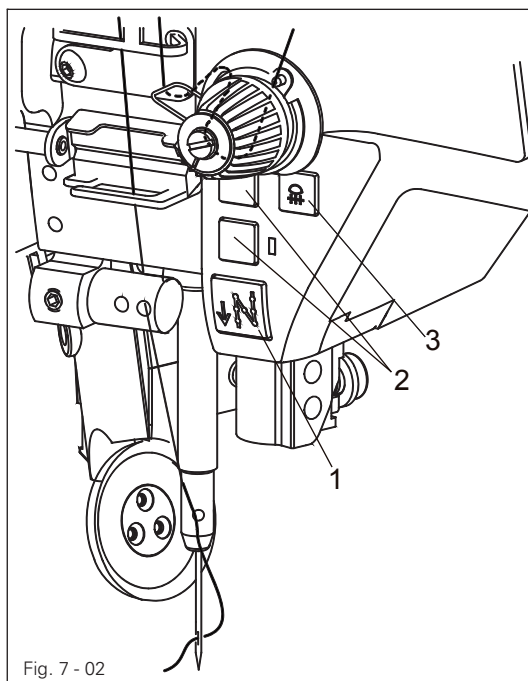


Fig. 7 - 02

- The machine sews backwards as long as the button 1 is pressed during the sewing operation.
- The buttons 2 can be assigned through the parameter setting (see separate parameter list).
- The sewing lamp integrated on the machine head is switched on and off with the button 3.

7.03 Bobbin thread monitoring using stitch counting

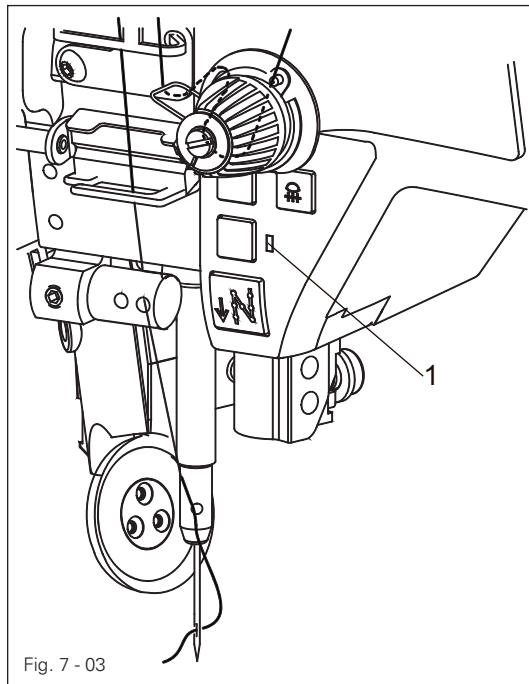


Fig. 7 - 03

- The diode 1 flashes on reaching the predefined stitch count.
- The stitch counting re-starts after cutting the thread and changing the bobbin.



For presetting the stitch count please refer to the separate instruction manual for the drive (see Chapter 5.3.1 **Setting the bobbin-stitch counter**).

7.04 Pedal

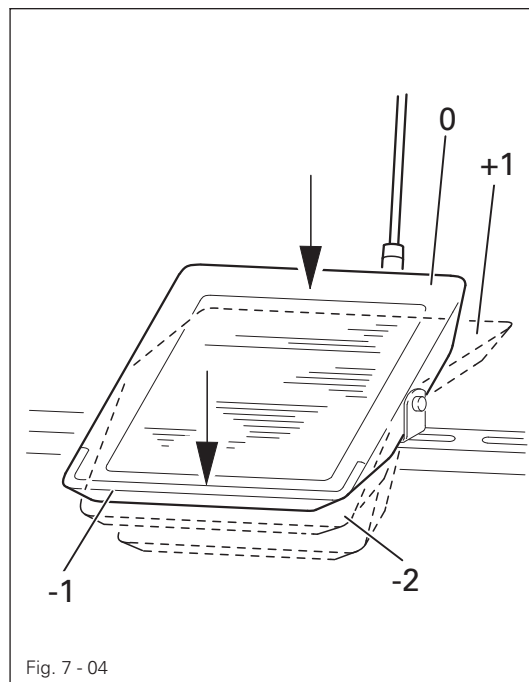
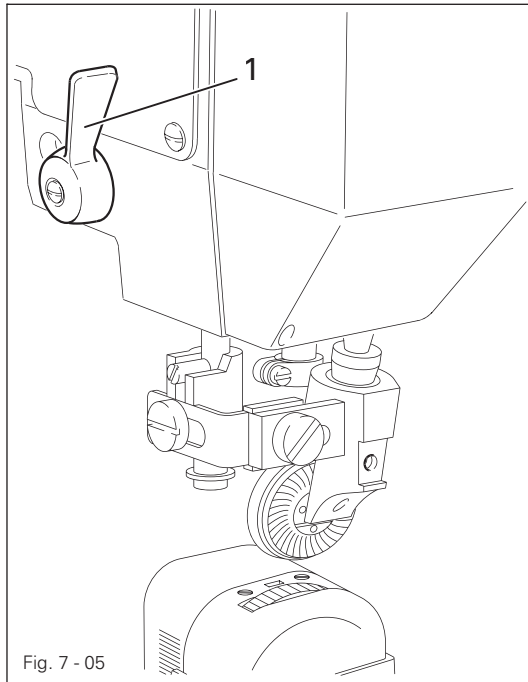


Fig. 7 - 04

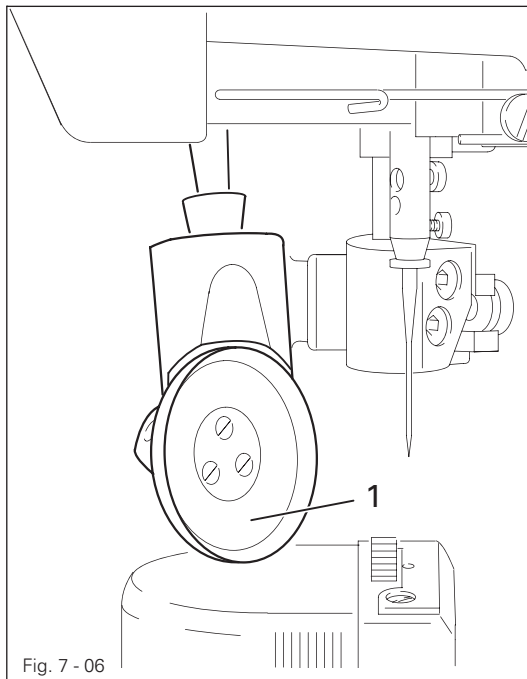
- With the main switch turned on
 - 0 = Neutral position
 - +1 = Sewing
 - 1 = Raise roller presser
 - 2 = Trim thread/
(in machines with thread trimmer -900/83)

7.05 Hand lever to raise the roller presser



- Turning the hand lever 1 raises the roller presser.

7.06 Swivelling out the roller presser



- The roller presser can be swivelled out by gently pulling downwards when the roller presser is in the raised position.

7.07 Button for stitch length regulation

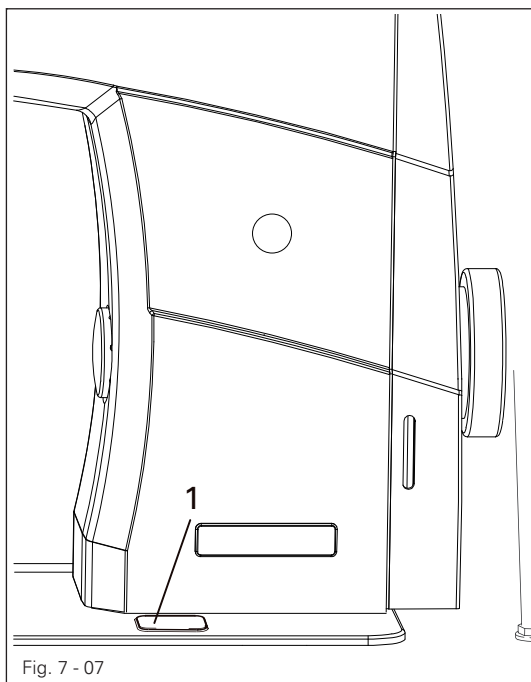


Fig. 7 - 07

- Pressing the reverse-feed lever 1 and turning the hand wheel adjusts the stitch length, see Chapter 9.07 Adjusting stitch lengths.

7.08 Knee lever

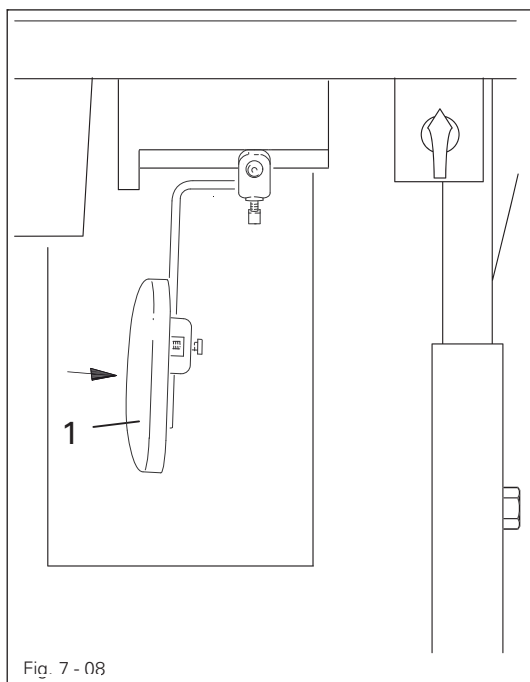
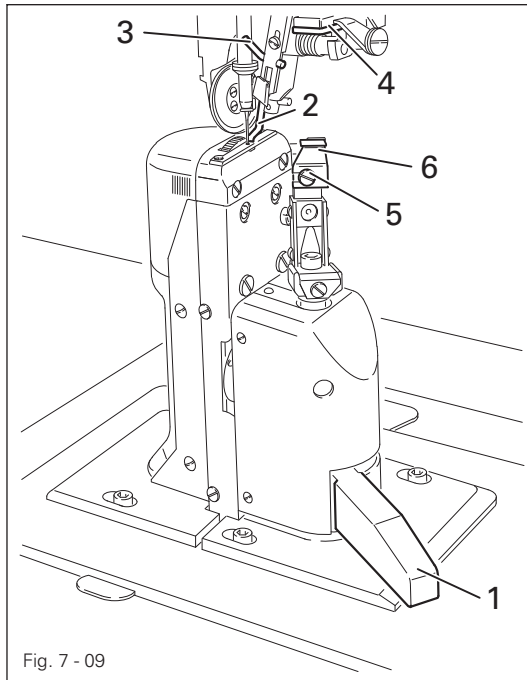


Fig. 7 - 08

- Pressing the knee lever 1 in the direction shown by the arrow raises the roller presser.

7.09 Edge trimmer -725/04 for PFAFF 571



Do not reach into the blade during operation! Risk of injury!

Switching on the knife drive:

- Swivel the lever 1 backwards; the knife moves to the operating position.

Switching off the knife drive:

- Press the lever 1; the knife swivels away backwards.

Switching on the edge guide:

- Swing in the edge guide 2 by hand and press the lever 3; the edge guide 2 moves to the operating position.

Switching off the edge guide:

- Raise the edge guide 2 and allow it to engage; the edge guide 2 is out of operation.
- Raise the lever 4; the edge guide swivels away backwards.

Replacing knives:



The work described below may only be carried out by technical staff or people with appropriate training!

- Switch the machine off.
- Release the screw 5 and remove the knife 6.
- Insert a new knife and gently tighten the screw 5.
- Adjust the knife as described in Chapter 13.05.05 **Knife movement** of the settings manual and tighten the screw 5.

7.10 Edge trimmer -725/04 for PFAFF 574 and 591

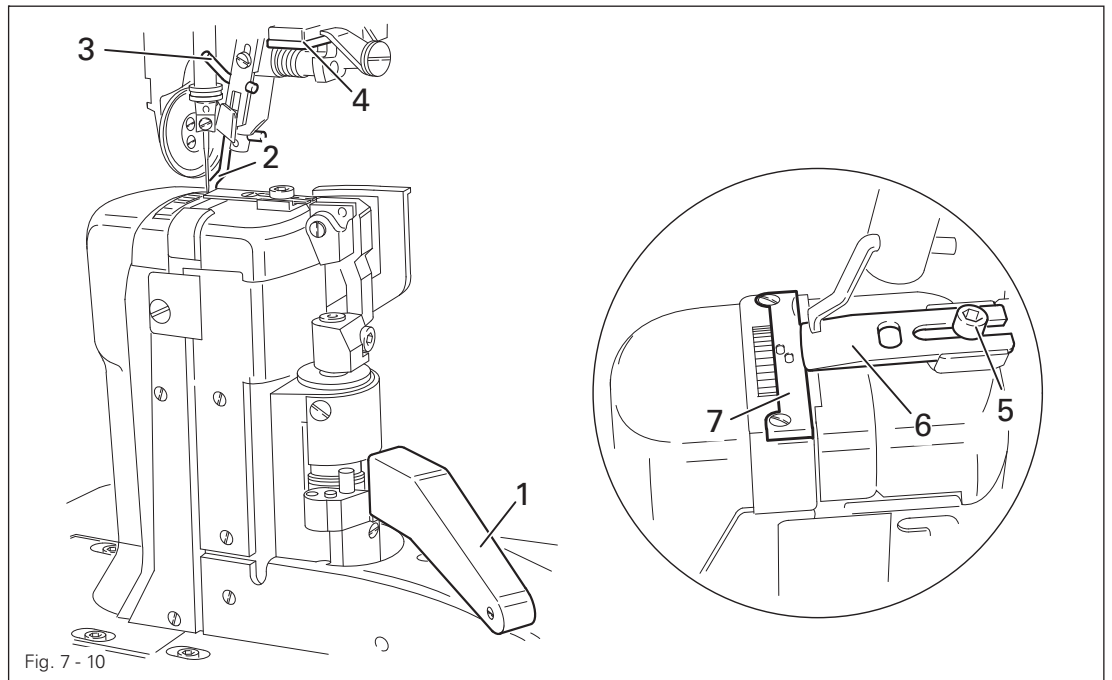


Fig. 7 - 10



Do not reach into the blade during operation! Risk of injury!

Switching on the knife drive:

- Swivel the lever 1 backwards; the knife moves to the operating position.

Switching off the knife drive:

- Press the lever 1; the knife swivels away backwards.

Switching on the edge guide:

- Swing in the edge guide 2 by hand and press the lever 3; the edge guide 2 moves to the operating position.

Switching off the edge guide:

- Raise the edge guide 2 and allow it to engage; the edge guide 2 is out of operation.
- Raise the lever 4; the edge guide swivels away backwards.

Replacing knives:



The work described below may only be carried out by technical staff or people with appropriate training!

- Switch the machine off.
- Release the screw 5 and remove the knife 6.
- Insert a new knife and slide it fully towards the needle plate insert 7.
- Gently tighten the screw 5.
- Adjust the knife as described in Chapter 13.05.07 Knife position of the settings manual and tighten the screw 5.

7.08 **Control panel** (only in machines with P40 CD)

The description can be found in the instruction manual for the drive.

8 Set-up and Initial Commissioning



The machine may only be set up and started up by qualified personnel! All of the relevant safety regulations must always be complied with in this process!
 If the machine was delivered without a table, then the stand and the table top provided must safely support the weight of the machine and its motor.
 Adequate stability of the stand must be guaranteed, even during the sewing operations.

8.01 Set-up

Suitable electrical supply connections must be provided at the erection site, see **Chapter 3 Technical data**. The erection site must also have a firm and level subsurface and adequate lighting.



The table top is lowered for packaging purposes.
 The adjustment of the table height is described below.

8.01.01 Setting the table height

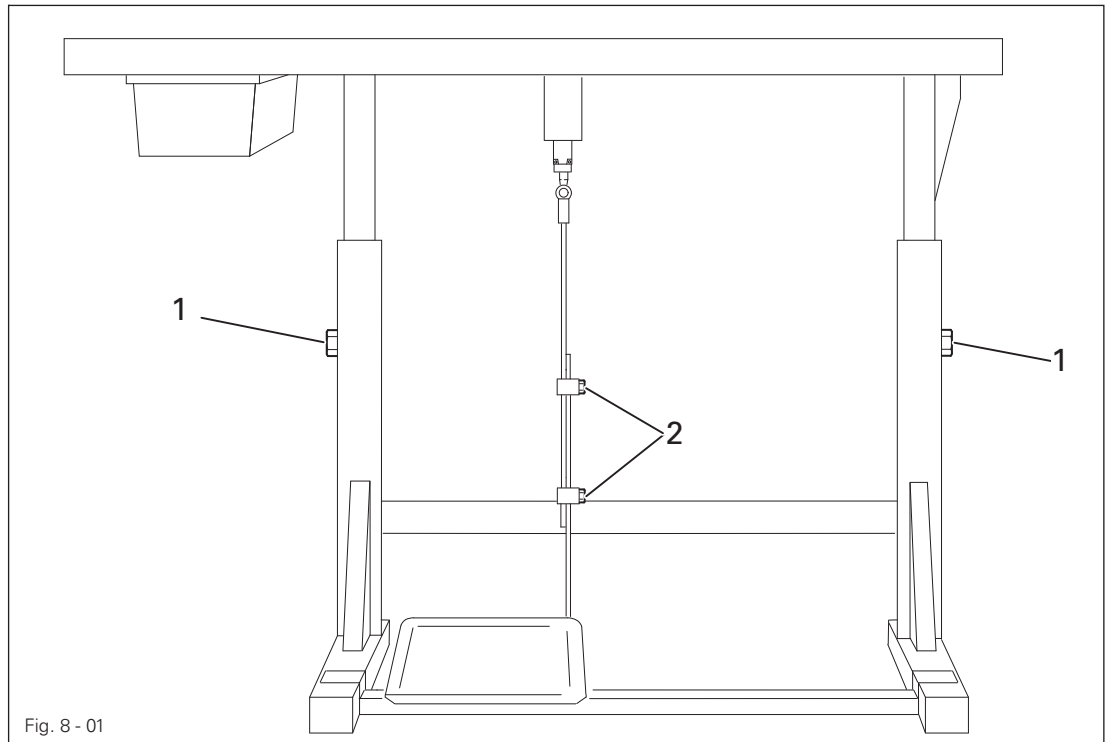


Fig. 8 - 01

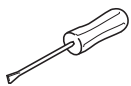
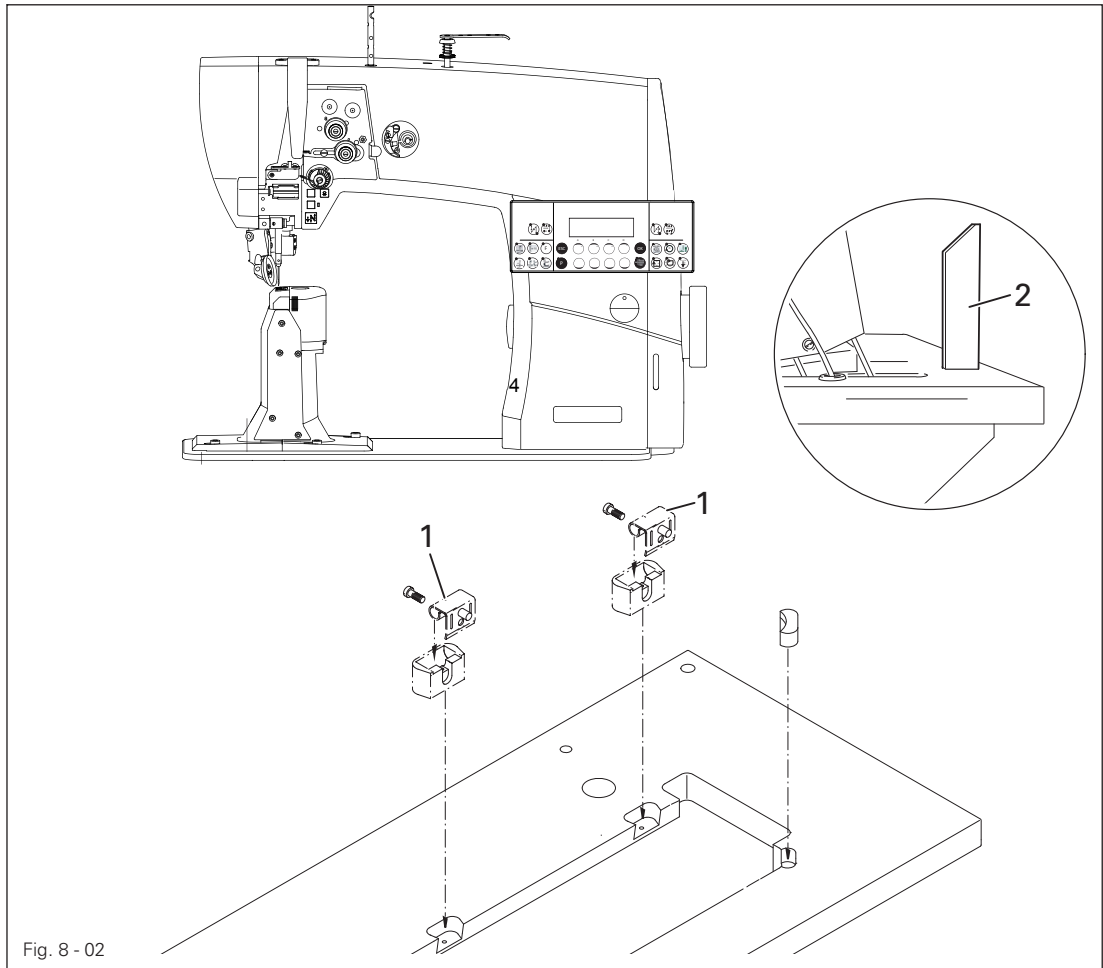
- Loosen the screws 1 and 2.
- Move the table top to the desired working height by pulling it out and pushing it in and align the table top horizontally.



Adjust the stand on both sides evenly to prevent it tilting.

- The stand must have all four feet firmly on the ground to make sure it is positioned securely.
- Firmly tighten the screws 1.
- Adjust and tighten the desired pedal position on the screws 2.

8.01.02 Inserting the sewing machine into the stand

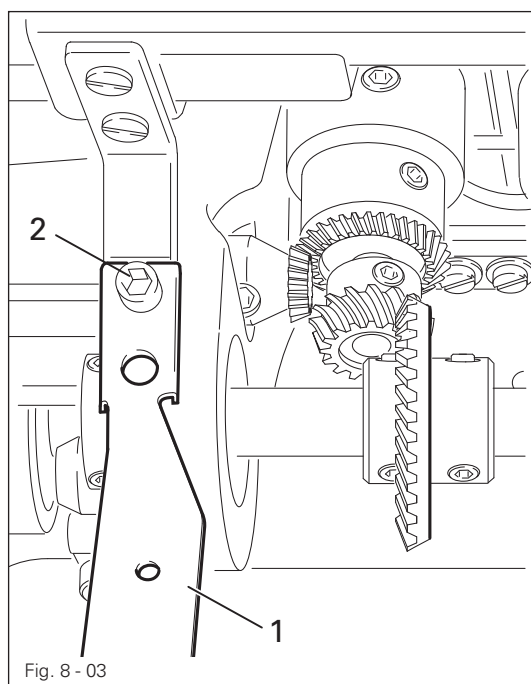


- The hinge 1 is screwed to the sewing head base plate.
- Insert the sewing machine into the table top.
- Insert the sewing head support 2 into the table top hole.



Do not operate the machine without the support 2! Risk of damage due to the top-heavy sewing head!
Machine can tip over backwards when moving it!

8.01.03 Assembling the anti-tipping device



Switch off the machine!
Risk of injury due to accidental machine start-up!

- Screw on the anti-tipping device 1 included in the accessories with the screw 2.

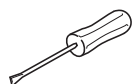
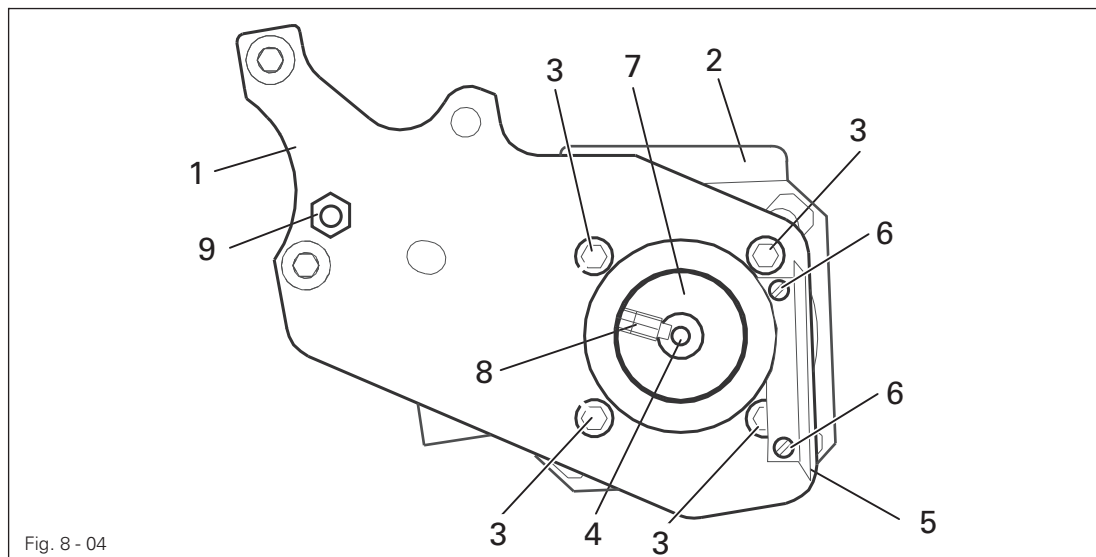
Do not operate the machine without the anti-tipping device 1!



Risk of injury by crushing between the sewing head and the table top!

8.02 Mounting the flange motor

8.02.01 Mounting the flange motor on the bearing plate



- Fix the bearing plate 1 onto the motor 2 using the screws 3 as shown in fig. 8-04.
- Remove the wedge from the motor shaft 4.
- Attach the angle bracket 5 with the screws 6.
- Mount the toothed belt wheel 7 onto the motor shaft 4 so that the screw 8 is positioned with the lug in the motor shaft slot 4.
- Screw the threaded bolts 9 into the bearing plate 1.

8.02.02 Mounting the flange motor on the machine

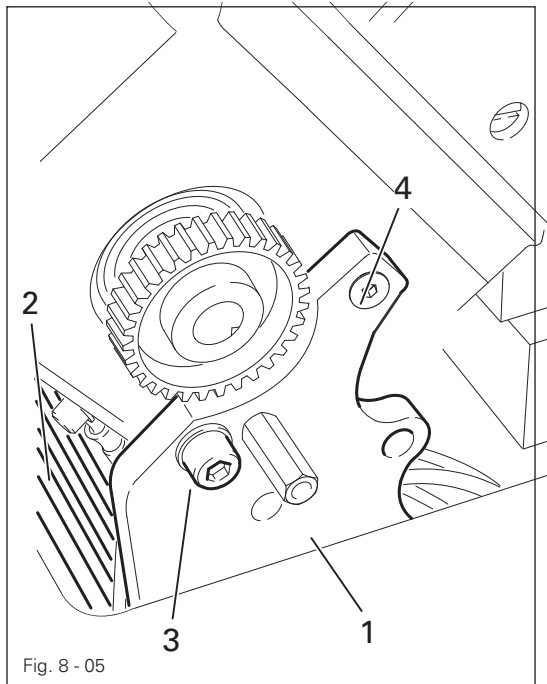


Fig. 8 - 05

- Use the screw 3 and 4 to fix the bearing plate 1 of the motor 2 to the machine housing (tighten the screws 3 and 4 slightly).

8.02.03 Applying and tensioning the toothed belt

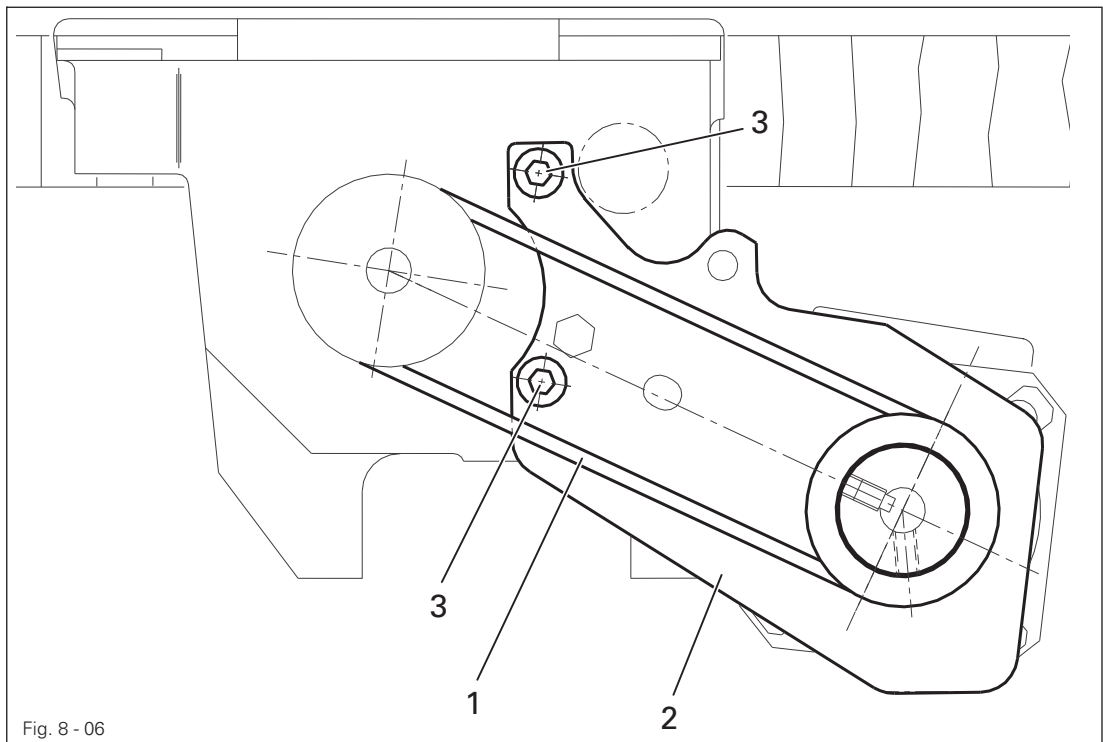
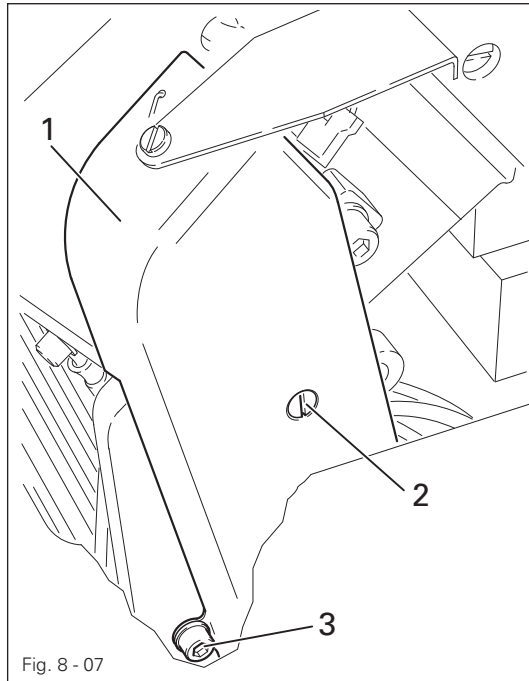


Fig. 8 - 06

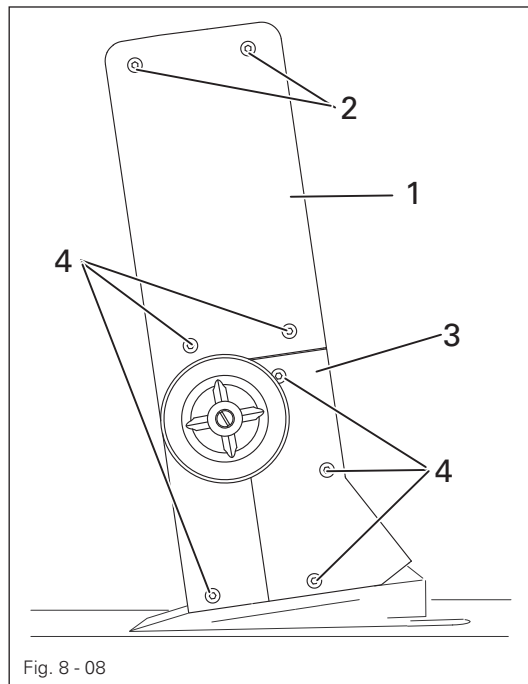
- Fit the toothed belt 1
- Pivot the motor bearing plate 2 so that the toothed belt 1 is taut.
- Tighten the screws 3 in this position.

8.02.04 Mounting the flange motor belt guard



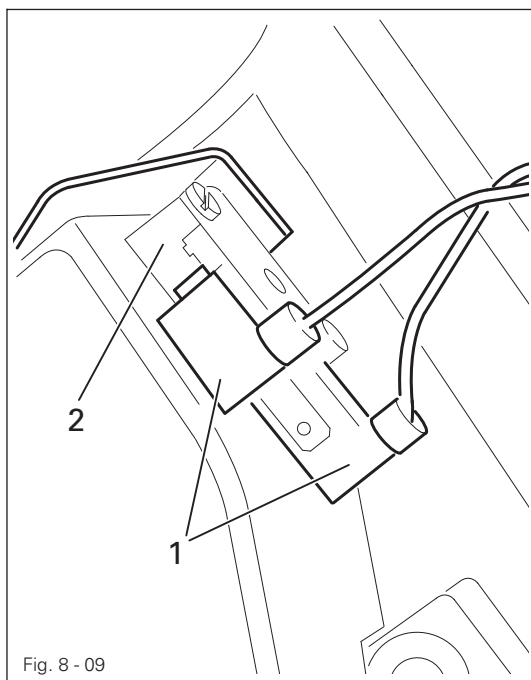
- Attach the belt guard 1 with the screws 2 and 3.

8.02.05 Mounting the machine cover



- Use the screws 2 (2x) and the screws 4 (3x) to fasten the cover 1 to the housing.
- Place the cover 3 on the cover 1 and fasten with the screws 4 (3x).

8.02.06 Connecting the safety switch



- Connect the plug 1 of the safety switch 2 as shown in Fig. 8 - 09.



If the sewing head is tilted back, the safety switch activates the start inhibitor, preventing the machine starting up if the main switch is turned on.

8.03 Connecting the plug-in connections and ground cable

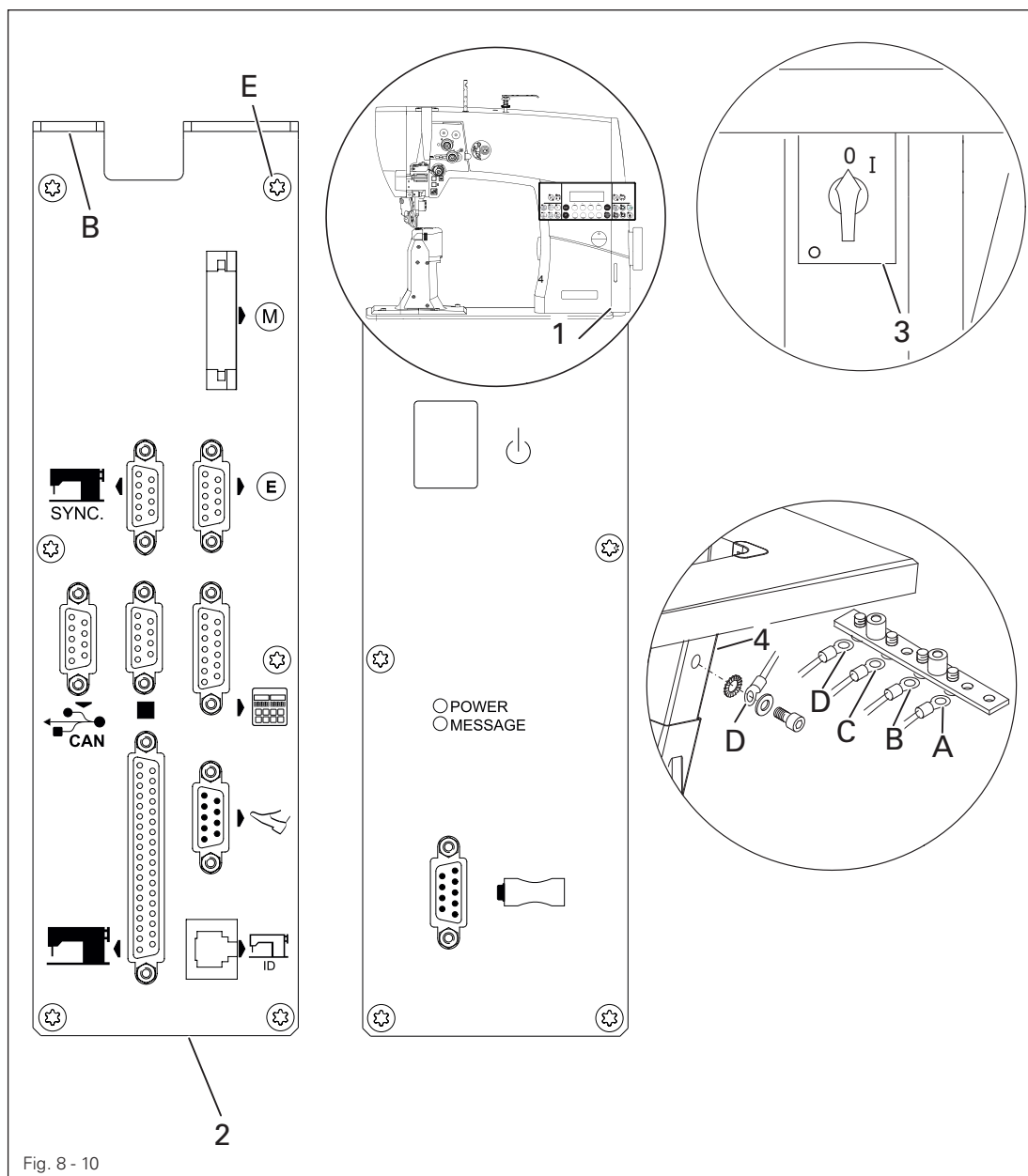
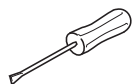


Fig. 8 - 10



- Insert all plugs on the control box 2 in accordance with their designation.
- Insert the "motor" to the bushing E and the bushing M.



Caution

Inserting the plug incorrectly can damage the control unit!

- Attach the following ground cables in order to discharge static electricity.
- Securely attach the ground cable from the sewing head 1 to ground point A.
- Securely attach the ground cable from control point B to ground point B.
- Securely attach the ground cable from the main switch 3 to ground point C.
- Securely attach the ground cable from the stand 4 to ground point D.
- Securely attached the ground cable from the motor cable M to ground point E.

8.04 Assembling the reel stand

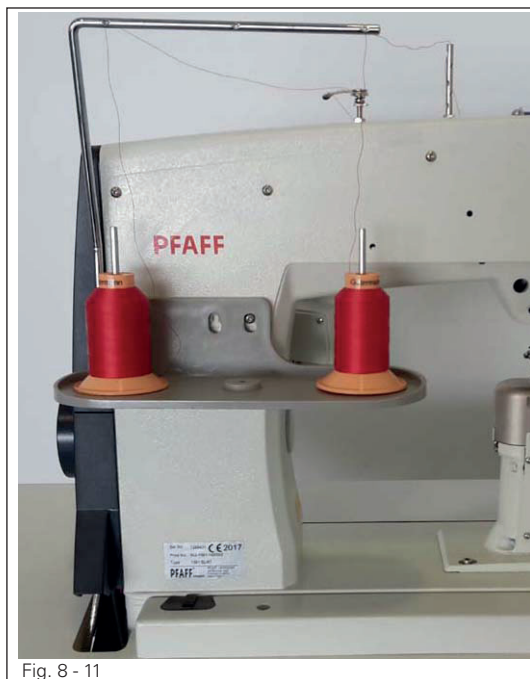


Fig. 8 - 11

- Assemble the reel stand as shown in the adjacent illustration.

8.05 Initial start-up

- Inspect the machine, particularly the electric cables, for any damage.
- Clean the machine thoroughly and then oil it, see also **Chapter 10 Maintenance and Care**.
- Arrange for technical staff to check whether the machine's motor may be operated at the existing mains voltage and whether it is connected properly.



Never operate the machine if there are any differences.



The machine must only be connected to a grounded socket!



Arrange for the home position of the machine drive to be verified by certified technicians before the initial start-up! Arrange for settings to be carried out by technicians where required (see **Chapter 4.4** of the drive service manual).

8.06 Switching the machine on / off

- Switch the machine on (see **Chapter 7.01 Main switch**).

8.07 Machine drive home position

- See **Chapter 4.4** of the drive service manual

8.08 Checking the start inhibitor function

- Switch on the machine at the main switch and move the sewing head.
The error message "WRN: 3109" must appear in the control panel.
- If the message does not appear, check the safety switch setting as explained in **Chapter 8.02.06 Connecting the safety switch**.
- Right the sewing head and acknowledge the error message.
The machine is ready for operation again.

9

Set-up



Observe and comply with all regulations and instructions in this instruction manual. Pay particular attention to all safety regulations!



All set-up work may only be carried out by appropriately instructed personnel. Disconnect the machine from the electricity mains for all set-up work by operating the main switch or by removing the mains plug!

9.01

Inserting the needle

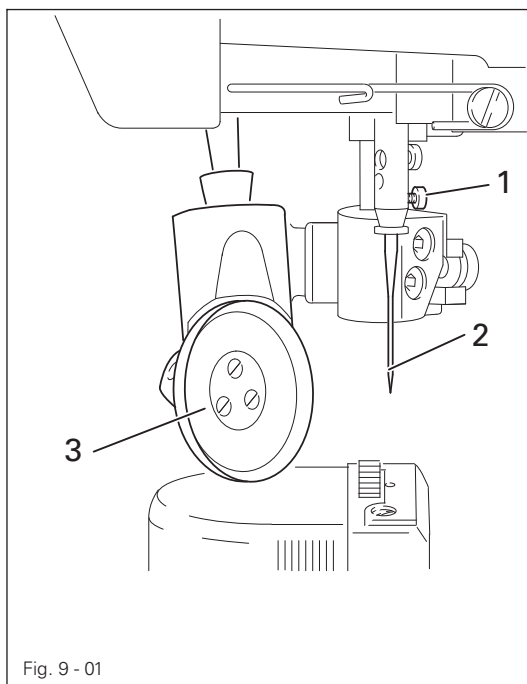


Fig. 9 - 01

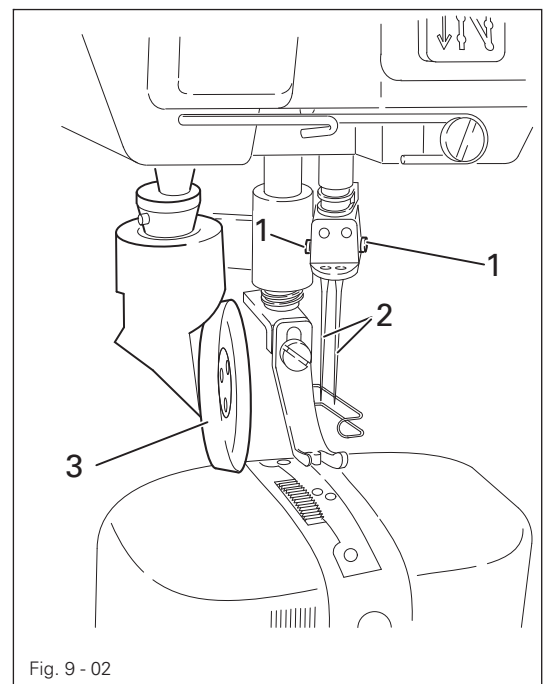


Fig. 9 - 02



Switch off the machine!
Risk of injury due to accidental machine start-up!



Only use needles of the system intended for the machine, see **Chapter 3 Technical Data!**

PFAFF 571 and 591

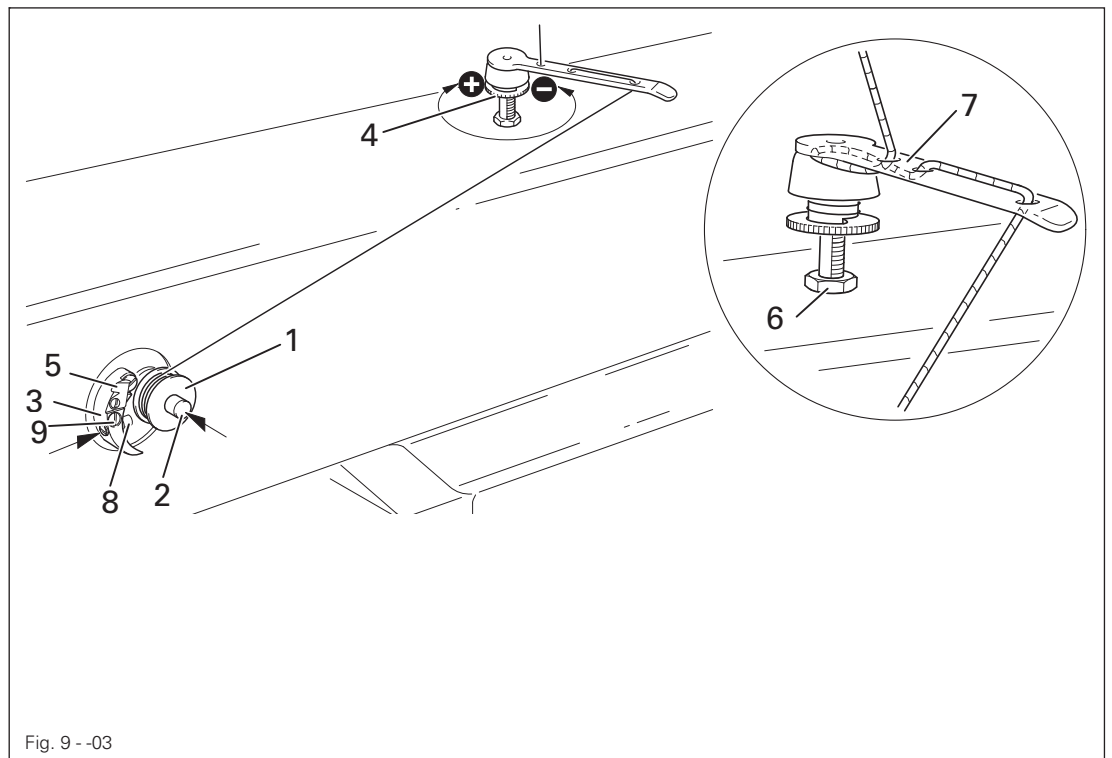
- Raise and fold out the roller presser 3.
- Bring the needle bar to the top position.
- Loosen the screw 1 and insert the needle 2 until you feel it stop. The long groove must point to the **right** with the PFAFF 571 and to the **left** with the PFAFF 574.
- Tighten the screw 1.

PFAFF 574

- Raise and fold out the roller presser 3.
- Bring the needle bar to the top position.
- Loosen the screws 1 and insert the needles 2 until you feel them stop. The long groove of the left needle must point to the right and that of the right needle must point to the left.
- Tighten the screws 1.

9.02

Winding the bobbin thread, adjusting the thread tension



- Fit the empty bobbin 1 onto the bobbin winder spindle 2 with the rest thread chamber on the outside.
- Thread in the thread as shown in Fig. 9 - 03 and wind it round the bobbin 1 a few times in an anti-clockwise direction.
- Switch on the bobbin winder by pressing the bobbin winder spindle 2 and the lever 3 simultaneously.



The bobbin fills up during sewing.



If the machine is only run for bobbin winding (without sewing), a bobbin case must be fitted in the hook.

Otherwise a jammed thread may damage the hook!

- The tension of the thread on the bobbin 1 can be adjusted with the knurled screw 4.
- The bobbin winder stops automatically when the bobbin 1 is sufficiently full.
- Remove the filled bobbin 1 and cut the thread with the knife 5.
- The fill amount of the bobbin 1 can be adjusted with the pin 8 (loosen the screw 9 and tighten it again)

If the thread is wound unevenly:

- Loosen the nut 6.
- Turn the thread guide 7 accordingly.
- Tighten the nut 6

9.03 Removing / inserting the bobbin case

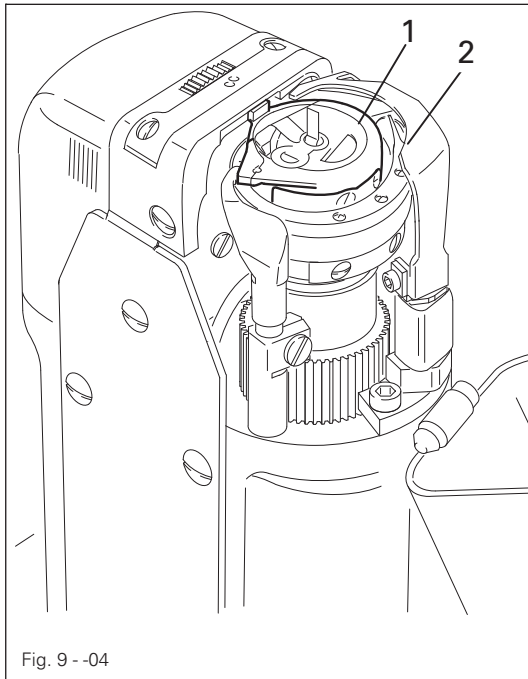


Fig. 9 - -04



Switch off the machine!
Risk of injury due to accidental machine start-up!

Removing the bobbin case:

- Bring the take-up lever to its top position.
- Open the post cover, raise the lever 1 and remove the bobbin case 2.

Inserting the bobbin case:

- Press the bobbin case 2 until you feel it snap into the bobbin case base.
- Move the lever 1 and close the post cover.



Do not operate the machine with an open post cover!
Risk of injury due to moving parts!

9.04 Inserting the bobbin case / adjusting the bobbin thread tension

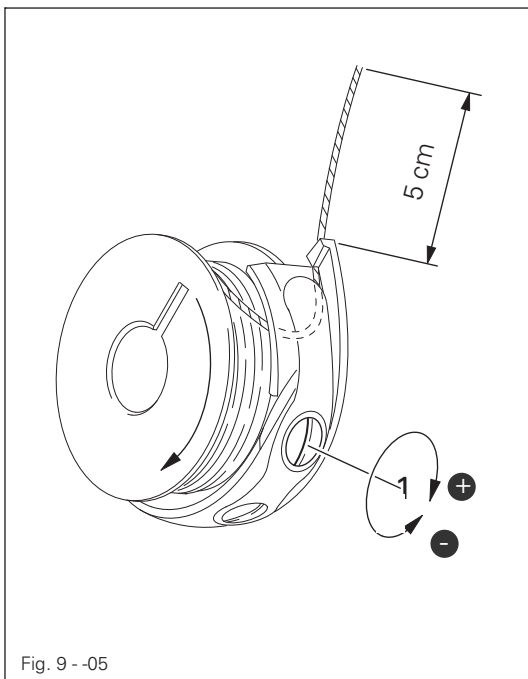


Fig. 9 - -05

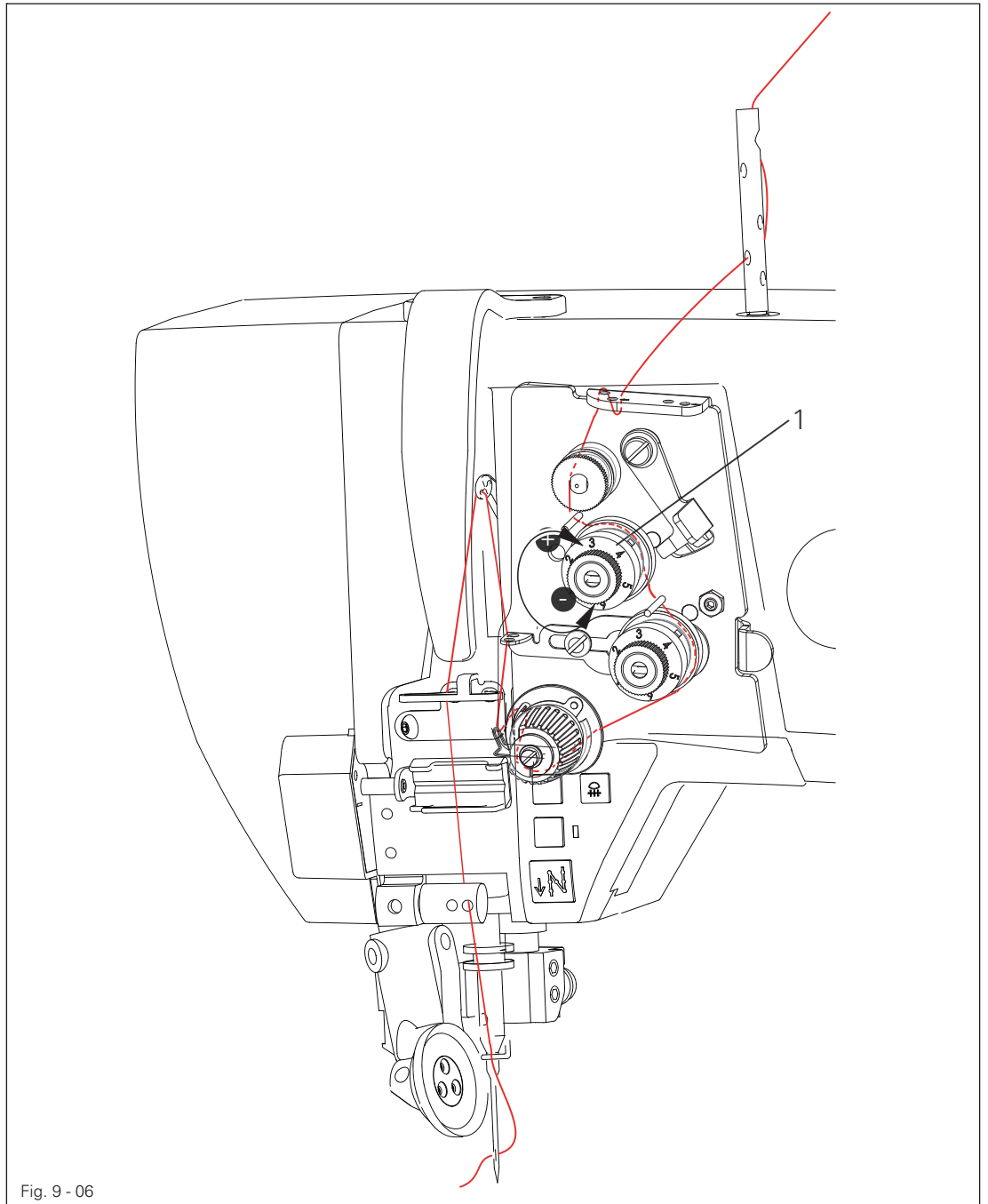


Switch off the machine!
Risk of injury due to accidental machine start-up!

- Insert the bobbin as shown in Fig. 9 - 05.
- When the thread is drawn off, the bobbin must turn in the direction shown by the arrows.
- Adjust the thread tension by turning the screw 1.

9.05 Threading the needle thread / adjusting the needle thread tension

(with the PFAFF 571 and 591)



Switch off the machine!
Risk of injury due to accidental machine start-up!

- Thread the needle thread as shown in Fig. 9 - 06. Please ensure that the PFAFF 571 needle is threaded from **right to left** and that of the PFAFF 591 is threaded from **left to right**.
- Adjust the needle thread tension by turning the knurled thumb screw 1.

9.06

Threading the needle thread / adjusting the needle thread tension
(with the PFAFF 574)

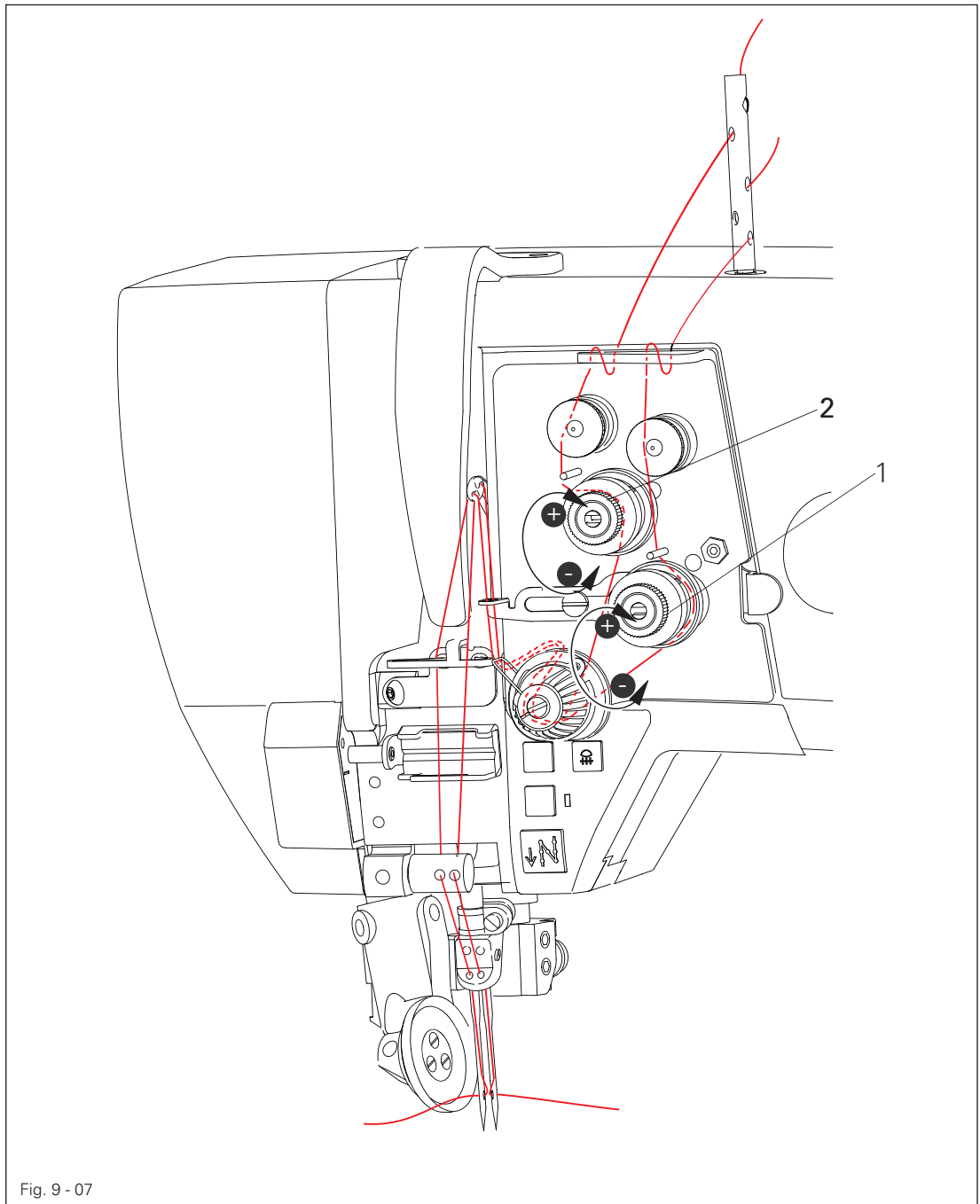


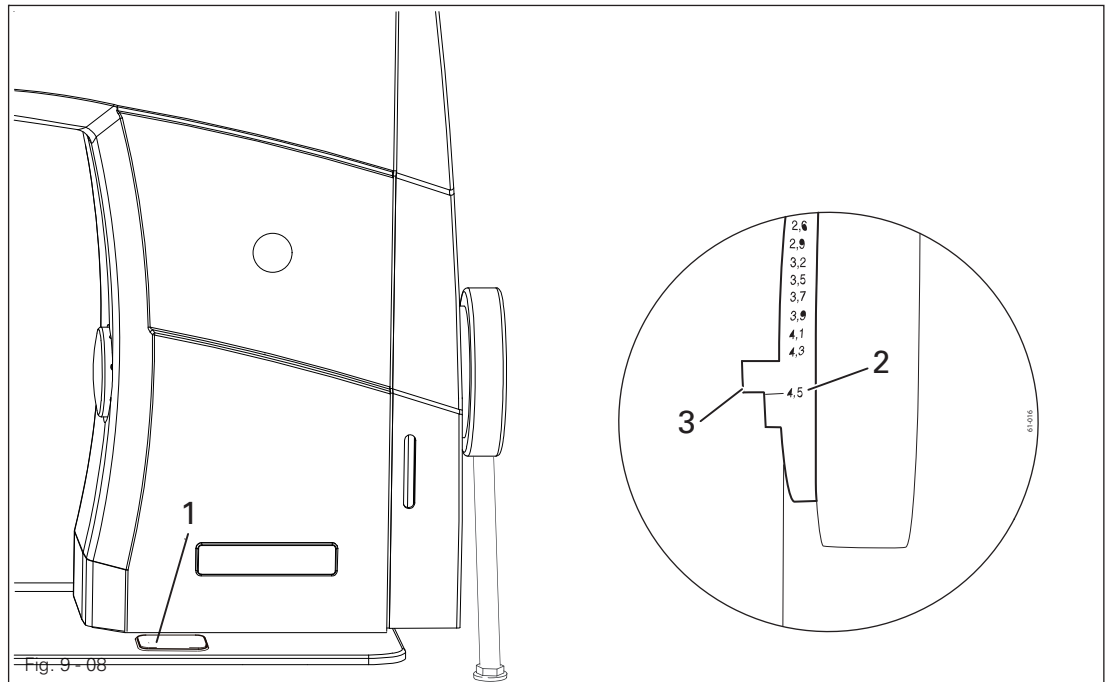
Fig. 9 - 07



Switch off the machine!
Risk of injury due to accidental machine start-up!

- Thread the needle thread as shown in Fig. 9 - 07. Please ensure that the right needle is threaded from the left and the left needle is threaded from the right.
- Adjust the needle thread tension by turning the knurled thumb screw 1 (right needle or 2 left needles).

9.07 Adjusting the stitch length



- Press the button **1** and turn the hand wheel simultaneously until the reverse-feed lever engages.
- Press and hold the button **1** and turn the hand wheel forwards or backwards until the desired stitch is indicated on the scale **2** opposite the lower edge **3** of the belt guard recess.

9.08 Setting the stitch counting function for the bobbin thread control

For the description please refer to the separate instruction manual for the drive, see **Chapter 5.3.1 Setting the bobbin-stitch counter.**

10 Maintenance and Care

10.01 Maintenance intervals

Cleaning	daily, several times if in continuous operation
Clean the hook area	daily, several times if in continuous operation
General oiling	daily, before start-up
Oil the hook	daily, before start-up
Oil level (thread lubrication / hook lubrication)	twice a week
Lubricate the bevel gears.....	once as year



These maintenance intervals are based on an average running time of a single shift production shop. Shorter maintenance intervals are recommended for increased running times.

10.02 Cleaning the machine

The required cleaning cycle for the machine depends on the following factors:

- Single or multi-shift operation
- Dust formation caused by the workpieces

Optimal cleaning instructions can therefore only be determined on a case-by-case basis.



Disconnect the machine from the electricity mains for all cleaning work by shutting off the main switch or removing the mains plug! Risk of injury due to accidental machine start-up!

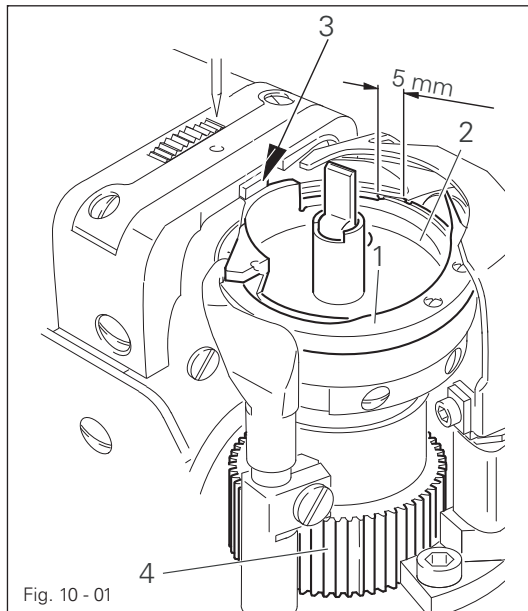


Fig. 10 - 01

The following tasks are recommended during single shift operation to avoid operational errors:

Clean the hook area

- Clean the hook area with a brush

Clean the hook

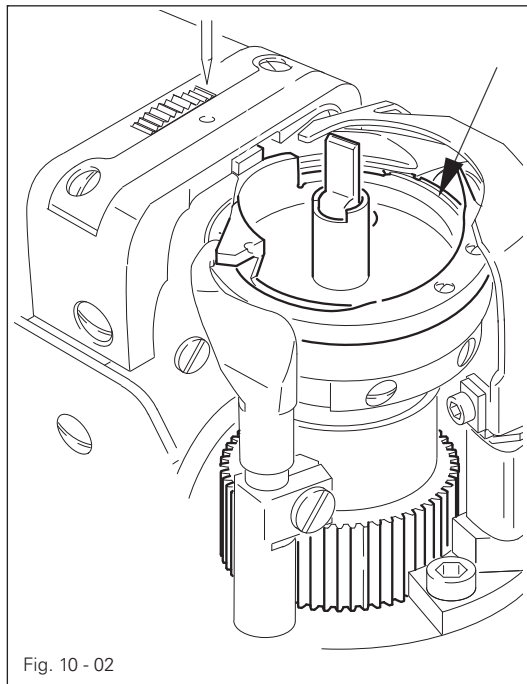
- Open the post cover.
- Bring the needle bar to the top position.
- Remove the bobbin case sewing head with bobbin.
- Unscrew the hook gib 1.
- Turn the hand wheel until the tip of the bobbin case 2 has penetrated approx. 5 mm into the groove of the hook race.
- Remove the bobbin case and clean the hook race with kerosene.

- Make sure that the horn 3 engages in the groove of the stitch plate when inserting the bobbin case.
- Screw on the hook gib 1.
- Insert the bobbin case with bobbin.
- Clean the pinion 4.
- Close the post cover.



Always operate the machine when the post cover is closed!
Risk of injury from the rotating hook!

10.03 Oiling the hook

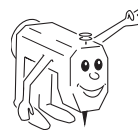


Switch off the machine!
Risk of injury due to accidental machine start-up!

- Open the post cover.
- Bring the needle bar to the top position.
- Add a few drops of oil onto the hook race at initial start-up or if the machine has been standing still for a prolonged period of time (see arrow).

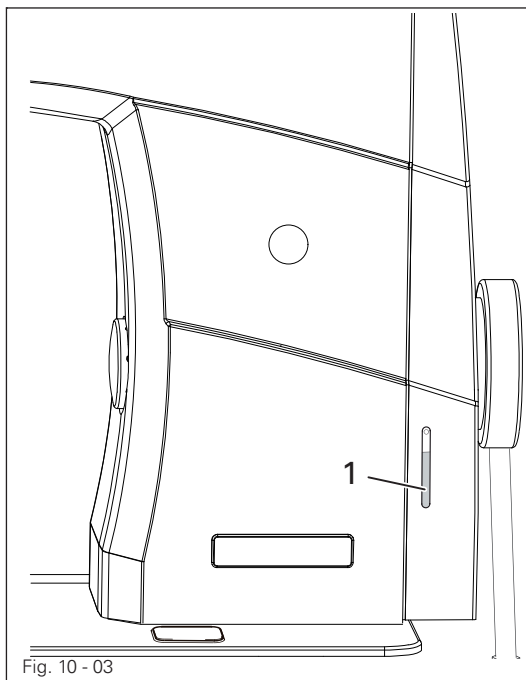


Only use oil with a centre viscosity of $22.0 \text{ mm}^2/\text{s}$ at $40 \text{ }^\circ\text{C}$ and a density of 0.865 g/cm^3 at $15 \text{ }^\circ\text{C}$!



We recommend PFAFF sewing machine oil, order no. 280-1-120 144.

10.04 Oil reservoir for hook lubrication



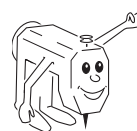
Check the oil level before every start-up.

Oil must always be visible in the sight glass 1

- Add oil through hole above the sight glass as needed.

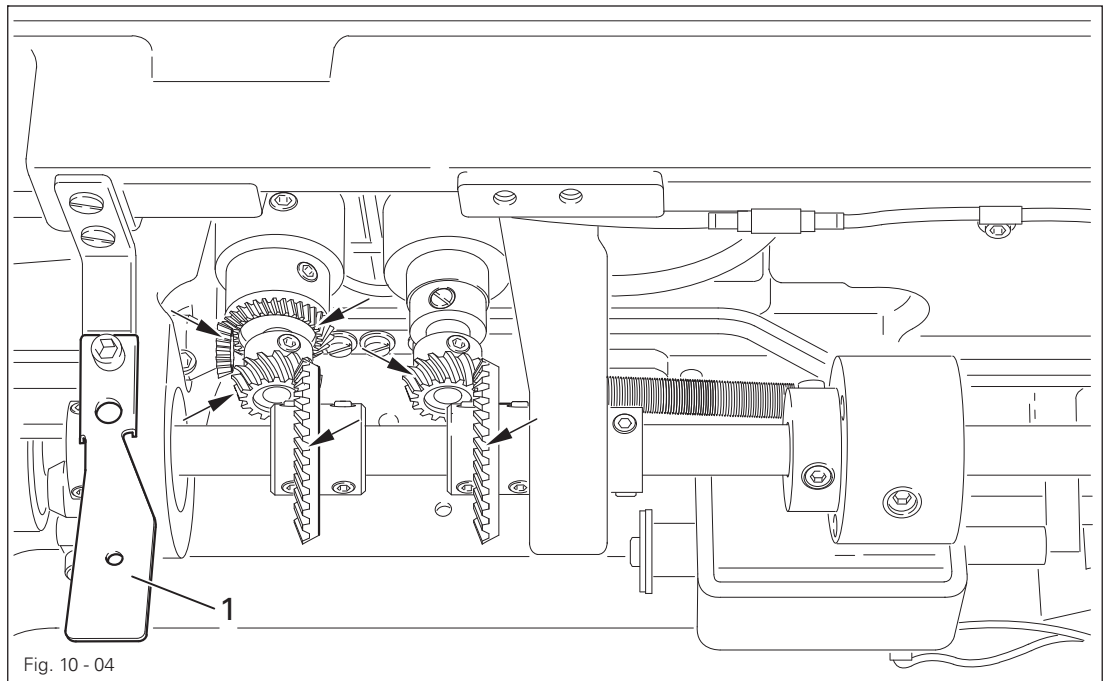


Only use oil with a centre viscosity of $22.0 \text{ mm}^2/\text{s}$ at $40 \text{ }^\circ\text{C}$ and a density of 0.865 g/cm^3 at $15 \text{ }^\circ\text{C}$!



We recommend PFAFF sewing machine oil, order no. 280-1-120 144.

10.05 Lubricating the bevel gears



Switch off the machine!
Risk of injury due to accidental machine start-up!

- Fresh grease should be applied to all bevel gears once a year.
- Tilt back the machine sewing head and let it rest on the sewing head support.

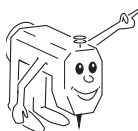


Fig. 10-04 shows the PFAFF 574 bevel gears.

- To return the machine sewing head to its upright position, press the anti-tipping device 1 backwards and return the machine sewing head to its upright position using both hands!

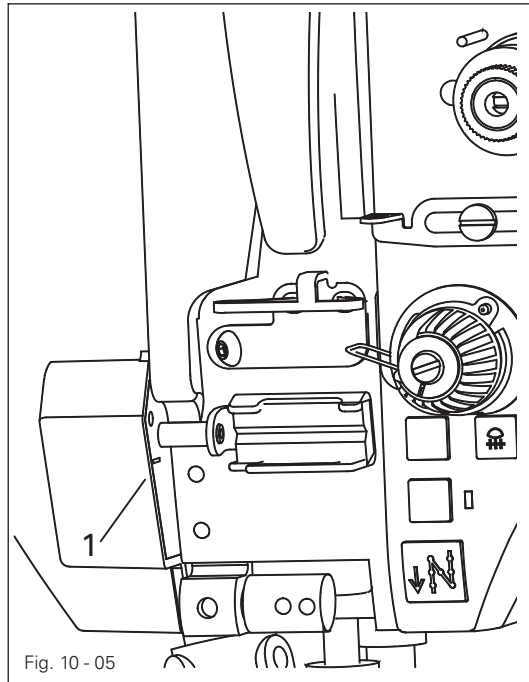


Return the machine sewing head to its upright position using both hands!
Risk of injury by crushing between the machine sewing head and the table top!



We recommend PFAFF sodium soap grease with a dripping point of approx. **150 °C.**
Order no.: 280-1-120 243.

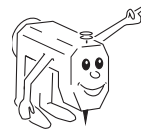
10.06 Topping up the thread lubrication oil reservoir



Check the oil level before every start-up.

The oil reservoir 1 must always have oil in it.

● Add oil through hole as needed



We recommend PFAFF thread lubricating oil, order no. 280-1-120 217.

10.07 Parameter settings

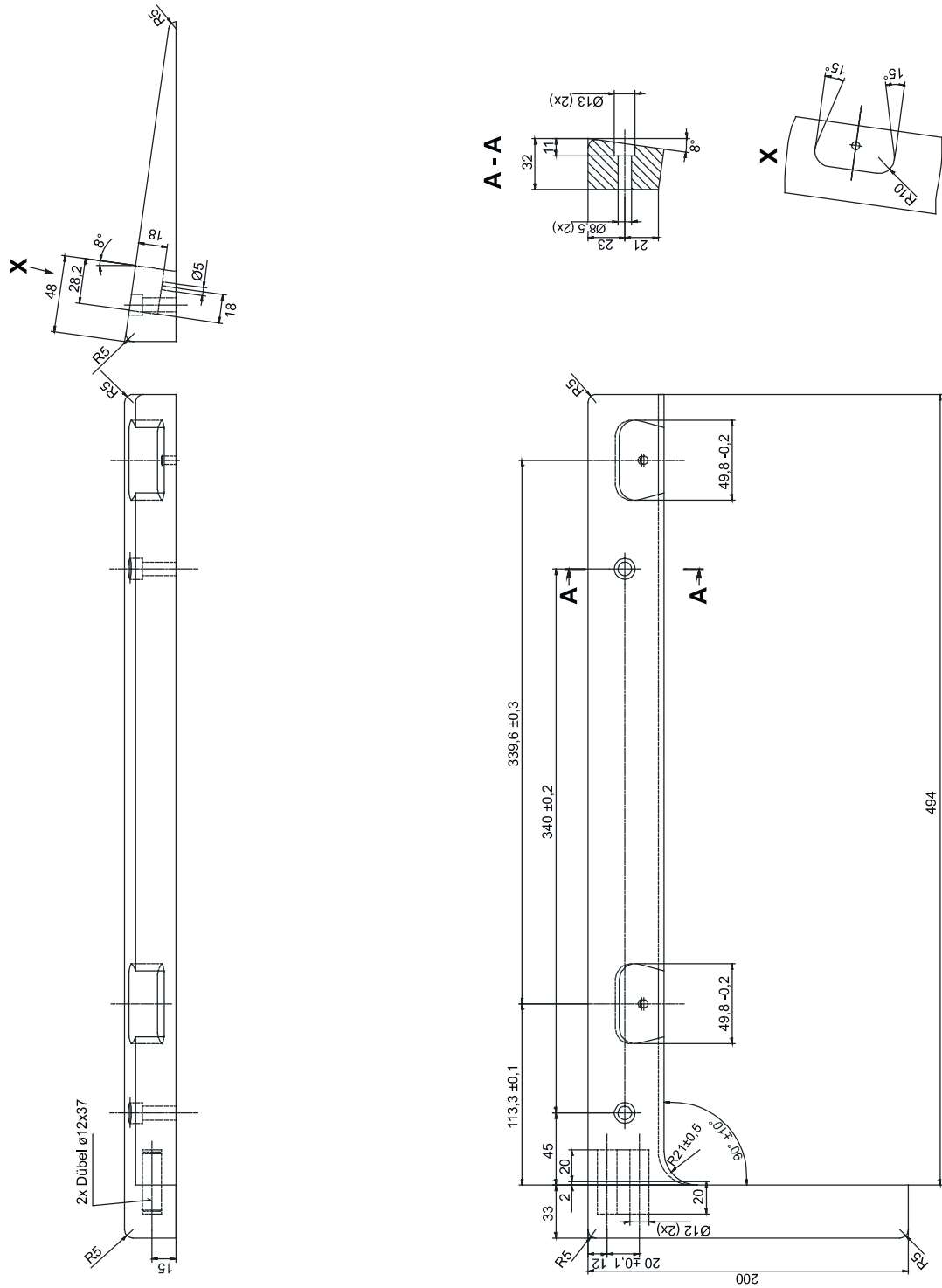


Parameter settings are described in the separate **parameter list** for the drive and may only be changed by qualified technicians.

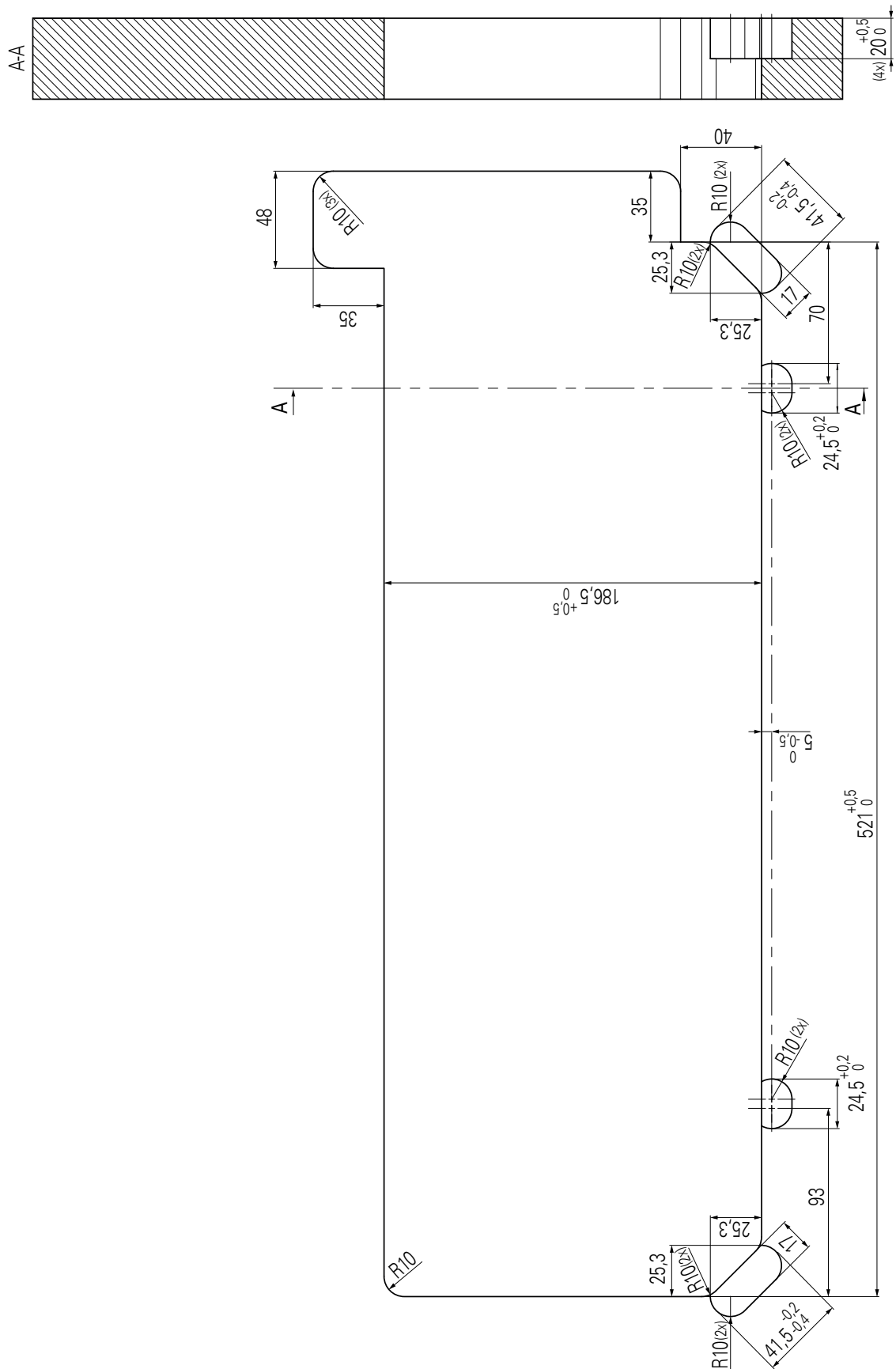
Tilt base

11 Table Top

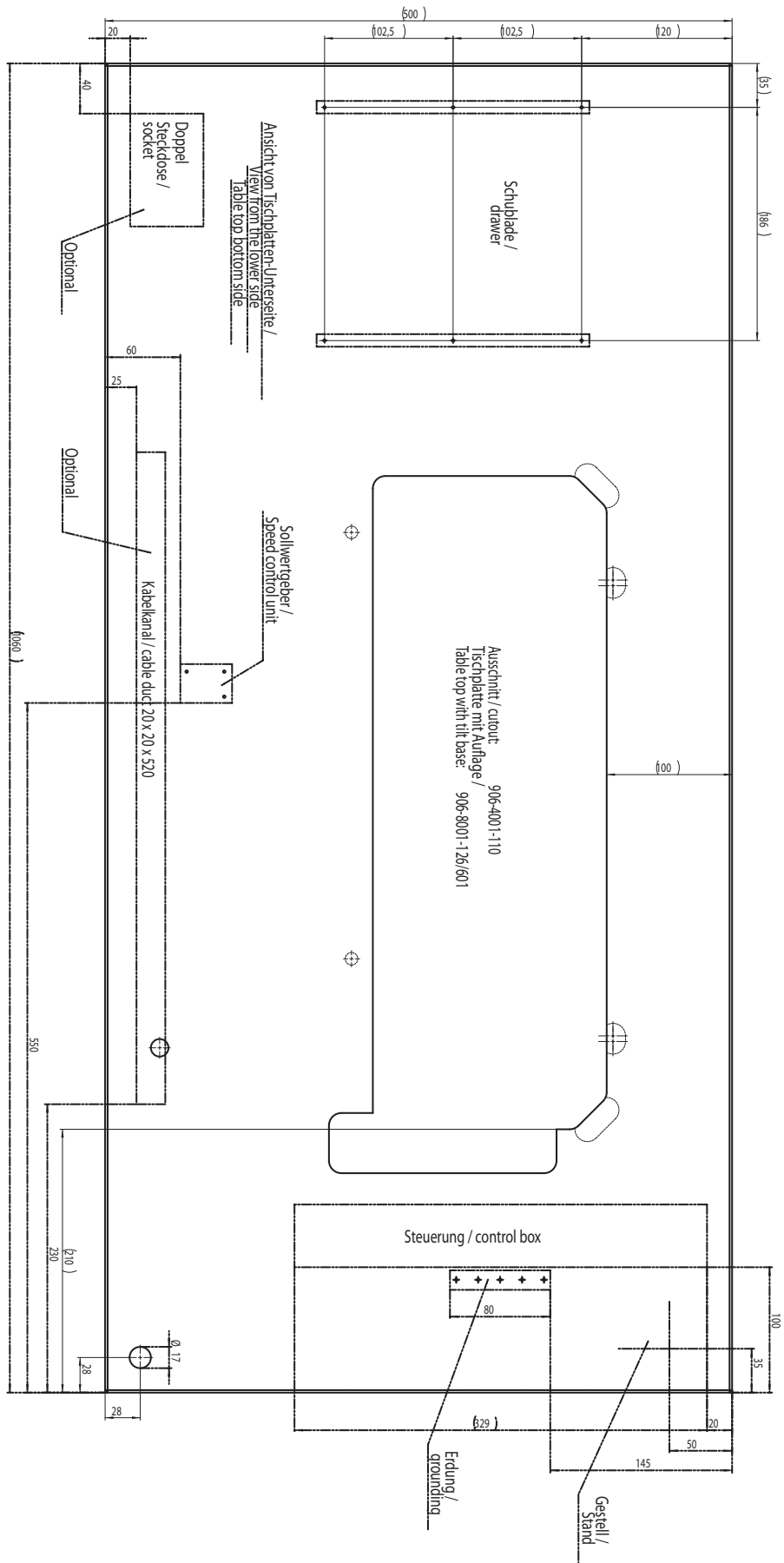
11.01 Tilt base



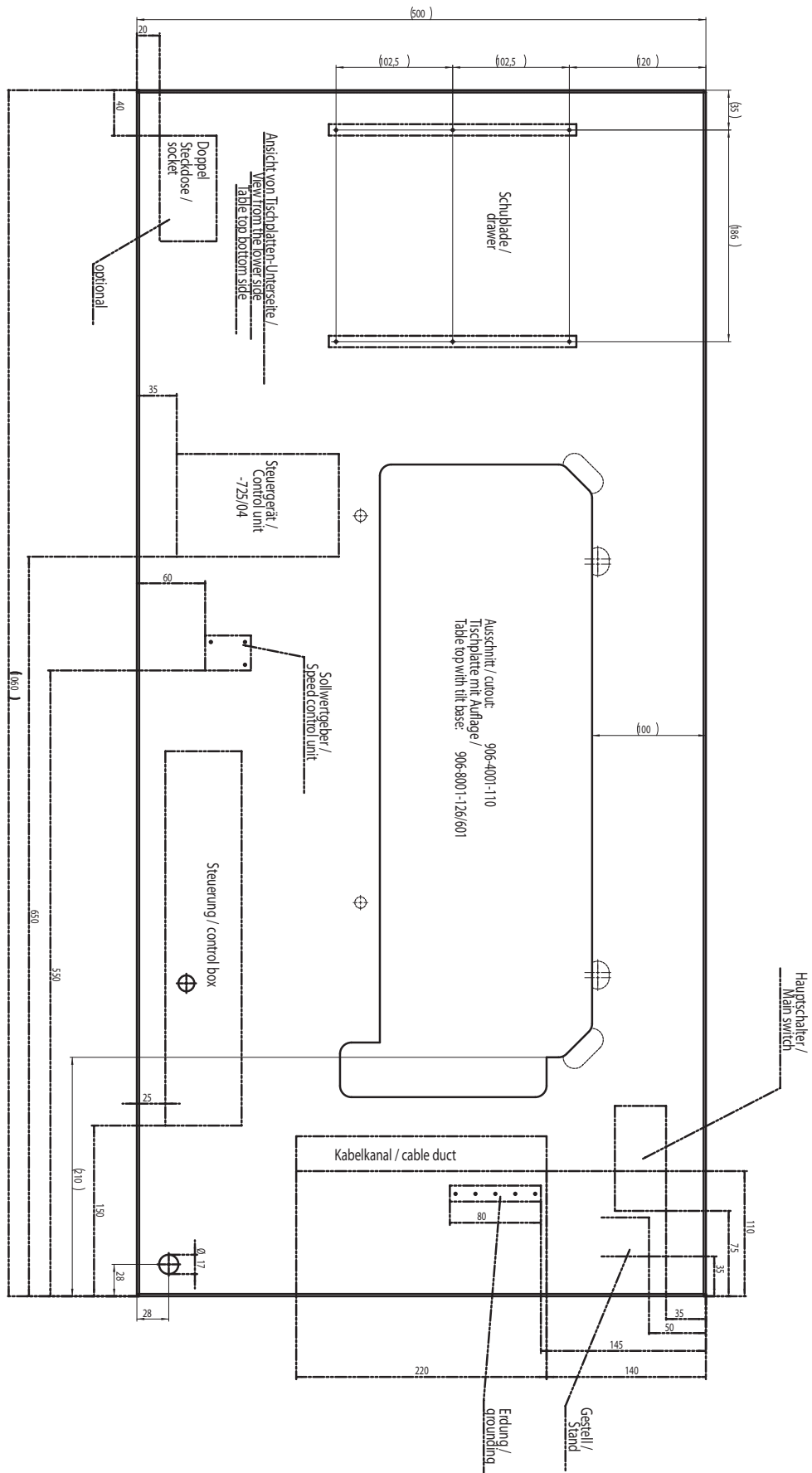
11.02 Table top cutout



11.03 Table top assembly without -725/..



11.04 Table top assembly with -725/..



12

Wearing Parts



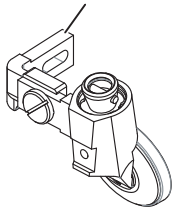
This list shows the most important wearing parts.

A detailed parts list for the complete machine can be downloaded at www.pfaff-industrial.de/de/service-support/downloads/technical As an alternative to the Internet download, the parts list can also be requested as a hard copy under order no. 296-12-19 398.

PFAFF 574

PFAFF 571; 591

91-363 048-93/001 Roller presser, with 25 mm dia.
 91-363 050-93/001 Roller presser, with 30 mm dia.
 91-363 052-93/001 Roller presser, with 35 mm dia.

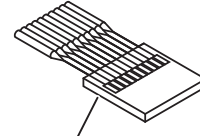


91-363 119-05 (Pfaff 571; 591)
 91-363 074-05 (Pfaff 574)

11-108 093-15
 91-173 664-15



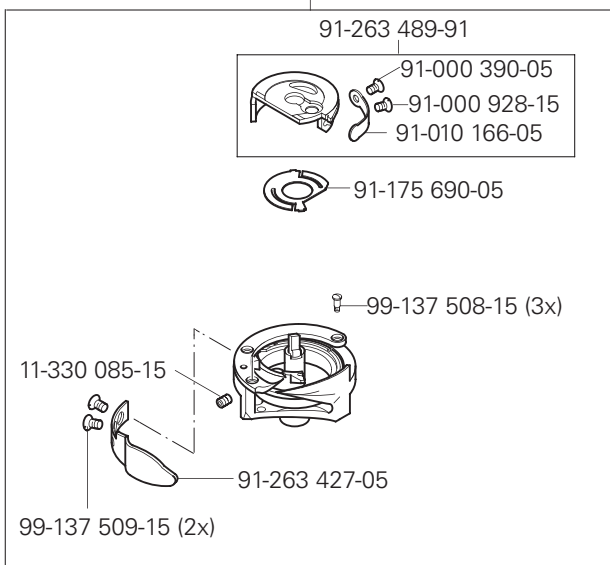
91-165 344-15 (2x)



PFAFF 571, 591
 System 134

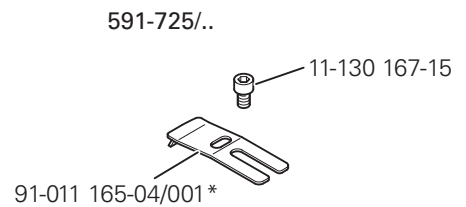
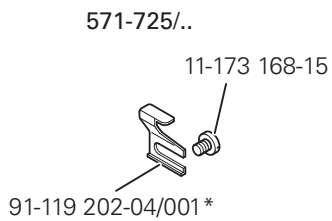
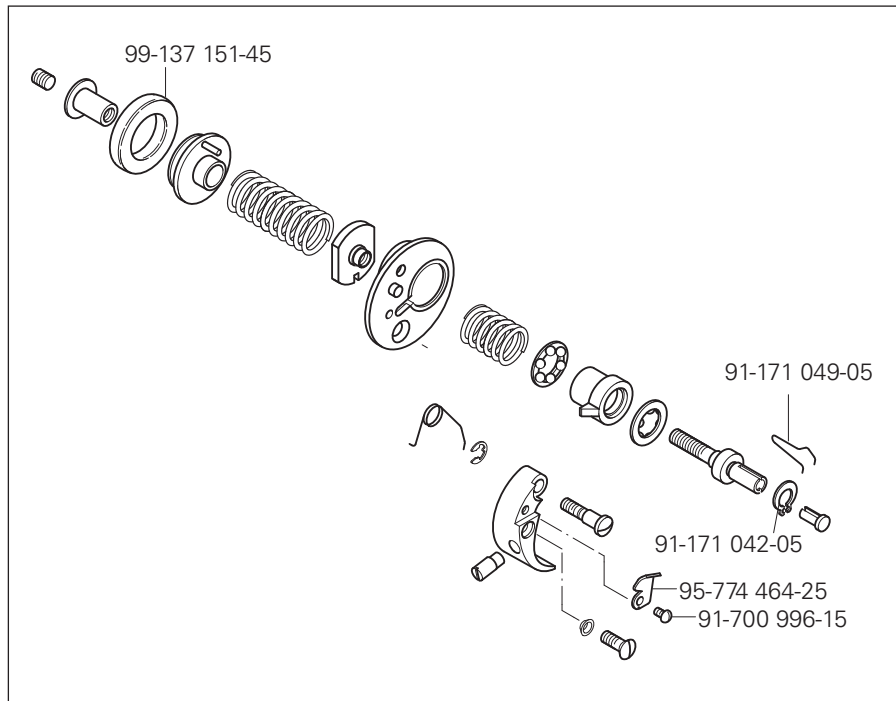
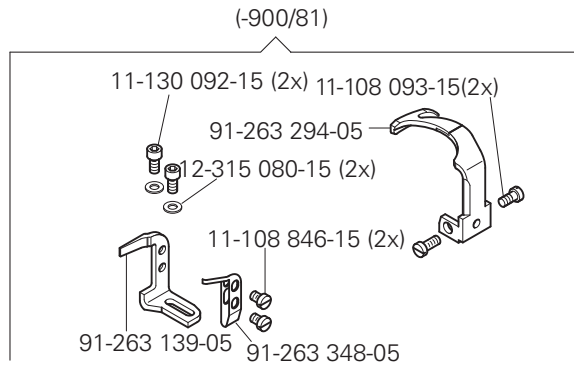
PFAFF 574
 System 134-35

91-263 490-91 B
 91-263 495-91 C



95-774 789-05





* More knives see parts list



Europäische Union
Wachstum durch Innovation – EFRE

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