

# 1181 1183

## INSTRUCTION MANUAL

This instruction manual applies to machines  
from the following serial numbers onwards:

# 6 500 122 →



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



The adjustment manual for the machines can be downloaded free of charge from the internet address

**[www.pfaff-industrial.com/pfaff/de/service/downloads](http://www.pfaff-industrial.com/pfaff/de/service/downloads)**

As an alternative to the internet download the adjustment manual can also be ordered in book form under part no. **296-12-19 202/002**.

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**PFAFF Industriesysteme  
und Maschinen AG**

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## **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 PFAFF agent.

## **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 jewellery 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!

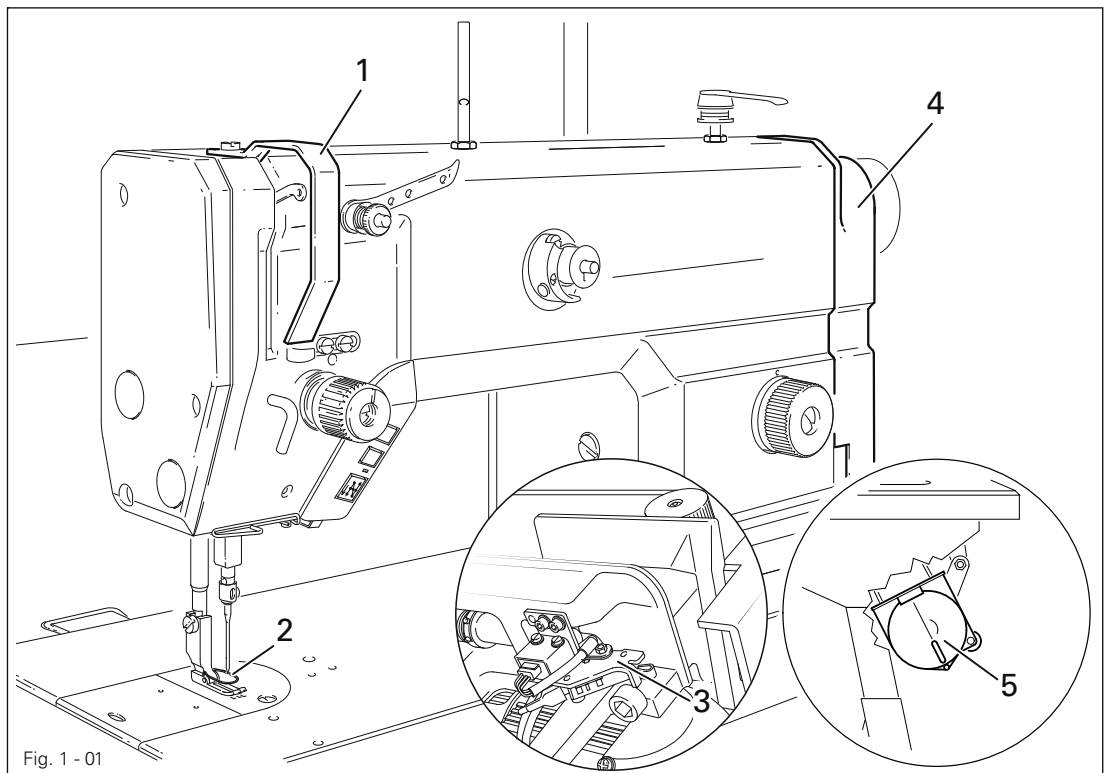


Fig. 1 - 01



Do not run the machine without take-up lever guard **1**!  
Danger of injury by moving take-up lever!



Do not run the machine without finger guard **2**!  
Danger of injury by up and down movement of needle!



Do not operate machines with integrated motor without start inhibitor **3**!  
Danger of injury if the machine is started accidentally!



If an external motor is used, do not operate the machine without the belt guards **4** and **5**!  
Danger of injury by the drive belt!



## 2

### Proper use

The **PFAFF 1181** is an single-needle ultra-high-speed seamer with compound feed

The **PFAFF 1183** is an single-needle ultra-high-speed seamer with drop feed

These machines are used in the industry for sewing lockstitch seams.



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 PFAFF 1181, PFAFF 1183

Stitch type: .....301 (lockstitch)

Needle system: ..... 134 or 134 KK on subclass -731/01

Needle size in 1/100 mm:

Version A: ..... 60 - 70

Version B: ..... 80 - 100

Version CN: ..... 110 - 120

Effective balance wheel diameter: .....65 mm

Fabric clearance: .....9 - 13 mm

Clear workspace width: .....260 mm

Clear workspace height: ..... 125 mm

Bed-plate dimensions: ..... 476 x 177 mm

Sewing head dimensions:

Length: ..... approx. 550 mm

Width: ..... approx. 180 mm

Height (above table): ..... approx. 300 mm

Max. stitch length:

Version A: .....3,0 mm

Version B: .....4.5 mm

Version CN: .....6.0 mm

Max. speed PFAFF 1181/ 1183

Version A and B: .....5500 spm ♦

Subclass -731/01: .....4500 spm ♦

Subclass -8/44: .....3000 spm ♦

Version CN: .....3800 spm ♦

Needle bar stroke: ..... 30 or 36 mm

Motor data: ..... see motor specification plate

Noise data:

Emission sound level at workplace at a speed of 4400 spm: .....  $L_{pA} = 80.0 \text{ dB(A)}$  ■

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

▲ Subject to technical alterations

♦ 3,800 s.p.m. with 36 mm needle bar stroke

■  $K_{pA} = 2,5 \text{ dB}$

3.02 Versions and subclasses

Version A: .....for sewing light materials  
Version B: ..... for sewing medium materials  
Version CN: ..... for sewing medium-heavy materials

Work aids:

Subclass -731/01 ..... edge trimmer  
Subclass -900/24..... thread trimmer  
Subclass -909/14 .....Thread trapper  
Subclass -910/06 ..... automatic foot lift  
Subclass -911/37 ..... automatic back-tacking mechanism

### 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.

### 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:



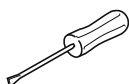
Note, information



Cleaning, care



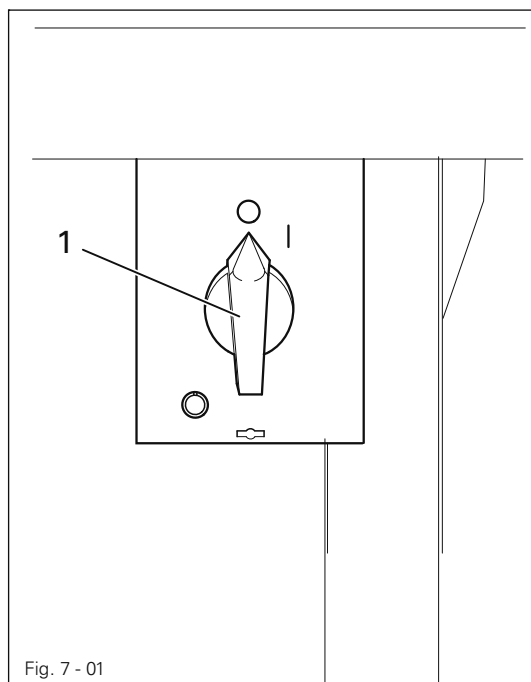
Lubrication



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

## 7 Controls

### 7.01 On/off switch

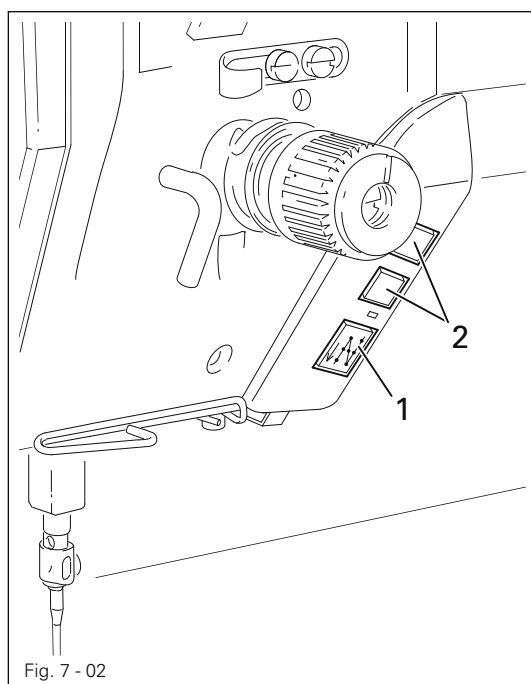


- The power supply to the machine is switched on or off by turning switch 1.



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

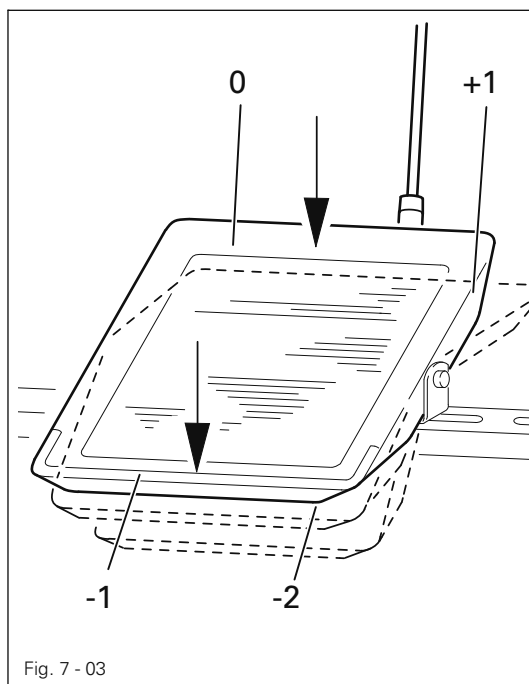
### 7.02 Keys on the machine head (only for machines with -911/..)



- As long as key 1 is pressed during sewing, the machine sews in reverse.
- Keys 2 can be used for parameter settings (see motor instruction manual).

## 7.03

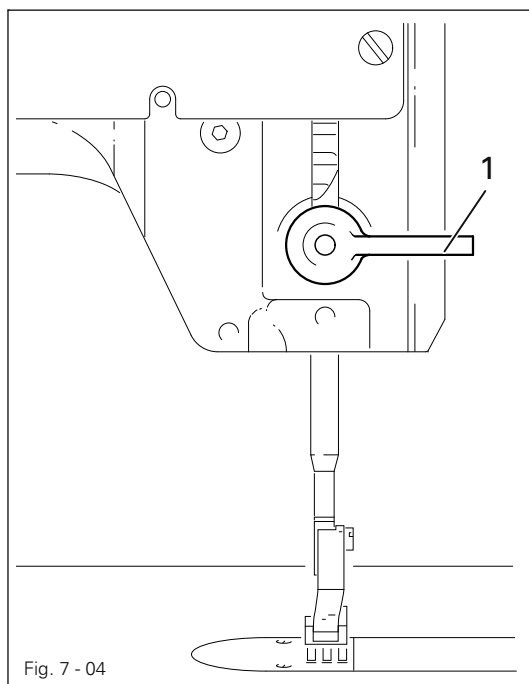
### Pedal



- With the on/off switch on
  - 0 = Machine stop
  - +1 = Sew
  - 1 = Raise presser foot (for machines with -910/06)
  - 2 = Trim thread (for machines with -900/24)

## 7.04

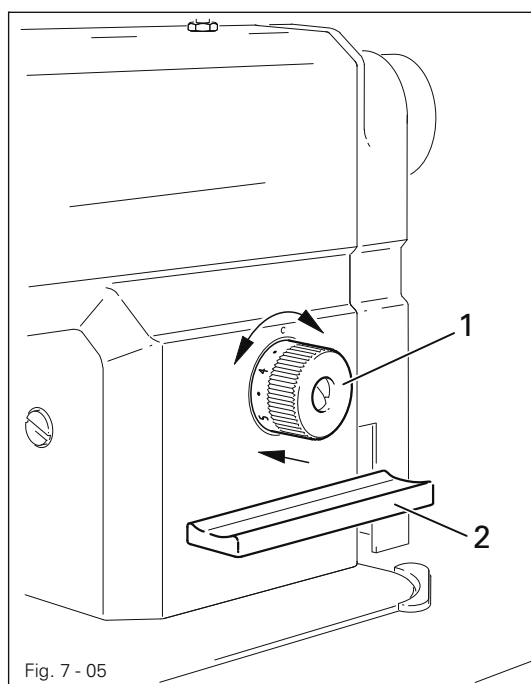
### Lever for lifting the presser foot



- The presser foot is raised by turning lever 1.

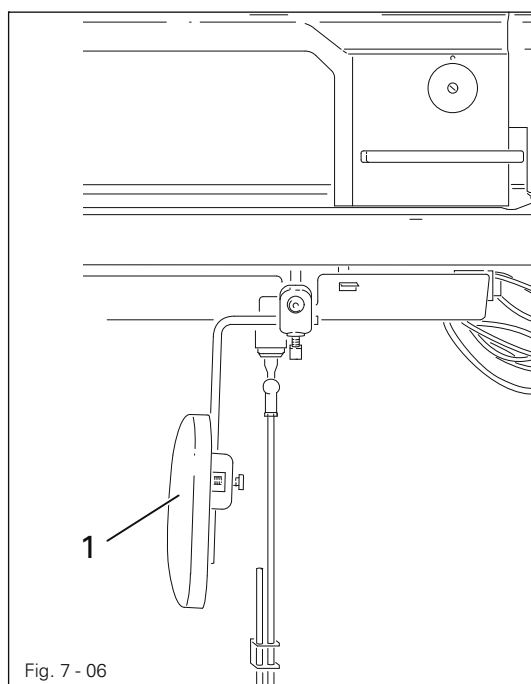


## 7.05 Feed regulator disk / Reverse feed lever



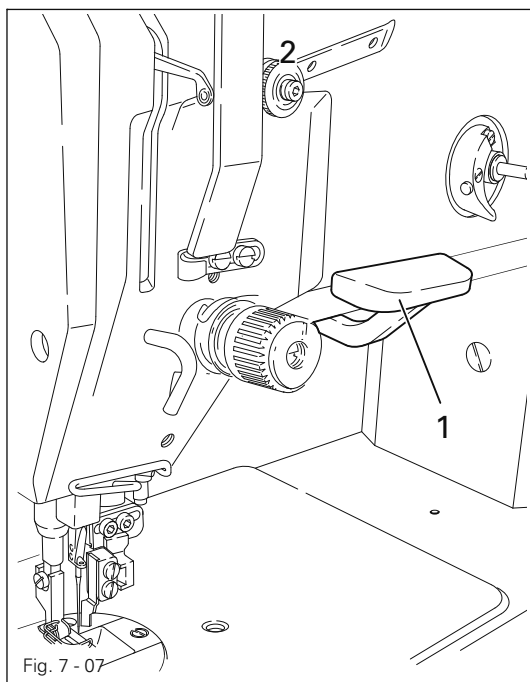
- The stitch length can be set by simultaneously applying pressure to disk 1 and turning it to the desired setting.
- For reverse sewing press lever 2.

## 7.06 Knee lever



- By pressing the knee lever 1 in the direction of the arrow, the presser foot is raised.

### 7.07 Edge trimmer -731/01



Do not touch the running motor! Danger of injury!

- By pressing or raising key 1, the edge trimmer is switched on or off.

### 7.08 Control panel

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

## 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

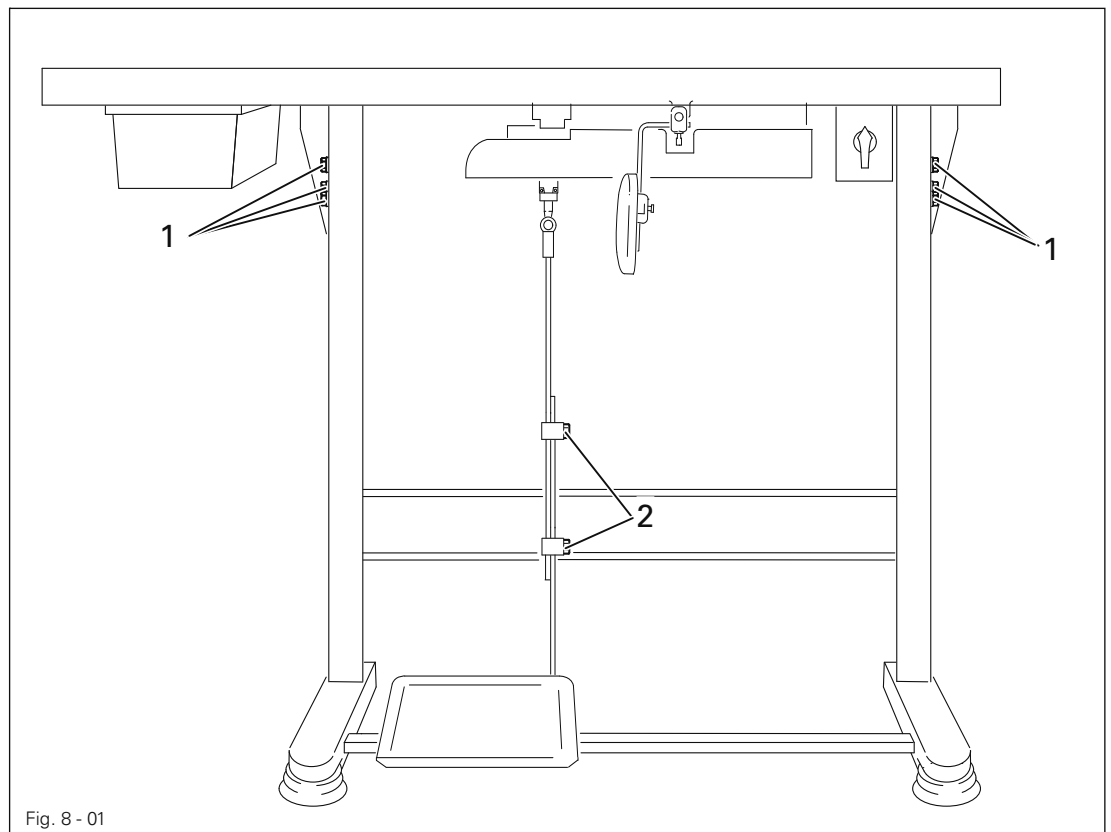


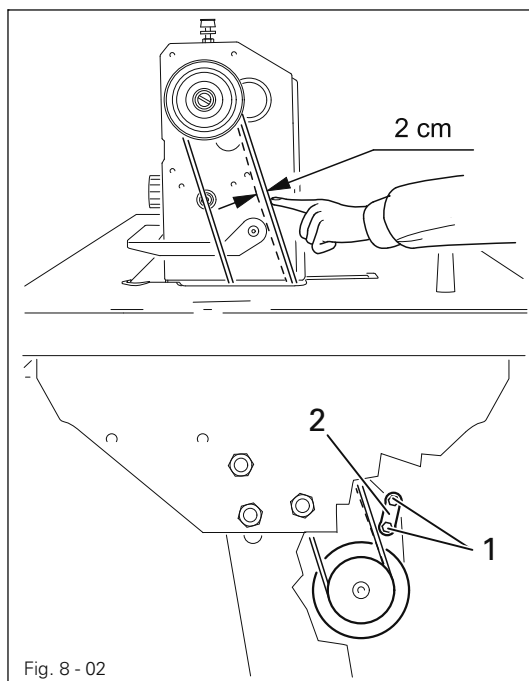
Fig. 8 - 01

- 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 Adjusting the V-belt tension



This step is eliminated for integrated sewing motors.



- Loosen nuts 1.
- Tighten the V-belt with belt take-up hanger 2.
- Tighten nuts 1.

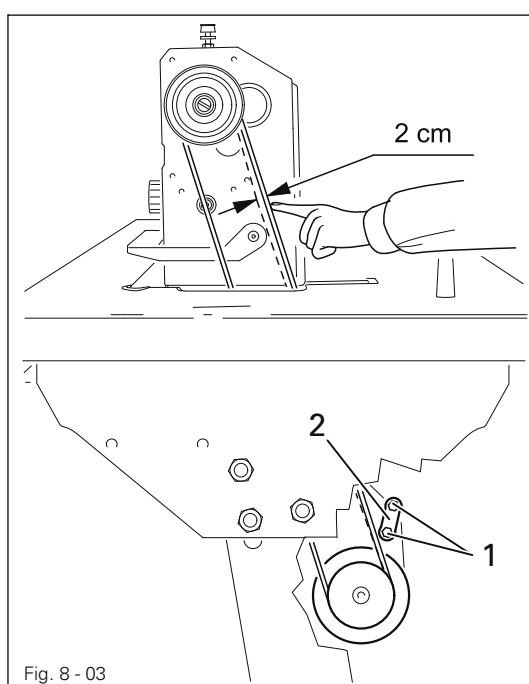


IA PFAFF motor is shown in Fig. 8-02. If another motor is used, carry out this step according to the instructions in the motor instruction manual.

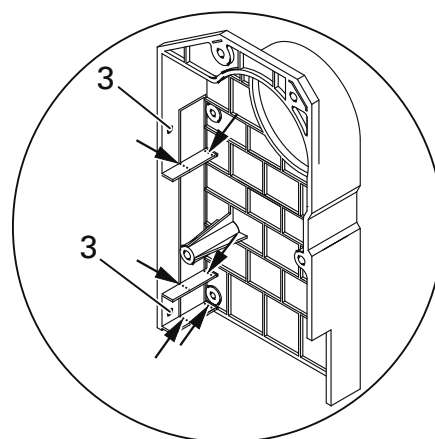
## 8.01.03 Mounting the upper V-belt guard



This step is eliminated for integrated sewing motors.



- Break out the belt guard case 1 at the points marked by the arrows.
- Fasten belt guard 2 in holes 3.
- Attach belt guard 4 to the machine case with screws 5.



### 8.01.04 Mounting the lower V-belt guard



This step is eliminated for integrated sewing motors.

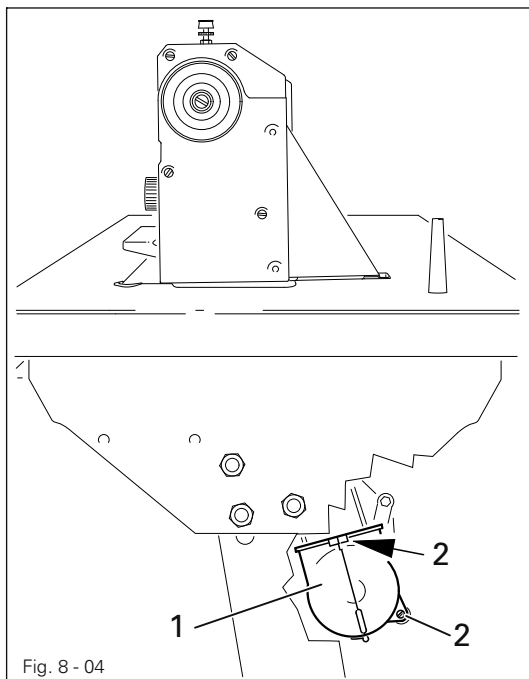


Fig. 8 - 04

- Align belt-guard 1 in such a way that both the motor pulley and the V-belt run freely.
- Tighten screws 2.



A PFAFFmotor is shown in Fig. 8-04. If another motor is used, carry out this step according to the instructions in the motor instruction manual.

### 8.01.05 Mounting the spool holder

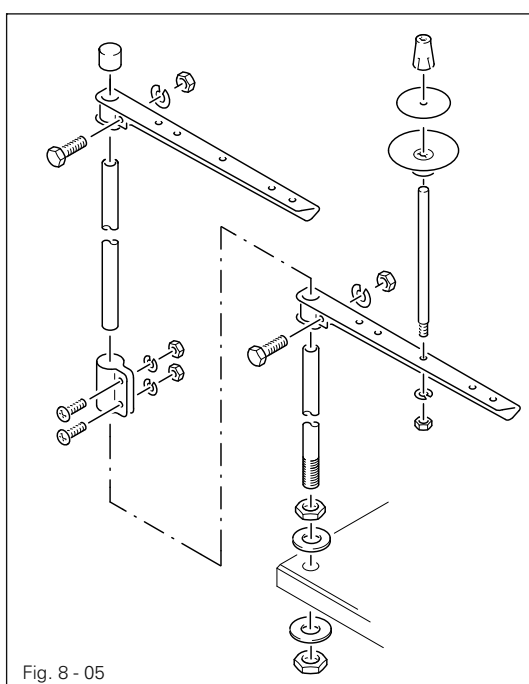
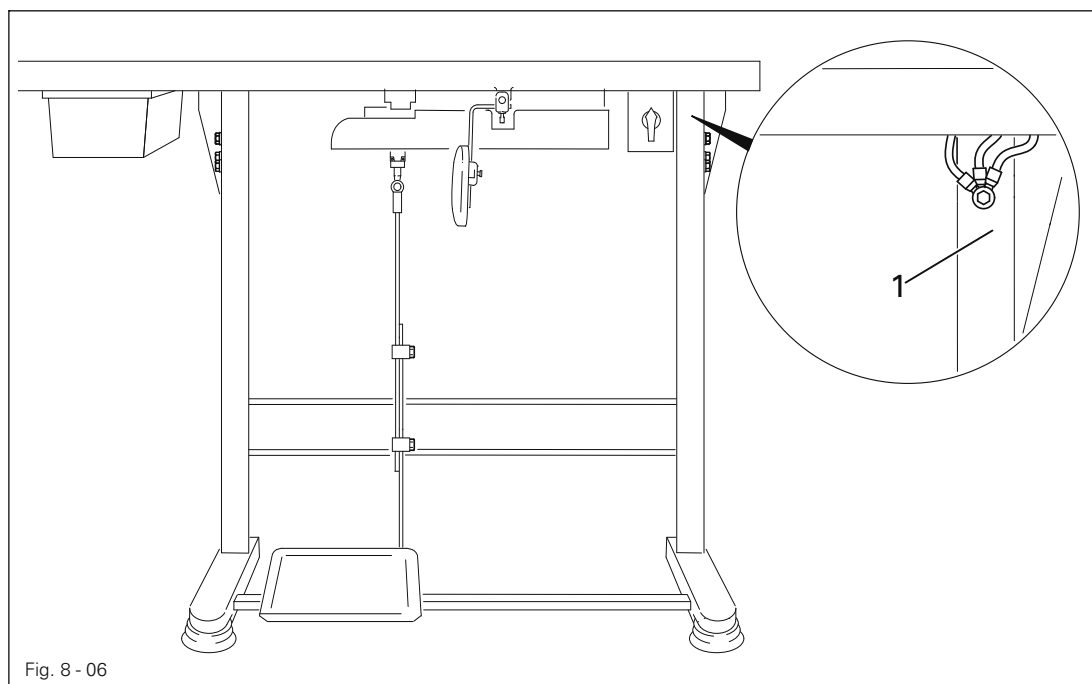


Fig. 8 - 05

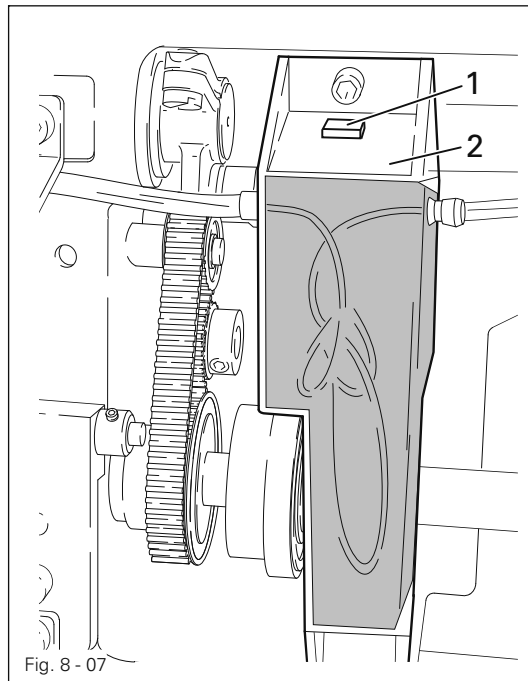
- Mount the spool holder as shown in Fig. 8-05.
- Insert the spool holder into the hole in the table top and fasten it with the nuts enclosed.

### 8.02 Connecting the plug-in connections and earth cables



- Connect all plug connections as described in the operations manual of the drive
- The following ground cables must be attached in order to discharge static electricity.
- Attach ground cables for machine, main switch, control unit and motor to ground point 1.

### 8.03 Commissioning the machine



- Check the machine, especially the electrical leads, for any damage.
- Remove pin 1 of the oil reservoir 2 (Fig. 8 - 07).



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.  
The machine may only be connected to an earthed socket!



Have home position of the machine drive verified by certified technicians before first commissioning! Have settings carried out by technicians where required (see chapter 8.05)

### 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

#### 8.05.01 On machines with EcoDrive and control unit P40 ED

- 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 "1" 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 "0".
- 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 **10.04 Parameter Settings**) and adjust them if necessary.
- Conclude the adjustment of the sewing motor by pressing the **TE/Speed key**.

#### 8.05.02 On machines with PicoDrive and control unit P40 PD2

- Switch on the machine.
- Call up the parameter input by pressing the "scroll" key.
- To switch the function keys to input (LED in the TE key lights up), press the **TE key**.
- By pressing the corresponding +/- keys, select parameter "798" and service level C, see Chapter **Selecting the User Level** in the separate Control Panel Instruction Manual.
- Select parameter "799" by pressing the corresponding +/- keys.
- Check whether the value is set at "2" and alter if necessary.
- Switch the machine off and then on again.
- Select parameter "800" by pressing the corresponding +/- keys.
- Check whether the value is set at "0" (balance wheel turns towards the operator) and alter if necessary.
- Select parameter "802" by pressing the corresponding +/- keys.
- Check whether the value is set at "0" (= no reduction ratio) and alter if necessary.



- .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.
- Conclude the adjustment of the sewing motor by pressing the "scroll" key

### 8.05.03 On machines with control unit MD-4-95-220-CE



- Press and hold button and switch on machine.
- Parameter **47** is displayed.



- Call up input level.
- Set Code "**62**" from the machine manufacturer.



- Confirm entry and switch off machine.



- Press and hold button and switch on machine.
- Parameter **208** is displayed.



- Call up parameter **236**.



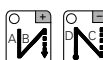
- Confirm entry.
- Set value from the machine typ (0 = PFAFF 1183, 1 = PFAFF 1181).



- Confirm entry and switch off machine.



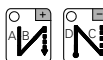
- Press and hold button and switch on machine.
- Parameter **176** is displayed.



- Call up parameter **192**.



- Press button **D+** to turn function "on".



- Call up parameter **181**.



- Call up input level.

- Sew a stitch with the pedal function.
- Turn the handwheel in rotational direction until the needle point (approaching from above) is on the upper edge of the needle plate.



- Confirm entry.



- Call up parameter **192**.



- Press button **D+** to turn function "off".



- Press button "**S**" to exit input.

### 8.06 Start inhibitor

#### 8.06.01 Mounting the start inhibitor

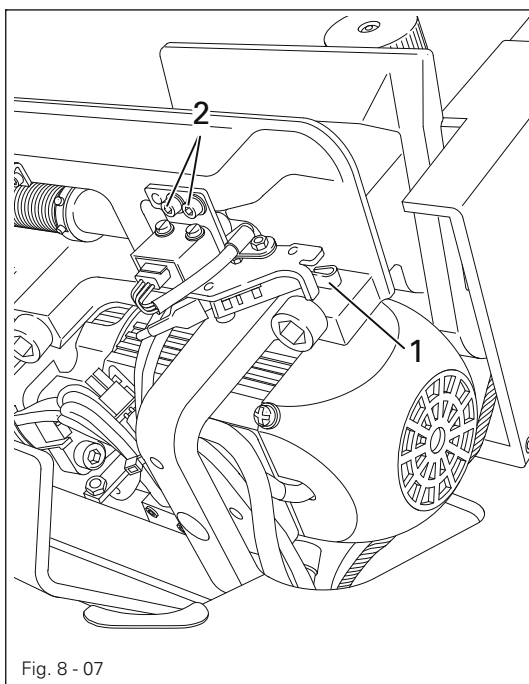


Fig. 8 - 07

- Set the machine into the table top.
- After loosening screws 2, set switch 1 so that it is activated when the sewing head is in an upright position.
- In this position tighten screws 2.

#### 8.06.02 Checking the start inhibitor function

- Switch the machine on at the main switch and tilt back the sewing head.
- The error message "**Er 0 16**" (on MD-4-95-220-CE) or "**Error 9**" (on Eco- or PicoDrive) must appear on the control panel.
- If the message does not appear, check the setting of safety switch 2.
- After the sewing head has been returned to the upright position, the machine is ready for operation again.

## 9

### Preparation



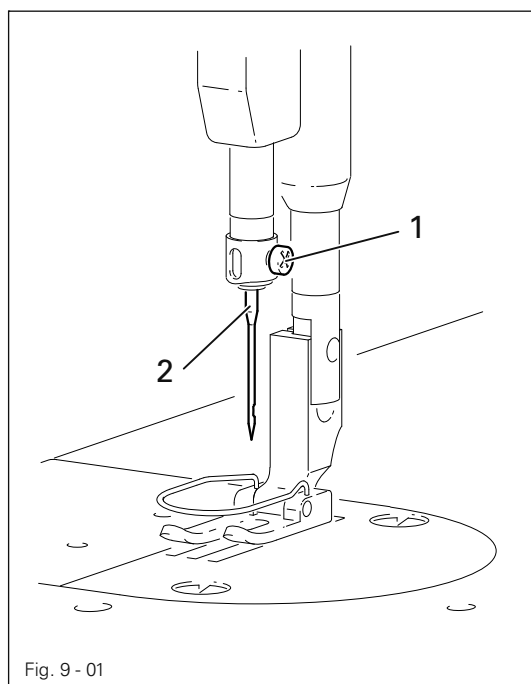
All regulations and instructions in this Instruction Manual are to be observed!  
Special attention is to be paid to the safety regulations!



All preparation work is only to be carried out by appropriately trained personnel.  
Before all preparation work, the machine is to be separated from the electricity supply by removing the plug from the mains or switching off the On/Off switch!

### 9.01

#### Inserting the needle

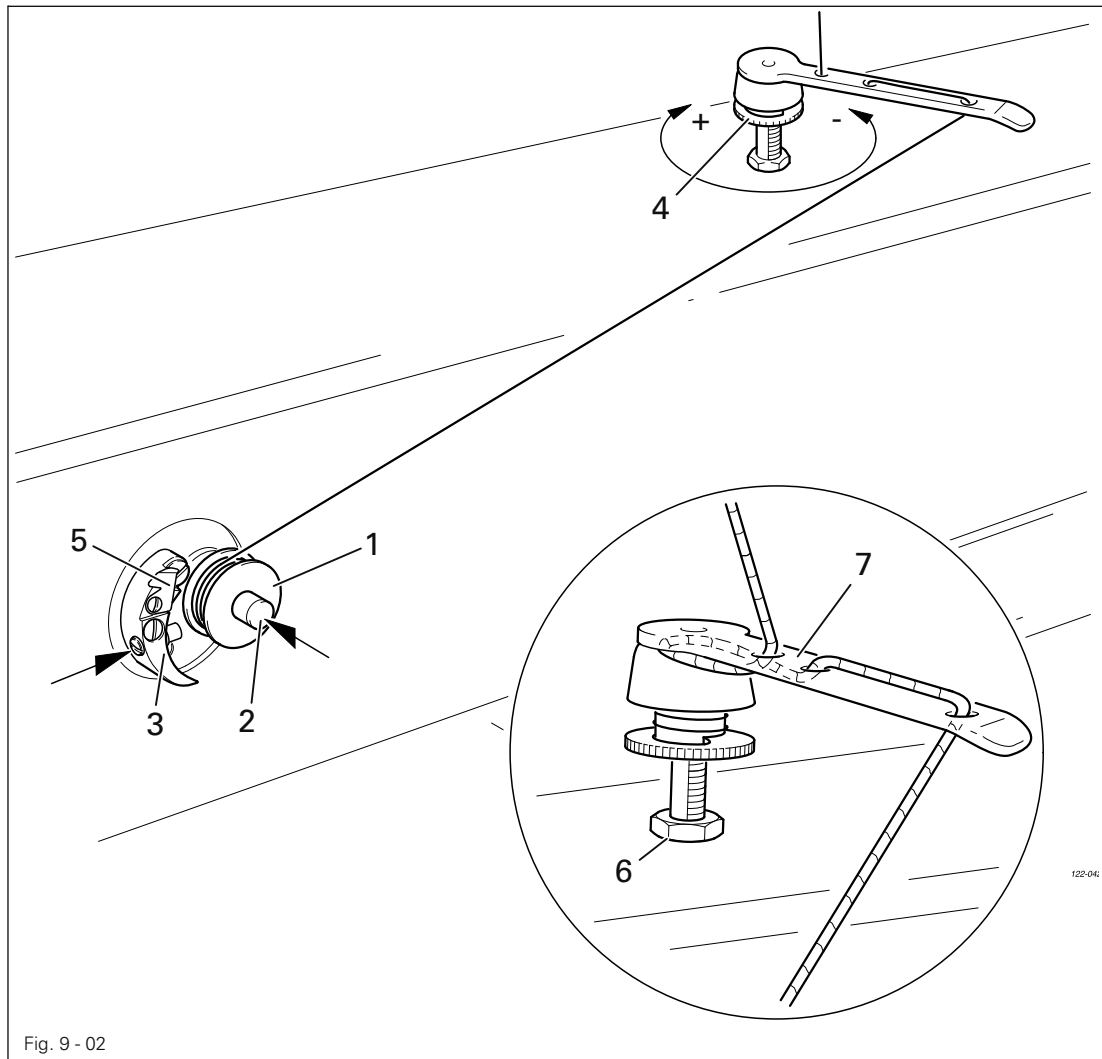


Switch off the machine!  
Danger of injury due to unintentional starting of the machine!



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

- Raise needle bar.
- Loosen screw 1 and insert needle 3 until you feel it stop.
- The long needle groove must be aligned in the direction of the machine head.
- Tighten screw 1.



- Place an empty bobbin 1 onto bobbin shaft 2.
- Thread the bobbin in accordance with Fig. 9-02 and wind it anti-clockwise around bobbin 1 a few times.
- Switch on the bobbin winder while at the same time pressing bobbin winder spindle 2 and lever 3.



The bobbin fills up during sewing.



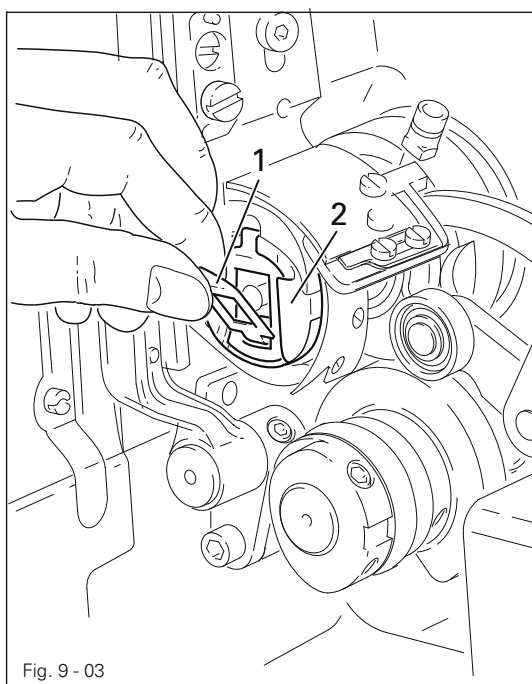
If the machine is only being used to wind the bobbin (without sewing), a bobbin case must be inserted in the hook! (Danger of damage to the hook).

- The tension of the thread on bobbin 1 can be adjusted with knurled screw 4.
- The bobbin winder stops automatically when bobbin 1 is full.
- Remove the filled bobbin 1 and cut the thread on knife 5.



If the thread is wound unevenly, loosen nut 6 and turn thread guide 7 accordingly. Retighten nut 6 after the adjustment.

## 9.03 Removing / Inserting the bobbin case



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

### Removing the bobbin case:

- Tilt back the machine.
- Raise latch 1 and remove bobbin case 2.

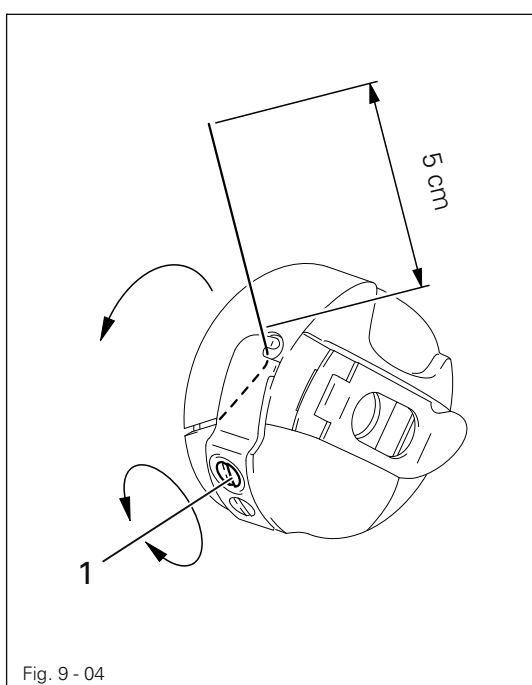
### Inserting the bobbin case:

- Press bobbin case 2 until you feel it snap into the bobbin case base.



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

## 9.04 Inserting the bobbin case / Adjusting the bobbin thread tension



- Insert the bobbin into the bobbin case.
- Pass the thread through the slot under the spring according to Fig. 9-04.
- Pass the thread through the notch.
- Adjust the thread tension by turning screw 1.



When the thread is pulled, the bobbin must rotate in the direction of the arrow.

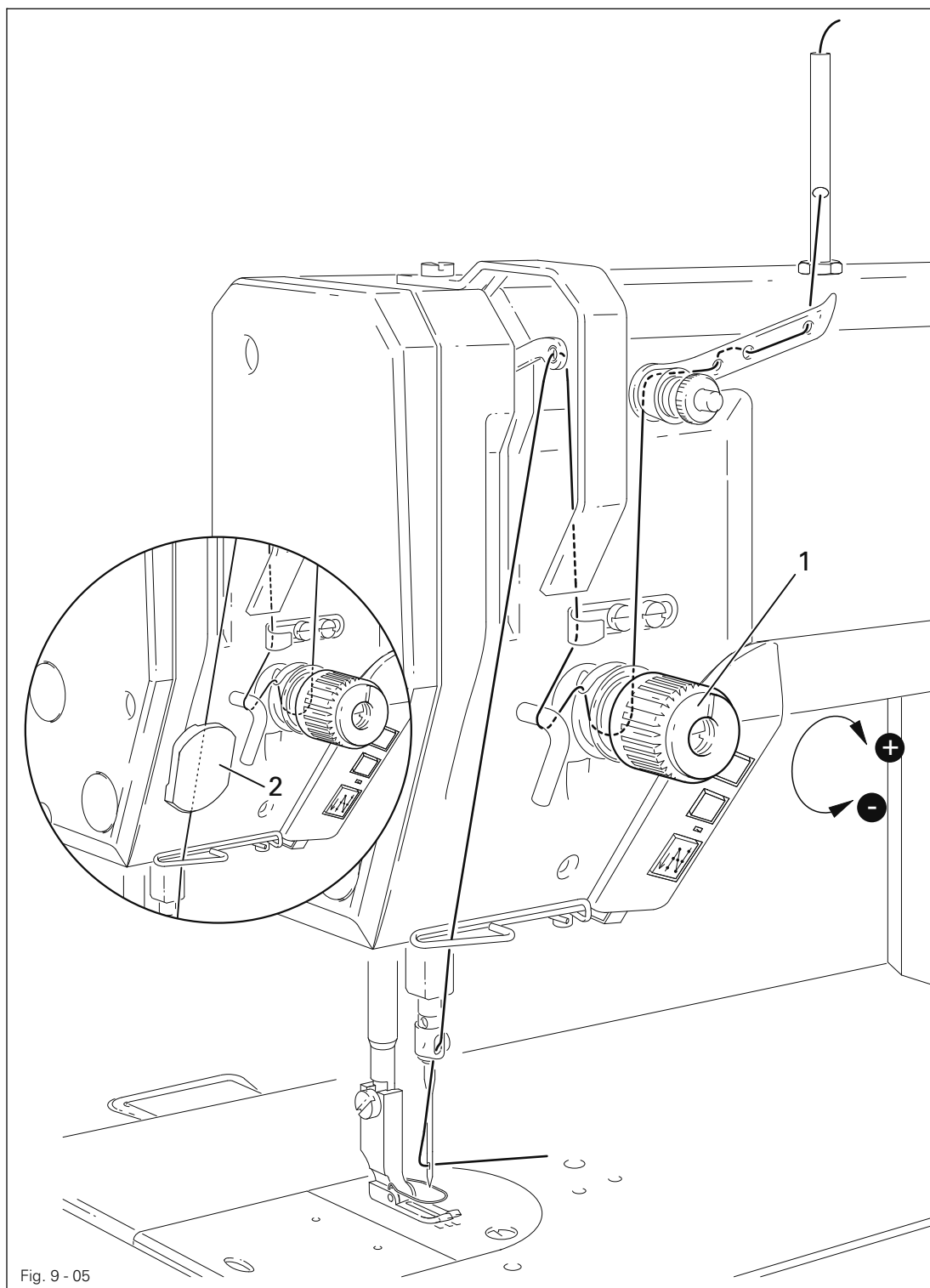


Fig. 9 - 05



Switch off the machine!

Danger of injury due to unintentional starting of the machine!

- Thread the machine as shown in Fig. 9-05.
- On machines with subclass -909/14 also guide the thread through thread trapper 2.
- Adjust the needle thread tension by turning disk 1.

## 10 Care and maintenance

### 10.01 Servicing and maintenance intervals

Clean .....	daily, more often if in continuous operation
Check oil level .....	monthly
Oil the trimmer -731/01 .....	once a week, more often if in continuous operation



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 the machine

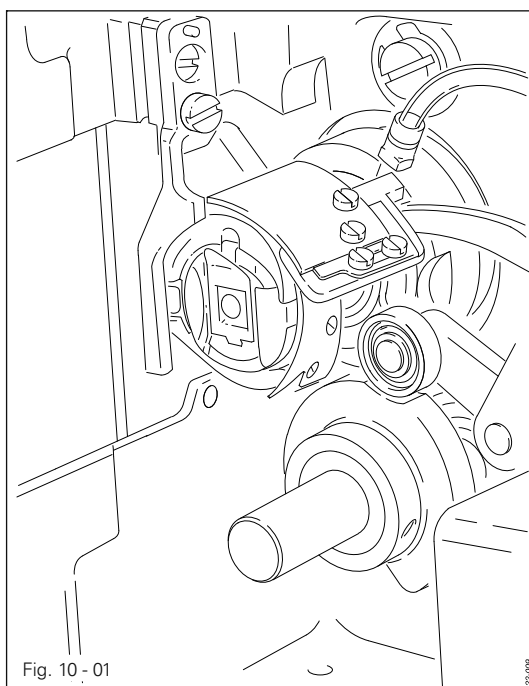
The cleaning cycle required for the machine depends on following factors:

- Single or several shift operation
- Amount of dust resulting from the workpiece

It is therefore only possible to stipulate the best possible cleaning instructions for each individual case.



For all cleaning work the machine must be disconnected from the mains by switching off the on/off switch or by removing the mains plug!  
Danger of injury if the machine suddenly starts up .



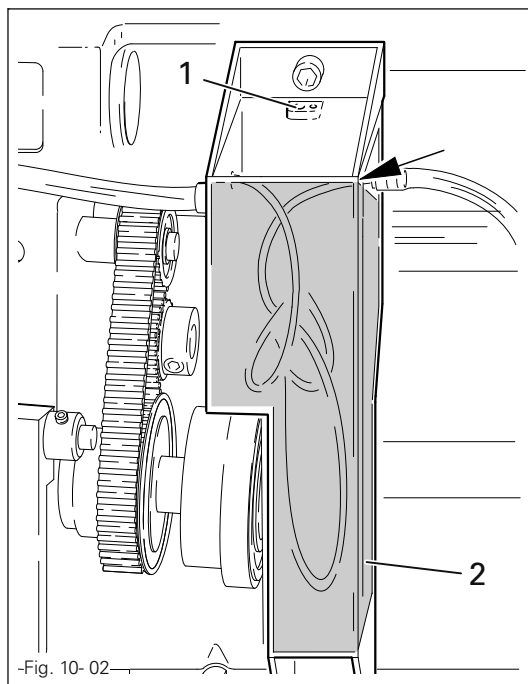
To avoid breakdowns, the following cleaning work is recommended for single shift operation:

- Swing out the cover plate and tilt back the sewing head.
- Clean the hook and hook compartment daily, more often if in continuous operation.



Return the machine to its upright position using **both** hands!  
Danger of injury by crushing between the edge of the machine and the table top!

### 10.03 Topping up the oil tank



The oil reservoir must always have oil in it.

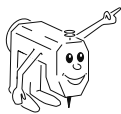
- Whenever it is necessary to refill the reservoir, tilt back the machine and let it rest on the sewing head support.
- Fill oil through hole **1** into the reservoir **2** up to the level of the front edge (see arrow).



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

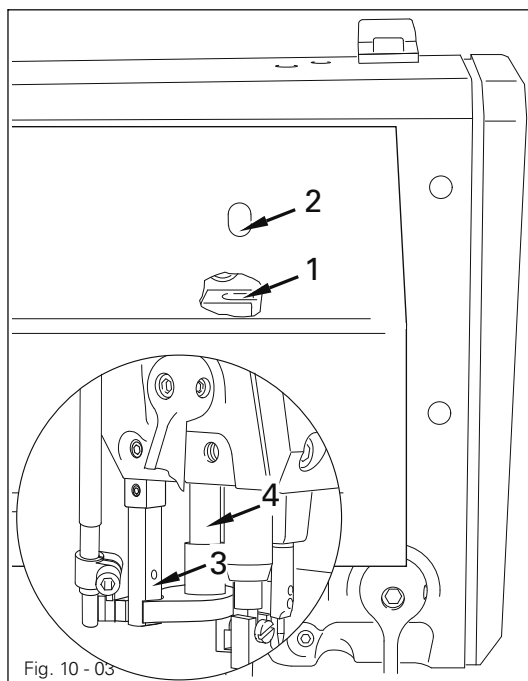


Only use oil with a mean viscosity of  $22.0 \text{ mm}^2/\text{s}$  at  $40^\circ\text{C}$  and a density of  $0.865 \text{ g/cm}^3$  at  $15^\circ\text{C}$ .



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

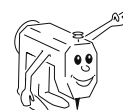
### 10.04 Oiling the edge trimmer -731/01



- Once a week pour oil on oil sponge **1** through hole **2**.
- Lubricate the guides **3** and **4** once a week.



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



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



## 10.05 Parameter settings



Parameter settings are described in the separate operations manual for the drive, and may only be changed by qualified technicians!

### 10.05.01 Parameter list for control unit P40 ED and P40 PD2

Group	Parameter	Description	User level	Setting range	Set value P40 ED	Set value P40 PD2
1	105	Speed for start backtackl	B, C	300 - 2000	1200	1200
	110	Speed for end backtack	B, C	300 - 2000	1200	1200
6	606	Speed min	B, C	30 - 300	180	180
	607	Speed max.	B, C	300 - 6000	▲	▲
6	609	Cutting speed 1	B, C	60 - 300	180	180
	660	Bobbin thread control 0 = off, 1 = thread monitor, 2 = reverse counter	A, B, C	0 - 2	0	-
	668	Thread wiper/thread blower 1 = on; 0 = off	B, C	0 - 1	0	-
7	700	Needle position 0 (needle reference position)	B, C	0 - 255	*	*
	702	Needle position 1 (needle lowered)	B, C	0 - 255	90	90
	703	Needle position 2 (take-up lever raised)	B, C	0 - 255	236	236
	705	Needle position 5 (end cutting signal 1)	B, C	0 - 255	200	200
	706	Needle position 5 (start cutting signal 2)	B, C	0 - 255	136	136
	707	Needle position 9 (start thread tension release/start thread catcher)	B, C	0 - 255	164	164
	760	Multiplier for the fixed value (200) stitch count	A,B, C	0 - 250	5	-
	797	Hardwaretest (OFF / ON ),	B, C		OFF	OFF
	799	Selected machine class	C	1 - 3	1	2
8	800	Rotating direction of the motor	C	0 - 1	0	0
	802	Main drive reduction ratio 0 = 1:1, 1 = variable	C	0 - 1	-	0

▲ See Chapter 3 Specifications

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

Group	Parameter	Description	User lever	Setting range	Set value P40 ED	Set value P40 PD2
9	985	Switch on angle for thread trapper	B, C	0 -255	67	67
	986	Switch off angle for thread trapper	B, C	0 -255	206	206
	989	Thread trapper at beginning of seam 1 = yes, 0 = no	B, C	0 - 2	0	0

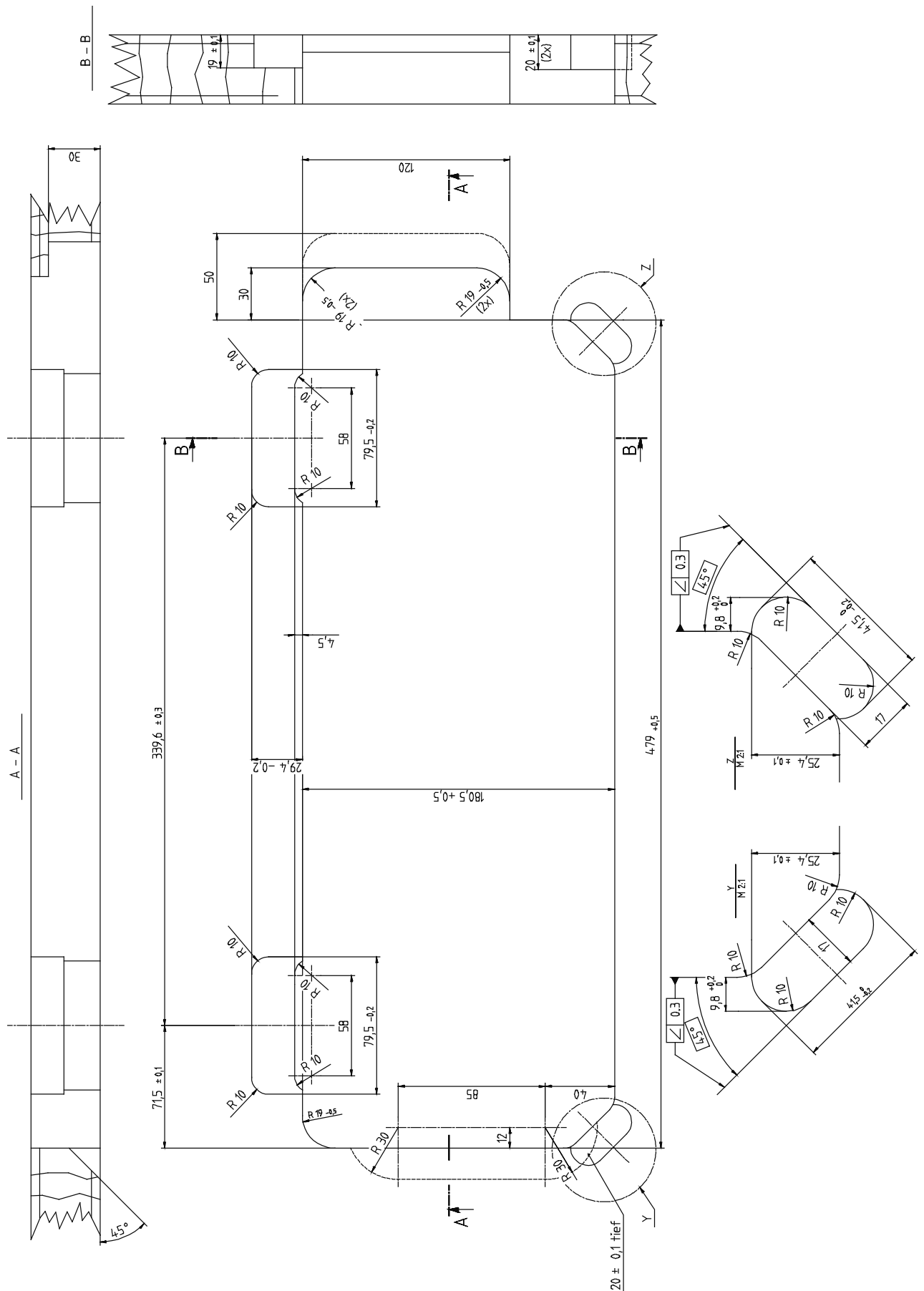
### 10.05.02 Parameter list for control unit MD-4-95-220-CE

Parameter	Description	Setting range	Set value
1	Speed max.	50 - 9999	▲
4	Speed for start backtackl	50 - 8000	1500
5	Speed for end backtack	50 - 8000	1500
40	Thread wiper	ON - OFF	ON
46	Rotating direction of the motor	CW - CCW	CW
47	Selected machine class	0 - 101	62
61	Cutting speed 1	50 - 500	220
81	Needle position 6 (start cutting signal 2)	0 - 360°	40°
84	Needle position 5 (end cutting signal 1)	0 - 360°	90°
85	Needle position 9 (start thread tension release/start thread catcher)	0 - 360°	120°
87	Tension release after thread lever position at t.d.c.	0 - 1500ms	20ms
179	Needle position 2 (take-up lever raised)	0 - 359°	83°
181	Needle position 1 - needle lowered (192 = off)	0 - 255	250
210	Switch on angle for thread trapper	0 - 359°	20°
211	Switch off angle for thread trapper	0 - 359°	90°
236	Machine version 0 = 1183; 1 = 1181	0 - 20	0



Further parameters see manual of the respective drive

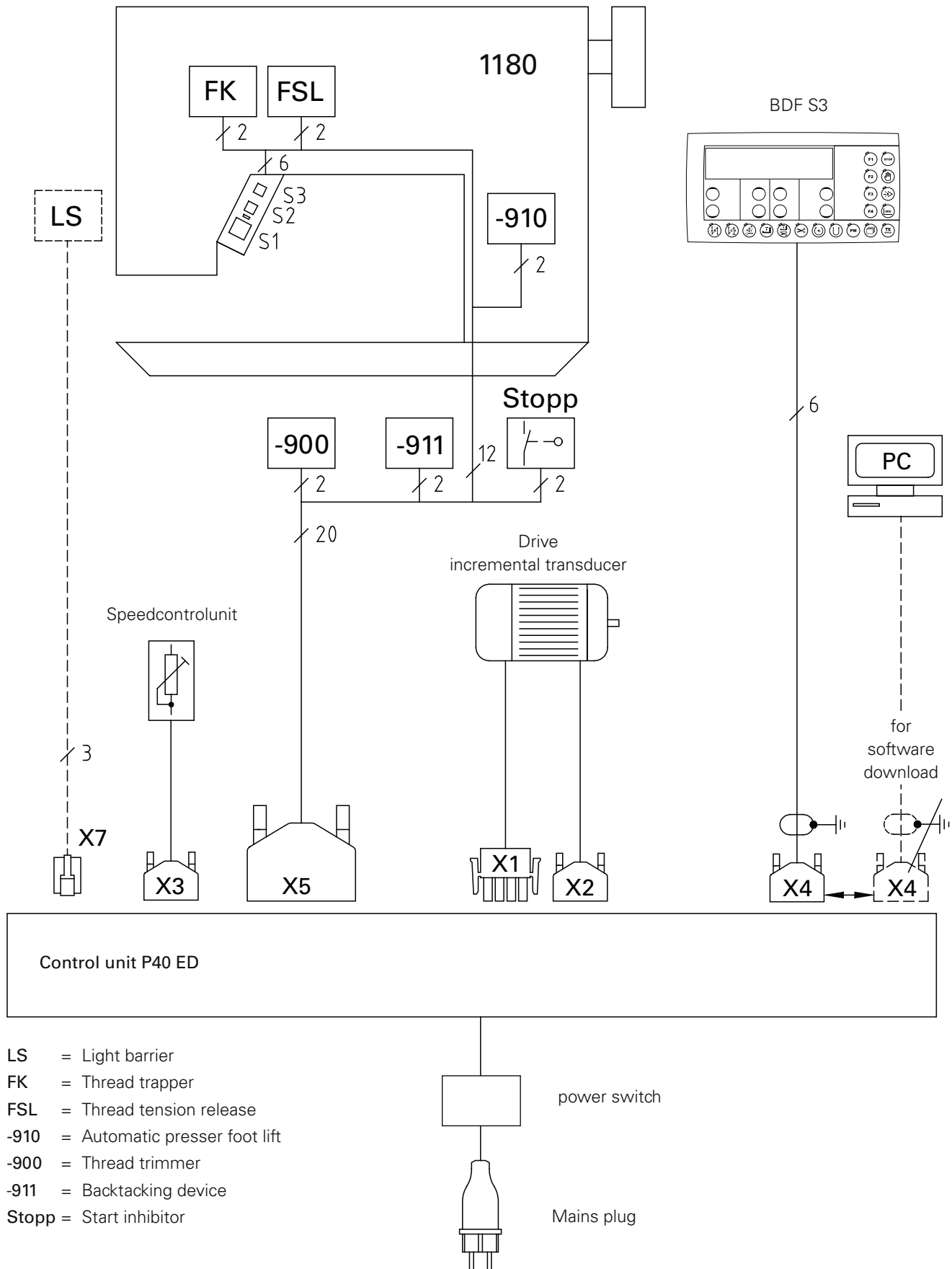
11 Table top cutout



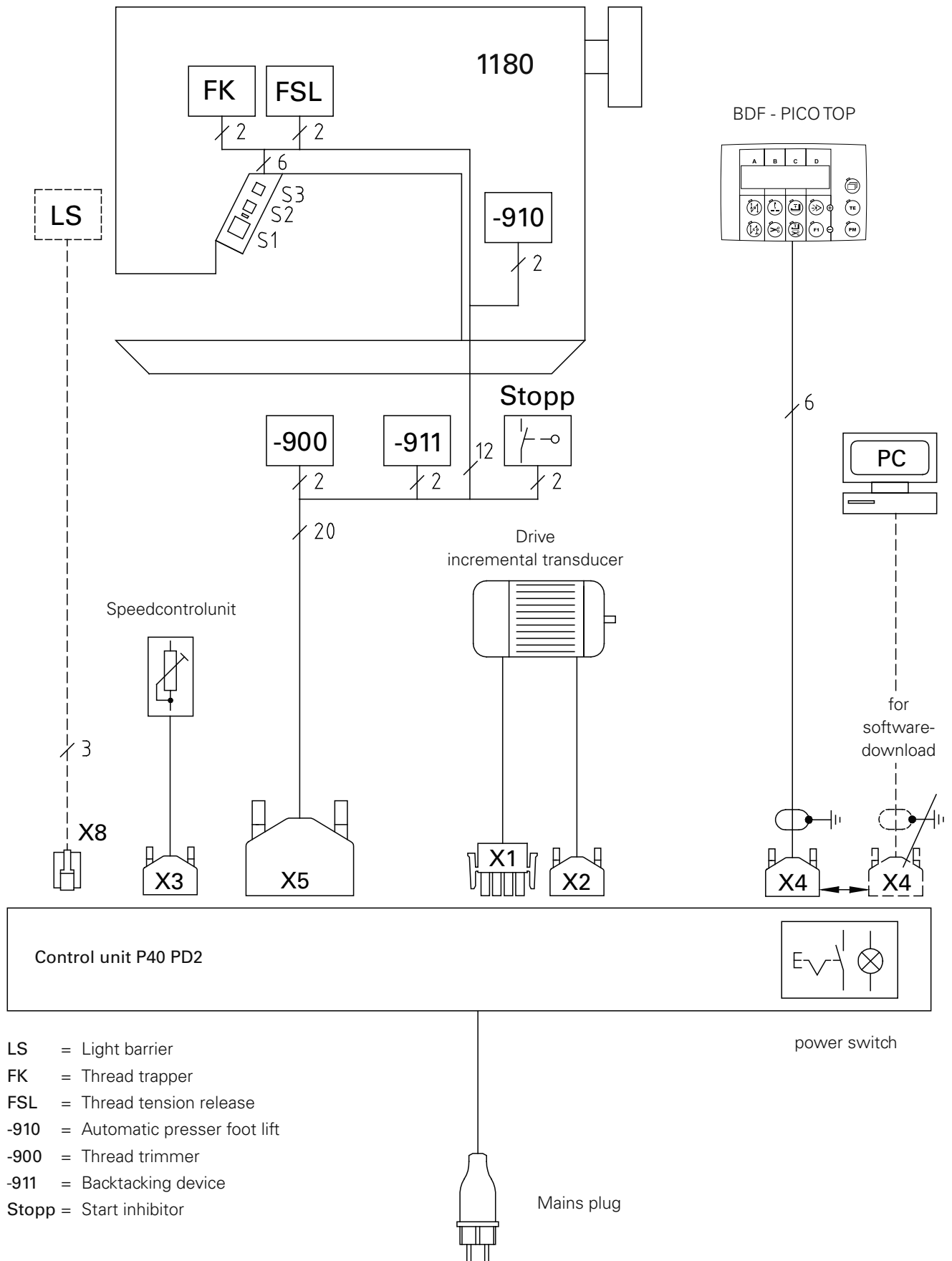
## Block diagram

### 12 Block diagram

#### 12.01 Block diagram PFAFF 1180 with control unit P40 ED

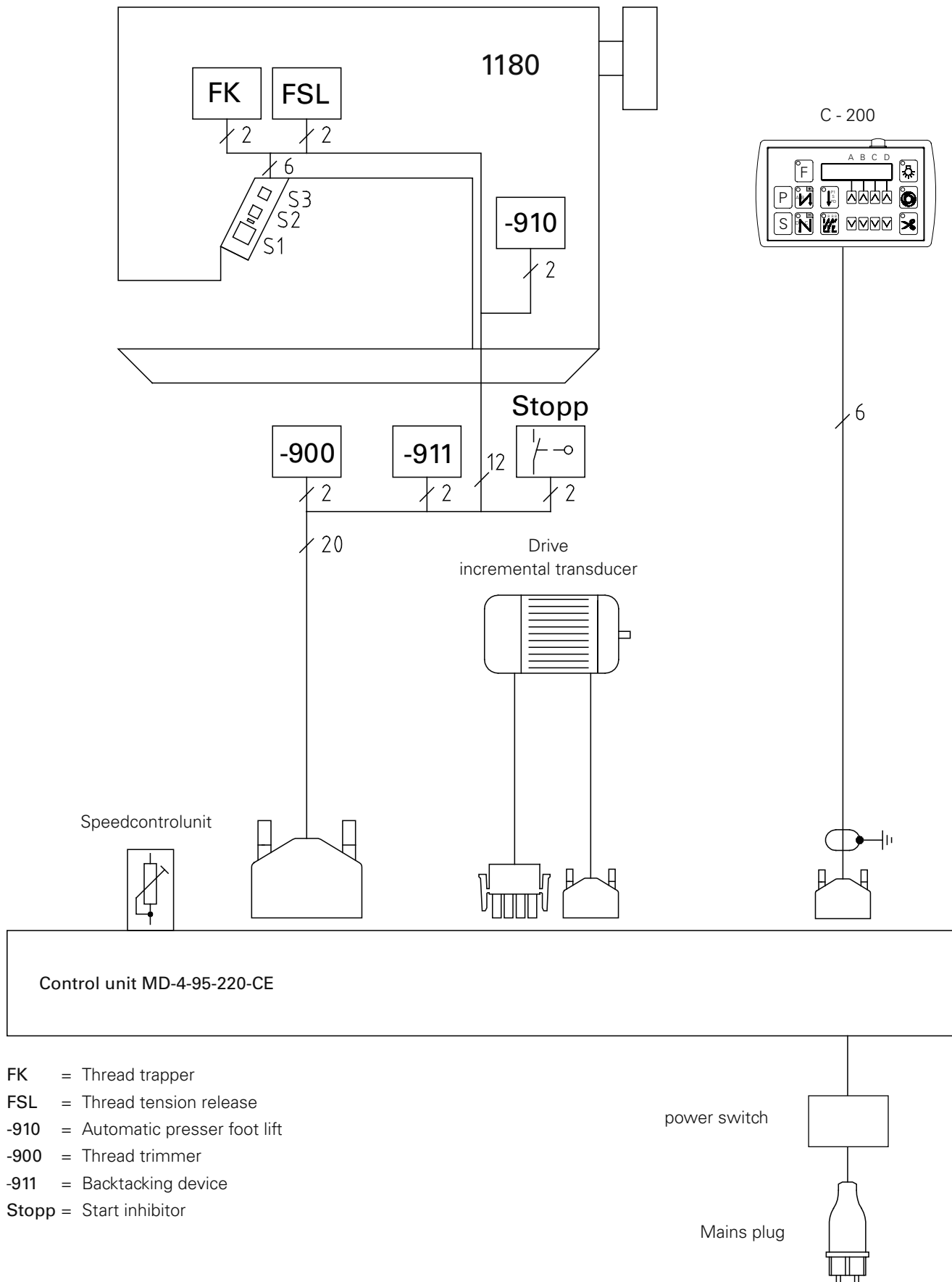


## 12.02 Block diagram PFAFF 1180 with control unit P40 PD2



## Block diagram

12.03 Block diagram PFAFF 1180 with control unit MD-4-95-220-CE

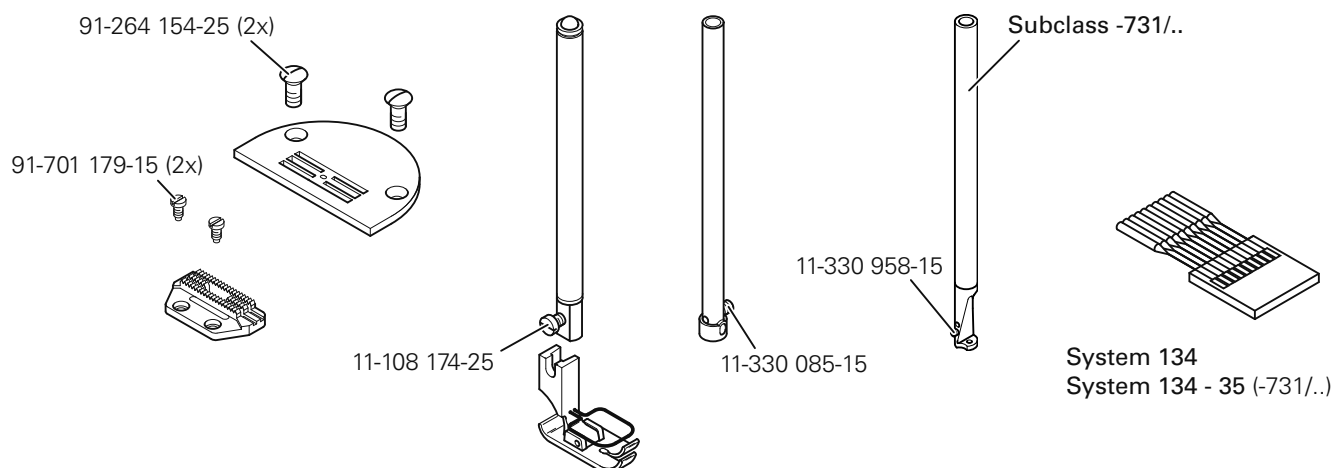


## 13 Wearing parts

This is a list of the most important wearing parts.

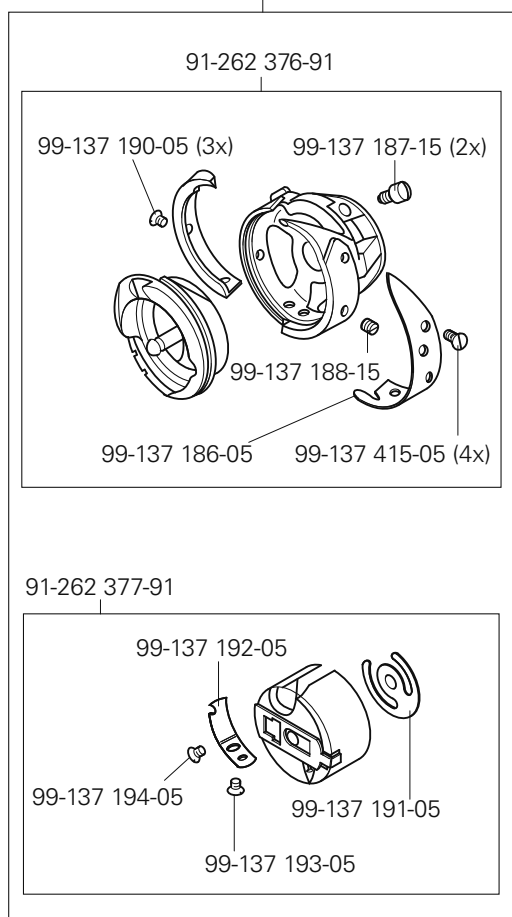
A detailed parts list for the complete machine is included with the accessories.

In case of loss, the parts list can be downloaded from the internet address [www.pfaff-industrial.com/pfaff/de/service/downloads](http://www.pfaff-industrial.com/pfaff/de/service/downloads) As an alternative to the internet download the parts lists can also be ordered in book form under part no. 296-12-19 201.



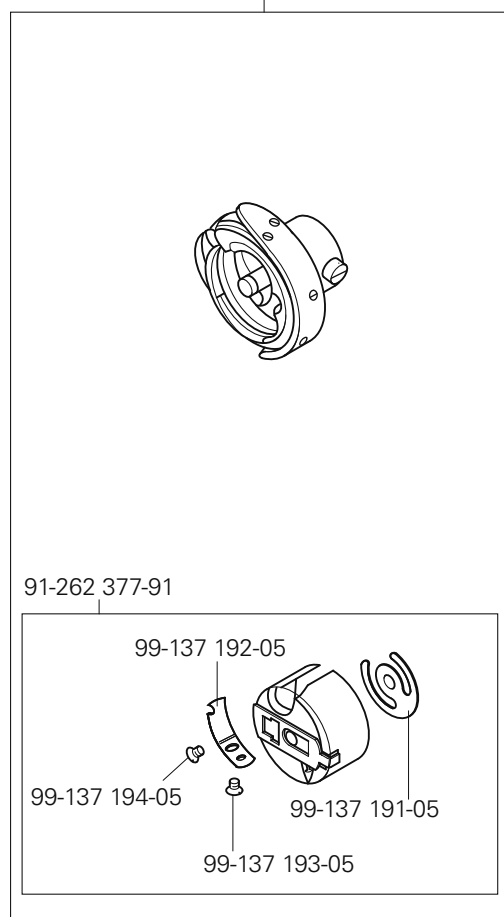
PFAFF 1181; 1183 A + B

91-262 250-91

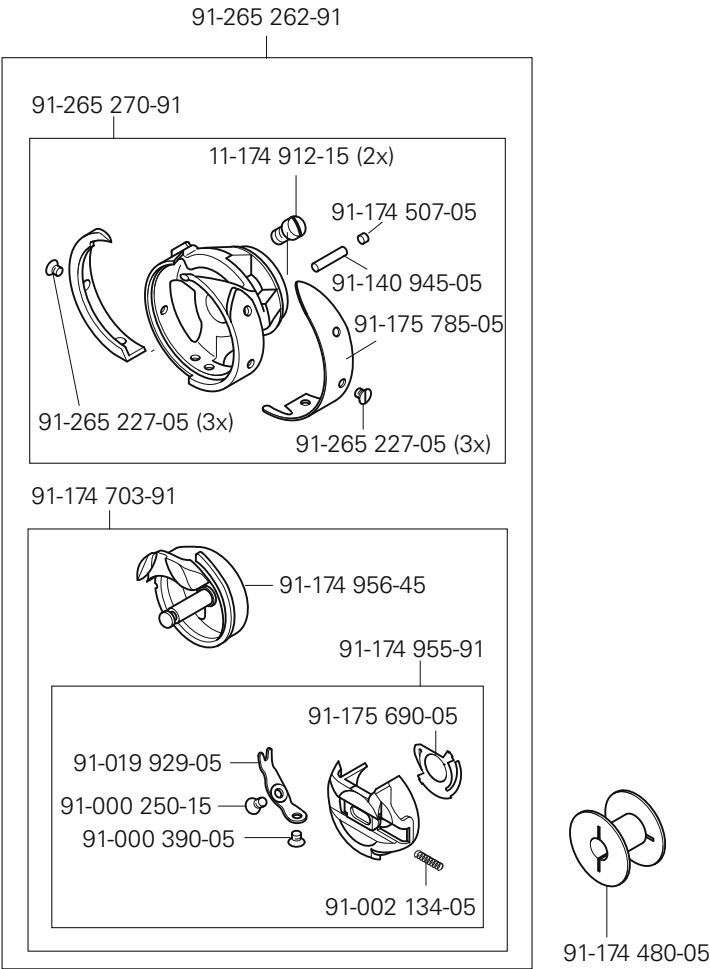


PFAFF 1181; 1183 C

91-264 383-91



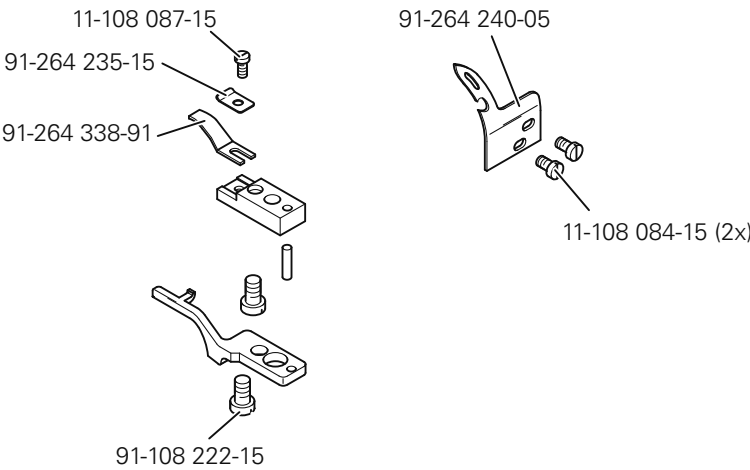
PFAFF 1181-G; 1183-G



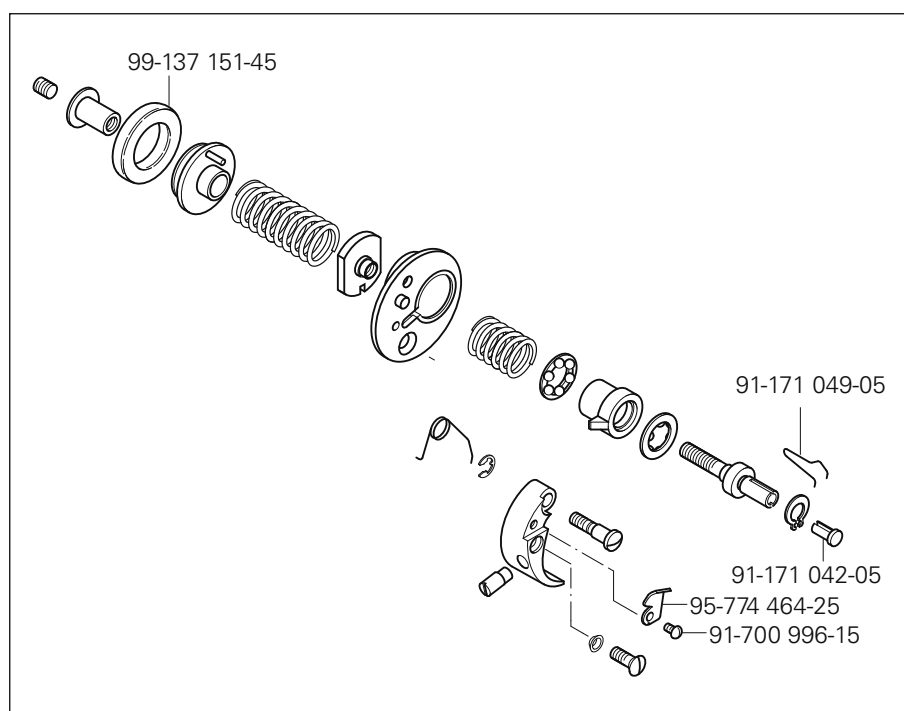
Subclass -731/..

	Subclass	Trimming margin	Partnumber
	-731/01-8/11 A	5,0 mm	91-069 595-04/002
	-731/01-8/11 B	3,5 mm	91-169 395-04/002
	-731/01-8/11 B	4,0 - 7,0 mm	91-069 595-04/002

Subclass -900/24









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