



MODEL S-4002

**ELECTRONIC BUTTON STITCHER
MACHINE**

PARTS AND SERVICE MANUAL

MACHINE SERIAL No:

PART NUMBER 97.2486.5.001

This manual is valid from the machine Serial No.: W40020001



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97.2486.5.001 ELECTRONIC BUTTON
STITCHER MACHINE
PARTS AND SERVICE MANUAL



S-4002

97.2486.4.001 ELECTRONIC BUTTON
STITCHER MACHINE
PARTS AND SERVICE MANUAL



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LIMITED WARRANTY ON NEW AMF REECE EQUIPMENT

Warranty provisions:

A ninety (90) day limited service labor warranty to correct defects in installation, workmanship, or material without charge for labor. This portion of the warranty applies to machines sold as "installed" only.

A one (1) year limited material warranty on major component parts to replace materials with defects. Any new part believed defective must be returned freight prepaid to AMF Reece, Inc. for inspection. If, upon inspection, the part or material is determined to be defective, AMF Reece, Inc. will replace it without charge to the customer for parts or material.

Service labor warranty period shall begin on the completed installation date. Material warranty shall begin on the date the equipment is shipped from AMF Reece, Inc.

Exclusions:

Excluded from both service labor warranty and material warranty are: (1) Consumable parts which would be normally considered replaceable in day-to-day operations. These include parts such as needles, knives, loopers and spreaders. (2) Normal adjustment and routine maintenance. This is the sole responsibility of the customer. (3) Cleaning and lubrication of equipment. (4) Parts found to be altered, broken or damaged due to neglect or improper installation or application. (5) Damage caused by the use of non-Genuine AMF Reece parts. (6) Shipping or delivery charges.

There is no service labor warranty for machines sold as "uninstalled".

Equipment installed without the assistance of a certified technician (either an AMF Reece Employee, a Certified Contractor, or that of an Authorized Distributor) will have the limited material warranty only. Only the defective material will be covered. Any charges associated with the use of an AMF Reece Technician or that of a Distributor to replace the defective part will be the customer's responsibility.

NO OTHER WARRANTY, EXPRESS OR IMPLIED, AS TO DESCRIPTION, QUALITY, MERCHANTABILITY, and FITNESS FOR A PARTICULAR PURPOSE, OR ANY OTHER MATTER IS GIVEN BY SELLER OR SELLER'S AGENT IN CONNECTION HERewith. UNDER NO CIRCUMSTANCES SHALL SELLER OR SELLER'S AGENT BE LIABLE FOR LOSS OF PROFITS OR ANY OTHER DIRECT OR INDIRECT COSTS, EXPENSES, LOSSES OR DAMAGES ARISING OUT OF DEFECTS IN OR FAILURE OF THE EQUIPMENT OR ANY PART THEREOF.

WHAT TO DO IF THERE IS A QUESTION REGARDING WARRANTY

If a machine is purchased through an authorized AMF Reece, Inc. distributor, warranty questions should be first directed to that distributor. However, the satisfaction and goodwill of our customers are of primary concern to AMF Reece, Inc. In the event that a warranty matter is not handled to your satisfaction, please contact AMF Reece office:

Prostejov, Czech Republic
Phone: (+420) 582-309-275
Fax: (+420) 582-360-608
e-mail: service@amfreece.cz



Warranty Registration Card

(Please Fax or Mail immediately after installation)

Note: All Warranty Claims Void, unless Registration Card on file at AMF Reece HQ

Machine model number:

(S101, S100, S104, S105, S311, Decostitch, S4000, EBS Mark II, etc)

Manufacturer's serial or production number:

Installation Site Information:

Customer's Name:

Customer's Mailing Address:

Customer's Telephone Number:

Supervising Mechanic's or Technician's Name:

Signature of Supervising Technician:

AMF Reece Technician's Name:

AMF Reece Technician's Signature:

Type of garment produced at this location?

Average Daily Production Expected from this machine?

(number of buttonholes, jackets sewn, pants produced, buttons sewn, etc)

Any special requirements required at this location?

What other AMF Reece Machines are at this location?

How can we serve you better?

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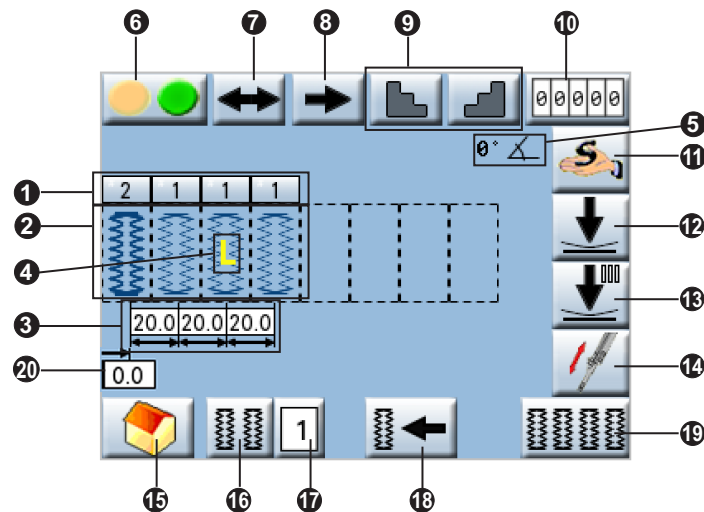
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E - STANDARD MACHINE ADJUSTMENT

1. ELECTRICAL DIAGRAM	
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D - MACHINE CONTROLS

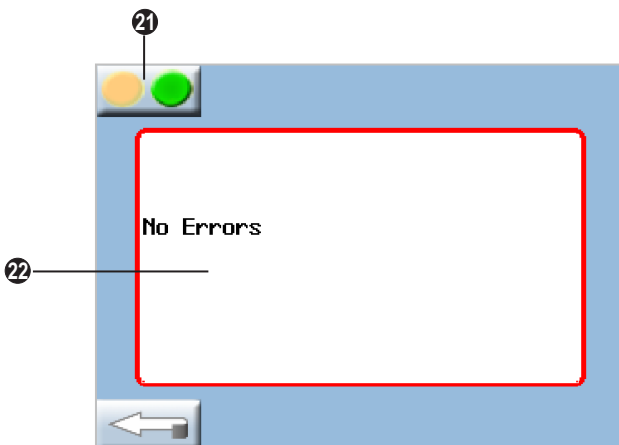
1. TOUCH-SCREEN PANEL MAIN SCREEN



- ❶ Buttonhole programs selected in the indexer sequence
- ❷ Graphic illustration of the adjusted sequence of buttonholes. The buttonholes are displayed in the way and direction how they will be sewn. The currently sewn buttonhole is highlighted by bold icon.
- ❸ Distance between individual buttonholes
- ❹ This symbol indicates indexer cycle interruption at the particular buttonhole. This feature is mainly useful for thread color exchange.
- ❺ Indication of indexer sewing angle
- ❻ Machine status / error number signalization. Press the button to switch to the Error Explanation Screen.
- ❼ Activation of automatic exchange between left & right sleeve
- ❽ Sleeve selection (sewing from left or right side)

- ❾ Step forward / backward in the indexer sequence
- ❿ Daily counter signalization. Press the button to switch to the Counter Screen.
- ⓫ Press this button to switch to the Service menu (refer to Chapter D 4)
- ⓬ Sewing head clamps activation
- ⓭ Indexer clamps activation
- ⓮ Thread pick-up activation
- ⓯ Home position establishment
- ⓰ Press this button to switch to the Indexer Parameters Screen (refer to Chapter D 3).
- ⓱ Indexer cycle program number selection / indication
- ⓲ Press this button to switch to the Buttonhole Parameters Screen (refer to Chapter D 2).
- ⓳ Indexer activation / deactivation
- ⓴ First buttonhole offset

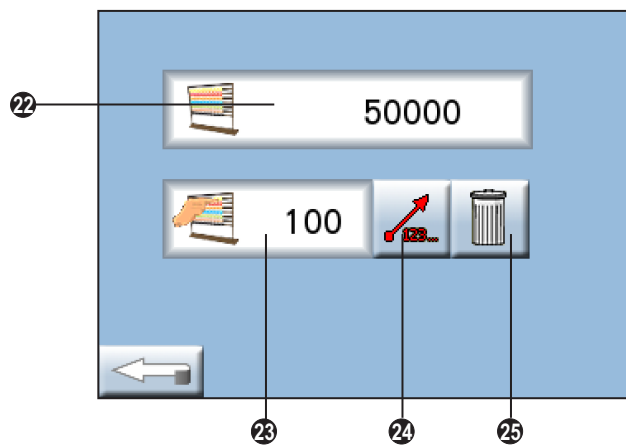
By pressing the button ❻ you switch to the Error Explanation Screen:



- ❶ Error number
- ❷ Error explanation

D - MACHINE CONTROLS

By pressing the button ⑩ you switch to the Counter Screen:



② Total counter of buttonholes sewn on the machine

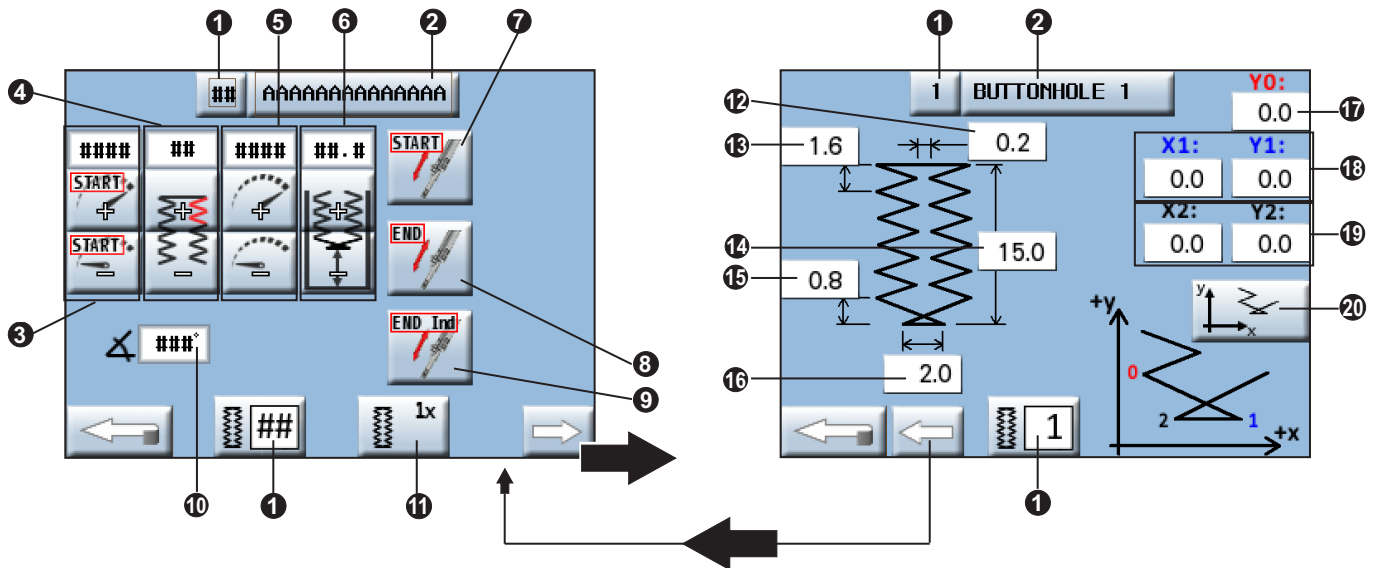
③ Daily buttonhole counter

④ Daily counter counting direction (ascending or descending)

⑤ Daily counter reset

D - MACHINE CONTROLS

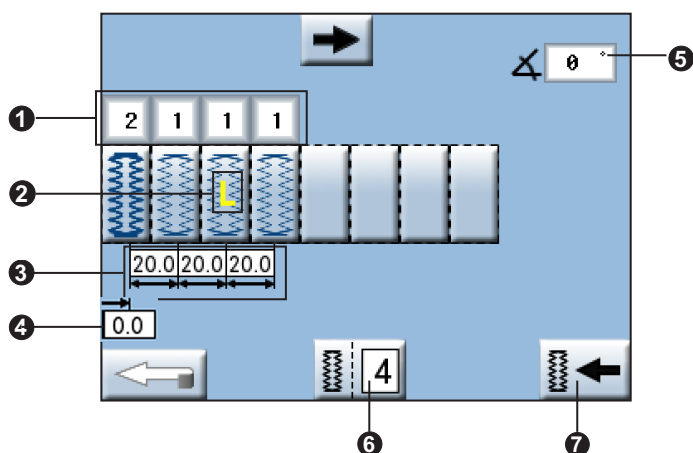
2. BUTTONHOLE PARAMETERS SCREEN



- ① Buttonhole program number selection / indication
- ② Buttonhole name
- ③ Initial slow sewing speed
- ④ Number of stitches being sewn at initial slow sewing speed
- ⑤ Sewing speed
- ⑥ Position of the buttonhole (shifts buttonhole closer / further from the sleeve edge)
- ⑦ Activation of thread pick-up opening at the beginning of buttonhole sewing to release the thread
- ⑧ Activation of thread pick-up at the end of buttonhole sewing
- ⑨ Activation of thread pick-up at the end of indexer cycle
- ⑩ Angle of the buttonhole. This option is valid when individual buttonhole angle setting mode is selected – refer to Chapter D 4.5.
- ⑪ Single or double buttonhole sewing
- ⑫ Cutting space adjustment
- ⑬ Stitch length adjustment
- ⑭ Buttonhole length adjustment
- ⑮ Bar-tack length adjustment
- ⑯ Bar-tack width adjustment
- ⑰ Bar-tack stitch nr. 0 (refer to the bottom-right picture on the screen) position correction
- ⑱ Bar-tack stitch nr. 1 (refer to the bottom-right picture on the screen) position correction
- ⑲ Bar-tack stitch nr. 2 (refer to the bottom-right picture on the screen) position correction
- ⑳ Bar-tack position correction enable/disable

D - MACHINE CONTROLS

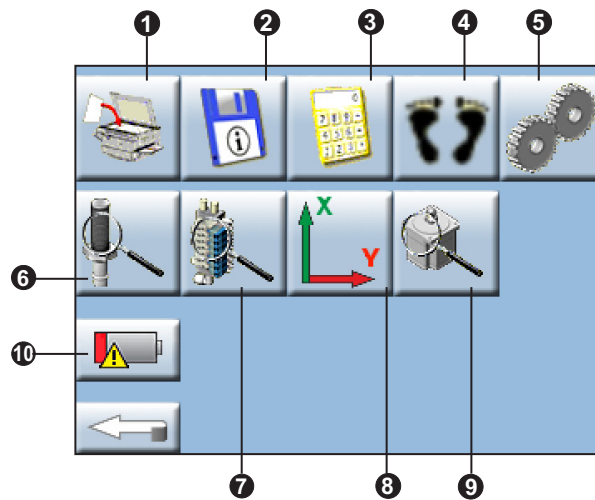
3. INDEXER PARAMETERS SCREEN



- ❶ Selection of buttonhole program numbers in the indexer sequence
- ❷ This symbol indicates indexer cycle interruption at the particular buttonhole. Press the buttonhole icon to activate cycle interruption at that buttonhole. This feature is mainly useful for thread color exchange.
- ❸ Adjustment of distance between individual buttonholes
- ❹ First buttonhole offset
- ❺ Indexer sewing angle adjustment
- ❻ Adjustment of the number of buttonholes in the indexer cycle
- ❼ Press this button to switch to the Buttonhole Parameters Screen.

D - MACHINE CONTROLS

4. SERVICE MENU



- ❶ Switch to Program Copy Screen (refer to Chapter D 4.2)
- ❷ Switch to Software Information Screen (refer to Chapter D 4.3)
- ❸ Password Entering (refer to Chapter D 4.1)
- ❹ Switch to Buttonhole Step-by-Step Sewing Screen (refer to Chapter D 4.4)
- ❺ Switch to Machine Parameters Screen (refer to Chapter D 4.5)
- ❻ Switch to Sensors Test Screen (refer to Chapter D 4.6)
- ❼ Switch to Valves Test Screen (refer to Chapter D 4.7)
- ❽ Switch to X-Y Motors Adjustment Screen (refer to Chapter D 4.8)
- ❾ Switch to Sewing Motor Adjustment Screen (refer to Chapter D 4.9)
- ❿ Indication of PLC controller battery low status / Switch to Battery Status Screen (refer to Chapter D 4.10)

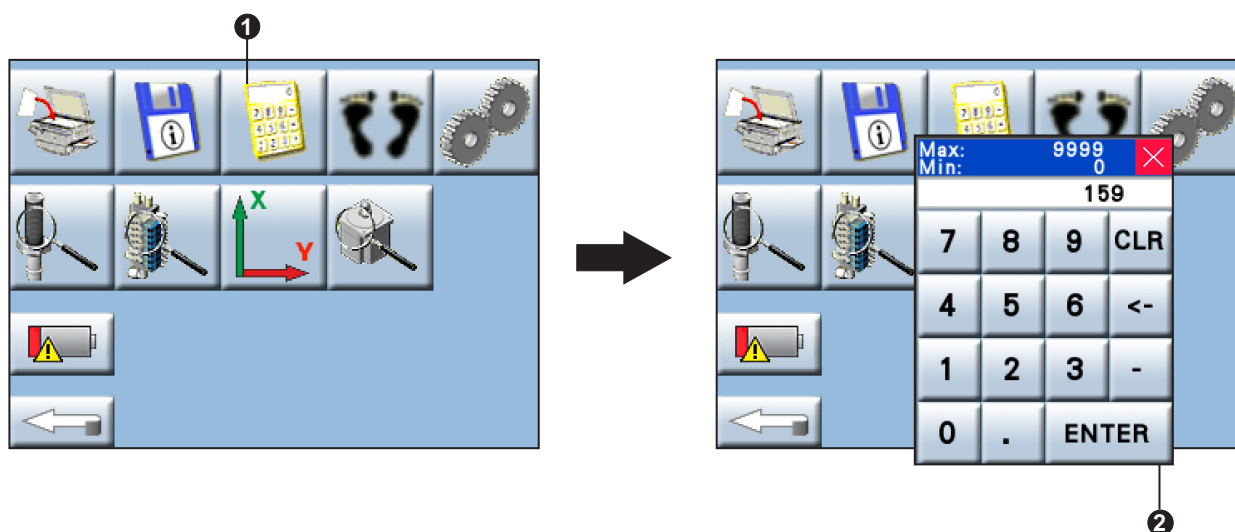
D - MACHINE CONTROLS

4.1. Password Submitting Screen

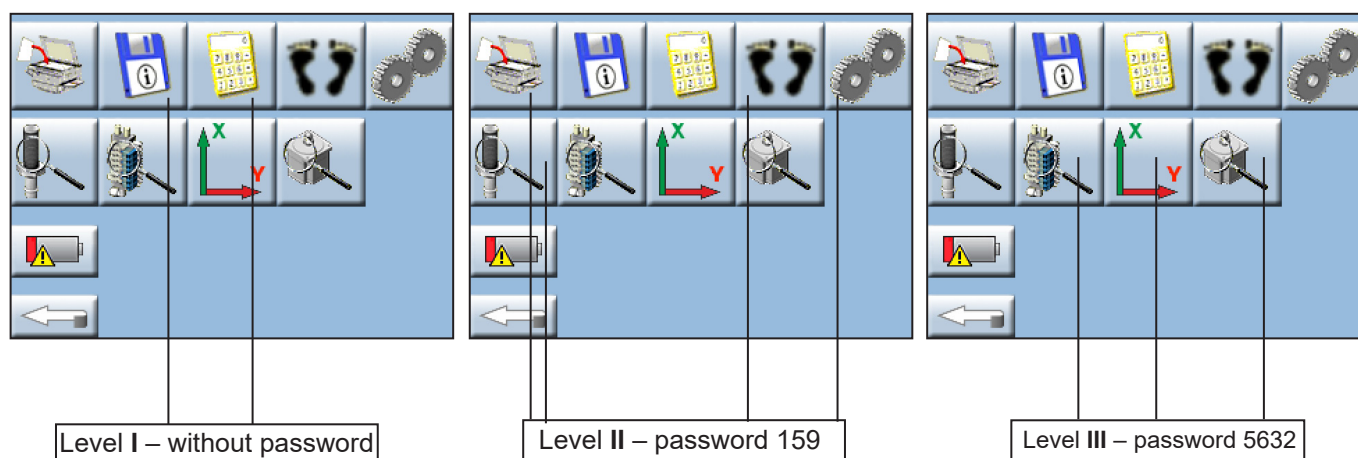
All the buttonhole parameters are protected by the password of level II. Consequently, the buttonhole parameters can be viewed but cannot be changed. Level II password is requested for the change.

Service menu is protected from unqualified parameters change by security passwords. It is split into three levels according to severity and frequency of usage.

Press button **1** on the Service Menu Screen. Numerical keyboard appears. Enter the code for the respective level. Validate it by pressing the button **2**.

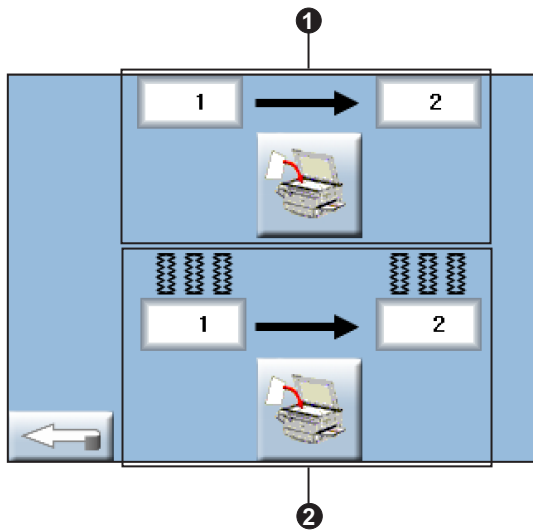


On the screens below there is an overview of protection level of individual service menu buttons together with the respective passwords. After entering a password, all the buttons of respective level are activated including all the buttons of lower levels. E.g., after entering the password of protection level III, all the buttons of level I and II are also activated.



D - MACHINE CONTROLS

4.2. Program Copy Screen



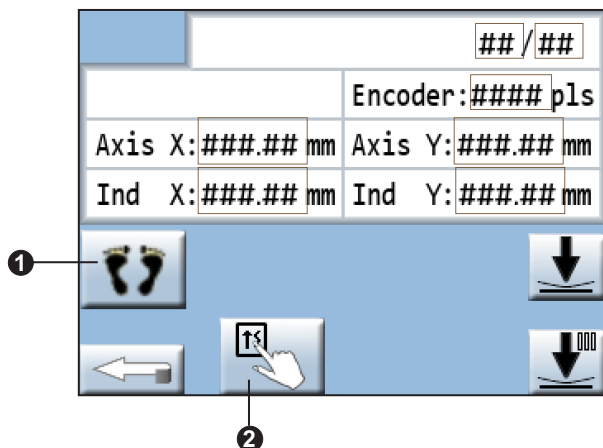
- ❶ Copying of a buttonhole program
- ❷ Copying of an indexer cycle program

4.3. Software Information Screen



- ❶ Software version numbers

4.4. Buttonhole Step-by-Step Sewing Screen

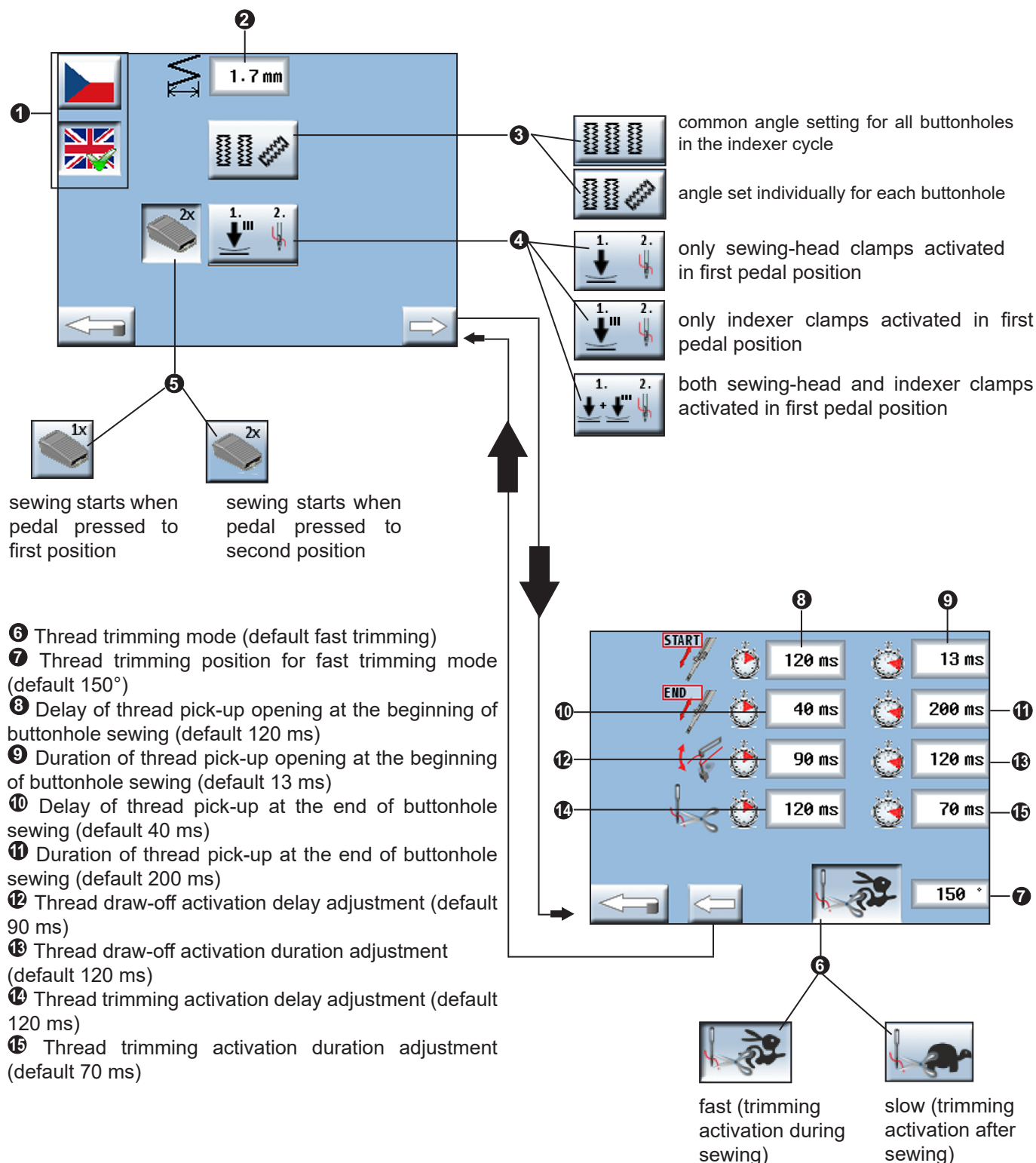


- ❶ Activation of buttonhole step-by-step sewing mode
- ❷ Proceed to next stitch

D - MACHINE CONTROLS

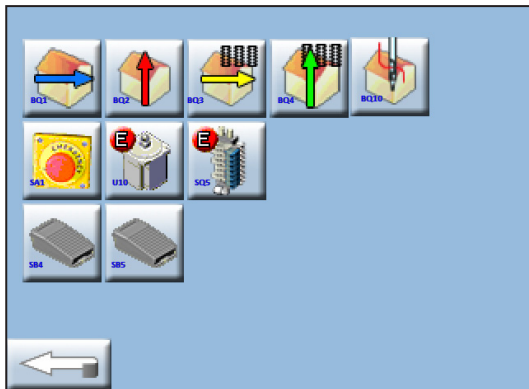
4.5. Machine Parameters Screen

- ❶ Language selection
- ❷ Mechanical bite adjustment – **this value must be set according to the adjusted mechanical bite of the sewing head**
- ❸ Buttonhole angle setting mode
- ❹ Foot-pedal control setting – clamps control when pedal pressed to first position
- ❺ Foot-pedal control setting – sewing start

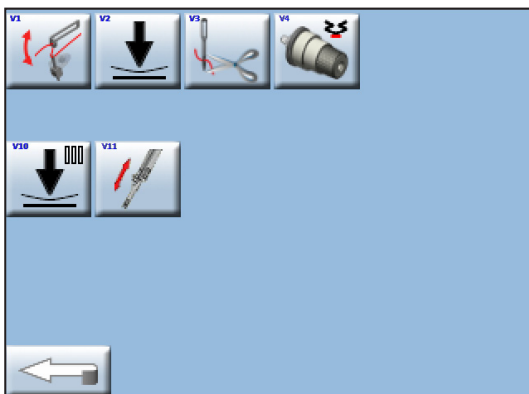


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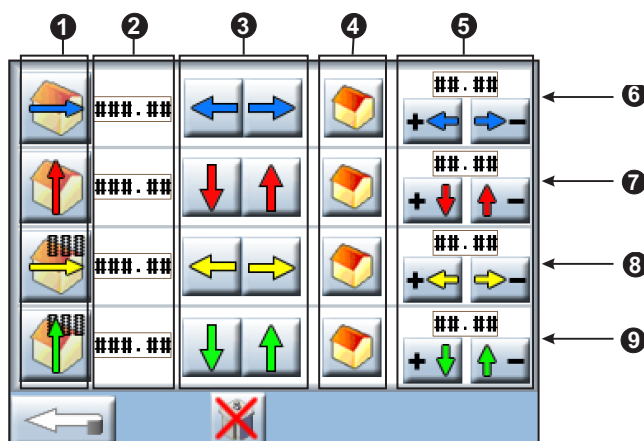
4.6. Sensors Test Screen



4.7. Valves Test Screen



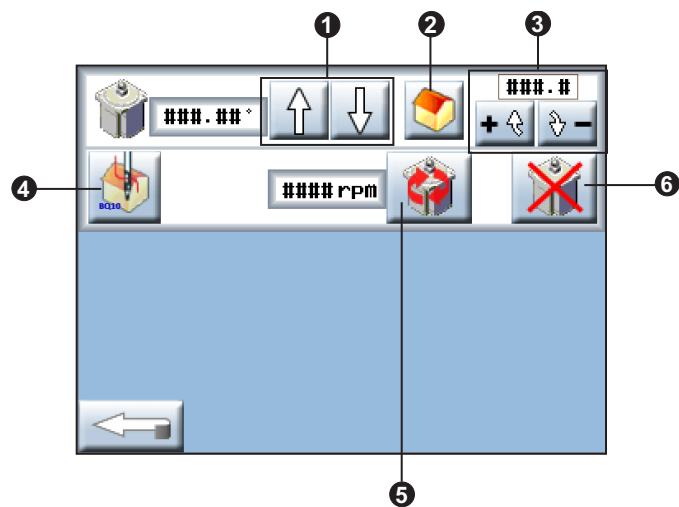
4.8. X-Y Motors Adjustment Screen



- ① Axis home position sensor
- ② Axis current position
- ③ Axis movement test
- ④ Axis home position establishment
- ⑤ Axis home position electronic correction
- ⑥ Axis X row
- ⑦ Axis Y row
- ⑧ Indexer axis X row
- ⑨ Indexer axis Y row

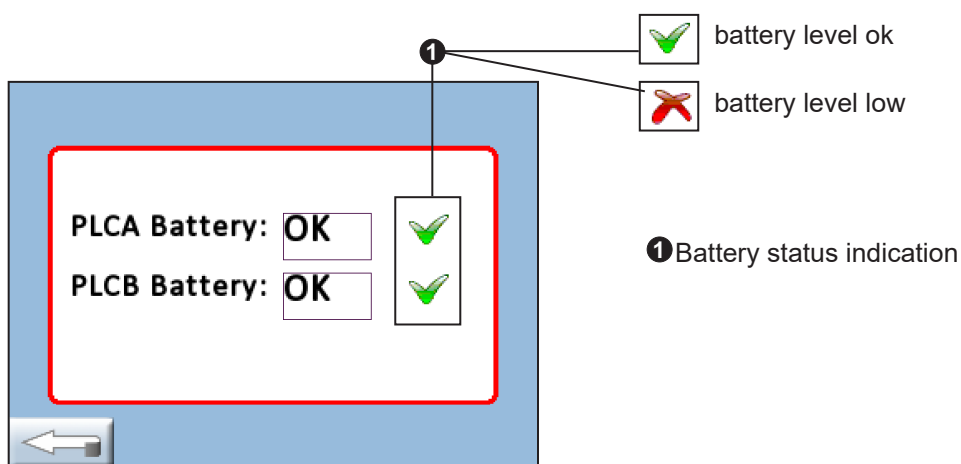
D - MACHINE CONTROLS

4.9. Sewing Motor Adjustment Screen



- ① Sewing motor movement test
- ② Sewing motor home position establishment
- ③ Sewing motor home position electronic correction
- ④ Sewing motor home position sensor status
- ⑤ Sewing motor continual run
- ⑥ Sewing motor enable / disable

4.10. Battery Status Screen



- ① Battery status indication

E - STANDARD MACHINE ADJUSTMENT

1. ELECTRICAL DIAGRAM

