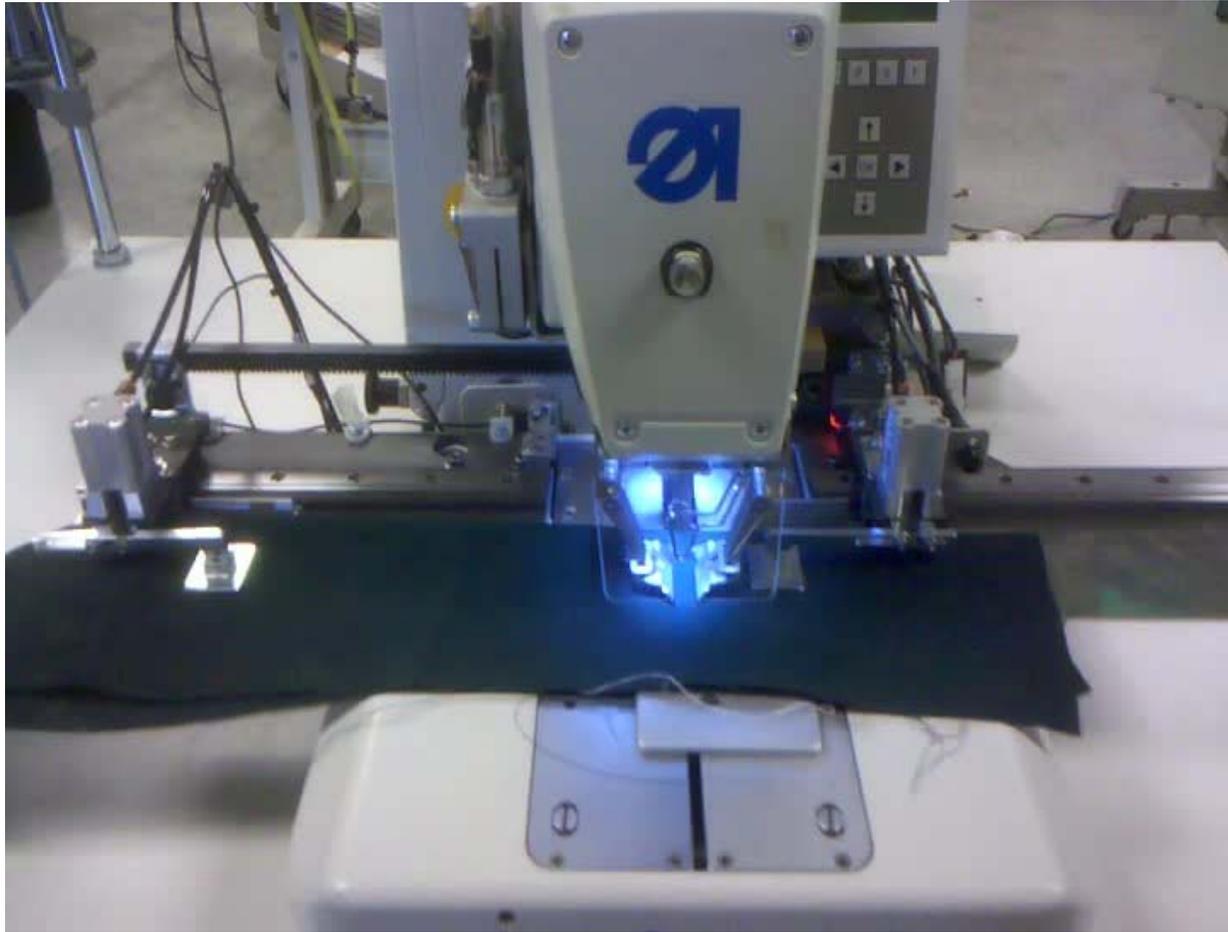


# DURKOPP ADLER 580/GTN1668 INDEXER INSTRUCTIONS



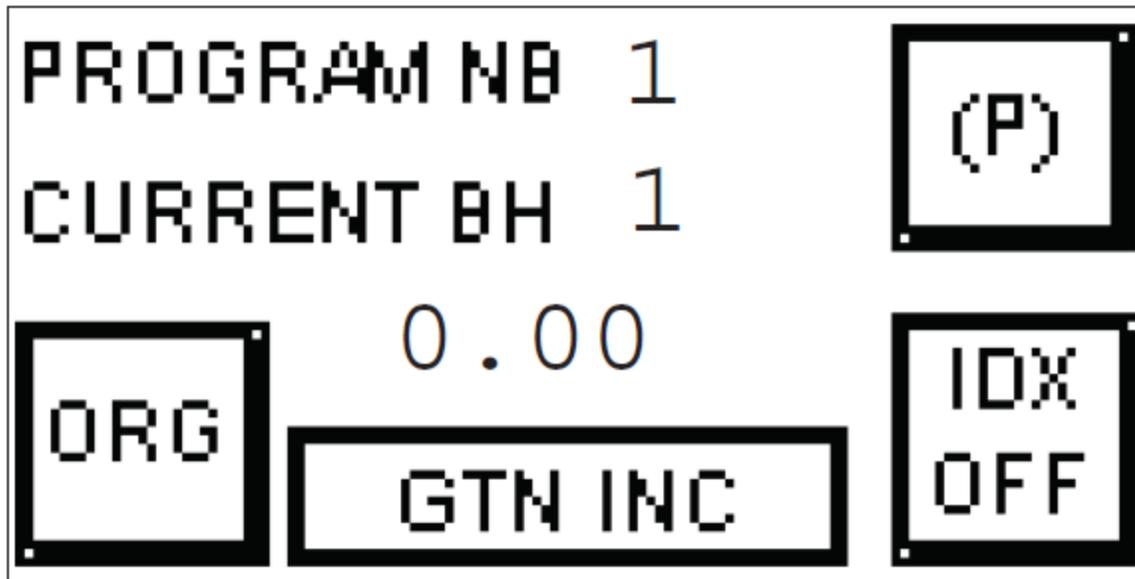
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## MAIN OPERATION SCREEN



**PROGRAM NB.** This number is the current program loaded into memory. There is a maximum of 10 stored programs available to use.

To change number: Press on the actual number and a keyboard will appear. Type a number between 1~10, press enter. The selected pattern is in memory. Note if there is no program it will sew one hole at the zero position.

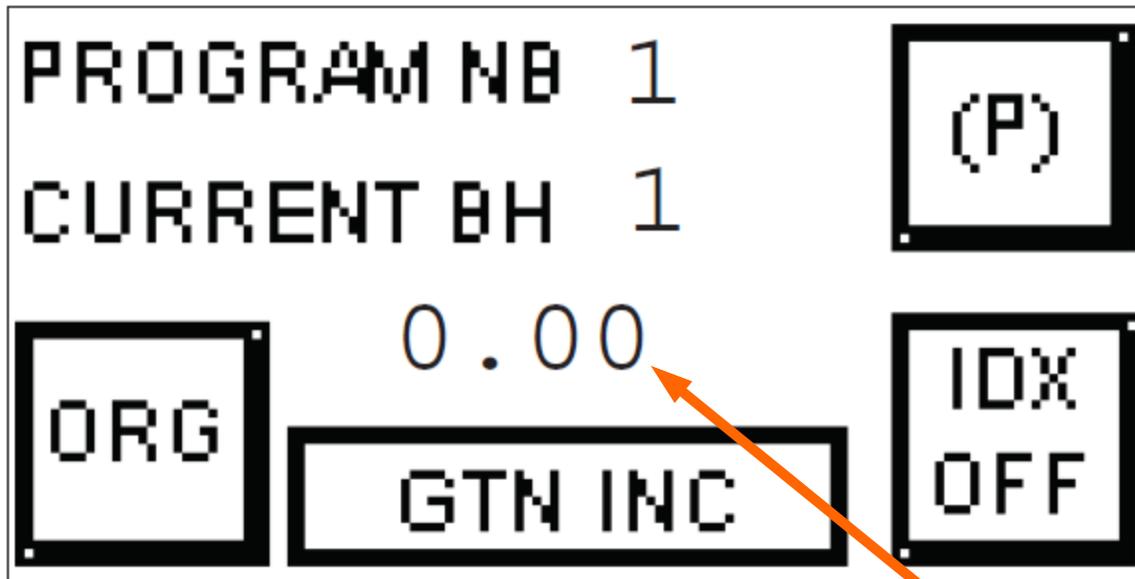
**CURRENT BH.** The number appearing on this screen is the current buttonhole to be sewn. If you press this button and enter a different number it will jump to that location.

**Example:** If you have a program with 4 buttonholes you can type any of the 4 positions to start your cycle.

**ORG.** Pressing this button will move the index position back to the start position by way of the position origin sensor.

**Example:** If the first hole you want to sew is at 25 after you press ORG the indexer will move to the mechanical home which is zero then jump to 25mm position. It always looks for mechanical home first

## MAIN OPERATION SCREEN CONTINUED



CURRENT POSITION

**CURRENT POSITION:** This is the position of the indexer. Depending on the loaded program and the current buttonhole this number will reflect that information.

**IDX ON/OFF:** The indexer is programmed to be **on** when the machine is turned on. If you press the key to turn it off, the indexer moves to the right and turns indexing function **off**. When it is off the indexer is out of the way to remove the machine clamps for threading. You can test sew or do repairs from this position.

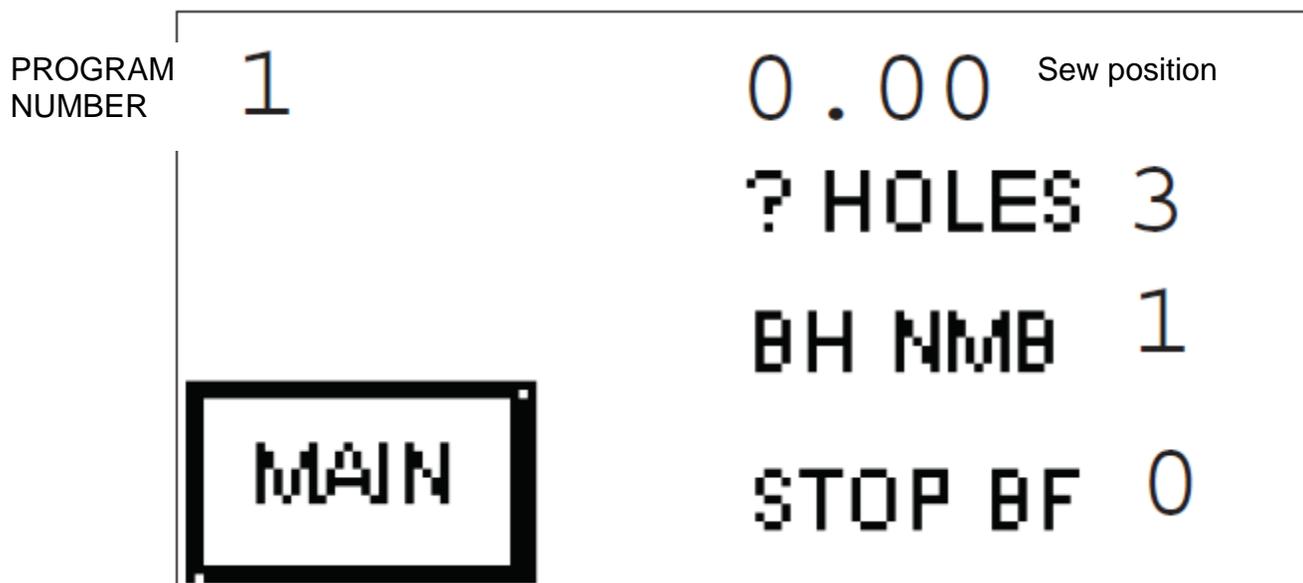
**NOTE:** The sewing machine is still active to sew in this state. Only the indexer portion is off.

**BOOT SEQUENCE:** When the machine is turned "ON" the indexer will move slightly to the right then it will slowly move left to the home position sensor. The home position sensor is the Sunx sensor on the right side of the indexer. When it reaches the home sensor the indexer stops and it marks this position as "Zero". All the programs will base their position off of the base zero position.

**BASIC OPERATION:** When writing programs as we will discuss on next page the absolute position will be the location the machine will sew at. If you write a program with 3 buttonhole positions and the three positions are 0, 25.4, and 50.8 you will sew the first hole at zero, move 25.4 mm and sew, and move another 25.4mm relatively to the 50.8mm position. Your input values will always be the absolute position not the relative movement.

**(P):** Program mode.

## PROGRAM MODE



**PROGRAM NUMBER:** The program number is the number in the upper left corner. This is the number of the program you are creating or editing. Whatever program you were in when you pressed the “P” key is what you will see. If you want to create a different program or edit a different program simply press this number and when the keyboard appears enter the new number between 1 to 10.

**CREATING PROGRAM:** First step is enter how many buttonholes will be sewn. ? Holes. Press the number and when the keyboard appears press the number of holes you want to sew per cycle.

Second step is confirm the BH NMB (button hole number) is at the 1 position. You will enter the position data for buttonhole one. If you want the first button hole to start sewing at the zero position then you simply press the BH NMB and when the keyboard appears enter 2. If you want the first buttonhole to start at any other position then with the BH NMB still at 1 press the number 0.00 and when the keyboard appears type the position you want to start sewing at. (you can enter .01 increments)

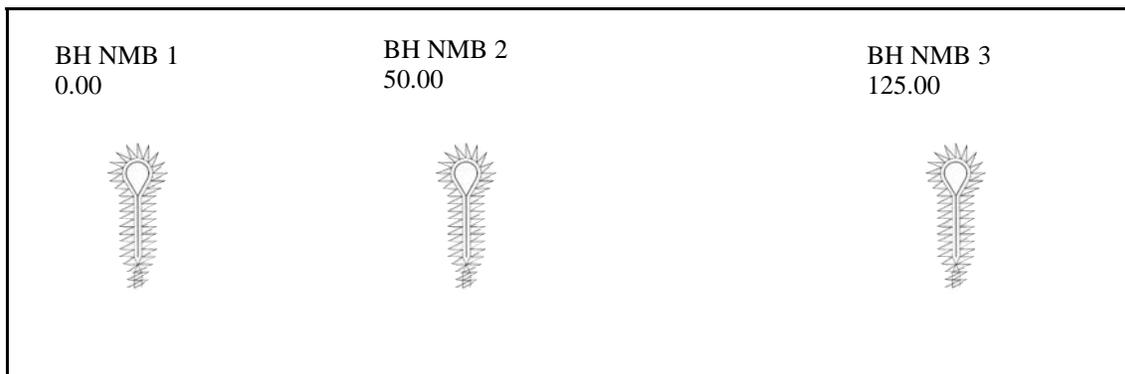
Continue entering data for all BH NMB in your program. If you have them all at zero that is where they will sew.

**STOP BF:** This is a command that is used on a mirrored program. If you write a program that has 6 buttonholes and you want it to temporarily stop the program to re-load a piece of fabric you can use this feature. There is only 2 choices. 0 means no stop and any other number you want to temporarily stop at. **NOTE:** You only get one temporary stop per program. The “BF” means **before the** number you input. **Example:** if you had 6 buttonholes and you entered 4 in STOP BF this means the clamp would come up after the 3 buttonhole and allow you to place another piece **before** it sews the 4th, 5th, and 6th hole.

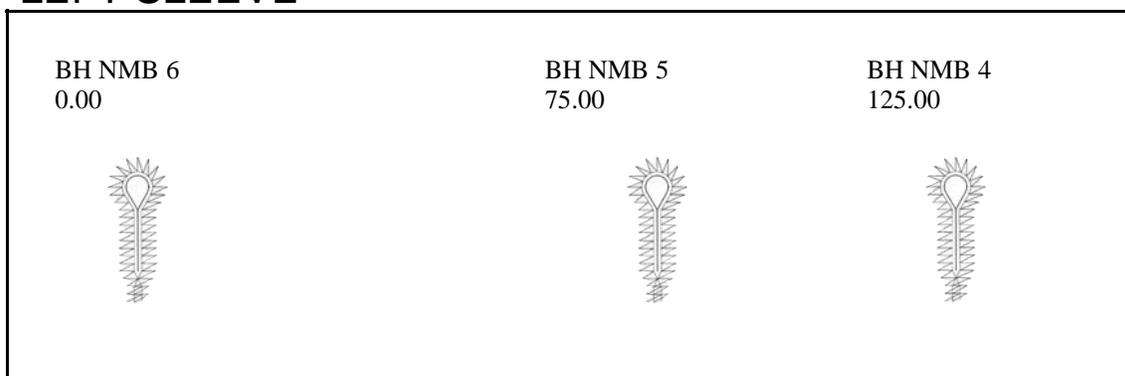
## PROGRAM EXAMPLE:

### RIGHT SLEEVE

? HOLES: 6 STOP BF: 4



### LEFT SLEEVE



**NOTE:** There are many different possibilities to programming the GTN1668. You do not have to start your first buttonhole on zero. You can start it anywhere you wish to as long as it fits within the area of the two sensors. The left side of the indexer is adjustable so if you make the field smaller then you must take that into consideration on the program loaded.

The above program could be written as two separate programs. If you had two machines in tandem and one machine running lefts and one running rights write two programs. Programs would be written with 3 buttonholes rather than 6. You would put zero in BF and BH NBR 4, would become 1, BH NBR 5 would become 2, and BH NBR 6 would become 3. The left sleeve would always start from the opposite side.