

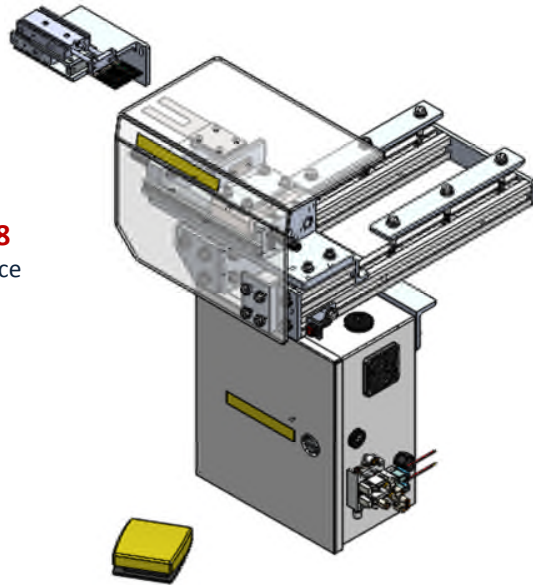
CEDAR Systems: **WLD/1306** Installation & Operation



CEDAR Systems CS-1306 & ODC-2512
Electronic, Programmable Pattern Machine
With "On Demand" Cold Cut Device



CEDAR Systems WLD-18
Web Tuck & Hook Insert Device



Collier Equipment, Inc.
100 Mill Creek Circle
Lexington, AL 35648

Ph: (256) 229-6595
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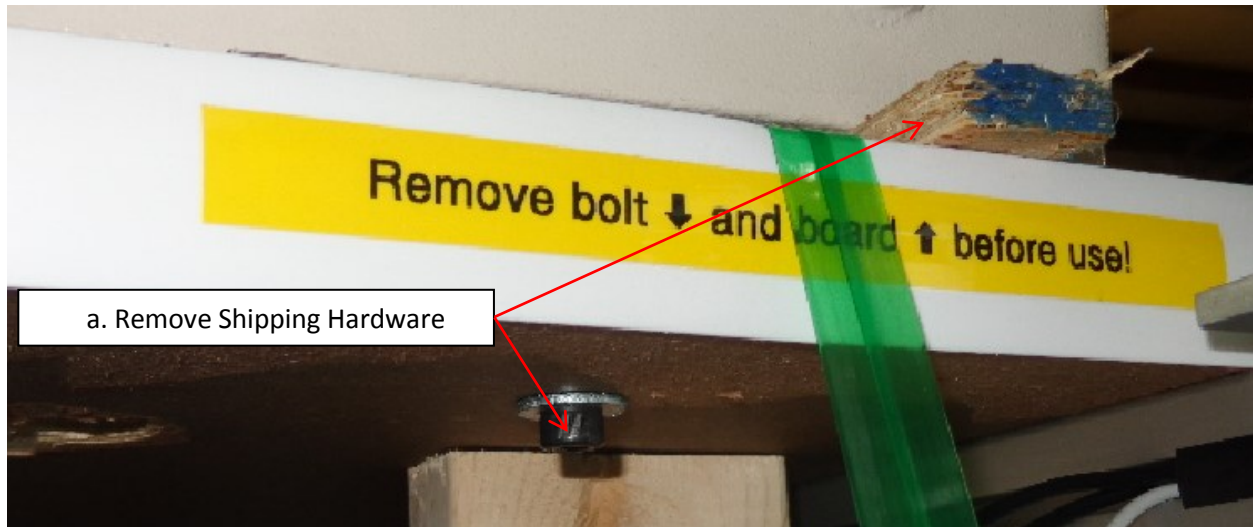
CEDAR Systems
Automated Machines & Devices
For the Sewn Products Industry

The home of **tice** Engineering & **VMW** AUTOMATED APPAREL EQUIPMENT

CEDARS WLD/1306 with ODC-2512 Installation & Operation

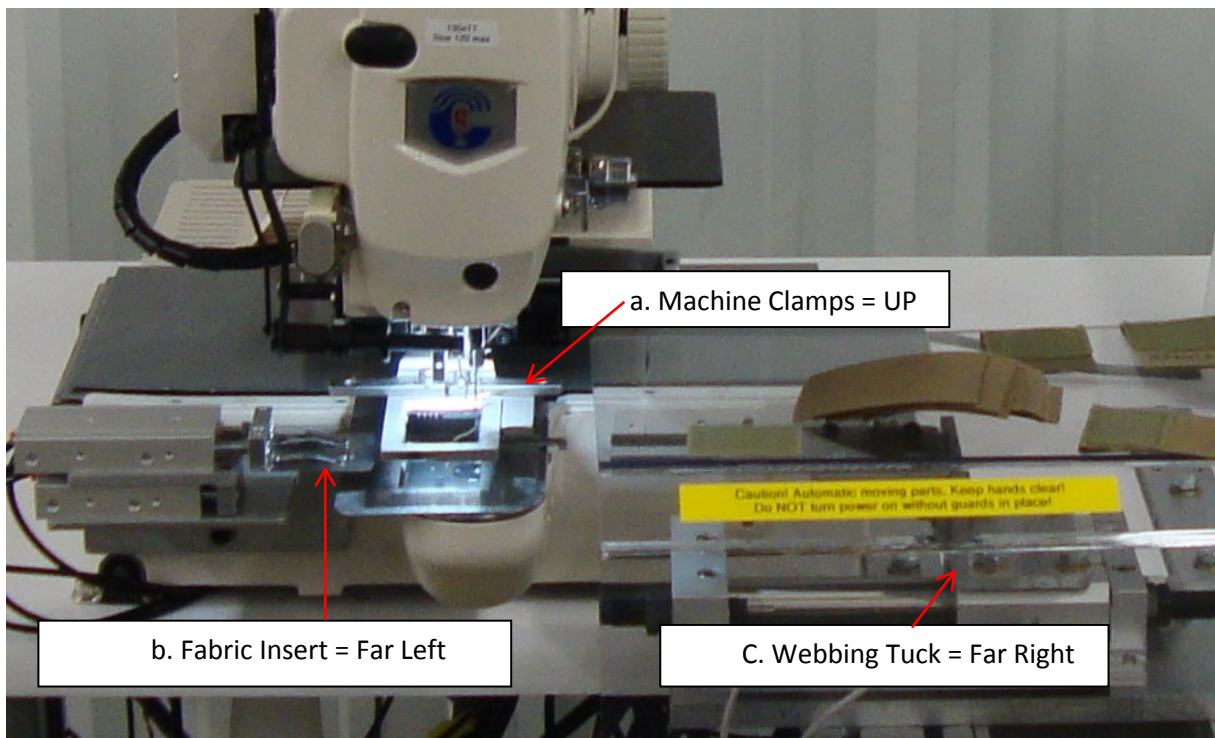
1) Sewing Head anchor bolt and shim:

- a. Upon receiving of your CEDAR Systems WTD/1306, there is an anchor bolt with a washer under the table and wood shim between the sewing head and table top. These are in place to keep the machine secure during shipping. **These MUST be REMOVED** and discarded before operating this equipment. Failure to do so may result in damage to the equipment.



2) Home positions for each component of the CEDAR Systems WLD/1306:

- a. Machine Clamps are in the UP Position.
- b. Fabric Insert / Material Fold Assist is retracted to the far left.
- c. Lower Webbing Tuck is retracted to the far right.



!!Only properly trained and qualified personnel are to operate this equipment!!

3) Needles:

- a. The correct Needle System for the CEDARS WLD/1306 is 135x17. The Maximum Size is 120.

4) Air Pressure:

- a. Incoming Air Pressure is to be set 70 – 100 psi.

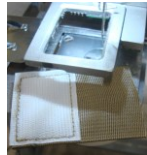
5) Incoming Voltage:

- a. The incoming voltage to this unit is to be 220 VAC, Single Phase.
 - i. The incoming power goes into the main On/Off Switch. Then it exits the On/Off Switch and enters a junction box underneath the right side of the table.
 - ii. From the junction box, there are 2 exits which go to the following:
 1. Sewing Machine Control Box
 2. WLD Power Supply

6) Turning the machine on: DO NOT proceed if you are not qualified to operate this machine.

- a. Before turning the machine on, make sure that all safety guards are properly attached and the control box door for the WLD is closed and secured.
- b. It is recommended to place a piece of webbing under the clamp to help protect the fabric retainers from damage during the initialization of the machine.
- c. After setting air pressure, checking that the incoming voltage is correct and all safety guards are in place, press the main ON switch.
- d. Make sure program #2 is selected in the home screen of the machine programmer then press the Blue Icon in the lower left corner of the programmer. This will make the machine “Ready” to sew the first piece.

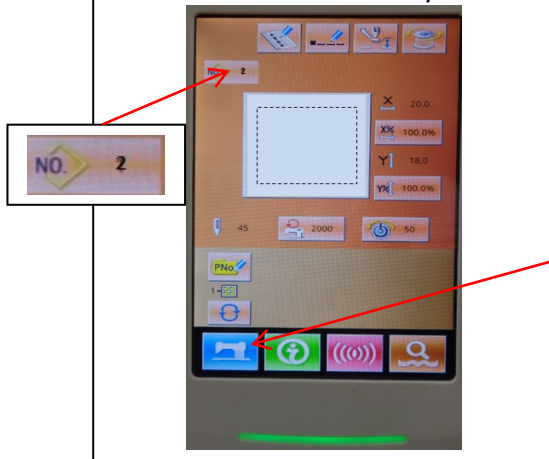
b. Place spare fabric under clamp



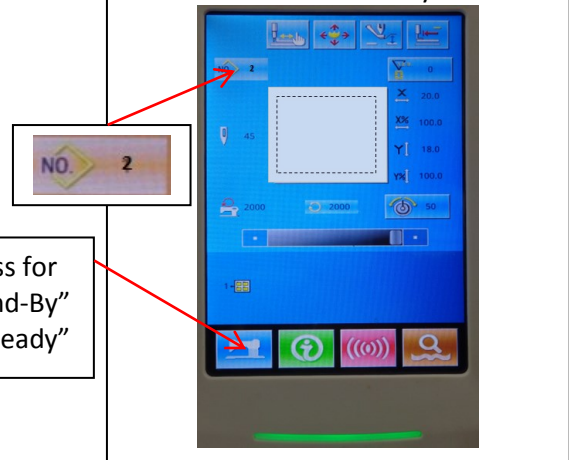
c. Off / On Switch



d. Machine is in “Stand-By Mode”

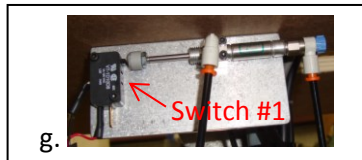
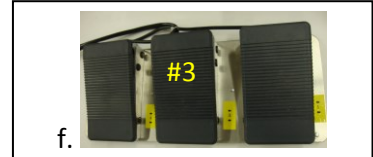
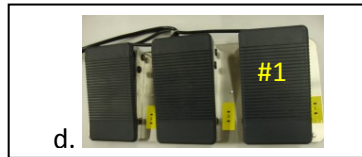
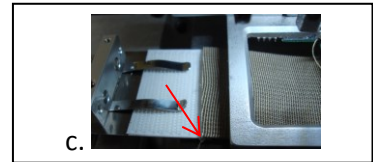
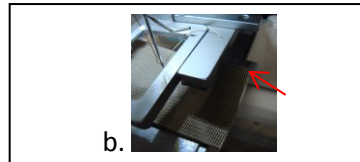
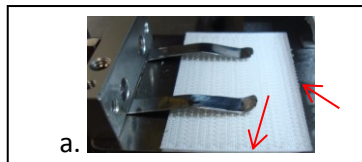


d. Machine is in “Ready Mode”



7) Sequence of operation for insertion:

- a. Insert pre-cut Hook (size is to be 2" x 1.50") onto the Hook Inserter, between the stainless material and the spring fingers. Making sure that the right edge of the hook is aligned with the right edge of stainless and front edge is aligned with the front edge of the stainless.
- b. Insert pre-cut webbing (minimum length is to be 3-3/8"). Align the right-rear corner of the webbing with the right-rear edge guide.
- c. Align the left-front edge of the webbing on top and with the front edge of the hook inserter.
- d. Press and release the #1 Machine Foot Pedal to lower the right-clamp.
- e. Press and release #2 External WLD Pedal to start the WLD device motions. This will insert the Webbing Tuck device and the Hook Load device.
- f. Press and release the #3 Machine Foot Pedal to lower the left clamp.
- g. Once the left clamp is lowered, Switch #1 (Located under the table, on the left side) makes contact and returns the WLD devices to the home positions.
- h. If you are satisfied with the alignment of the materials, Press #4 Machine Foot Pedal to begin sewing.
- i. If the materials need to be re-aligned, Press #3 Machine pedal to raise the left clamp, Press #1 Machine Pedal to raise the right clamp then, Press the Reset Button (located on the right side of the WLD main frame) to manually return the WLD devices to the Home positions.



Always practice safety procedures when operating automated equipment.

For more information on automated equipment and devices, contact us.

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