



意大利威比玛 牛仔智造专家

ITALY VI.BE.MAC. JEANS SMART SOLUTION

使用说明书

OPERATING INSTRUCTION

B2501

全自动牛仔贴袋机

Full Automatic Pocket Setter



开头语

衷心感谢您购买本公司产品！

使用机器之前，请仔细阅读本操作手册，并按照本手册内注明的方式进行操作，否则，如违规操作所造成损失本公司不承担责任。请您仔细加以保管，以便日后查阅。

说明书的内容可能被修改，而不需预先通知。

PROLOGUE

Thanking you for your purchase our products sincerely.

Please reading this operation manual carefully before operation. If the user operates the machine contrary to regulations herein, we will not take responsibility for any loss caused thereby to the user or any third party. Keep it carefully for reading in the further.

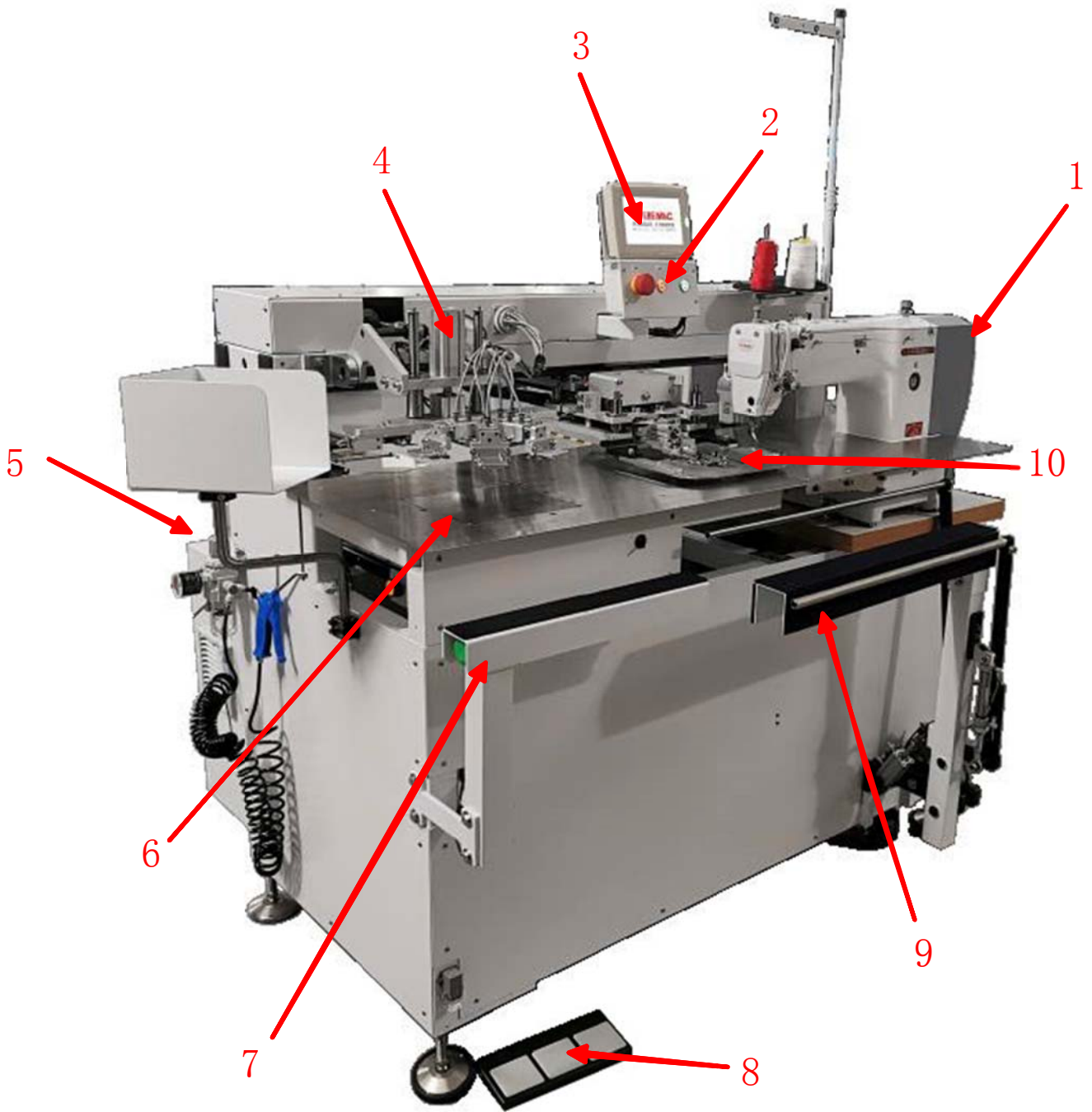
The contents of this manual may be subject to change without advance notification.

目录

第一章 设备基本信息.....	1
第二章 设备参数.....	2
第三章 安全注意事项.....	3
第四章 按键功能说明.....	4
4.1 各按键功能说明.....	4
4.2 复位操作说明.....	6
4.2.1 开机复位操作.....	6
4.2.2 急停复位操作.....	6
第五章 触摸屏界面说明.....	7
5.1 主控界面说明.....	7
5.2 缝制加工界面.....	8
5.3 加工计数区.....	9
5.3.1 底线计数.....	9
5.4 花样校正.....	10
5.5 灯光控制.....	10
5.6 功能按键.....	11
5.6.1 U 盘读取.....	11
5.6.2 花样管理.....	12
5.6.3 设备检测.....	12
5.6.4 辅助功能.....	13
5.6.5 取料测试.....	13
5.7 绕线.....	14
第六章 操作流程.....	15
6.1 操作前的准备工作.....	15
6.2 操作说明.....	15
6.2.1 启动机器.....	15
6.2.2 复位操作.....	15
6.2.3 裁片摆放.....	18
6.2.4 口袋摆放.....	18
6.2.5 口袋折叠.....	19
6.2.6 关机.....	19
第七章 调试说明.....	20
7.1 模具更换.....	20
7.1.1 模具位置.....	20
7.1.2 换模步骤.....	21

7.1.3	调整折角刀位置	22
7.1.4	取料测试	23
7.2	冗位调整	24
7.2.1	冗位效果	24
7.2.2	冗位大小调整	25
第七章	电气配线	26
8.1	信号板输入	26
8.2	信号板输出	27
第八章	维护	29
9.1	设备保养明细	29
9.2	料件更换	29
第九章	常见问题及解决方法	30
第十章	装箱清单	33

第一章 设备基本信息






- | | | | | |
|--------|--------|-------|--------|---------|
| 1、缝纫机头 | 2、电源开关 | 3、触摸屏 | 4、折叠装置 | 5、电控箱 |
| 6、吸风系统 | 7、放料架 | 8、脚踏板 | 9、收料装置 | 10、移料装置 |

第二章 设备参数

全自动冷折贴袋机		
1	机头配置	VBM2210-D
2	最快缝纫速度/rpm	2800r/min
3	机针型号	DPX17
4	缝制针距长度/mm	0.05—12.7
5	缝制范围 mm	90X90~220X220mm
6	旋梭	半回转 2 倍摆梭
7	额定电压/V	220
8	额定气压/Mpa	0.6
9	额定功率/KW	3.5KW
10	单位时间耗气量	1.8L/min
11	主轴、X/Y 控制	AC 伺服马达
12	设备尺寸/mm	1750L×1250W×1900H（展开）
13	包装尺寸/mm	1920L×1500W×1775H（打包）
14	设备净重/kg	500kg
15	装箱毛重/kg	600kg

第三章 安全注意事项

为了安全地使用自动机的注意事项

	<p>1、为了防止因触电造成的事故，在接通了电源的状态下，请不要打开马达电气箱的防护盖，也不要触摸电气箱内的零部件。</p>
	<p>1、为了防止对人身的伤害，缝纫机上下动作时或返回原来位置时，请一定注意不要夹到手指。 2、堆叠器动作时，请注意避让不要将手等伸入其中，以防夹手。 3、关闭了电源开关之后，缝纫机压脚将动作，因此请注意不要夹到手指等。 4、当调试折叠装置时，折叠装置动作，请注意不要让气缸夹到手指。 5、移料装置动作时，请注意不要将手移入移料装置中或运转轨迹上，以防手指夹伤。</p>
	<p>1、为了防止对人身的伤害，请不要在卸下了同步带护罩、手指防护器等安全装置的状态下运转机器。 2、为了防止被卷入机器的人身事故，机器运转中，请不要让手指、头发、衣服靠近带轮、皮带、马达附近，也不要物品放到上面。 3、为了防止对人身的伤害，打开电源时或缝纫机运转中，请不要把手指放到机针附近。 4、为了防止对人身的伤害，缝纫机运转中，请不要把手指放到挑线杆护罩内。 5、缝纫机运转是高速转动，为了防止伤害到手，运转中请绝对不要让手靠近机针。另外，更换缝纫线时，请一定关闭电源。 6、缝纫机运转中，请不要切断电源或切断空气供给源。 8、为了防止因触电造成的事故，在卸下电源地线的状态下，请不要运转缝纫机。 9、为了防止因电气零件损坏造成的事故，打雷时，为了安全请停止作业，并拔掉电源插头。 10、为了防止因电气零件损坏造成的事故，从寒冷地方立即移动到温暖地方等时会发生结露现象，因此请等待水滴完全干燥后再接通电源。 11、因为本产品属于精密机器，所以操作时请充分注意，不要把水、油溅到机器上面，也不要让机器掉落给与机器冲击。 12、本机器是 A 级工业用机器。在家庭环境下使用此机器的话，有可能发生电波干扰的现象。此时，请使用采取适当的措施解决电波干扰问题。</p>

*重要安全信息：

- ✓ 对机器操作不当可能会导致人身伤害，请在操作前仔细阅读本说明并正确操作。
- ✓ 机器正式运行通电前，请先清理机器上以及周围杂物，并再通气。
- ✓ 严禁在通电状态下打开电控箱或触摸屏内部零件。
- ✓ 本机器需要在接受培训后或专人指导下使用，以确保使用者的人身安全。

第四章 按键功能说明

4.1 各按键功能说明

(1): 气源开关——横向拨动手滑阀，实现设备气源通断



(2): 急停按钮（左）——缝制急停
关机按钮（中）——按下后机器关机
开机按钮（右）——按下后机器开机



(3): 脚踏板——脚踏模式下，袋形板的伸出与退回



(4): 启动开关——两侧按钮同时按下后，设备开始折叠或移料动作



(5): 折叠急停——按下黄色按钮后袋型板后退返回初始状



(6): 夹具气路通断——将手扳阀向左侧扳动，夹具气路断开，进入换模状态

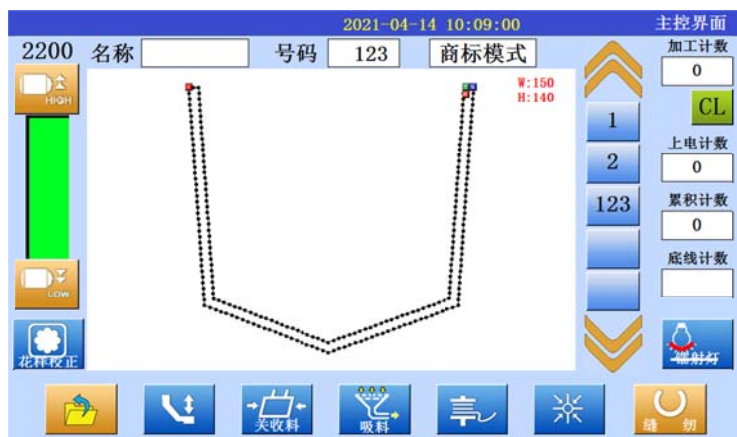


(7): 整套夹具气路切换——逆时针旋转锁紧套，夹具气路快插接头打开
顺时针旋转锁紧套，夹具气路快插接头被锁紧

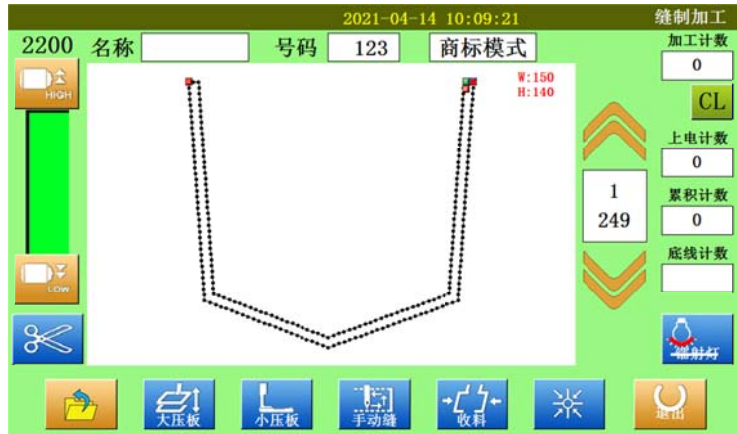


(8): 触摸屏界面

A: 主功能界面



B: 缝制加工界面



4.2 复位操作说明




4.2.1 开机复位操作

步骤	说明	按键方法
1	开机	4.1- (2)
2	复位	5.1-
3	进入缝纫模式	5.1-

4.2.2 急停复位操作

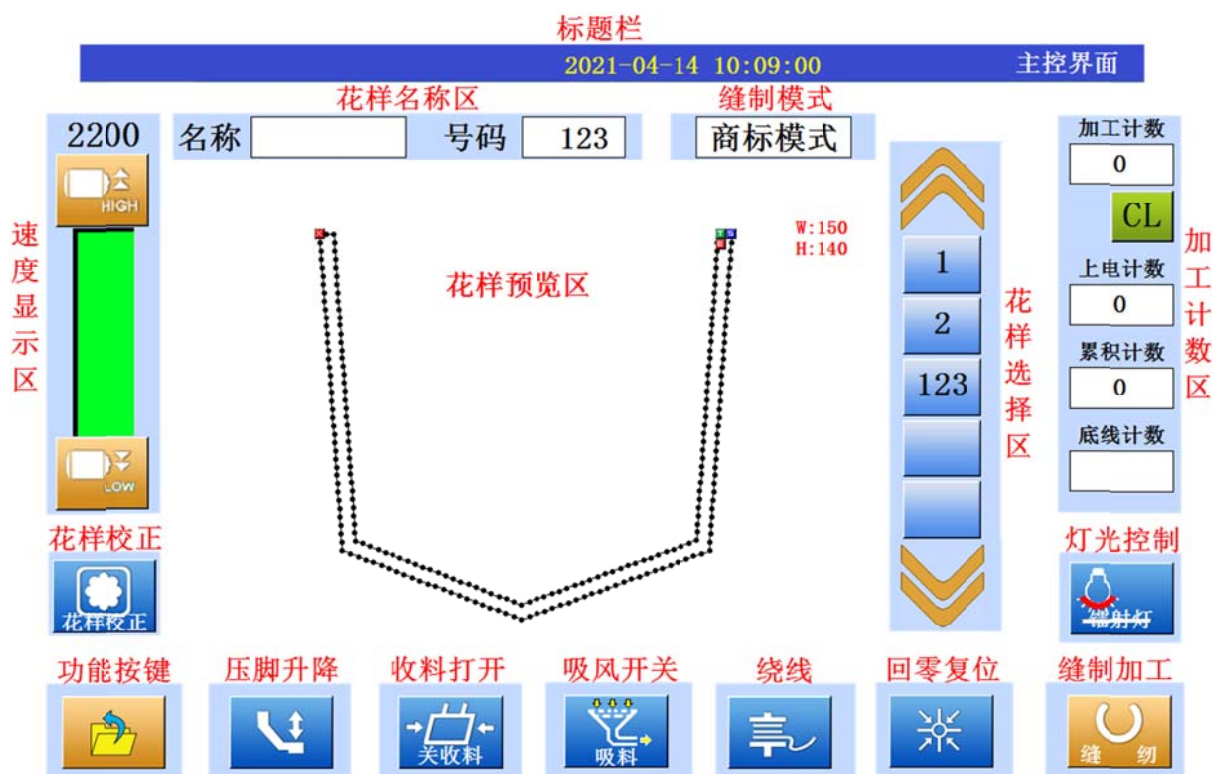
情景一：折叠急停复位，复位的步骤：按下机器左侧黄色按钮后，袋型板后退返回初始状态，此时再踩下脚踏板，袋型板伸出，面料重新摆放，摆放完成后按下绿色启动按钮，开始折叠动作。

情景二：缝制过程中急停，复位的步骤：急停开关顺时针旋转复位，然后可以选择：

- (1) 继续缝制：在 B 缝制加工界面点击右侧  按键退至断线处，再点击下方  手动缝按键继续缝制；
- (2) 重新缝制：在 B 缝制加工界面点击  回零按键进行复位。

第五章 触摸屏界面说明

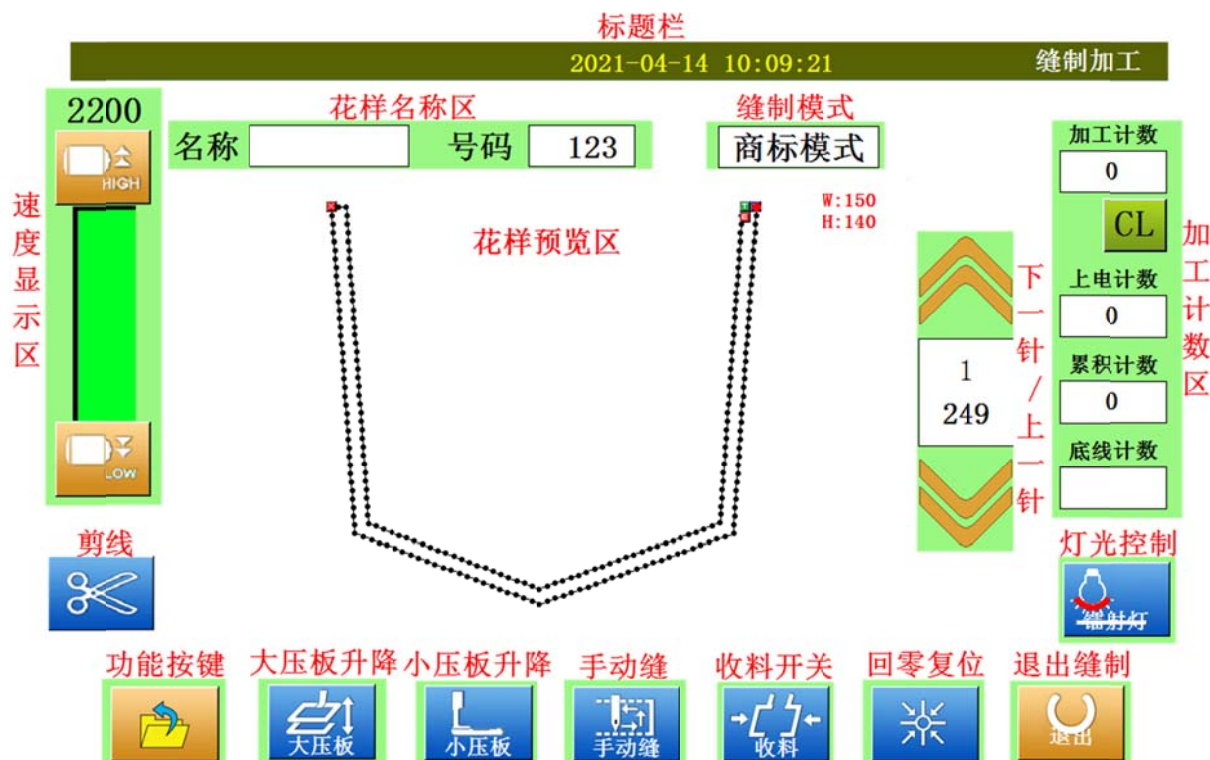
5.1 主控界面说明



功能	概述	详细设定
标题栏	显示当前时间，界面名称	
花样名称区	显示当前花样名称，序号	
缝制模式	显示当前缝制模式 自动模式：全自动模式 商标模式：半自动模式	一级参数 1.36 修改
速度显示区	显示当前缝制速度 ：加速 ：减速	
花样预览区	显示当前缝制花样	
花样选择区	点击花样编号或者 键和 键进行切换	
加工计数区	显示加工计数	见 5.3
花样校正	进入花样校正界面，调整抓料位置	见 5.4
灯光控制	进入灯光控制界面	见 5.5
功能按键	点开功能选择	见 5.6
压脚升降	点击切换压脚高位/低位	
收料打开	点击打开收料杆	

吸风开关	点击开启/关闭吸风	
绕线	点击进入绕线界面	见 5.7
回零复位	点击进行复位操作	
缝制加工	点击进入缝制加工界面	见 5.2

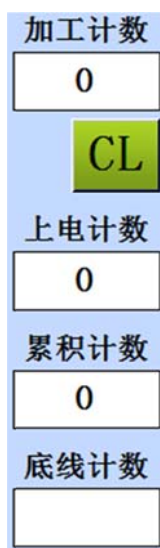
5.2 缝制加工界面



功能	概述	详细设定
标题栏	显示当前时间，界面名称	
花样名称区	显示当前花样名称，序号	
缝制模式	显示当前缝制模式 自动模式：全自动模式 商标模式：半自动模式	一级参数 1.36 修改
速度显示区	显示当前缝制速度 ：加速 ：减速	
花样预览区	显示当前缝制花样	
下一针/上一针	点击 键和 键进行下一针/上一针切换	
加工计数区	显示加工计数	见 5.3
剪线	点击进行手动剪线动作	

灯光控制	进入激光灯控制界面	见 5.5
功能按键	点开功能选择	见 5.6
大压板升降	点击切换大压板高位/低位状态	
小压板升降	点击切换小压板高位/低位状态	
手动缝	a) 点击进行缝纫动作，可用于不折叠只缝纫需求，便于观察线迹状态； b) 断线后回到断线处继续缝纫；	
收料开关	点击打开收料杆	
回零复位	点击进行复位操作	
退出缝制	点击退出缝制加工界面	

5.3 加工计数区



加工计数：显示加工数量

CL：点击清除加工数量

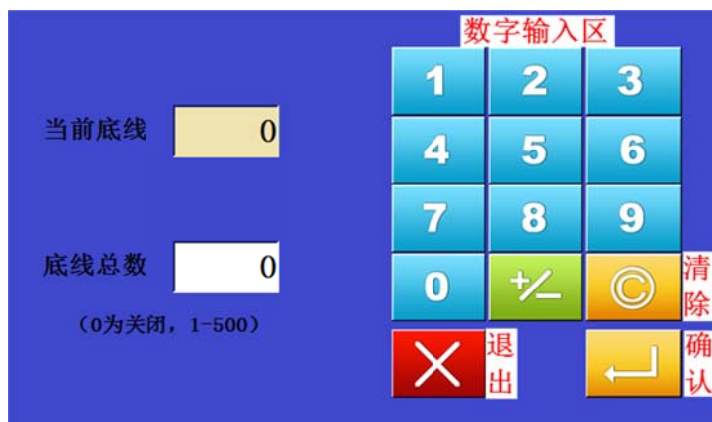
上电计数：显示本次开机后加工数量

累积计数：显示累计数量

底线计数：进行底线计数操作，见 5.3.1

5.3.1 底线计数

点击底线计数方框，可进入设置界面：



当前底线：设置当前可缝制件数

底线总数：设置一个满梭芯缝纫线可缝制件数

注意：当数值为 0 时，表示取消底线计数。

5.4 花样校正


点击主控界面花样校正按键，可以进入花样校正界面，进行抓料调整：



取料按键：点击会将压板移到取料位置

回零按键：点击会将压板从取料位置移动到零点位置

方向调整：点击可以移动压板进行取料位置校正，：正常速度 ：稍快速度

：更快速度

压板升降：点击控制压板高位/低位状态

不保存退出：点击退出该界面并不保存修改

保存退出：点击保存修改并退出该界面（注意：只有点击回零按键，压板回到零位才有效）

5.5 灯光控制

点击灯光控制按键可进入激光灯控制界面：



袋形板：点击袋形板动作

吸风开关：点击进行吸风动作开启/关闭

灯光：1-4 为灯光控制按键，点击可打开/关闭灯光，如辅助定位激光灯/机头 LED 灯

退出：点击退出该界面

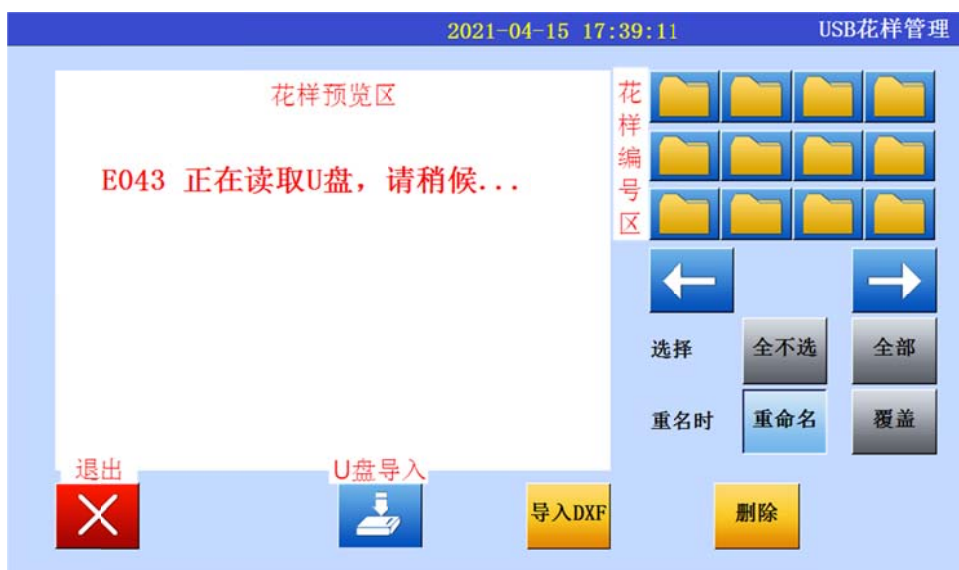
5.6 功能按键

点击功能按键可展开功能界面：



功能	概述	详细设定
U 盘读取	可将 U 盘中的花样读取到触摸屏中	见 5.6.1
花样管理	进行花样的删除，存储至 U 盘	见 5.6.2
新建花样	进行新花样的编辑	见《花样编辑说明书》
修改花样	进行当前花样的修改	见《花样编辑说明书》
说明书	本机使用说明书	
参数管理	进行本机缝制参数的设置	
设备检测	进行本机的检测与调试	见 5.6.3
辅助功能	其他辅助功能	见 5.6.4
取料测试	进行单步操作模式	见 5.6.5
对模打板	同上	

5.6.1 U 盘读取

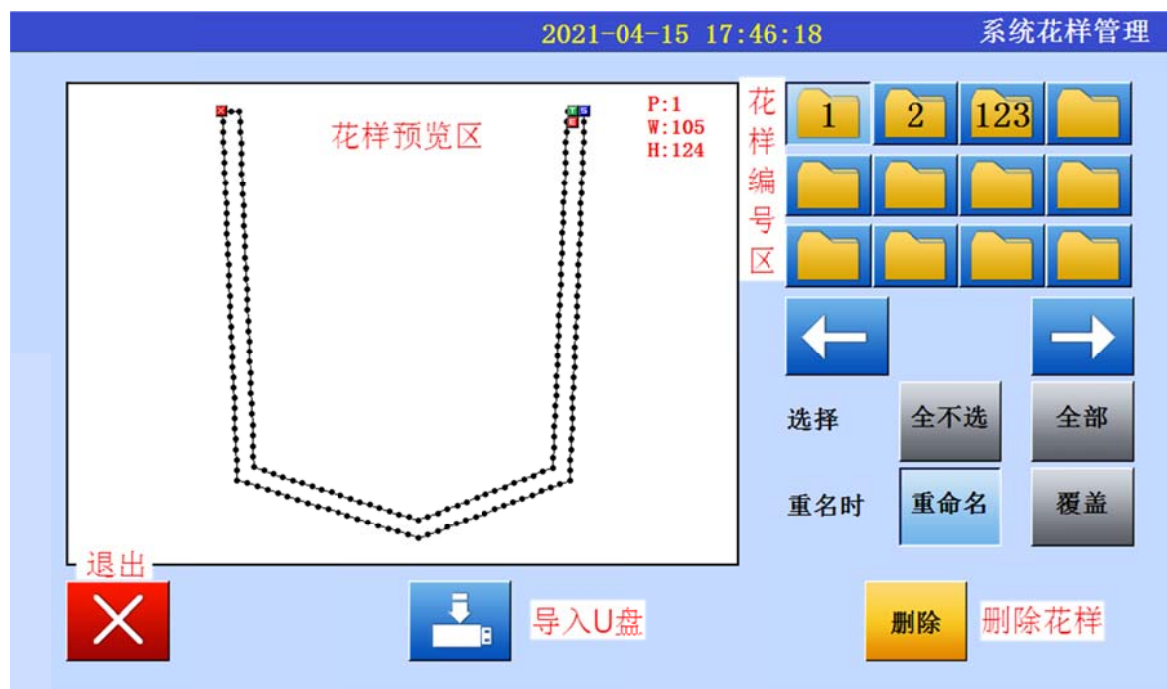


花样编号区：在此显示从 U 盘中读取花样的名称，序号；

选中花样后， 序号框颜色会变浅，注意：可多选！

U 盘导入：点击会将选中花样导入触摸屏；

5.6.2 花样管理



花样编号区：在此显示触摸屏中存储花样的名称，序号；

选中花样后， 序号框颜色会变浅，注意：可多选！

导入 U 盘：点击会将选中花样导入 U 盘中（需提前插入 U 盘）；

删除花样：点击会将选中花样删除，注意：可多选花样并同时删除！

5.6.3 设备检测

点击设备检测进入设备检测界面：



输出测试：点击进入本机输出测试界面，点击各按键可测试相对应的输出模块；

输入测试：点击进入本机输入测试界面，移动本机各部件可进行输入模块测试；

X/Y 轴测试：点击进入本机移动轴测试界面，点击方向键移动 X/Y 轴；

触屏校对：点击后可以触屏的校正；

主轴测试：点击后可以缝纫机主轴的测试；

息屏设置：点击进行触摸屏的息屏（即触摸屏无动作后进入暗屏）参数设置；

5.6.4 辅助功能

点击辅助功能进入辅助功能界面：



修改密码：可以修改本机参数设置界面密码；



恢复设置：点击进入本机参数恢复出厂设置界面；

升级备份：点击可以进入触屏升级界面；


中文显示：点击可以进行中英文切换（需关机重启后才会生效）


5.6.5 取料测试

本界面可以进行单步测试，已进行模具调试；

点击  按键和  按键可以进行上一步/下一步操作（按下绿色启动按钮也可以下一步操作，但不能后退）；

* **Step:** 显示当前步数；

 **取料校正**：当进行到第 18 步时，可以点击此按钮进行压板与袋形板的位置校正；


 **进入打板**：当进行到第 22 步时，可以点击此按钮进入打板界面；



5.7 绕线

点击绕线按键进入绕线界面：



进入绕线界面后，点击  按键和  按键可以进入绕线速度的减速/加速；双手按压绿色启动按钮（见 4.1 各按键功能说明-（3）），即可启动绕线，点击屏幕退出按钮即可退出绕线状态。

第六章 操作流程

6.1 操作前的准备工作

操作人员开机前应对机器进行检查：

- 清理机器台面杂物，确保不会有杂物阻碍机器运行；
- 检查气压表压力，使其符合机器使用要求；
- 检查针梭是否安装正确；
- 手摇机头手轮，检查机头能否顺畅转动；
- 检查车缝线是否正确穿好；
- 检查压板海绵是否完好无损；

6.2 操作说明

6.2.1 启动机器

按压触摸屏下方启动按钮，设备通电开机。



6.2.2 复位操作

进行开机复位。点击触摸屏中回零复位按键，进行复位（参考 4.1 各按键功能说明至 4.2.2 急停复位操作）



在系统一级参数中可以选择袋形板模式和缝制模式：

1) 参数 1.8 袋形板伸出控制模式

踏板模式：机器复位或循环缝制时，踩下踏板，袋形板伸出，吸风打开；

按钮模式：机器复位或循环缝制时，按下绿色启动按钮，袋形板伸出，吸风打开；

自动模式：机器复位或循环缝制时，袋形板自动伸出，吸风打开；



2) 参数 1.36 缝制模式

商标模式：折叠动作和取料动作独立分开，需要分别按压启动按钮开关才能实现动作需求；

自动模式下：折叠动作和取料动作连接在一起，从折叠、取料到缝制只需按压一次启动按钮开关；

2021-06-17 17:22:05 参数管理 - (1级)

项目	值	项目	值
1. 29 断线检测开关	关闭	1. 30 停车后是否锁定主轴	不锁
1. 31 绕线速度	1300	1. 32 寸动时是否校验主轴	校验
1. 33 花样输入方式	手动	1. 34 断线检测频率	10
1. 35 吸风开关类型	全开	1. 36 缝制模式	商标模式
1. 37 断线检测极性	不变	1. 38 半针位置	800
1. 39 Y反向送料同步校验	-100	1. 40 X反向送料同步校验	-100
1. 41 Y正向送料同步校验	-100	1. 42 X正向送料同步校验	-100

2021-06-17 17:22:23 参数管理 - (1级)

项目	值	项目	值
1. 29 断线			不锁
1. 31 绕线			校验
1. 33 花样			10
1. 35 吸风			商标模式
1. 37 断线			800
1. 39 Y反向			-100
1. 41 Y正向			-100

1. 36 缝制模式

自动模式

✕

商标模式

↩

6.2.3 裁片摆放

将大身裁片摆放于吸风区域



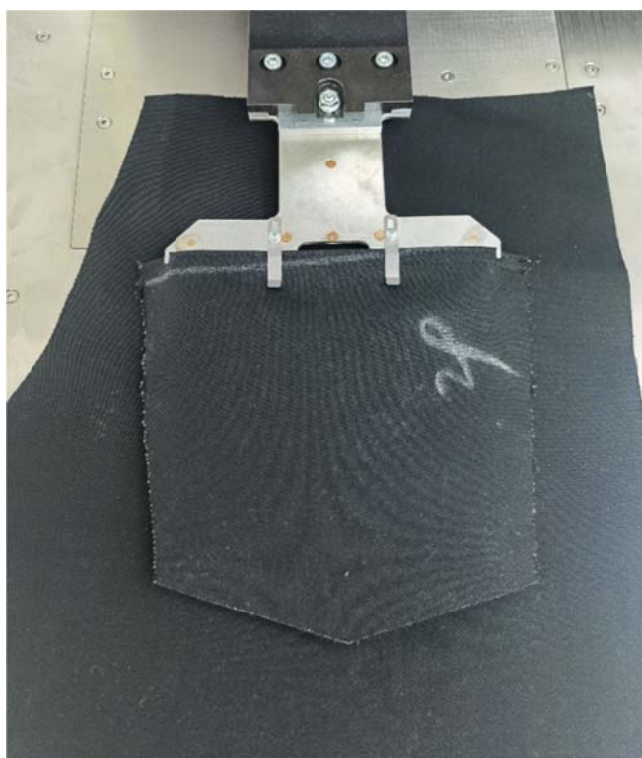
6.2.4 口袋摆放

[商标模式]

放大身布料 → 踩下踏板 → 袋形板伸出 → 吸风开启 → 放口袋裁片

[自动模式]

袋形板自动伸出 → 吸风开启 → 放大身布料 → 放口袋裁片



6.2.5 口袋折叠

双手按压放料架两侧绿色启动按钮开关，此时折叠装置翻转、下压，完成口袋的自动折边；

待折边完成后，自动模式下，取料压板装置自动向左移动抓料；商标模式下，需再次手动按压启动开关后，取料压板装置向左移动取料；

取料压板抓料后，袋形板向后抽出缩回，压板装置移料至右方缝制区域进行自动缝制，缝纫完成后自动收料。

注意：取料压板装置移料至缝纫区域后，即可再次摆放裁片，依次循环操作。

6.2.6 关机

操作完毕后，按压触摸屏下方关机按钮，设备关机。

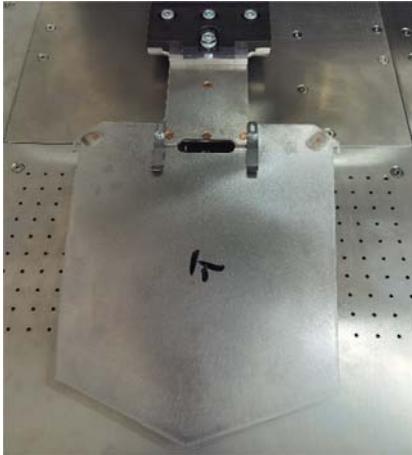
设备关机后，请按照 第九章-维护 要求进行设备日常维护。

第七章 调试说明

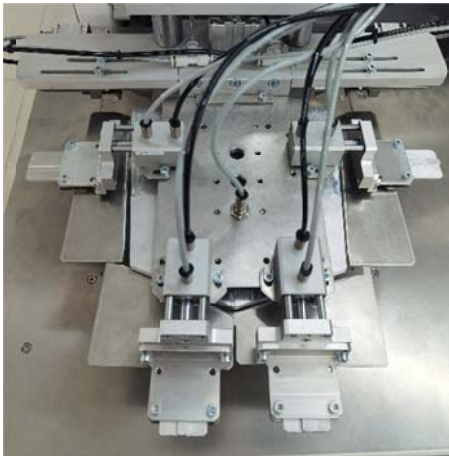
7.1 模具更换

7.1.1 模具位置

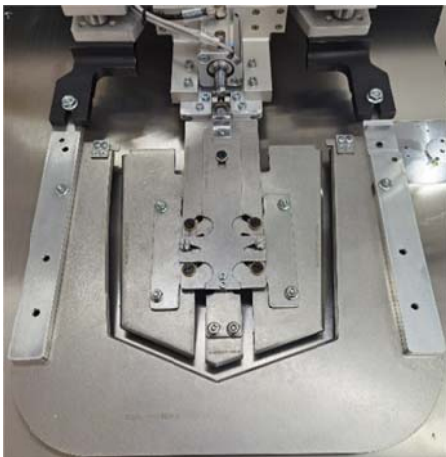
1) 袋形板



2) 折叠装置



3) 取料压板装置

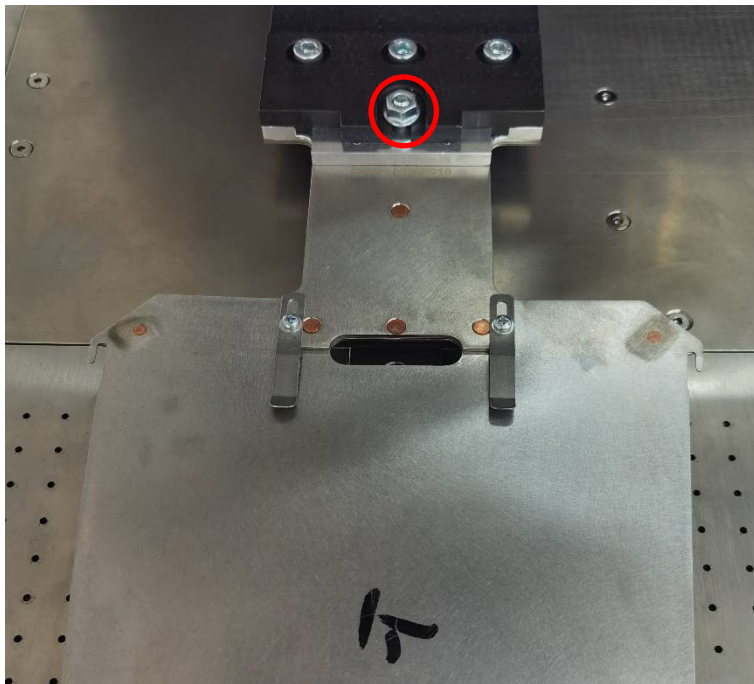


7.1.2 换模步骤

A) 拆卸模具

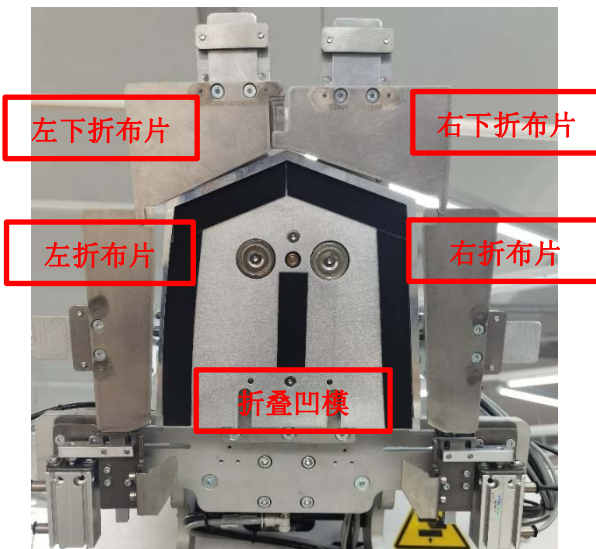
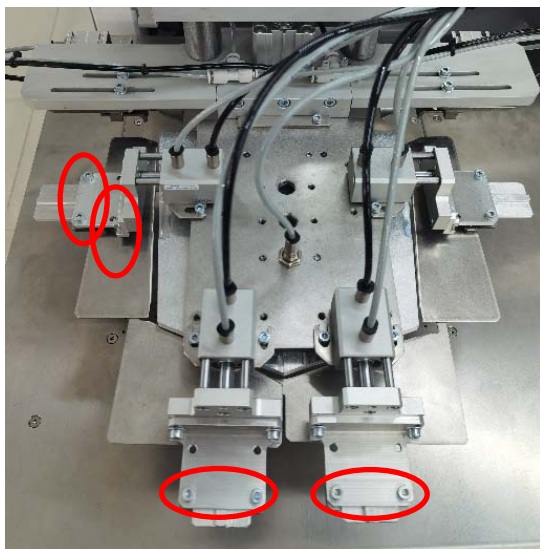
拆卸袋形板:

袋形板由 M6 螺母固定，拧开后沿着导槽向外拉出即可完成拆卸



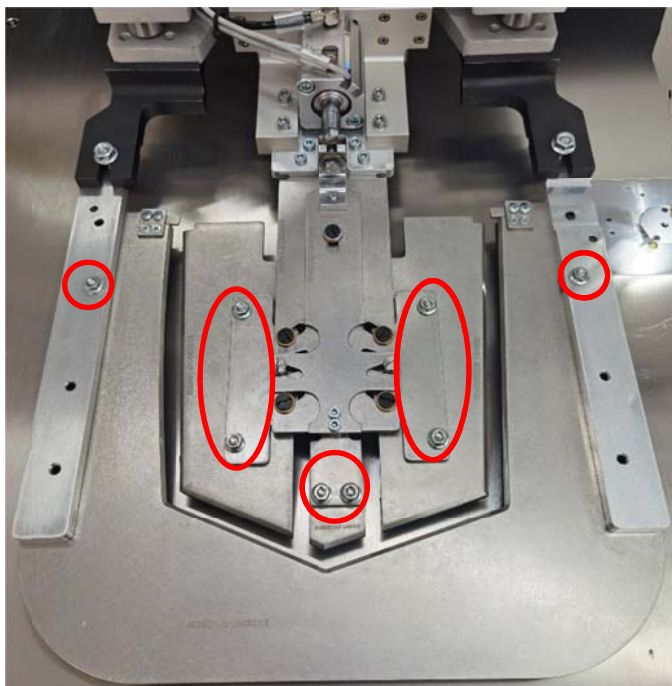
拆卸折叠模具时，需按步骤进行：

- 1、拆卸折叠凹模；
- 2、拆卸右下折布片；
- 3、拆卸左下折布片；
- 4、拆卸左、右折布片；



拆卸取料压板模具：

- 1、拆卸大压板；
- 2、拆卸伸缩压板；



B) 安装模具



模具的安装与拆卸动作相反，位置相同，注意折叠装置中折布片的先后顺序。

7.1.3 调整反折角刀位置




松开折角到固定螺钉，分别调节左右两侧反折角刀的位置至合适位置，拧紧螺钉。

7.1.4 取料测试

进入取料测试界面，a 主界面 →  →  取料测试：



点击  按钮和  按钮检验折叠效果注意：当进行到第 18 步时，可以

点击右侧  按钮，进入取料校正界面：



点击方向键可移动压板装置，进行调整压板上下左右与口袋对齐。

当进行到第 22 步时，可以点击右侧  按钮，进入打板界面：



触摸屏打版详见《花样编辑说明书》

7.2 冗位调整

7.2.1 冗位开关

可在一级系统参数 1.16 选项进行冗位功能的开关设置

项目		值		项目		值	
1.15	打板速度	3		1.16	冗位开关	关闭	
1.17	气压检测开关	打开		1.18	气压检测极性	不变	
1.19	空送时自动加剪线	不加		1.20	机针冷却开关	关闭	
1.21	空送图案的时间	0		1.22	扫线开关	关	
1.23	急停开关极性	不变		1.24	手动缝（移出时）空送速	13	
1.25	备用参数	关		1.26	扫线时间	100	
1.27	缝纫结束自动加剪线	不加		1.28	冗位杆缩回多久冗位板抬起	600	

7.2.2 冗位效果

先将大身布料摆放在台板面上，再踩脚踏板，冗位压板伸出并下压



7.2.3 冗位大小调整

松开冗位限位板的固定螺钉，手动上下调节限位板的高低位置，即可实现冗位压板高度的调整，调整完后锁紧螺钉。



第八章 电气配线

8.1 信号板输入

信号名称	插座号	规格	传感器线数	回零后状态
X 原点	IN1	3P	1X3	L 灭
Y1 原点	IN2	3P	1X3	H 亮
Z 原点	IN3	3P	1X3	L 灭
袋形板里	IN4	3P	1X3	1 灭
备用	IN5	3P	1X3	
折边器下	IN6	3P	1X3	1 灭
Y2	IN7	3P	1X3	
袋形踏板	IN8	3P	1X3	OFF 灭
备用	IN9	3P	1X3	
折边器上	IN10	3P	1X3	0 亮
翻转上	IN11	3P	1X3	1 灭
翻转下	IN12	3P	1X3	1 灭
袋形板外	IN13	3P	1X3	0 亮
备用	IN14	3P	1X3	
对条格脚踏	IN15	3P	1X3	OFF 灭
气压检测	IN16	3P	1X3	1 灭
折料启动	IN17	3P	1X3	1 灭
压板上	IN18	3P	1X3	0 亮
压板下	IN19	3P	1X3	1 灭
伸缩板到位	IN20	3P	1X3	1 灭
缝制急停	IN21	3P	1X3	0 亮
折料急停	IN22	3P	1X3	0 亮
IN23	IN23	3P	1X3	
IN24	IN24	3P	1X3	
换模检测	IN25	3P	1X3	1 灭
IN26	IN26	3P	1X3	
IN27	IN27	3P	1X3	
IN28	IN28	3P	1X3	
X 轴报警	主板	JK2-1	1X3	2 为公共
Y 轴报警	主板	JK2-3		
断线检测	主板	J6-4	1X6	1 位+5V
备用	主板	J6-5	1X6	3 位-5V
Z 轴故障报警	主板	J6-6	1X6	

8.2 信号板输出

电磁阀主阀组

编号	名称	端口号	性质	回零后开关	备注
1	备用				
2	下吸合	JC2	电磁阀	OFF	32V
3	吸风	J25	电磁阀	OFF	
4	袋模抬放 1	J12	电磁阀	ON	袋形板下气缸
5	袋模抬放 2	J2	电磁阀	ON	袋形板上气缸
6	袋形板进出	J3	电磁阀	OFF	
7	翻转上	J16	电磁阀	ON	
	翻转下	J20	电磁阀	OFF	
8	折边抬放 1	J18	电磁阀	OFF	折边上气缸
9	折边抬放 2	J17	电磁阀	OFF	折边下气缸
10	大压板	JC1	电磁阀	ON	32V
11	折料 4	J10	电磁阀	OFF	反折角
12	小板抬放	J8	电磁阀	ON	
13	小板伸缩	J9	电磁阀	OFF	

电磁阀收料阀组

编号	名称	端口号	性质	回零后开关	备注
14	收料 1	J1	电磁阀	OFF	24V, 收料支架气缸
15	收料 3	J22	电磁阀	OFF	收料摆杆气缸
16	收料 2	J13	电磁阀	OFF	备用

电磁阀冗位阀组

编号	名称	端口号	性质	回零后开关	备注
17	冗位气缸	J14	电磁阀	OFF	参数 1.16 开关
18	冗位伸缩	J37	电磁阀	OFF	
19	冗位板	J38	电磁阀	OFF	

电磁阀模具阀组

编号	名称	端口号	性质	回零后开关	备注
1	折料 1	J4	电磁阀	OFF	折料左、右
2	折料 2	J5	电磁阀	OFF	折料左下、折料下
3	折料 3	J6	电磁阀	OFF	折料右下、两侧折角
4	顶袋板	J21	电磁阀	OFF	针缸

其他输出

名称	端口号	性质	回零后开关	备注
报警灯	J7		ON	
机针冷却	J11	电磁阀	OFF	
辅助压板	J15	电磁阀	OFF	
吸风电机	J19	电磁阀	OFF	
扫线	J23	电磁阀	OFF	78
分段扫线	J24	电磁阀	OFF	
剪线	JC3	电磁阀	OFF	32V
松线	JC4	电磁阀	OFF	32V
备用	JC5	电磁阀	OFF	32V
备用	JC6	电磁阀	OFF	32V
镭射灯 1	J51	5V		
镭射灯 2	J52	5V		
镭射灯 3	J53	5V		
镭射灯 4	J54	5V		

第九章 维护

在更换机器零件、维护或者拆卸机器时，必须断开电源和气源。只有专业人员可以进行下面的操作。

9.1 设备保养明细

设备保养清单及要求详见下表：

序号	项目	保养周期				要点描述
		每天	每周	每月	半年	
1	清理线毛	√				清理机针和梭芯附近线毛
2	清理油污	√				清理台板、针板、梭芯油污
3	清理灰尘		√			清除设备表面及零部件灰尘
4	风机滤芯		√			清理风机滤芯灰尘
5	压板海绵		√			检查海绵是否磨损，磨损需更换
6	折叠装置			√		检查折叠装置水平性，紧固螺钉
7	袋形板			√		检查袋形板水平性，紧固螺钉
8	压料装置			√		检查压料装置水平性，紧固螺钉
9	气管接口			√		检查气管接口气密性，不漏气
10	机头油量			√		针、梭供油不低于警戒线
11	梭芯			√		检查梭芯是否有毛刺
12	感应器				√	检查灵敏度，感应正常
13	滑动件				√	检查滑动件润滑，不足需添加润滑剂
14	电控箱				√	检查散热风扇，清理灰尘

9.2 料件更换

为更快地确认所需更换的料件，请注意提供一下信息：

整机零件：1) 机器型号和序列号

模具零件：1) 模具型号和序列号

2) 料件名称及编号

2) 料件详细描述及照片

3) 料件表及详细照片

例如：

型号：贴袋机 B2501 序列号：2021-009

容位压杆 182212368

第十章 常见问题及解决方法

断线/跳线	
原因	1、针、梭有毛刺；2、过线有毛刺；3、针、梭配合不良；4、中压脚过高；5、中压脚碰压板；
解决措施	1、检查并抛光针、梭；2、检查并抛光过线；3、检查并调整针梭配合；4、调整中压脚高度；5、修改花样或者修改压框

布料起皱	
原因	中压脚高度过低
解决措施	调整中压脚高度

反折角未折角	
原因	折角刀位置偏差
解决措施	调整折角到位置（上下、左右）

折角上露	
原因	1、左右折刀缺口上方不足；2、袋形板抽出带布
解决措施	1、调整左右折刀上方缺口位置，使其反折角增大；2、检查袋形板高度

E002 请检查气阀开关	
解决措施	开启气阀

E003 伸缩板未缩到位	
解决措施	1、检查传感器位置 2、检查传感器是否损坏

E007 使用期限到，请与厂家联系	
解决措施	请联系厂家

E008 主轴过载，请关机	
解决措施	主轴负载过大，请检查机械是否存在卡点

E010 超出缝纫范围	
解决措施	超出缝制范围

E011 请按确认键	
解决措施	点击确认键

E012 系统锁定中，请检查急停开关	
解决措施	检查急停开关是否被按下

E014 X 轴回零失败	
解决措施	重新回零

E015 Y 轴回零失败	
解决措施	重新回零
E016 Z 轴回零失败	
解决措施	检查中压脚是否卡点
E021 单步针距超长	
解决措施	检查是否存在超大针距
E031 回零失败	
解决措施	重新回零
E033 启动按钮被长时间按下	
解决措施	检查启动按钮是否短路
E038 底线用完报警，按底线交接键或取消键	
解决措施	底线报警，点击确认键
E033 正在读取 U 盘，请稍后	
解决措施	等候读取完毕，或重新插入 U 盘
E033 气压过低或无气	
解决措施	检查气源压力
E053 折边器翻转下感应不到位	
解决措施	检查折边器是否翻转；检查传感器是否异常；
E055 袋形板未返回原位	
解决措施	检查袋形板是否复位；检查传感器是否异常；
E056 袋形板未到折料位	
解决措施	检查袋形板是否伸出；检查传感器是否异常；
E057 大压板位抬起，或传感器感应不到	
解决措施	检查大压板是否抬起；检查传感器是否异常；
E059 折边器下感应不到	
解决措施	检查折边器是否落下；检查传感器是否异常；
E061 X 轴故障，请关机检查	
解决措施	检查 X 轴电机线是否松动；关机重启；

E062 Y 轴故障，请关机检查	
解决措施	检查 Y 轴电机线是否松动；关机重启；
E064 大压板位放下或传感器感应不到	
解决措施	检查大压板是否落下；检查传感器是否异常；
E065 折料急停中，请检查折料急停按钮	
解决措施	重新放布
E072 折边器下感应不到位	
解决措施	检查折边器是否落下；检查传感器是否异常；
E073 折边器上感应不到位	
解决措施	检查折边器是否上升；检查传感器是否异常；
E100 正在穿线，穿好后按回车键	
解决措施	点击确认键
E1030 正在传输文件，请稍候...	
解决措施	等待传输完成；长时请关机重启
E1060 断线或断线检测频率不符	
解决措施	断线；断线检测频率设置过大

Content

1. Basic Information of Equipment	1
2. Equipment Parameters	2
3. Safety Precautions	3
4. Button Function Description	5
4.1 Each Button function description	5
4.2 Reset operation instructions	7
4.2.2 Emergency stop reset operation	8
5. Description of Touch Screen	9
5.1 Main control interface description	9
5.2 Sewing process interface	10
5.3 Processing counting area	11
5.3.1 Bottom thread count	12
5.4 Pattern pick up calibration	12
5.5 Laser light control	13
5.6 Function keys	13
5.6.1 USB driver reader	14
5.6.2 Pattern management	14
5.6.3 Device check	15
5.6.4 Other function	15
5.6.5 Feeding test(step test)	16
5.7 Thread winding	17
6. Operating procedures	18
6.1 Preparation before operation	18
6.2 Operating instructions	18
6.2.1 Turn on the machine	18
6.2.2 Machine reset	18
6.2.3 Fabric placement	21
6.2.4 Pocket placement	21
6.2.5 Pocket folding	22
7. Adjusting	23
7.1 Jig changing	23
7.1.1 Jig position	23
7.1.2 Jig changing procedures	24
7.1.3 Adjust the position of the reflex corner knife	25
7.1.4 Fabric pick up test	26

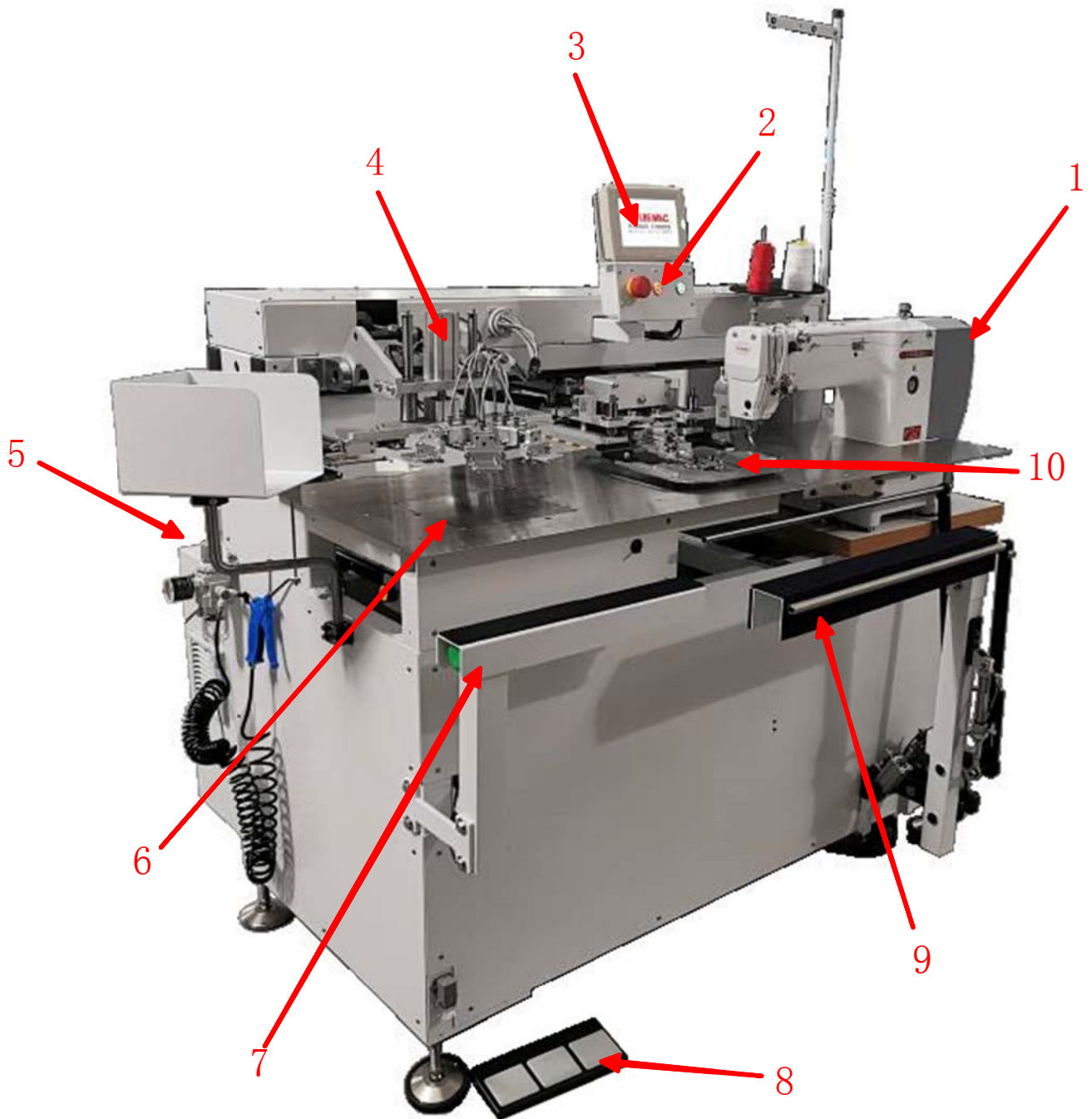
- 7.2 Redundancy adjusting 27
 - 7.2.1 Redundancy setting 27
 - 7.2.2 Redundant effect 27
 - 7.2.3 Redundant size adjustment 28

- 8. Electrical Wiring**..... 29
 - 8.1 Signal Board Input 29
 - 8.2 Signal Panel Output 30

- 9. Maintenance** 33
 - 9.1 Details of Maintenance 33
 - 9.2 Parts Replacement 34

- 10. Common Problems and Solutions** 35

1. Basic Information of Equipment



1. Sewing machine head 2. Power switch 3. Touch screen 4. Folding device

5. Control box 6. Suction System 7. Loading rack 8. Pedal 9. Stacker




10. Fabric moving device

2. Equipment Parameters

Automatic pocket setter		
1	Sewing head configuration	VBM2210-D
2	The fastest sewing speed /rpm	2800r/min
3	Needle model	DPX17
4	Sewing stitch length /mm	0.05—12.7
5	Sewing range/mm	90X90~220X220mm
6	Hook	Half-turn 2 times shuttle
7	Rated voltage /V	220
8	Rated air pressure /Mpa	0.6
9	Rated power /KW	3.5
10	Air consumption per unit time	1.8L/min
11	Spindle, X/Y control	AC Servo motor
12	Equipment size /mm	1750L×1250W×1900H
13	Package dimensions /mm	1920L×1500W×1775H
14	Equipment net weight /kg	500kg
15	Gross weight /kg	600kg

3. Safety Precautions

Precautions for safe use of automation

	<p>1. In order to prevent accidents caused by electric shock, please do not open the protective cover of the motor electrical box or touch the parts inside the electrical box when the power is turned on.</p>
	<p>1. In order to prevent personal injury, please be careful not to pinch your fingers when the sewing machine moves up and down or when it returns to its original position.</p> <p>2. When the stacker is moving, please keep your hands away from it to prevent your hands from being pinched.</p> <p>3. After turning off the power switch, the presser foot of the sewing machine will move, so please be careful not to pinch your fingers, etc.</p> <p>4. When debugging the folding device, the folding device moves, please be careful not to let the cylinder pinch your fingers.</p> <p>5. When the material moving device is moving, please be careful not to move your hands into the material moving device or on the running track to prevent fingers from being caught.</p>
	<p>1. In order to prevent personal injury, please do not operate the machine with the timing belt guard, finger guard and other safety devices removed.</p> <p>2. In order to prevent personal accidents from being involved in the machine, please do not put fingers, hair, or clothes near the pulley, belt, or motor, and do not put objects on it while the machine is running.</p> <p>3. In order to prevent personal injury, please do not put your fingers near the needle when the power is turned on or the sewing machine is running.</p> <p>4. In order to prevent personal injury, please do not put your fingers in the thread take-up guard while the sewing machine is running.</p> <p>5. The sewing machine rotates at a high speed. In order to prevent injury to your hands, please never let your hands close to the needle during operation. In addition, when replacing the sewing thread, be sure to turn off the power.</p> <p>6. Please do not cut off the power supply or cut off the air supply source while the sewing machine is running.</p> <p>8. In order to prevent accidents caused by electric shock, please do not run the sewing machine when the ground wire of the power supply is removed.</p> <p>9. In order to prevent accidents caused by damage to electrical parts, please stop working for safety and unplug the power plug when thundering occurs.</p> <p>10. In order to prevent accidents caused by damage to electrical parts, condensation will occur when you move from a cold place to a warm</p>

	<p>place immediately, so please wait until the water droplets are completely dry before turning on the power.</p> <p>11. Because this product is a precision machine, please pay full attention to it during operation. Don't splash water or oil on the machine, and don't let the machine drop and impact the machine.</p> <p>12. This machine is a Class A industrial machine. If this device is used in a home environment, radio wave interference may occur. At this time, the user is requested to take appropriate measures to solve the problem of radio wave interference.</p>
--	---

*** Important safety information:**

- ✓ **Improper operation of the machine may cause personal injury, please read this instruction carefully before operation and operate it correctly.**
- ✓ **Before the machine is officially running and powered on, please clean up the debris on and around the machine, and then ventilate it.**
- ✓ **It is strictly forbidden to open the internal parts of the electric control box or the touch screen when the power is on.**
- ✓ **This machine needs to be used after receiving training or under the guidance of a dedicated person to ensure the personal safety of the user.**

4. Button Function Description

4.1 Each Button function description

(1): Air source switch-slide the hand slide valve horizontally to realize the on-off of the air source of the equipment.



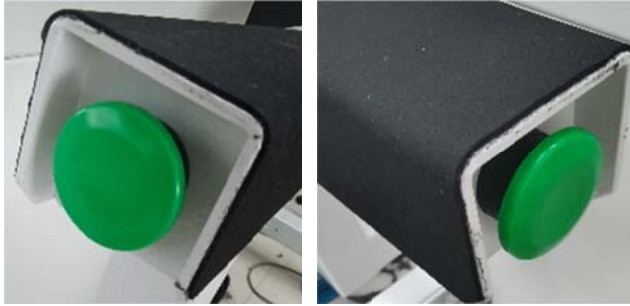
(2): Emergency stop button (left)-sewing emergency stop
Power-off button (middle)-the machine shuts down after it is pressed
Power-on button (right)-press to turn on the machine



(3): Pedal-in the foot pedal mode, the bag-shaped board extends and retracts.



(4): Start switch - after pressing the buttons on both sides at the same time, the equipment starts to fold or move material



(5): Folding emergency stop - press the yellow button and then the pocket plate will move back and return to the initial state



(6): The air circuit of the jig is on and off: move the lever valve to the left, the air circuit of the fixture is disconnected, and the mold change state is entered

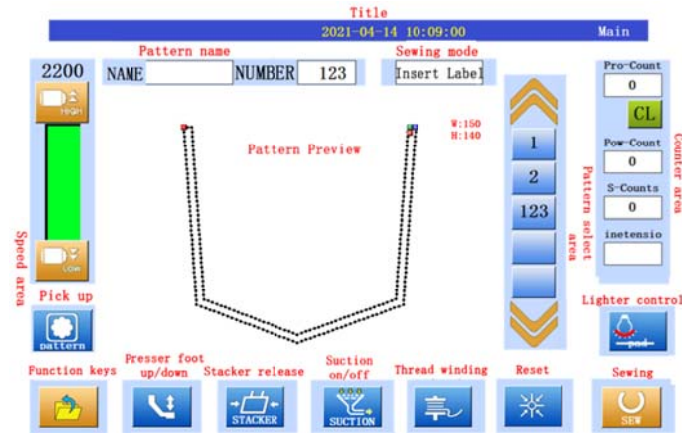


(7): Complete set of jig gas path switching: Rotate the locking sleeve counterclockwise to open the clamp pneumatic quick-plug connector. Rotate the locking sleeve clockwise, the clamp pneumatic quick-plug connector is locked.

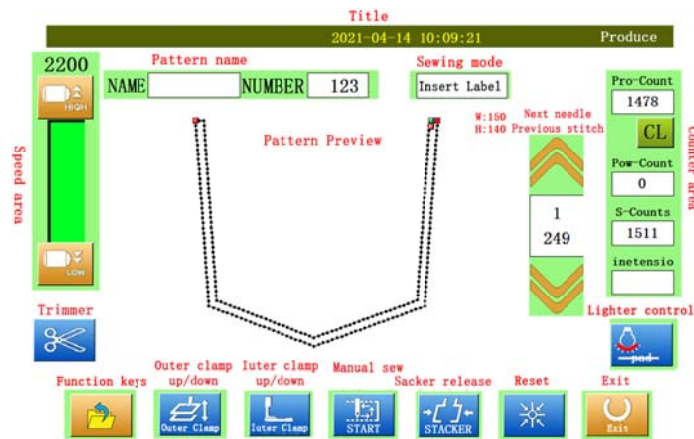


(8): Touch screen interface

A: Main function interface





B: Sewing processing interface



4.2 Reset operation instructions

4.2.1 Power-on reset operation

Step	Instruction	Button operation
1	Power-on	4.1- (2)
2	Reset	5.1- 
3	Enter sewing mode	5.1- 

4.2.2 Emergency stop reset operation

Scene 1: Folding emergency stop reset

Reset steps: After pressing the yellow button on the left side of the machine, the bag-shaped board returns to the initial state. At this time, step on the foot pedal, the bag-shaped board extends, and the fabric is placed again. After the placement is completed, press the green start button to start folding action

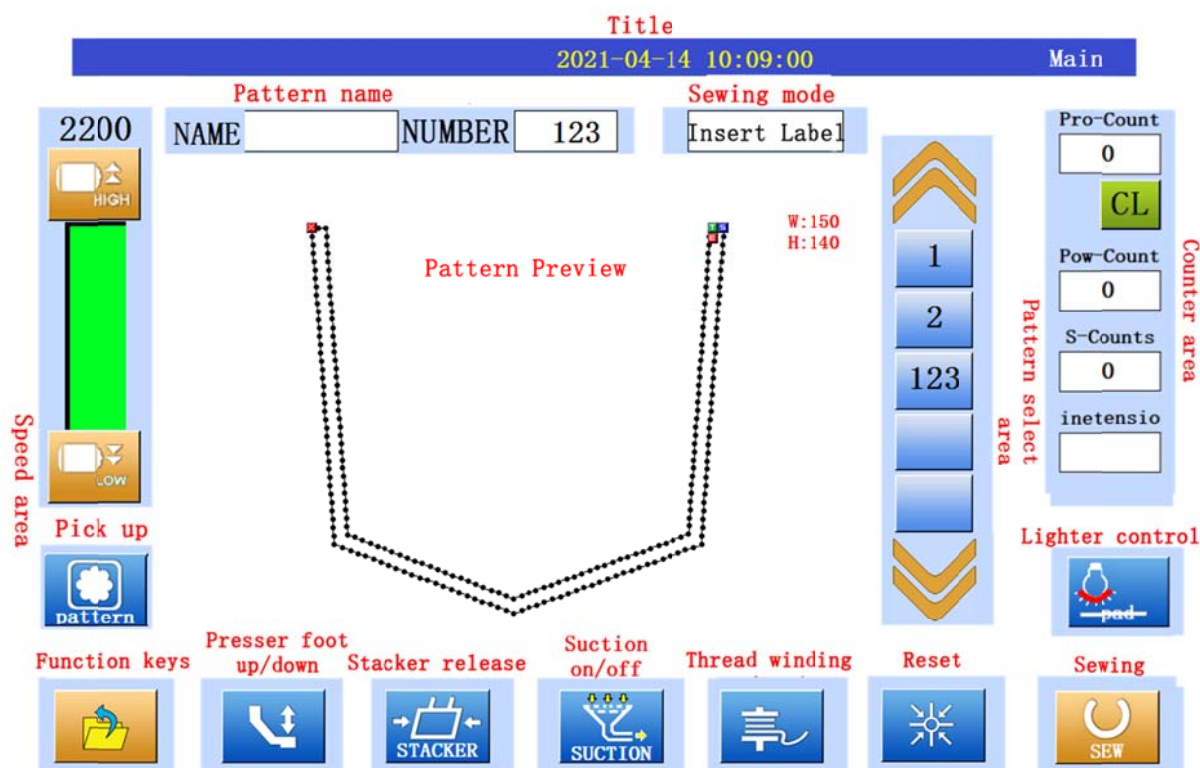
Scene 2: Emergency stop during sewing





Reset steps: turn the emergency stop switch clockwise to reset, and then you can choose:

- (1) In the B sewing processing interface, click the right button  to return to the broken thread, and then click the manual sewing button  below to continue sewing;
- (2) In the B sewing processing interface, Click the zero return button  to reset.

5. Description of Touch Screen

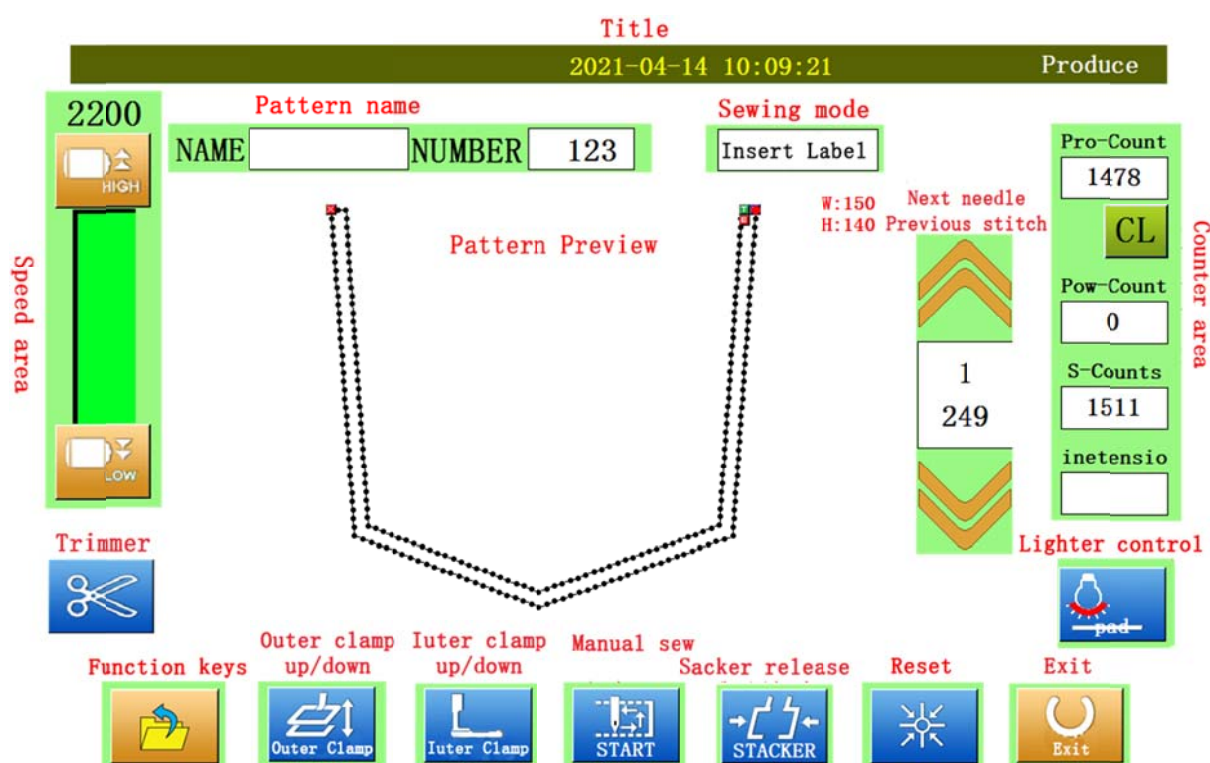
5.1 Main control interface description







Function	Description	Details
Title	Display current time, interface name	
Pattern area	Display the name and serial number of the current pattern	
Sewing mode	Display current sewing mode	
Speed display area	Display the current sewing speed  : speed up  : speed down	
Pattern preview area	Display current sewing pattern	
Pattern selection area	Click the pattern number or  and  key to switch	
Processing counting area	Display Processing counting	See 5.3
Pattern correction	Enter the pattern correction interface, adjust the gripping position	See 5.4
Lighting control	Enter the light control interface	See 5.5

Function Button	Click on function selection	See 5.6
Presser foot lift	Click to switch presser foot high/low	
Stacker open	Click to open stacker	
Suction switch	Click to open/close suction	
Winding	Click to enter the winding interface	See 5.7
Home reset	Click reset button	
Sewing processing	Click to enter the sewing process interface	See 5.2

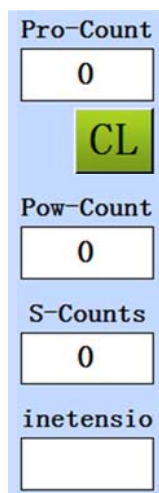
5.2 Sewing process interface



Function	Description	Details
Title	Display current time, interface name	
Pattern area	Display the name and serial number of the current pattern	
Sewing mode	Display current sewing mode Automatic mode: Fully automatic mode Trademark mode: semi-automatic mode	First level parameter 1.36 modification

Speed display area	Display the current sewing speed  : speed up  : speed down	
Pattern preview area	Display current sewing pattern	
Next stitch/previous stitch	Click button  and  to switch Next stitch/previous stitch	
Processing counting area	Display Processing counting	See 5.3
Trimming	Click for manual trimming	
Lighting control	Enter the light control interface	See 5.5
Function Button	Click on function selection	See 5.6
Large platen lifting	Click to switch the high/low state of the large platen	
Small platen lifting	Click to switch the high/low state of the small platen	
Manual sewing	a) Click to perform sewing action, which can be used for sewing without folding, which is convenient for observing the stitch status; b) After the thread is broken, return to the broken thread to continue sewing;	
Stacker open	Click to open stacker	
Home reset	Click reset button	
Exit the sewing processing	Click to exit the sewing processing interface	

5.3 Processing counting area



Processing counting: Display processing quantity

CL: Click to clear the processing quantity

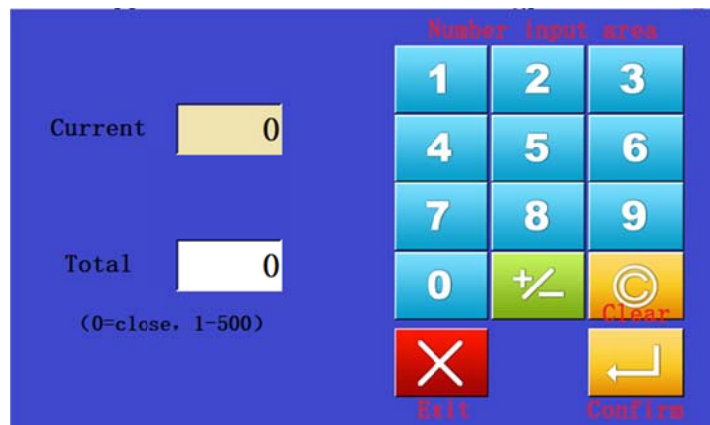
Power-on count: display the number of processing after this power-on

Cumulative count: display the cumulative number

Bottom thread count: perform bottom thread count operation, see 5.3.1

5.3.1 Bottom thread count

Click the bottom thread count box to enter the setting interface:



Current bottom thread: set the current number of pieces that can be sewn

Total number of bottom threads: set the number of pieces that can be sewn with a full bobbin sewing thread

Note: When the value is 0, it means that the bottom thread count is canceled.

5.4 Pattern pick up calibration

In Main Interface, press Pick Up, enter Pattern Pick Up Interface:



Pick up position: click it, carrier clamp moves to Pick up position

To zero: click it, carrier clamp moves to Zero position from Pick up position

Direction: modify the pick up position, : normal speed; : fast speed;

: faster speed

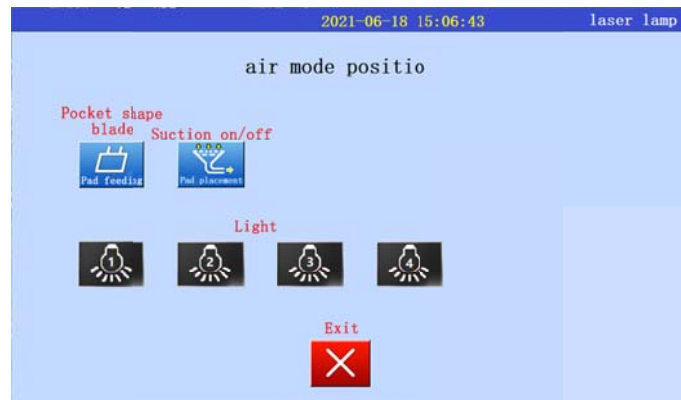
Carrier clamp up/down: click to control the Carrier clamp up/down condition

Exit without change saving: click to exit without change saving

Save and exit: click to save and exit (this function will be valid only after click To Zero position to let carrier clamp back to Zero position)

5.5 Laser light control

Click Laser light control button to enter the control page:



Pocket shape blade: pocket shape blade in and out

Suction: Suction on/off

Laser light: 1-4 controls corresponding light on/off, like position laser light and head led light

Exit: Quit this page

5.6 Function keys

Click function keys to expand the function interface:



Function	Description	Details
USB reader	Read the Pattern in USB driver	See 5.6.1
Pattern manage	Pattern management: delete, copy to USB	See 5.6.2
Make new pattern	Make new pattern	See Pattern Make Manual
Edit pattern	Edit current pattern	See Pattern Make Manual
Manual	Machine Manual	
Parameter manage	Parameter setting	
Machine check	Machine I/O test and other checks	See 5.6.3
Other function	Others function setting	See 5.6.4
Pick up test	Step operation test	See 5.6.5
Pattern test	Step operation test	

5.6.1 USB driver reader

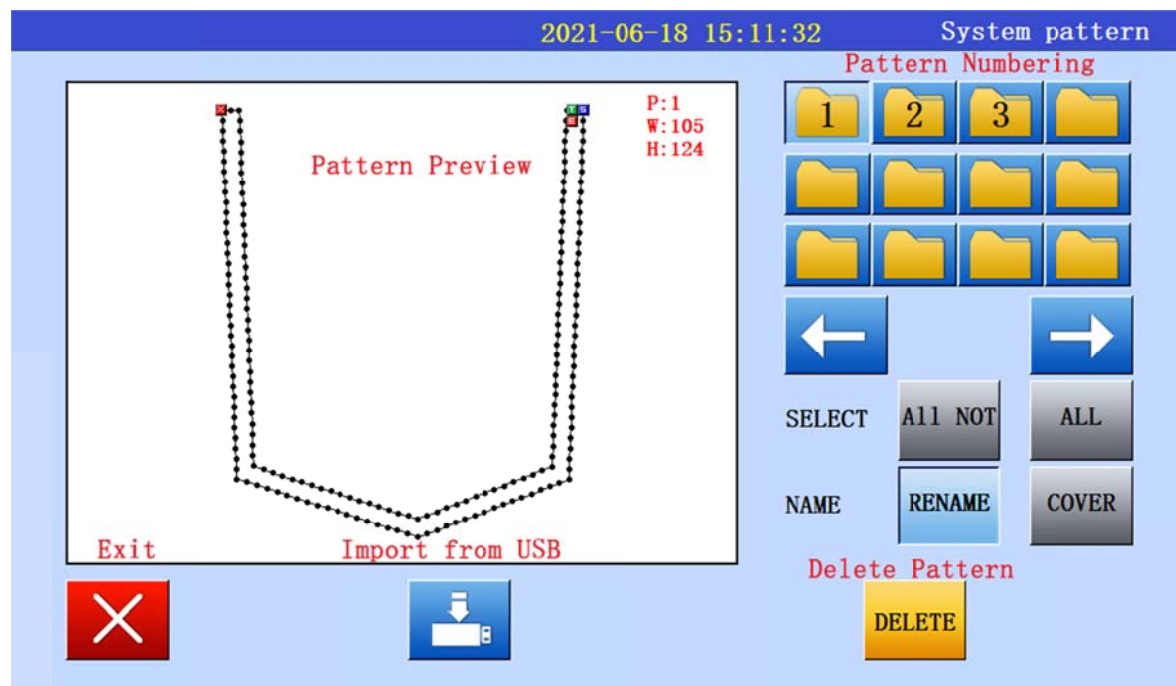


Pattern number area: The pattern read from the USB are displayed here;

When pattern is selected,  color will be lighter, Notes: multiple choice.

USB import: Click to import the selected pattern into the touch screen from USB.

5.6.2 Pattern management



Pattern number area: The pattern read from storage are displayed here;

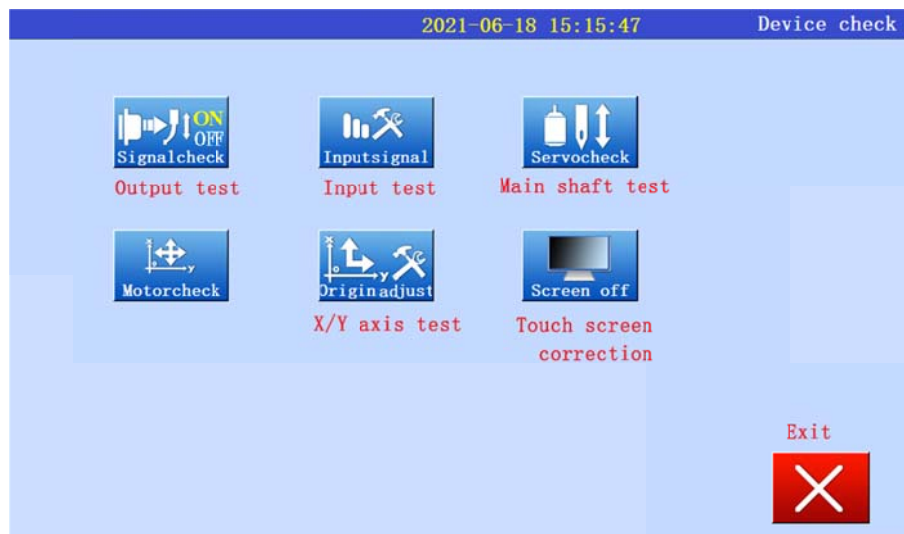
When pattern is selected,  color will be lighter, Notes: multiple choice.

Copy to USB: Copy pattern to USB (put USB first);

Delete pattern: Delete selected patterns.

5.6.3 Device check

Click Device Check to enter device check interface:



Output test: click into Output test page, test the corresponding output module;

Input test: click into Input test page, test the corresponding input module;

X/Y axle test: click into X/Y axle test page, use arrow keys to test;

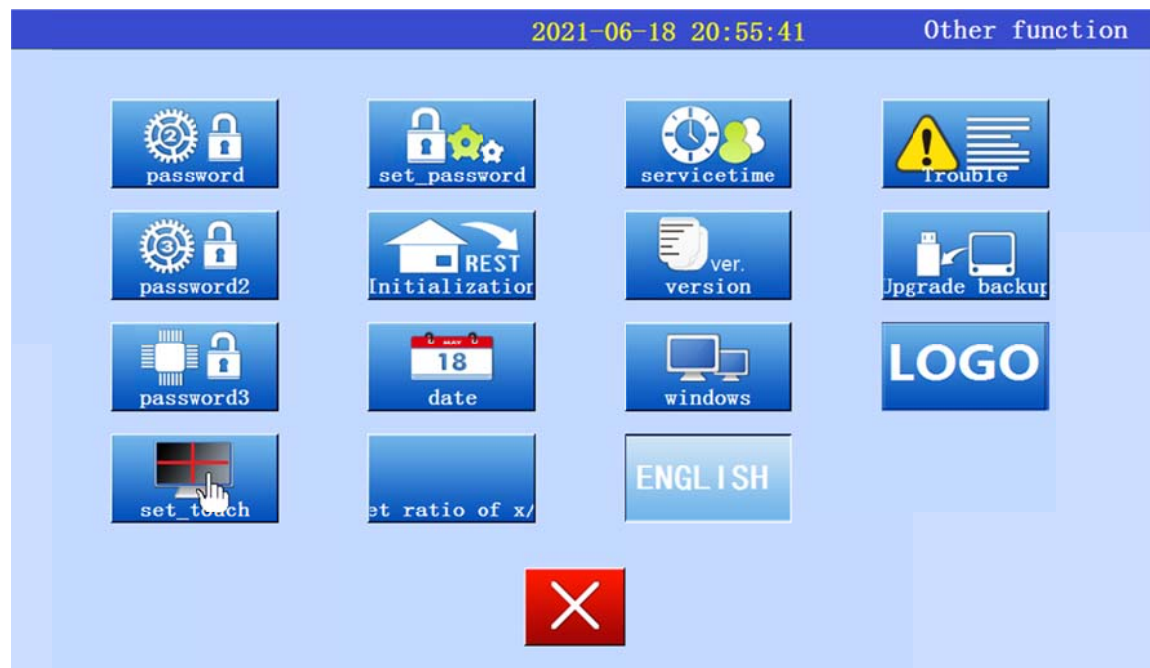
Touch screen test: click into touch screen calibration;

Main shaft test: click into main shaft test page;

Screen off setting: click into screen off parameter setting.

5.6.4 Other function

Click Other Function to enter other function setting interface:



Modify password(PW): you can modify the password of this machine's parameter;



Restore settings: click into the machine parameter restore factory settings;

Upgrade backup: click to enter the touch screen upgrade interface;

Language: click to switch between Chinese and English (need to restart machine)

5.6.5 Feeding test(step test)

This interface can be tested in a single step, after the mold has been set;

Click  and  to go to previous and next step (press green start button also can go to next step, but cannot withdraw);

* Step: show current step;

: When reach step 18, you can click this button to correct the position of the carrier clamp and pocket shape blade;

: When reach step 22, you can click this button to enter the Pattern Make

Page;



5.7 Thread winding

Click into thread winding page:



Enter thread winding page, click  and  to set the winding speed;
Press two green start-up button(see 4.1 4.1 Each Button function description) to start thread winding, click Exit to quit winding.

6. Operating procedures

6.1 Preparation before operation

The operator should check the machine before starting up:

- Clean up the machine table to ensure that nothing will hinder the operation of the machine;
- Check the air pressure to make it meet the requirements of the machine;
- Check whether the needle and hook are installed correctly;
- Turn the hand wheel of the machine head by hand to check whether the machine head can run smoothly;
- Check whether the sewing thread is proper;
- Check whether the clamp sponge is good.

6.2 Operating instructions

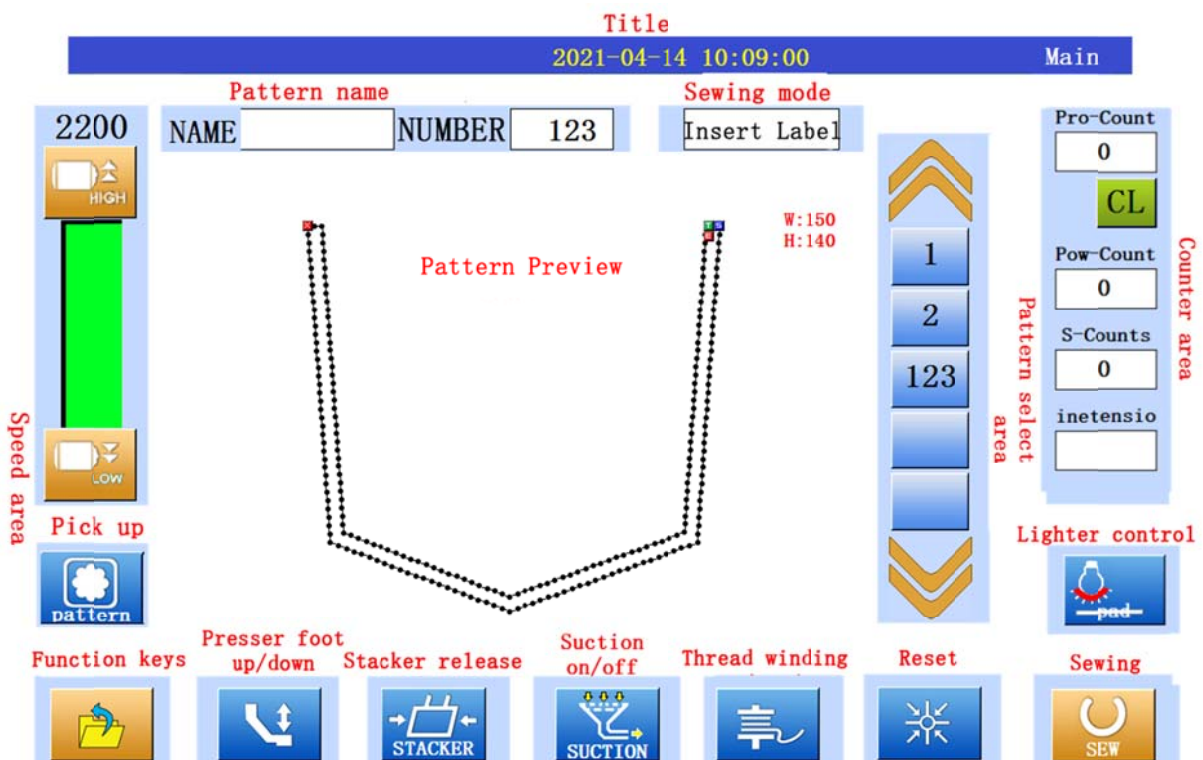
6.2.1 Turn on the machine

Press the start button, power on the machine.



6.2.2 Machine reset

Reset machine after power on. Click the Reset button on screen to reset machine(see 4.1 Button function description and 4.2.2 Emergency stop reset operation)



In Parameter Level 1, set Pocket Shape Blade Mode and Sewing Mode:

1) Parameter 1.8 Pocket Shape Blade Out Control Method

Pedal mode: When the machine is reset or in sewing cycle, step on the pedal, the pocket shape blade out, and the suction is turned on;

Button mode: When the machine is reset or in sewing cycle, press green start-up button, the pocket shape blade out, and the suction is turned on;

Auto-mode: When the machine is reset or in sewing cycle, the pocket shape blade out automatically, and the suction is turned on automatically;

2021-06-21 08:44:02 Parameter

ITEM	VALUE	ITEM	VALUE
1.1 Max sewing speed	3000	1.2 First stitch speed	400
1.3 Second stitch speed	800	1.4 Third stitch speed	1200
1.5 Trimming after urgents	No	1.6 Needle upper stop position	3947
1.7 U motor back to origin	4	1.8 Pocket mould out method	By pedal
1.9 Inner clamp down timer	0	1.10 Thread trimmer switch	open
1.11 Needle bar lift-back	0	1.12 Thread tension of first	50
1.13 Machine back to home	4	1.14 X belt moving speed	15

2021-06-21 08:44:40 Parameter

ITEM	VALUE	ITEM	VALUE
1.1 Max s			400
1.3 Secon			1200
1.5 Trimm			3947
1.7 U mot			By pedal
1.9 Inner			open
1.11 Need			50
1.13 Mach			15

1.8 Pocket mould out method

Auto-out
By button
By pedal

2) Parameter 1.36 Sewing Mode

Semi-auto mode: folding and fabric pick up are separated, need to press start button several times;

Full-auto mode: folding and fabric pick up are connected, only need to press start button once to complete folding, pick up, and sewing;

2021-06-21 08:45:26 Parameter

ITEM	VALUE	ITEM	VALUE
1. 29 Thread breakage detect	close	1. 30 Auto-lock mainshaft a	no
1. 31 Thread winding speed	1300	1. 32 Mainshaft calibration	Yes
1. 33 Pattern input method	aoto	1. 34 Thread breakage detect	10
1. 35 Suction sections swit	1	1. 36 Machine sewing mode	trademark
1. 37 Thread break detector	unchange	1. 38 Half stitch position	800
1. 39 Axis Y Reverse Feedir	-100	1. 40 Axis X Reverse Feedir	-100
1. 41 Axis Y obverse Feedir	-100	1. 42 Axis X obverse Feedir	-100

2021-06-21 08:45:57 Parameter

ITEM	VALUE	ITEM	VALUE
1. 29 Thre			no
1. 31 Thre			Yes
1. 33 Patt			10
1. 35 Suct			trademark
1. 37 Thre			800
1. 39 Axis			-100
1. 41 Axis			-100

1. 36 Machine sewing mode

automatic

trademark

X

6. 2. 3 Fabric placement

Put the body fabric on vacuum area



6. 2. 4 Pocket placement

[Semi-auto mode]

Put body fabric → Foot pedal → Pocket blade out → Vacuum on → Put pocket fabric

[Full automatic mode]

Pocket blade out → Vacuum on → Put body fabric → Put pocket fabric



6. 2. 5 Pocket folding

Press the green start button switch on both sides of the feeding rack with both hands, and the folding device is turned over and pressed down to complete the automatic folding of the pocket;

After the hemming is completed, in the automatic mode, the reclaiming and pressing plate device automatically moves to the left to grab the material; in the trademark mode, after manually pressing the start switch again, the reclaiming and pressing plate device moves to the left to take the material;

After the material is grabbed by the reclaiming platen, the bag-shaped plate is drawn back and retracted, and the platen device moves the material to the right sewing area for automatic sewing. After the sewing is completed, the material is automatically collected.

Note: After the reclaiming and pressing plate device moves the material to the sewing area, the pieces can be placed again, and the operation will be cycled in turn

6. 2. 6 Turn off machine

After the operation is completed, press the shutdown button at the bottom of the touch screen to shut down the device.

After the device is shut down, please perform routine maintenance of the device in accordance with the requirements of Chapter 9-Maintenance. After the operation is completed, press the shutdown button at the bottom of the touch screen to shut down the device.

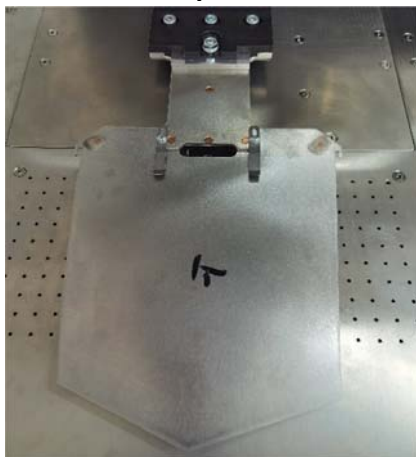
After the device is shut down, please perform routine maintenance of the device in accordance with the requirements of Chapter 9-Maintenance.

7. Adjusting

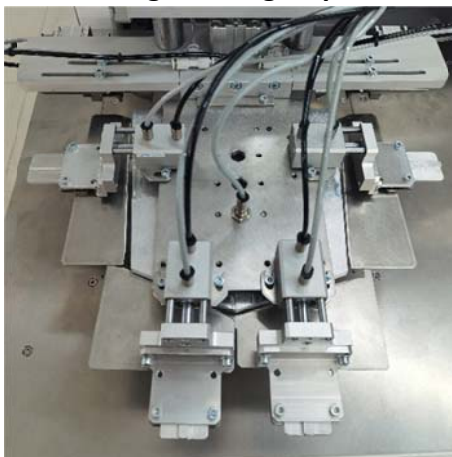
7.1 Jig changing

7.1.1 Jig position

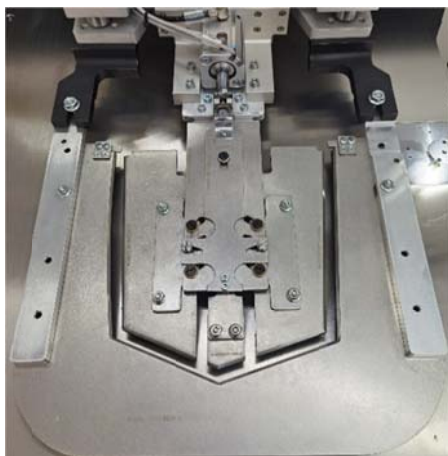
1) Pocket shape blade



2) Folding device group



3) Fabric carrier device

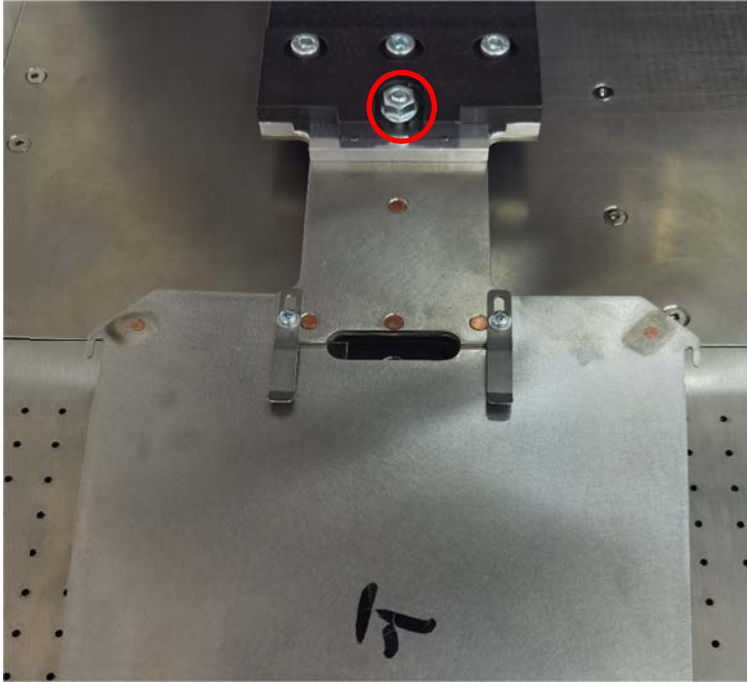


7.1.2 Jig changing procedures

A) Disassemble the mold

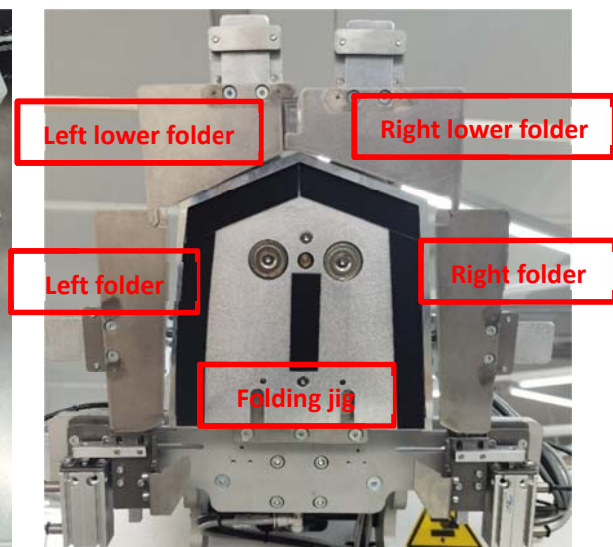
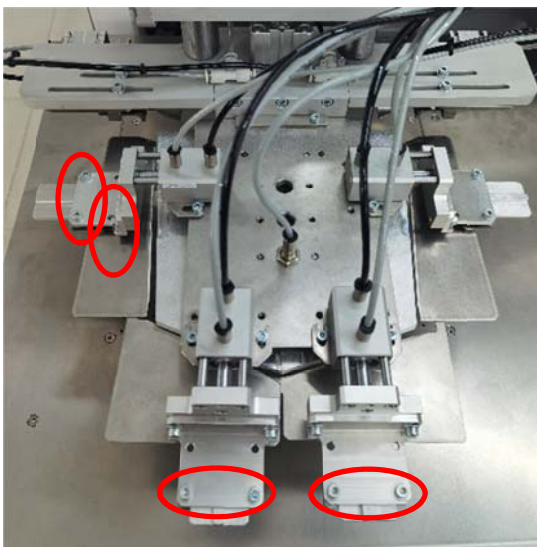
Remove the bag-shaped board:

The bag-shaped plate is fixed by M6 nuts, after unscrewing, pull out along the guide groove to complete the disassembly



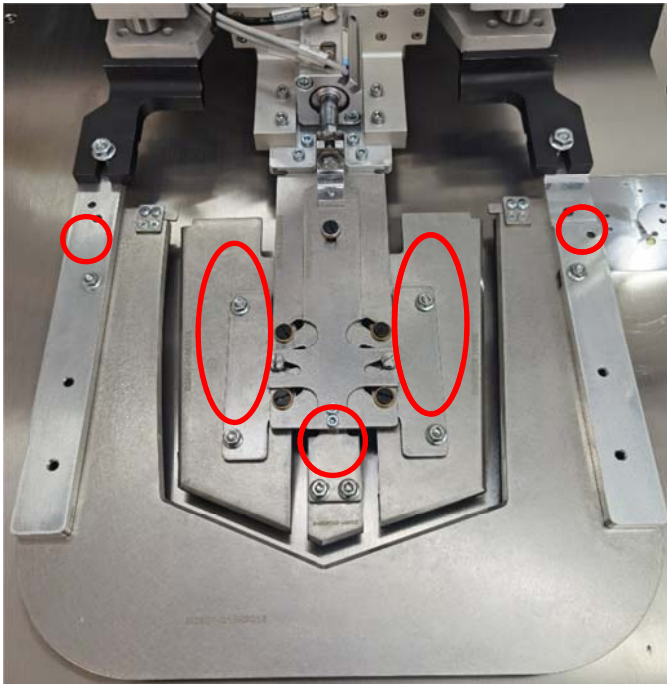
When disassembling the folding mold, follow the steps:

1. Disassemble the folding die;
2. Remove the lower right fold sheet;
3. Remove the lower left fold sheet;
4. Remove the left and right folded cloth pieces;



Disassemble the carrier template:

- 1. Remove the outer clamp;**
- 2. Remove the inner clamp;**

**B) Install the jig**

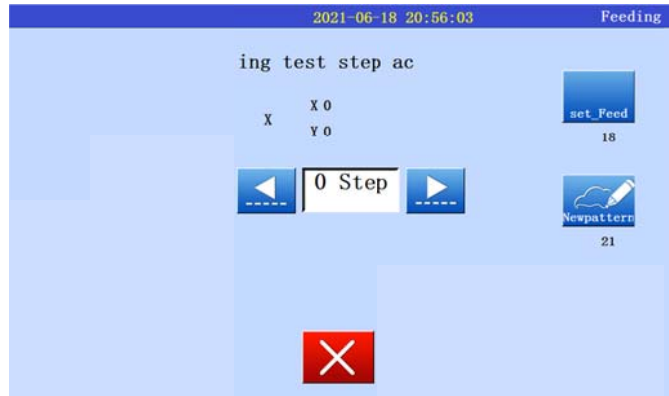
The installation and disassembly of the mold are opposite, and the positions are the same. Pay attention to the sequence of the folded cloth in the folding device.

7.1.3 Adjust the position of the reflex corner knife

Loosen the corners to the fixing screws, adjust the positions of the corner knives on the left and right sides to the appropriate positions, and tighten the screws.

7.1.4 Fabric pick up test

Enter testing interface, a main interface →  →  :



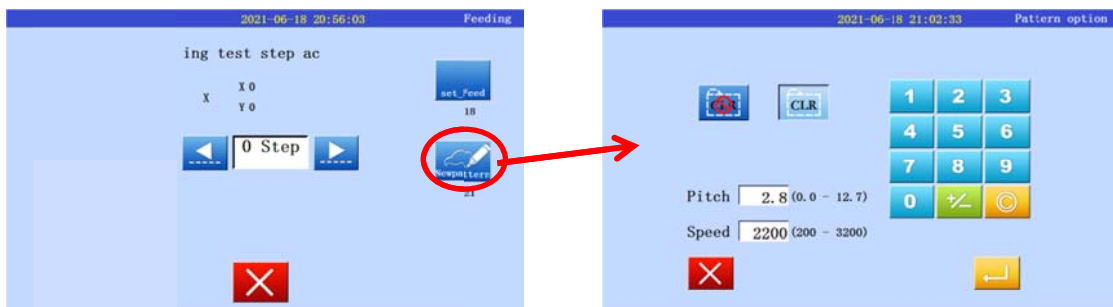
Click  to test the folding. Attention: When it comes to 18th step, pls click

 to enter fabric pick up interface.:



Click on the arrow keys to move the pressure plate device and adjust the pressure plate to align the upper and lower left and right sides with the pocket.

When it comes to the 22th step, pls click  to enter the pattern making interface:



Pls check 《pattern making manual》 for pattern making details

7.2 Redundancy adjusting

7.2.1 Redundancy setting

The redundancy function can be set in the 1.16 option of the first-level system parameter.

ITEM		VALUE	ITEM		VALUE
1. 15	New pattern processing	3	1. 16	Clamp up after sewing	yes
1. 17	Air pressure detector	open	1. 18	Air pressure detector	unchange
1. 19	Auto thread trimming	No	1. 20	Needle Cooler	OFF
1. 21	Pattern idle feeding	0	1. 22	Thread wiper switch	close
1. 23	Emergency stop switch	unchange	1. 24	Clamp moving out speed	13
1. 25	Table pin 2 switch	close	1. 26	Thread wiper timing	100
1. 27	Auto thread trimming	No	1. 28	Motor U out speed	4

7.2.2 Redundant effect

First put the body fabric on the table, and then step on the foot pedal, and the redundant pressing plate extends and presses down



7.2.3 Redundant size adjustment

Loosen the fixing screws of the redundant limit plate and manually adjust the height of the limit plate up and down to adjust the height of the redundant plate. After the adjustment, tighten the screw.



8. Electrical Wiring

8.1 Signal Board Input

Signal Name	Socket NO.	Specification	Amount of sensor wires	Status After Reset
X Base Point	IN1	3P	1X3	L ON
Y1 Base Point	IN2	3P	1X3	H OFF
Z Base Point	IN3	3P	1X3	L ON
Pocket Shape Board Outward	IN4	3P	1X3	1 OFF
Spare	IN5	3P	1X3	
Side Folder Downward	IN6	3P	1X3	1 OFF
Y2	IN7	3P	1X3	
Pedal of Pocket Shape Board	IN8	3P	1X3	OFF OFF
Spare	IN9	3P	1X3	
Side Folder Upward	IN10	3P	1X3	0 ON
Rotation Upward	IN11	3P	1X3	1 OFF
Rotation Downward	IN12	3P	1X3	1 OFF
Pocket Shape Board Inward	IN13	3P	1X3	0 ON
Spare	IN14	3P	1X3	
Alignment Pedal	IN15	3P	1X3	OFF OFF
Pressure Detection	IN16	3P	1X3	1 OFF
Start Folding	IN17	3P	1X3	1 OFF
Pressing Board Upward	IN18	3P	1X3	0 ON
Pressing Board Downward	IN19	3P	1X3	1 OFF
Expanding Board in Place	IN20	3P	1X3	1 OFF
Sewing Emergency Stop	IN21	3P	1X3	0 ON
Folding Emergency Stop	IN22	3P	1X3	0 ON
IN23	IN23	3P	1X3	
IN24	IN24	3P	1X3	
Jig-replacing Detection	IN25	3P	1X3	1 OFF

IN26	IN26	3P	1X3	
IN27	IN27	3P	1X3	
IN28	IN28	3P	1X3	
X Axis Warn	Main Board	JK2-1	1X3	2 Public Negative
Y Axis Warn	Main Board	JK2-3		
Thread Breaking Detection	Main Board	J6-4	1X6	1 Potential+5V
Spare	Main Board	J6-5	1X6	3 Potential-5V
Z Axis Warn	Main Board	J6-6	1X6	

8.2 Signal Panel Output

Solenoid valve main valve group

No.	Name	Socket No.	Nature	Status after Reset	Remarks
1	Spare				
2	Down Suction	JC2	Solenoid Valve	OFF	32V
3	Suction	J25	Solenoid Valve	OFF	
4	Pocket Blade lifting 1	J12	Solenoid Valve	ON	Pocket Blade Lower Cylinder
5	Pocket Blade lifting 2	J2	Solenoid Valve	ON	Pocket Blade Upper Cylinder
6	Pocket Blade In/Out	J3	Solenoid Valve	OFF	
7	Rotation Up	J16	Solenoid Valve	ON	
	Rotation Down	J20	Solenoid Valve	OFF	
8	Side Folding Lifting 1	J18	Solenoid Valve	OFF	Side Folding Upper Cylinder
9	Side Folding Lifting 2	J17	Solenoid Valve	OFF	Side Folding Lower Cylinder
10	Large Pressing Board	JC1	Solenoid Valve	ON	32V
11	Folding 4	J10	Solenoid Valve	OFF	Upper Conner
12	Small Pressing Board Lifting	J8	Solenoid Valve	ON	
13	Small Pressing Board Lifting	J9	Solenoid Valve	OFF	

Solenoid valve receiving valve group

No.	Name	Socket No.	Nature	Status after Reset	Remarks
14	Receiving 1	J1	Solenoid Valve	OFF	24V, Receiving bracket cylinder
15	Receiving 3	J22	Solenoid Valve	OFF	Receiving pendulum cylinder
16	Receiving 2	J13	Solenoid Valve	OFF	Spare

Solenoid valve redundancy valve group

No.	Name	Socket No.	Nature	Status after Reset	Remarks
17	Redundancy Cylinder	J14	Solenoid Valve	OFF	Parameter 1.16 Switch
18	Redundancy Expand	J37	Solenoid Valve	OFF	
19	Redundancy Board	J38	Solenoid Valve	OFF	

Solenoid valve Jig valve group

No.	Name	Socket No.	Nature	Status after Reset	Remarks
1	Folding 1	J4	Solenoid Valve	OFF	Fold Right, Left
2	Folding 2	J5	Solenoid Valve	OFF	Fold Left Down, Fold Down
3	Folding 3	J6	Solenoid Valve	OFF	Fold Right Down, Both Sides Fold Corner
4	Top pocket board	J21	Solenoid Valve	OFF	Needle Cylinder

Other Output

Name	Socket No.	Nature	Status after Reset	Remarks
Alarm Light	J7		ON	
Needle Cooling	J11	Solenoid Valve	OFF	
Auxiliary Pressure Plate	J15	Solenoid Valve	OFF	
Suction Motor	J19	Solenoid Valve	OFF	
Thread Sweeping	J23	Solenoid Valve	OFF	78
Sectional sweeping	J24	Solenoid Valve	OFF	
Trimming	JC3	Solenoid Valve	OFF	32V
Thread Loosing	JC4	Solenoid Valve	OFF	32V
Spare	JC5	Solenoid Valve	OFF	32V
Spare	JC6	Solenoid Valve	OFF	32V
Laser Light 1	J51	5V		
Laser Light 2	J52	5V		
Laser Light 3	J53	5V		
Laser Light 4	J54	5V		

9. Maintenance

When replacing machine parts, maintaining or disassembling the machine, the power and air supply must be disconnected. Only professionals can perform the following operations.

9.1 Details of Maintenance

The equipment maintenance list and requirements are detailed in the following table:

No.	Item.	Maintenance Period				Description
		Daily	Weekly	Monthly	Half-year	
1	Clean Thread Wool	√				Clean the thread waste around the needle and bobbin
2	Clean Oil Stains	√				Clean up oil stains on the table, needle plate, and bobbin
3	Clean Dirt		√			Remove dust on the surface of the equipment and parts
4	Blower Motor Filter		√			Clean the dust of the fan filter
5	Pressing Board Sponge		√			Check whether the sponge is worn or not, and need to be replaced if worn
6	Folding Device			√		Check the level of the folding device, tighten the screws
7	Pocket Shape Board			√		Check the levelness of the pocket-shaped board and tighten the screws
8	Pressing Device			√		Check the levelness of the pressing device and tighten the screws
9	Air pipe port			√		Check the air tightness of the tracheal interface, no air leakage
10	Oil Indicator of Head			√		Needle and shuttle oil supply is not lower than the warning line
11	Bobbin			√		Check the bobbin for burrs
12	Sensor				√	Check the sensitivity, the induction is normal

13	Sliding Parts				√	Check the lubrication of the sliding parts, if insufficient, add lubricant
14	Control Box				√	Check the cooling fan and clean up the dust

9.2 Parts Replacement

In order to confirm the materials that need to be replaced more quickly, please pay attention to provide the following information:

Machine parts: 1) Machine model and serial number 2) Name and serial number of materials Jig parts: 3) Material list and detailed photos

1) Mold model and serial number

2) Detailed description and photos of materials

E.g.:

Model: Pocket Patching Machine B2501

Serial Number: 2021-009

Capacity pressure rod 182212368

10. Common Problems and Solutions

Thread Break/Jump	
Cause	1. The needle and shuttle have burrs; 2. The thread has burrs; 3. The needle and shuttle are not properly matched; 4. The middle presser foot is too high; 5. The middle presser foot touches the pressure plate;
Solution	1. Check and polish the needle and shuttle; 2. Check and polish the thread; 3. Check and adjust the needle and shuttle coordination; 4. Adjust the height of the middle presser foot; 5. Modify the pattern or modify the press frame

Fabric Wrinkling	
Cause	The height of the middle presser foot is too low
Solution	Adjust the height of the middle presser foot

Folding Corner Unfolded angle	
Cause	Corner folding knife position deviation
Solution	Adjust the chamfer to the position (up and down, left and right)

Corner Exposed	
Cause	1. There is not enough above the notch of the left and right folding knife; 2. The cloth is drawn out of the bag-shaped board
Solution	1. Adjust the position of the notch above the left and right folding knives to increase the reflex angle; 2. Check the height of the bag-shaped plate

E002 Please check the valve switch	
Solution	Open the air valve

E003 The expand board is not retracted in place	
Solution	1. Check the position of the sensor 2. Check whether the sensor is damaged

E007 The expiration date is up, please contact the manufacturer	
Solution	Please contact the manufacturer

E008 Spindle overload, please shut down	
Solution	The spindle is overload, please check whether there is a stuck point in the machine

E010 Out of sewing range	
Solution	Out of sewing range, please check

E011 Please press confirm button	
Solution	press confirm button

E012 The system is locked, please check the emergency stop switch	
Solution	Check whether the emergency stop switch is pressed
E014 X axis return to zero failed	
Solution	Try to return to zero again
E015 Y axis return to zero failed	
Solution	Try to return to zero again
E016 Z axis return to zero failed	
Solution	Check whether the presser foot is stuck
E021 Single step stitch length is extra long	
Solution	Check if there is an oversized stitch length
E031 Return to zero failed	
Solution	Try to return to zero again
E033 The start button is pressed for a long time	
Solution	Check whether the start button is short-circuited
E038 Alarm when the bottom thread runs out, press the bottom thread transfer button or cancel button	
Solution	Bottom line alarm, click the confirm button
E033 U disk is being read, please wait	
Solution	Wait for the reading to be completed, or re-insert the U disk
E033 Air pressure is too low or airless	
Solution	Check the air pressure
E053 Induction of the folding device is not in place when it is turned over	
Solution	Check whether the folding device is turned over; check whether the sensor is abnormal;
E055 The bag board does not return to its original position	
Solution	Check whether the bag-shaped board is reset; check whether the sensor is abnormal;
E056 The bag-shaped board has not reached the folding position	
Solution	Check whether the bag-shaped board is extended; check whether the sensor is abnormal;

E057 The large platen position is raised, or the sensor cannot sense	
Solution	Check whether the large pressure plate is lifted; check whether the sensor is abnormal;
E059 Not sensed under the folding device	
Solution	Check whether the folding device is dropped; check whether the sensor is abnormal;
E061 X-axis failure, please turn off and check	
Solution	Check whether the X-axis motor cable is loose; shut down and restart;
E062 Y-axis failure, please turn off and check	
Solution	Check whether the Y-axis motor cable is loose; shut down and restart;
E064 Large pressure board position is down or the sensor cannot sense	
Solution	Check whether the large pressure plate is dropped; check whether the sensor is abnormal;
E065 Folding emergency stop, please check the folding emergency stop button	
Solution	Place fabric again
E072 Folding device downward is not sensed in right position	
Solution	Check whether the folding device is dropped; check whether the sensor is abnormal;
E073 Folding device upward is not sensed in right position	
Solution	Check whether the folding device is lifted; check whether the sensor is abnormal;
E100 Threading, press enter after finishing	
Solution	Click the confirm button
E1030 File transfer, please wait...	
Solution	Wait for the transfer to complete; please shut down and restart for a long time
E1060 Thread-break or thread-break detection frequency does not match	
Solution	Thread-break; Thread-break frequency is set too large



意大利威比玛 牛仔智造专家

ITALY VI.BE.MAC. JEANS SMART SOLUTION

花样编辑说明书

PATTERN MAKING OPERATING INSTRUCTION

B2501

全自动牛仔贴袋机

Full Automatic Pocket Setter



目录



第一章 打版流程.....	1
第二章 界面补充介绍	3
2.1 打版输入界面	3
第三章 基本输入.....	5
3.1 直线输入.....	5
3.2 圆弧输入.....	7
3.3 圆形输入.....	9
3.4 多边形输入.....	11
3.5 功能码输入.....	14
第四章 应用输入.....	16
4.1 多重缝输入.....	16
4.2 人字缝输入.....	18
第五章 花样资料的修改.....	20
5.1 进入和退出修改模式的方法.....	21
5.2 花样的查看.....	21
5.3 整体移动.....	22
5.4 删除针.....	23
5.5 加针.....	24
5.6 点移动(只移动选中点).....	24
5.7 点移动(选中点以后都移动).....	25
5.8 区段移动(前后图形不变).....	26
5.9 区段移动(在前后图形加上新针步).....	28
5.10 区段修改(直线修改).....	29
5.11 区段修改(圆弧、多边形修改).....	30
5.12 区段修改(人字缝修改).....	31
5.13 中压脚高度设置.....	32
5.14 缝制速度修改(修改制定区段速度).....	33
5.15 缝制速度修改(修改指定点后所有针步).....	34
5.16 代码修改(加入代码).....	34
5.17 代码修改(删除代码).....	35


第一章 打版流程

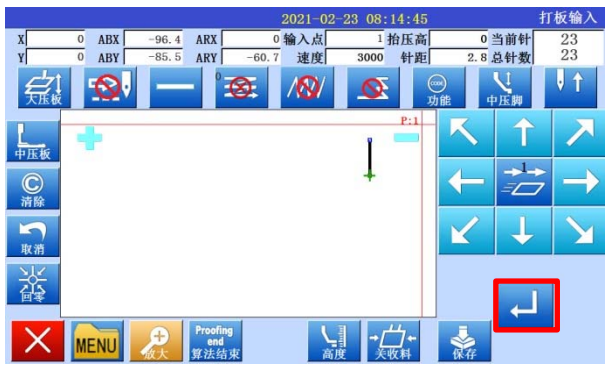
这里介绍进行新花样的打版流程和界面的切换。


<p>1、从主界面按下按钮  ；</p>	
<p>2、在菜单界面按下按钮  新建花样 ；</p>	
<p>3、显示打版输入参数界面： ①针距一栏：0.1mm-12.7mm ②速度一栏：3000 可通过  ~  数字键进行输入，使用  键清除输入； 上述参数设定完成后，按下  键；</p>	
<p>4、显示出打版输入界面： 首次进入时默认为空送  ； 按住  方向键移动压板，将花样起点移动到机针底下（按住方向键移动时，屏上绿色十字光标会移动，X 和 Y 坐标值也会变化）。 移动到达目的地后，请按  键确定（表示从原点到起点键的空送资料已完成生成）。</p>	

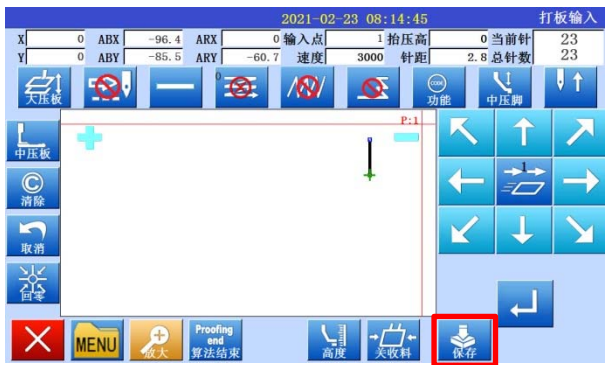
5、按下确定键后，空送图标切换成


 缝纫，再按住  方向键将压板移动到下一点，十字光标跟随移动。

移动到目的地后，请按  键确定（表示起点到终点间的直线缝资料已完成生成，屏幕上出现一条黑色粗线）。




6、按下  保存键进入保存界面进行花样的保存。



7、点击 新保存图样 按键；
然后点击  确定键进入命名界面。



8、在名称框中写入名称（数字和英文组合），然后点击  确定键完成保存。

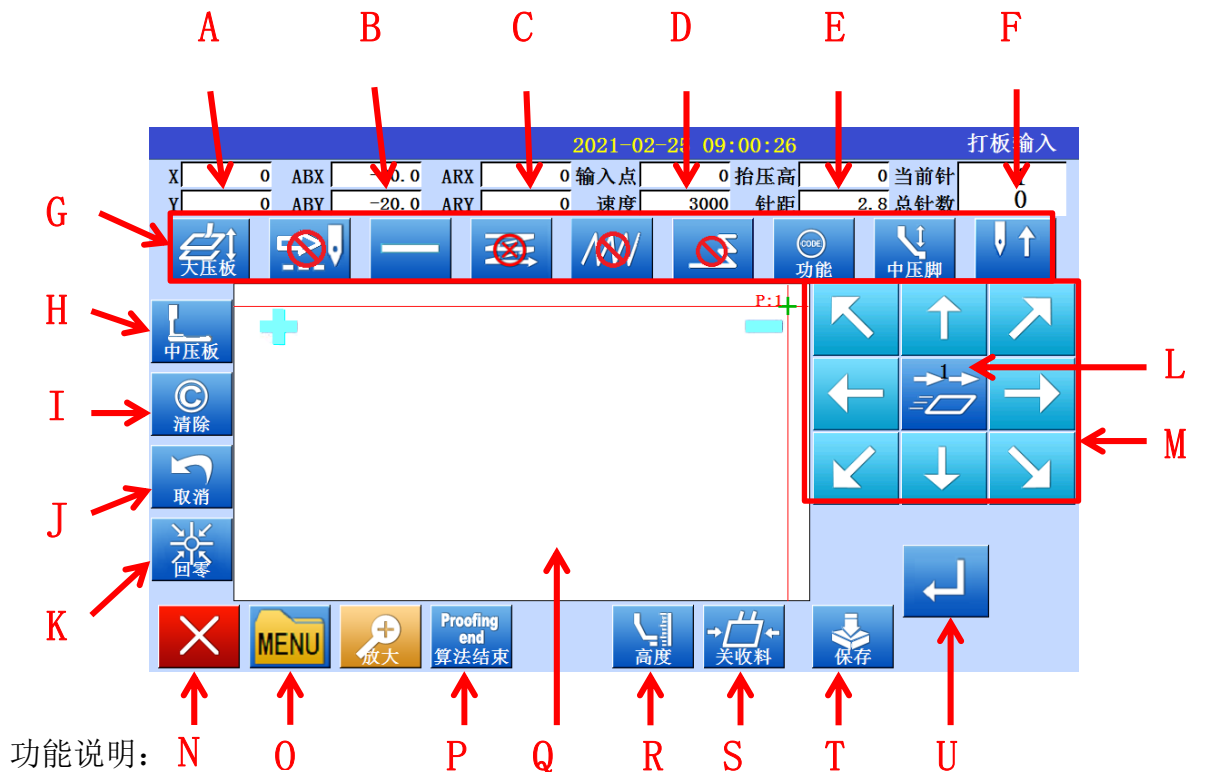


9、点击确定键后会返回到缝制主界面，到此图样打版已完成。



第二章 界面补充介绍

2.1 打版输入界面



序号	功能	内容
A	坐标	显示 X/Y 坐标
B	绝对坐标	显示 X/Y 绝对坐标
C	相对坐标	显示 X/Y 相对坐标
D	速度	显示当前速度
E	抬压高/针距	显示当前压脚高度/针距
F	当前针/总针数	显示当前机针针数/总针数
G	打版输入	各项打版输入功能
H	中压板移动	点击进行中压板的抬升/下降
I	清除	点击清除最后已确认的点，回到上一确认点
J	取消	点击撤销压板移动，回到上一确认点
K	回零	点击清除所有线迹并回到原点
L	压板移动速度	: 正常速度 : 稍快速度 : 更快速度
M	方向键	各个方向移动压板
N	退出键	点击退出打版输入
O	菜单键	无
P	算法结束	点击生成多重缝
Q	预览框	预览显示花样图形 : 放大预览图形 : 缩小预览图形
R	中压脚高度键	点击进入中压脚高度设定界面

S	收料开关	点击手动开启/关闭收料
T	保存键	点击进入保存界面
U	确定键	确认当前点



功能说明:

序号	功能	内容
A	大压板移动	点击进行大压板的抬升/下降
B	空送键	设置当前输入方法是否为空送  : 空送  : 取消空送, 即缝纫
C	输入方法设定键	表示当前基本输入方法, 点击进入设定界面
D	多重缝设定键	表示当前多重缝方法, 点击进入设定界面
E	人字缝设定键	表示当前人字缝方法, 点击进入设定界面
F	倒针输入设定键	表示当前倒针输入方法, 点击进入设定界面
G	功能码输入键	点击进入功能码输入界面
H	中压脚移动	点击进行中压脚的抬升/下降
I	针移动	点击进行机针的抬升/下降


第三章 基本输入

本章介绍几种基本输入方法：

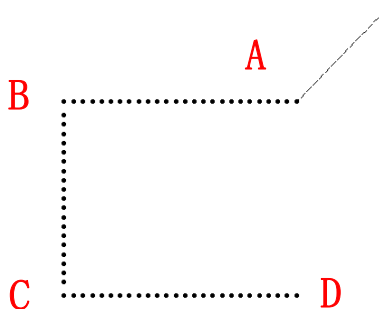
功能	按键符号	说明
直线输入		输入 2 点：当前位置(已确定)和下一确定点间生成直线车缝
圆弧输入		输入 3 点：当前位置(已确定)为起点和下两个确定点为中间点与终点，3 点间生成圆弧车缝
圆形输入		输入 3 点：当前位置(已确定)为起点和下两个确定点为中间点与终点，3 点间生成圆形车缝
曲线输入		当前位置(已确定)和之后确定多个点生成曲线车缝
多边形输入		当前位置(已确定)和之后确定多个点间用直线连接生成多边形车缝
点缝输入		按照一个输入点一针的方式车缝
功能码输入		在已完成输入的图形资料中，在指定位置输入功能码

3.1 直线输入

操作要点：







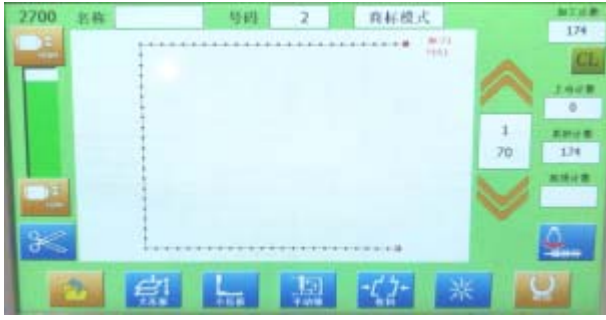
- 请指定输入方法为直线输入 
- 请输入 2 点：当前位置(已确定)为第一点，通过方向键将压板移动到指定位置，然后点击确定键，为第二点，两点之间生成直线车缝。

【例】实例说明如何制作下图图形资料。




操作说明:

<p>1、输入到 A 点间的空送:</p> <p>1) 从主界面按  键和  键进入打版输入参数界面, 设定参数后进入打版输入界面。(参照【第一章 打版流程】内容);</p> <p>2) 查证空送图标是否为空送 , 不是点击  按钮进行切换;</p> <p>3) 点击方向键, 将压板指定位置 A 移动到机针底下, 点击确定键 , 确定 A 点, 原点至 A 点间的空送资料生成。</p>	 
<p>2、输入到 B 点间的车缝:</p> <p>1) 第一次空送后, 空送图标切换为非空送 , 检查;</p> <p>2) 点击方向键移动压板, 将 B 点移动到机针底下;</p> <p>3) 点击  确定键, 生成 A 点至 B 点的直线车缝资料。</p>	
<p>3、输入到 C 点间的车缝:</p> <p>1) 用方向键把 C 点位置移动到机针底下;</p> <p>2) 点击  确定键, 生成 B 点至 C 点的直线车缝资料。</p>	
<p>4、输入到 D 点间的车缝:</p> <p>1) 用方向键把 D 点位置移动到机针底下;</p> <p>2) 点击  确定键, 生成 C 点至 D 点的直线车缝资料。</p>	

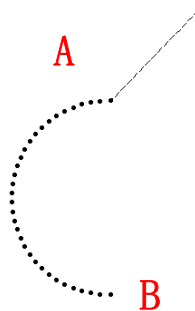
<p>5、按下  保存键进入保存界面进行花样的保存；</p> <p>输入花样名称及号码后，按下  键回到缝制加工界面。</p> <p>【保存后，程序会自动生成回原点的空送资料】</p>	 <p>2021-02-23 08:52:55 保存选择</p> <p>名称 <input type="text"/> 号码 <input type="text" value="2"/></p> <p>新保存图样</p> <p>覆盖原图样</p> <p>不保存退出</p> <p></p>
<p>6、图形资料的查证：</p> <p>1) 回到缝制加工界面后，点击  键和  键(前移/后移)测试图形资料的动作是否正确。</p> <p>2) 如要修改，请参阅【第五章 花样资料的修改】说明。</p>	 <p>2700 名称 号码 2 裁标模式</p> <p>加工位置 174</p> <p>1 70 174</p>

3.2 圆弧输入

操作要点：

- 请指定输入方法为圆弧输入 
- 请输入 3 点：当前位置(已确定)为第一点，通过方向键将压板移动到圆弧中间位置，然后点击确定键，为第二点；通过方向键将压板移动到圆弧终点位置，然后点击确定键，为第三点；三点之间生成圆弧车缝。

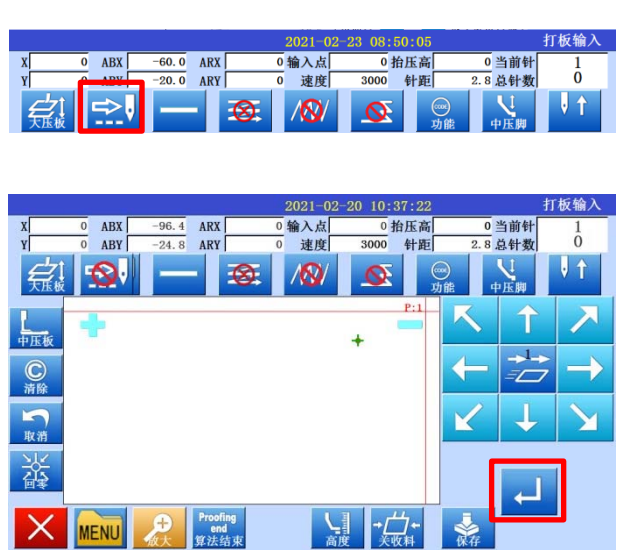
【例】实例说明如何制作下图图形资料。



操作说明：

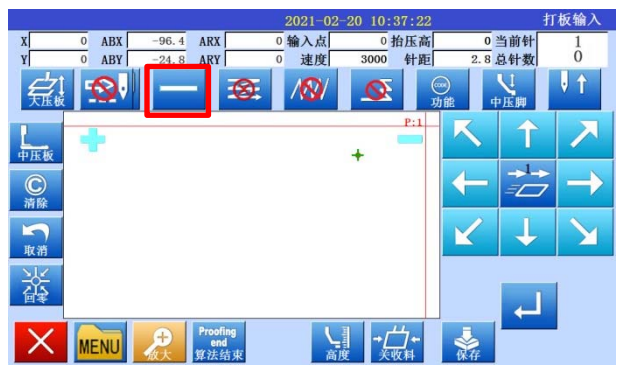
1、输入到 A 点间的空送：

- 1) 从主界面按  键和  键进入打版输入参数界面，设定参数后进入打版输入界面。(参照【第一章 打版流程】内容)；
- 2) 查证空送图标是否为空送 ，不是点击  按钮切换；
- 3) 将压板指定位置 A 移动到机针底下，点击确定键 ，确定 A 点，原点至 A 点间的空送资料生成。





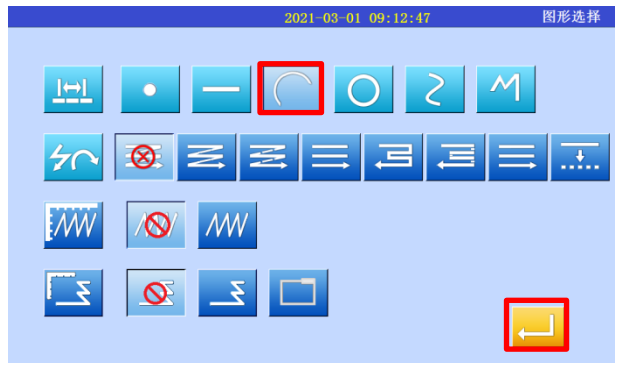
2、转换输入方法的设定：

- 1) 第一次空送后，空送图标切换为非空送 ，检查；
- 2) 如果显示的不是  圆弧输入，按一下  键进入输入方法设定界面。





3、设定圆弧输入：

- 1) 点击  键选择圆弧输入；
- 2) 点击  确定键回到打版输入界面。



4、输入到 B 点间的车缝：


- 1) 用方向键把圆弧中间点移动到机针底下；
- 2) 点击  确定键，预览界面出现一点；
- 3) 用方向键把圆弧终点移动到机针底下；
- 4) 点击  确定键，将生成圆弧车缝资料。



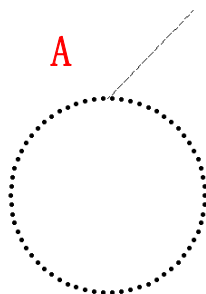
<p>5、按下  保存键进入保存界面进行花样的保存；</p> <p>输入花样名称及号码后，按下  键回到缝制加工界面。</p> <p>【保存后，程序会自动生成回原点的空送资料】</p>	 <p>2021-02-23 08:52:55 保存选择</p> <p>名称 <input type="text"/> 号码 <input type="text" value="2"/></p> <p>新保存图样</p> <p>覆盖原图样</p> <p>不保存退出</p> <p> </p>
<p>6、图形资料的查证：</p> <p>1) 回到缝制加工界面后，点击  键和  键(前移/后移)测试图形资料的动作是否正确。</p> <p>2) 如要修改，请参阅【第五章 花样资料的修改】说明。</p>	 <p>2700 名称 <input type="text"/> 号码 <input type="text" value="2"/> 光标模式</p> <p>1 25</p> <p>174</p>

3.3 圆形输入

操作要点：






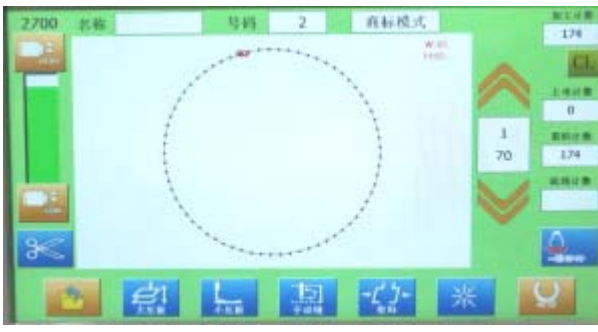
- 请指定输入方法为圆形输入 
- 请输入 3 点：当前位置(已确定)为第一点，通过方向键将压板移动到圆形上任一位置，然后点击确定键，为第二点；通过方向键将压板移动到圆形下一位置，然后点击确定键，为第三点；三点之间生成圆形车缝。

【例】实例说明如何制作下图图形资料。



操作说明:

<p>1、输入到 A 点间的空送:</p> <p>1) 从主界面按  键和  键进入打版输入参数界面, 设定参数后进入打版输入界面。(参照【第一章 打版流程】内容);</p> <p>2) 查证空送图标是否为空送 , 不是点击  按钮切换;</p> <p>3) 点击方向键, 将压板指定位置 A 移动到机针底下, 点击确定键 , 确定 A 点, 原点至 A 点间的空送资料生成。</p>	 
<p>2、转换输入方法的设定:</p> <p>1) 第一次空送后, 空送图标切换为非空送 , 检查;</p> <p>2) 如果显示的不是  圆形输入, 按一下  键进入输入方法设定界面。</p>	
<p>3、设定圆形输入:</p> <p>1) 点击  键选择圆形输入;</p> <p>2) 点击  确定键回到打版输入界面。</p>	
<p>4、输入圆形车缝:</p> <p>1) 用方向键把圆形任一点移动到机针底下;</p> <p>2) 点击  确定键, 预览界面出现一点;</p> <p>3) 用方向键把圆形下一任意点移动到机针底下;</p> <p>4) 点击  确定键, 将生成圆形车缝资料。</p>	 

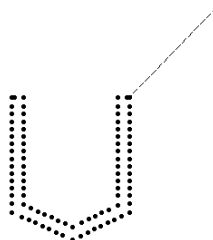
<p>5、按下  保存键进入保存界面进行花样的保存；</p> <p>输入花样名称及号码后，按下  键回到缝制加工界面。</p> <p>【保存后，程序会自动生成回原点的空送资料】</p>	 <p>2021-02-23 08:52:55 保存选择</p> <p>名称 <input type="text"/> 号码 <input type="text" value="2"/></p> <p>新保存图样</p> <p>覆盖原图样</p> <p>不保存退出</p> <p></p>
<p>6、图形资料的查证：</p> <p>1) 回到缝制加工界面后，点击  键和  键（前移/后移）测试图形资料的动作是否正确。</p> <p>2) 如要修改，请参阅【第五章 花样资料的修改】说明。</p>	 <p>2700 名称 <input type="text"/> 号码 <input type="text" value="2"/> 商标模式</p> <p>加工位置 174</p> <p>上移计数 0</p> <p>1 70</p> <p>下移计数 174</p>

3.4 多边形输入

操作要点：

- 请指定输入方法为圆形输入 
- 当前位置(已确定)和输入点之间用直线连接生成多边形车缝。



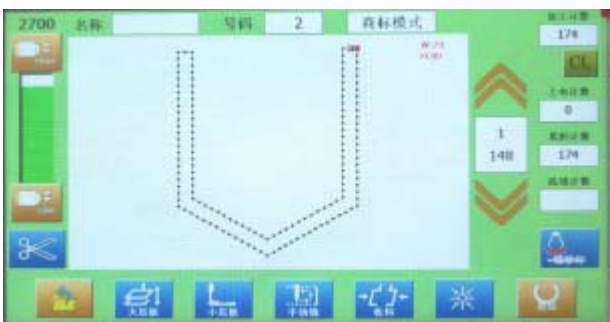
【例】实例说明如何制作下图图形资料。



操作说明:

<p>1、转换输入方法的设定:</p> <ol style="list-style-type: none"> 1) 从主界面按  键和  键进入打版输入参数界面，设定参数后进入打版输入界面。(参照【第一章 打版流程】内容); 2) 按一下  键进入输入方法设定界面; 3) 点击  键选择多边形输入; 4) 点击  键进入多重缝制输入界面(自动生成双线，贴袋机多重缝次数为2次)。 	 
<p>2、设定双线间距:</p> <ol style="list-style-type: none"> 1) 点击  键展开参数设置选项; 2) 在参数选项中进行参数设置后，点击  确定键返回输入方法设定界面; 3) 再次点击  键返回打版输入界面。 	
<p>4、输入到第1点间的空送:</p> <ol style="list-style-type: none"> 1) 查证空送图标是否为空送  ，不是点击  按钮切换; 2) 点击方向键，将压板指定位置移动到机针底下，点击确定键  ，确定第1点，原点至第1点间的空送资料生成。 3) 第一次空送后，空送图标切换为非空送  ，检查; 	 

<p>5、确定后续点：</p> <p>1) 用方向键将第 2 点移动到机针底下， 点击  确定键；</p> <p>2) 用方向键将第 3 点移动到机针底下， 点击  确定键；</p> <p>3) 用方向键将第 4 点移动到机针底下， 点击  确定键；</p> <p>4) 用方向键将第 5 点移动到机针底下， 点击  确定键；</p> <p>5) 全部点确认后，点击  算法结束键。</p>	 
<p>6、系统生成多变形车缝资料后，点击  键进入输入方法设定界面；</p> <p>点击  键和  键，然后点击  确定键返回打版输入界面；</p>	
<p>7、准备封口：</p> <p>1) 可点击花样预览区域  键方法花样；</p> <p>2) 在花样最后一针处，移动压板到初始针位置处，点击  键生成直线车缝资料。</p>	
<p>8、按下  保存键进入保存界面进行花样的保存；</p> <p>输入花样名称及号码后，按下  键回到缝制加工界面。</p> <p>【保存后，程序会自动生成回原点的空送资料】</p>	

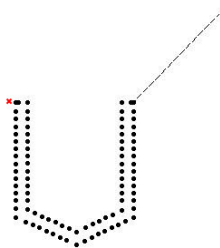
<p>9、图形资料的查证：</p> <p>1) 回到缝制加工界面后，点击  键和  键(前移/后移)测试图形资料的动作是否正确。</p> <p>2) 如要修改，请参阅【第五章 花样资料的修改】说明。</p>	
---	--

3.5 功能码输入

操作要点：

- 请进入花样修改模式
- 请指定功能码

【例】实例说明如何制作下图图形资料，在封口的第一针点前添加缩板功能码。





操作说明：

<p>1、在主控界面通过  键和  键选择所需修改的花样，点击  键和  修改花样键进入花样修改界面。</p>	
<p>2、在修改模式中点击  代码数据按键；</p> <p>点击  功能码添加按键，然后点击  确定键进入针步选择界面。</p>	

<p>3、点击  键和  键将压板移动到缩板功能码添加处，点击  确定键进入功能输入界面。</p>	
<p>4、点击  退板按键，然后点击  确定键返回花样修改主界面。</p>	
<p>5、按下  保存键进入保存界面进行花样的保存； 输入花样名称及号码后，按下  键回到主控界面。</p>	
<p>6、图形资料的查证： 1) 进入缝制加工界面，点击  键和  键(前移/后移)测试图形资料的动作是否正确。 2) 如要修改，请参阅【第五章 花样资料的修改】说明。</p>	

功能码设定一览表：

功能	按键符号	说明
剪线		在指定针步添加剪线功能
退板		在指定针步添加退板(缩板)功能


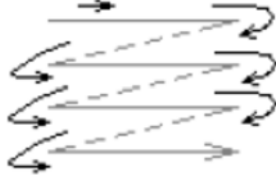

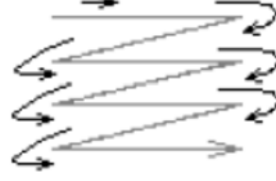

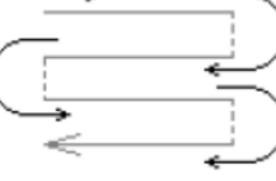

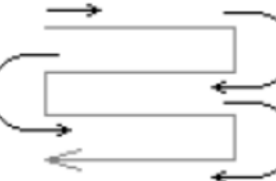
第四章 应用输入

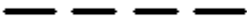
可做倒针车缝、多重缝、离边缝、人字缝，并可以和基本输入混合使用，对图形的打版能简单制作完成。


功能	图标
多重缝	 : 同向多重缝(车缝方式)  : 同向多重缝(移送方式)  : 逆向多重缝(车缝方式)  : 逆向多重缝(移送方式)
人字缝	

【注】点缝输入时不能混合使用这些应用输入方法。

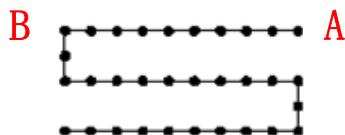
4.1 多重缝输入

种类	连接	按键	产生的车缝样式	说明
同向多重缝 (多重缝)	空送			固定方向的[车缝]，用[空送]连接做多重缝纫。
	车缝			固定方向的[车缝]，用[车缝]连接做多重缝纫。
逆向多重缝 (来回多重缝)	空送			来回方向的[车缝]，用[空送]连接做多重缝纫。
	车缝			来回方向的[车缝]，用[车缝]连接做多重缝纫。

样式中  (虚线部分)表示[空送]。

样式中  (实线部分)表示[车缝]。


【例】实例说明如何制作下图的图形资料，制作直线的逆向多重缝(距离：6mm，次数：3次，方向：右)




操作说明：

<p>1、输入方法的设定：</p> <p>1) 进入打版输入界面后，先点击方向键移动压板至 A 点的空送确认，再按  键进入输入方法的设定界面；</p> <p>2) 确定为直线输入键  ；</p> <p>3) 再按多重缝制输入键  ，进入多重缝制输入界面；</p>	
<p>2、多重缝制输入的详细设定：</p> <p>1) 在此界面设定参数，先点击  (来回多重缝)；设置距离为 6.0，次数为 3；</p> <p>2) 点击  确定键返回上一界面；</p> <p>3) 再次点击  确定键返回输入打版界面。</p>	
<p>3、图形资料的输入：</p> <p>1) 点击方向键移动压板，将 B 点移动到机针底下点击  确定键；</p>	
<p>4、图形资料的查证：</p> <p>1) 点击  保存按钮，保存完毕后进入缝制加工界面；</p> <p>2) 点击  键和  键查询车缝资料。</p>	

方向设定说明:

要在输入的车缝方向的左方做多重缝的话, 请按  键(左方)。

要在输入的车缝方向的右方做多重缝的话, 请按  键(右方)。

距离设定说明:

表示每一条多重缝间的距离, 可设定 0-20mm。点击[距离]的输入框会变黄, 表示正处于输入状态, 通过数字键盘输入即可。

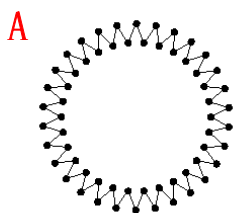
次数设定说明:

表示多重缝的次数, 可设定 2-50 次。点击[次数]的输入框变黄, 表示正处于输入状态, 通过数字键盘输入即可

【注】在光标输入的界面里也可以按  键, 直接展开多重缝制输入界面。

4.2 人字缝输入

【例】实例说明如何制作下图的图形资料, 用圆形输入做人字缝(人字缝的人字宽度: 5mm, 针距: 3mm)

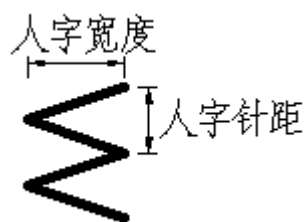


操作说明:

<p>1、输入方法的设定:</p> <p>1) 进入打版输入界面, 点击方向键移动压板至 A 点的空送确认, 再按  键进入输入方法的设定界面;</p> <p>2) 点击圆形输入键  ;</p> <p>3) 再按人字缝输入键  , 进入人字缝输入界面;</p>	
<p>2、人字缝的详细设定:</p> <p>1) 在此界面设定参数, 先点击  ; 设置针距为 3.0, 宽度为 5.0;</p> <p>2) 再点击  键;</p> <p>3) 点击  确定键返回上一界面;</p> <p>4) 点击  键返回输入打版界面。</p>	

<p>3、图形资料的输入： 1) 点击方向键移动压板，将圆形下一点移动到机针底下后点  确定键； 2) 点击方向键移动压板，将圆形最后一点移动到机针底下后点  确定键；</p>	
<p>4、图形资料的查证： 1) 点击  保存按钮，保存完毕后进入缝制加工界面； 2) 点击  键和  键查询车缝资料。</p>	

人字宽度、人字针距说明：



点击人字[人字针距]或[人字宽度]的输入框会变黄，表示正处于输入状态，通过数字键盘输入即可。

人字缝方向说明：



：在轴右侧进行人字缝




：以轴为中心向左侧进行人字缝



：以轴为中心向右侧进行人字缝



：在轴左侧进行人字缝

【注】在打版输入界面也可以点击  键进入人字缝设定界面。

第五章 花样资料的修改

下表展示了花样修改的主要功能：

功能	按键	内容	详细说明
针步修改 		以指定点的移动为参考进行整体移动	
		删除指定的针步	 : 指定两点间的针步  : 指定点后的所有针步
		在指定位置加入指定数量的针步	
		修改指定针步的位置	 : 移动点后续针步不变  : 移动点后续针步跟随改变
		移动指定范围内的针步位置	 : 修改前后资料不加针步  : 修改前后资料加针步
		在指定 2 点间做直线、多边形、曲线、人字缝、移动资料的修改	
		修改指定 2 点间的中压脚高度	 : 指定两点间的中压脚高度  : 指定点后所有中压脚高度
针步速度 			 : 指定两点间的缝纫速度  : 指定点后所有缝纫速度
代码数据 		指定点添加代码	
		指定点删除代码	

5.1 进入和退出修改模式的方法





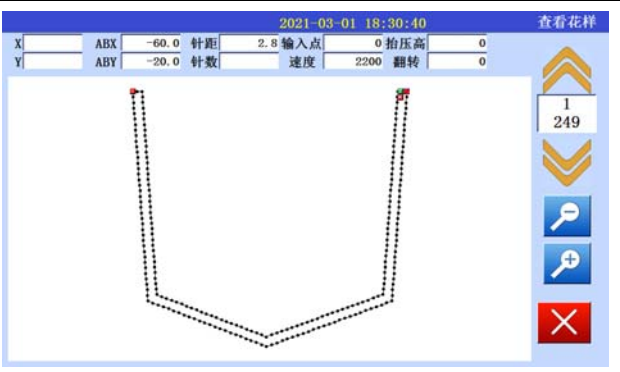
操作说明：

<p>1、进入修改模式：</p> <p>1) 在主界面使用  键和  键选择需要修改的花样，然后点击  按键；</p> <p>2) 然后点击  修改花样键，就会进入修改模式；</p>	
<p>2、退出修改模式：</p> <p>1) 点击  保存按钮，进入保存界面；</p> <p>2) 在保存界面可以选择“新保存图样”，即将修改后图样另存为新花样，选择此项后点击确认会进入命名界面；也可选择“覆盖原图样”，即将修改后图样覆盖原图；“不保存退出”即不保存修改；</p>	

5.2 花样的查看

操作说明：

<p>1) 在花样修改界面点击  查看按钮；</p>	
---	--

<p>2) 此界面查看，压板不会移动，界面上方参数栏显示当前针步信息；</p> <p>3) 点击  键和  键可以上下移动针步；</p> <p>4) 点击  键和  键可以放大/缩小图形；</p>	
--	--

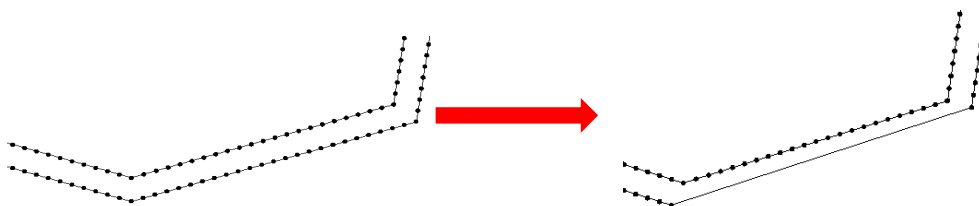
5.3 整体移动

【例】如下将整体移动花样资料。
操作说明：

<p>1、进入整体移动界面：</p> <p>1) 在花样修改界面点击  按钮，然后点击  确定键；</p> <p>2) 使用  键和  键移动针步到指定位置，本例以右下角为参考点，将红色点移动到右下角，然后点击  确定键；</p> <p>3) 点击  键和  键可以放大/缩小图形；</p>	
<p>2、采样：</p> <p>1) 点击方向键将选定参考点进行移动；</p> <p>2) 点击  键可撤销移动；</p> <p>3) 点击  键和  键可放大/缩小花样；</p> <p>4) 点击  键可下降/抬起中压脚；</p> <p>5) 移动完成后点击  确定键，即完成整体移动并返回花样修改主界面；</p> <p>6) 点击  保存按钮退出。</p>	

5.4 删除针

【例】如下将删除指定针步。

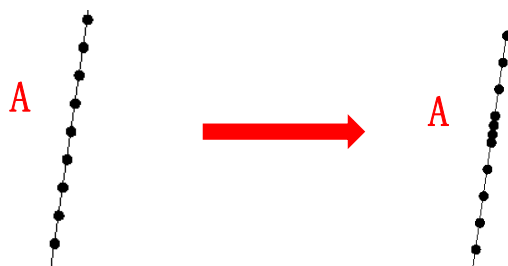


操作说明：











<p>1、进入删除针界面：</p> <p>1) 在花样修改界面点击  按钮， 然后点击  确定键；</p> <p>2) 检查  为选中状态；</p>	
<p>2、采样：</p> <p>1) 点击  键和  键可以放大/缩小图形；</p> <p>2) 点击  键可下降/抬起中压脚；</p> <p>3) 本例删除右下边针步，使用  键和  键先将移动红点到右下角， 然后点击  确定键；</p> <p>4) 开始点确定后，再使用  键和  键将红点移动到下方尖角，右下边会变红，代表即将删除的部分；</p> <p>5) 结束点选择后点击  确定键，即完成删除针步并返回花样修改主界面；</p> <p>6) 点击  保存按钮退出。</p>	 

5.5 加针

【例】如下图的图形资料，在左图 A 点后方加针 2 针，成右图。



操作说明：

<p>1、进入加针界面：</p> <p>1) 在花样修改界面点击  按钮， 然后点击  确定键；</p> <p>2) 点击  键和  键可以放大/缩小图形；</p> <p>3) 点击  键可下降/抬起中压脚；</p>	
<p>2、采样：</p> <p>1) 本例在右边一点加入针步，使用  键和  键先将移动红点到指定位置，然后点击  确定键；</p> <p>2) 进入加针参数界面，选中加入针数 2 针，点击  确定键，即完成加针并返回花样修改主界面；</p> <p>3) 点击  保存按钮退出。</p>	

5.6 点移动(只移动选中点)

【例】如下图图形资料，将 A 点移动。

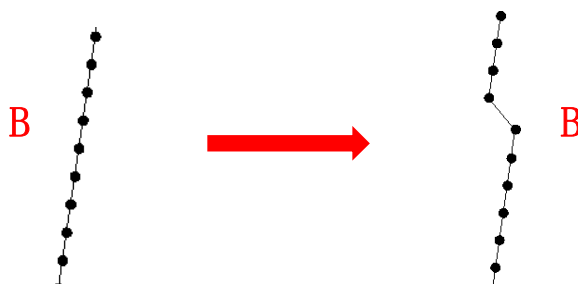


操作说明：

<p>1、进入点移动界面：</p> <p>1) 在花样修改界面点击  按钮， 然后点击  确定键；</p> <p>2) 点击  键；</p>	 <p>2021-03-02 09:20:11 花样修改 修改回原点路线</p>
<p>2、采样：</p> <p>1) 点击  键和  键可放大/缩小花样；</p> <p>2) 点击  键可下降/抬起中压脚；</p> <p>3) 使用  键和  键先移动红点到指定位置，然后点击  确定键；</p> <p>4) 使用方向键移动选中点到指定位置，点击  键可撤销移动；</p> <p>5) 移完后点击  确定键，即完成点移动并返回花样修改主界面；</p> <p>6) 点击  保存按钮退出。</p>	 <p>2021-03-02 08:56:58 输入点 0 X -65.4 0 Y -95.7 0 26 249</p>  <p>2021-03-02 09:00:55 输入点 0 X -64.8 0 Y -86.6 0</p>

5.7 点移动(选中点以后都移动)

【例】如下图图形资料，把B点移动(后方点跟随移动)

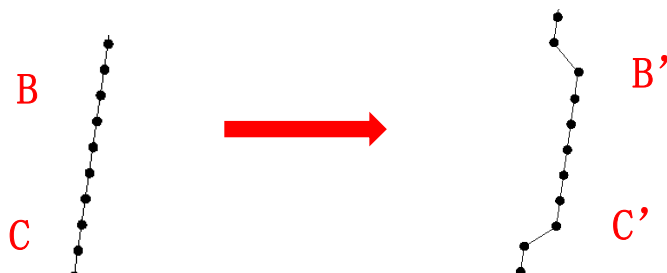


操作说明：

<p>1、进入点移动界面：</p> <p>1) 在花样修改界面点击  按钮，</p> <p>然后点击  确定键；</p> <p>2) 点击  键；</p>	 <p>2021-03-02 09:20:11 花样修改</p> <p>修改回原点路线</p> <p>类型B</p> <p>针步修改 针步速度 代码数据</p> <p>整体移动 删除针 加针</p> <p>点移动 区段移动 区域修改</p> <p>高度</p> <p>天收料 保存</p>												
<p>2、采样：</p> <p>1) 点击  键和  键可放大/缩小花样；</p> <p>2) 点击  键可下降/抬起中压脚；</p> <p>3) 使用  键和  键先移动红点到指定位置，然后点击  确定键；</p> <p>4) 使用方向键移动选中点到指定位置，点击  键可撤销移动；</p> <p>5) 移完后点击  确定键，即完成点移动并返回花样修改主界面；</p> <p>6) 点击  保存按钮退出。</p>	 <p>2021-03-02 09:07:07 采样</p> <p>输入点 0</p> <table border="1"> <tr> <td>X</td> <td>-64.8</td> <td>0</td> </tr> <tr> <td>Y</td> <td>-86.6</td> <td>0</td> </tr> </table> <p>23 249</p> <p>2021-03-02 09:14:54 采样</p> <p>输入点 0</p> <table border="1"> <tr> <td>X</td> <td>-64.8</td> <td>0</td> </tr> <tr> <td>Y</td> <td>-86.6</td> <td>0</td> </tr> </table> <p>← ↑ ↗</p> <p>← →</p> <p>↖ ↓ ↘</p> <p>保存</p>	X	-64.8	0	Y	-86.6	0	X	-64.8	0	Y	-86.6	0
X	-64.8	0											
Y	-86.6	0											
X	-64.8	0											
Y	-86.6	0											



5.8 区段移动(前后图形不变)

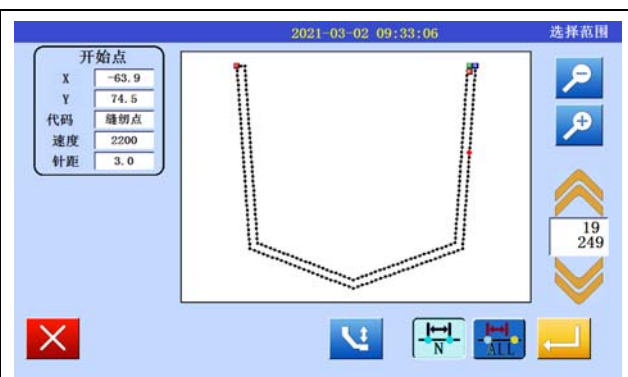
【例】如下图的图形资料，把B点和C点间的图形资料移动成B'点到C'点。这时B'点到C'点前后资料不变。



操作说明：

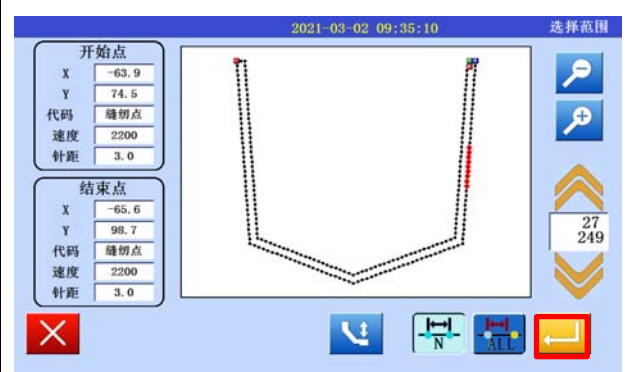
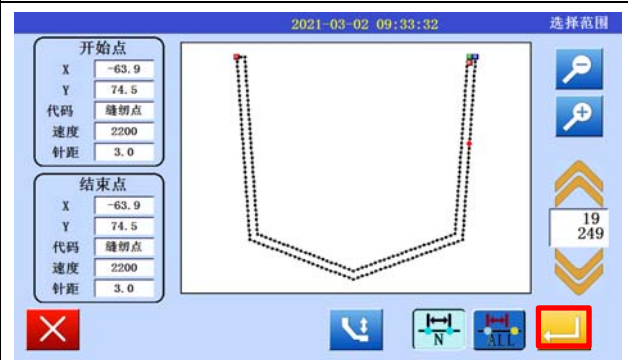
1、进入区段移动界面：

- 1) 在花样修改界面点击  按钮，
然后点击  确定键；



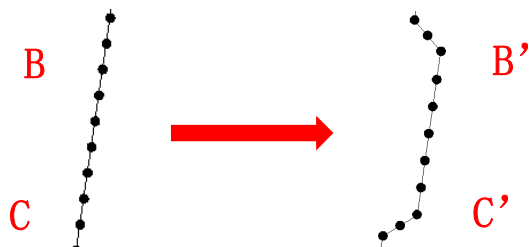
2、采样：

- 1) 点击  键和  键可以放大/缩小图形；
- 2) 点击  键可下降/抬起中压脚；
- 3) 使用  键和  键先移动红点到区段开始点，然后点击  确定键；
- 4) 再使用  键和  键移动红点到区段结束点，红色线条即为要修改区段，然后点击  确定键；
- 5) 点击  键，输入针距，再点击  确定键，即完成区段移动并返回花样修改主界面；
- 6) 点击  保存按钮退出。














5.9 区段移动(在前后图形加上新针步)

【例】如下图的图形资料，把B点和C点间的图形资料移动成B'点到C'点。这时B'点到C'点前后资料加上新针步。



操作说明:

<p>1、进入区段移动界面:</p> <p>1) 在花样修改界面点击  按钮，</p> <p>然后点击  确定键;</p>	
<p>2、采样:</p> <p>1) 点击  键和  键可以放大/缩小图形;</p> <p>2) 点击  键可下降/抬起中压脚;</p> <p>3) 使用  键和  键先移动红点到区段开始点，然后点击  确定键;</p> <p>4) 再使用  键和  键移动红点到区段结束点，红色线条即为要修改区段，然后点击  确定键;</p> <p>5) 点击  键，输入针距，再点击  确定键，即完成区段移动并返回花样修改主界面;</p> <p>6) 点击  保存按钮退出。</p>	

5.10 区段修改(直线修改)

【例】如下图的图形资料，把从 A 点到 B 点的图形资料修改为直线资料。













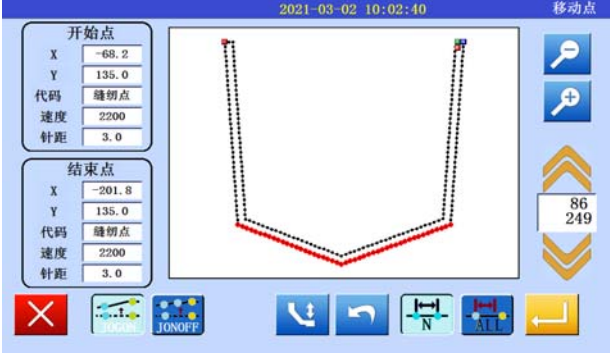










操作说明：


<p>1、进入区段修改界面：</p> <p>1) 在花样修改界面点击 按钮， 然后点击 确定键；</p> <p>2) 选择 直线输入，输入针距值， 然后点击 确定键。</p>	
<p>2、采样：</p> <p>1) 点击 键和 键可以放大/缩小图形；</p> <p>2) 点击 键可下降/抬起中压脚；</p> <p>3) 使用 键和 键先移动红点到区段开始点，然后点击 确定键；</p> <p>4) 再使用 键和 键移动红点到区段结束点，红色线条即为要修改区段，然后点击 确定键，即完成区段修改并返回花样修改主界面；</p> <p>5) 点击 保存按钮退出。</p>	


5.11 区段修改(圆弧、多边形修改)

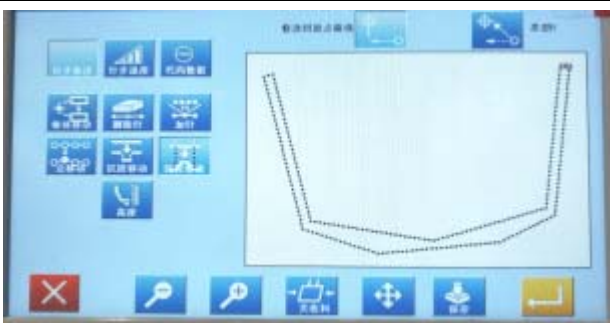
操作说明:

<p>1、进入区段修改界面:</p> <p>1) 在花样修改界面点击  按钮, 然后点击  确定键;</p> <p>2) 将区段修改成多段线, 选择  键, 输入针距值;</p> <p>3) 选择完毕后点击  确定键。</p>	 <p>2021-03-02 10:23:01 区段修改</p> <p>针距 2.8 (0.0-12.7)</p>
<p>2、选择指定修改区段:</p> <p>1) 使用  键和  键先移动红点到区段开始点, 然后点击  确定键;</p> <p>2) 再使用  键和  键移动红点到区段结束点, 红色线条即为要修改区段, 然后点击  确定键,</p> <p>3) 点击  键和  键可以放大/缩小图形;</p>	 <p>2021-03-02 10:02:40 移动点</p> <p>开始点 X: -68.2 Y: 135.0 代码: 缝切点 速度: 2200 针距: 3.0</p> <p>结束点 X: -201.8 Y: 135.0 代码: 缝切点 速度: 2200 针距: 3.0</p>
<p>3、修改位置:</p> <p>1) 点击  键和  键可放大/缩小花样;</p> <p>2) 使用  键和  键移动指针, 移动到需要修改的位置; 起点“S”和终点“E”不能修改;</p> <p>3) 选中移动点后, 点击方向键进行移动, 移动完毕后点击  确定键;</p> <p>4) 再次使用  键和  键移动指针, 移动到需要修改的位置;</p> <p>5) 然后点击方向键将选中点进行移动;</p>	 <p>输入点: 2 多边形</p> <p>X: -211.2 Y: 140.0</p>

6) 重复 2) 至 5) 步，直至修改完成；

点击  键，则会从起点“S”开始，按照确定点的顺序，生成一条条直线；

7) 回到修改主界面后点击  保存按钮退出。



5.12 区段修改(人字缝修改)

【例】如下图的图形资料，把一段直线改为人字缝资料。



操作说明：

1、进入区段修改界面：

1) 在花样修改界面点击  按钮，然后点击  确定键；

2) 选中  键，再选中  键，然后在人字针距输入 3.0，在人字宽度输入 5.0；

3) 然后点击  确定键，



2、采样：

1) 点击  键和  键可放大/缩小花样；

2) 使用  键和  键先移动红点到区段开始点，然后点击  确定键；


3) 再使用  键和  键移动红点到区段结束点，红色线条即为要修改区段，然后点击  确定键；

4) 修改完毕回到主界面后点击  保存按钮退出。



5.13 中压脚高度设置






操作说明：

<p>1、进入压脚高度界面：</p> <p>1) 在花样修改界面点击  按钮，</p> <p>然后点击  确定键；</p>	 <p>2021-03-02 09:20:11 花样修改 修改回原点路线 类型B</p> <p>针步修改 针步速度 代码数据 整体移动 删除针 加针 点移动 区段移动 区域修改 高度</p>
<p>2、采样：</p> <p>1) 点击  键和  键可放大/缩小花样；</p> <p>2) 使用  键和  键先移动红点到区段开始点，然后点击  确定键；</p> <p>3) 再使用  键和  键移动红点到区段结束点，红色线条即为要修改区段，然后点击  确定键；</p> <p>4) 在高度设置界面，输入值，点击  确定键后回到主界面；</p> <p>5) 点击  保存按钮退出。</p>	 <p>2021-03-02 13:44:52 选择范围</p> <p>开始点 X -63.2 Y 65.4 代码 缝切点 速度 2200 针距 3.0</p> <p>选择范围 16 249</p>  <p>2021-03-02 13:45:20 选择范围</p> <p>开始点 X -63.2 Y 65.4 代码 缝切点 速度 2200 针距 3.0</p> <p>结束点 X -65.8 Y 101.7 代码 缝切点 速度 2200 针距 3.0</p> <p>选择范围 28 249</p>  <p>2021-03-02 17:44:09 花样参数</p> <p>中压高度 <input type="text" value="5.0"/> (0.0 - 20.0)</p> <p>1 2 3 4 5 6 7 8 9 0 +/-</p>

5.14 缝制速度修改(修改指定区段速度)

说明：改变某一段的缝纫速度，例如花样拐角速度。



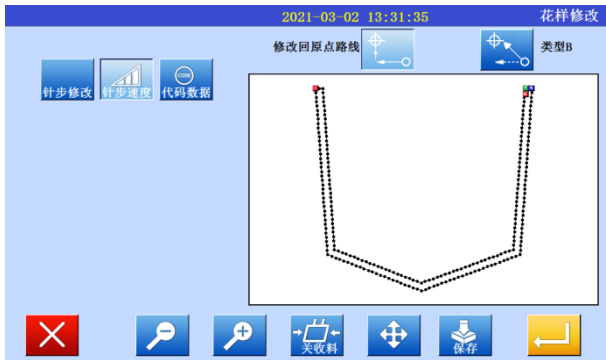









操作说明：

<p>1、进入针步速度界面：</p> <p>1) 在花样修改界面点击  按钮，</p> <p>然后点击  确定键；</p>	 <p>2021-03-02 13:31:35 花样修改</p> <p>修改回原点路线</p> <p>针步修改 针步速度 代码数据</p> <p>类型B</p>																																
<p>2、采样：</p> <p>1) 点击  键和  键可放大/缩小花样；</p> <p>2) 点击  键；</p> <p>3) 使用  键和  键先移动红点到区段开始点，然后点击  确定键；</p> <p>4) 再使用  键和  键移动红点到区段结束点，红色线条即为要修改区段，然后点击  确定键；</p> <p>5) 在速度设置界面，输入 2200，点击  确定键后回到主界面；</p> <p>6) 点击  保存按钮退出。</p>	 <p>2021-03-02 13:44:52 选择范围</p> <p>开始点</p> <table border="1"> <tr><td>X</td><td>-63.2</td></tr> <tr><td>Y</td><td>65.4</td></tr> <tr><td>代码</td><td>缝切点</td></tr> <tr><td>速度</td><td>2200</td></tr> <tr><td>针距</td><td>3.0</td></tr> </table> <p>16 249</p> <p>2021-03-02 13:45:20 选择范围</p> <p>结束点</p> <table border="1"> <tr><td>X</td><td>-65.8</td></tr> <tr><td>Y</td><td>101.7</td></tr> <tr><td>代码</td><td>缝切点</td></tr> <tr><td>速度</td><td>2200</td></tr> <tr><td>针距</td><td>3.0</td></tr> </table> <p>28 249</p> <p>2021-03-02 13:45:57 花样参数</p> <p>速度 2200 (400 - 3200)</p> <table border="1"> <tr><td>1</td><td>2</td><td>3</td></tr> <tr><td>4</td><td>5</td><td>6</td></tr> <tr><td>7</td><td>8</td><td>9</td></tr> <tr><td>0</td><td>↶</td><td>⊙</td></tr> </table>	X	-63.2	Y	65.4	代码	缝切点	速度	2200	针距	3.0	X	-65.8	Y	101.7	代码	缝切点	速度	2200	针距	3.0	1	2	3	4	5	6	7	8	9	0	↶	⊙
X	-63.2																																
Y	65.4																																
代码	缝切点																																
速度	2200																																
针距	3.0																																
X	-65.8																																
Y	101.7																																
代码	缝切点																																
速度	2200																																
针距	3.0																																
1	2	3																															
4	5	6																															
7	8	9																															
0	↶	⊙																															

5.15 缝制速度修改(修改指定点后所有针步)

说明：选中 1 点，该点以后所有针步都会变更速度。

操作说明：



<p>1、进入针步速度界面：</p> <p>1) 在花样修改界面点击  按钮，</p> <p>然后点击  确定键；</p>	 <p>2021-03-02 13:31:35 花样修改</p> <p>修改回原点路线</p> <p>针步修改 针步速度 代码数据</p> <p>类型B</p> <p>关闭 保存</p>																						
<p>2、采样：</p> <p>1) 点击  键和  键可放大/缩小花样；</p> <p>2) 点击  键；</p> <p>3) 使用  键和  键先移动红点到区段开始点，然后点击  确定键；</p> <p>4) 在速度设置界面，输入 2200，点击  确定键后回到主界面；</p> <p>5) 点击  保存按钮退出。</p>	 <p>2021-03-02 17:22:45 选择范围</p> <p>开始点</p> <table border="1"> <tr><td>X</td><td>-64.1</td></tr> <tr><td>Y</td><td>77.5</td></tr> <tr><td>代码</td><td>缝制点</td></tr> <tr><td>速度</td><td>2200</td></tr> <tr><td>针距</td><td>3.0</td></tr> </table> <p>20 249</p> <p>2021-03-02 13:45:57 花样参数</p> <table border="1"> <tr><td>1</td><td>2</td><td>3</td></tr> <tr><td>4</td><td>5</td><td>6</td></tr> <tr><td>7</td><td>8</td><td>9</td></tr> <tr><td>0</td><td>↵</td><td>⊙</td></tr> </table> <p>速度 2200 (400 - 3200)</p>	X	-64.1	Y	77.5	代码	缝制点	速度	2200	针距	3.0	1	2	3	4	5	6	7	8	9	0	↵	⊙
X	-64.1																						
Y	77.5																						
代码	缝制点																						
速度	2200																						
针距	3.0																						
1	2	3																					
4	5	6																					
7	8	9																					
0	↵	⊙																					

5.16 代码修改(加入代码)

【例】如下图的图形资料，在缝内线时要加入缩板资料。



操作说明：




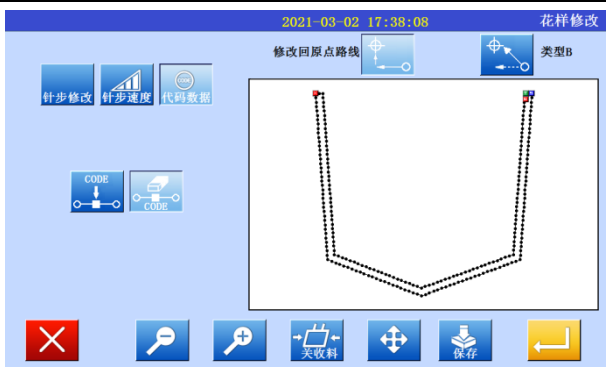






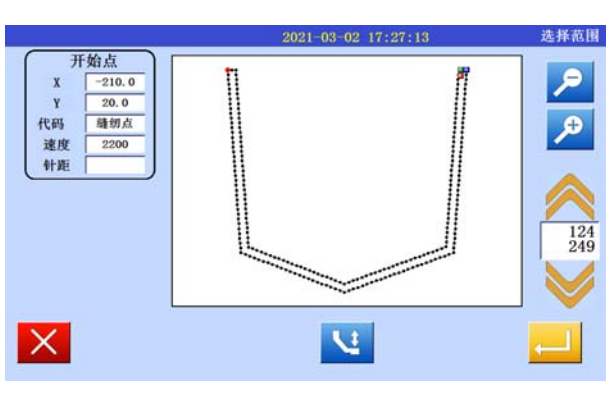
<p>1、进入代码数据界面：</p> <p>1) 在花样修改界面点击  按钮，再点击  按钮，然后点击  确定键；</p>	 <p>2021-03-02 17:30:34 花样修改 修改回原点路线 类型B 针步修改 针步速度 代码数据 CODE CODE 天收料 保存 确定键</p>
<p>2、选定修改位置：</p> <p>1) 点击  键和  键可放大/缩小花样；</p> <p>2) 使用  键和  键移动红点到代码添加处；</p> <p>3) 选择完毕后点击  确定键。</p>	 <p>2021-03-02 17:27:13 选择范围 开始点 X -210.0 Y 20.0 代码 缝切点 速度 2200 针距 放大键 缩小键 124 249 确定键</p>
<p>3、添加代码：</p> <p>1) 代码输入界面选择  退板按钮，然后点击  确定键返回修改花样主界面；</p> <p>2) 点击  保存按钮退出。</p>	 <p>2021-03-02 17:32:38 功能输入 (停针) 退板 夹线 关闭 打开 延伸 确定键</p>

5.17 代码修改(删除代码)

【例】如下图的图形资料，要消除口袋内线的缩板功能码。



操作说明：


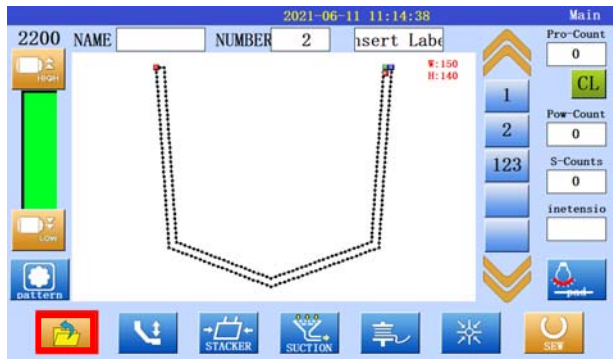




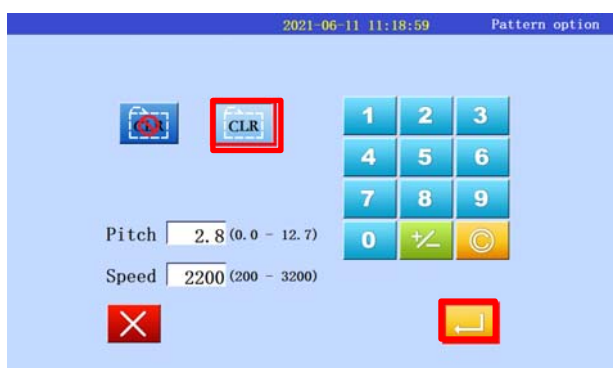



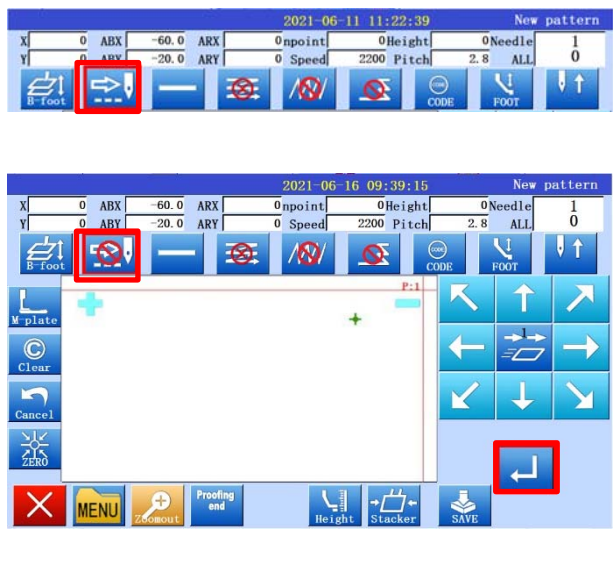
<p>1、进入代码数据界面：</p> <p>1) 在花样修改界面点击  按钮，</p> <p>再点击  按钮，然后点击  确定键；</p>	 <p>2021-03-02 17:38:08 花样修改</p> <p>修改回原点路线</p> <p>针步修改 针步速度 代码数据</p> <p>CODE CODE</p> <p>天收料 保存</p>										
<p>2、选定修改位置：</p> <p>1) 点击  键和  键可放大/缩小花样；</p> <p>2) 使用  键和  键移动红点到代码删除处，点击  确定键；</p> <p>3) 点击  保存按钮退出。</p>	 <p>2021-03-02 17:27:13 选择范围</p> <p>开始点</p> <table border="1"> <tr><td>X</td><td>-210.0</td></tr> <tr><td>Y</td><td>20.0</td></tr> <tr><td>代码</td><td>删除点</td></tr> <tr><td>速度</td><td>2200</td></tr> <tr><td>针距</td><td></td></tr> </table> <p>124 249</p>	X	-210.0	Y	20.0	代码	删除点	速度	2200	针距	
X	-210.0										
Y	20.0										
代码	删除点										
速度	2200										
针距											




Content


1、 New Pattern Making	1
2、 Program Introduction	3
2.1 New Pattern Make Interface	3
3、 Basic Stitching Shape Setting	5
3.1 Straight Line Creation	5
3.2 Arc Line Creation	7
3.3 Circle Line Creation	9
3.4 Polygon Creation	11
3.5 Feature Codes Input	14
4、 Special Sewing Shape Input	16
4.1 Multiple Stitching	16
4.2 Zig Zag	18
5、 Edit Pattern	20
5.1 Enter And Exit Edit Pattern Mode	21
5.2 Viewing Patterns	21
5.3 Overall Moving	22
5.4 Delete Stitches	23
5.5 Add Stitches	24
5.6 Point Moving (only move specified point)	24
5.7 Point Moving (Move all the stitches start from specified point)	25
5.8 Area Moving (only move the specified area)	26
5.9 Area Moving (will add stitches before and after the moving area)	28
5.10 Area Modification (change to straight line)	29
5.11 Area Modification (change to curve line / polygon)	30
5.12 Area Modification (change to zig zag)	31
5.13 Presser Foot Height Setting	32
5.14 Sewing Speed Modification (with an area)	33
5.15 Sewing Speed Modification (change speed start from specified point)	34
5.16 Feature Code Modification (add feature code)	34
5.17 Feature Code Modification (delete feature code)	35

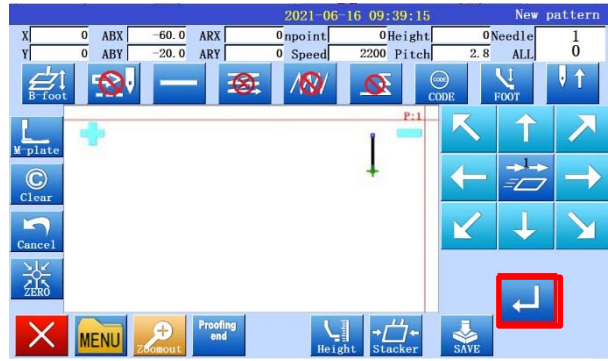
1、 New Pattern Making


This an introduction for the new pattern making process and interface switching.

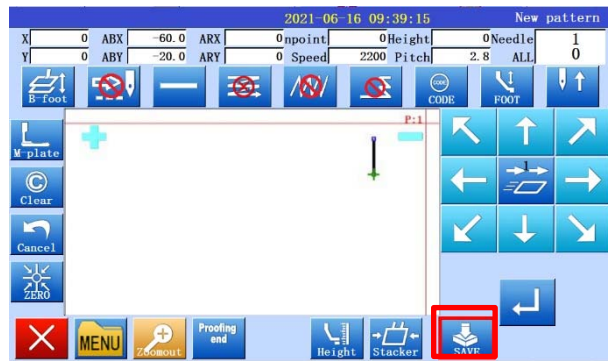
<p>1.1 In Main Interface, press ;</p>	
<p>1.2 Press New Pattern Make ;</p>	
<p>1.3 Pattern Parameter Input Interface: ① Stitch length: 0.1mm-12.7mm ② Sewing speed: max.3200 rpm Use  ~  to input numbers, press  to delete; Finally, press </p>	
<p>1.4 New Pattern Make Interface: The first time you enter, the default is empty sewing  (without stitches); Long press  to move the carrier clamp, to make the first stitch point under needle (when long press the direction keys, the green + on the screen will follow, also the X and Y value will change) When reach the start point, press  to confirm the stitching routine from zero point to start point.</p>	


1.5 After start point is confirmed,  changes to , long press  to move the carrier clamp to next turning point, also the green + will follow.

When reach the point, press  to confirm the stitching routine from start point to next point. A black line shows on screen.




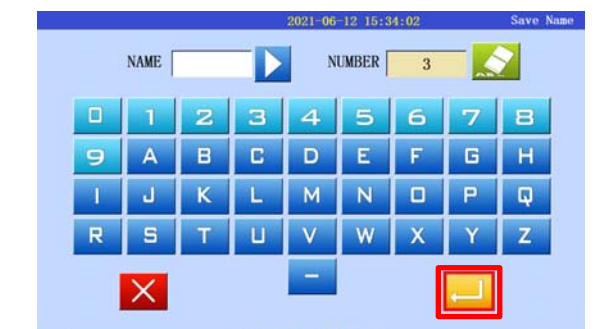
1.6 Press  to Pattern Saving Interface.



1.7 Press Save As New; then press  to the Name Interface.



1.8 Input the new pattern name and size, press  to save it.

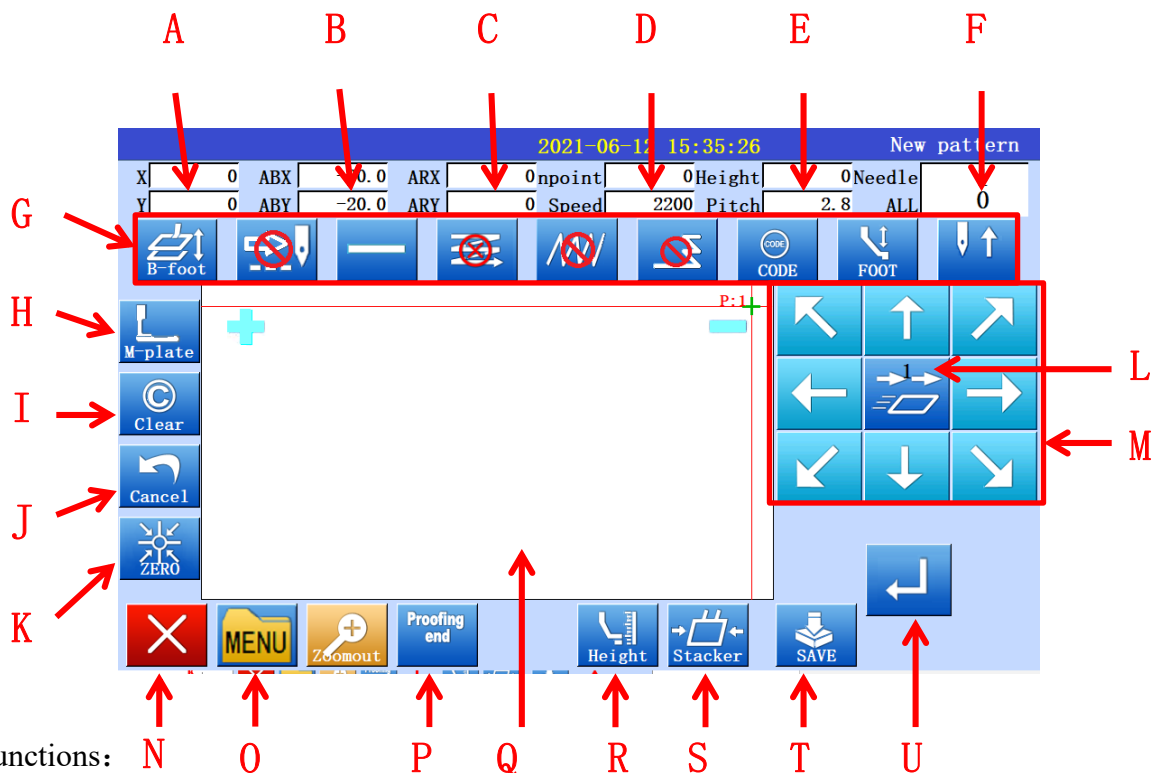


1.9 After saving, it will return to the Sewing Interface, and the new pattern is created.






2、 Program Introduction

2.1 New Pattern Make Interface





Functions:

Area	Function	Description
A	Coordinates	X&Y position value
B	Absolute coordinates	X&Y absolute position value
C	Relative coordinates	X&Y relative position value
D	Speed	Current speed
E	PFH & SL	Current presser foot height and stitch length
F	Current & total stitches	Current stitch numbers and total stitch numbers
G	Stitch functions area	All the stitching functions
H	Inner clamp actions	Inner clamp up and down
I	Clear	Clear last point parameter, return to previous point
J	Cancel	Cancel the last carrier clamp movement, return to previous point position
K	Reset	Clear all the points and lines, return to zero position
L	Carrier moving speed	 : Normal speed;  : Faster speed;  : Fastest speed
M	Direction arrow keys	Move carrier clamp to different positions
N	Quit/Back	Quit Stitching Create Interface and back to Main Interface
O	Menu	None
P	Proofing end	To create Multiple Stitches
Q	Preview window	Preview display pattern graphics

R	Presser foot height	Presser foot height setting
S	Stacker	Stacker on/off
T	Saving key	To enter Pattern Saving Interface
U	Confirming key	Confirm current point position










Functions:

Area	Function	Description
A	Outer clamp actions	Outer clamp up and down
B	Empty sewing	 : empty sewing  : real sewing
C	Stitching shape	Enter stitching shape setting interface, like straight line, round, curve, multiple stitching, etc.
D	Multi-stitch setting	Enter multi-stitch setting interface
E	Zig zag setting	Enter zig zag sewing setting interface
F	Reverse sewing setting	Enter reverse sewing setting interface
G	Feature codes	Enter sewing feature setting interface
H	Presser foot setting	Presser foot up and down
I	Needle movement	Needle up and down

3、 Basic Stitching Shape Setting

This chapter introduces several basic stitching shape setting:

Shape	Icon	Description
Straight line		Input 2 points positions: start point and end point of the line, to create a straight line between the two points
Arc line		Input 3 points positions: start point, middle point, and end point of the arc line, to create an arc line on the 3 points
Circle line		Input 3 points positions: start point, another 2 points on the circle, to create a circle line base on the 3 points
Curve line		Input start point and other points on the curve line
Polygon		Input start point and other turning points, all the points will be connected by straight lines
Point stitch		One point for one stitch
Feature codes		Add sewing features on the stitching line, like trimming, inner clamp open and close

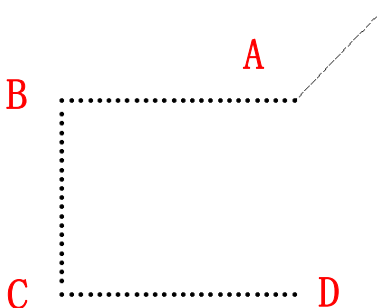
3.1 Straight Line Creation

Operation points:









- Set-in Straight-line Creation
- Input 2 points: set the start point, then long press arrow key to reach the end point, press confirm icon to set the end point, one straight sewing line between the 2 points is created.

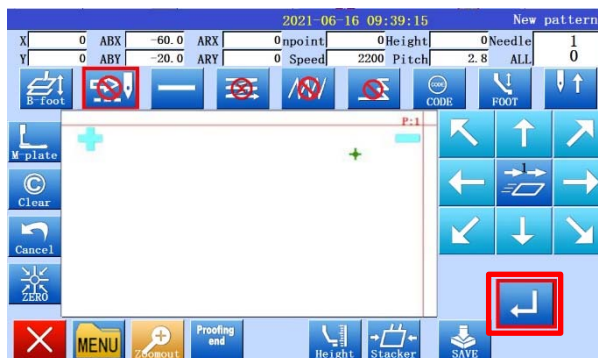
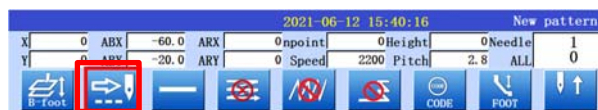
【e.g.】







Instructions:

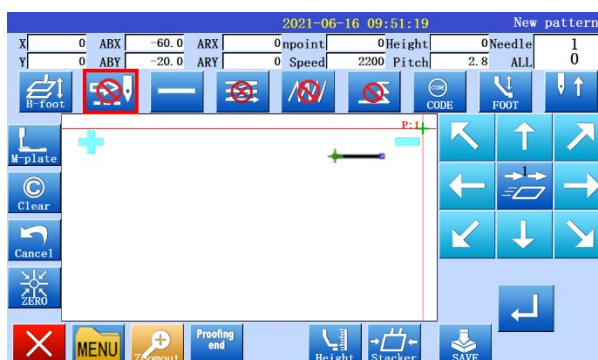
3.1.1 Set empty sewing to start point A:

- 1) In Main Interface, press  and , input parameter and enter New Pattern Make Interface.(Refer to 1.1 to 1.3);
- 2) Check the empty sewing icon , if not, press  to switch to ;
- 3) Long press arrow key to move the carrier clamp, to make the start stitch point A under needle. Press  to confirm the stitching routine from zero point to start point A.





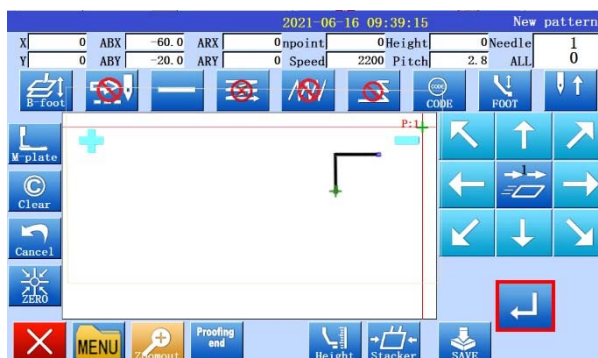
3.1.2 A to B stitching:

- 1) After one time empty sewing, machine changes to real sewing , press  to switch to ;
- 2) Move point B under needle;
- 3) Press  to confirm the stitching routine from point A to B.





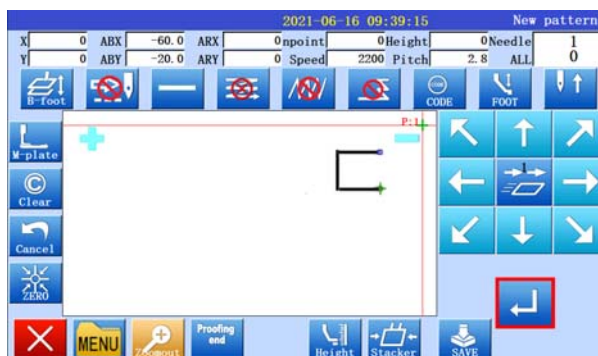
3.1.3 B to C stitching:






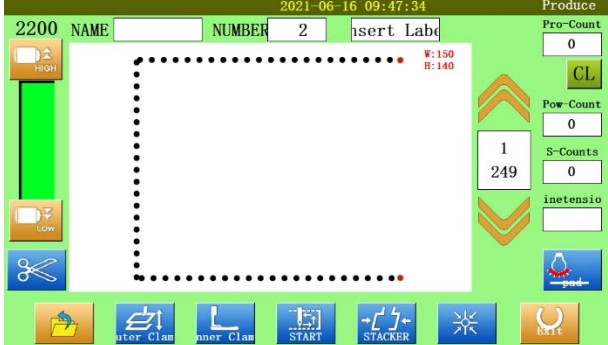
- 1) Switch to empty sewing ;
- 2) Move point C under needle;
- 3) Press  to confirm the stitching routine from point B to C.



3.1.4 C to D stitching:


- 1) Switch to empty sewing ;
- 2) Move point D under needle;
- 3) Press  to confirm the stitching routine from point C to D.



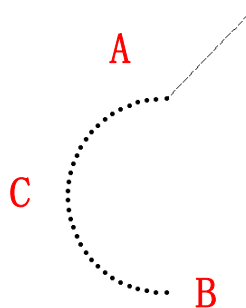
<p>3.1.5 Press  to save the pattern; Input pattern name and size, press  to save and return to Sewing Interface. 【After saving, the program itself will create the routine back to zero position】</p>	
<p>3.1.6 Double check: 1) In Sewing Interface, press  and  (Move forward/backward) to check the stitching pattern. 2) If need to modify, please refer to 【Chapter 5、Edit Pattern】</p>	

3.2 Arc Line Creation

Operation points:







- Set-in Arc-line Creation 
- Input 3 points positions: set the start point, middle point, and end point of the arc line, to create an arc sewing line on the 3 points

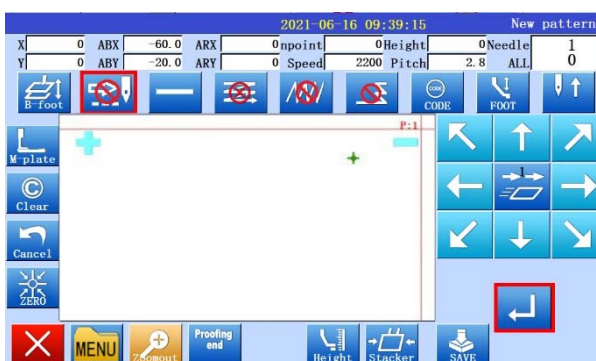
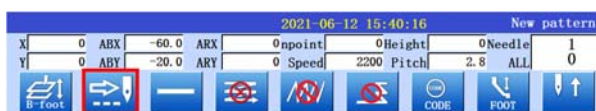
【e.g.】







Instructions:

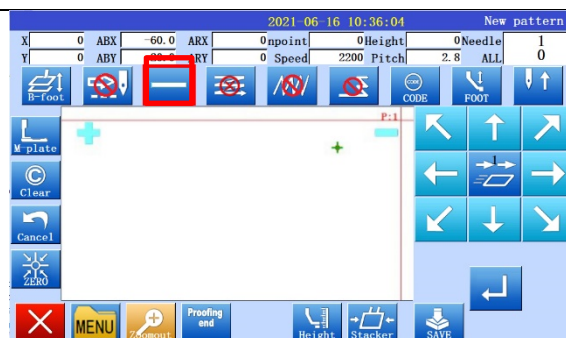
3.2.1 Set empty sewing to start point A:

- 1) In Main Interface, press  and , input parameter and enter New Pattern Interface. (1.1 to 1.3);
- 2) Check the empty sewing icon , if not, press  to switch to ;
- 3) Long press arrow key to move the carrier clamp, to make the start stitch point A under needle. Press  to confirm the stitching routine from zero point to start point A.





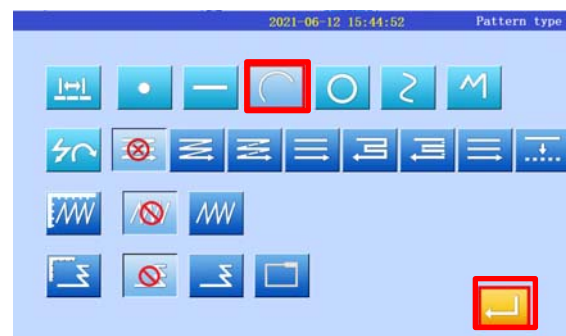
3.2.2 Change stitching shape setting:

- 1) After one time empty sewing, machine changes to real sewing , press  to switch to ;
- 2) Press  to enter Stitching Shape Setting to choose arc line shape





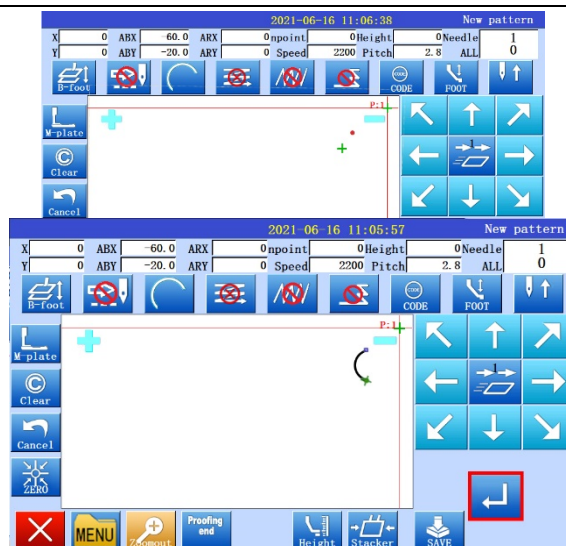
3.2.3 Set in arc line shape stitching:






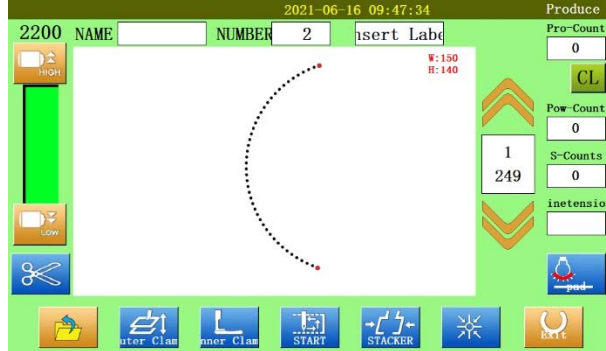
- 1) Press  to set in arc line shape;
- 2) Press  to save and return to New Pattern Make Interface



3.2.4 Create arc line from A to B:


- 1) Move arc line middle point C under needle;
- 2) Press  to confirm, the middle point shows in preview window;
- 3) Move end point B under needle;
- 4) Press  to confirm and create arc line.



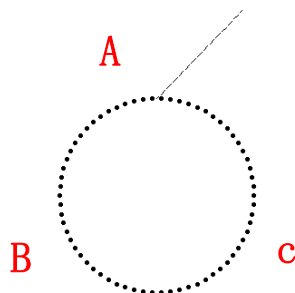
<p>3.2.5 Press  to save the pattern;</p> <p>Input pattern name and size, press  to save and return to Sewing Interface.</p> <p>【After saving, the program itself will create the routine back to zero position】</p>	
<p>3.2.6 Double check:</p> <p>1) In Sewing Interface, press  and  (Move forward/backward) to check the stitching pattern.</p> <p>2) If need to modify, please refer to 【Chapter 5、 Edit Pattern】</p>	

3.3 Circle Line Creation







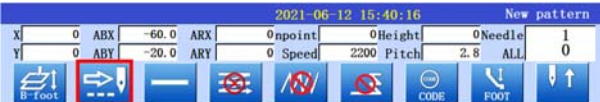

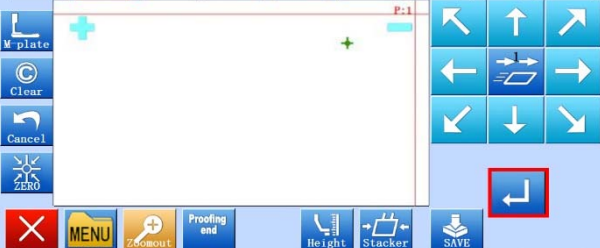




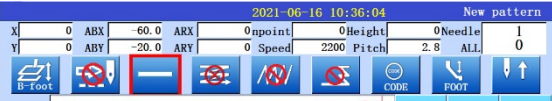
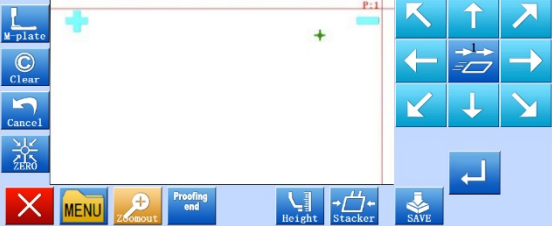





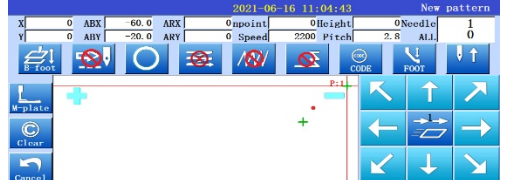
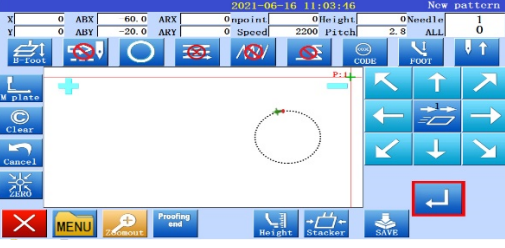
Operation points:






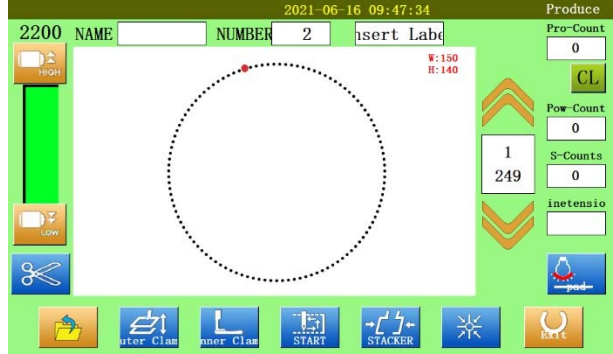
- Set-in Circle-line Creation 
- Input 3 points positions: set the start point, and another 2 points on the circle, to create a circle sewing line base on the 3 points

【e.g.】




Instructions:

<p>3.3.1 Set empty sewing to start point A:</p> <ol style="list-style-type: none"> 1) In Main Interface, press  and , input parameter and enter New Pattern Interface.(1.1 to 1.3); 2) Check the empty sewing icon , if not, press  to switch to ; 3) Long press arrow key to move the carrier clamp, to make the start stitch point A under needle. Press  to confirm the stitching routine from zero point to start point A. 	  
<p>3.3.2 Change stitching shape setting:</p> <ol style="list-style-type: none"> 1) After one time empty sewing, machine changes to real sewing , press  to switch to . 2) Press Basic Stitching Shape Setting  to choose circle line shape 	 
<p>3.3.3 Set in circle line shape stitching:</p> <ol style="list-style-type: none"> 1) Press  to set in circle shape; 2) Press  to save and return to New Pattern Make Interface 	
<p>3.3.4 Create circle line base on A, B, C:</p> <ol style="list-style-type: none"> 1) Move any point B(on circle) under needle; 2) Press  to confirm, the middle point shows in preview window; 3) Move another point C(on circle) under needle; 4) Press  to confirm and create circle line. 	 

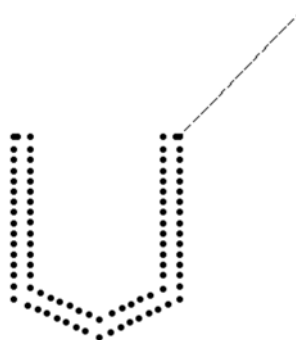
<p>3.3.5 Press  to save the pattern; Input pattern name and size, press  to save and return to Sewing Interface. 【After saving, the program itself will create the routine back to zero position】</p>	
<p>3.3.6 Double check: 1) In Sewing Interface, press  and  (Move forward/backward) to check the stitching pattern. 2) If need to modify, please refer to 【Chapter 5、Edit Pattern】</p>	

3.4 Polygon Creation

Operation points:






- Set-in Polygon Creation 
- Input start point and other turning points, all the points will be connected by straight lines

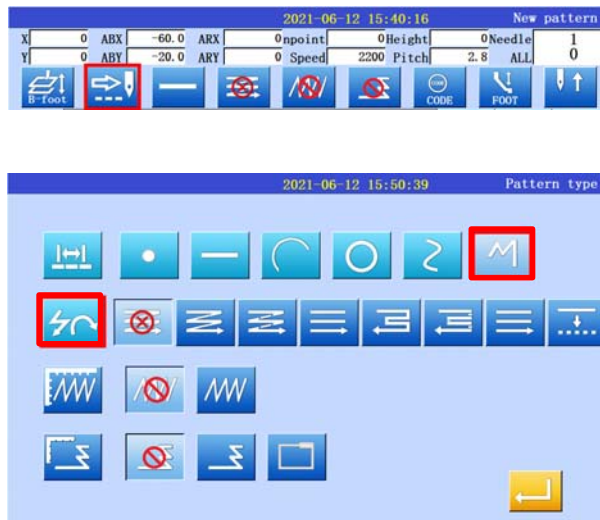
【e.g.】





Instructions:


3.4.1 Change stitching shape setting:

- 1) In Main Interface, press  and , input parameter and enter New Pattern Make Interface.(Refer to 1.1 to 1.3);
- 2) Press  to enter Stitching Shape Setting
- 3) Press  to set in polygon shape;
- 4) Press  to multi-stitch setting interface (It can automatically create double line stitching when set frequency 2 times)










3.4.2 Needle gauge set:

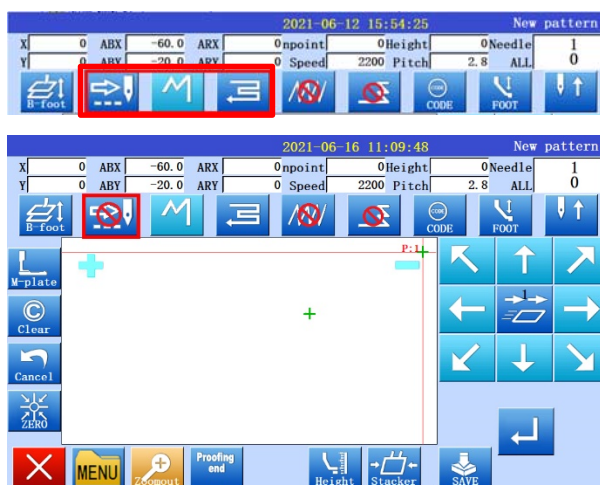
- 1) Press  to see parameter setting;
- 2) Input requested parameter, press  to confirm and return to previous interface;

3.4.3 Press  to return to New Pattern Make Interface.








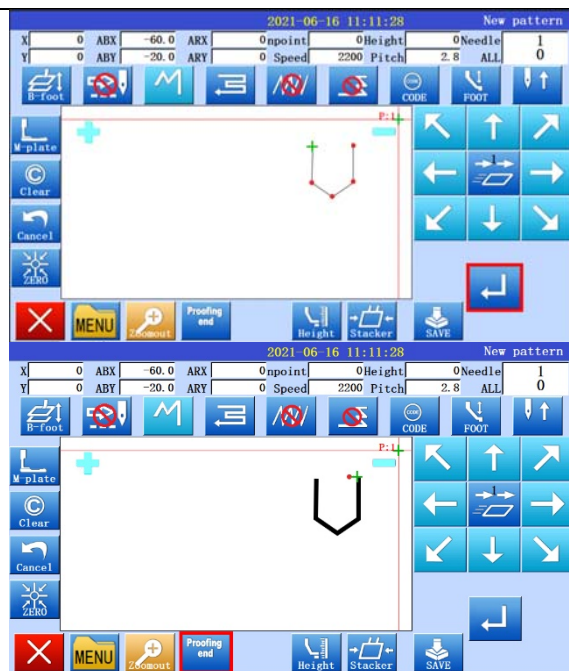
3.4.4 Set empty sewing to start point:


- 1) Check the empty sewing icon , if not, press  to switch to .
- 2) Long press arrow key to move the carrier clamp, to make the start stitch point under needle. Press  to confirm the stitching routine from zero point to start point
- 3) After one time empty sewing, machine changes to real sewing , press  to switch to .






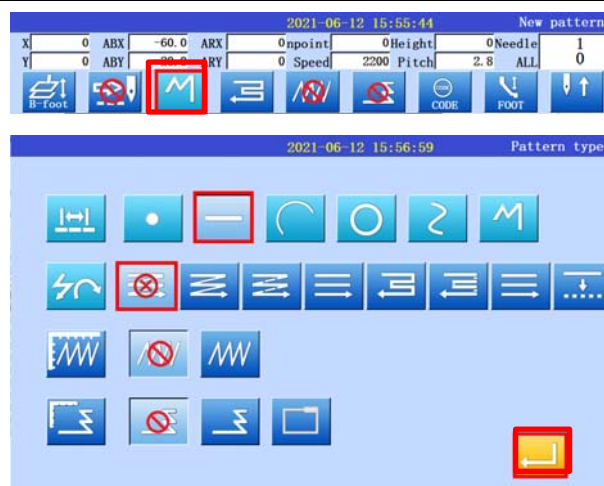
3.4.5 Confirm others points:

- 1) Move the 2nd point under needle;
press  to confirm.
- 2) Move the 3rd point under needle;
press  to confirm.
- 3) Move the 4th point under needle;
press  to confirm.
- 4) Move the 5th point under needle;
press  to confirm.
- 5) Finally, press  to end proofing.





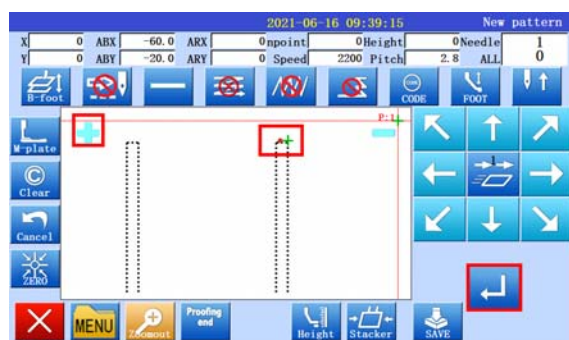
3.4.6 Press  to enter Stitching Shape Setting

Press  and , then press  to confirm and return to New Pattern Make Interface.




3.4.7 Close outer stitch and inner stitch:

- 1) Press  to zoom in the pattern drawing;
- 2) Now the inner stitch end point is under needle, move the carrier clamp, to make the start point under needle.
Press  to confirm the close line.





3.4.8 Press  to save the pattern;

Input pattern name and size, press  to save and return to Sewing Interface.

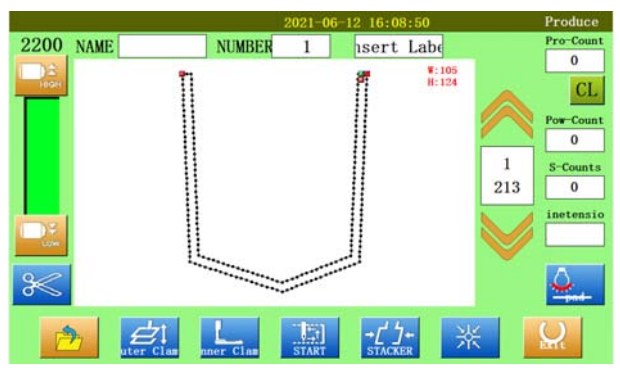
【After saving, the program itself will create the routine back to zero position】



3.4.9 Double check:


3) In Sewing Interface, press  and  (Move forward/backward) to check the stitching pattern.

1) If need to modify, please refer to **【Chapter 5、 Edit Pattern】**

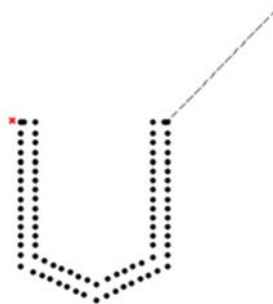


3.5 Feature Codes Input





Operation points:

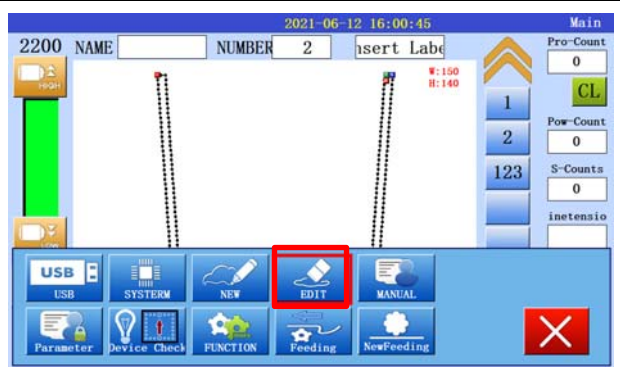
- Enter Edit Pattern mode 
- Choose Feature Codes




【e.g.】 Before the first stitch of closing stitching, add an inner clamp retraction feature code.

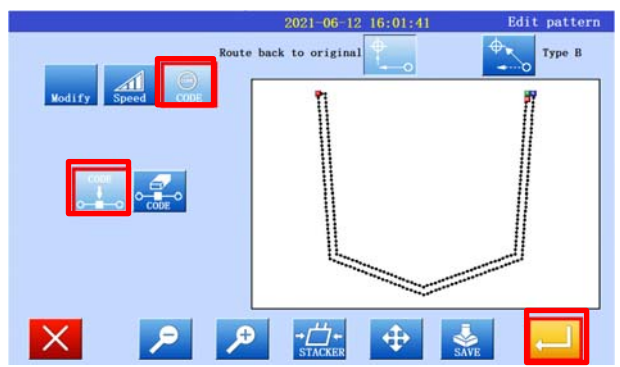





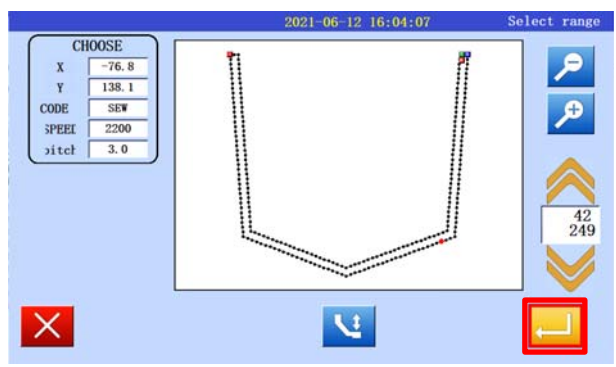








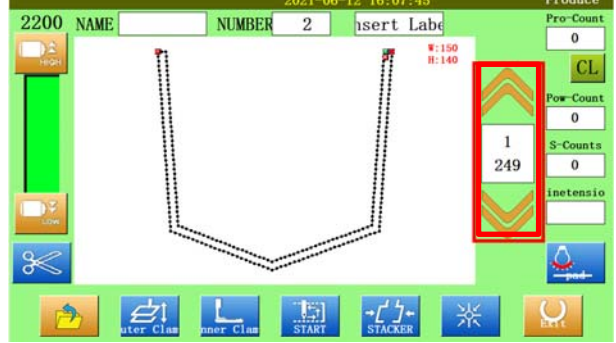
Instructions:

3.5.1 In the Main Interface, use  and  to select a pattern, press  and  to enter Edit Pattern Interface.





3.5.2 Press  for code; press  for code addition, then press  to enter Stitches Interface.








<p>3.5.3 Press  and  to move the carrier clamp to the position where will add the inner clamp retraction code, press  to enter feature input interface.</p>	
<p>3.5.4 Press  for inner clamp retraction, then press  to confirm and return to Edit Pattern Interface.</p>	
<p>3.5.5 Press  to save the pattern; Input pattern name and size, press  to save and return to Sewing Interface. 【After saving, the program itself will create the routine back to zero position】</p>	
<p>3.5.6 Double check:</p> <ol style="list-style-type: none"> 1) In Sewing Interface, press  and  (Move forward/backward) to check the stitching pattern. 2) If need to modify, please refer to 【Chapter 5、Edit Pattern】 	

Feature code setting list:

Feature	Icon	Description
Trimming		Add thread trimming feature at specified stitch point
Retraction		Add inner clamp retraction feature at specified stitch point


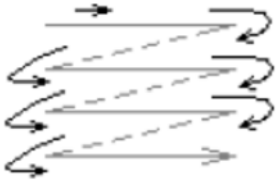

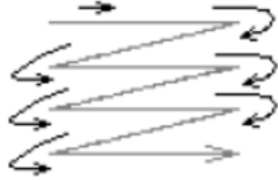

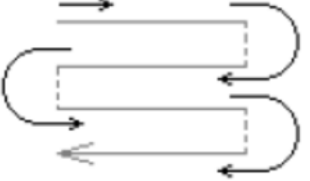

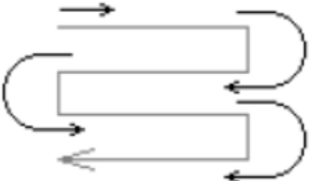
4、 Special Sewing Shape Input



It can be used for reverse stitching, multiple stitching, off-edge stitching, and zig zag stitching, and can be mixed with basic stitching shape, so the pattern-making can be easily completed.

Sewing Shape	Icon
Multiple Stitching	 : Same direction multi-stitch (connected)
	 : Same direction multi-stitch (separated)
	 : Reverse direction multi-stitch (connected)
	 : Reverse direction multi-stitch ((separated)
Zig Zag Stitching	

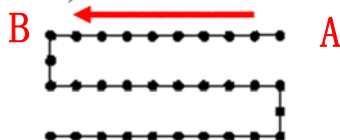
【Notes】 Point Stitch type cannot mix with these Special Sewing Type.

4.1 Multiple Stitching

Type	Connection	Icon	Sewing Routine	Description
Same direction	Separated			Same direction multiple stitching, lines are separated
	Connected			Same direction multiple stitching, lines are connected.
Reverse direction	Separated			Reverse direction multiple stitching, lines are separated.
	Connected			Reverse direction multiple stitching, lines are connected.

In the Sewing Routine:  dotted line means stitching lines are separated;
 solid line means stitching lines are connected.


【e.g.】 Reverse direction multiple stitching, lines are connected. (Straight line, needle gauge 6mm, 3 times, initial from right to left)




Instructions:

<p>4.1.1 Sewing type setting:</p> <ol style="list-style-type: none"> 1) Enter New Pattern Make Interface, move carrier clamp to make start point A under needle, press  to confirm the stitching routine from zero point to start point A. Then press  to enter Sewing Shape Setting; 2) Press  to select straight line; 3) Press  to enter multiple stitching setting interface. 	
<p>4.1.2 Multiple stitching setting:</p> <ol style="list-style-type: none"> 1) Press  to select reverse direction multi-stitch; needle gauge 6mm, 3 times; 2) Press  back to Stitching Shape; 3) Press  back to New Pattern. 	
<p>4.1.3 Pattern creation:</p> <ol style="list-style-type: none"> 1) Move carrier clamp to make point B under needle, press  to confirm the stitching routine from A to B. 	
<p>4.1.4 Double check:</p> <ol style="list-style-type: none"> 1) Press  to save the pattern; press  to save and return to Sewing Interface. 2) Press  and  to check the stitching pattern. 	

Position Setting Introduction:

If need multiple stitching at the left side of sewing direction, press ;


If need multiple stitching at the right side of sewing direction, press .

Needle Gauge:

The distance between nearby two stitching lines, from 0 to 20mm. Press Needle Gauge, the input box turns to yellow, use number keys to input desired needle gauge value.

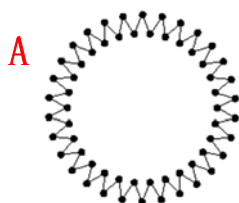
Frequency Setting:

The frequency of multiple stitching, from 2 to 50 times. Press Frequency, the input box turns to yellow, use number keys to input desired frequency value.





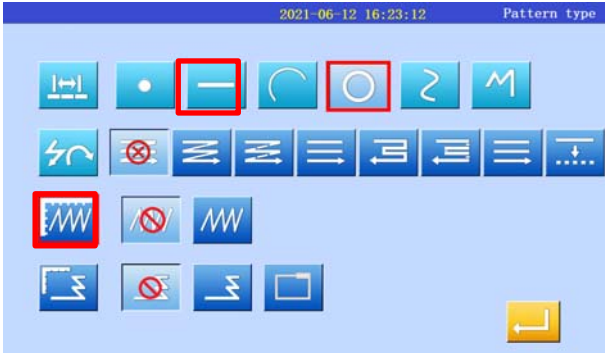




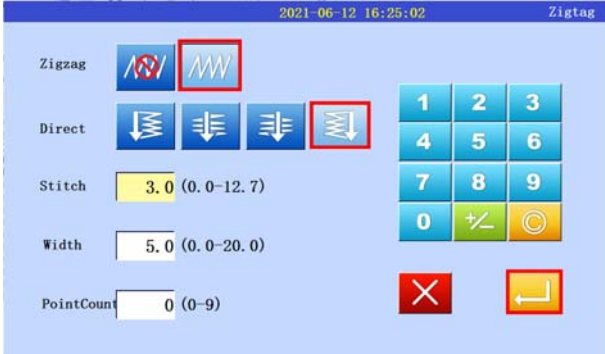
【Notes】 Press  in the cursor input interface, it directly expands the multi-stitch input interface.



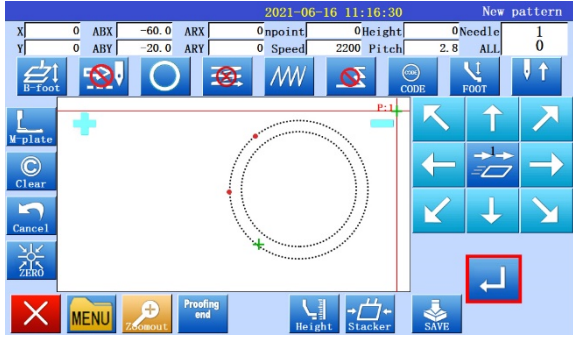




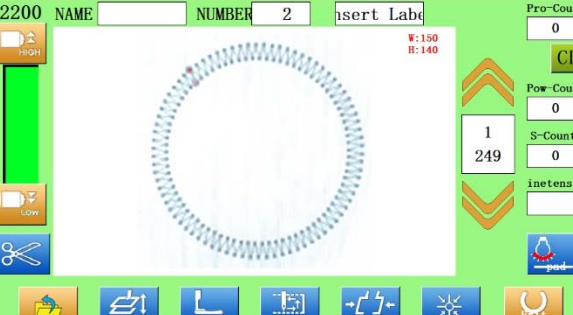
4.2 Zig Zag

【e.g.】 Create a circle by zig zag stitching (zig zag width: 5mm, stitch length: 3mm)

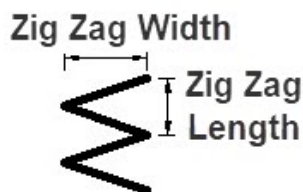


Instructions:

<p>4.2.1 Sewing type setting:</p> <ol style="list-style-type: none"> 1) Enter New Pattern Make Interface, move carrier clamp to make start point A under need  press to confirm the stitching routine from zero point to start point A. The  press to enter Sewing Shape Setting; 2) Press  to select circle shape; 3) Press  to enter multiple stitching setting interface; 	
<p>4.2.2 Zig zag stitching setting:</p> <ol style="list-style-type: none"> 1) Press , set stitch length 3mm, zig zag width 5mm; 2) Press  to set right side of stitch; 3) Press  back to Stitching Shape; 4) Press  back to New Pattern. 	

<p>4.2.3 Pattern creation:</p> <ol style="list-style-type: none"> 1) Move any point (on circle) under needle, press  to confirm; 2) Move another any point (on circle) under needle, press  to confirm; 	
<p>4.2.4 Double check:</p> <ol style="list-style-type: none"> 1) Press  to save the pattern; press  to save and return to Sewing Interface. 2) Press  and  to check the stitching pattern. 	

Zig Zag Width and Stitch Length Setting:



Press zig zag Stitch Length and Width, the input box turns to yellow, use number keys to input desired value.

Zig Zag Position Setting:



: Zig zag at the left side of sewing direction;




: Sewing direction line in center, zig zag starts;



: Sewing direction line in center, zig zag starts from right side, stitches to right side;


























: Zig zag at the right side of sewing direction;

【Notes】 Press  in the cursor input interface, it directly expands the zig zag stitch input interface.





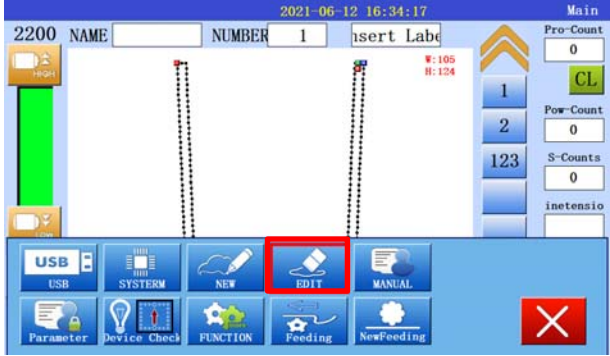

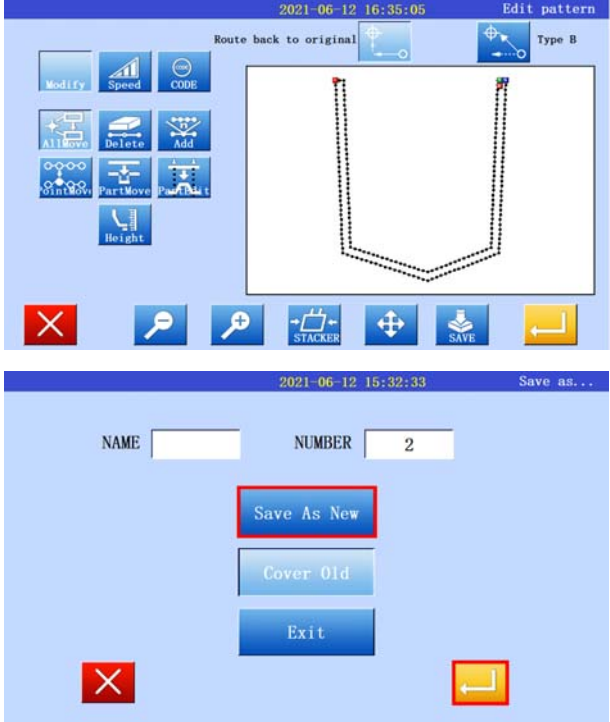
5、 Edit Pattern

The following table shows the main functions of pattern modification:

Function	Icon	Content	Description
Stitch modification 		Take the movement of the specified point as a reference for overall movement	
		Delete the specified stitch	 : the stitches between two points  : All stitches after the point
		Add stitches at the specified position	
		Modify the position of the specified stitch	 : The following stitches remain unchanged after moving the point  : Follow the change after moving the point
		Move the stitch position within the specified range	 : Do not add stitches after modification  : Add stitches after modification
		Move straight line, polygon, curve, zig zag movement between two specified points	
		Modify the presser foot height between the specified 2 points	 : Height of presser foot between two points  : Height of presser foot after specified point
Stitch speed 			 : Speed between two points  : Speed after specified point
Code data 		Add code at specified point	
		Delete code at specified point	


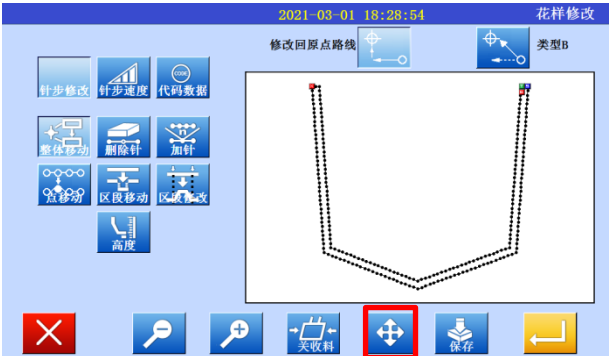
5.1 Enter And Exit Edit Pattern Mode

Instructions:



<p>5.1.1 Enter the Edit Pattern mode:</p> <p>1) In Main Interface, press  and  to pattern, then press  ;</p> <p>2) Press  to enter the Edit Pattern mode;</p>	
<p>5.1.2 Quit the Edit Pattern mode:</p> <p>1) Press  to enter Saving Interface;</p> <p>2) In Saving Interface, press Save As New to save as a new pattern file; press Cover Old to cover original pattern file; press Exit to quit without pattern modification saving.</p>	



5.2 Viewing Patterns

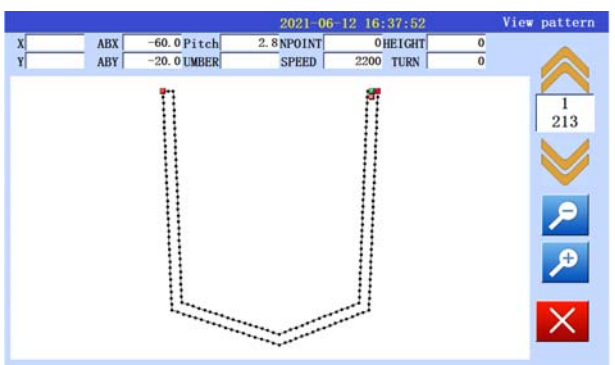
Instructions:

<p>1) In Edit Pattern Interface, press  to view pattern;</p>	
---	--

2) In this interface, carrier will not move, the parameter bar displays the current stitch information;

3) press  and  to move stitches



4) Press  and  to zoon in/out;








5.3 Overall Moving

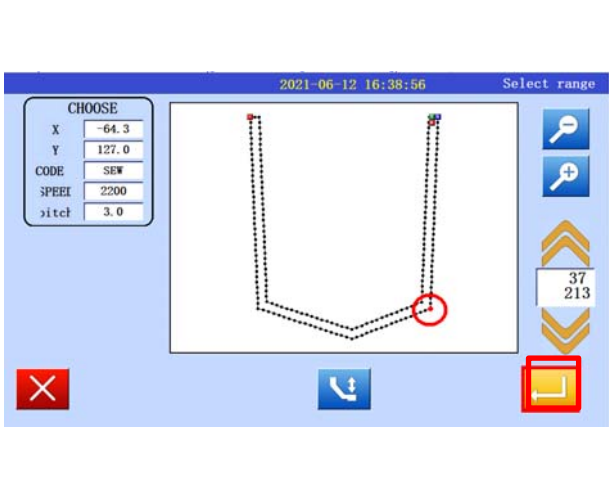
【e.g.】 Pattern overall moving as follows
Instructions:

5.3.1 Enter Overall movement interface:

1) In Edit Pattern Interface, press  and press  ;

2) Use  and  to move to specified stitch position, then press  to confirm;


3) Press  and  to zoon in/out;






CHOOSE	
X	-64.3
Y	127.0
CODE	SEW
SPEED	2200
stitch	3.0


5.3.2 Sampling:


1) Press the arrow keys to move the selected reference red point to specified position;

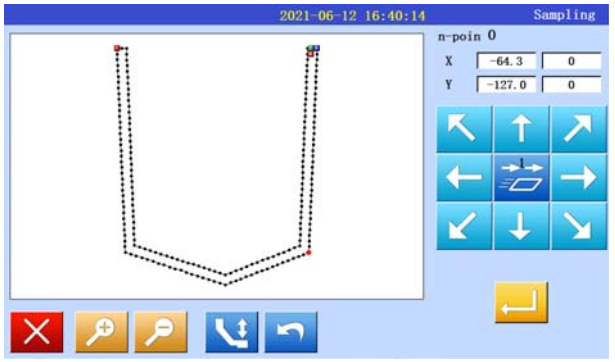
2) Press  can cancel the last move;

3) Press  and  to zoon in/out;

Press  make presser foot up and down;

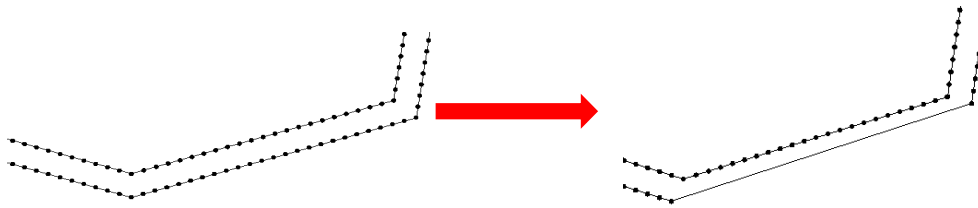
4) After overall moving, press  to confirm and back to Edit Pattern Interface;

5) Press  to save and quit.




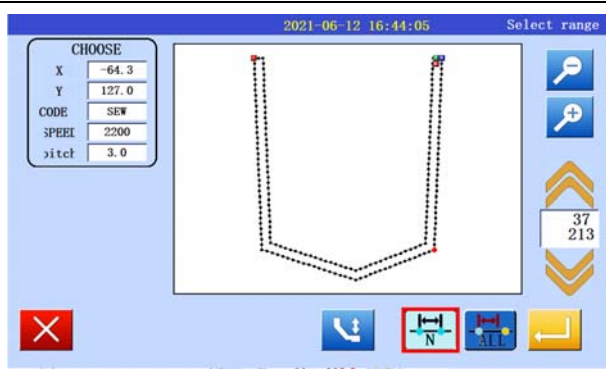










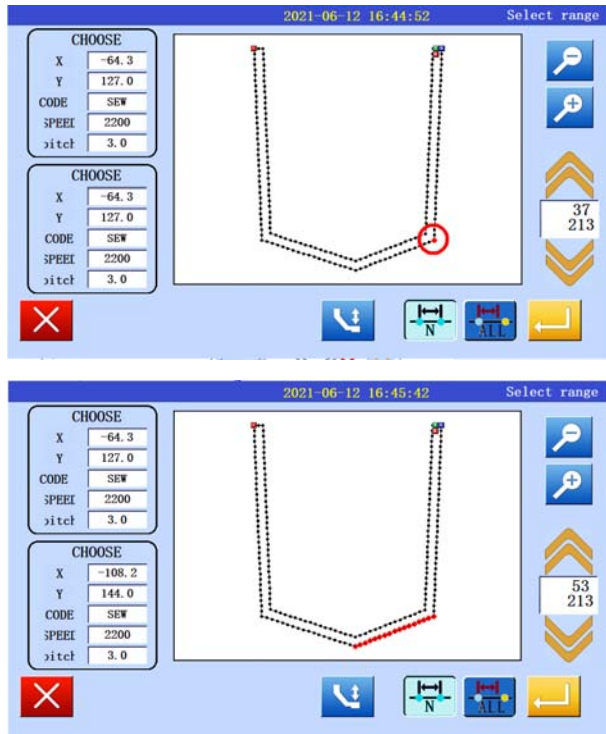


5.4 Delete Stitches

【e.g.】 Delete stitches as following:

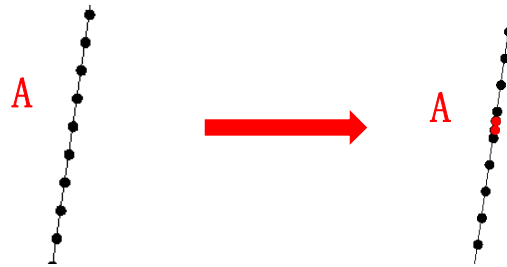


Instructions:






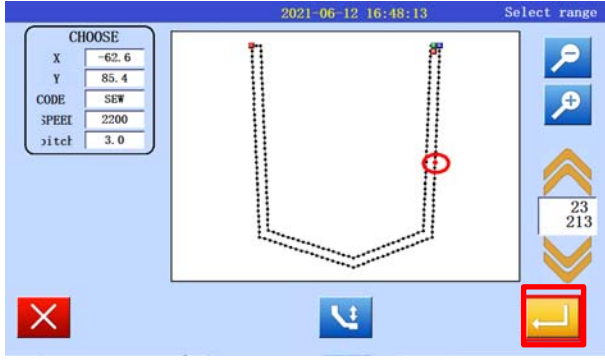






<p>5.4.1 Enter Stitch Delete Interface:</p> <p>1) In Edit Pattern Interface, press  and press ;</p> <p>2) Check  is selected;</p>	
<p>5.4.2 Sampling:</p> <p>1) Press  and  to zoom in/out;</p> <p>2) Press  make presser foot up and down;</p> <p>3) Use  and  to move to the start of deleting stitches, then press  to confirm;</p> <p>4) Use  and  to move to the end of deleting stitches, the deleting stitch area changes to red;</p> <p>5) Press  to delete the specified stitches and back to Edit Pattern Interface;</p> <p>6) Press  to save and quit.</p>	

5.5 Add Stitches

【e.g.】 Add 2 stitches behind Point A as following:

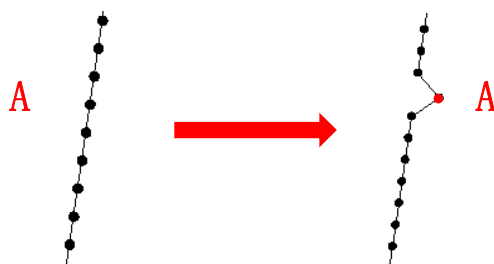


Instructions:




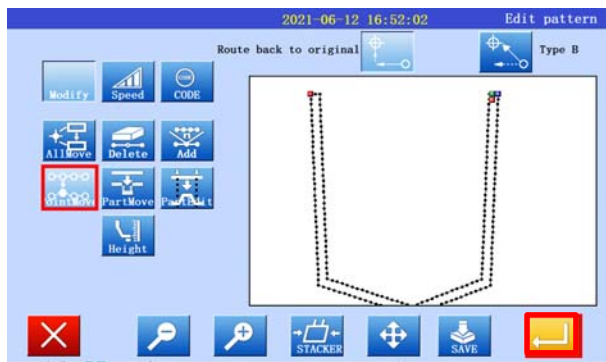











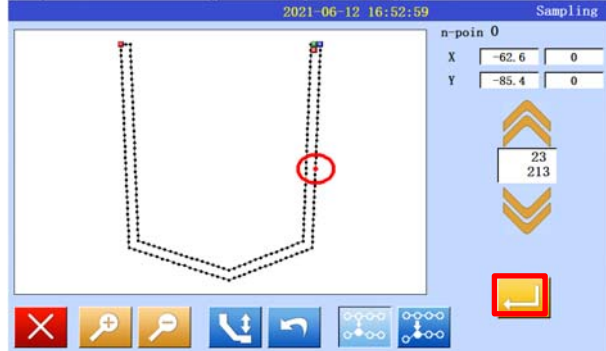
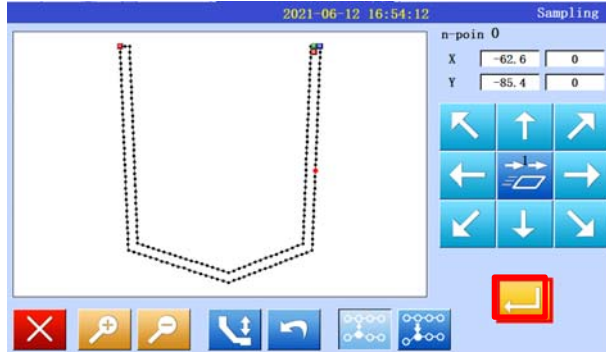
<p>5.5.1 Enter Add Stitches Interface:</p> <p>1) In Edit Pattern Interface, press  and press ;</p> <p>2) Press  and  to zoom in/out;</p> <p>3) Press  make presser foot up and down;</p>	
<p>5.5.2 Sampling:</p> <p>1) Use  and  to move to the specified stitch, then press  to confirm;</p> <p>2) Enter Add Stitches Interface, input 2 stitches, press  to confirm add stitches and back to back to Edit Pattern Interface;</p> <p>3) Press  to save and quit.</p>	

5.6 Point Moving (only move specified point)

【e.g.】 Move point A as following:

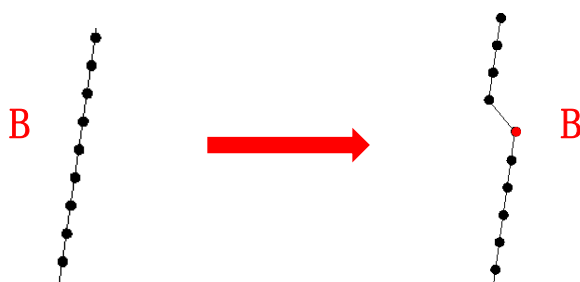


Instructions:




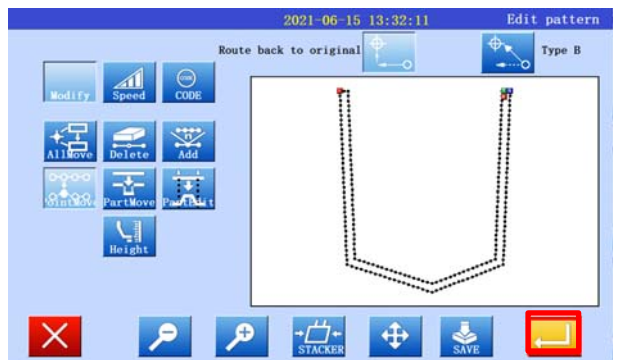











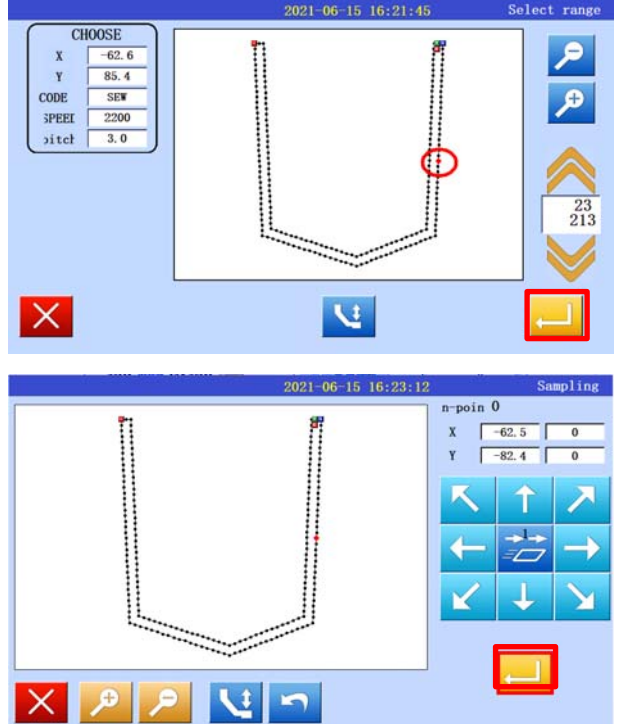
<p>5.6.1 Enter Point Move Interface:</p> <p>1) In Edit Pattern Interface, press  and press ;</p> <p>2) Press ;</p>	
<p>5.6.2 Sampling:</p> <p>1) Press  and  to zoom in/out;</p> <p>2) Press  make presser foot up and down;</p> <p>3) Use  and  to move to the specified stitch, then press  to confirm;</p> <p>4) Use  and  to move the point to specified position, Press  can cancel the last move;</p> <p>5) Press  to confirm and back to Edit Pattern Interface;</p> <p>6) Press  to save and quit.</p>	 

5.7 Point Moving (Move all the stitches start from specified point)

【e.g.】 Move point B, all the stitches start from point B will follow the moving:

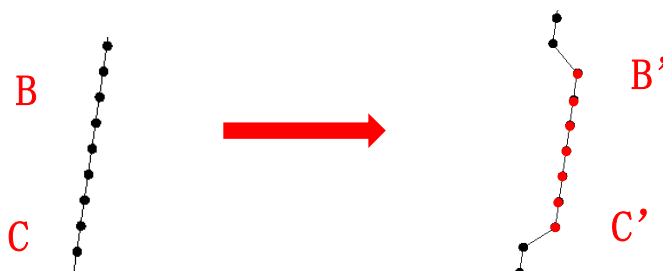


Instructions:

<p>5.7.1 Enter Point Move Interface:</p> <p>1) In Edit Pattern Interface, press  and press ;</p> <p>2) Press  ;</p>	
<p>5.7.2 Sampling:</p> <p>1) Press  and  to zoon in/out;</p> <p>2) Press  make presser foot up and down;</p> <p>3) Use  and  to move to the specified stitch, then press  to confirm;</p> <p>4) Use  and  to move the point to specified position, press  can cancel the last move;</p> <p>5) Press  to confirm and back to Edit Pattern Interface;</p> <p>6) Press  to save and quit.</p>	



5.8 Area Moving (only move the specified area)

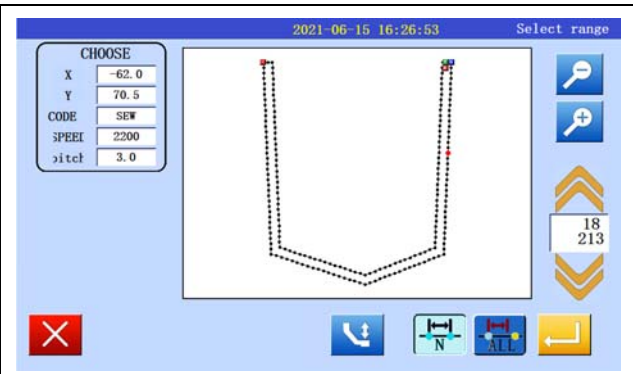
【e.g.】 Move Area B-C move to B' - C' , the other stitches will not change.















Instructions:

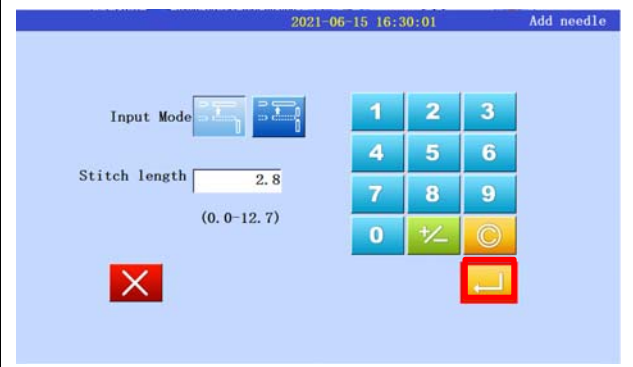
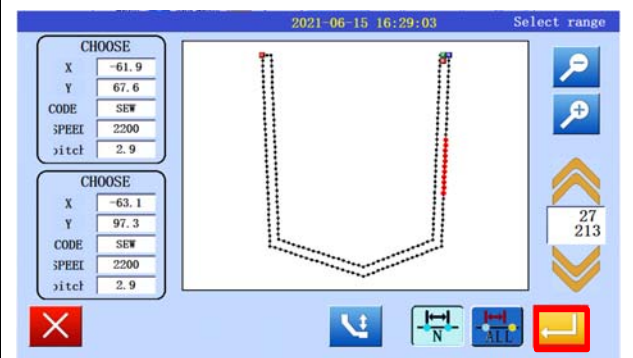
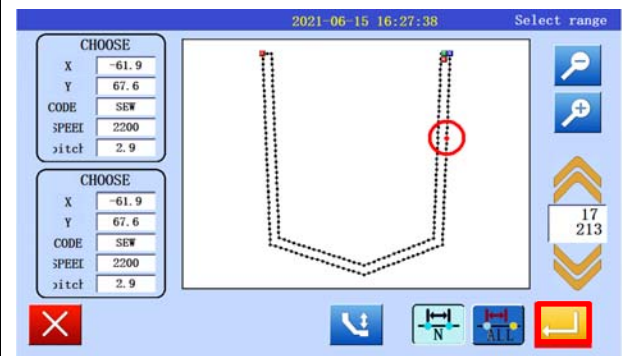
5.8.1 Entering Area Moving Interface:

In Edit Pattern Interface, press  and press ;



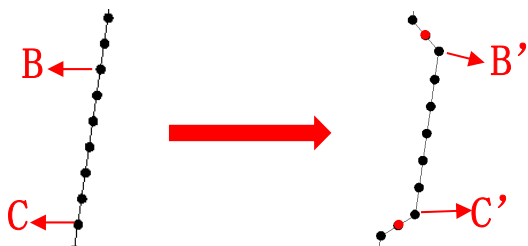
5.8.2 Sampling:

- 1) Press  and  to zoom in/out;
- 2) Press  make presser foot up and down;
- 3) Use  and  to move to the start stitch of specified area, then press  to confirm;
- 4) Use  and  to move to the end of specified area, the moving area changes to red, press ;
- 5) Press , input stitch length, press  to confirm and back to Edit Pattern Interface;
- 6) Press  to save and quit.

















5.9 Area Moving (will add stitches before and after the moving area)

【e.g.】 Move Area B-C move to B' - C' , add stitches before and after B' - C' .

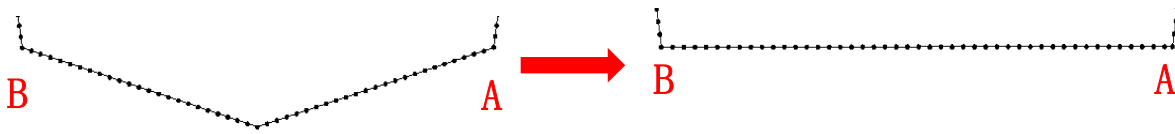


Instructions:

<p>5.9.1 Entering Area Moving Interface:</p> <p>In Edit Pattern Interface, press  and press ;</p>	
<p>5.9.2 Sampling:</p> <ol style="list-style-type: none"> 1) Press  and  to zoon in/out; 2) Press  make presser foot up and down; 3) Use  and  to move to the start stitch of specified area, then press  to confirm; 4) Use  and  to move to the end of specified area, the moving area changes to red, press ; 5) Press , input stitch length, press  to confirm and back to Edit Pattern Interface; 6) Press  to save and quit. 	

5.10 Area Modification (change to straight line)

【e.g.】 Change A-B into straight line.



Instructions:

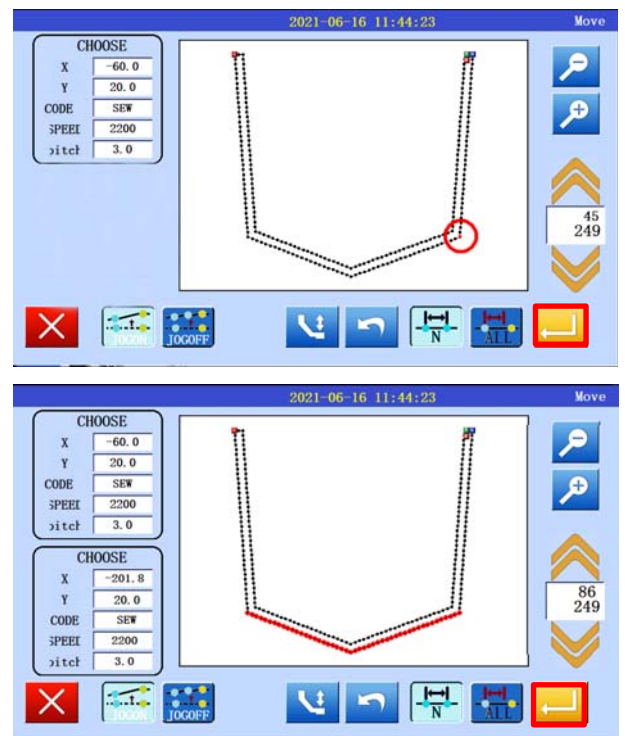
5.10.1 Entering Area Modification Interface:

- 1) In Edit Pattern Interface, press and press ;
- 2) Select for straight line, input stitch length, press ;







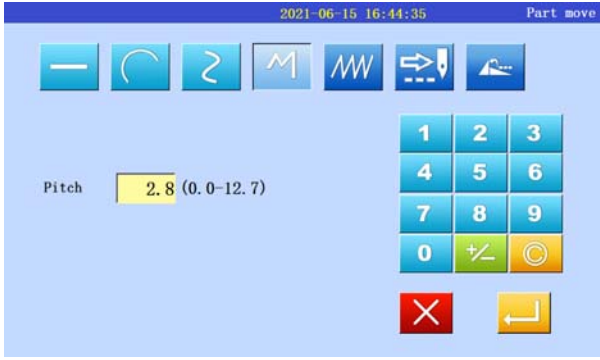








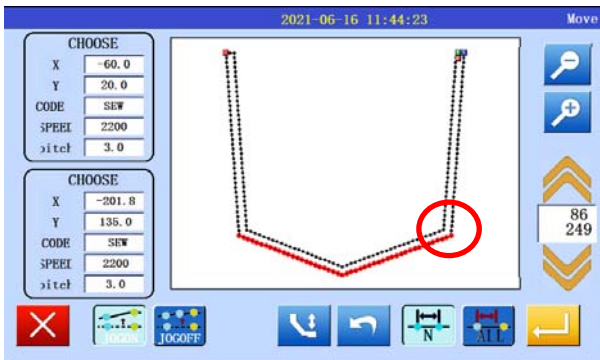








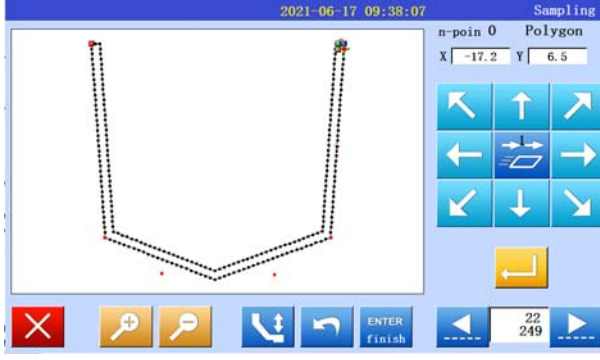
5.10.2 Sampling:


- 1) Press and to zoom in/out;
- 2) Press make presser foot up and down;
- 3) Use and to move to the start stitch of specified area, then press to confirm;
- 4) Use and to move to the end of specified area, the specified area changes to red, press to confirm and back to Edit Pattern Interface;
- 5) Press to save and quit.





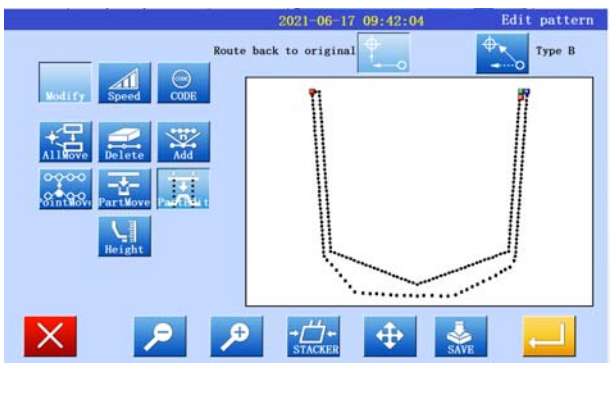
5.11 Area Modification (change to curve line / polygon)

Instructions:

<p>5.11.1 Entering Area Modification Interface:</p> <ol style="list-style-type: none"> 1) In Edit Pattern Interface, press  and press ; 2) Change to polygon, select , input stitch length; 3) Press  to confirm. 	
<p>5.11.2 Specify the area:</p> <ol style="list-style-type: none"> 1) Use  and  to move to the start stitch of specified area, then press  to confirm; 2) Use  and  to move to the end of specified area, the specified area changes to red, press ; 3) Press  and  to zoon in/out; 	
<p>5.11.3 Move to specified position:</p> <ol style="list-style-type: none"> 1) Press  and  to zoon in/out; 2) Use  and  to move the red pointer to the stitch point which will be moved, the area start point “S” and end point “E” can not move; 3) Use arrow keys to move the selected point the specified position, press  to confirm; 4) Again use  and  to move red pointer to the stitch point which will be moved; 5) Use arrow keys to move the selected point the specified position, press  to confirm; 	

6) Repeat step-2) to 5) , until finish all the point movement; press  , the moved points will be connected by straight lines;

7) Press  to confirm and back to Edit Pattern Interface, press  to save and quit.





5.12 Area Modification (change to zig zag)



【e.g.】 Change straight line to zigzag.




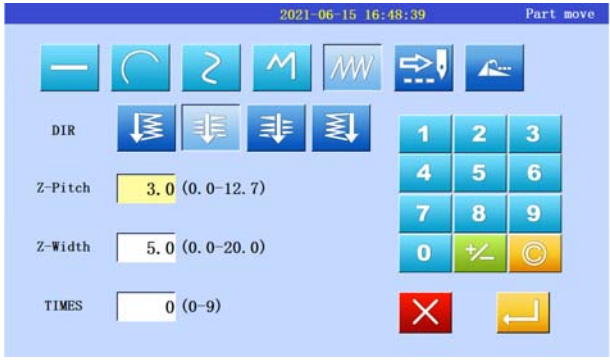
Instructions:

5.12.1 Entering Area Modification Interface:



1) In Edit Pattern Interface, press  and press ;




2) Select  , then press  , input stitch length 3.0, width 5.0;




3) Press  to confirm;




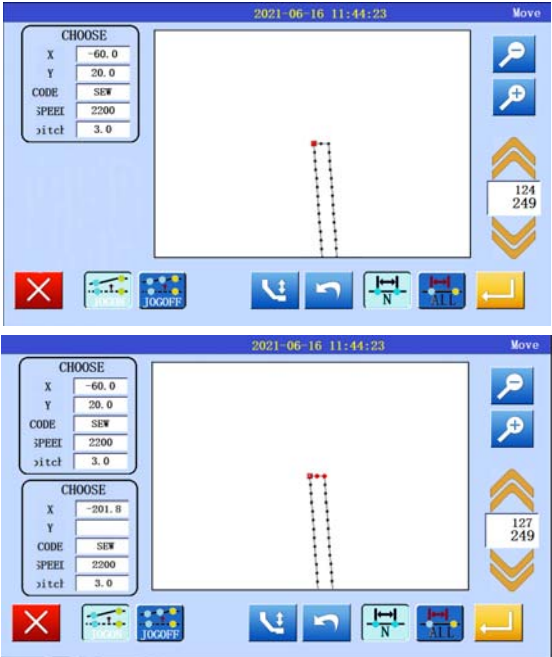
5.12.2 Sampling:

1) Press  and  to zoon in/out;

2) Use  and  to move to the start stitch of specified area, then press  to confirm;

3) Use  and  to move to the end of specified area, the specified area changes to red, press  to confirm and back to Edit Pattern Interface;



4) Press  to save and quit.

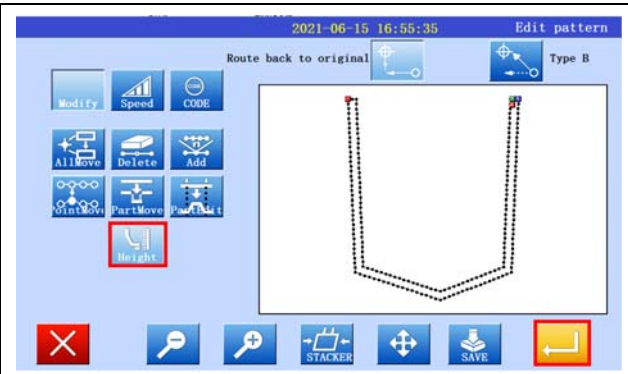


5.13 Presser Foot Height Setting











Instructions:

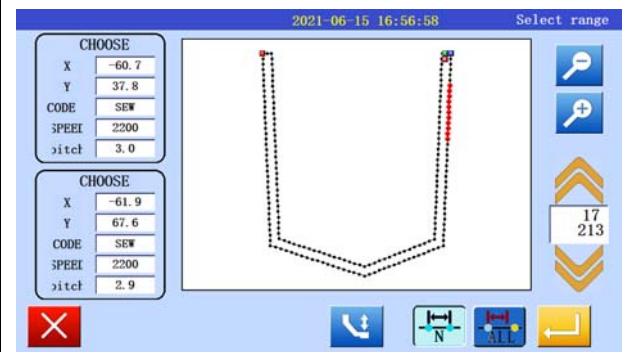
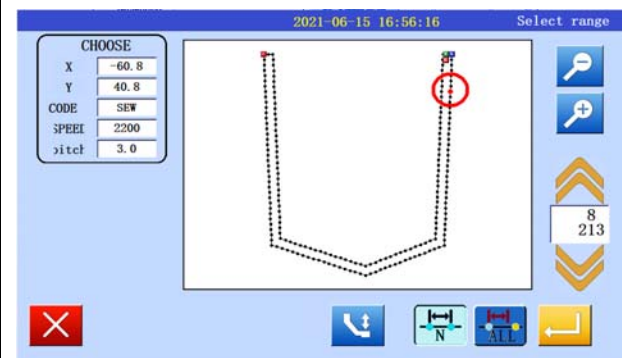
5.13.1 Entering Presser Foot Height Interface:

- 1) In Edit Pattern Interface, press  and press ;



5.13.2 Sampling:

- 1) Press  and  to zoom in/out;
- 2) Use  and  to move to the start stitch of specified area, then press  to confirm;
- 3) Use  and  to move to the end of specified area, the specified area changes to red, press  to confirm;
- 4) In Presser Foot Height Interface, Input required value, press  to confirm and back to Edit Pattern Interface;
- 5) Press  to save and quit.





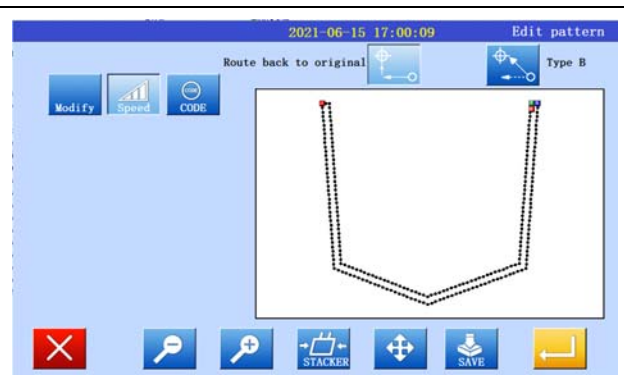
5.14 Sewing Speed Modification (with an area)

Description: Change the sewing speed of a certain area, such as the pattern corner speed.












Instructions:

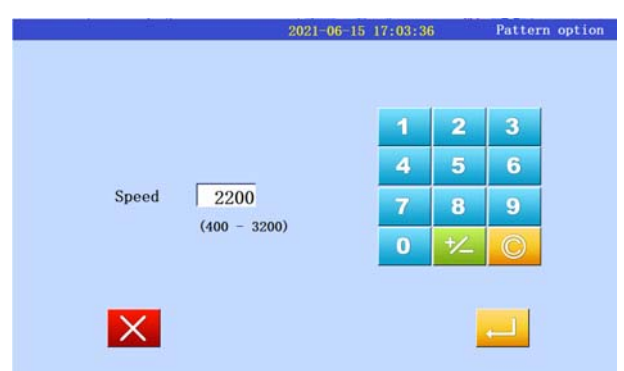
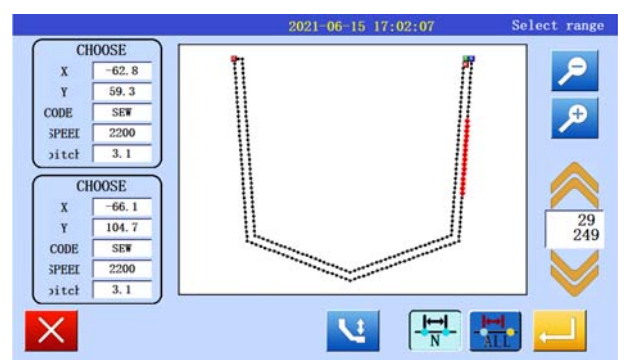
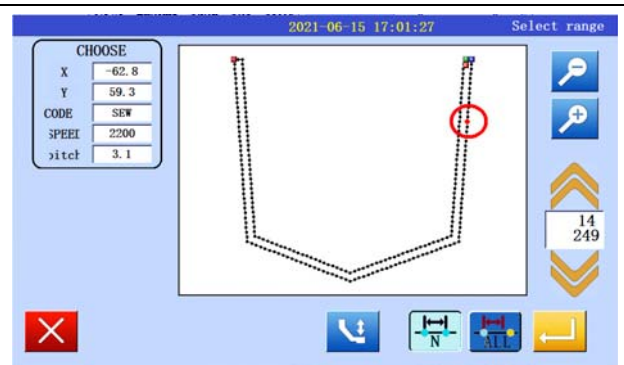
5.14.1 Entering Stitch Step Speed Interface:

In Edit Pattern Interface, press  and press ;



5.14.2 Sampling:












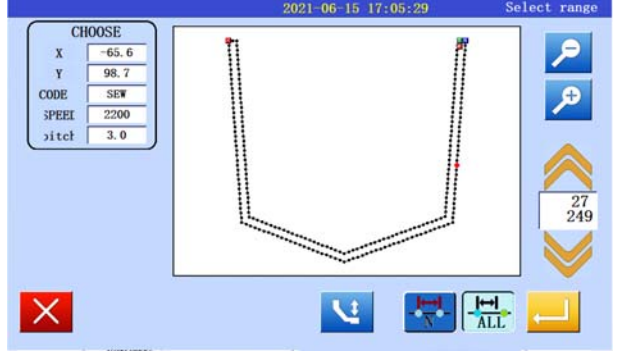

- 1) Press  and  to zoon in/out;
- 2) Press  ;
- 3) Use  and  to move to the start stitch of specified area, then press  to confirm;
- 4) Use  and  to move to the end of specified area, the specified area changes to red, press  to confirm;
- 5) In Speed Setting Interface, input 2200 , press  to confirm and back to Edit Pattern Interface;
- 6) Press  to save and quit.



5.15 Sewing Speed Modification (change speed start from specified point)

Description: When a point is selected, all stitches after this point will change the speed.

Instructions:




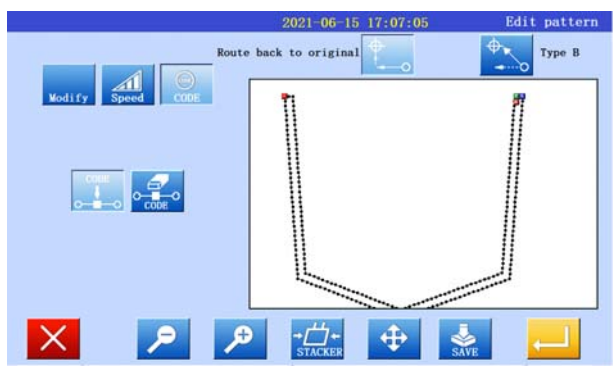





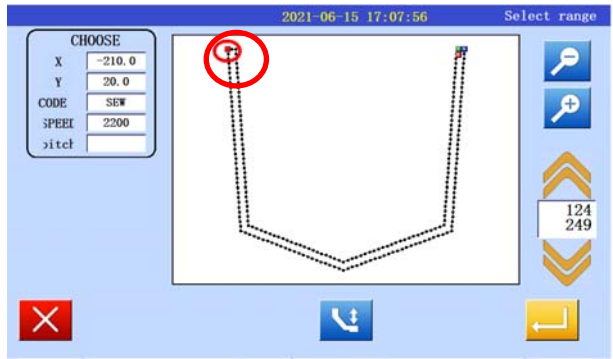




<p>1、 Entering Stich Step Speed Interface: In Edit Pattern Interface, press  and press ;</p>	
<p>2、 Sampling: 1) Press  and  to zoon in/out; 2) Press  ; 3) Use  and  to move to the start stitch of speed changing, then press  to confirm; 4) In Speed Setting Interface, input 2200 , Press  to confirm and back to Edit Pattern Interface; 5) Press  to save and quit.</p>	 

5.16 Feature Code Modification (add feature code)

【e.g.】 When start the inner sewing, add a feature code for inner clamp retraction.



Instructions:

<p>5.16.1 Entering Feature Code Interface:</p> <p>In Edit Pattern Interface, press ,</p> <p>then press , and press  ;</p>													
<p>5.16.2 Specify the modification point:</p> <p>1) Press  and  to zoom in/out;</p> <p>2) Use  and  to move to the point where need to add a feature code</p> <p>3) Press  to confirm;</p>	 <table border="1" data-bbox="799 607 927 734"> <tr><th colspan="2">CHOOSE</th></tr> <tr><td>X</td><td>-210.0</td></tr> <tr><td>Y</td><td>20.0</td></tr> <tr><td>CODE</td><td>SEW</td></tr> <tr><td>SPEED</td><td>2200</td></tr> <tr><td>stitch</td><td></td></tr> </table>	CHOOSE		X	-210.0	Y	20.0	CODE	SEW	SPEED	2200	stitch	
CHOOSE													
X	-210.0												
Y	20.0												
CODE	SEW												
SPEED	2200												
stitch													
<p>5.16.3 Add a feature code:</p> <p>1) In Feature Code Interface, press , then press  to confirm and back to Edit Pattern Interface;</p> <p>2) Press  to save and quit.</p>													




5.17 Feature Code Modification (delete feature code)

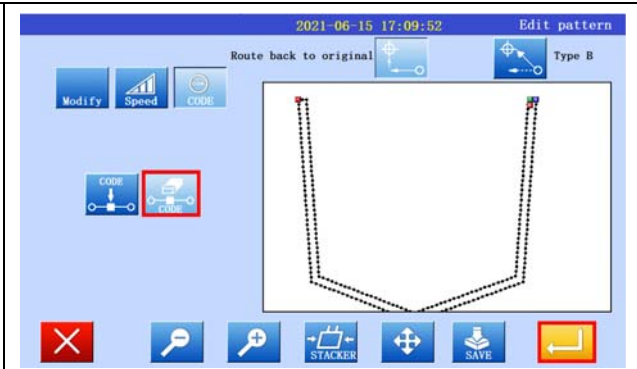
【e.g.】 Delete the feature code for inner clamp retraction as following:









Instructions:

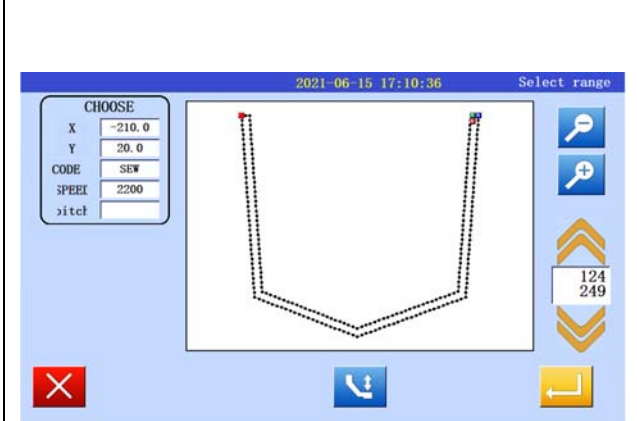
5.17.1 Entering Feature Code Interface:

In Edit Pattern Interface, press ,
 then press , and press  ;



5.18.1 Specify the modification point and delete the feature code:

- 1) Press  and  to zoom in/out;
- 2) Use  and  to move to the feature code point, then press  to delete and back to Edit Pattern Interface;
- 3) Press  to save and quit.





关注威比玛微信公众号



VBM Official Account

意大利威比玛公司

Italy company : VI.BE.MAC s.p.a

意大利维罗纳省乔瓦尼卢帕托托市蒙特帕斯特罗7/i号
37057 S.Giovanni Lupatoto(VR),Italy-Via Monte Pastello 7/i
电话/TEL : +39 045 8778151/52
传真/FAX : +39 045 8779024
网址/HTTP : www.vibemac.com
邮箱/E-mail : sales@vbm-grp.com customercare@vbm-grp.com

浙江威比玛智能缝制科技有限公司

Company: Zhejiang VI.BE.MAC. Smart Sewing Technology Co., LTD.

浙江省台州市椒江区三甲东海大道东段1008号
No. 1008 East Donghai Avenue, Jiaojiang District, Taizhou City, Zhejiang Province
电话/TEL : 0086-0576-89086118
网址/HTTP : www.vibemac.com
邮箱/E-mail : sales@vbm-cn.com