











Safety Precautions














1、 The sign and meaning of safe operation



The safety signs used in this instruction manual and products are intended to allow you to use the product correctly and safely to prevent you and others from being injured. The pattern and meaning of the logo are as follows:

 危険	If you ignore this mark and carry out wrong operation, it will cause serious injury or death.
 注意	If you ignore this mark and carry out wrong operation, it will cause personal injury and equipment damage.
	This symbol means "Precautions". The pattern in the triangle indicates what must be paid attention to. (For example, the image on the left means "Beware of injury")
	This symbol means "Forbidden"
	This symbol means "must". The pattern in the circle indicates what must be done. (For example, the figure on the left indicates "must be grounded")

2、 Safety Precautions

 危険	
	When opening the electric control box, first turn off the power switch and unplug the power plug from the socket, wait at least 5 minutes, and then open the control box cover. Touching areas with high voltage can cause personal injury.
 注意	
Using environment	
	Avoid using this sewing machine near strong electrical interference sources (such as high-frequency welding machines). Strong electrical interference sources may affect the normal operation of the sewing machine.
	The fluctuation of the power supply voltage should be used in an environment within $\pm 10\%$ of the rated voltage. Large voltage fluctuations will affect the normal operation of the sewing machine, and a voltage regulator is required.

	The ambient temperature should be used within the range of 0 °C 50 °C. Low or high temperature will affect the normal operation of the sewing machine.
	The relative humidity should be within the range of 35% to 85%, and the device will not be used in an environment where condensation will form. Dry, humid, or condensed environments can affect the correct operation of the sewing machine.
	The compressed air supply should be greater than the total air consumption required by the sewing machine. Insufficient compressed air supply will cause the sewing machine to operate abnormally.
	In the event of a thunderstorm, turn off the power switch and unplug the power plug from the outlet. Lightning may affect the correct operation of the sewing machine.
Installation	
	Please have a trained technician install the machine.
	Do not connect power and air pressure until the installation is complete. If the start switch is pressed by mistake, the machine action may cause injury.
	When disassembling or moving the machine, please operate with both hands. Do not press hard on the machine. If the machine loses its balance, it may fall over to the ground and cause injury or damage.
	Must be grounded. The ground wire is not secure, which is the cause of electric shock or malfunction.
	All cables should be fixed at least 25mm away from moving parts. In addition, do not bend it too much or fix it too tightly with staples. May cause fire or electric shock.
Sewing	
	This sewing machine is limited to use by personnel who have received training in safe operation.
	During the sewing process, do not touch any moving parts or lean objects on the moving parts, as this may cause personal injury or damage to the sewing machine.
	If a malfunction occurs during operation of the sewing machine, or if abnormal noises or smells are heard, immediately turn off the power. Then please contact the purchase store or a trained technician.
Maintenance and inspection	
	When the following conditions occur, turn off the power and unplug the power plug. Otherwise, accidentally pressing the start switch may cause injury.

	1. Inspection, adjustment and maintenance 2. Replace needles, cutters and other vulnerable parts
	When you must connect the power switch and air source switch for adjustment, you must be very careful to observe all safety precautions.
	Sewing machine damage caused by unauthorized modification of the sewing machine is not covered by the warranty.

Manual

1. Overview.....	1
1.1 Technical parameter table.....	1
1.2 Host name.....	2
2. Transportation and installation	3
2.1 Lifting and transportation	3
2.2 Loading and unloading	3
2.3 Installation	3
3. Preparation before sewing	5
4. Preparation of head pattern	6
4.1 Enter the pattern editing interface	6
4.2 Setting the second origin for pattern editing	7
4.3 Pattern editing and setting of sewing stitches	8
5. Leading control system	11
5.1 Sewing data input interface	11
5.2 Sewing interface	12
5.3 Pattern browsing	13
5.4 New pattern	13
5.5 Copying patterns	14
5.6 Tag parameter setting	15
5.7 Standard test mode	16
5.8 Program Information Interface	16
5.9 Pattern parameter file transmission	17
5.10 Settings page	17
5.11 Machine parameter 1 setting	18
5.12 Alarm history page	19
5.13 Machine parameter 2 settings	19
5.14 Factory reset	19
5.15 Diagnostic mode	20
5.16 Chinese and English settings.....	20
5.17 Counting information display.....	20
6. Adjustment	21
6.1 Replacement of the label and process flow of the process equipment	21
6.2 Photoelectric sensor adjustment	24
6.3 Fiber amplifier adjustment.....	25
6.5 Proximity switch adjustment	27
6.6 Air pressure detection adjustment	28
6.7 Pressure regulator adjustment	28
7. Maintenance	29
8. Troubleshooting	30
9 List of remaining parts	30
9.1 Conveyor.....	32
9.2 Feeding device	35

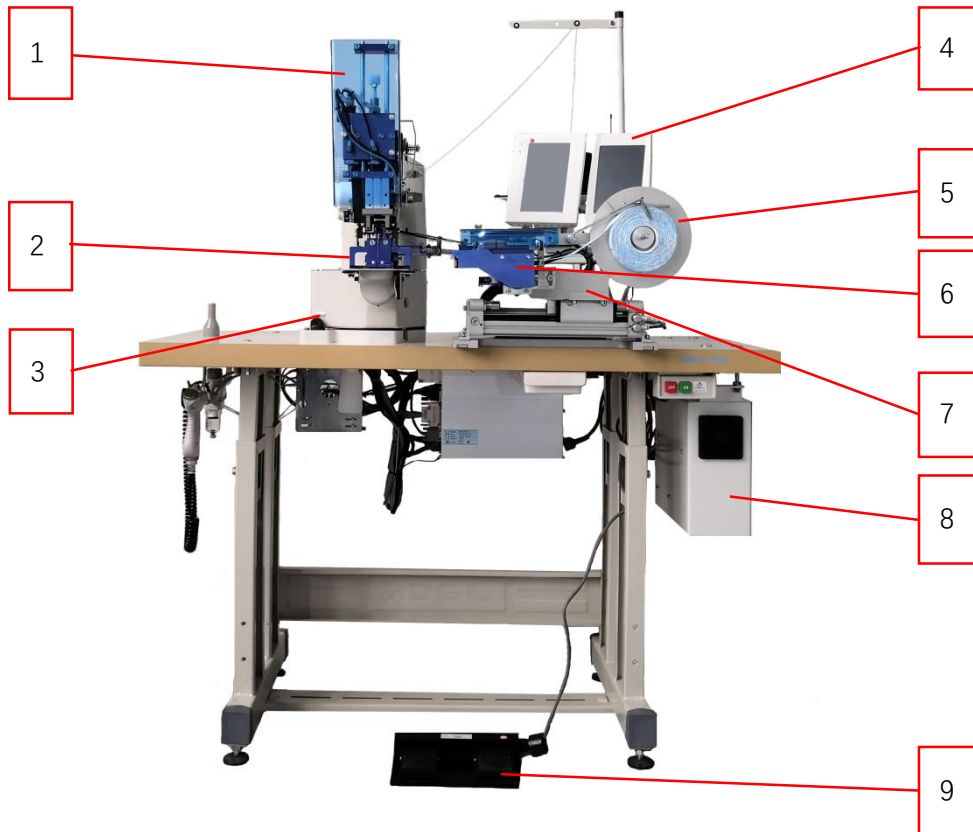
9.3 Support device	36
9.4 Presser foot mechanism.....	38
9.5 Folding mechanism	40
9.6 Operation screen device	44
9.7 Head and platen parts	46

1.Draft

1.1 Technical Data Sheet

No.	Name	Parameters
1	Max sewing speed	2300rpm/min
2	Sewing area	XY:60mmx40mm
3	Stitch length	0.1mm-10mm(0.1mm 单位)
4	Storage capacity	In total 20000 stitches, max 2000 needle per piece
5	Standard pattern number	100 kinds
6	Memorable data	200 type patterns
7	Zoom in and out	20-200% (1% unit) in X direction and Y direction respectively
8	Motor	550W servo motor
9	Power and voltage	220VAC ±10%, 50-60Hz
10	Air supply	≥0.4Mpa
11	Using temperature	0°C-50°C
12	Label size	The maximum distance of sewing stitches on both sides is 60mm, and the maximum length of one side sewing is 40mm
13	Machine configuration	One label on the right side
14	Machine size	1200mm×710mm×1600mm
15	Machine weight	Around 100kg
16	Sewing mode	1.full automatic 2.semi automatic 3.manual mode 4.testing mode

1.2 Name of parts



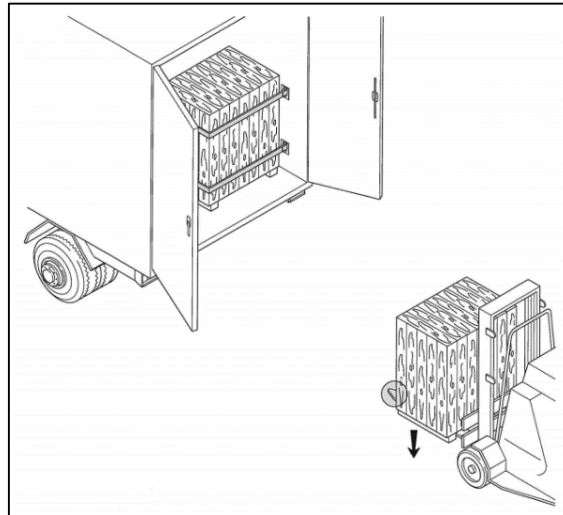
- ① Presser foot construction
- ② Folding device
- ③ Sewing head
- ④ Monitor
- ⑤ Label feeding device
- ⑥ Feeding device
- ⑦ Supporting device
- ⑧ Control box
- ⑨ Foot pedal

2. Transportation and installation

2.1 Lifting and transportation

The machine must be packed and transported. When lifting, check whether the load capacity of the forklift's bay can bear the weight of the machine.

When the machine is placed on trucks and vans, it must be secured with ropes or belts.



F.2.1 transport

2.2 Load and unload

When unloading, ensure that the forklift's bay can bear the full weight of the machine.

When unpacking, check the machine for obvious damage during transportation. If there is damage, please do not use the machine and contact the manufacturer for disposal. Place the machine on a fixed, flat surface and do not expose it to the open air.

2.3 Installation

Note: The machine must only be installed by professionals.

The manufacturer is not responsible for any property or personal damage caused by incorrectly installed machinery. These installation errors are mainly due to non-compliance with instructions and failure to meet the connection requirements of the main parts.

⚠ If the machine is mounted on a suspended surface, check whether the surface can bear the weight of the machine.

There must be no flammable or explosive materials or objects in the area where the machine is located.

It is mandatory to leave a space of 0.5 meters around the machine to operate and maintain the machine.

The machine must be placed on a hard and flat surface. Turn the nut "A" of the foot (Figure 2.2) to adjust the balance of the machine.

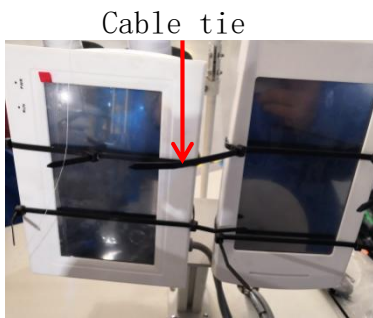


Figure 2.2 Foot

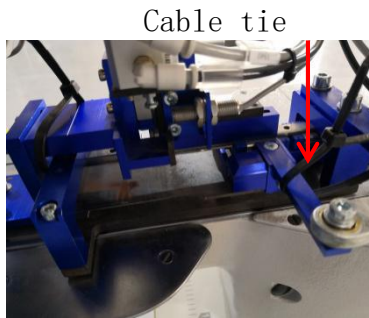
In order to make transportation more convenient, the movable part of the machine is tied and fixed by a cable tie.

Before use, please check:

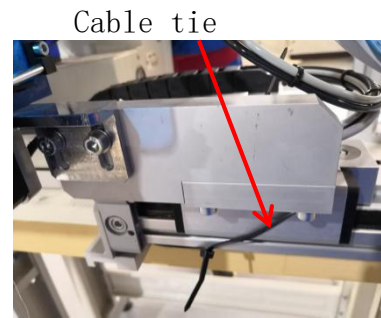
- The display screen is bound and fixed by a cable tie (Figure 2.3). Before use, remove the cable tie;
- The folding mechanism is fixed by a cable tie (Figure 2.4). Before use, remove the cable tie;
- The supporting device is fixed by a cable tie (figure 2.5). Before use, remove the cable tie;
- The presser foot mechanism is fixed by a cable tie (Figure 2.6) and (Figure 2.7). Before use, remove the cable tie;
- The wire rack is fixed by a cable tie (Figure 2.8). Before use, remove the cable tie;
- The trademark pressure plate is fixed by a cable tie (Figure 2.9). Before use, remove the cable tie;
- The pedal is fixed by a cable tie (Figure 2.10). Before use, remove the cable tie and place the pedal on the ground for convenient operation;
- Air gun, fixed by a cable tie (Figure 2.11), remove the cable tie before use;



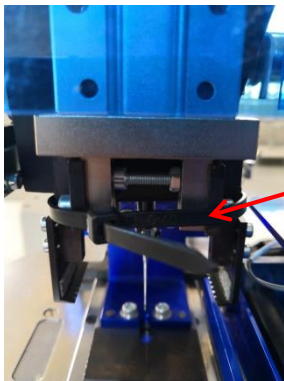
F.2.3



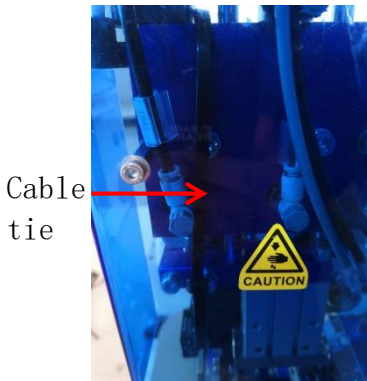
F.2.4



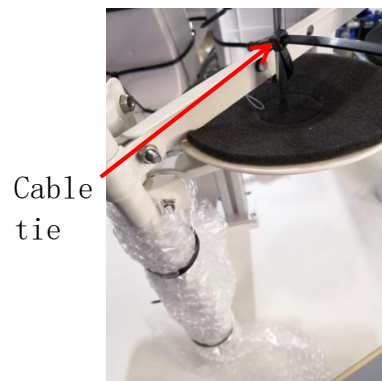
F.2.5



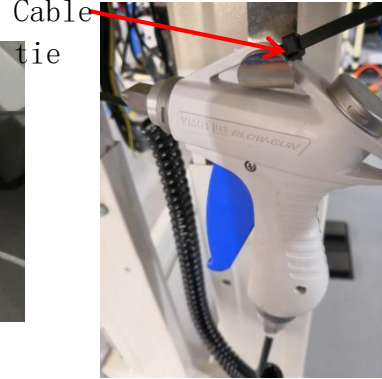
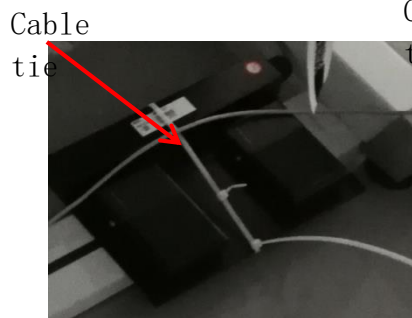
F.2.6



F.2.7



F.2.8

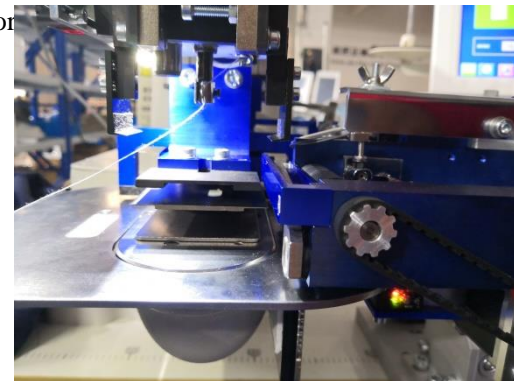


3.Preparation before sewing

After the initial installation of the machine in the factory is completed, it needs to be debugged by professionals according to the following steps to ensure the safety of operation and the effect of sewing:

- 1) Without opening the air source and power supply, manually push the rodless cylinder to the presser foot of the machine head to check whether there is interference between the conveyor and the folding mechanism (as shown in Figure 3.1). If there is interference, it must be referred by Adjustments are made in Chapter 6 of this manual. It is not allowed to power on and debug under interference. If there is no interference, proceed to the next step;

- 2) Check whether the organic needle has been installed, if not, the needle needs to be installed, the needle groove faces outward, and the needle handle needs to be installed to the end;
- 3) Turn on the power switch and the main air source switch, and confirm that the intake air pressure is 0.4MPa (4 standard atmospheric pressures);
- 4) Wait for the machine head operation panel to start and enter the initial work interface, then check whether the pattern displayed on the machine head control panel is a collar sewing pattern;
- 5) Switch the two control panels to the work preparation interface and wait for



4.Edit Sewing Pattern

The machine sews collar label by using bartacking machine, this manual book takes Jack Bartacking Machine 19006BS-D(touch screen) as an example, introduces how to edit sewing patterns according to the collar labels.

4.1 Enter Into Editing Interface

(1) After booting, without any operation, click the system setting button at A in the initial work main interface (see Figure 4.1.1) to enter the system setting interface (see Figure 4.1.2).

(2) On the system setting interface, click the pattern editing button at position B in the figure to enter the pattern editing confirmation interface (see Figure 4.1.3).

(3) After confirmation, enter the pattern editing interface (see Figure 4.1.4)

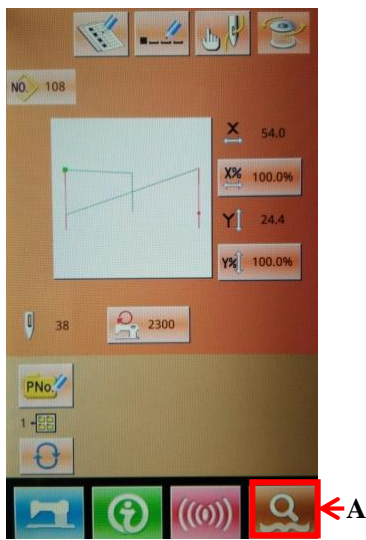


Figure 4.1.1 Main Interface

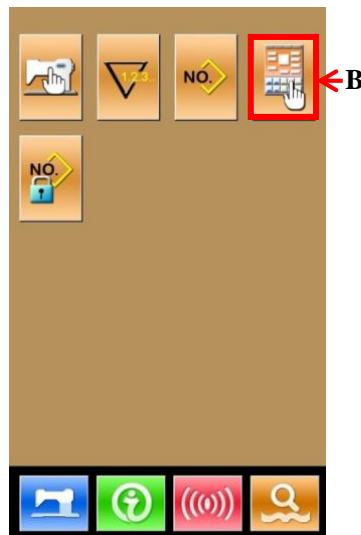


Figure 4.1.2 System Setting

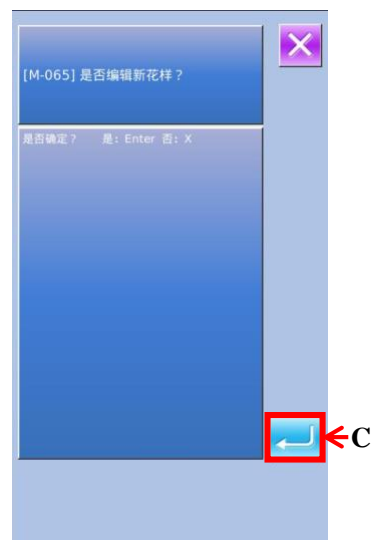


Figure 4.1.3 Patten Edit Entering



Figure 4.1.4 Editing Interface

4.2 Pattern editing to set the second zero point

(1) Empty Feed: Click the Empty Feed button at A in the pattern editing interface (see Figure 4.2.1) to enter a confirmation interface (see Figure 4.2.2), and click the "OK" button at C to enter the empty feed editing Interface (Figure 4.2.3).

(2) Set the coordinate point of the second zero point: move the position by the arrow button at E in the air feed editing interface, the coordinate display of the cursor movement at D, the first column is the absolute coordinates, the second column is the relative coordinates. Now send the cursor empty to the coordinate point (0, 15.5), click the OK button at F to complete the setting of the first empty coordinate, and stay at the set point.

(3) Set the second zero point: click the function list button at position B in the pattern editing interface (see Figure 4.2.1), and click the "second zero point" function at position G in the function list (see Figure 4.2.4) Then click the "Confirm" button at H to display the confirmation interface (as shown in Figure 4.2.5), and then click the confirmation button at I to automatically jump to the pattern editing interface after completing the second zero point setting.

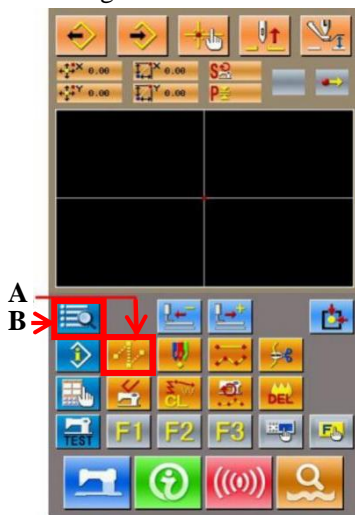


Figure 4.2.1 Editing Interface

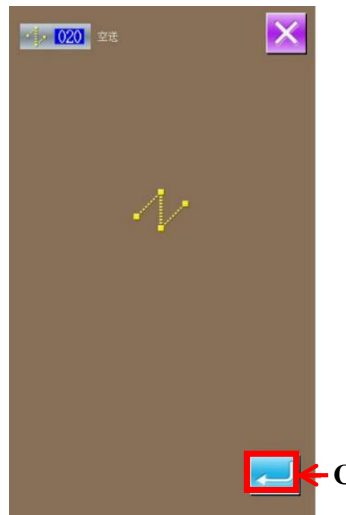


Figure 4.2.2 Empty Feed Confirm

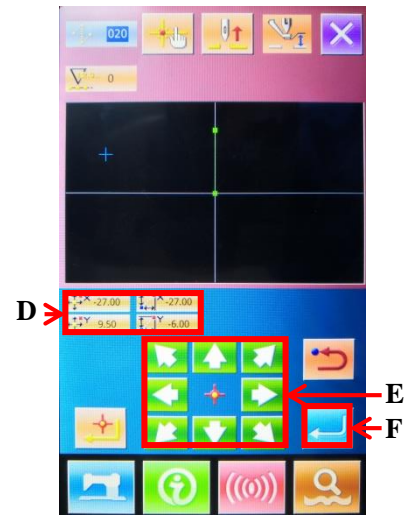


Figure 4.2.3 Empty Feed Edit



Figure 4.2.4 Functional List

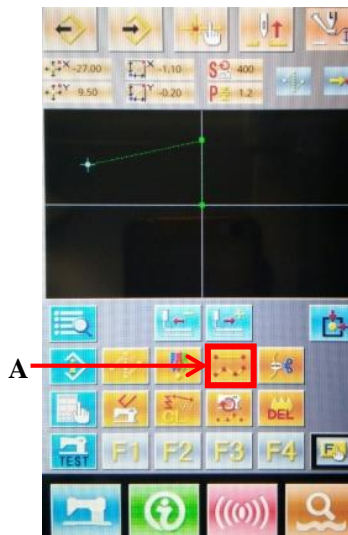


Figure 4.2.4 Function List

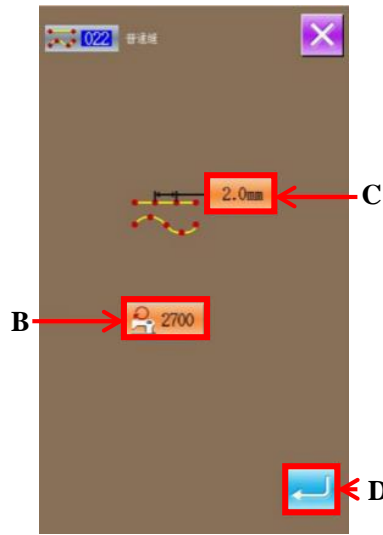
4.3 Pattern Editing to Set Sewing Stitches

(1) Refer to the empty feed command operation in 4.2, send the cross cursor from the second origin to the coordinate point (-27, 9.50), and return to the pattern editing interface after completion (see Figure 4.3.1);

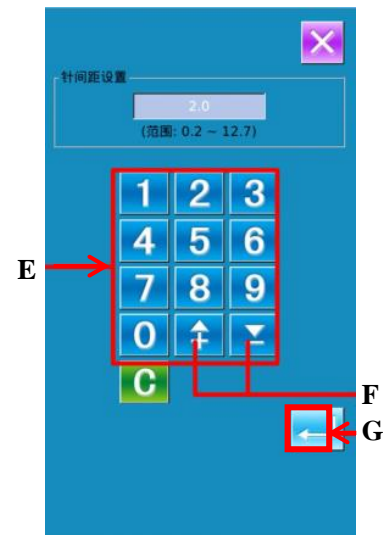
(2) Click the "ordinary sewing" button at position A on the pattern editing interface to enter the sewing parameter setting interface (see Figure 4.3.2), and click the number at C to enter the stitch length setting interface (see Figure 4.3.3). Use E numeric keyboard and F numeric addition and subtraction to set the required stitch length, click the "OK" button at G to return to the sewing parameter setting interface (the default is 2mm, you do not need to enter the setting), click B to enter the sewing speed Setting (see Figure 4.3.4), use the numeric keyboard to input the speed, and then click H to confirm. Click the "OK" button at D to enter the sewing editing interface (see Figure 4.3.5), move the cross cursor through the arrow keys to determine the coordinate point (-27, 15.5), and click the "OK" button after the effect is shown in Figure 4.3.6 In the same way, set the next sewing end point (-27, -8.5) after confirmation as shown in Figure 4.3.7, and then set the next sewing point (-27, -2.5) after confirmation as shown in Figure 4.3.8 It shows that the sewing trajectory on one side has been set;



4.3.1 Parameters Interface



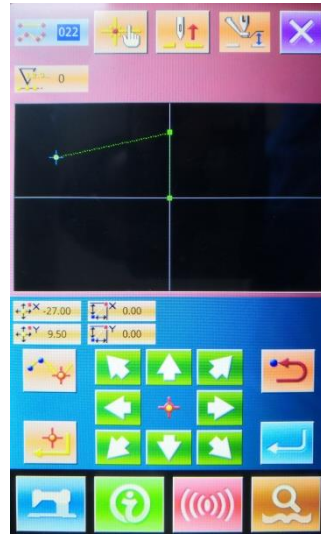
4.3.2 Parameters Interface



4.3.3 Stitch Length Setting



4.3.4 Parameters Interface



4.3.5 Sewing Editing Interface



4.3.6 Sewing Interface 1



4.3.7 Sewing Interface 2



4.3.8 Sewing Interface 3

(3) Perform the empty feed operation as in step (1) above, and send the cursor to the coordinate point (27, 9.50), as shown in Figure 4.3.9 after the setting is completed;

(4) Execute the second step (2) in the same step as the ordinary sewing operation, confirm the coordinate point (27,15.50) with the arrow keys and click confirm as shown in Figure 4.3.10, the next sewing point (27,- 8.5) After confirmation, see Figure 4.3.11, and then set the next sewing point (27, -2.5) after confirmation, as shown in Figure 4.3.12;

(5) In the pattern editing interface (as shown in Figure 4.3.12), click the "Output" button at I to enter the output interface (as shown in Figure 4.3.13; enter the number as the pattern number, note that the naming is not allowed to be same as name of the existing pattern, it is recommended to use the number generated by default, click the "OK" button in the red circle of No. 1 to complete the naming, and then the automatic insertion thread trimming interface will pop up (Figure 4.3.14), click the "OK" button to complete the editing of the new pattern , And then return to the pattern editing interface (Figure 4.3.12);

(6) Click the button at position J on the pattern editing interface to enter the prompt interface of "whether to return to the sewing interface" (see Figure 4.3.15), and click the enter button in the red circle on the 1st to return to the main interface of booting.



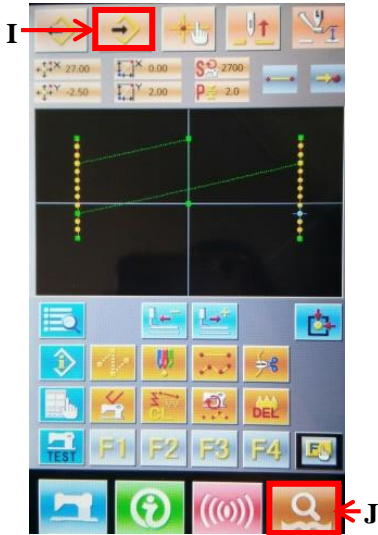
4.3.9 Sewing Interface 4



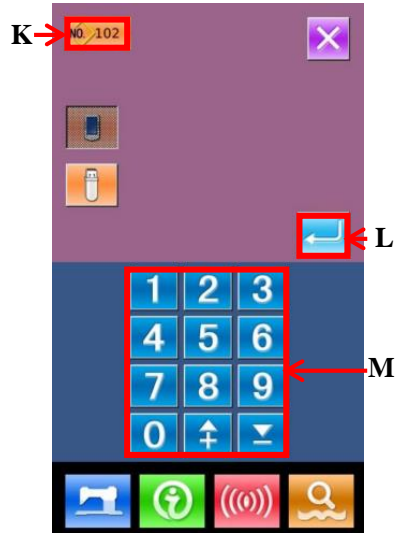
4.3.10 Sewing Interface 5



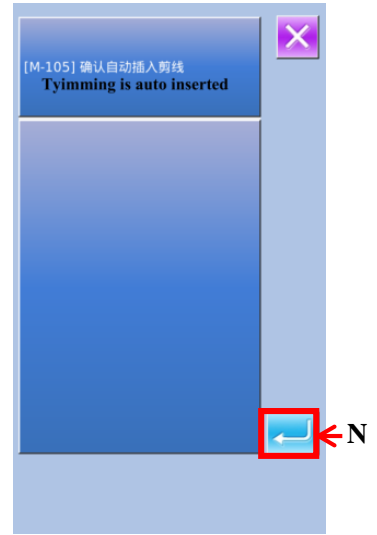
4.3.11 Sewing Interface 6



4.3.12 Pattern Completed



4.3.13 Pattern Naming



4.3.14 Auto Insertion Trimming



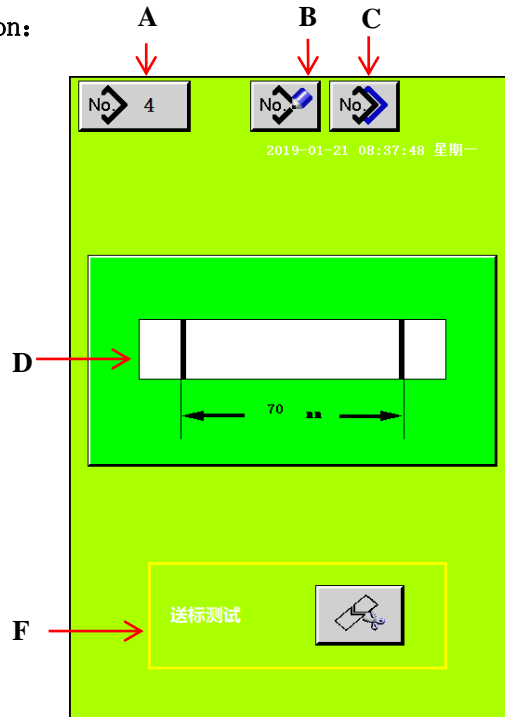
4.3.15 Return to Sewing

5. Collar Label Control System

5.1 Sewing Data Input Interface

The sewing data input interface is shown on the right. For detailed function descriptions, please refer to the function key description table.


Function Introduction:



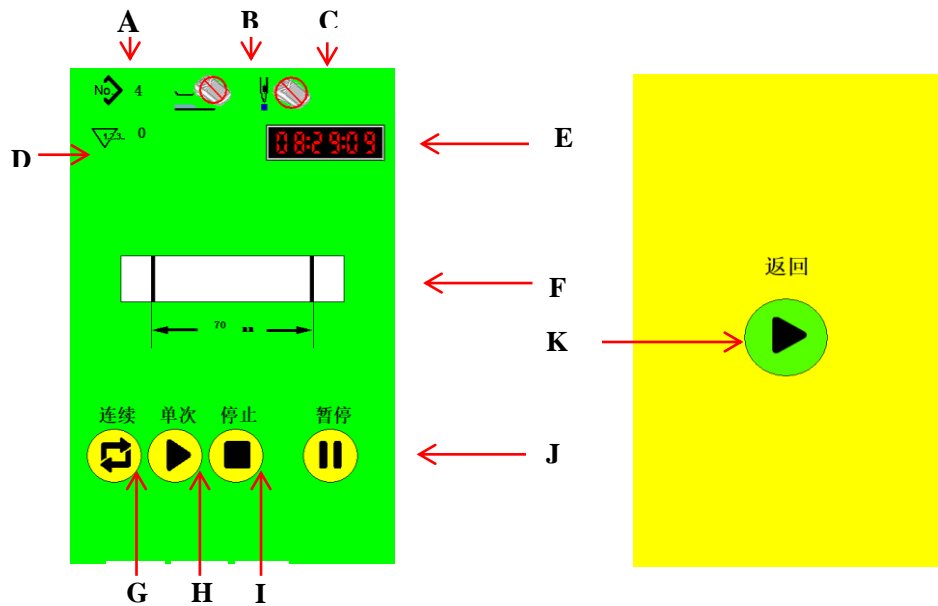
Sewing Data Input Interface

No.	Function	Description
A	Pattern Browsing	Browse choose and delete pattern
B	Pattern Creating	Can create 99 patterns
C	Pattern Copy	Can copy patterns
D	Label Copy	Label parameter setting under current pattern number
F	Label Feed Test	Pattern parameter validation can be achieved by passing a label

5.2 Sewing Interface

Press  in the **sewing data input interface** to enter the **sewing interface** as shown on the right, and press again to return to the **sewing data input interface**. See the function key description table for detailed function description.


Function Introduction:



Pause Interface

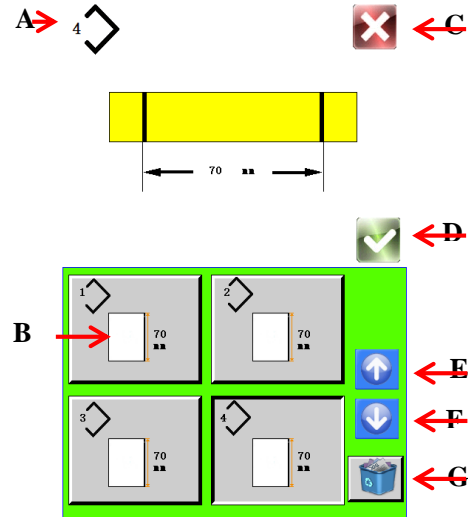
No.	Function	Sewing Interface Description
A	Pattern Number	Display current pattern number
B	Presser pedal status display	Shows whether the presser foot pedal can be enabled (cannot be used for automatic presser foot, which can be modified on the machine parameter interface)
C	Sewing pedal status display	Shows whether the sewing pedal can be enabled (cannot be used for automatic sewing, which can be modified on the machine parameter interface)
D	Sewing Counter	Display sewing count (can be cleared on the sewing count interface)
E	Time	Shows current time
F	Label length	Label length
G	Start	Start the standard-feed sewing, and continue the standard-feed sewing after the sewing is completed, and enter the " repeat run " state. You can press this key during " Start Once " to enter " Repeat Run ".
H	Single sewing	Start the standard feeding sewing once. After the sewing is completed, the standard sewing will not be continued. You can press this key while " Repeat Run " is in progress, and it will stop when the sewing ends.
I	Stop	Stop the sewing, and immediately stop the operation and reset during the " repetitive operation " or " start once ".
J	Pause button	When the user enables continuous label sending or other modes in the sewing process, press the button to "screen" the foot and the sewn up sensor.
K	Pause restore	Return to the <u>int</u> interface and state before the pause button was pressed, so that the foot pedal and sewing sensor can be controlled.

5.3 Pattern Browsing

Press  to enter into pattern browsing interface (shown below. Detailed introduction as follow


Function Introduction:

No.	Function	Description
A	Pattern no.	Shows selected pattern no.
B	Select area	Shows available pattern no.
C	Exit	Exit the pattern browsing selection and keep the pattern selection before entering the interface.
D	Confirm	Confirm newly selected pattern
E	Page up	Page up
F	Page down	Page down
G	Delete	Delete selected patterns (cannot delete all patterns, at least one pattern must be kept)



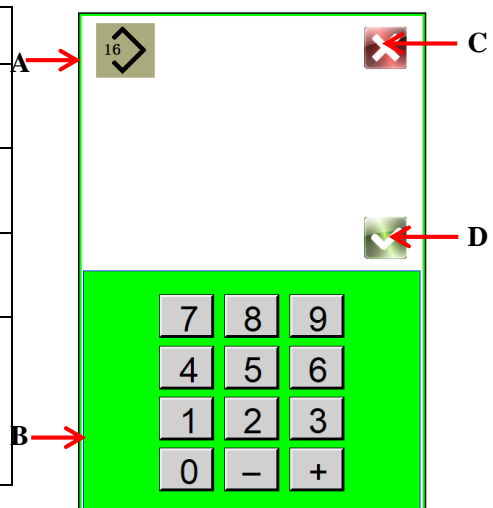
Pattern Browsing

5.4 Create Pattern

Press  to enter into pattern creating interface (shown below. Detailed introduction as follow


Function Introduction:

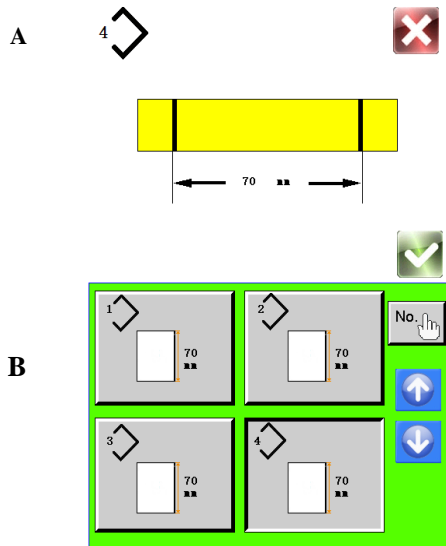
No.	Function	Description
A	Pattern No.	Display the pattern number to be created
B	Input area	Display pattern number keyboard input area
C	Exit	Exit new pattern creation, there will be no new pattern creation
D	Confirm	Confirm that the new pattern needs to be created. If the pattern already exists, this button is not displayed.



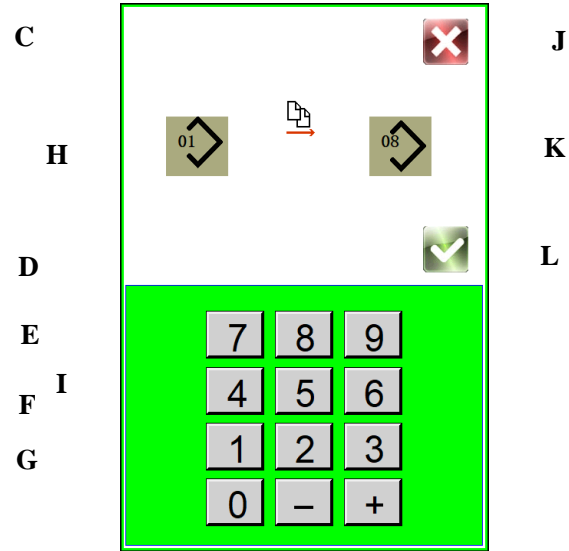
Pattern Creating Interface

5.5 Pattern Copy

Press  to enter into pattern copy interface (shown as right figure. Detailed introduction as follow
Function Introduction:




pattern copy interface 1

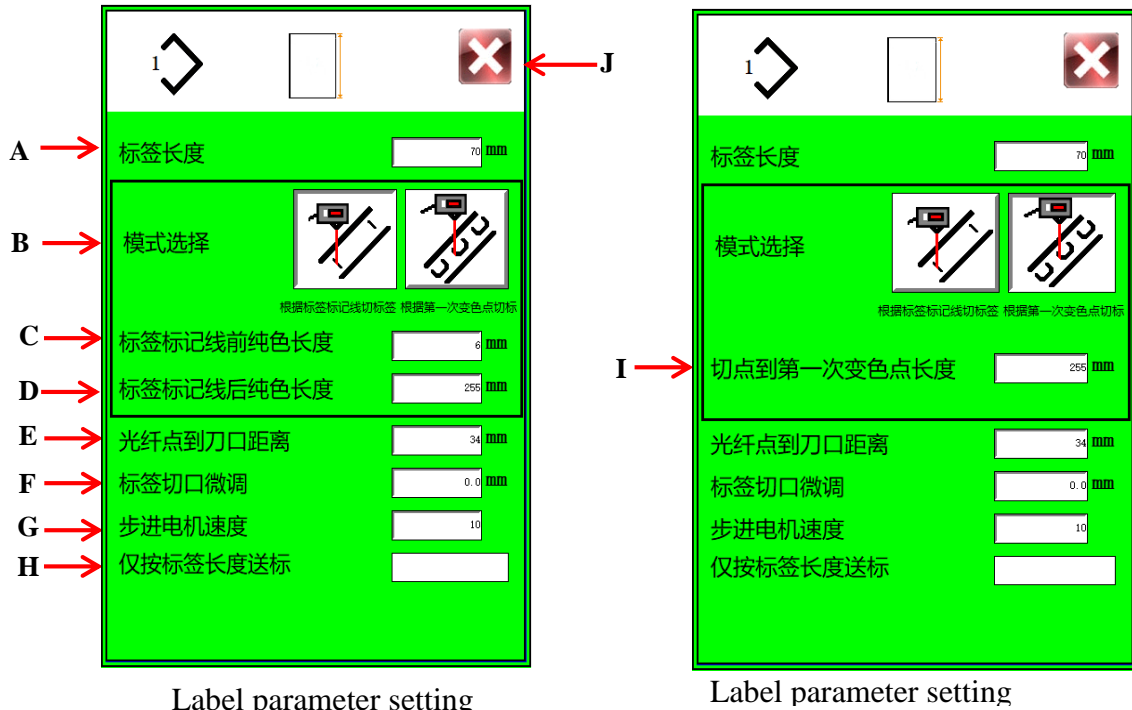


pattern copy interface 2

No.	Function	Description
A	Pattern no.	Show the copied pattern number
B	Select area	Select area of copied pattern number is displayed
C	Exit	Exit pattern copy, the pattern will not be copied
D	Confirm	Confirm the selected pattern, the pattern will be copied
E	Copy	Enter the pattern copy interface 2
F	Page on	Page on
G	Page down	Page down
H	Pattern no. copied	Show the copied pattern number
I	Input area	Enter the copied pattern number
J	Exit	Exit copy
K	Copy pattern no.	Display the copied pattern number
L	Confirm	Confirm to copy the pattern of H to the pattern of K

5.6 Label Parameter Setting

Press  enter into Label Parameter Setting interface, enter into coordinated parameter interface (as right figure shows)



Label parameter setting


Label parameter setting

Function Introduction:

Name	Function	Description
A	Label Length	Enter the label length. Enter the length between the two marked lines of the label as shown in the figure below.
B	Mode selection	Choose to detect in mark line mode or the first change of color point detection
C	The length of the solid color before the label marking line	Take the black line on a white background as an example, there will be a blank area before and after the black mark line. It is required to enter the length of this area, which is generally 6mm, as shown in the above figure
D	The length of the solid color after the label marking line	Take the black line on a white background as an example, there will be a blank area after the black mark line. It is required to enter the length of this area, which is generally 255mm, as shown in the above figure
E	Fiber point to blade distance	The distance between the fiber point and the blade is generally 34mm, which is related to the mechanical structure of the machine and is generally not adjusted.
F	Label cut fine-tuning	Fine adjustment of label cut. When the black mark line is too much, if there is more than 1mm, you can set this value to -1. When the black marking line does not come out enough, if it is less than 1mm, this value can be set to 1. As shown below.
G	Stepper motor speed	Stepping motor speed gear, a total of 10 gears, respectively 1-10

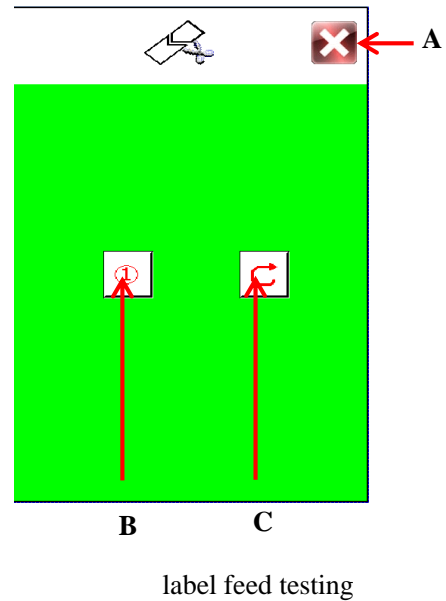
H	Only send labels according to label length	If this option is selected, the label will not be sent according to the detection mark line. The more labels are sent, the higher the offset error. Generally, this option is not selected.
I	Length from tangent point to the first color change point	It is suitable for the detection method without marking lines. Taking black characters on a white background as an example, the distance from the cut point to the point of the first color change.
J	Exit	Exit Setting

5.7 Label feed testing mode


Press  enter into label feed testing mode, Detailed introduction as followed.

Function Description:

Name	Function	Description
A	Exit	Exit the standard test mode
B	Single feed	Press the corresponding label once to send the label once, which can be used to confirm the corresponding label parameters.
C	Repeat feed	Press the corresponding label once to send the label repeatedly




5.8 Program Information Interface

Press  on the sewing data input interface to enter the program information interface as shown on the right, and press again to return to the sewing data input interface. The program information interface displays the program version number.



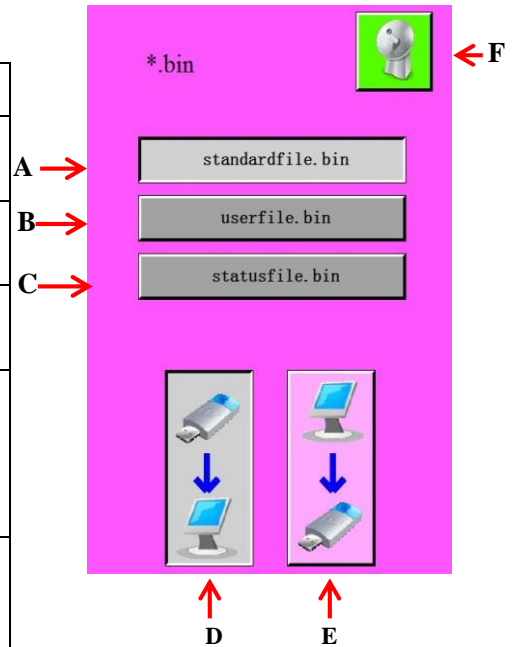
5.9 Pattern parameter file transfer

Press  on the **sewing data input interface** to enter the **pattern parameter file transmission** as shown on the right, and press again to return to the **sewing data input interface**. See the function key description table for detailed function description.

Please note: Insert the USB flash drive before operation.


Function Description

Name	Function	Introduction
A	File Selection	Choose standardfile.bin file
B	File Selection	Choose userfile.bin file
C	File Selection	Choose statusfile.bin file
D	Select transmission direction	Set file transfer from U disk to touch screen
E	Select transmission direction	Set file transfer from U disk to touch screen
F	Execute	According to the file selection and transfer direction selection, the action is executed. Follow the prompts to perform subsequent actions.



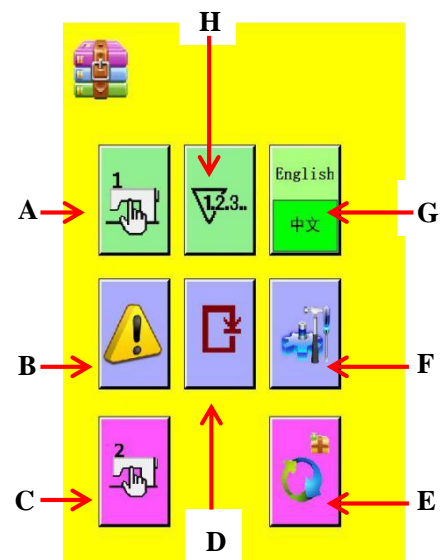
Pattern parameter file transfer

5.10 Settings page

Press  on the **sewing data input interface** to enter the setting page as shown on the right, and press again to return to the **sewing data input interface**. See the function key description table for detailed function description.


Function Description:

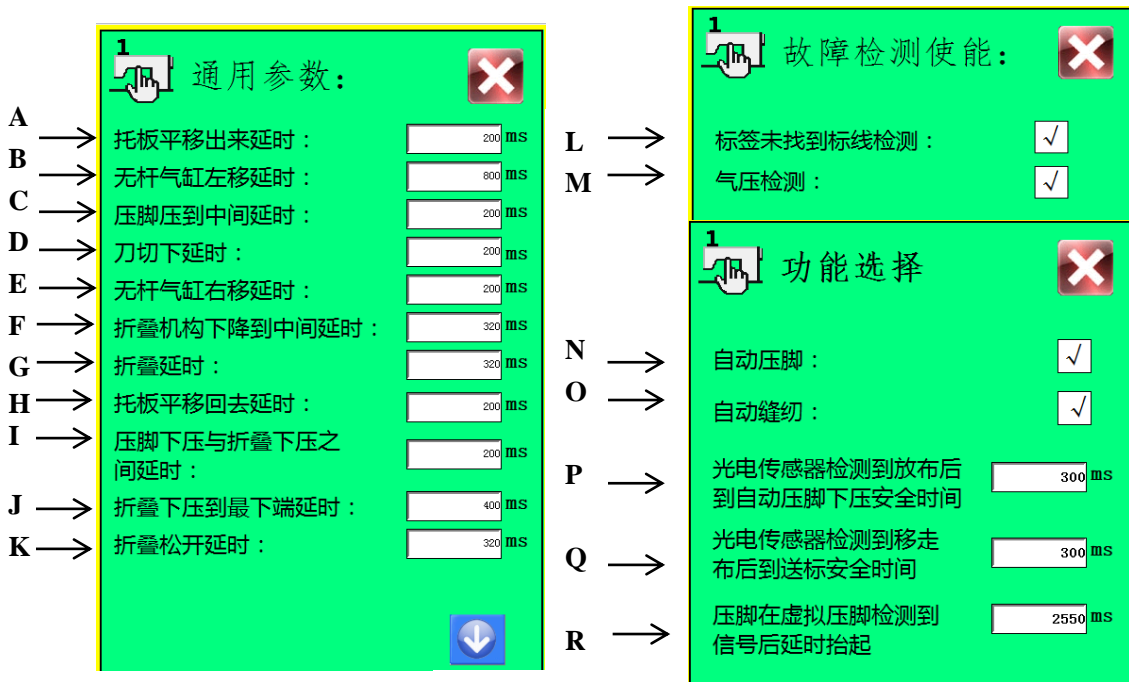
Name	Function	Description
A	Machine parameter 1 setting	Set commonly used machine parameters, such as delay, fault enable, pedal settings and other parameters.
B	Fault history	Shows fault history
C	Machine parameter 2	Set unused machine parameters, need password to enter



	Setting	
D	Single step operation	Step by step test, password required
E	Parameter restoration to factory settings	The parameters are restored to the factory settings, a password is required to enter
F	Diagnostic mode	Enter I / O diagnostic mode
G	Chinese and English switch	Chinese and English language switching
H	Count	Display count information

5.11 Machine parameter 1 setting

Press  to enter the machine parameter 1 setting interface, a total of 3 pages, you can use the up and down page keys to turn the page, and the exit key to exit, as shown in the following figure. For the detailed function description, see the function key description table.



The image displays two screenshots of the machine parameter 1 setting interface. The left screenshot, titled '通用参数' (General Parameters), shows settings A through K with corresponding delay values in milliseconds. The right screenshot, titled '故障检测使能' (Fault Detection Enable) and '功能选择' (Function Selection), shows settings L through R with checkboxes and delay values.

Setting	Function	Value
A	托板平移出来延时	200 ms
B	无杆气缸左移延时	800 ms
C	压脚压到中间延时	200 ms
D	刀切下延时	200 ms
E	无杆气缸右移延时	200 ms
F	折叠机构下降到中间延时	320 ms
G	折叠延时	320 ms
H	托板平移回去延时	200 ms
I	压脚下压与折叠下压之间延时	200 ms
J	折叠下压到最下端延时	400 ms
K	折叠松开延时	320 ms
L	故障检测使能	<input checked="" type="checkbox"/>
M	标签未找到标线检测	<input checked="" type="checkbox"/>
	气压检测	<input checked="" type="checkbox"/>
N	功能选择 - 自动压脚	<input checked="" type="checkbox"/>
O	功能选择 - 自动缝纫	<input checked="" type="checkbox"/>
P	功能选择 - 光电传感器检测到放布后到自动压脚下压安全时间	300 ms
Q	功能选择 - 光电传感器检测到移走布后到送标安全时间	300 ms
R	功能选择 - 压脚在虚拟压脚检测到信号后延时抬起	2550 ms


Function Description:

Machine parameter 1 setting

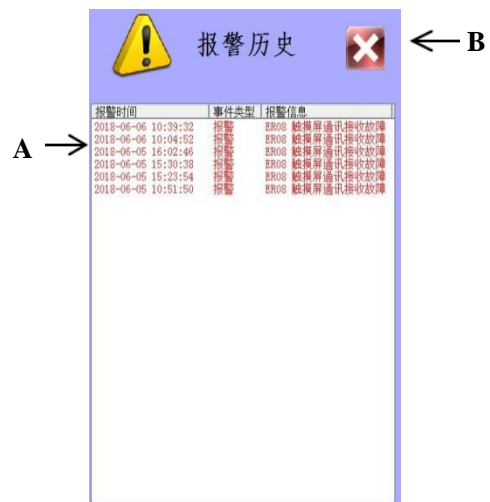
Name	Function	Description
A	The pallet shifts out delay	The pallet shifts out delay, the default is 200ms
B	Rodless cylinder left shift delay	Delay of left movement of rodless cylinder, default
C	Presser foot presses to the middle delay	Presser foot presses to the middle delay, default 200ms
D	Knife cut delay	Knife cutting delay, default 200ms

E	Delay of right movement of rodless cylinder	Delay of right movement of rodless cylinder, default 200ms
F	Folding mechanism falling to the middle delay	Folding mechanism falling to the middle delay, default 320ms
G	Folding delay	Folding action delay, default 320ms
H	The pallet shifts back to the delay	The pallet shifts back to the delay, the default is 200ms
I	Delay between presser foot lowering and folding lowering	Delay between presser foot lowering and folding lowering, default 200ms
J	Fold down to the bottom delay	Delay when folding down to the bottom, default 400ms
K	Fold and release delay	Fold and release delay, default 320ms
L	Label not found mark detection	Label not found mark detection
M	Barometric pressure detection	Air pressure fault detection, open by default
N	Automatic presser foot	Automatic presser foot
O	Automatic sewing	Automatic sewing
P	After the photoelectric sensor detects the laying of cloth, it will be safe to press the automatic presser foot.	The photoelectric sensor detects the safety time after the cloth is placed to the automatic presser foot, the default is 300ms
Q	The photoelectric sensor detects the removal of the cloth and the time to deliver the label is safe	The photoelectric sensor detects the removal of the cloth to the safety time of label feeding, the default is 300ms
R	The presser foot raises the delay when the virtual presser foot detects a signal delay	The presser foot raises the delay when the virtual presser foot detects a signal delay, the default is 2550ms

5.12 Alarm history page


Press  to enter the alarm history display interface.
See the function key description table for detailed function description.
Function Description:

Name	Function	Description
A	Alarm history display	Alarm history display
B	Exit	Exit alarm history display



alarm history display

5.13 Machine parameter 2 setting

Press  and enter the password "11" to enter the machine parameter 2 setting interface, as shown on the right. For detailed function description, please refer to the function key description table.


Function Description:

Name	Function	Description
A	Photoelectric sensor is invalid	Used for durable running-in of the machine, it is not turned on by default
B	Stepper motor coefficient	Set stepper motor coefficient, default 6250
C	Knife action times	Record the number of knife movements, a password is required for resetting
D	Total sewing times	Record the total number of sewing pieces, need password to clear




Machine parameter 2 setting

5.14 Restore the factory settings

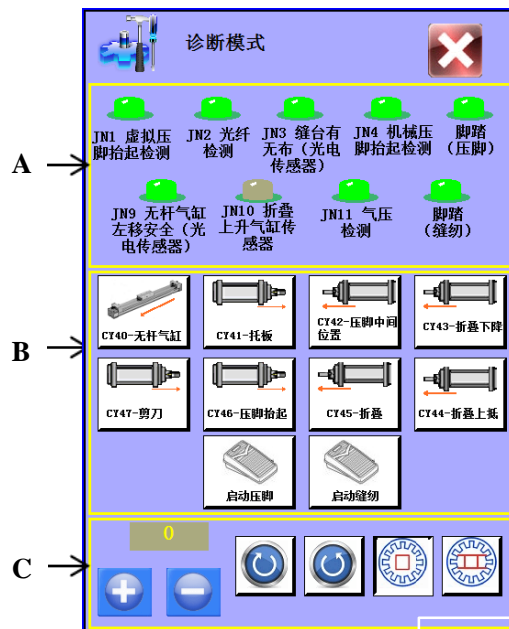
Press  and enter the password "110119120" to restore the factory settings.

5.15 Diagnostic mode


Press  to enter the diagnosis mode, as shown on the right, see the function key description table for detailed function description.

Function Description:


A	Input	Enter the input port test interface
B	Output	Enter the output port test interface
C	Motor	Enter the stepping motor test interface

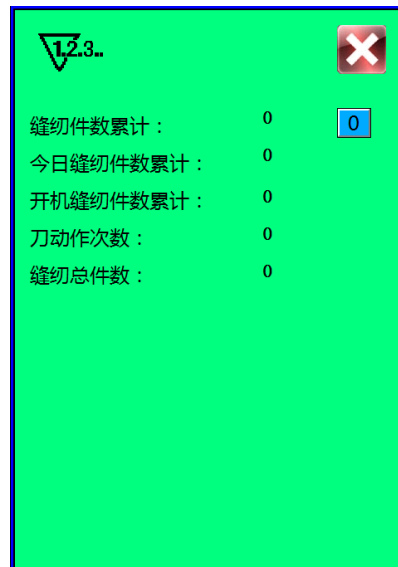


5.16 Chinese and English settings

Press  to switch between Chinese and English.

5.17 Counting information display

Press  to enter the count information display interface, as shown on the right.



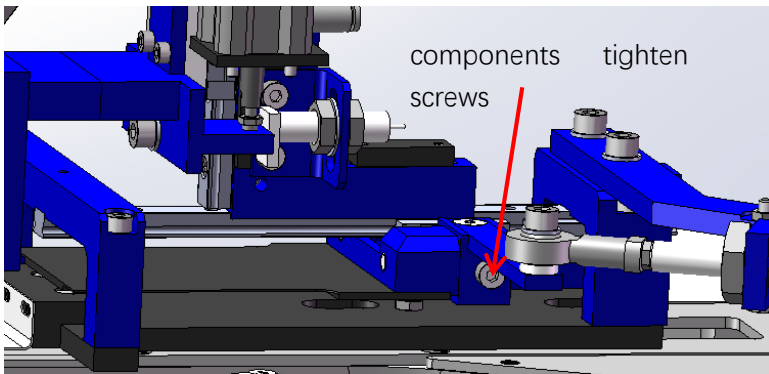
Counting information display

6. Making adjustment

6.1 change labels and program setting process

When replacing the label and its process, it is necessary to debug the program and equipment. This manual describes the commissioning for different sizes of lead labels.

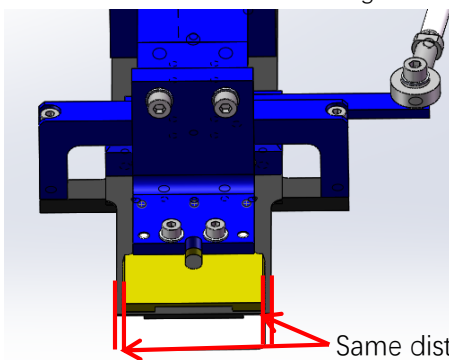
1) Replace the folding label plate of the corresponding size according to the size requirements of the replacement collar, remove the folding label plate assembly from the folding mechanism (see Figure 6.1.1), and remove the folding label plate from the folding label plate fixing block. Then replace the folding label board (as shown in Figure 6.1.2), and put the folding label assembly back into the folding mechanism. Align the folding plate with the pressing plate (see Figure 6.1.3), and then adjust the left and right horizontal fixing blocks (see Figure 6.1.4), loosen the adjustment screws in the figure to adjust the horizontal position, and fold the marking plate. There is a trademark gap with the folding plate (see Figure 6.1.5) to ensure that it will not collide.



F.6.1.1 folding device components



F.6.1.2 label folding plate



Same distance

Adjusting screws

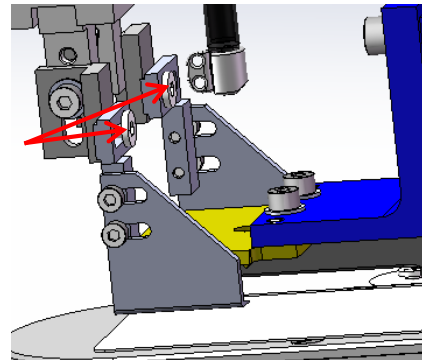
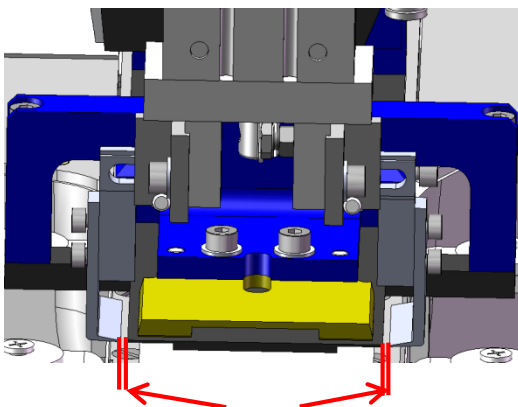


图 6.1.3 label pressing plate and label folding comparison

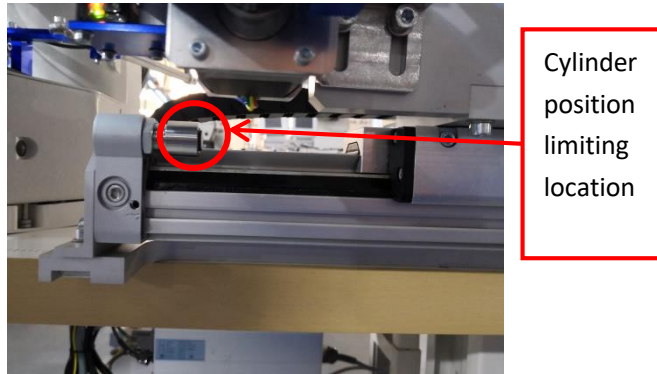


Distance is the same to the thickness of one piece of label

2) Debug the left-right symmetry of the leader. When the lead label is sent out by the conveyor, it reaches the folding label board. At this time, ensure that the lead label is parallel to the end surface of the folding label board, and there is no inclination. Then, the pressing label board is pressed down, and the leader label is cut off. Are the lengths of the two ends of the target board equal? If not, adjust the cylinder limit at the indicated position, and then retest. The aligned state is shown in Figure 6.1.6. The left and right fine adjustment of the collar can be adjusted by adjusting the limit position of the cylinder (see Figure 6.1.7).

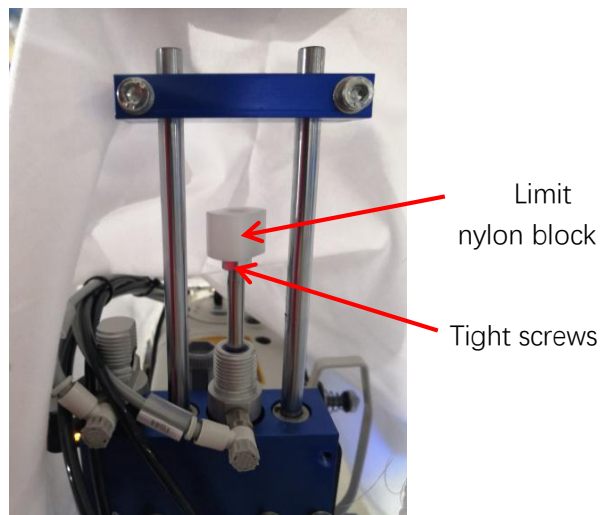


F.6.1.6 label folding style



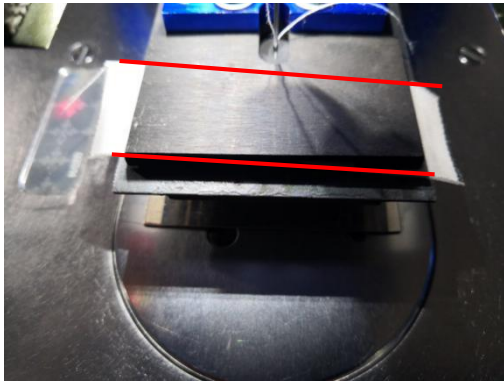
F.6.1.7 Cylinder position limiting device

2) If the longitudinal gap of the left and right folding label plates is too small or too large, adjust the limit nylon block on the presser foot mechanism to ensure that the longitudinal distance between the left and right folding label plates and the folding label plate is about 0.5mm (after the label is folded, the collar label touches the side Wall, if the upper limit nylon block is not loose, no adjustment is required);

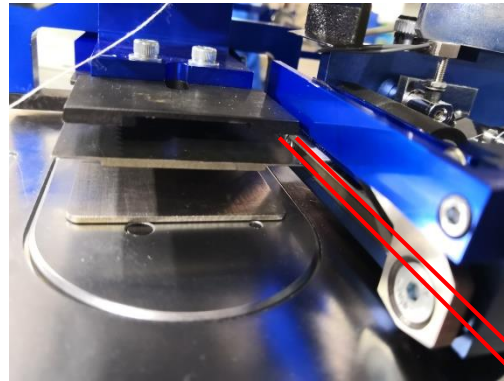


F.6.1.8 label folding

6)When the collar is folded, if a misalignment occurs, see Figure 6.1.9. At this time, it is necessary to adjust the conveying device and the folding device to be parallel, as shown in Figure 6.1.10. The specific adjustment methods are as follows:



F. 6. 1. 9Schematic diagram of lead oblique delivery



F. 6. 1. 10presser foot and clamp feeding device

Loosen the four screws on the left and right sides of the rodless cylinder in the support device (Figure 6.1.11 and Figure 6.1.2), and then adjust the lower edge of the conveyor and the edge of the folding plate to be parallel.



F. 6. 1. 11Rodless cylinder left adjusting screw



F. 6. 1. 12Rodless cylinder right adjusting screw

6.2 Photoelectric sensor adjustment

There are two photoelectric sensors, the first one is labeled JN3, which is located at the nose (see Figure 6.2.1). The second label is JN9 and is located at the bottom of the conveyor (see Figure 6.2.2).

Sensor induction effect adjustment:

Step 1: Turn knob A to the side marked with the letter D;

Step 2: Adjust knob C to achieve the following effect: The green light is always on. When there is no object blocking, the indicator B orange light is on; when there is object blocking, the indicator B orange light is off.

JN3 sensor position adjustment:

Step 1: Remove the screw at position D in Figure 6.2.1, and then loosen the sensor fixing screw,

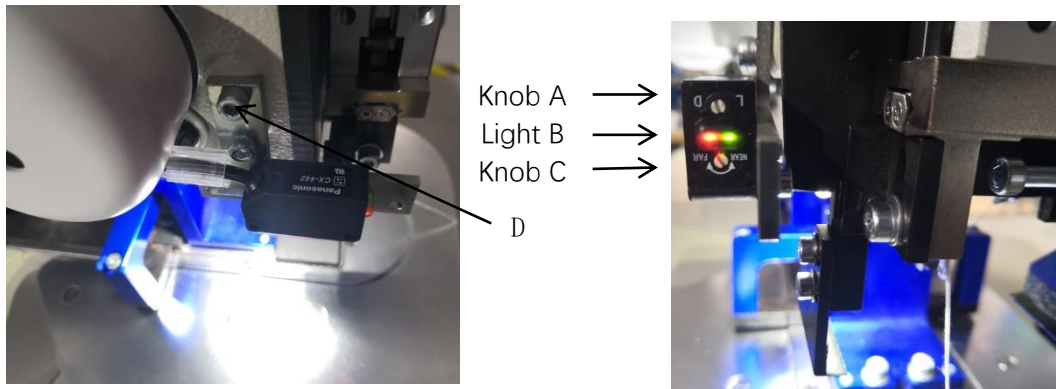


图 6.2.1 sewing head sensor

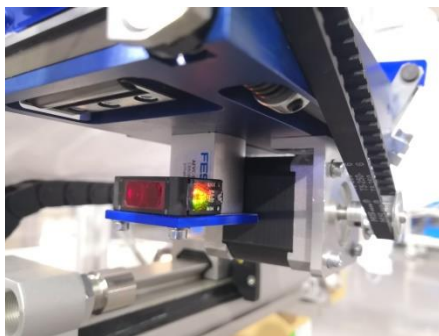
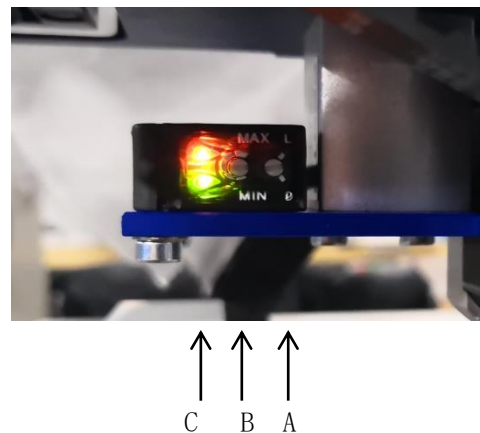
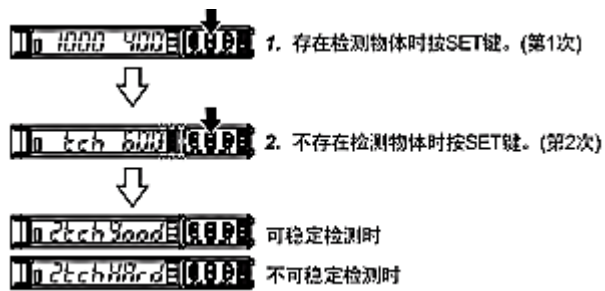


图 6.2. FEEDING DEVICE SENSOR





Method 2: You can record the fiber values for the white and black lines separately, and then press "+" or "-" to adjust the threshold so that it is at the average of the two

6.5 Approaching switch setting

There are two proximity switches, labeled as JN1, JN4, JN1 is located in the tail of the nose, covered by the tail hood.

When the presser foot moves, the detected object moves. Therefore, the action of the detected object is detected to indicate the action of the presser foot.

Adjustment requirements: when the presser foot is raised, the indicator light is on; when the presser foot is pressed, the indicator light is off.

Another JN4 is located on the folding mechanism to detect whether the presser foot is raised. When the presser foot is pressed, the indicator light is off.

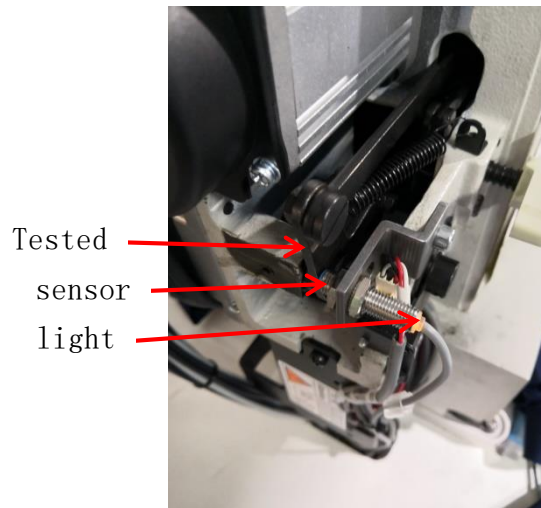
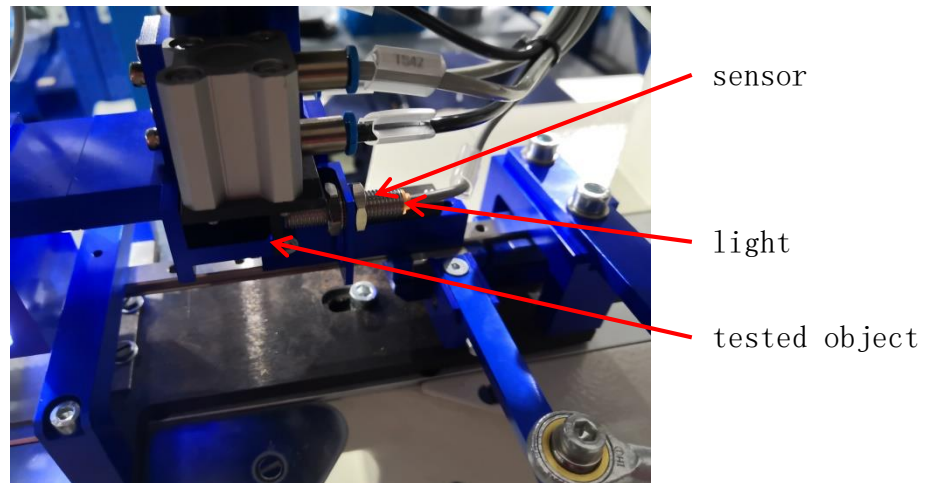


图 6.5.1 tail part of sewing head approaching switch



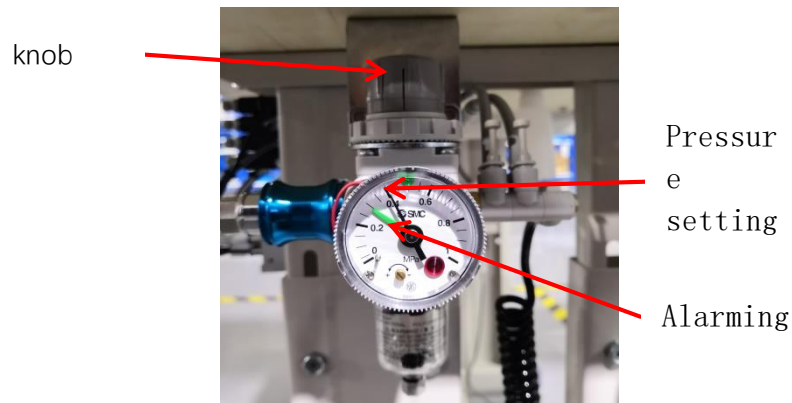
F. 6. 5. 2 folding device approaching switch

6.6 Air pressure detection adjustment

There is a total of air pressure detection, which is located below the left side of the platen. The black arrow in the barometer is the set air pressure, and the green arrow is the alarm indicating air pressure

After ventilating, pull out the adjustment knob and turn the adjustment knob to make the set air pressure 0.4MPa.

Open the glass cover of the barometer and turn the green arrow to set the alarm indication pressure to 0.3MPa.



F. 6. 6. 1pressure checking

6.7Pressure regulator adjustment

Enter the diagnosis mode, ventilate the corresponding trachea separately, and then adjust the corresponding air pressure. After the air pressure is adjusted, the nut should be locked. **The air pressure in the table below is for reference only, the actual air pressure will be different according to the actual commissioning.**

No	Air pressure
TB40	3bar
TB46	2bar
TS46	2bar
TB48	2bar



F. 6. 7. 1Pressure regulator adjustment

7.Maintenance



When change spare parts,maintenance,we need to cut off the power and air.only professional people can do the following operation.

Motors cleaning

Cleaning the motor regularly.

Needle plate cleaning

Loose the screws and clean.

Lubrication

Check the lubricating oil level of the machine head regularly and top up with white oil if necessary.

Add lubricant to the shaft.

Destroy the machine

If you want to destroy the machine, split the various parts and send them to the appropriate collection point.

8. Troubleshooting

ER01 doesn't find the label mark	
Reason	The label is used up; the label marking line is printed incorrectly; the label transmission is invalid; the label parameter setting is wrong; other.
Solution	Label marking detection failure. Please check whether the label transmission is correct. If it is not correct, you can manually fine-tune and clear the fault.
ER02 sewing head is not reset, presser foot is not up	
Reason	Sewing head is not reset ; sensor SE10 installation or connection wrong 。
Solution	Sewing head enters sewing mode or check the sensor SE10.
ER03 air pressure is not enough	
Reason	No air connection; pressure detector setting and connection checking.
Solution	Checking the air connection and power connection
ER04 touch panel connection wrong	
Reason	Touch panel connection wrong
solution	Pls connect the power and restart the machine
ER05 touch panel connection broken	
Reason	Touch panel connection is broken
Solution	Pls check the power connection
ER06 Move the objects on the sewing plate away	
reason	There are objects on the sewing plate ; or sensor LS01 abnormal。
solution	Pls move away the fabric on the sewing plate, or check whether sensor LS01 is wrong or good.
ER07 pls put the fabric to sew	
reason	No fabric; or sensor LS01 abnormal
solution	Pls put the fabric and sew, or check sensor LS01
ER08 presser foot is not on	
Reason	Presser foot is not up, threading is on.
solution	After threading, it will recover automatically.

9 Other parts

In order to quickly and easily confirm the remaining parts required, a parts manual is provided, which contains a list of parts.