

記號說明 ICON INDICATORS IN THIS MANUAL



1. 燈亮
1. LIGHT ON



2. 操作順序
2. OPERATION STEP



3. 按此鍵表計數增加
3. PRESS FOR COUNTER INCREASE



4. 按此鍵表計數減少
4. PRESS FOR COUNTER DECREASE



5. 按此鍵時可於工程段數間切刀。(例縫褲口的左右邊。)
5. PRESS THIS KEY TO TRIM TO CONTINUE THE NEXT SECTIONS.(FOR EXAMPLE;WHEN SEWING BOTH EDGE OF THE UNDER PANTS.)

重要 :放入鬆緊帶的正確位置:

IMPORTANT:THE RIGHT POSITION FOR INSERTING ELASTIC TAPE:

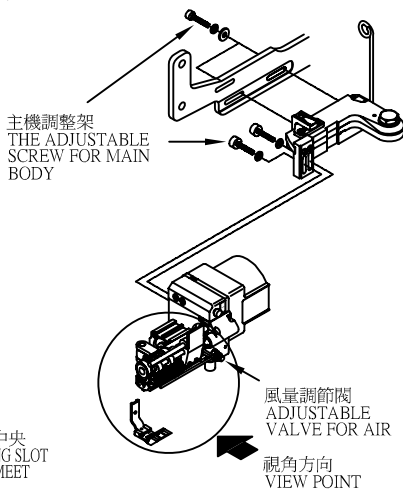
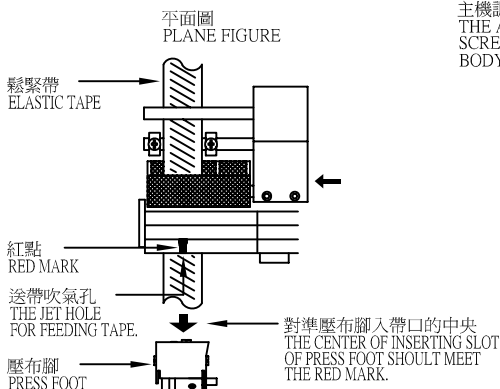
必需調整主機的紅點對準壓布腳入帶口的中央。

(送帶用吹氣孔是在紅點的下方)

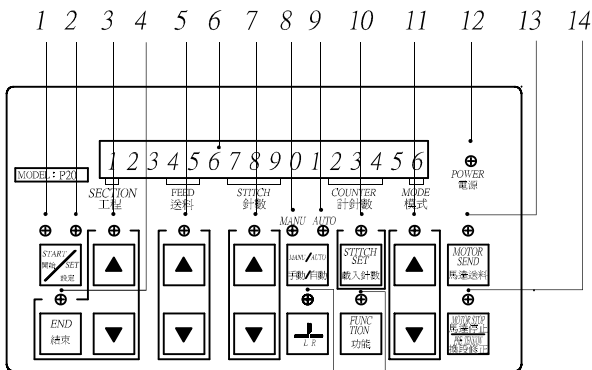
MAKE SURE THE CENTER OF INSERTING SLOT OF

PRESS FOOT SHOULDT MEET THE RED MARK.


(THE JET HOLE IS UNDER THE RED MARK)



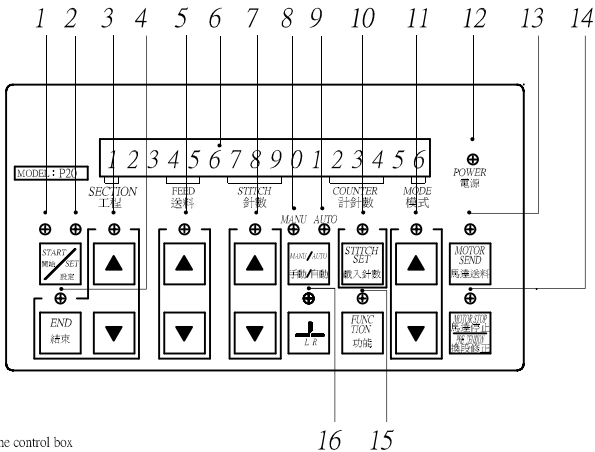
控制盒面板說明



控制盒用途說明

- 1 開始(循環開關): 回復啓始狀態
- 2 設定(循環開關): 進入設定修改狀態
- 3 工程: ○模式: ■、A、C、D設定工程段數1~18段
○模式: E~Z設定工程段數1~9段
- 4 結束: 設定工程結束。
- 5 送料: 每針送料長度設定00~99每增加1=0.025MM
- 6 視窗: 顯示現在狀態。
- 7 針數: 設定工程所需要的針數0~999(手動時則不顯示)
- 8 手動: 用手動開關進入下一工程。
- 9 自動: 設定針數累計到達時依序進入下一車縫工程。
- 10 載入針數: 在試縫完成後可將計數器內所顯示的數字(針數)轉入"針數"的視窗內作為該工程的針數設定(注意!原針數會被覆蓋掉)
- 11 模式: 可儲存27組不同工程內容的資料(■, A~Z 共27組)
(進入功能鍵模式內時另有用途請參照功鍵內容說明 第4~6頁)
- 12 電源: 燈亮時控制鍵才可操作(開關在電源箱)。
- 13 馬達送料: 按此鍵時馬達運轉, 可便於插入鬆緊帶用。
- 14 馬達停止: 在START時按此鍵馬達停止運轉。(再按功能鍵時, 能測出縫紉機的轉速)
換段修正: 在SET時按此鍵為換段修正設定。(請參考功能說明 第14、15頁)
- 15 功能: 按此鍵時可提供各種縫製需要的功能設定(請參考功能說明 第4~6頁)。
- 16 : 按此鍵時可於工程段數間切刀。(例縫褲口的左右邊, 請參考 第12~13頁 操作說明)。

THE MANUAL OF THE CONTROL PANEL



The instruction of the control box

- 1 Start (Circulating Switch) : Return to the status of the beginning.
- 2 Set (Circulating Switch) : Enter to the modified status.
- 3 Section : \odot A、C and D can be setting the section from 1~18.
 \odot E~Z can be setting the section from 1-9.
- 4 End : Press this key to complete the setting transaction.
- 5 Feed : To set the distance of each stitch when feeding From 00-99.
 (00=0mm.For each additional one=0.025MM.)
- 6 Data Panel : Indicate the data status.
- 7 Stitch : To set the stitches from 000~999 for the need section.
- 8 Manual : During the manual condition, using the manual botton to enter the next section.
- 9 Auto : When the stitch are executed, the machine will automatic progress in to the next section.
- 10 Stitch : After Complete the sewing test, press this key to duplicate the testing result of stitches to enter the setting of the next stitches section.
- 11 Mode : Use this key can memory up to 27 different sections of the information from \blacksquare ,A~Z.
 (For the detail,please refer to the functional guide in page 4-6.)
- 12 Power : Unable to operate unless this indicate lights is on. (Switch is on the power box.)
- 13 Motor send : Press this key to start the motor for easily insert the elastic tape.
- 14 Motor stop : During the Start lamp is lighting, press this key to stop the motor.(To check the RPM figure, press the Pre.Tension function key after press the motor stop.)
 Pre. Tension : During the Set lamp is lighting, press this key to set the Pre. Tension.
 (For the detail,please refer to the function guide in page 14,15.)
- 15 Function : Press this key to set the functional for all sewing type.(Please refer to the functional guide in page 4-6.)
- 16 \perp : Press this key to trim during each sections. (For example: When sewing the both side of the under pants.Please refer to the operating guide on page 12-13.)

功能鍵內容說明 FUNCTION KEY DATA INDEX

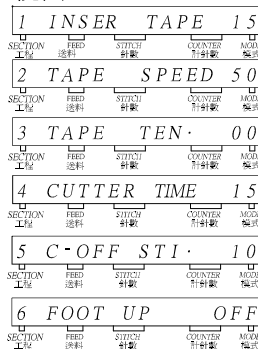
功能鍵內容一

- 1 送帶的長度設定 (00=35mm 每增加1=1mm 99=134mm)
- 2 進帶的速度設定 (00=50mm/s 每加1=1.9mm/s 99=238mm/s)
- 3 送料後回拉長度的設定 (00=0 每增加1=0.35mm 99=34mm)
- 4 切刀時間設定 (00=0.1秒 每增加1=0.005 秒 99=0.6秒)
- 5 切刀後繼續車縫的針數(車縫切刀和車針間的鬆緊帶00=0針 99=99針)
- 6 縫畢後壓布腳自動提升或不自動提升的選擇

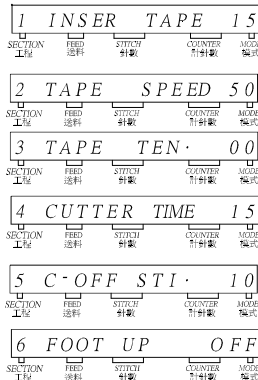
Context 1 of Function Key

- 1 SETTING THE LENGTH OF THE INSERT TAPE
(00=35mm Every 1 unit =1mm up to 99 units =134mm)
- 2 SETTING THE SPEED OF THE INSERT TAPE
(00=50mm/s 1 unit=1.91mm/s to 99 units=238mm/s)
- 3 SETTING THE PULL BACK LENGTH AFTER FEEDING
(00=0) Every 1 unit=0.35mm up to 99 units=34mm)
- 4 CUTTER TIMER(00=0.1 SEC. Every 1 unit=0.005sec.
up to 99 units=0.6 sec.)
- 5 C-OFF STI. (The elastic tape between the trimmer and
needle. 00=0stitch up to 99=99stitch)
- 6 FOOT UP (After finish sewing, the foot can be
lifted up automatically or not by owner's choice.)

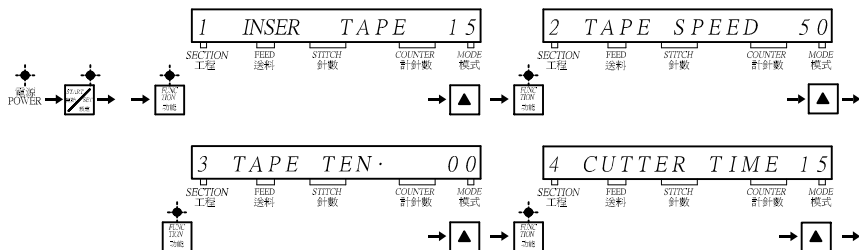
視窗

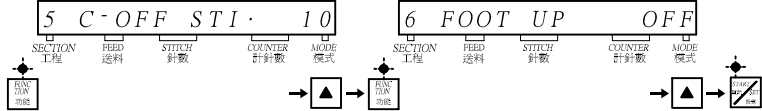


WINDOWS



操作說明 OPERATION GUIDE





功能鍵內容二:按功能鍵二秒,修改出貨時已設定內容

Context 2 of Function Key:Press this key 2 sec

to changing pre-programed.

A. 補償針車高低速縫製時所產生的針目誤值

(車速愈快針目會愈大)

A. Compensation for the error stitch of the high/low sewing speed

(Higher speed then Bigger stitch)

圖一

Map 1

操作說明

OPERATING INSTRUCTIONS

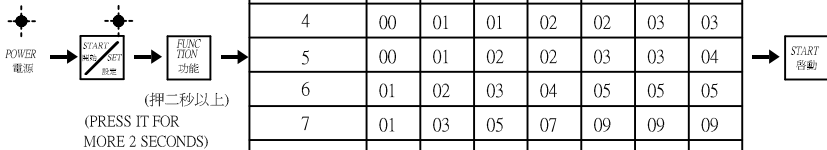
送料補償表

Compensation list

*:出貨時設定

*:Pre-programed

馬達轉數 Mode R.P.M. 模式編號	3000	4000	5000	6000	7000	8000	9000
*0	00	00	00	00	00	00	00
1	00	00	01	01	01	01	01
2	00	00	01	01	02	02	02
3	00	01	01	01	02	02	02
4	00	01	01	02	02	03	03
5	00	01	02	02	03	03	04
6	01	02	03	04	05	05	05
7	01	03	05	07	09	09	09
8	01	04	07	10	13	13	13
9	01	04	08	11	13	13	13



B.送料範圍選擇

B.Choose the Feed Range

圖二

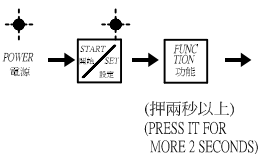
Map 2

操作說明

OPERATING INSTRUCTIONS

*:出貨時設定

*:PRE-PROGRAMMED



模式編號 Mode	送料範圍 Feed Range	適用針車 Applicable machines
0	0.2mm-1.2mm	四點人字車 Zig-Zag4point stitch
*1	0.4mm-1.4mm	四點人字車 Zig-Zag4point stitch
2	0.4mm-2.4mm	二點人字車 Zig-Zag2point stitch
3	0.6mm-2.6mm	二點人字車 Zig-Zag2point stitch
4	0.6mm-3.1mm	
5	0.8mm-3.3mm	一般平車 Flat bed
6	1.0mm-3.5mm	
7	1.1mm-3.6mm	縫邊車 Overlock
8	1.2mm-3.7mm	
9	1.3mm-3.8mm	

START
啟動

使用說明(本說明內容將由簡單漸進複雜方式)

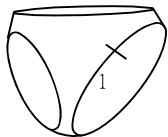
OPERATION GUIDE (IT WILL BE FROM EASY TO COMPLEX.)

例一.

內容：單一工程為手動.

EXAMPLE 1.

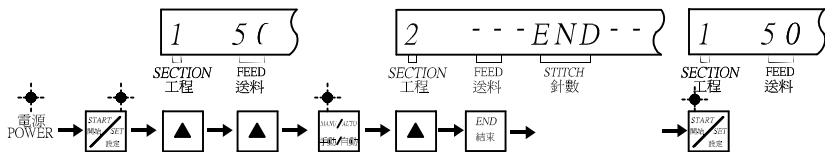
CONTEXT : SINGLE SECTION FOR MANUAL.



工程 SECTION	送料 FEED	針數 STITCH
1	50	

操作說明

OPERATION GUIDE

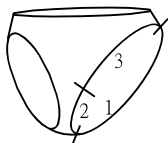


例二.

內容：一,二,三段工程均為手動.

EXAMPLE 2.

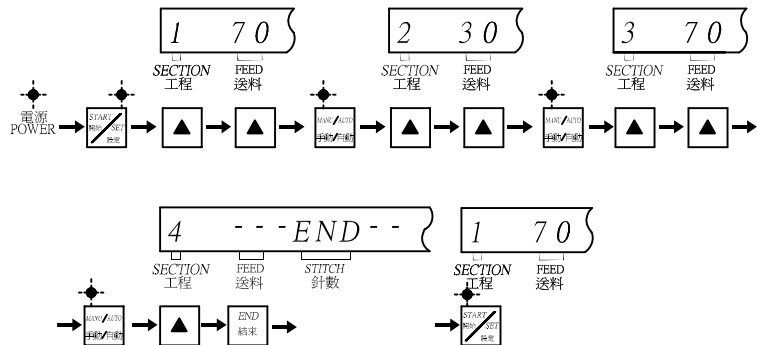
CONTEXT : ALL THREE SECTIONS ARE MANUAL.



工程 SECTION	送料 FEED	針數 STITCH
1	70	
2	30	
3	70	

操作說明

OPERATION GUIDE

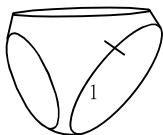


例三.

內容：單一段工程為自動。

EXAMPLE 3.

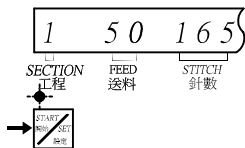
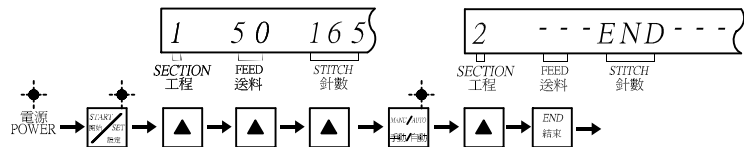
CONTEXT : SINGLE SECTION FOR AUTO.



工程 SECTION	送料 FEED	針數 STITCH
1	50	165

操作說明

OPERATION GUIDE

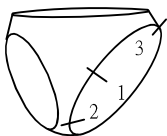


例四.

內容：一,二,三段工程均為自動.

EXAMPLE 4.

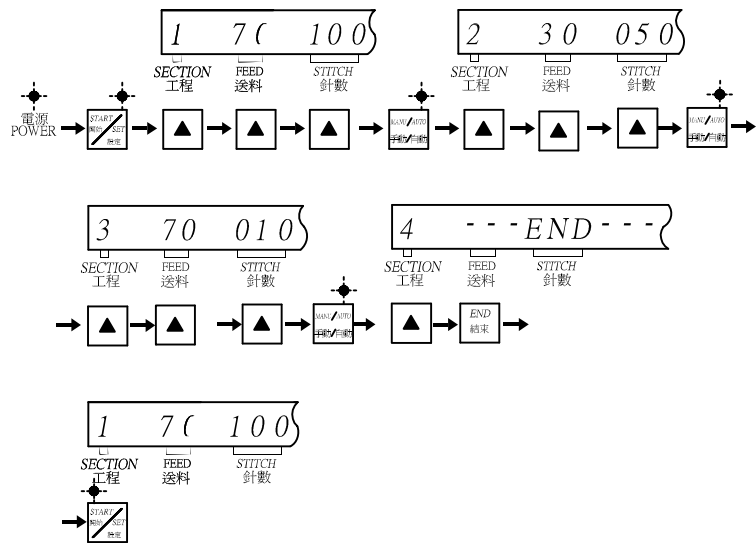
CONTEXT : ALL THREE SECTIONS ARE AUTO.



工程 SECTION	送料 FEED	針數 STITCH
1	70	100
2	30	50
3	70	10

操作說明

OPERATION GUIDE

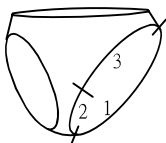


例五.

內容： 第一,二段工程為自動;第三段手動.

EXAMPLE 5.

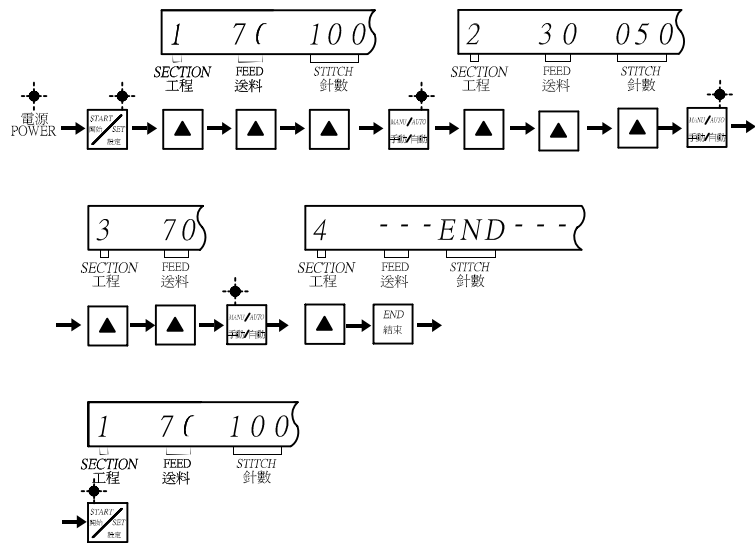
CONTEXT : SECTION 1,2 ARE AUTO;SECTION 3 IS MANUAL.



工程 SECTION	送料 FEED	針數 STITCH
1	70	100
2	30	50
3	70	-

操作說明

OPERATION GUIDE



例六.

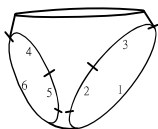
- 內容：
1. 褲口左右二邊縫製.
 2. 工程內容資料儲存於"A"
 3. 第 1,2,4,5 工程為自動.

- 本例設定：
1. 針車起動後馬達自動回拉(註一).
 2. 切刀後30針壓腳自動提升及自動進帶(註二).

EXAMPLE 6.

- CONTEXT：
1. SEWING TWO LEG OPENINGS OF SLIPS.
 2. SECTION DATA STORED IN "A"
 3. SECTION 1,2,4,5 ARE AUTO.

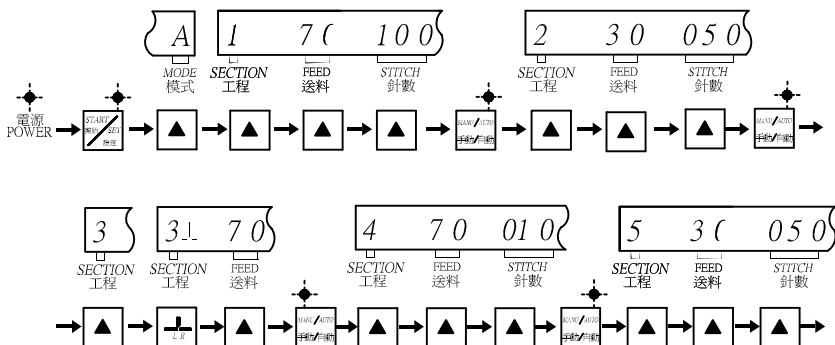
- EXAMPLE：
1. AUTO PULL BACK AFTER STARTING THE MACHINE. (REMARK 1.)
 2. AUTO LIFTING AND FEEDING AFTER CUTTING AND 30 STITCHES AFTERWARD. (REMARK 2.)

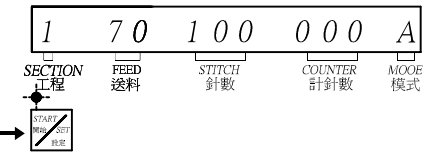
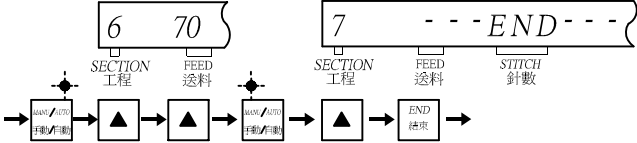


工程 SECTION	送料 FEED	針數 STITCH
1	70	100
2	30	50
3	70	-
4	70	10
5	30	50
6	70	-

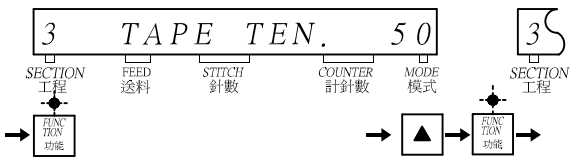
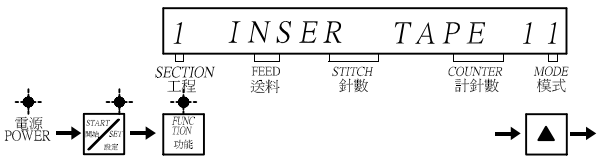
操作說明

OPERATION GUIDE

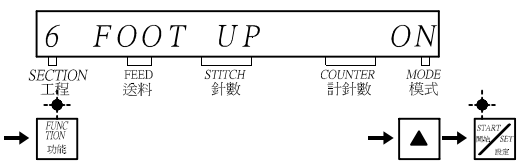




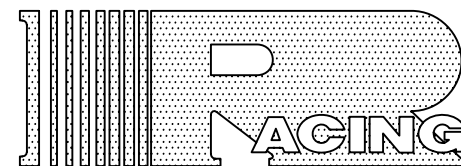
註一



註二



MCL 20
MCA 18Z-19



使用手冊
MANUAL

鬆緊帶換段修正功能：修正車縫時換段造成鬆緊帶誤差。

ADJUSTABLE FUNCTION AT INTERCOURSE SECTION
OF ELASTIC BAND : Correct stitching differential at
intercourse section of elastic band.

1. 功能說明：

為解決在多段車縫過程中，變換不同工程段落時，鬆緊帶將會產生緩衝段的誤差，可借由此功能來回拉或補償緩衝段的誤差。

1. Function Explanation :

To eliminate the difference at multi-section stitching while elastic band yields carved in and out, this function serves as a reparation and/or offsetting difference by pull and push back and forth.

2. 修正方式：

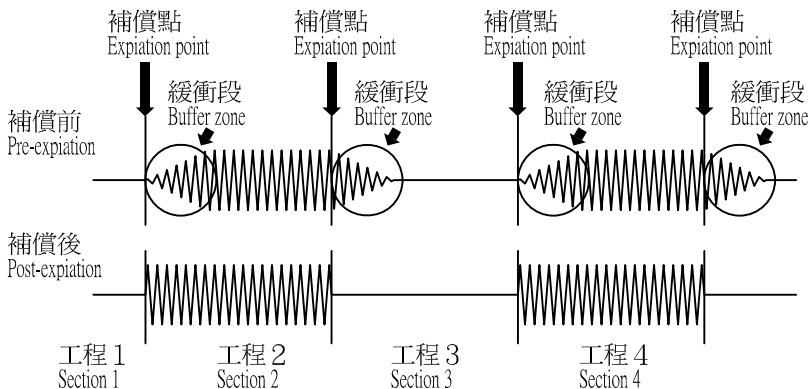
- A. 工程 1 換到工程 2 時由工程 1 修正。
- B. 工程 2 換到工程 3 時由工程 2 修正。
- C. 工程到最後一段返回工程 1 時由最後一段修正。

註：鬆緊帶修正值 0=0MM，每增加 1 為 0.3 5MM。(回拉或補償自動判斷)

2. Correction Module :

- A. Transit from 1st segment to 2nd segment:adjust from segment one.
- B. Transit from 2nd segment to 3rd segment:adjust from segment two.
- C. Rationalize above operation until it goes back to segment one:adjust from the last segment.

Note:Elastic Band correction value:0=0mm,evey extend one depicts 0.35MM.(Automatic judgment for pull or push compensation)



操作說明：

OPERATION GUIDE：

例：工程段落修正值為 50。

Example: Section correction value reads 50.

