



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

自动门襟装饰线缝机

Automatic Fly Piece Unit



# INTRODUCTION

Thanks for the purchase of this industrial sewing machine made by VI.BE.MAC. S.p.A.

Before beginning to operate with this automatic unit, it is requested to read this manual, so that it can help you to understand the operation of the unit. They will illustrate to you the method of job to follow in the respect of the current regulations.

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Should you require an additional copy of this manual or clarification on any general or technical point contained within the manual, please contact.

"Suggestions and/or recommendations on ways to improve the following manual would be appreciated".

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# 1 GENERAL MACHINE SPECIFICATIONS

This unit can be programmed along two axes, it can carry out “J” seam on the front fly panel, on jeans, casual trousers and workwear, with double parallel stitches or non-parallel stitches.

This machine permits to create a customized “J” pattern with the maximum freedom of style, the default jig has good applicability, and both the left and right “J” pattern on the front fly panel can be sewn, satisfying any fashion request, with no cost in terms of extra jigs.

It can be transformed for operations like back pocket embroidery, sewing darts and pleats, run flap stitch, simply by purchasing the necessary parts.

## 1.1 SUPPLY VOLTAGE

Supply Voltage	
Voltage	220V $\pm$ 10%, 50/60 $\pm$ 2%
Power	800W $\pm$ 10%

## 1.2 COMPRESSED AIR CONSUMPTION AND PRESSURE

Consumption: 10L/min

Pressure: 5.5bars

## 1.3 TECHNICAL SPECIFICATIONS

Max. Sewing Range	220 x 100 mm
Fly Width	26-46 mm (Default)
Needle	DP x 17#19
Stitch Length	0.05-12.7 mm
Max. Speed	2700 rpm

# 2 CONDITIONS FOR USE

(1) Power supply

- The power supply is constant and does not fluctuate by more than 10%.
- The power supply capacity must be able to ensure that it is within the specified capacity.

(2) Power disturbance

- Keep away from radio wave transmitters and high frequency devices that emit strong radio waves and magnetic fields.

(3) Temperature and humidity.

- The machine must not operate at high temperatures (above 40 °c) or low temperatures (below 10 °c).
- Outdoors or places that will not be directly exposed to sunlight.
- Keep away from electric heaters.
- Places where the relative humidity is above 45% or below 85%, and places without dew.

(4) Air

- There is no corrosive or less dusty place.
- Places not prone to gas explosion or oil explosion.

(5) Vibration

- If excessive vibration is likely to happen in the place where the sewing machine is placed, move the control box to another place.

(6) Power cable

- Do not press the power cable or twist the power cable excessively.
- Before turning on the machine, be sure to check whether the voltage of the power source to be connected is the same as the voltage marked on the control box, and then the power can be supplied after confirmation. If it is connected to a power transformer device, it should be checked before powering on. At this time, the button-type power switch on the sewing machine must be [OFF].
- In order to prevent noise interference, and electric shocks caused by leakage, the grounding wire on the power cable must be properly grounded.

(7) Disassemble

- When you want to remove the motor or control box, you must first turn off the power and unplug the power plug.
- Do not only pull the power cable when unplugging the power plug, you must hold the power plug with your hands and pull it out.
- There is dangerous high voltage in the control box, so if you want to open the control box cover, you must turn off the power and wait for more than 10 minutes before opening the control box.

(8) Maintenance and repair

- Do not pile up debris near the vents of the dust-proof net of the control box to block air circulation, especially dust, paper scraps, bushes, etc. on the dust-proof net.
- Only qualified personnel are permitted to commission the machine and carry out extraordinary maintenance work.

### 3 BASIC SCREEN AND KEY OPERATION INSTRUCTIONS

Description of Main Page - P1

Pattern Style Name      Pattern S/N

PI      16:11

名称 TEST      120      ← 120 →      Pattern S/N Switch

TYPE : B      00000      ↔ 300.0 mm

移送      ↓ 00837 00842      ↓ 200.0 mm ≤ 2506.9

Press and hold this area to move, you can drag the pattern into the display area; Press and hold any position without moving, you can return to the default full-screen display

Point Moving

Sewing Speed

5

Display Needle Drop Point

Hide needle Drop Point

Inner /outer clamp up/down

Enter Menu P3

Back to 0      Enter Round Positioning Page      Enter Setting P4      Thread Tension      Presser foot Setting (Long press to enter threading mode)

CODE	Needle number	All needle number	Y direction range	Total length of sewing
TYPE : B	00000	00000	↔ 300.0 mm	
FEND	↓ 00837 00842		↓ 200.0 mm	≤ 2506.9

Current needle number      X direction range

Show Pattern form



...Press this key to enter the screen for modifying the reference value of the presser foot.



(This function is disabled when the presser foot is lowered. If you need to modify the reference value of the presser foot, please adjust the presser foot to the up position.)

**【Warning: When threading the needle, never press the pedal, it will cause the sewing machine to run, which is very dangerous, so be sure to move your foot away from the pedal when threading】**

## 4 SELECT FUNCTION SYSTEM

### 4.1 READ AND SELECT PATTERN

Instructions

- In the initial page P1 press , enter P3,
- Press  to enter pattern select page
- Select pattern name and S/N, and confirm
  - The pattern can be read from the internal memory or USB etc.;
  - When the pattern S/N is from USB is the same as the existing number in the internal memory, it will display [Overwrite, replace the original graphic data? ]
- Complete



...Press this key to enter the quick pattern reading page (only the internal memory is valid)



...Press this key to enter the modification view bar code page (only select internal memory is valid)




...Press this key to enter the delete designated pattern page



...Press this key to set whether to update the display pattern simultaneously.



### 4.2 DELETE PATTERN

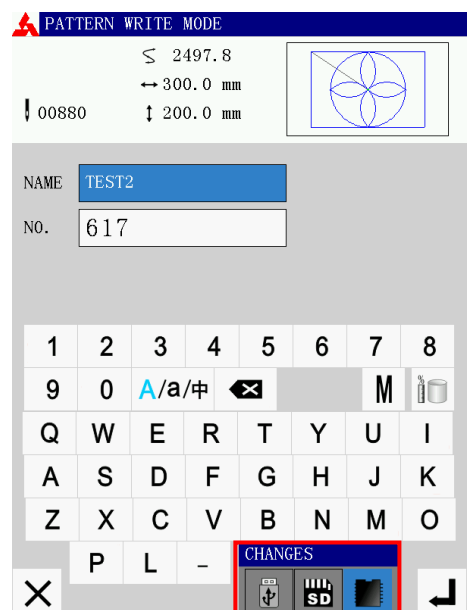
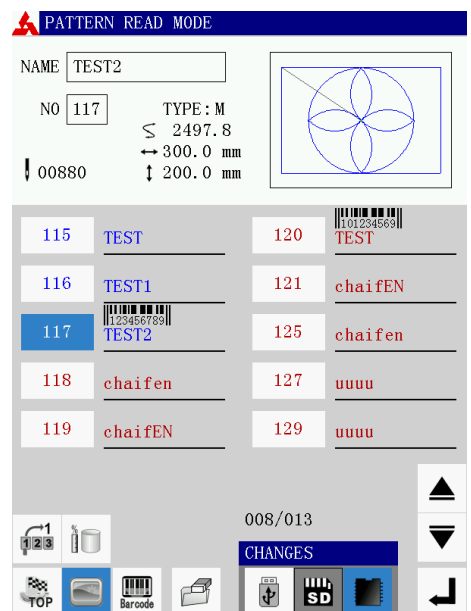
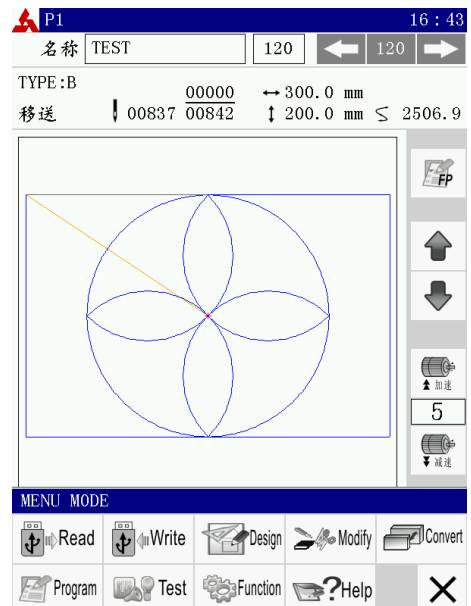
Instructions:

- Select pattern to be deleted, press 
  - It will display 【Delete sewing data in internal memory? 】 or 【Delete sewing data on USB and other disks?】
- Press confirm to delete

### 4.3 WRITE PATTERNS

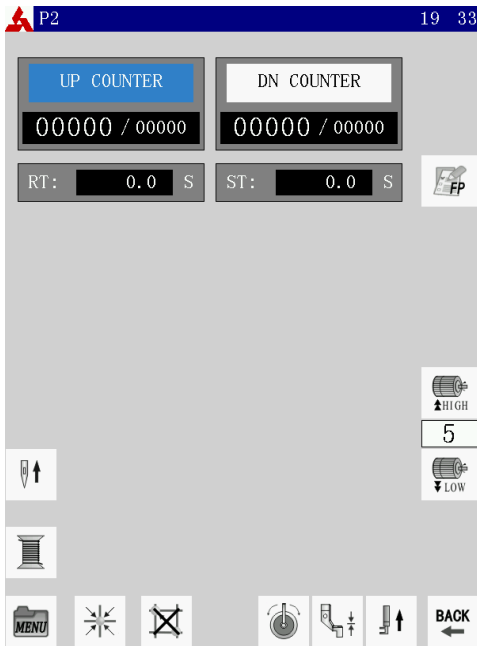
Instructions:

- In the initial page P1 press , enter P3,
- Press  to enter pattern writing page
- Start to write pattern

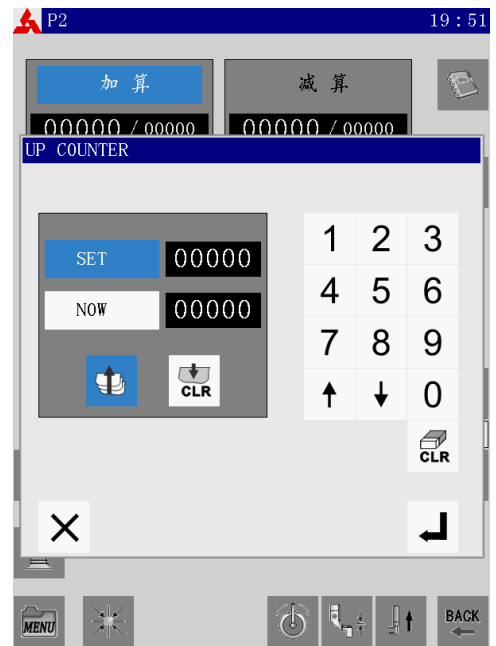


- When writing a pattern to the internal memory, if same name is also in the internal memory, it will display 【Overwrite/replace the original graphics data in the memory? 】【
- When writing a pattern to the SD card, if same name is also available on the SD card, it will display 【Overwrite/replace the original graphic data of the SD card? 】【
- After the displayed message of 【SD card is writing sewing data... 】【, it will return to the standard page

## 4.4 STITCHES SETTING



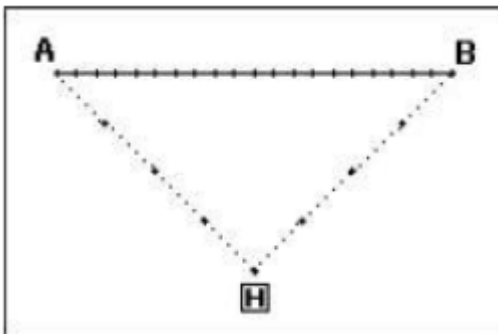
In the left pic, P2, press UP COUNTER, to enter the right pic page, press the setting key, and use the number keys to input the set value.





## 5 SEWING PROGRAMMING

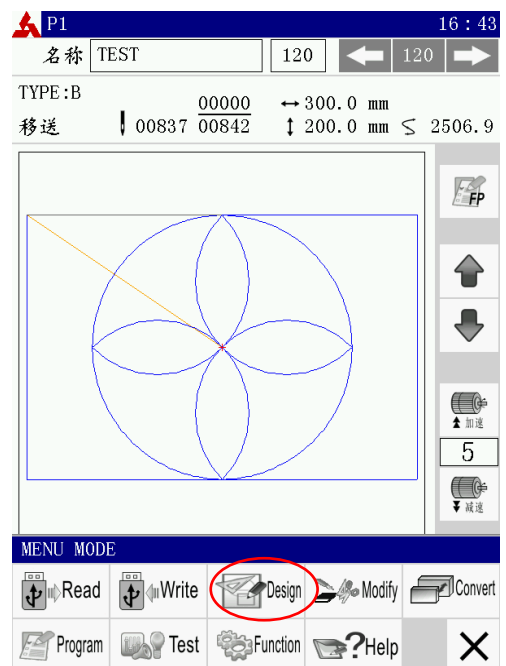
### 5.1 MAKE A SEWING PROGRAM

Lower the inner clamp and outer clamp:

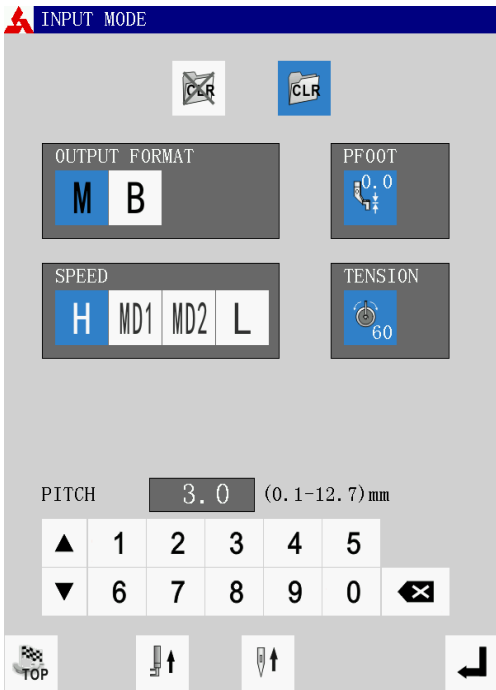


1、 In the initial page P1 press , enter P3,;

2、 Press  to enter pattern making







...Compile and design based on the original pattern



...Make a new pattern



...Set sewing speed in this icon

H: High Speed MD1: Medium speed  
MD2: Low to medium speed L: Low speed

Set stitch length, use number keys, and up & down arrow keys to set the stitch length from 1(0.1mm)—127(12.7mm)



...Intermediate presser-foot reference value setting



...Thread tension reference value setting



...Press to enter initial page



...Press this key to adjust the lifting of the presser foot (change the up and down direction according to the arrow)

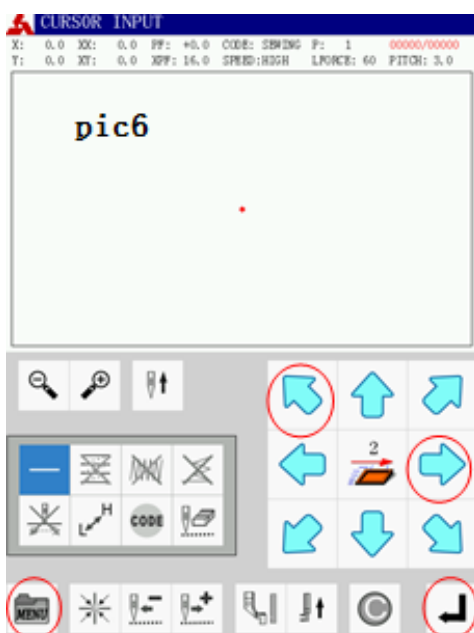


...Press this key to set the needle stop position (the arrow will indicate the current needle stop position)

3、 After setting the above data, press



to confirm and enter the Input PIC 6 (moving key input page)




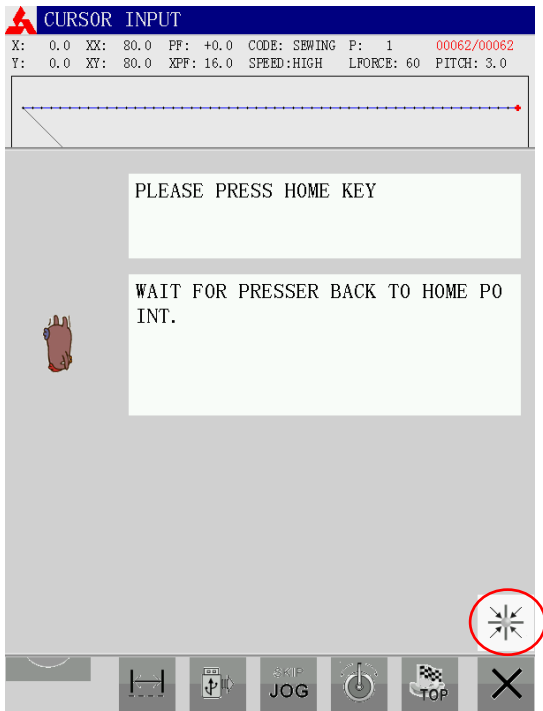
When the Input PIC 6 is displayed, the machine is automatically set to FEED. Now use the arrow keys to reach point A and press the confirm key to confirm. (It means that the feeding data from home position to point A has been completed.)

- At this point the code changes from FEED to SEW, now move to B point using the directional arrow, and press the confirm key to confirm. (In this way we have created a straight line from A to B now)

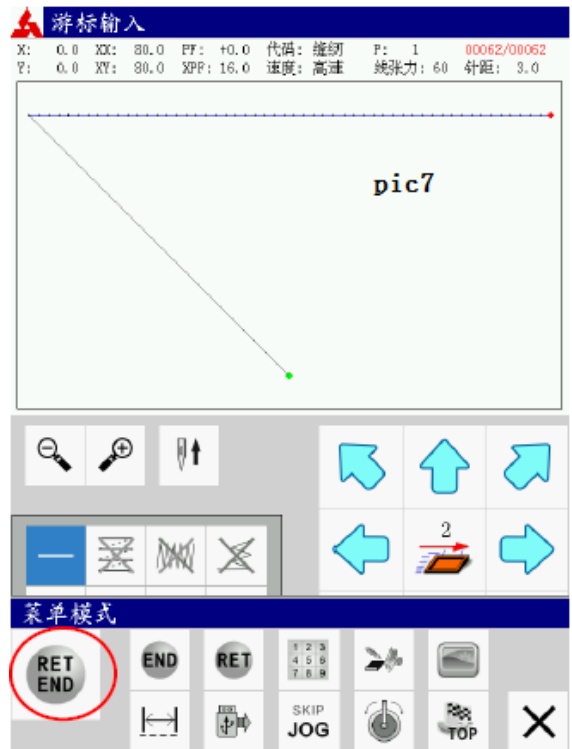
4、 Press  , enter Pic 7.

Press  to end the program and complete pattern input.

Pic 8 appears , press Home Position  , the machine returns to Home Position



Pic8



**! ATTENTION :**  
**After clicking the RETEND button, the machine will automatically reset back to the original position, so make sure that the needle is in the high position before clicking to avoid breaking the needle.**



5、 Save pattern

- Display the name and number of the original pattern
- Selection of saving method

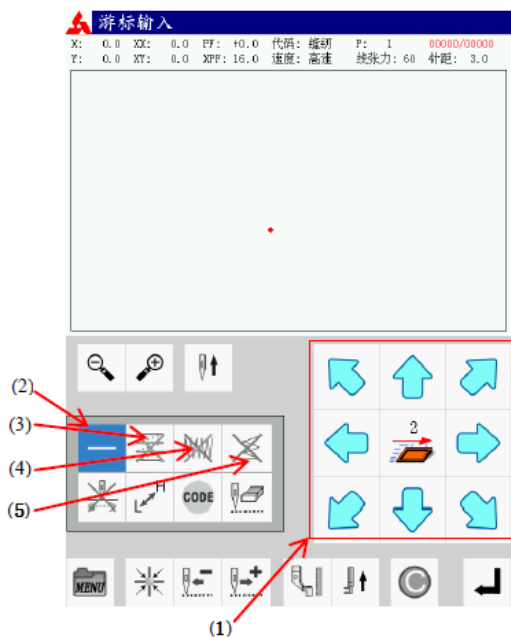
OVERWRITE: The generated pattern will overwrite the original numbered pattern in the memory.

SAVE NEW PROGRAM: will go to the pattern composing screen, set the name and number of the saved pattern.

EXIT WITHOUT SAVING: Update the designed pattern to the memory, but do not save the pattern.

- Confirm and back to Page 1
- Complete

## Extra explanation of input Pic 6:



The relationship between the stitches at the current needle position and the total number of stitches:

◆ If at the end position, the number of stitches at the current needle position = the total number of stitches:

[X ,Y] : Display the movement amount which moved by the movement keys

[ PF ] : Display the current change amount of the presser foot in the design:

[CODE]: Display the currently set input status;

[ P ] : Display the number of input points for polyline, arc, curve, etc.

◆ If during the Inch Move, the number of stitches at the current needle position < the total number of stitches

[X ,Y] [ PF ] [CODE]: the currently set input status

XX : Current coordinate value of platform X

YY : Current coordinate value of platform Y

XPF : Current height of the middle presser foot

(1) [Direction key] Press this key,the cursor moves

(2) [Input method setting key]

Currently set basic sewing input method. (Input of point, straight line, broken line, circle, curve, irregular curve, etc.) When you press this key, it will switch to the sewing method setting page.

(3) [Multi-segment sewing input, auxiliary sewing input setting key]

Currently set in multi-segment sewing input and auxiliary sewing input methods. Press this key to switch to the detailed setting page of multi-segment sewing and auxiliary sewing.

(4) [Z sewing setting key] Currently set in Z sewing input

(5) [Front and rear reverse sewing input setting key]

Currently set in Front and rear reverse sewing

(6) [CODE] explanation

FEED--- Idle delivery (transfer without stitching)

FEND--- Idle delivery finish (will display in inching move)


SEW ---basic seam (point, straight line, broken line, circle, curve, irregular curve, etc.)


P ---Multi-segment sewing - same direction      I --- Multi-segment sewing – different direction

O --- auxiliary sewing

Z ---Z sewing

B --- Front and rear reverse sewing

 [Cancel key]: When you press this button, you can cancel the last input operation that has NOT been confirmed, and return to the previous input point.

 [Cancel key of the last input point]: Press this key to cancel the last CONFIRMED input point and return to the previous input point.



[Speed set key]: Press this button to change the speed: H-L-MD2-MD2-H...



[Additional function setting key]: Press this button to converted into a code setting module.



[Presser foot setting key]: Press this key to enter the middle presser foot setting page.



[Inching back button]: Press this key, the jig will move backward according to the graphic track



[Inching forward button]: Press this key, the jig will move forward according to the graphic track



[Zoom out]: Press this key to zoom out the graphic



[Zoom in]: Press this key to zoom in the graphic



... Press this key to set the needle stop position upper or lower (the arrow will indicate).



...Pressing this key to create the function data of returning to the origin from the current position and ending, complete the pattern input module.



...Press this button to make the finished function data and complete the pattern input module.



...Pressing this key will create the data sent back to the origin from the current position.



...Press this key to switch to the input screen with the number keys.



...Pressing this key will switch to the screen of moving key input.



...Press this key to enter the correction module page to revise the input pattern data.



...Press this key to enter the graphic display page.



...Press this key to switch to the page for changing the stitch length.



...Press this key to enter the call-out function page, and the call-out of the existing pattern data will be added to the back of the pattern being input.








...Press this key to switch to jump inching setting page.



...Press this key to switch to thread tension setting page.








## 5.2 PROGRAM A “J” SHAPE STITCH


- 1、 Lower the inner and outer clamp;
- 2、 Follow step5.1 to enter Pic 6;
- 3、 Check **【CODE】** should be FEED(empty transfer), if not, press  , **【CODE】** will change to FEED;
- 4、 Press arrow key to reach Point 1(see **Pattern 1, page11**), press  to confirm;
- 5、 Press  , select sewing mode, it will display Pic 9.


at this point should select Straight Line  , press  to confirm;

**Remarks:** There are 7 icons in the first line, respectively representing:


Table 1


Name	Icon	Description
Stitch Length		Stitch Length
Straight Line		Input 2 points positions: start point and end point of the line, to create a straight line between the two points
Curve		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		Input 3 points positions: start point, another 2 points on the circle, to create a circle line base on the 3 points
Irregular Curve		Input start point and other points(max. 127 points) on the curve line
Broken Line		Input start point and other turning points, all the points will be connected by straight lines
Point		Stitch by stitch *Within 12.7mm*

- 6、 Press arrow key to reach Point 2 (see Pattern 1, page11), press  to


confirm; Press  , select sewing mode, it will display Pic 10,

At this point should select Curve Line  , press  to confirm.

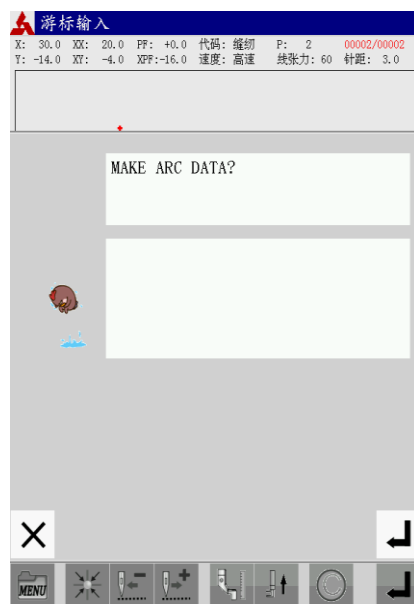
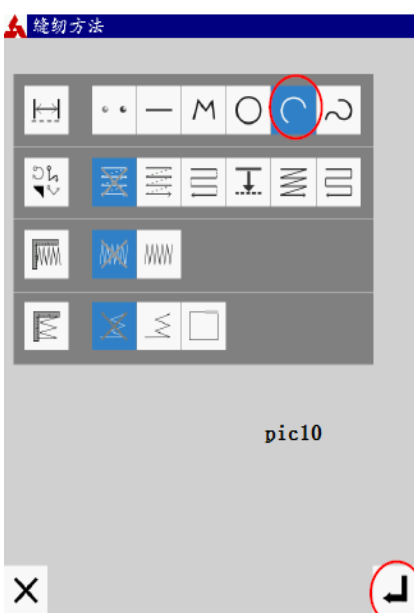
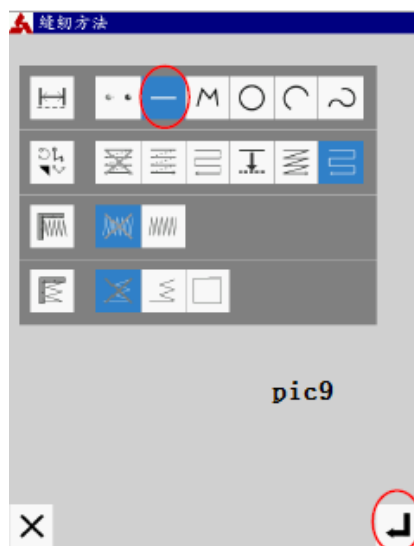
- 7、 Press arrow key to reach Point 3 (Pattern 1, page11), press  to confirm.










- 8、 Press arrow key to reach Point 4 (Pattern 1, page11), press  to confirm. It will display **【MAKE ARC DATA?】**

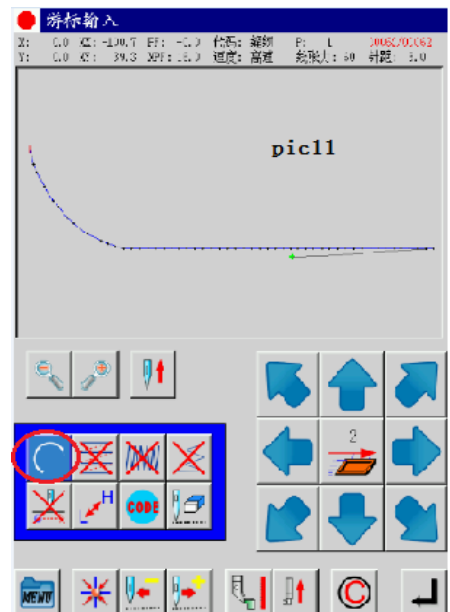
- If press  , it will back to the input page of Point 4





- If press  , it will start to do the curve line.

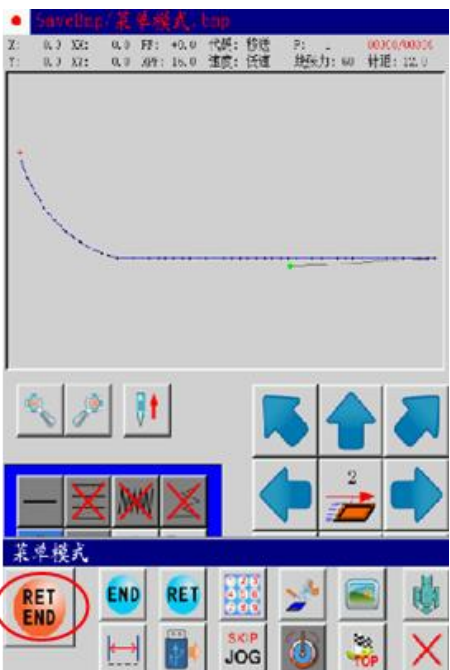
It will display **【Data creating】** , **【Please wait】**





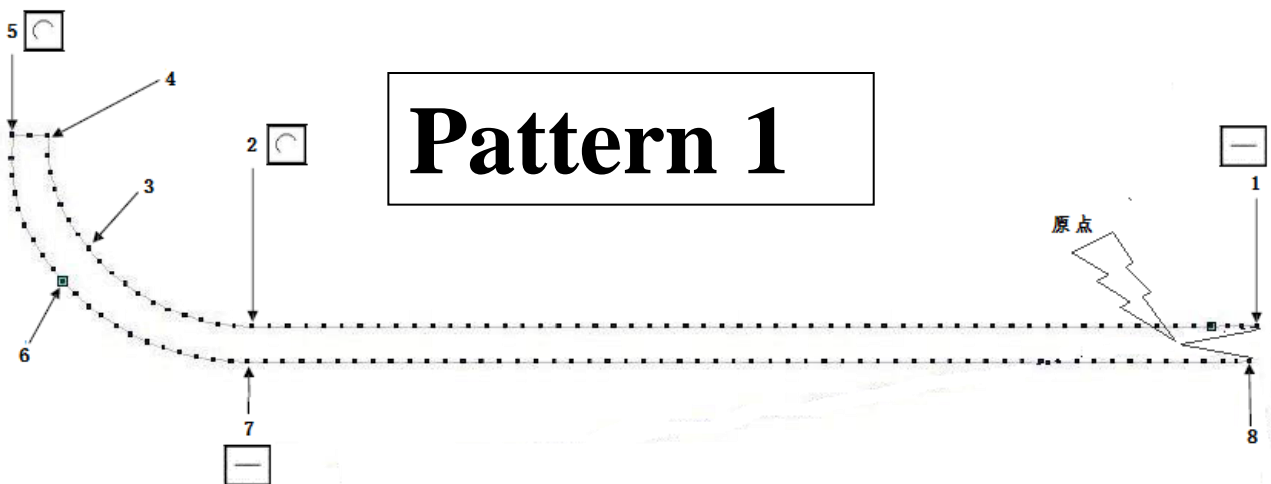
- 9、 Press  to select required sewing line,  
 at this point should select Straight Line , press  to confirm
- 10、 Press arrow key to reach Point 5 (Pattern 1, page11), press  to confirm.
- 11、 Press  to select required sewing line, Pic 9 will come,  
 at this point should select Curve Line , press  to confirm
- 12、 Press arrow key to reach Point 6 (Pattern 1, page11), press  to confirm.
- 13、 Press arrow key to reach Point 7 (Pattern 1, page11), press  to confirm. Then it will display **【MAKE ARC DATA?】** .









- Press  to select required sewing line, at this point should select  
 Straight Line , press  to confirm
- 14、 Press arrow key to reach Point 7 (Pattern 1, page11), press  to confirm. Then it will back to Input PIC 6 (moving key input page);

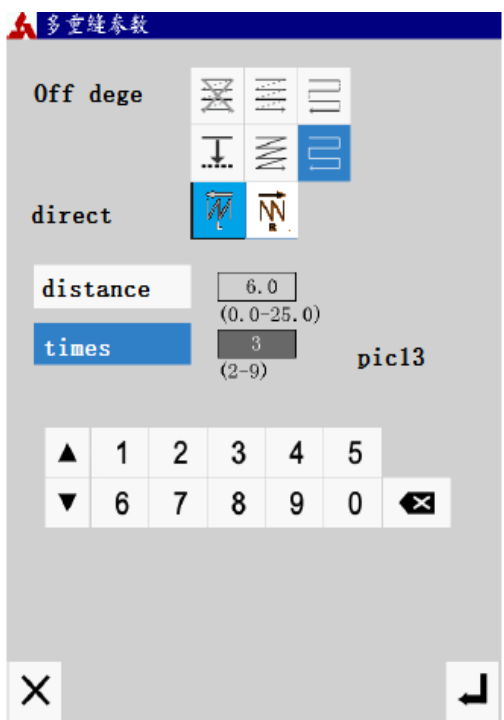
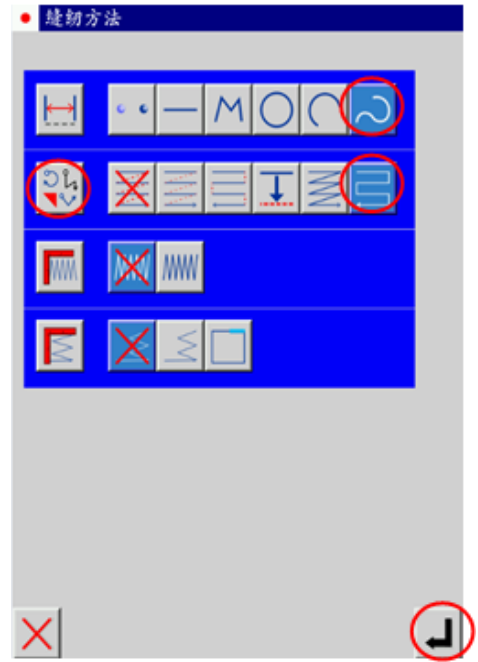





- 15、 Press  to enter PIC 7, then press  ;
- 16、 Input name and drawing number, and save the pattern.






### 5.3 PROGRAM MAKING WITH OTHER FUNCTIONS

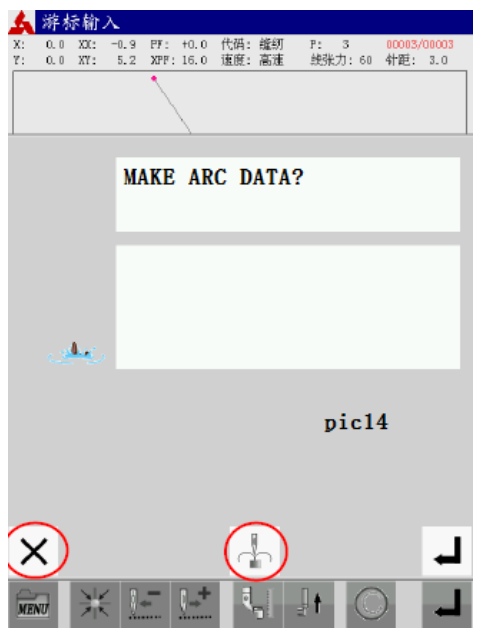
- 1、 Lower the inner and outer clamp;
- 2、 Follow step5.1 to enter Pic 6;
- 3、 Check **【CODE】** should be FEED(empty transfer), if not, press , **【CODE】** will change to FEED;
- 4、 Press arrow key to reach Point 1(see **Pattern 2, page13**), press  to confirm;
- 5、 Press  to select required sewing line;
- 6、 Press  to select irregular curve, then select other function in the second row of icons(see Table 2), press  to select Reverse direction multi-stitch, press  to set the detail parameter of multi-stitch(Pic 13);











- 7、 Press  to select reverse direction multi-stitch, and press , then set needle gauge and number of repetitions, here we set 2 times, press  to confirm; it will back to sewing method setting page.

- 8、 Press  to confirm, it will back to the moving key input page; use arrow key to reach point 2(see **Pattern 2, page13**), press  to confirm;

Press  again, Pic 14 will display:




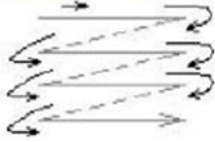

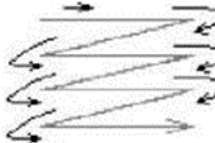

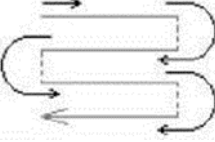


- 9、 Press , set the point 2 as the curve start
  - Press arrow key to reach Point 3 (Pattern 2, page13), press  to confirm.
  - Press arrow key to reach Point 4 (Pattern 2, page13), press  to confirm.
  - Press arrow key to reach Point 5 (Pattern 2, page13), press  to confirm.
  - Press arrow key to reach Point 6 (Pattern 2, page13), press  to confirm.
- Pic 14 will display, showing [Create curve data? ], press  ;

14、press , when back to zero point nearby, press  ;



15、Press , and press , and press  ;

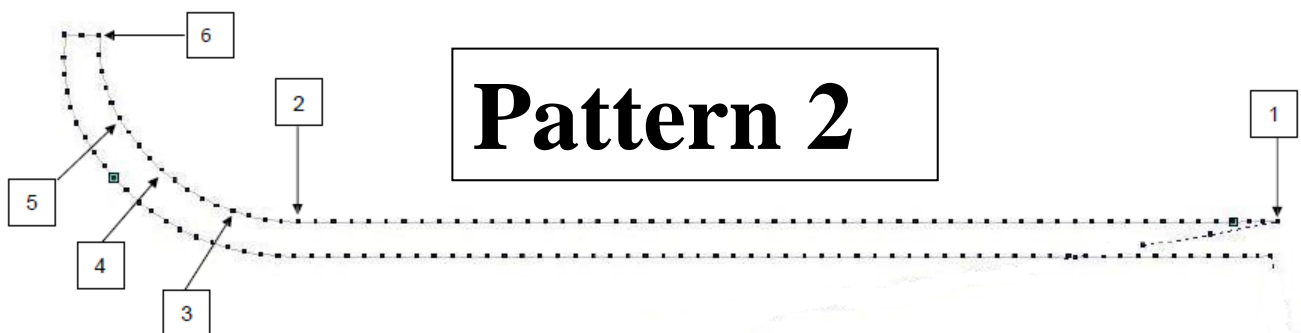
16、Save program;

**Table 2:**

Type	Connection	Icon	Stitching line	Description
Multiple Stitching (Same direction)	Line to line connected			After trimming the first sewing line, [Idle feed] jumps back to the starting point of the second sewing line to do the same direction sewing
	Line to line separated			After the first sewing line, the thread will not be trimmed, and continue to sew to the starting point of the second sewing line for continuous sewing in the same direction
Reverse direction multi-stitch (Reverse direction)	Line to line connected			After trimming the first sewing line, [Idle feed] jumps back to the starting point of the second sewing line to do the reverse direction sewing
	Line to line separated			After the first sewing line, the thread will not be trimmed, and continue to sew to the starting point of the second sewing line for continuous sewing in the reverse direction

Remarks (Pic 13):

- Make a multi-segment stitch on the left side of the direction of stitching, need to press  for left;
- Make a multi-segment stitch on the right side of the direction of stitching, need to press  for right;
- Needle gauge: distance between two near sewing line, it can be set at 0.0-25.0mm. To set the distance, first press the distance key to select it, and then use the number keys or up and down keys to set;
- Cycle times: The times of multi-segment sewing, can be set between 2-9 times.

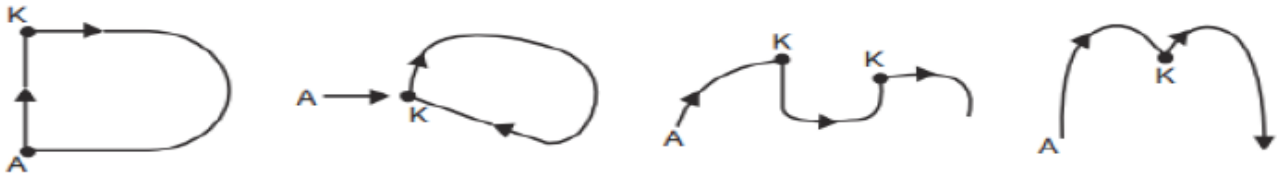




### Supplementary explanation of program editing:

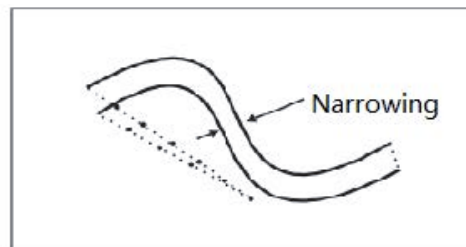
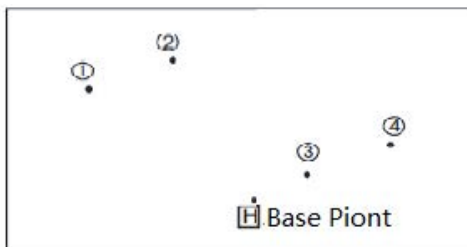
- ◆ If the distance between the start point and the end point of the curve input is less than 0.5mm, the [closed graph] will not be completed, and the start point and the end point will automatically be on the same coordinate.
- ◆ When curve input, the various shapes as shown in the figure below, the corner of point K should be set as the start of curve input(paragraph point).

(In auxiliary sewing, same direction multi-segment sewing, and reverse multi-segment sewing, if there are discontinuous points, they can also be input by paragraph points.)

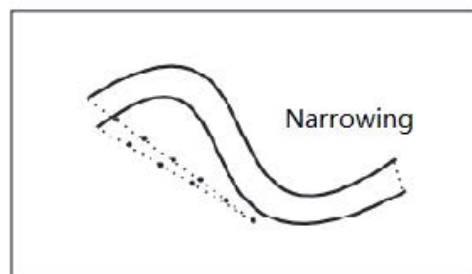


- ◆ When inputting a point, the distance between the point and the point should be within 12.7mm.
- ◆ Reverse stitching before and after sewing, multi-segment stitching, auxiliary stitching, and zigzag stitching can be used in combination with basic input. Pattern programming can be easily completed, but these application inputs cannot be mixed during point input.
- ◆ Patterns combined by curve input and multi-segment sewing:

As shown in the below left picture, after empty feeding from the origin to the position ①, use the curve input to do the multi-segment sewing 10mm through the positions ②, ③, and ④. If set 2 times, it will be made into a pattern as shown in the below right picture, the distance will become [narrower] at some part.



If the [narrow] part requires the same distance, you can input more ② between ② and ③ to make a pattern like below right picture.



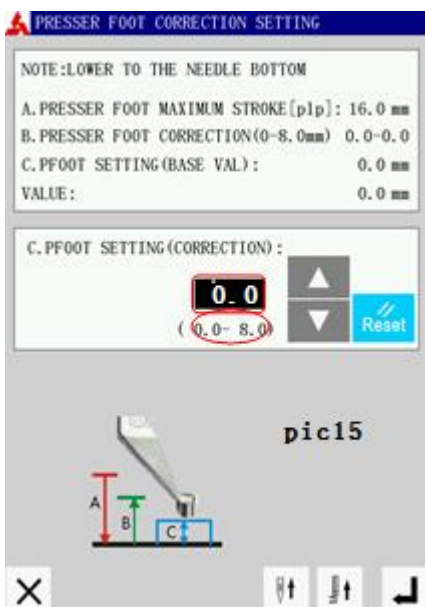
Therefore, when the conditions of multi-segment [distance], [circle times], and curve input points are different, there will be different changes, please try more.

## 5.4 PRESSER FOOT REGULATION DURING PROGRAMMING MODE


The movement of the presser foot is determined by a step motor that works directly on the presser foot bar.

### ATTENTION


Before adjusting the presser foot height control that THICKNESS on the main menu is set on **0** mm




#### 1、Setting presser foot height

◆ Press  to enter Pic 15, increase or decrease the value using the arrow keys, once settled the value to **0mm**. (In the process of adjustment, the presser foot height value will change)


◆ Press  to confirm;


◆ If press , the height will reset to previous value


Note: When adjusting the height of the presser foot, must first set the presser foot to the lowered position, if it is not, press .

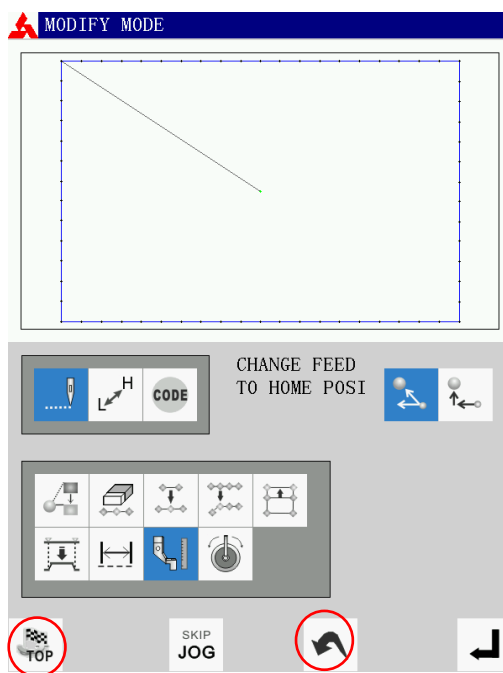
#### 2、Correction of the height of the intermediate presser foot

◆ First enter the correction module (please refer to the method of entering the correction module);

◆ Press the sewing item data change key , and then press the

middle presser foot correction key 


◆ Press  to confirm and it will move to next page







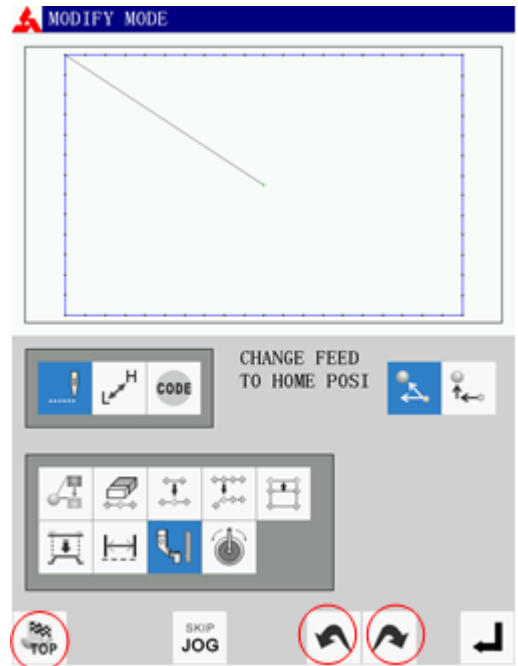
## 6 GENERAL SPECIFICATIONS OF MODIFY MODE

◆ Lower the clamps;

◆ Press , then press , enter Modify Mode

◆ After modification, press  to quit

-  : Cancel this modification (no modify, no display)
-  : Redo the modification of the undo point (no modify, no display)
- ◆ Return to the origin after modification
-  : Return to origin directly (this icon should be selected)
-  : Add-on return to the origin (don't select this icon).



## 6.1 PART MOVEMENT (NEW PATTERN ADDING BEFORE AND AFTER)



【Example】 For the below pattern, move the pattern D - E to D1 - E1. At this time, add new patterns before and after D1 - E1.



Steps:

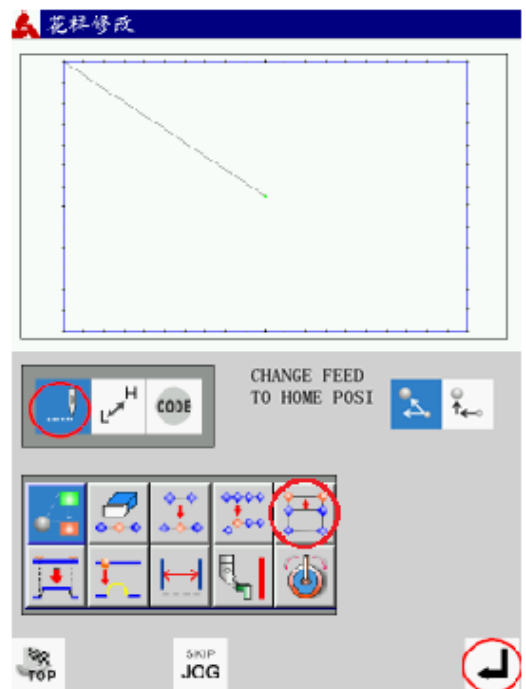
### 1、 Selection of part movement







































- First lower the inner and outer clamps, and then enter the modification module (refer to the method of entering the modification module, enter Pic 16).

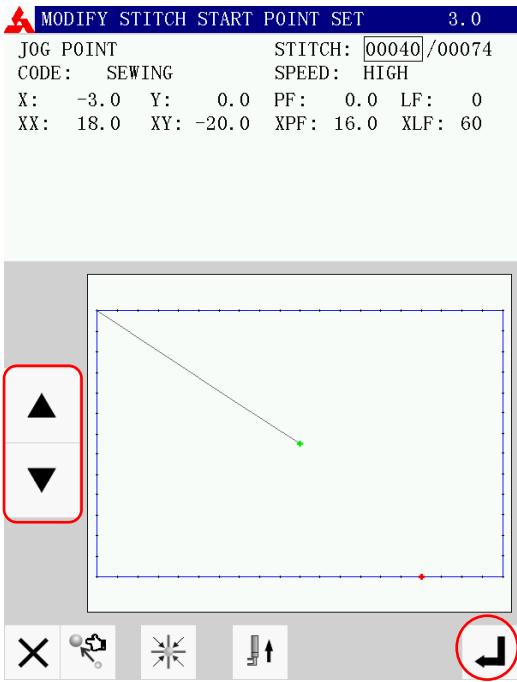
- Press  and then press .

- Press  to confirm.







- ◆ There are 3 keys in the first line of the pattern modification interface, which can input various modification functions:



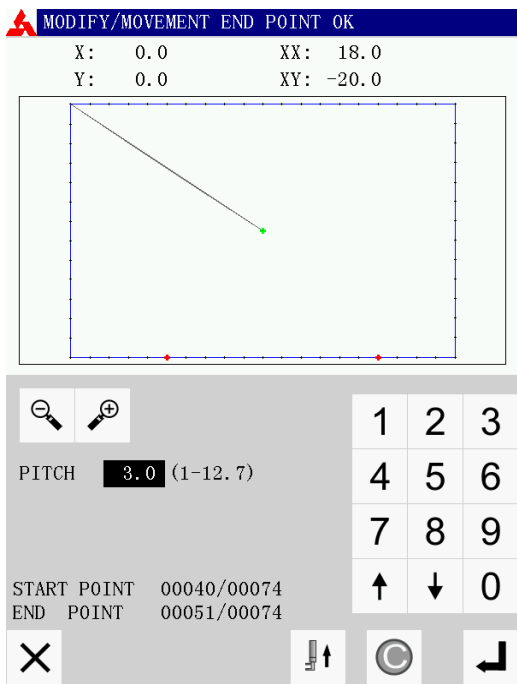
	Function	Icon	Description	Icon	Details
 Sewing item change	Modifies the position of the first sewing		The complete program is moved of the measure desired		Moving starting point
					Fixed starting point
	Delete stitch		Deletes a specified number of stitches		Absolutely delete
					Relatively delete
					Delete all stitches
	Add stitch		Add a stitch at the designated position		Absolutely add
					Relatively add
					Adds a sewing stitch adding keeping the same stitch length
	Modify a stitch position		Modify a stitch position		Moves only the specified stitch(fixed)
					Moves all the stitches from the specified one on
			Modify the partial position		Moves all the stitches from the specified one on
	Move a block		Pattern movement within the specified range		The modification changes the length of the stitch where it is performed.
					The modification ADDS a stitch where it is performed
	Modify a block		The area between 2 points is modified using arc, line, zig zag		
	Modify stitch length		Modify the stitch length in the specified range		Modifies the stitch length of a specified number of stitches
				Modifies all the stitches stitch length.	
Modify presser foot height		Modify presser foot height in the specified position			
Thread tension					
Modify speed				Modifies the speed of a specified number of stitches	
				Modifies the speed of all stitches	
Add or remove a code				Add code	
				Delete code	



2、 Determine the scope of block modification

- Press   to reach Point D (The start point of block)
- Press  to confirm
- Press   to Point E (The end point of block)。
- Press  to confirm

**! Attention:**  
 When the end point is confirmed, the clamp will automatically move back to the start point position. So pay attention to the stop position of the needle.





3、 Set stitch length

Use the number keys to set the stitch length to 3.0mm


- Press  to confirm

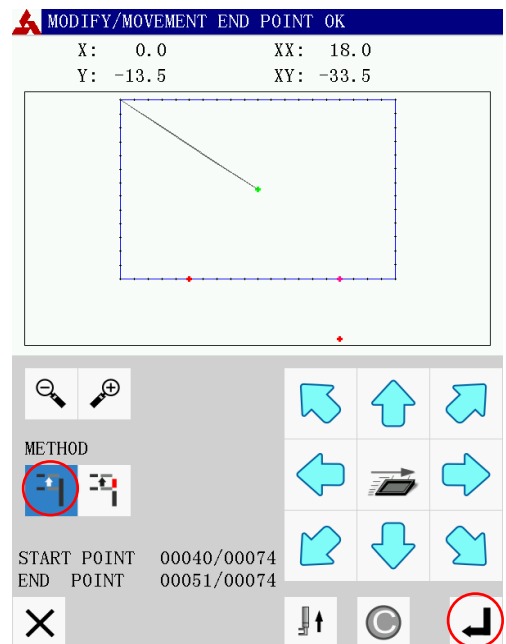
4、 Determine the amount of movement

- Set the moving method, press the pattern add button 
- Press arrow key to move to Point D1
- Press  to confirm (Perform block move)

5、 Check out the modified pattern

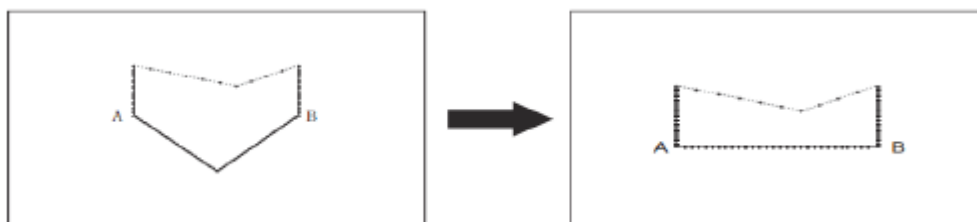
- Complete the modification

Press , it will leave the modification mode and switch to the page for saving the pattern. After the pattern is saved, it will return to the initial page.



## 6.2 BLOCK MODIFICATION 1 (STRAIGHT LINE MODIFICATION)

[Example] For the below pattern shown in the figure below, modify the pattern from A to B to a straight line.

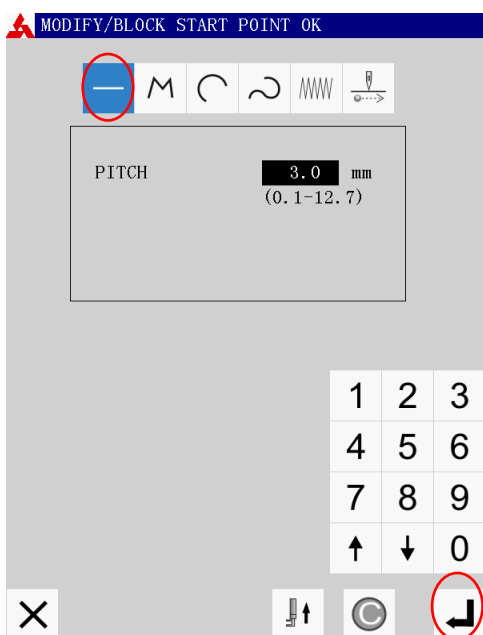


Steps:

### 1、 Selection of block modification

- First lower the inner and outer clamp, and then enter the modification mode (refer to the method of entering the modification mode, enter PIC 16).

- Press and then press
- Press to confirm and go to next page



### 2、 Select the type of modification

- Select straight line
- Set stitch length to 3.0mm
- Press to confirm

### 3、 Determine the range of block modification

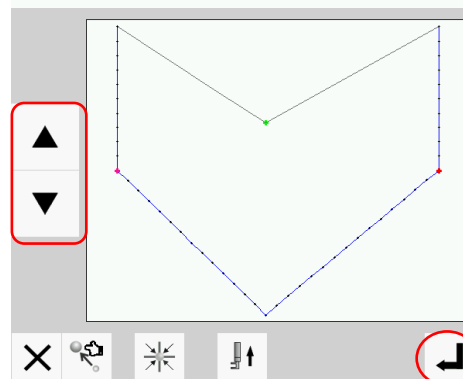
- Press to reach Point A (The start of modification)
- Press to confirm

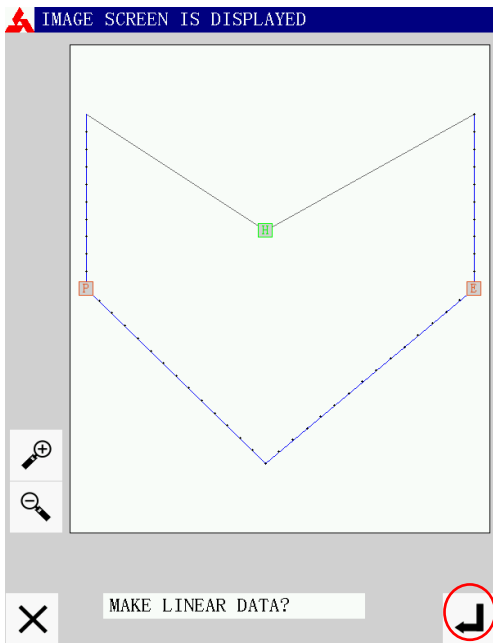
MODIFY STITCH START POINT SET		3.0
JOG POINT	STITCH: 00013/00058	
CODE: SEWING	SPEED: HIGH	
X: 1.0 Y: -1.0	PF: 0.0 LF: 0	
XX: -30.0 XY: -10.0	XPF: 16.0 XLF: 60	
JOG POINT	STITCH: 00042/00058	
CODE: SEWING	SPEED: HIGH	
X: 0.0 Y: 3.0	PF: 0.0 LF: 0	
XX: 35.0 XY: -10.0	XPF: 16.0 XLF: 60	

- Press to reach Point A (The end of modification)
- Press to confirm and go to next page

### 4、 Do you want to execute the modified data?


- Press to confirm and execute the block modification






5. Check out the modified pattern

- Complete block modification

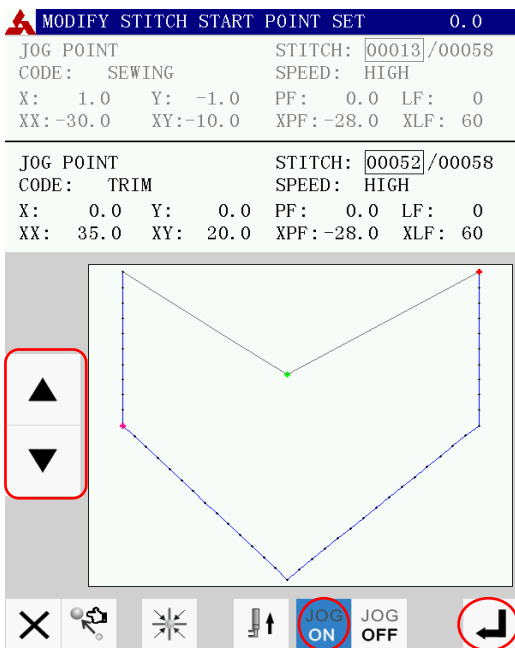
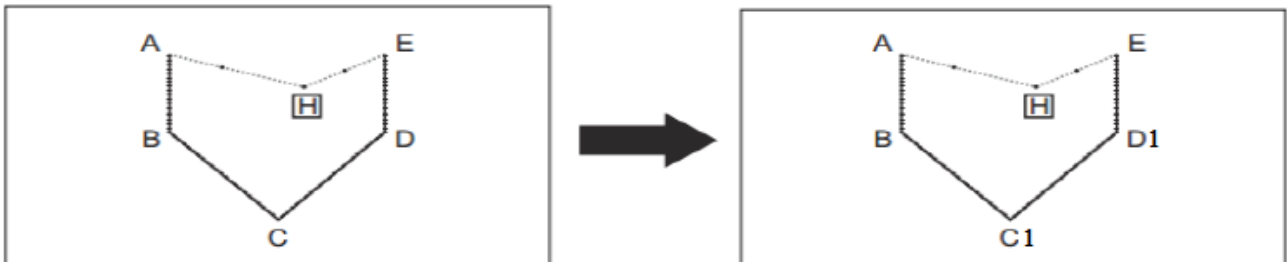
Press  , it will leave the modification mode and switch to the page for saving the pattern. After the pattern is saved, it will return to the initial page.

(If press  , cancel the modification input, and return to the state before modification.)

### 6.3 BLOCK MODIFICATION 2 (BROKEN LINE, CURVE AND IRREGULAR CURVE MODIFICATION)

The method of using the JOG key <sup>JOG</sup> ON to modify the specified position (it is convenient to use the original pattern data as a reference to make corrections.)




【Example】 : In the below pattern, modify C - D to C1 - D1.





Steps:







1. Selection of block modification

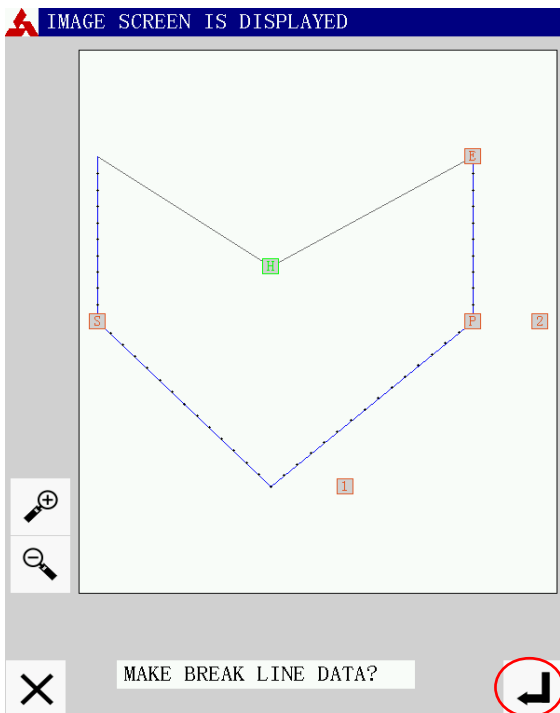
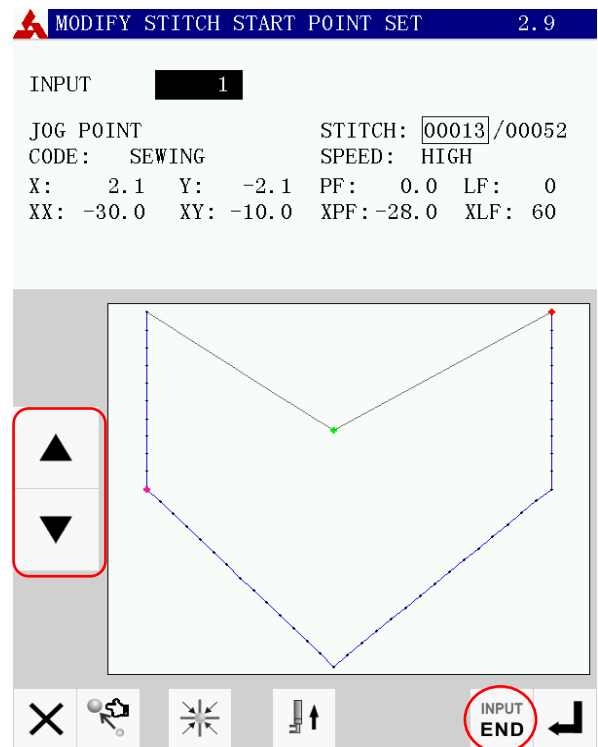
- First lower the inner and outer clamp, and then enter the modification mode (refer to the method of entering the modification mode, enter PIC 16).


- Press  and then press 
- Press  to confirm and go to next page

2. Select the type of modification

- Select broken line 
- Set stitch length to 3.0mm
- Press  to confirm



- 3、 Determine the range of block modification
- Press  to reach Point B (The start of modification)
- Press  to confirm
- Press  to reach Point E (The start of modification)
- Press Jog Key 
- Press  to confirm
- 4、 Decide the modification position
- Press  to reach Point C(Modify point)



- Press  to confirm.
  - Press arrow key to Point C1 (needed point)
  - Same step 4 to reach Point D and Point D1.
- (Repeat Step 4 if there are many position points to be modified)


- Press  to confirm


5、 Complete block modification

- After all modification are done, press , it will display **【MAKE BREAK LINE DATA?】**.
- Press  to confirm

6、 Check out the modified pattern

- Complete block modification

Press , it will leave the modification mode and switch to the page for saving the pattern. After the pattern is saved, it will return to the initial page.

The method of **No** using the JOG key  to modify the specified position (it is convenient to use the new pattern data as a reference to make corrections.)



Steps:


Step 1~2 same;



- 3、 Determine the range of block modification

- Press   to reach Point B (The start of modification)

- Press   to confirm

- Press   to reach Point E (The start of modification)

- Press Jog Key Off **OFF**



- Press   to confirm

- 4、 Move the new needed position

- Press arrow key to Point C1 (needed point)

- Press   to confirm

- Same step 4 to reach Point D and Pont D1

- After all the needed points are modified, again press  

- 5、 Complete block modification?

- Press   to confirm **【Perform block modification】**

- 6、 Check out the modified pattern

- Complete block modification



Press **TOP**, it will leave the modification mode and switch to the page for saving the pattern. After the pattern is saved, it will return to the initial page.

## 6.4 MODIFYING STITCH LENGTH



**【e.g.】** To modify the stitch length from A to B (3.0mm→7.0mm)

Instructions:

- 1、 Selection of stitch length modification

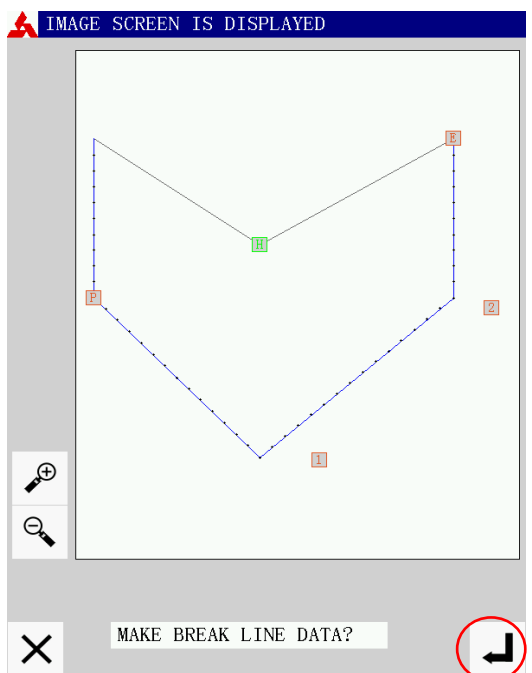
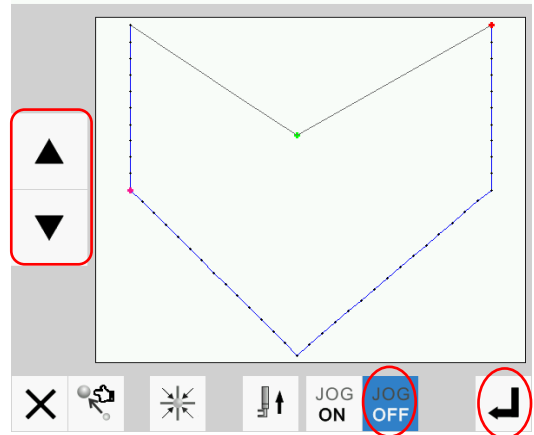
- First lower the inner and outer clamp, and then enter the modification mode (refer to the method of entering the modification mode, enter PIC 16).

- Press  and then press 

- Press   to confirm and go to next page

MODIFY STITCH START POINT SET				0.0
JOG POINT	CODE: SEWING	STITCH: 00013/00058	SPEED: HIGH	
X: 1.0	Y: -1.0	PF: 0.0	LF: 0	
XX: -30.0	XY: -10.0	XPF: 16.0	XLF: 60	

JOG POINT	CODE: TRIM	STITCH: 00052/00058	SPEED: HIGH	
X: 0.0	Y: 0.0	PF: 0.0	LF: 0	
XX: 35.0	XY: 20.0	XPF: 16.0	XLF: 60	



2、Determine the starting point of the modification

- Press   to reach Point A (The start of modification)
- Press  to confirm

3、Setting modification method


- Setting modification method (press the designated range key)

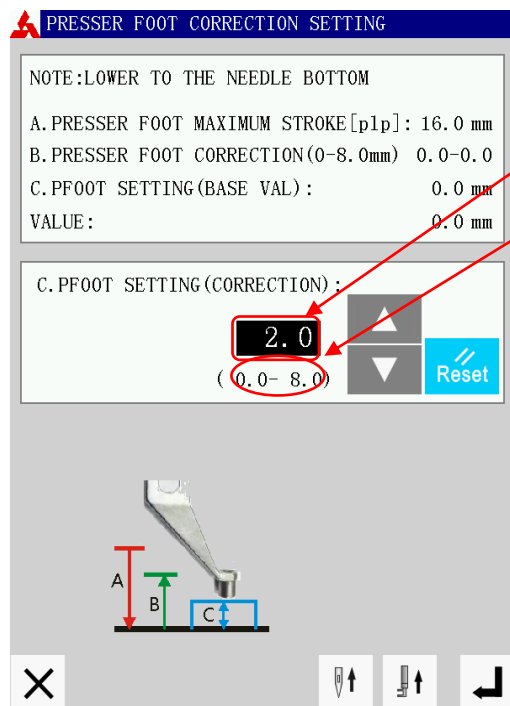
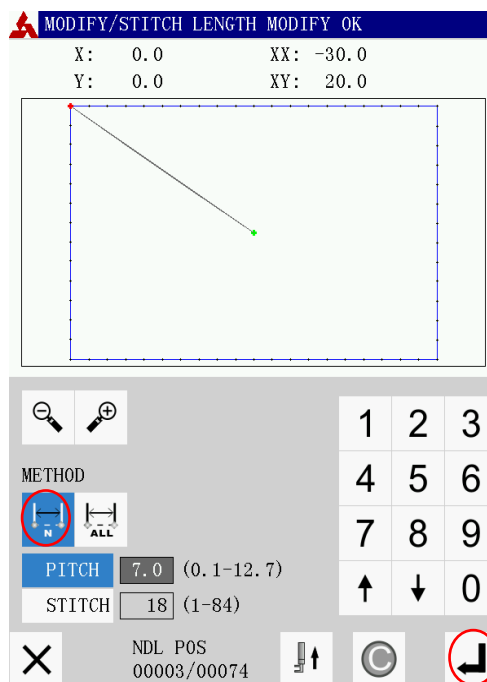


: Modify within the specified range.



: Modify all after the specified location.

- If it is set to modify within the specified range, the number of stitches to be modified = [18] stitches.
- Then set stitch length = 7.0mm
- Press  to confirm



## 6.5 MODIFY THE PRESSER FOOT HEIGHT




**ATTENTION:** for safety reasons while modifying the presser foot height the presser foot will remain in high position.

Before modifying the presser foot height control that the **THICKNESS** is set at 0mm.




【e.g.】 Change the presser foot height from B to C to 2.0mm

Instructions:


1、Selection of presser foot height modification




- First lower the inner and outer clamp, and then enter the modification mode (refer to the method of entering the modification mode, enter PIC 16).
- Press  and then press 
- Press  to confirm and go to next page

2、Set the modification position

- Press   to reach Point A (The start of modification)
- Press  to confirm

3、Set presser foot height (Note: Before adjust the presser foot height, presser foot must be in lowered position, if

not, press 

- Press   to set presser foot height = 2.0mm.
- Press  to confirm



## 6.6 MODIFYING SEWING SPEED

【e.g.】 Set the all the speed after point B to Middle-high speed( MD1)



Instruction:

### 1、 Selection of speed modification




- First lower the inner and outer clamp, and then enter the modification mode (refer to the method of entering the modification mode, enter PIC 16).

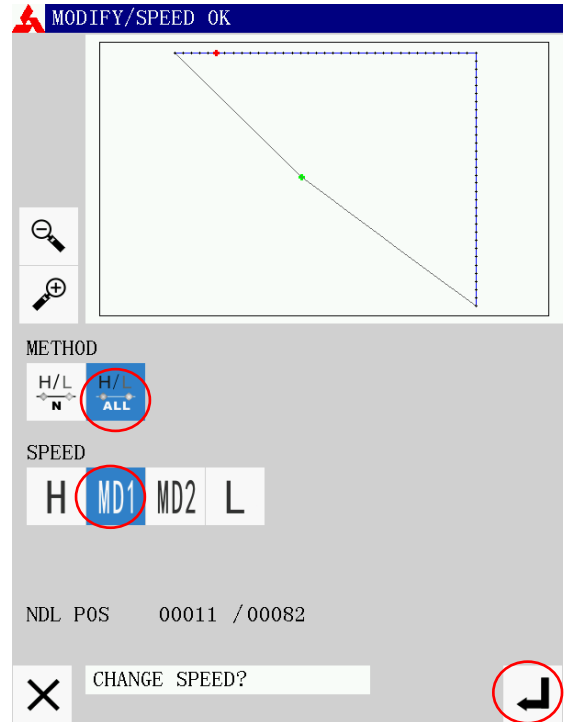
- Press  to reach Point A
- Press  to confirm and go to next page

### 2、 Determine the start point of the modification

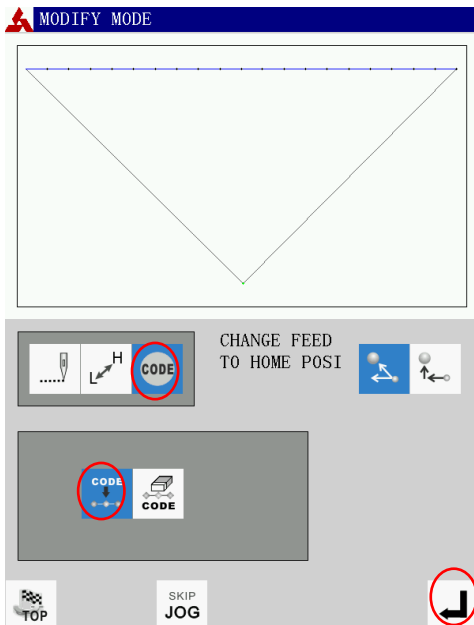
- Press  to reach Point A (The start of modification)
- Press  to confirm

### 3、 Set the modification method and speed

- Press  and then press  to set speed to MD1
- Press  to perform speed modification



## 6.7 ADDING CODES






Note: Please refer to the code

【e.g.】 At Point D, add Needle Up Stop code (USTP)



Instruction:

### 1、 Selection of adding codes


- First lower the inner and outer clamp, and then enter the modification mode (refer to the method of entering the modification mode, enter PIC 16).

- Press  and then press 
- Press  to confirm and go to next page


### 2、 Determine the position to add new code

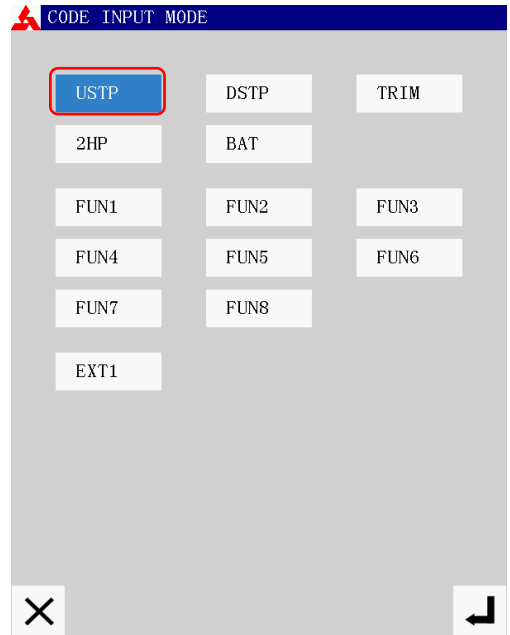
- Press  to reach Point D (The position to add new code)
- Press  to confirm

3、 Set the Additional Function to be added

- Press **USTP** programmed for NEEDLE up temporary stop
- Press  to confirm

4、 To perform adding code?

- Press  to perform adding code




## 6.8 PATTERN SIZE MODIFICATION

**【e.g.】** Reduce the pattern size, the stitch length remain (X: 50%, Y: 75%)

Instructions:

1、 Selection of size modification

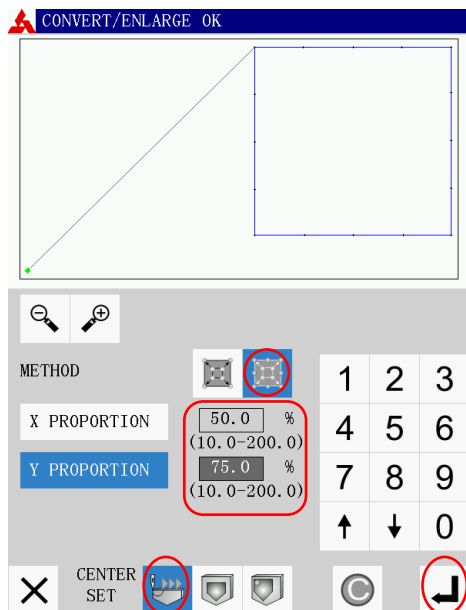
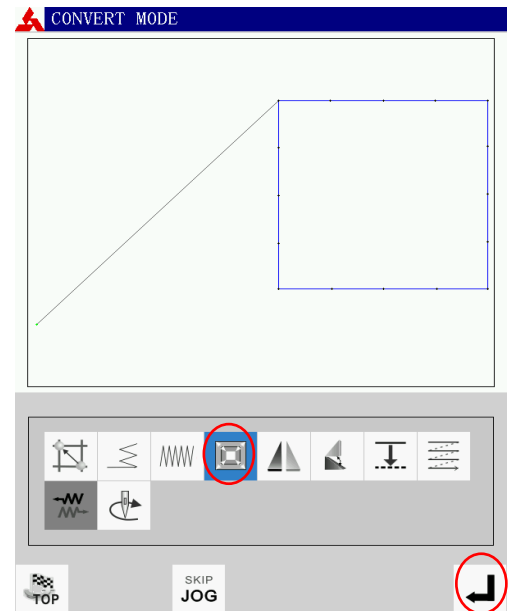
- Press  and then press  to enter pattern change mode

2、 Press size modification icon 

- Press  to perform

3、 Setting the style of f size modification

- Style (e.g. here select stitch length remain)



- Press number key or ↑ & ↓ to set zoom out ratio
- Specify the reference point (e.g. use the arrow key to specify any reference point.)



: Use the arrow key to specify reference point




: Use the center of the circle as the reference point



: Use the zero point as the reference point

3、 Set the position of reference point

- Press arrow key to reach Point A (zooming reference point)

- Press  to confirm

Notes:

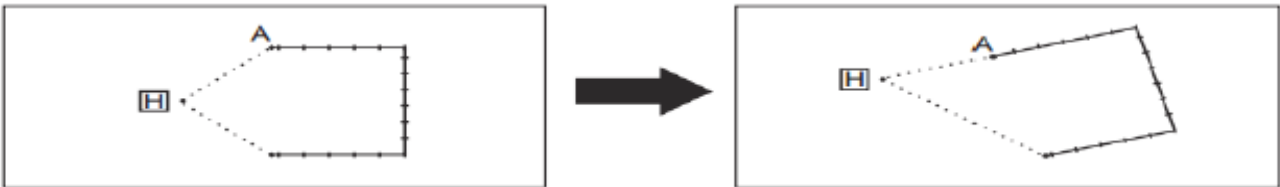
- ① If don't set the reference point with the arrow key, you can also set the reference point at any designated position. In this situation, directly press the confirm key.
- ② If the reference point is not on the sewing pattern, use the "move key" to reach point A, and press the confirm key.

#### 4、Perform zooming?

- Press  to confirm

## 6.9 ROTATION OF A PROGRAM



【e.g.】 As the below pattern, rotate 45° to the left with reference to point A.



Instructions:


#### 1、 Selection of pattern rotation


- Enter the pattern transformation module first

- Press 
- Press  to confirm


#### 2、 Set the rotation method


- Select the direction (e.g. select towards left)


 : towards the left

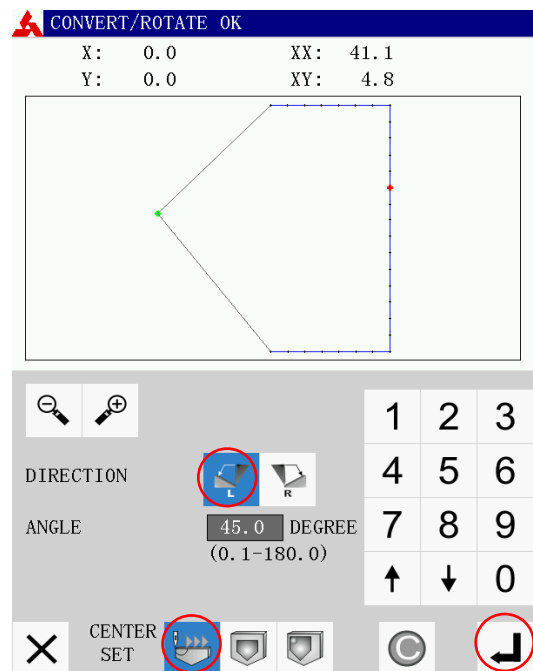
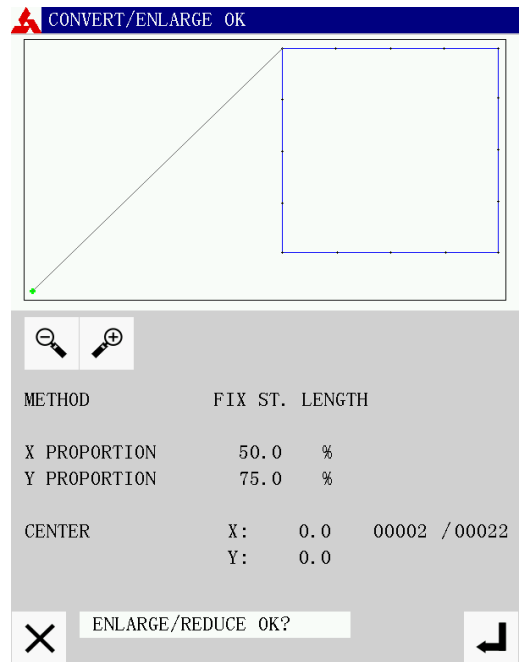
 : towards the right



- Set the desired angle of rotation using the number keys 45° .
- Specify a reference point (e.g. Specify any reference point.)

 : use the arrow key to specify reference point

 : Use the center of the circle as the reference point

 : Use the zero point as the reference point




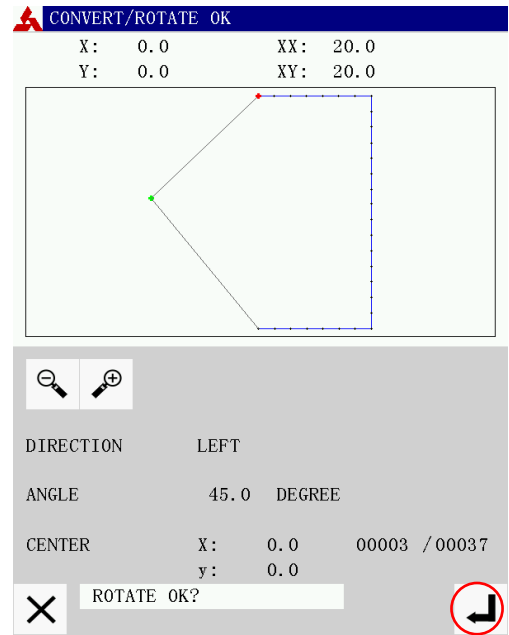
- Press  to confirm
- 3、Set the position of reference point
- Press arrow key to reach Point A(zooming reference point)
- Press  to confirm

Notes:

- ① If don't set the reference point with the arrow key, you can also set the reference point at any designated position. In this situation, directly press the confirm key.
- ②If the reference point is not on the sewing pattern, use the "move key" to reach point A, and press the confirm key.


4、Perform rotation?

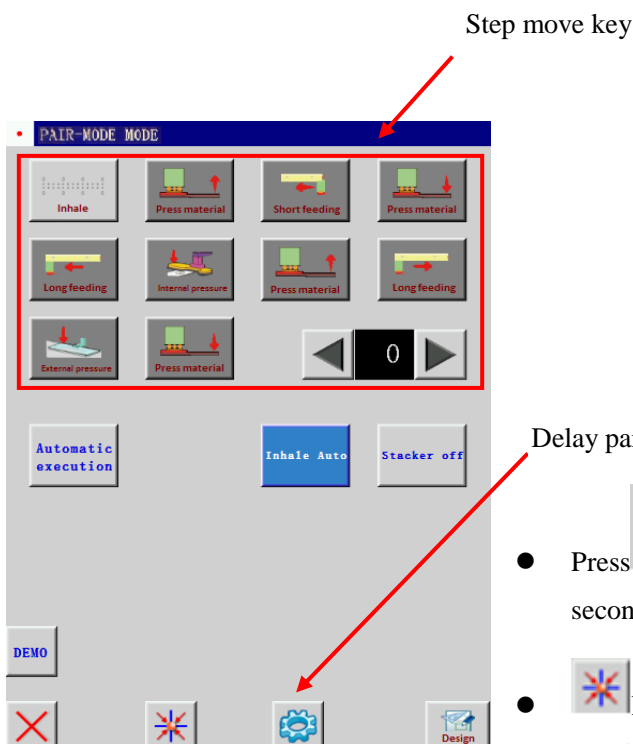
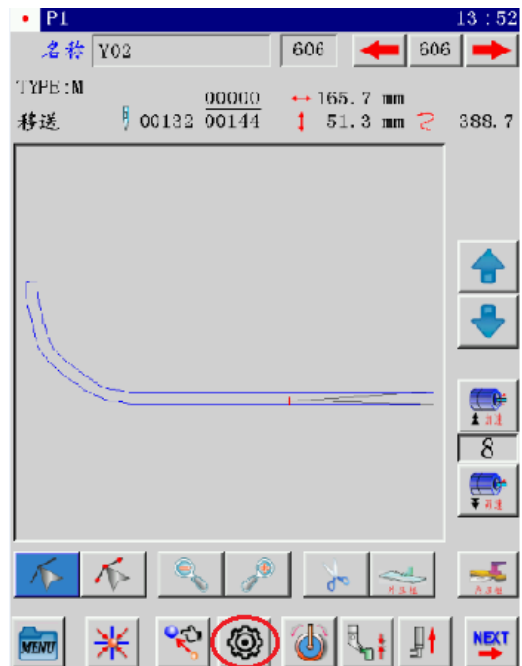
- Press  to confirm





## 7 FUNCTION MODULE

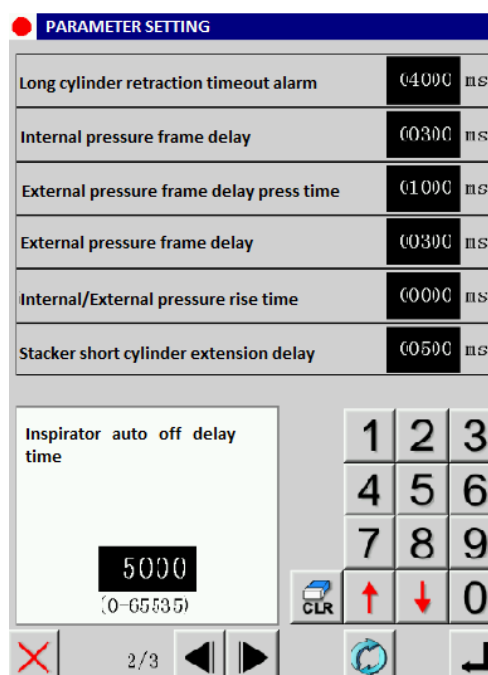
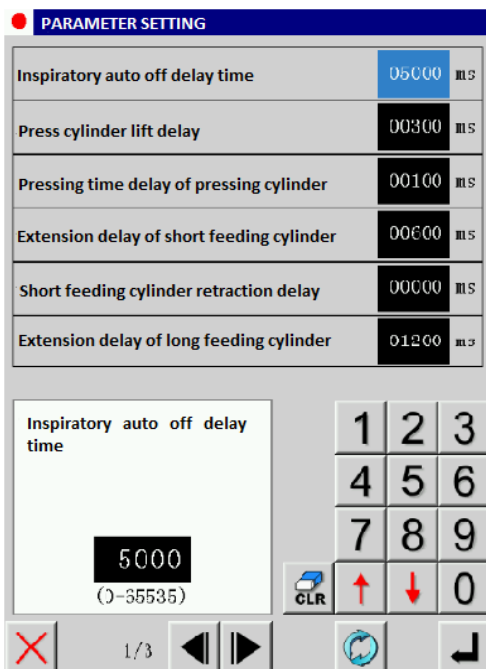
### 7.1 ADDITIONAL DEVICES PARAMETER

- Press  to enter pattern checking mode.



Delay parameter setting key

- Press , enter the parameter setting page, the first and second pages of the following interface.
-  Return-to-origin key for press frame and peripheral attachment



Note:








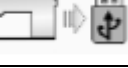









Automatic execution key: automatic execution of single-step actions, no need to manually click step by step

Automatic suction key: switch between automatic and manual suction [manually means step on the pedal to turn on the suction].

Stacker key: Stacker on and off switch key.

## 7.2 OVERVIEW OF HEAD FUNCTION MODULES


### ● Function table

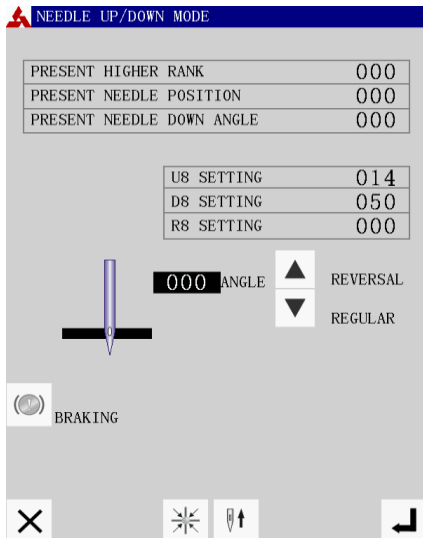
	Copy pattern		Set the angle of needle drop
	Format		Grouping pattern data
	System version		Screen picture related adjustments
	Read out the saved configuration file		Write and save system programs and setting files
	User login		Fault information record
	Passing information record		Networking Working Group
	Factory reset		Parameter modification
	Servo parameter setting		Step parameter setting
	File management system		

- Enter function table

Press MENU key then press  to enter head function modules.

### 7.3 SET THE ANGLE OF NEEDLE DROP

Press  to set the angle of needle up/down position.



U8 setting: the stop angle of the needle up stop position


D8 setting: the stop angle of the needle down stop position

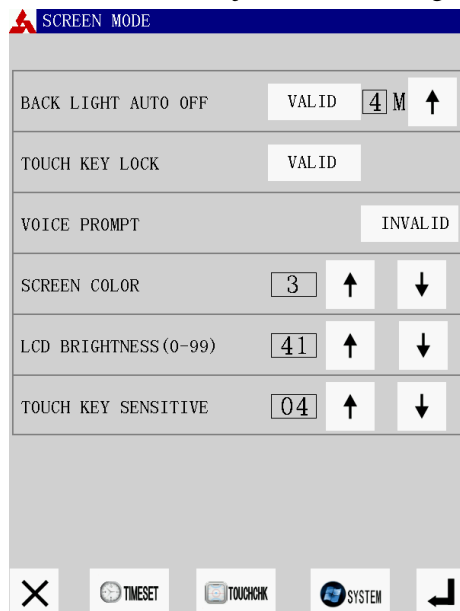
R8 setting: setting of the needle reversal angle

Note: For the detailed settings of these, please refer to [Needle Position] in the list of each program mode.

**! ATTENTION :**  
 When press  , needle will move up and down, please be aware of it.

### 7.4 VARIOUS SETTINGS RELATED TO THE SCREEN

Press  to adjust various settings related to the screen.



Screen power saving settings:

The screen light will automatically turn off when the set time is up.

Setting range: 1-9 minutes. Factory setting: [Valid], 5 minutes

Removal method: During the power-saving light-off period, just click anywhere on the panel to turn on the light.

Key security lock:

When lock is **【Valid】**, it will enter the state of preventing mis-operation, and all the keys have no function.

Removal method: Press and hold anywhere on the panel for more than 3 seconds, and wait for a beep to complete the release.

Description of the keys:

When the key is pressed, the title will display its detailed description, which can be set to be valid/invalid.

Original setting: [Valid].

Voice description:

When the key is pressed, its detailed description will be prompted by voice, which can be set as valid/invalid.

Original setting: [Valid].



Screen color:


The pattern of the background can be selected. Selection range: 1-4. Original setting: [1].


Screen brightness:


The contrast of the screen can be adjusted. Adjusting range: 0-99. (The higher the value, the higher the brightness of the screen)

Key sensitivity:

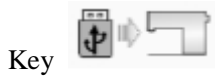
Adjustable touch screen touch effect. Adjustment range: 1-9. (The larger the value, the more the touch strength)

 : Click to enter the time modification page.

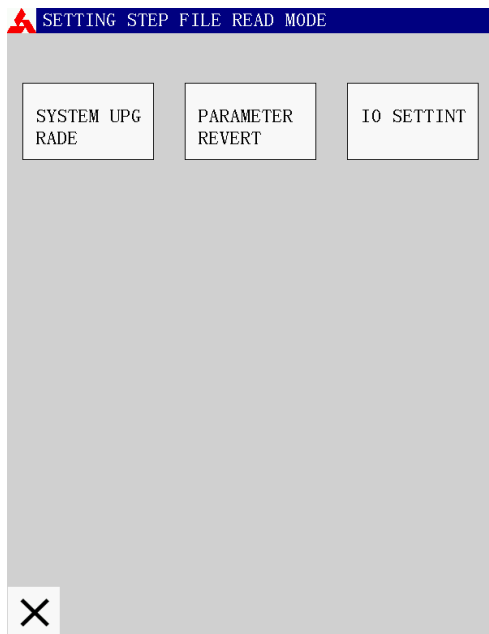
 : Click to enter the touch screen calibration page.

 : Click to enter to choose whether to switch to the H-operating system page.

## 7.5 SET FILE READ FUNCTION



Read out the pre-stored (backed up) setting files and step files on the floppy disk.





Support system upgrade, system parameter restoration, IO setting parameter restoration.


Note: The new data will be overwritten when reading, and the original setting data will be erased, please pay attention to it.

- Choose the type of motherboard to upgrade

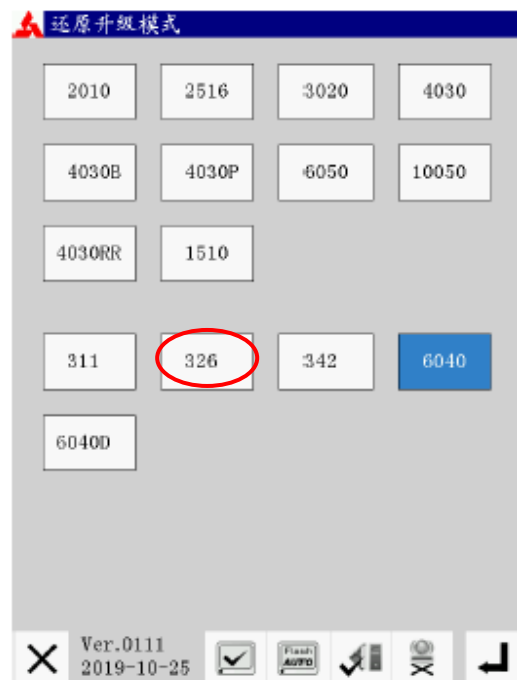
 : Pattern maker device program upgrade options

 : Flash upgrade options

 : Mainboard program upgrade options

 : Wifi module upgrade options

Note: Need to connect to the wifi module to select the upgrade mode, otherwise it will not be upgraded.



## 7.6 SYSTEM PROGRAM, SETTING FILE

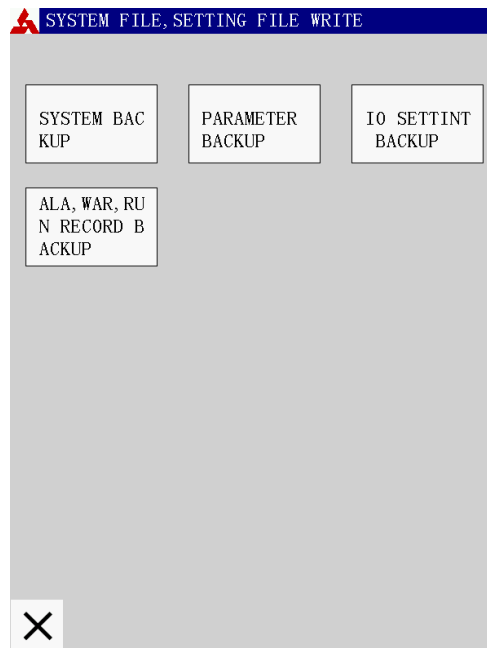
### WRITING FUNCTION



Key

Write (backup) system programs, setting files, step files, and information records to a floppy disk.

- Please use formatted disks  
Existing files will be covered with new data when writing, and the original data will be erased, please pay attention.



## 7.7 USER LOGIN FUNCTION



Key

Switch login user, modify user information



Switch to entering the user name

Switch to the state of entering the password

- Login mode selection



: The user does not automatically log out after logging in



: After the user logs in, it will automatically log out after a delay of 30 minutes



: After the user logs in, use one time to automatically log out

- Login level options




: Operator user level (user 1-5)






: Manager user level (users 6-7)




: Manufacturer user level (user 8-9)


Press  to switch to the machine authorization messages page

- Press  to confirm
- If need to log out current account, press .

- After inputting the authorization password, press , the authorization information of the device will be displayed.



Press  to enter user information page.

- Select the user account which need to be modified, press 
- Input password, modify information and confirm to complete the information modification.

## 7.8 PARAMETER CORRECTION



A total of 4 types of parameters can be corrected: mechanical origin parameter correction, forward and reverse gap compensation correction, needle bar rotation automatic correction, and visual coordinate system correction.



: mechanical origin parameter correction mode



: forward and reverse gap compensation correction mode



: needle bar rotation automatic correction mode



: visual coordinate system correction mode

Brief description of correction method:

- Select a correction mode
- Use the arrow keys to move the it to the correct position
- Press confirm key to complete the correction.



: Turn on the selected correction function



: Turn off the selected correction function



: Visual coordinate system positioning

## 7.9 INPUT/OUTPUT SIGNAL MODULE

- Press  and then press  to enter I/O test page



: Verification of input signal (Caution! The sewing machine may actually move)



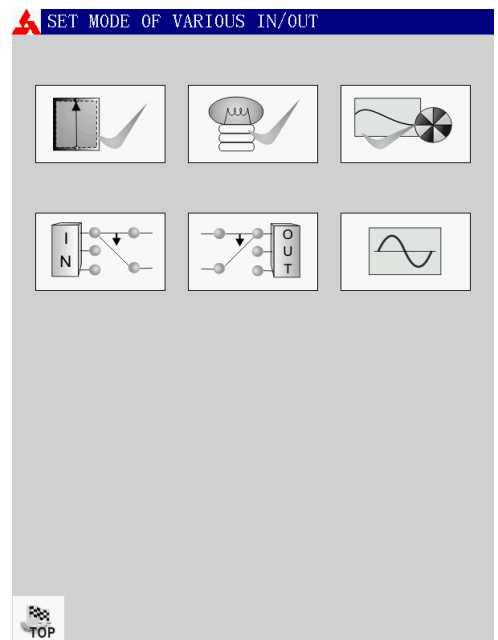
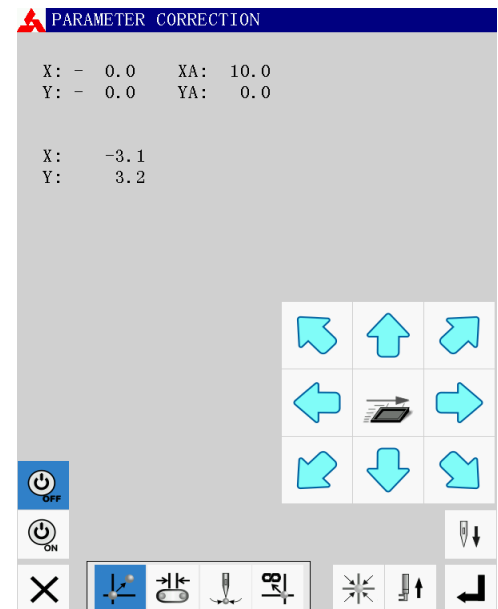
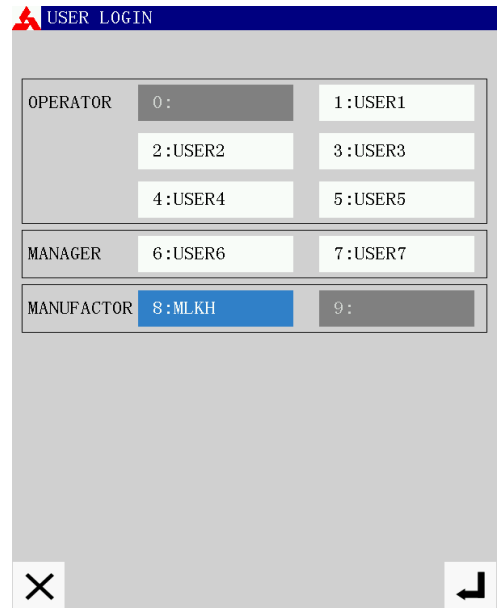
: Verification of the output signal (Caution! The sewing machine may actually operate)



: Verification of origin detectors, encoders, and position detectors (Caution! The presser foot will drop and the sewing machine may actually operate)



: Self-defined input signal (input signal logic)



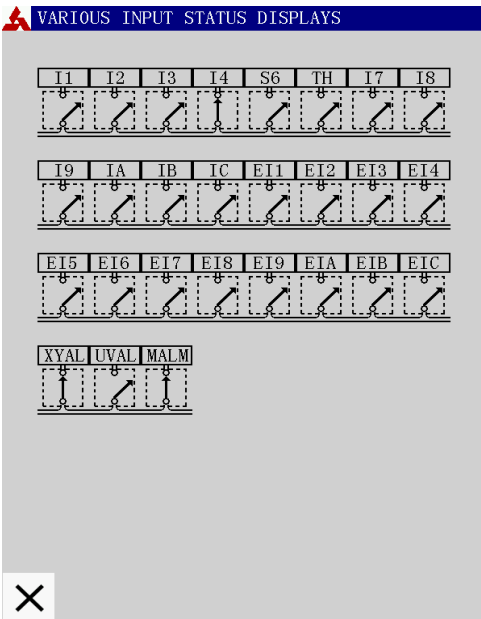


: Self-defined output signal (output signal logic)



: Analog input setting

### ◆ Verification of input signal



- It can verify the **ON/OFF** status of various input signals



: input signals ON



: input signals OFF

Note: In the case of priority display of the fault message, sometimes the ON/OFF of the input signal will be covered.

### ◆ Verification of output signal

Each output signal can be verified. There are [1] display reference status mode, and [2] manual output signal test mode.

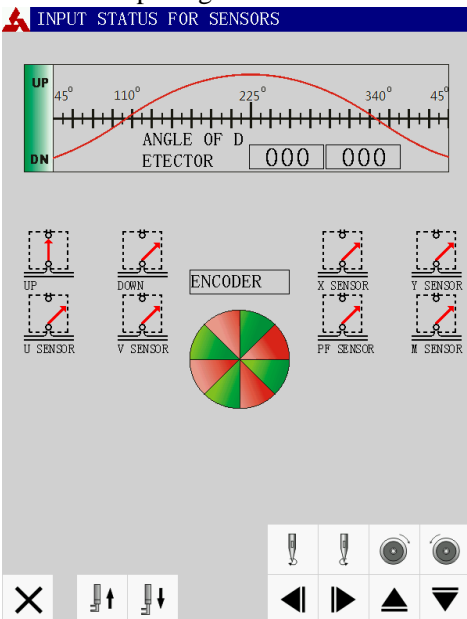
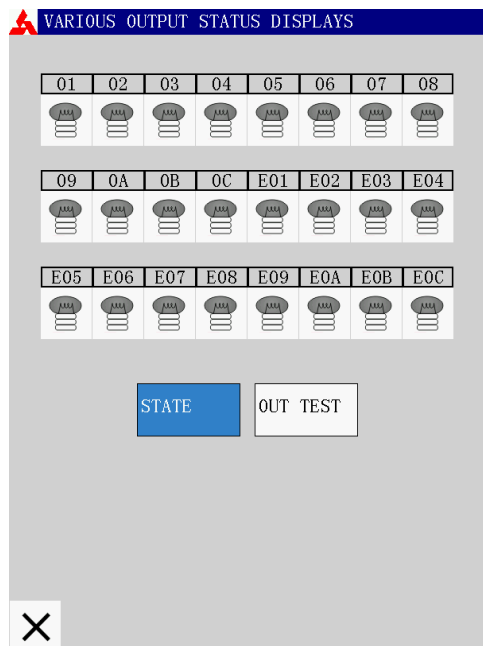
Press the mode switch key and the screen will switch



: output signal ON



: output signal OFF



### ◆ Verification of origin detector and encoder detector

The status of the origin detector and encoder detector is clearly displayed.

- The angle of the detector is based on the lower stop detection position.
- The colors of the encoders are reversed to each other.



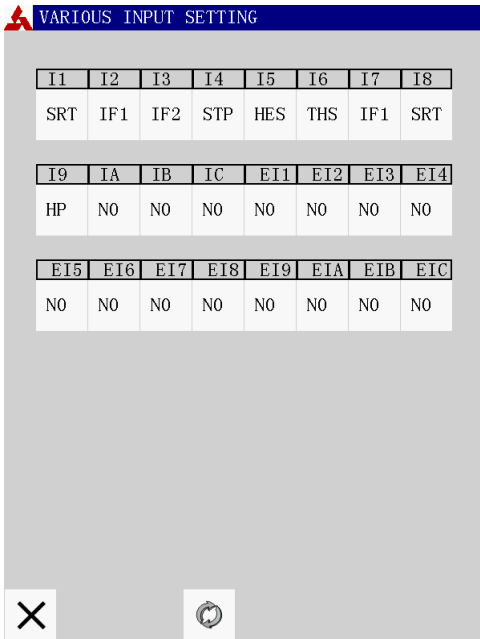
: Detected



: Undetected

Note:

In the case of priority display of fault messages, individual displays are sometimes covered. When this function is entered, the magnetic field of the stepping motor will be released, and once the origin return/running signal is input, the magnetic field will turn



ON again.

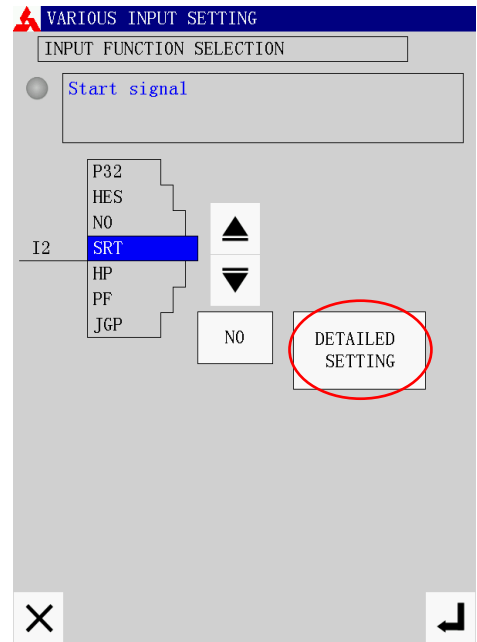
◆ Self-defined input signal (input signal logic)

(1) Customize input signal page

- Click any key of the desired physical input (I1-I9, IA-IF, EI1-EI9, EIA-EIC), it will become the selected input signal page.
- The changed part of the initial set value will be reversed.
- Press to reset to original setting.

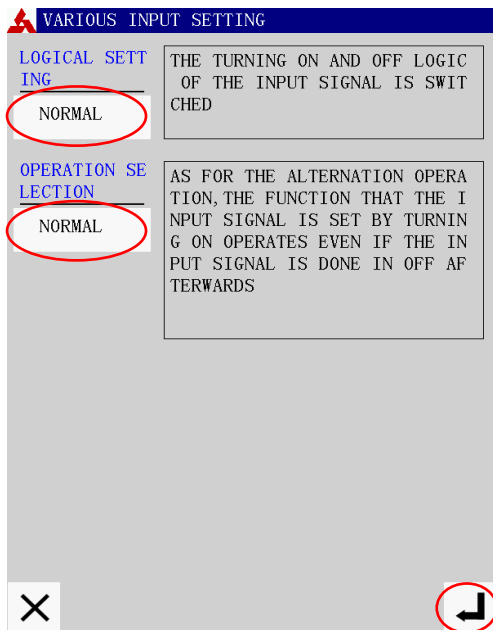
(2) Input signal selection page

- Press to select required signal (e.g. select [SRT])  
(For signal types, please refer to the description of the input signal setting table.)
- Press [Detailed Setting Key], it will change to the detailed setting page.



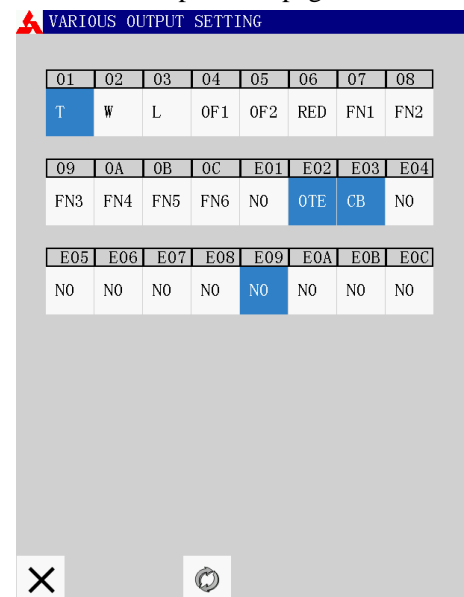
(3) Detailed setting page

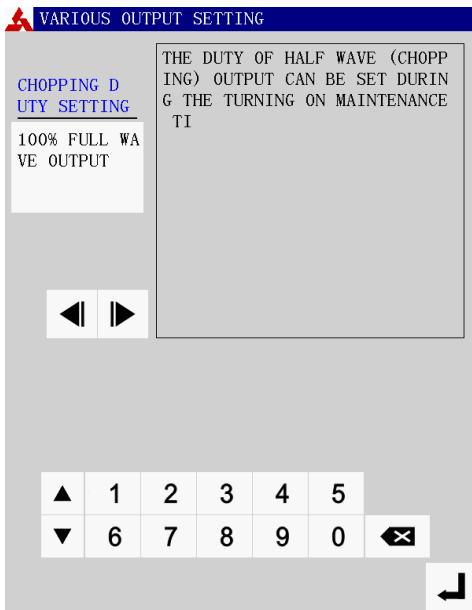
- It will switch to the theory of input signal. (Normal/Reverse)
- It will switch to the action of the input signal. (Normal/Alternate Switch)
- Press to confirm and back to previous page,



◆ Self-defined output signal (output signal logic)

Step (1) - (3) are same as input signal setting,






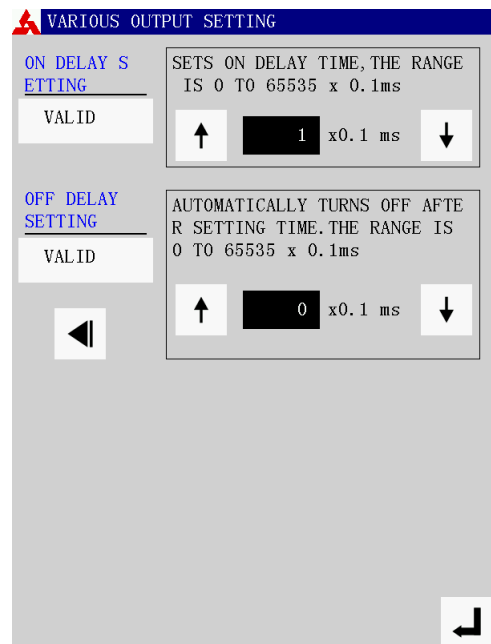
#### 4) Detailed setting page 2

- Set pulse output (there are 8 kinds + manual setting)
- Full-wave output time setting. (0-6553.5ms)

Note: For the theory and action of the signal, please refer to the section diagram and action description of [Input/Output Interactive Logic].

#### (5) Detailed setting page 3

- Start delay setting  
(Valid/invalid, delay range 0-6553.5ms).
- Turn off delay setting  
(Valid/invalid, delay range 0-6553.5ms).
- Press  to confirm and back to output signal operation selection page,



## 8 MAINTENANCES

### 8.1 ERROR MESSAGE

#### 1、 When the power displays [OFF]

- The [error code] and the reason are displayed on the monitor
- When the [error code] is displayed, please refer to the content in the table below.

Error Code	Monitor	Error Name	Possible Reason	Solution
PWR-OFF	PWR-OFF	Power Off	1. Indicates that the power supply becomes [OFF] 2. In the three-phase power supply, whether the U-phase or V-phase is open phase [Explanation] Ending processing	1. After a certain period of time, the display will automatically turn off 2. Check the plugs and sockets of the power supply line

STOP	STOP	Emergency On	<p>1. The emergency button is in the state of [on]</p> <p>2. The wire connection of the emergency stop button is bad</p> <p>[Explanation] The emergency pause button is being pressed</p>	<p>1. Turn the emergency pause button to the right to release the pause state</p> <p>2. Check the emergency button and its wiring, etc.</p>
------	------	--------------	---	---

2、【E-\*\*】 Fault information (cannot be restored)

- When the control box detects an error, the [error code] and description will be displayed on the display, and there will be continuous beeping.
- When the [error code] is displayed, please refer to the content in the table below to deal with it
- Press the power switch [OFF] and then press [ON] to return to the [normal mode]

Error Code	Monitor	Error Name	Possible Reason	Solution
E-001	E-001	Spindle current is too high, Power [off]	<p>*Is the main motor wiring short-circuited?</p> <p>*Is the load torque of the sewing machine too large?</p> <p>[Explanation] The main motor overcurrent detection is working</p>	<p>Main motor wiring</p> <p>*Turn the pulley by hand to confirm whether it can be turned gently</p>
E-002	E-002	Voltage is too high Power [off]	<p>Is the voltage of the power supply too high?</p> <p>*Is the inertia of the sewing machine too large?</p> <p>[Explanation] Overvoltage detection is in progress</p>	<p>Check power supply voltage</p>
E-003	E-003	The main motor detector is abnormal Power [off]	<p>Is the plug of the main motor detector loose?</p> <p>*Is the signal of the motor detector disconnected?</p> <p>*Is the belt loose?</p> <p>*Is the sewing machine stuck?</p> <p>*Is the main motor stuck?</p> <p>[Explanation] The main motor detector is normal?</p>	<p>Check the detector plug of the main motor and plug it in.</p> <p>*Check the main motor detector signal</p> <p>*Check the belt</p> <p>*Check the sewing machine</p> <p>*Check the main motor</p>
E-004	E-004	The main motor connection wiring is abnormal Power [off]	<p>Is the plug of the main motor loose?</p> <p>*Is the signal of the main motor disconnected?</p> <p>[Explanation] The motor output plug is loose</p>	<p>Check the plug of the main motor and plug it in.</p> <p>*Check the signal of the main motor.</p>

E-008	E-008	The detector is abnormal Power [off]	Is the plug of the position detector loose? *The signal line of the position detector is abnormal? [Explanation] The signal wire is broken due to poor position detector or loose plug	Check the plug of the position detector and plug it in. *Check the signal of the position detector
E-009	E-009	The magnet wire is not normal. Power [off]	Is the connecting wire of the magnet wire short-circuited? *The magnet wire itself is bad. [Explanation] Poor magnet wire	Check the wiring of the magnet wire. *Replace the solenoid wire.
E-010	E-010	The origin sensor is abnormal. Power [off]	Is the wiring of the origin sensor poorly connected or short-circuited? *Is the model wrong? [Explanation] Unable to find the origin position	Check the wiring of the origin sensor. *Check model *Check the input and output setting function [Confirmation of zero point, sensor, and detector]
E-011	E-011	The internal memory is abnormal. Power [off]	When the power was last turned on, it was not stored. [Explanation] There was no normal storage when the power was last turned on	Reboot machine
E-020	E-020	The pattern maker is abnormal Power [off]	Is the wiring of the pattern maker poorly connected or short-circuited? [off] No pattern maker connected	Check the wiring of the pattern maker
E-025	E-025	Air pressure is too low Power [off]	The detected input signal (ARS) of the air pressure is too low. [off] Air pressure is too low	*Take the power [off] to remove obstacles
E-026	E-026	[PDM] Current is too high Power [off]	Is the wiring of the stepping motor poorly connected or short-circuited? [Explanation] The stepping motor is disconnected, deteriorated or the PMD substrate is normal	Check the wiring of the stepping motor

## 8.2 TROUBLE SHOOTING

Problem	Reason	Solution
1. Easily thread-broken	Bad thread quality	Use better quality thread
	Needle thread tension too big	Properly adjust the needle thread tension
	Needle is small	Use proper needle
	The shuttle head or drive shaft is scratched	Use oilstone and cloth wheel to polish or replace with new products



	There are scars around the needle hole of the needle plate	Use cloth wheel to polish or replace with new products
	The needle hits the needle hole of the presser foot	Adjust the position of the presser foot
	The thread is blown by the heat of the needle	Sewing speed down
		Please use cooling oil
	Please use needle cooling device	
2. The thread slips out of the needle when sewing starts (the remaining thread is too short)	The tension disc of the upper thread is not open during thread trimming	Please adjust the pay-off action on the line
	The thread was cut before the trimmer close	Please adjust the position of the fixed knife
	The needle size is too large for the thread	Use proper needle
	The pressure of the upper thread auxiliary regulator is too strong	Adjust the upper thread auxiliary regulator
	The position of the wire guide on the shuttle seat is wrong	Adjust the position of the guide plate on the shuttle seat
	The position of the needle and the hook is messed up	Adjust the position between the needle and the hook
	The bobbin thread timing is wrong	Adjust the relationship of the trimmer cam
Adjust the position of the moving knife		
Adjust the stop position of the position detector		
3. Stitch skips when starting sewing	When the thread is trimmed, the shuttle runs idly, causing the remaining thread shorter	Please use the original bobbin case with anti-idling shrapnel
	The pressure on the bobbin thread is too strong	Please adjust the bobbin skin pressure of the bobbin case appropriately
	After thread trimming, the remaining thread on the needle is too short	Adjust the pressure of the upper thread auxiliary regulator to less pressure
		Adjust the trimmer cam
		Raise of thread release time
		Adjust the position of the guide plate on the shuttle seat
Adjust the position between the needle and the hook		
4. The thread left on the needle is too long after thread trimming	The pressure of the upper thread auxiliary regulator is too week	Adjust the upper thread auxiliary regulator
	Trimming time is late	Adjust the trimmer cam
		Adjust the stop position of the position detector
The thread release time is too early	Make of thread release time late	
5. Cannot cut the	The position of the wire guide on the shuttle seat is wrong	Adjust the position of the guide plate on the shuttle seat

thread	The function of canceling the automatic thread trimming operation is executing	Restore the automatic thread trimming function
	The edge of the fixed knife is	Please change to a new fixed knife
	The position of the moving knife is	Adjust the position of the moving knife
	Needle skipping during trimming	Adjustment to prevent skipped stitches
	The solenoid for thread trimming is damaged	Please replace with a new solenoid
	Wrong trimming time	Adjust thread trimming cam
Adjust the stop position of the position detector		
6. Skipping stitches often	The gap between the needle and the tip of the hook is too large	Adjust the gap between the needle and the hook
	The positional relationship between the needle and the hook is wrong	Adjust the position between the needle and the hook
	The needle is bent	Please change a new needle
	The drive handle hits the needle and the needle is skewed	Please adjust the gap between the needle and the drive handle
	Bad position or direction of needle	Install the needle at correct position
	Presser foot height is incorrect	Adjust the height
7. Bad take-up condition	Weak tension on the upper thread	Adjust the tension properly
	If the tension disc of the upper thread regulator is not closed, the thread will float	Adjust the installation position of the upper line regulator
		Please adjust the thread release on the line
	Presser foot height is incorrect	Adjust the height
	The gap between the drive handle and the shuttle is not right;	Please replace with a new shuttle or drive handle
	The presser foot up and down time	Adjust the up and down time of presser foot
8. The sewing machine still doesn't work when I step on the operation switch	Whether the connecting wire of the foot switch is plugged in properly	Plug in the connecting wire
	No pattern data in internal memory	Reinstall
	Emergency stop pause button into a halfway pause state	Turn the emergency stop button to the right once to release the halfway pause state
	The operation switch is broken	Please change to a new operation switch
9. High-speed run when connected to power	Poor contact of the connection wire of the position detector	Plug in the connecting wire
	The position detector is broken	Please change to a new
10. The external presser foot will not move	Whether the connecting wire of the foot switch is plugged in properly	Plug in the connecting wire
	The pressure of the external presser foot is too weak	Increase the pressure of the outer presser foot

	The external presser foot switch	Please change to a new
11. The sewing pattern is deformed	The connection between X and Y Shifting Platforms is loosen (some clearance exists)	Adjust the contact pressure of the X-Y shifting platforms
	The pressure of the external presser foot is too weak	Increase the pressure of the outer presser foot
	The sewing material is too heavy	Slow down the sewing speed
		Slow down the empty feed speed
		Re-set the weight of the outer presser foot
The belt in the X-Y direction is loose	Adjust the tension of the X-Y axis belt	
12. When the power is turned on or when the sewing is finished, it will automatically go back to the origin.	The X-Y axis detector cable is not plugged in properly	Plug in the connecting wire
	The X-Y axis detector is broken (the small red light does not light up when the original position is detected)	Please change the X-Y axis detector to confirm that the small red light should be on when the original position is detected

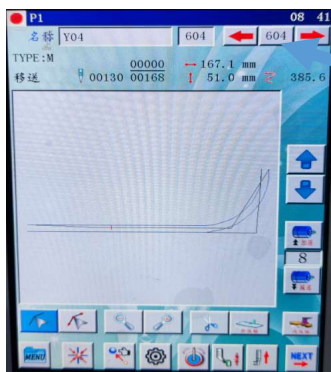
# 附录1:

## 从左侧缝纫切换到右侧缝纫操作教程:

### Instruction: Switch from left to right fly

1. 缝纫花样在显示屏上切换成右侧花样

Change to right side "J" pattern



花样切换  
Change pattern

2. 将手动控制阀切换到右端

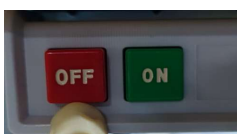
Switch the manual control valve to the right side



向右侧切换  
Switch to right

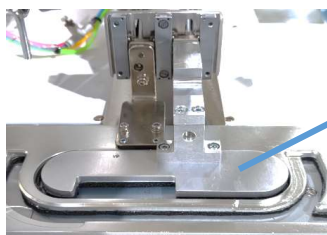
3. 机器关闭电源，并关闭气源

Power off machine and disconnect air



4. 将压料机构移到合适的位置，  
更换用于右侧缝纫的内压板

Adjust the position of fabric feed device,  
and exchange the inner clamp for right side  
sewing



右侧内压板  
在附件里  
The extra  
inner clamp is  
in accessory  
box

5. 更换收料气缸气管位置

Change the connection of the air pipe of the  
stacker cylinder

更换气管位置  
Change the  
air pipe connection



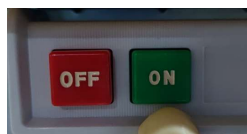
6. 将整个收料装置移到机器右侧放置

Move the stacker to right side



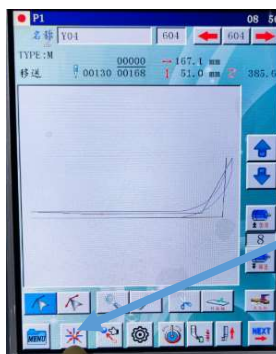
7. 机器开启电源，并开启气源

Power on machine and connect air



8. 在显示屏上点击回原点

In the panel, click reset to zero position

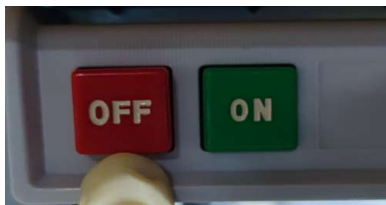


显示屏原点  
Reset to zero position

## 附录2： 机器翻转操作教程 Sewing head turnover instruction

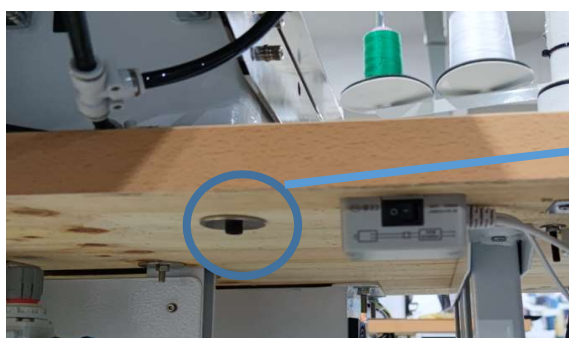
1. 机器关闭电源，并关闭气源

Power off machine and disconnect air



2. 拆卸机头拉紧螺钉

Remove the machine head tightening screw



拉紧螺钉A  
Tightening screw

3. 拆掉两根手动阀处的气管

Remove the two air pipes at the valve



气管短  
Short air pipe

气管长  
Long air pipe

4. 此时便可将机器轻松翻转。维修结束后，别忘了将步骤2中的螺钉A，重新安装锁紧  
Now, the machine can be easily turned over. After the repair, don't forget to reinstall and tighten the screw A in step 2.





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