



**WEISHI**<sup>®</sup>  
MACHINERY

缝纫机系列

# 使用说明书

Sewing machine series

## WS-8600

自动袖衩缝纫机

Automatic sleeve placket attaching machine



上海威士机械有限公司

HANGHAI WEISHI MACHINERY CO.,LTD.

## Preface

This manual is written for technical service staffs and operating personnel.

In the Operation Manual for sewing machine preservers in the garment factory and the sewing operators, we have made a thorough explanation on how to use this sewing machine. So in this Service Manual, we will make some explanations on particular and relevant functions, on the adjustment methods for compiling, on the phenomenon resulted from changes in value and other various functions.

In addition to this manual, please refer to other Operation Manuals and parts list when preserving and repairing this machine.

## For a safe adjustment operation.

Before adjusting the sewing machine, the automatic machine and the appendant devices (hereinafter called the machine), the operator should read the machine's "Important Safety Instructions" carefully and understand it fully.




The "Important Safety Instructions" in this Service Manual explains some items which are not included in the machinery specification you bought.

Besides, in order to make you fully understand this Service Manual and the warning signs stickup in the machine body, the warning signs are used separately according to the following descriptions.







You should fully understand and consciously comply with its contents.

Adjustments: Parts' replacement, removal, repair, assemble and other operations.

### (1) Descriptions about the dangerous level

 <b>Danger</b>	When operating and maintaining the machine, the dangerous parts which could cause death or serious injury by the third person's misoperation and the privies couldn't avoid.
 <b>Warning</b>	The potential parts which could cause death or serious injury by the third person's misoperation and the privies couldn't avoid when operating and maintaining the machine.
 <b>Caution</b>	The parts which could cause moderate or minor injury by the third person's misoperation and the privies couldn't avoid when operating and maintaining the machine.

### (2) Descriptions about the indications of the warning patterns

Warning patterns		Moving Parts: be cautious of the industrial accident.	Indication Sign		Belt Drive: be cautious of the industrial accident.
		High Voltage Parts: be cautious of electric shock.			Indicate the correct direction of rotation
		High Temperature Parts: be cautious of scalding			Indicate the earth wire that should be earthed.

		accident.			
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**Important Safety Instructions**

Accident: Refers to the physical and property damage.

Cut off the power: Refers to turn off the power switch and pull out the power plug from the socket.



**Danger**

To prevent the electric shock, when it is necessary to open the electrical cabinet, please cut off the power first and then open the electrical cabinet after at least 5 minutes.



**Caution**

**Basic**

1. To prevent human injury, please read and understand this Service Manual before operating. Besides, in order to use this Service Manual easily at any time, please keep it properly.
2. To prevent accidents caused by accidental start, please cut off the power before making any adjustment. When it has to operate with the power on, please do not step on the pedal or press the start button. When leaving the machine, it is necessary to cut off the power.
3. To prevent human injury, please verify whether the connecting terminal, cable and other things are damaged, loosen and so on after making adjustments.

**Education**

1. To prevent human injury when adjusting the operation, the person who is responsible should be taught about the latest information and safety knowledge, and be trained to operate according to this Service Manual and the Operation Manual.

**Mechanical**

1. To prevent the accidents caused by misadjustments, the adjustment should be made according to this Service Manual and the Operation Manual by the maintenance technician who is familiar with mechanistic relations and has been trained about the safety knowledge.
2. Please use the genuine components made by our company when replacing components. Our company shall not bear the responsibility for the incidents caused by inappropriate adjustment and for the using of the components which are not made by our company.

If the adjustment can't be made within the range of indication, you should terminate the repairing work immediately and authorize the technician in our company or in the agency shop to solve.

3. To prevent human injury, please verify whether the screws and nuts are loose after making adjustment.

4. To prevent human injury, when unexpected things happen during adjustment or machine still can't work normally after adjustment, please stop operating immediately.
5. To prevent human injury, when adjusting, the safety devices removed or damaged should be installed at its original place and verify whether they are normal and valid.
6. To prevent human injury, the warning signs stickup in the machine should be able to see clearly at any time. When they are desquamated or contaminated, you should replace a new one immediately.

#### **Electrical**

1. To prevent accidents and electric shock, please authorize the specified person with electrical knowledge or the technician in our company or in the agency shop to make the adjustment.
2. To prevent human injury, if the fuse blows out, please cut off the power, find out the cause, eliminate the trouble, and then replace a new fuse with the same capacity (specification).
3. To prevent human injury, please verify whether the connecting terminal, cable and other things are damaged, loose and shed after making adjustments.

#### **Air-pressure**

1. To prevent accidents caused by accidental start, when using air cylinder and other air-pressure components to make adjustment, please cut off the air supply and drain the internal compressed air first.
2. To prevent accidents caused by faulty action, please verify whether there is water in cylinder and air tube.

#### **Mechanical adjustment in clutch motor**

1. After cutting off the power, the clutch motor will continue to spin because of its inertia. To prevent human injury, please start to adjust after verifying the motor has stopped.

#### **Mechanical application and transformation**

1. To prevent human injury, do not make any adjustment or transformation which is not complied with the specifications of the machine. Our company shall not bear any responsibility for the accidents caused by such adjustment or transformation.
2. To prevent human injury, do not operate exceeding the machine's using range or the usage specified in this Service Manual and the Operation Manual. Our company shall not bear any responsibility for the accident caused by such operation.

**Precautions in various stages****Machinery Part****Caution****Move**

- 1、 To prevent human injury, please use two or more than two persons to lift this machine and use a moped to move it.
- 2、 To prevent human injury, please adopt sufficient safety precautions to prevent accidental drop and turnover when lifting or moving.
- 3、 We have made a thorough explanation about the installation in the Operation Manual, please read carefully and fully understand before operating.

**Component Replacement**

- 1、 To prevent human injury, please replace the component under the direction of this Service Manual and the Operation Manual.
- 2、 To prevent occupational injury and human injury, please operate after cutting off the power.
- 3、 To prevent human injury, please operate after the machine has been installed steadily. Meanwhile, it is necessary to choose appropriate tools.
- 4、 To prevent human injury, please verify whether the screws and nuts are loose, whether they have unexpected contact with other components after finishing operation.
- 5、 Please use the genuine components made by our company to replace.

Our company shall not bear any responsibility for the accidents caused by the using of the components which are not by our company.

If you couldn't replace the components normally under the direction, please stop repairing and contact with the technicians in our company or the agency shop.

**Adjustmen**

- 1、 To prevent human injury, please make adjustments within the range indicated in this Service Manual and the Operation Manual.
- 2、 To prevent human injury, please operate after the machine has been installed steadily. Meanwhile, it is necessary to choose appropriate tools.

- 3、 To prevent human injury, please verify whether the screws and the nuts are loose, whether they have unexpected contact with other components after finish operating.
- 4、 To prevent human injury, when it has to operate with the power on, please be careful enough and do not press the button accidentally.
- 5、 To prevent human injury and being involved in the machine, please be careful enough and do not let your hair or clothes touch the transmission part when operating sewing test.

#### Disassemble, Assemble

1. To prevent human injury, please make adjustments within the range indicated in this Service Manual and the Operation Manual.
2. To prevent human injury, please operate after the machine has been installed steadily.
3. To prevent human injury, please verify whether there is unexpected contact between components after finishing assemble.
4. To prevent human injury, when solidifying the screw and the nut, if there is specified torsional moment, please solidify in coincidence with the requirement; if there is no such requirement, please solidify in an appropriate torsional moment.
5. To prevent human injury, please verify whether the direction of rotation is correct during trial running.
6. To prevent human injury during trial running, please be careful enough and do not let your hair or clothes touch the transmission part.

#### Precautions in various stages

#### Electricity part



## Caution

#### Move

1. To prevent human injury, please use two or more than two persons to lift this machine and use a moped to move it.
2. To prevent human injury, please adopt sufficient safety precautions to prevent accidental drop and turnover when lifting or moving.
3. We have made a thorough explanation about the installation in the Operation Manual, please read carefully and understand fully before operating.

#### Component Replacement

1. To prevent accidents and electric shock, please authorize the technicians with electrical knowledge to operate.

2. To prevent the accidents and electric shock, when it is necessary to open the electrical cabinet, please cut off the power first and then open the electrical cabinet after at least 5 minutes. Do not operate when your hands are wet.
3. To prevent human injury, please replace the components under the directions in this Service Manual and the Operation Manual.
4. To prevent human injury, please operate after the machine has been installed steadily. Meanwhile, it is necessary to choose appropriate tools.
5. To prevent human injury, please verify whether this component has unexpected contact with other components after replacing and verify whether the connecting terminal and the plug are poor contact, whether the screws and nuts are loose.
6. To prevent human injury, please verify whether the connecting terminal, cable head are damaged, shed or loose after operating.

According to the request of security, there are some floating polyvinyl chloride tube, insulating tape and other insulating materials, and the internal wiring adopt the circuitous way in order to keep away from the high-tension line. And all of them should be repristinated after operating.

7. Please use the genuine components made by our company to replace.

Our company shall not bear any responsibility for the accidents caused by the using of the components which are not made by our company.

If you couldn't replace the components normally under the direction, please stop repairing and contact with the technicians in our company or in the agency shop.

8. To prevent human injury, if the fuse blows out, please cut off the power, find out the cause, eliminate the trouble, and then replace a new fuse with the same capacity (specification).

#### Adjustmen

1. To prevent accidents and electric shock, please authorize the technicians with electrical knowledge to operate.
2. To prevent the accidents and electric shock, when it is necessary to open the electrical cabinet, please cut off the power first and then open the electrical cabinet after at least 5 minutes. Do not operate when your hands are wet.
3. To prevent human injury, please make adjustments on the adjustable components (variable inductance, potentiometer, variable capacity) according to the indications in this Service Manual and the Operation Manual only
4. To prevent human injury, please operate after the machine has been installed steadily. Meanwhile, it is necessary to choose appropriate tools.
5. To prevent human injury, please verify whether the screws and the nuts are loose, whether they have unexpected contact with other components.
6. To prevent human injury, please verify whether the connecting terminal, cable head are damaged, shed or loose after operating.



7. To prevent human from injury and being involved in the machine, please be careful enough and do not let your hair or clothes touch the transmission part when operating sewing test.

#### Disassemble, Assemble

1. To prevent human injury, please make adjustments within the range indicated in this Service Manual and the Operation Manual.
2. To prevent the accidents and electric shock, when it is necessary to open the electrical cabinet, please cut off the power first and then open the electrical cabinet after at least 5 minutes. Do not operate when your hands are wet.
3. To prevent human injury, please replace the components under the directions in this Service Manual and the Operation Manual.
4. To prevent human from injury, please operate after the machine has been installed steadily. Meanwhile, it is necessary to choose appropriate tools.
5. To prevent human injury, when solidifying the screw and the nut, if there is specified torsional moment, please solidify in coincidence with the requirement; if there is no such requirement, please solidify in an appropriate torsional moment.
6. To prevent human injury, please verify whether the screws and nuts are loose, whether they have unexpected contact with other components.
7. To prevent human injury, please verify whether the connecting terminal, cable head are damaged, shed or loose after operating.

According to the request of security, there are some floating polyvinyl chloride tube, insulating tape and other insulating materials, and the internal wiring adopt the circuitous way in order to keep away from the high-tension line. And all of them should be reprinted after operating.


8. To prevent human injury, please verify whether the direction of rotation is correct during trial running.
9. To prevent human from injury during trial running, please be careful enough and do not let your hair or clothes touch the transmission part.

### Important Safety Instructions about WS-8600



**Danger**

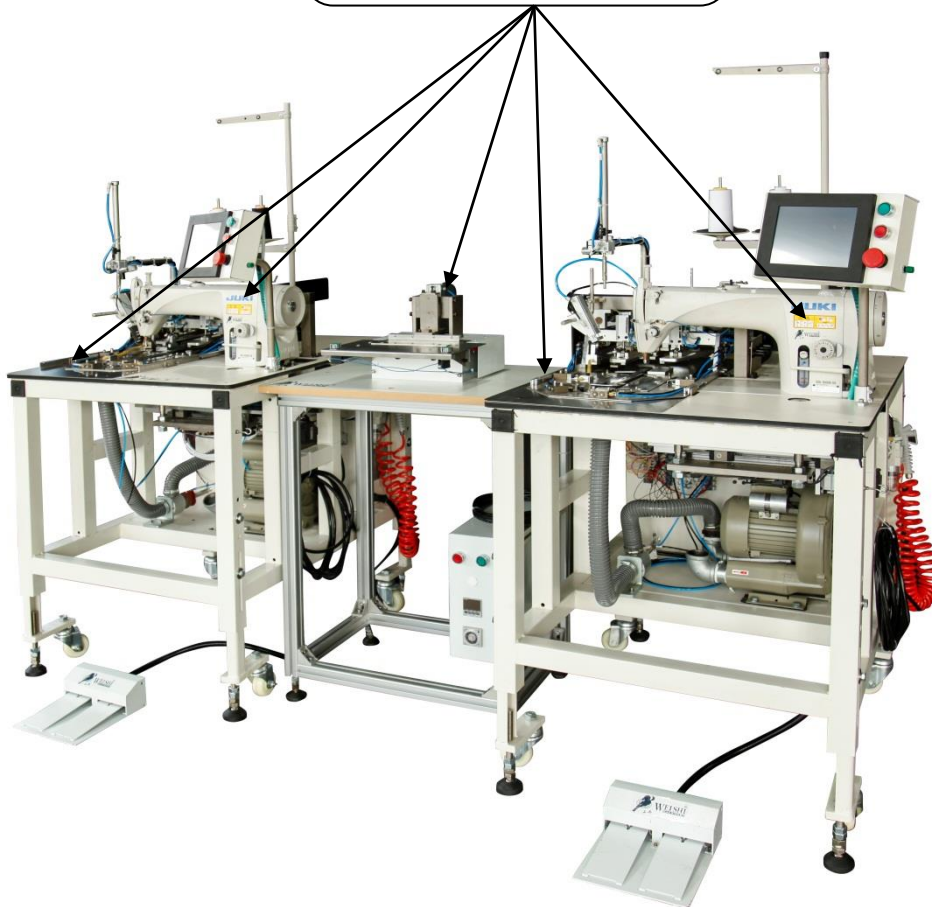
1. To prevent electric shock, during the power supply importing period, do not touch the components in the electrical cabinet when the motor electrical cabinet is open.
2. After changing pattern, please verify the needle point. Once the pattern exceeds the presser foot, the needle would run into the presser foot and snap.

 <p><b>Caution</b></p>	<ol style="list-style-type: none"><li>1. When power is on, but no display on the operation screen, please cut off the power and verify the supply voltage and the power source specification.</li><li>2. To prevent the accident caused by the accidental start, before pressing the start button please verify there is no barriers underneath when coiling.</li><li>3. When the power button is off, the setout button is on, and the presser foot button is on, do not put your fingers beneath the presser foot, because the presser foot will automatically fall down.</li></ol>
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## Safety Device

The machineries and safety devices recorded here are made under the domestic specifications; the devices may be different according to different sale places

Please be kindly noted these Safety warnings all time



危險

DANGER The book, in some places have been omitted the eye shield, therefore

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## 一、规格参数

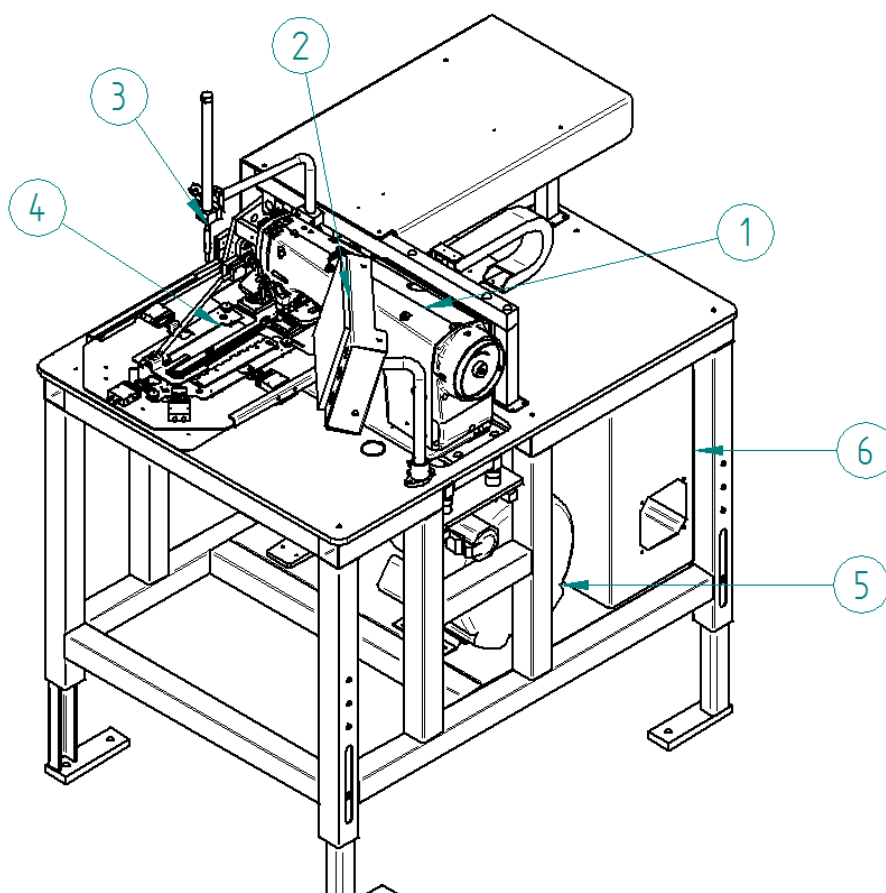
specificaton

NO.	ITEM	Basic parameters
1	Maximum sewing speed (needle/min)	3000
2	Stitch length/mm / mm	1-3
3	needle number	DB×11#11-14#
4	Cloth feeding mode:	INTERMITTENT
5	Sewing scope/mm	30W×200L
6	Rated voltage/V	220
7	Operating air pressure/Mpa	0.5
8	Air consumption/L/min	200
9	Dimension mm	1120L×760W×1600H
10	Weight	350Kg

※ Maximum sewing speed can be used according to the drop speed of the sewing condition.

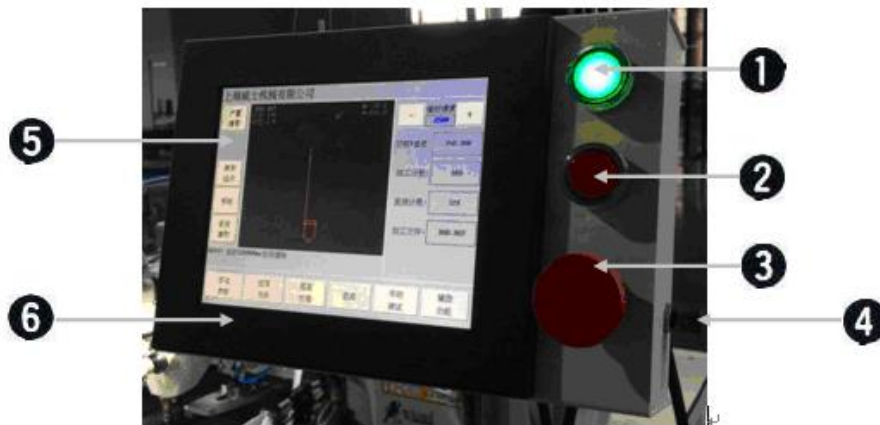
## 二、各部位的名称

### NAME OF EACH PARTS



- 1、SEWING HEAD
- 3、LOW RAISING SYSTEMS
- 5、FAN MOTOR

- 2、OPERATION PANEL
- 4、EDGE FOLDING SYSTEMS
- 6、ELECTRIC BOX

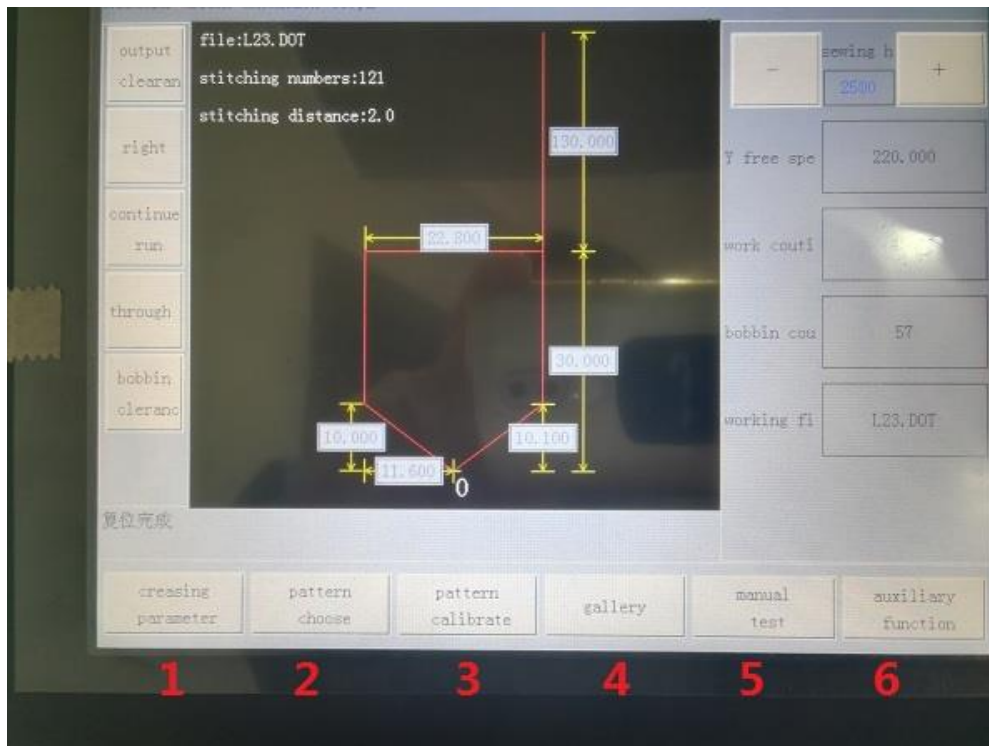


	button	description
①	Power ON	Main supply of the machine is on after this button being pressed.
②	Power OFF	Main supply of the machine is off after this button being pressed.
③	EMERGENCY	The system will stop after emergency button being pressed, thereafter, press button ④ or system restoration when emergency button is canceled.。
④	Reset Button	Servo returns to zero point and the machine enters into work state after this button being pressed.
⑤	Human-machine Interface	Set sewing parameter and select machining graphics on human-machine interface.
⑥	TOUCH SCREEN	8" TOUCH SCREEN。

When the boot initialization is finished, the system will automatically enter the main screen, Please do not operate the machine during this time, because the system is not ready state.

Plrese RESET the machine after e initialization procedure

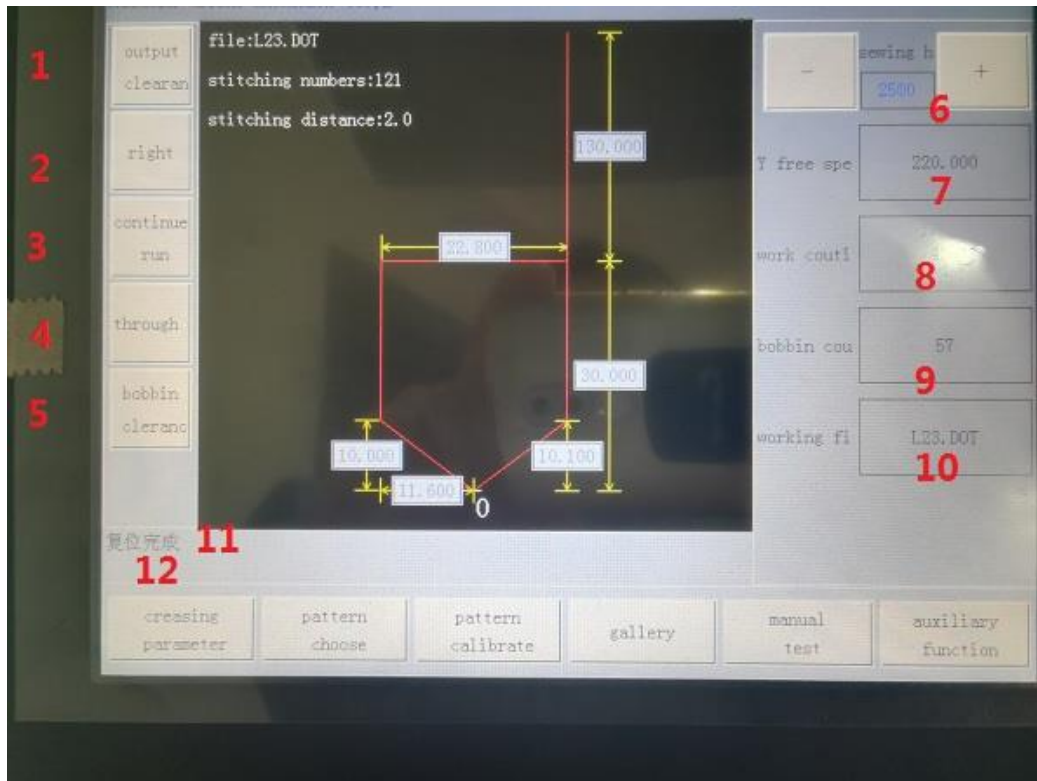
(1) SUB-MENU OF INTERFACE:



	Button	description
①	Creasing parameter	To set the creasing parameter, production parameter and choose function
②	Pattern choose	To choose the patter file and set the needle distance。 (with a security level 1 of the picture)
③	Pattern calibrate	To calibrate the pattern and set the location of starting , material picking , ending sewing and etc. (with a security level 2 of the picture). Non-professionals please do not to get into and modify parameters。
④	Gallery	To create new pattern
⑤	Manual test	To maual test the movement and IO signal。 (with a security level 1 of the picture)
⑥	Auxiliary function	To set some other parameter, file manager and systems information.



(2) parameter and operation:



	button	description
①	Output clearance	Clear off the production quantity
②	Right/left placket	Right/left placket manual switch
③	Step/continuous run	Before stitching, choose the folding edge mode (1) continuous: continuously fold edge; (2) step: run step after step by pedal start
④	Thread through	Press it to lay down the upper and lower press plate, enable easy threading
⑤	Bobbin clearance	Clear off the bobbin capacity.
⑥	Sewing speed	temporary Change the sewing speed “+/-” It will be resumed to previous after screen switch or power restart
⑦	Y free speed	Y axis freely movement speed
⑧	Work counting	Production counting number
⑨	Bobbin counting	Bobbin counting number

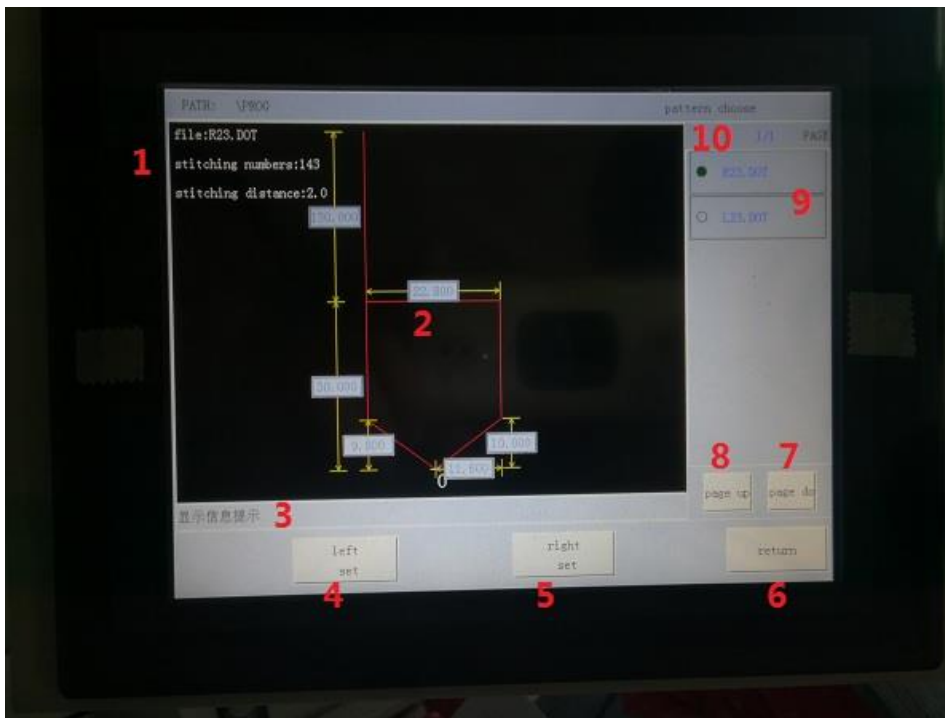
<b>10</b>	Working file	The file name of processing currently
<b>11</b>	Run information	Currently run information
<b>12</b>	Alarm information	Current alarm information



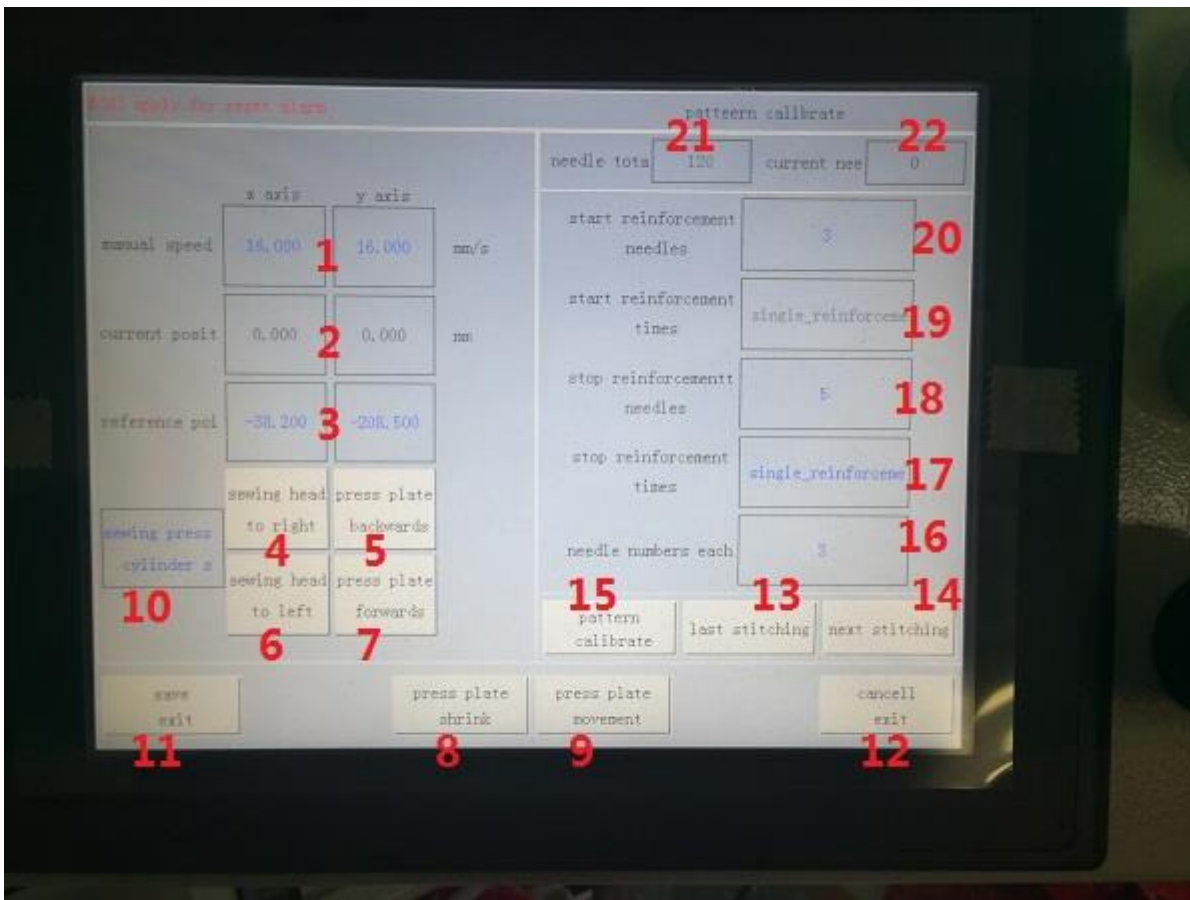
	button	description
<b>1</b>	2 <sup>nd</sup> thread clasp on-delay(ms)	Time to 2 <sup>nd</sup> thread clasp open(ms)。
<b>2</b>	2 <sup>nd</sup> thread clasp off-delay(ms)	Time to 2 <sup>nd</sup> thread clasp close(ms)。
<b>3</b>	Bobbin count setting	Set the bobbin count。 press “bobbin clearance” to clear current bobbin number
<b>4</b>	Current bobbin counting	Set the current bobbin counting

<b>5</b>	sewing speed (rpm)	Set the sewing speed when power on
<b>6</b>	Start speed (rpm)	Sewing speed in the begining
<b>7</b>	Thread break detector	Switch on/off the thread break detector
<b>8</b>	Bobbin counting function	Switch on/off the bobbin counting function。
<b>9</b>	Vacuum motor	Switch on/off the vacuum motor
<b>10</b>	Sewing start confirmation	after folding the edge , Need Confirmation to stitch
<b>11</b>	Left/right placket automatic switch	Left/right placket automatic switch
<b>12</b>	2 <sup>nd</sup> thread clamp function	Switch on/off the 2 <sup>nd</sup> thread clamp function
<b>13</b>	stacker	Switch on/off the automatic stacker
<b>14</b>	Save changes	Save changes and return
<b>15</b>	return	Return without save change。

## 5. PATTERN SELECTION

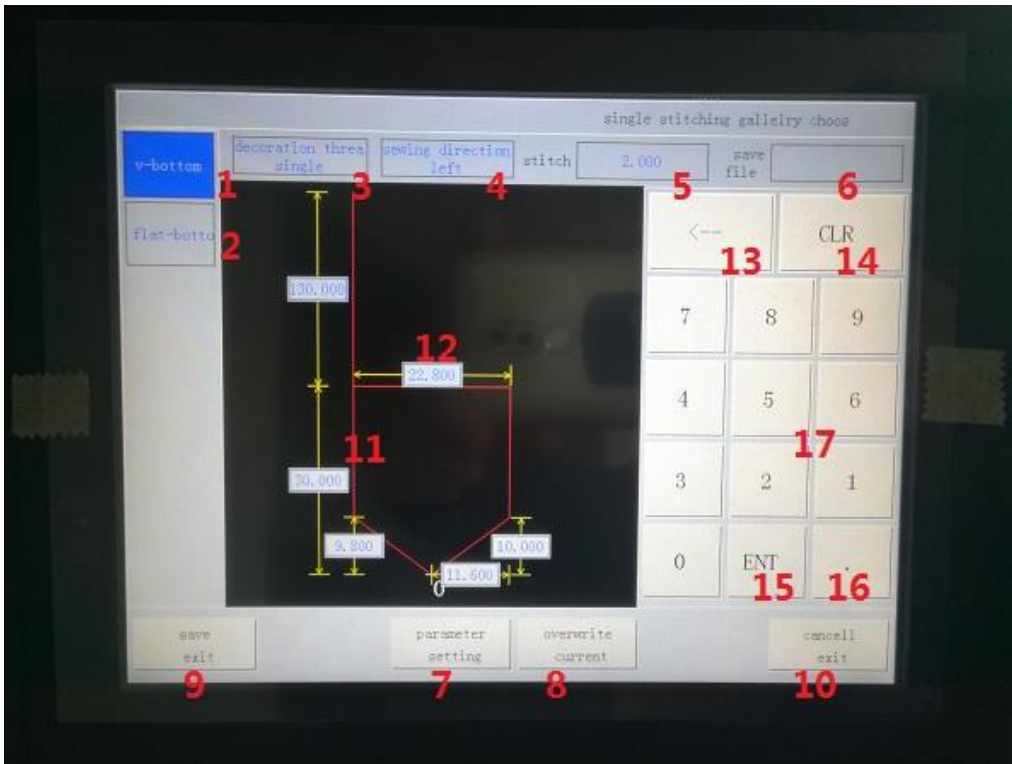


	BUTTON	DESCRIPTION
①		File name and needle distance
②		Placket measurement
③	information	Current running information
④	Left placket	Choose current left placket pattern and save
⑤	Right placket	Choose current Right placket pattern and save
⑥	return	Return to home page
⑦	Page down	Page down to next file list
⑧	Page up	Page up to previous file list
⑨		File list
⑩		Page of file list



	button	description
①	Manual speed	Set the sewing head ,press plate manual move speed
②	Current position	Current position of x axis, y axis
③	Reference point	The position of reference point of Current patent
④	Sewing head to right	Manual move sewing head to right
⑤	Press plate backwards	Manual move press plate backwards
⑥	Sewing head to left	Manual move sewing head to left
⑦	Press plate forwards	Manual move press plate forwards
⑧	Press plate shrink	Manual shrink the pressplate

<b>9</b>	Press plate movement	Manual shrink or expand the press plate
<b>10</b>	Sewing press plate cylinder movement	Sewing press plate cylinder shrink or expand
<b>11</b>	Save exit	Save change and return home pate
<b>12</b>	Cancel and exit	Cancel change and return home pate
<b>13</b>	last stitching	Manual move X, Y to last stitching
<b>14</b>	Next stitching	Manual move X, Y to next stitching
<b>15</b>	Pattern calibrate	After change the reference point, “pattern calibrate” update current pattern and move to current needle position
<b>16</b>	Needle number each	Stitching numbers each step
<b>17</b>	Stop reinforcement times	reinforcement times in the ending
<b>18</b>	Stop reinforcement needles	reinforcement needles in the ending
<b>19</b>	Start reinforcement times	reinforcement times in the beginning
<b>20</b>	Start reinforcement needles	reinforcement needles in the beginning
<b>21</b>	Total needles	Total needles of current pattern
<b>22</b>	Current needle	Current needle

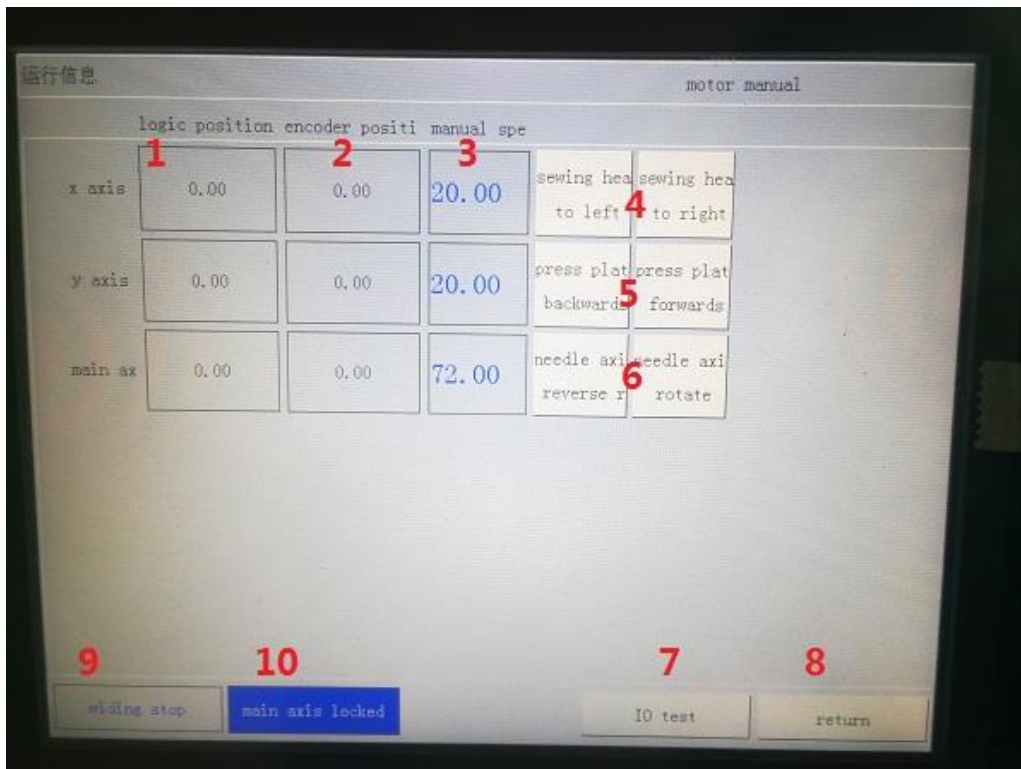


	button	description
①	V Shape bottom	V shape bottom
②	Flat bottom	Flat bottom
③	Decoration thread	Decoration thread type: single, double, cross
④	Processing direction	Left or right placket
⑤	Stitching distance	Stitching distance setting
⑥	Save file as	Save file name as
⑦	Parameter setting	Create the pattern according to setting parameter
⑧	Overwrite current	Overwrite current processing file
⑨	Save exit	Save change and return
⑩	Cancel exit	Cancel changes and return
⑪		Pattern display

<b>12</b>		Measurement input
<b>13</b>	“←”	delete
<b>14</b>	“CLR”	Clear off the data
<b>15</b>	“ENT”	Confirm and enter
<b>16</b>	“.”	Decimal point
<b>17</b>		0~~9

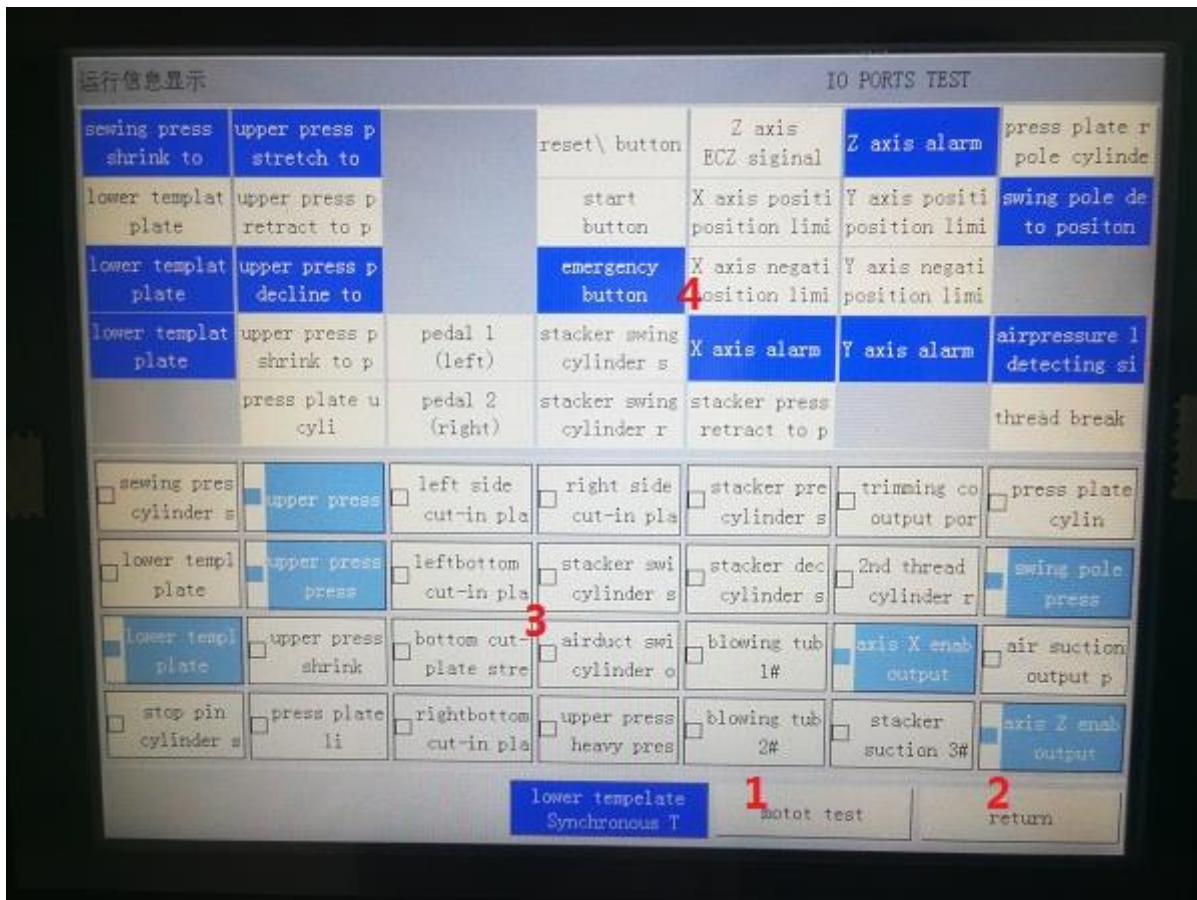


(1) motor manual test:



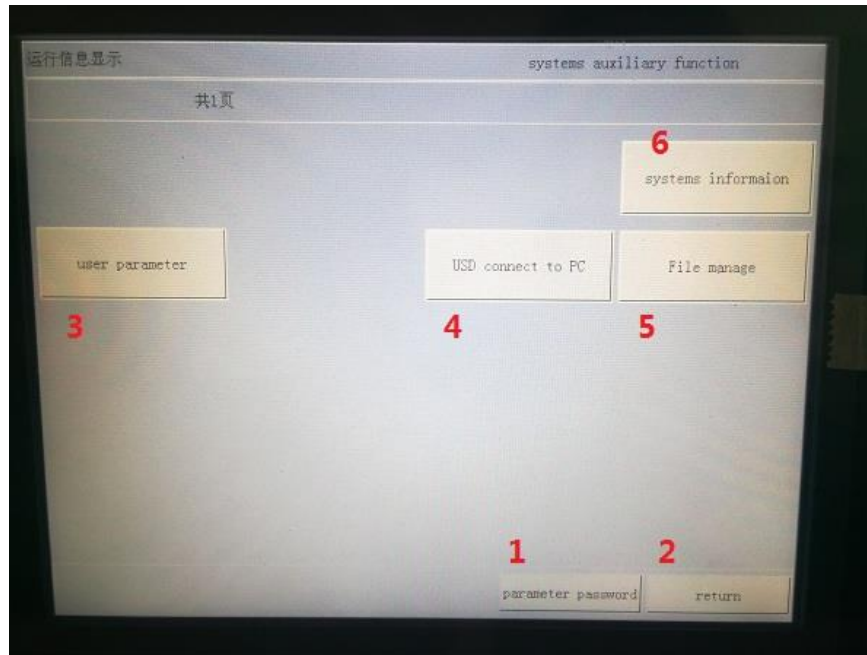
	button	description
①	Logic position	Logic position X, Y , main axis
②	Encoder position	Encoder of X, Y, main axis
③	Manual speed	Manual speed of X, Y, main axis
④		manual movement of X (sewing head)
⑤		manual movement of Y (Press plate)
⑥		manual rotary of A axis(main axis)forward/reverse
⑦	IO Test	Manual test of IO
⑧	return	return
⑨	Wilding start/stop	Wilding start/stop
⑩	Main axis lock	Maix axis/locler or unlock

(2) IO Manual test:

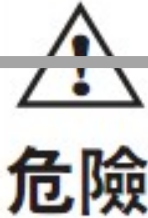


	button	descriptio
①	Motor test	Manual test motor
②	return	return
③		Manual output
④		Manual input

辅助功能主要包括用户非常用功能，如：用户参数，程序更新，usb 连接，系统信息，文件管理。



	button	descriton
①	Parameter password	Imput the password to protect the parameter
②	return	return
③	User parameter	User parameter
④	USB to PC	USB connect to PC
⑤	File manger	File manager
⑥	Systems information	Systems information



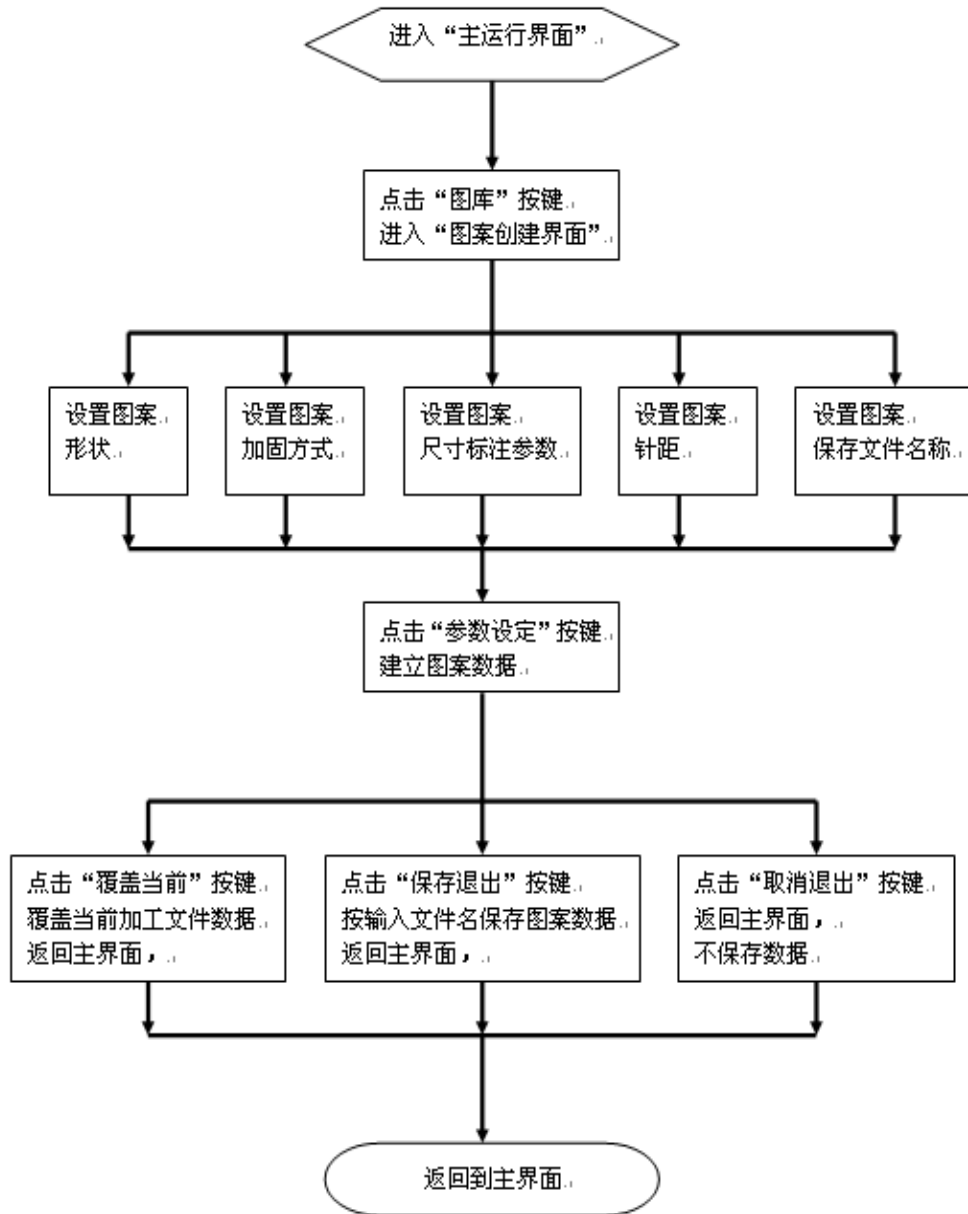
TO avoid the mistakes and hurt, please ensure below

- 1、 please clean the machine and add lubrication oil。
- 2、 AC 200V~240V。
- 3、 please don' t use the machine if voltage is not correct
- 4、 copmress air pressure0.5MPa
- 5、 don' t directly look at laser

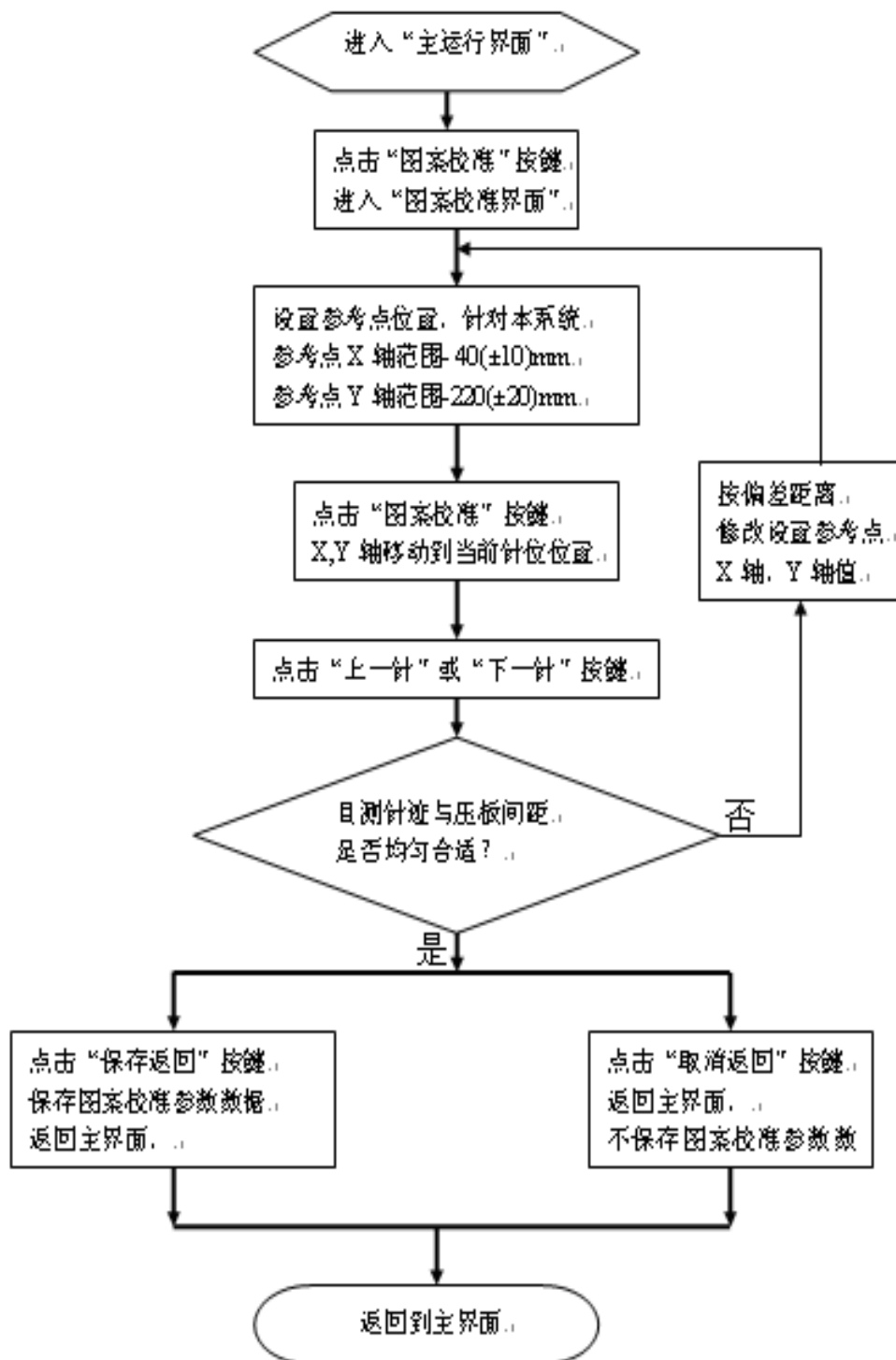
### (1) sewing head operation

- ◆ Switch on power
- ◆ Reset the sewing head
- ◆ Create patter file or choose the file from gallery
- ◆ Calibrate the pattern and save changes
- ◆ Enter into sewing interface
- ◆ Put material and step the right pedal to run
- ◆ The parameter for sewing head and service as indicated by the manual DDL-9000B

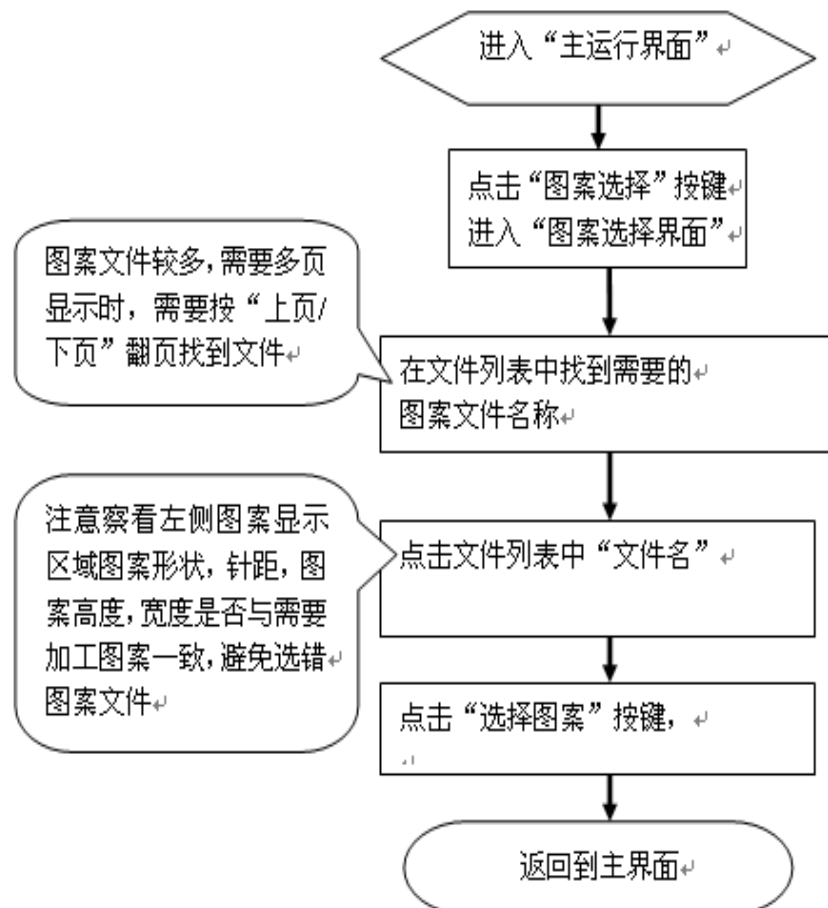
(1) 图案文件创建及修改流程:



## (2) 图案文件校准流程:



## (3) 图案文件更换流程:



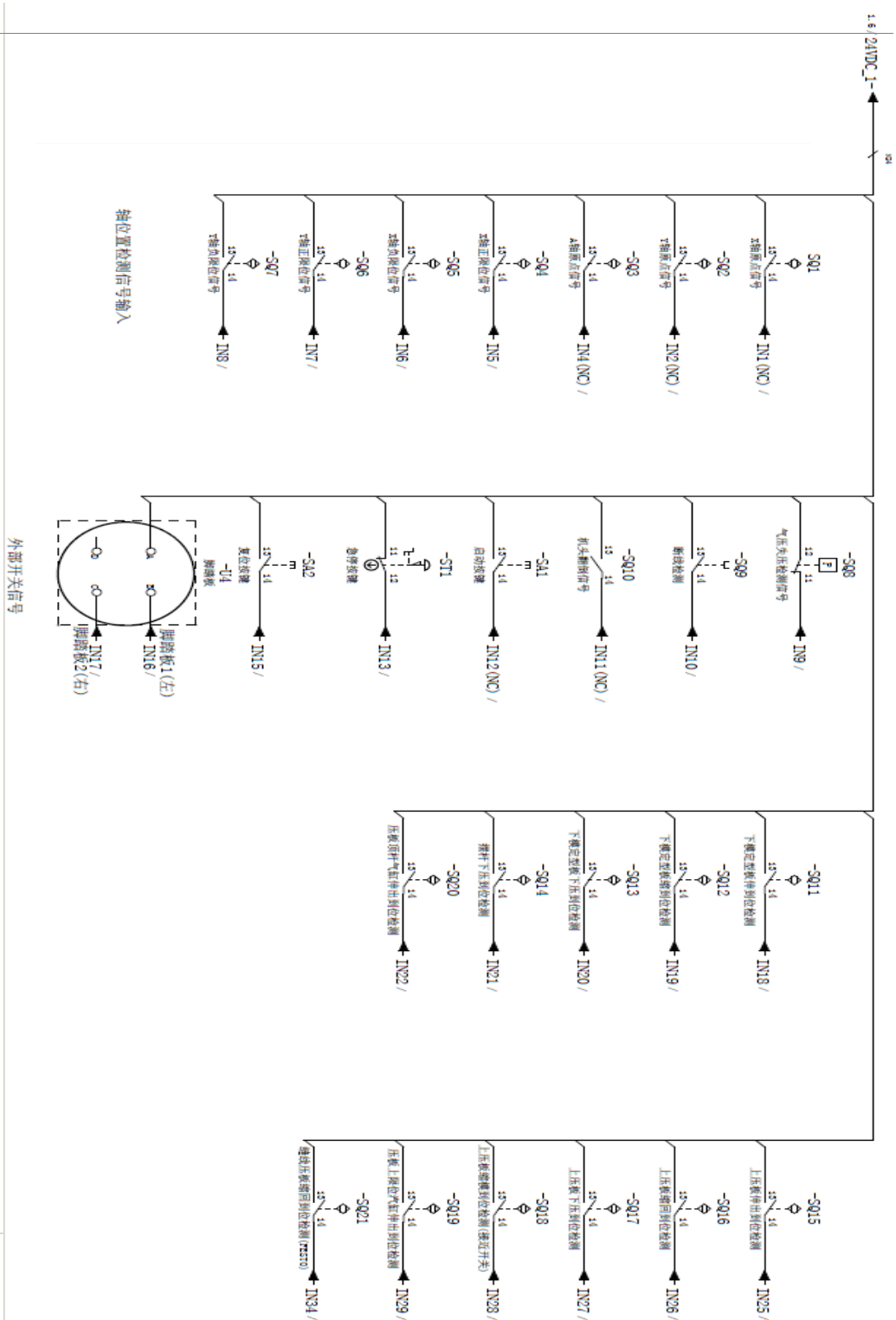
Below list is only for some main error information. If some error information out of the list come out, please kindly contact the manufacturer

No.	Error code	Description	Solution
1	E382	Emergency alarm	(1) check the emergency button;
2	E383	apply for reset alarm	(1) press reset
3	E336	Bobbin counting alarm	Set reasonable bobbin capacity. if remaining bobbin capacity is less than production demand, it will alarm to replace bobbin; If setting capacity at 0, it will not count .
4	E388	lower shaping plate stretch detecting error	(1)the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out solenoid and cylinder (4) check the air source. (5) check the IN18 input port
5	E389	lower shaping plate retract detecting error	1) the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out solenoid and cylinder (4) check the air source. (5) check the IN19 input port.
6	E391	lower shaping plate decline detecting error	1) the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out solenoid and cylinder (4) check the air source. (5) check the IN20 input port.
7	E412	thread break alarm	(1) Threading again (2) Check I10 input port

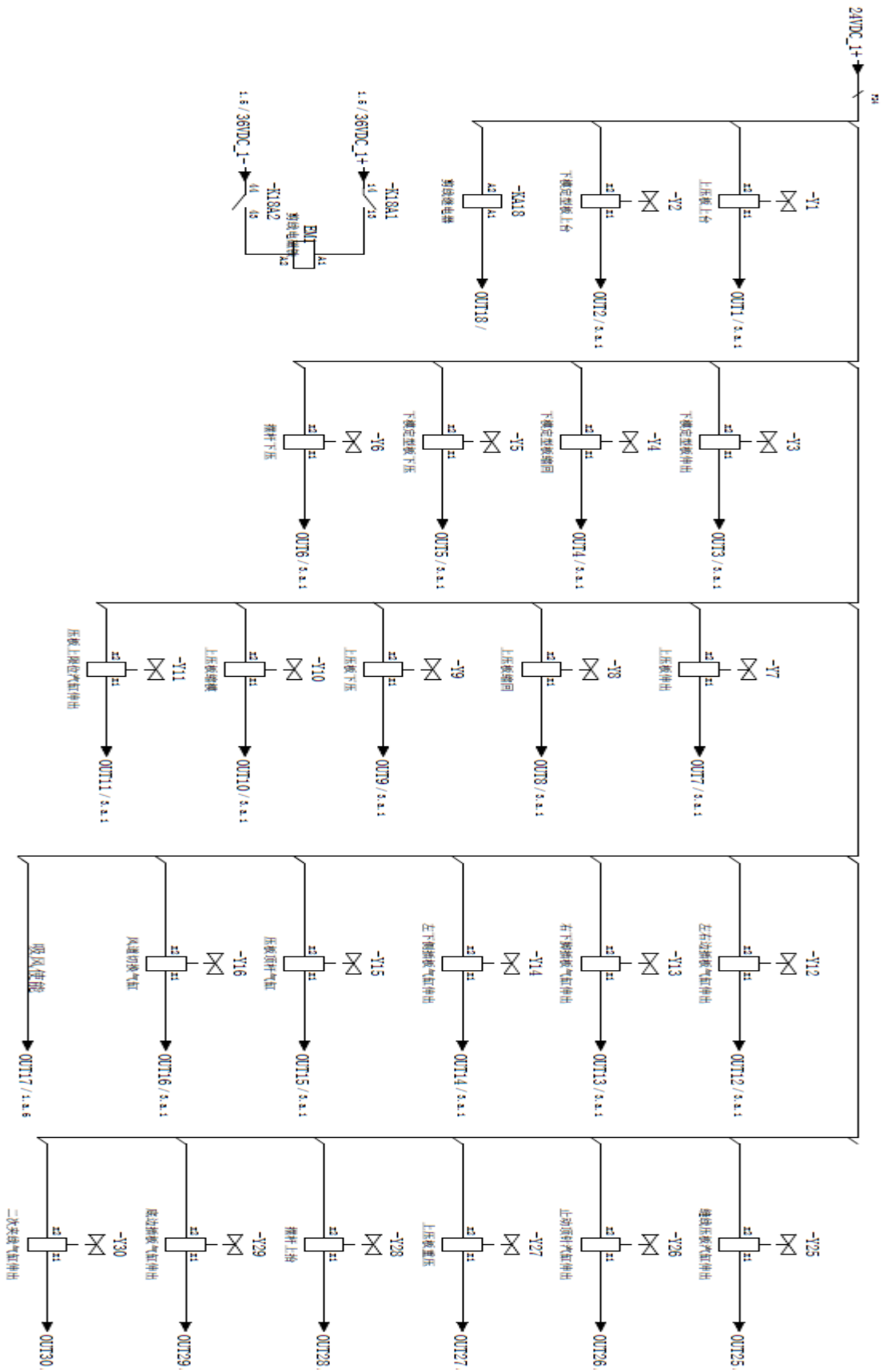


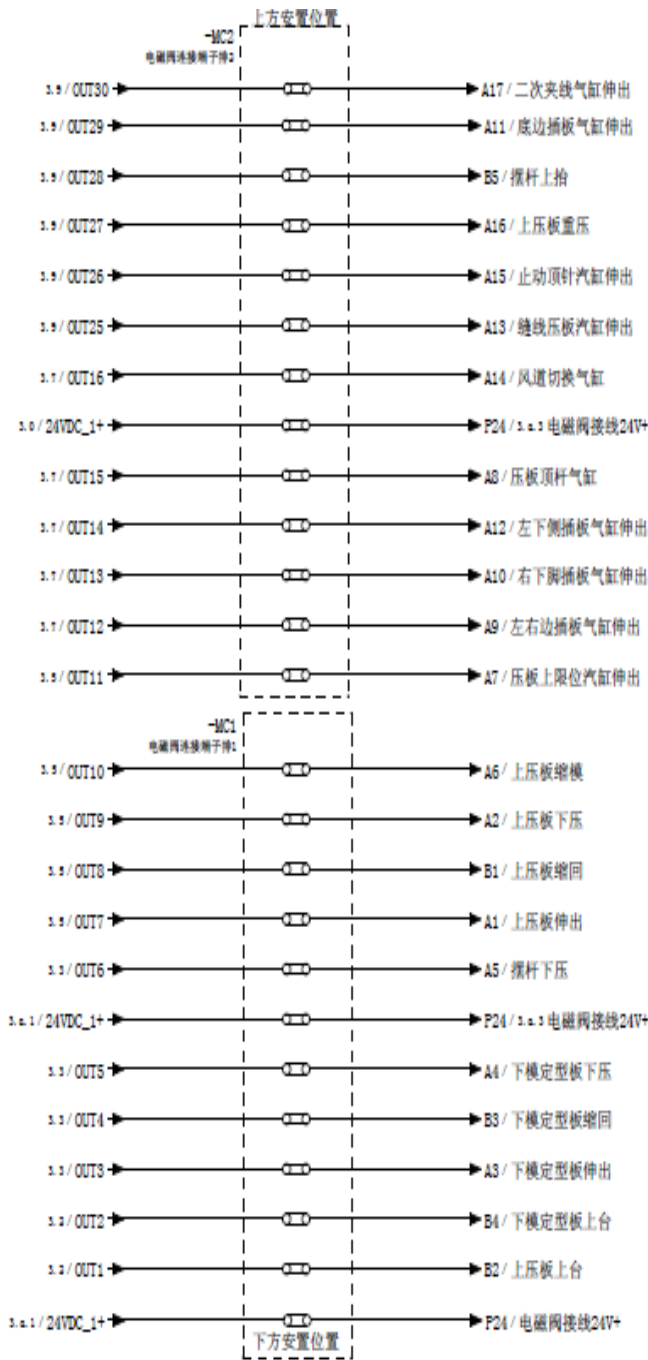
8	E393	swing pole decline detecting error	1) the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out solenoid and cylinder (4) check the air source. (5) check the IN21 input port
9	E465 E466 E468	X servo motor alarm Y servo motor alarm Z servo motor alarm	Power off and reset. (1) check the servo driver
10	E447 E448 E450	X position limit alarm Y position limit alarm Z position limit alarm	reset (1) X/Y/Z positive/negative limit positon sensor NOT ON or always on
11	E394	pressing plate rising cylinder stretch detecting error	(1)the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out solenoid and cylinder (4) check the air source. (5) check the IN22 input port
12	E396	upper pressing plate stretch detecting error	(1)the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out solenoid and cylinder (4) check the air source. (5) check the IN25 input port
13	E397	upper pressing plate retract detecting error	(1)the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out solenoid and cylinder (4) check the air source. (5) check the IN26 input port
14	E399	upper pressing plate decline detecting error	( (1) the sensor to detect the cylinder move out NOT ON or always ON ; (2) cylinder failure to move out (3) check the cylinder move out

			<p>solenoid and cylinder</p> <p>(4) check the air source.</p> <p>(5) check the IN27 input port</p>
15	E411	Air pressure alarm	<p>(1) check the air pressure 0.4mpa;</p> <p>(2) check the IN9 input port.</p>
16	E407	sewing press plate retract detecting error	<p>(1)the sensor to detect the cylinder move out NOT ON or always ON ;</p> <p>(2) cylinder failure to move out</p> <p>(3) check the cylinder move out solenoid and cylinder</p> <p>(4) check the air source.</p> <p>(5) check the IN71 input port</p>
17	E401	upper pressing plate retract detecting error	<p>(1)the sensor to detect the cylinder move out NOT ON or always ON ;</p> <p>(2) cylinder failure to move out</p> <p>(3) check the cylinder move out solenoid and cylinder</p> <p>(4) check the air source.</p> <p>(5) check the IN28 input port</p>
18	E402	pressing plate upper position limit cylinder stretch detecting error	<p>(1)the sensor to detect the cylinder move out NOT ON or always ON ;</p> <p>(2) cylinder failure to move out</p> <p>(3) check the cylinder move out solenoid and cylinder</p> <p>(4) check the air source.</p> <p>(5) check the IN29 input port</p>







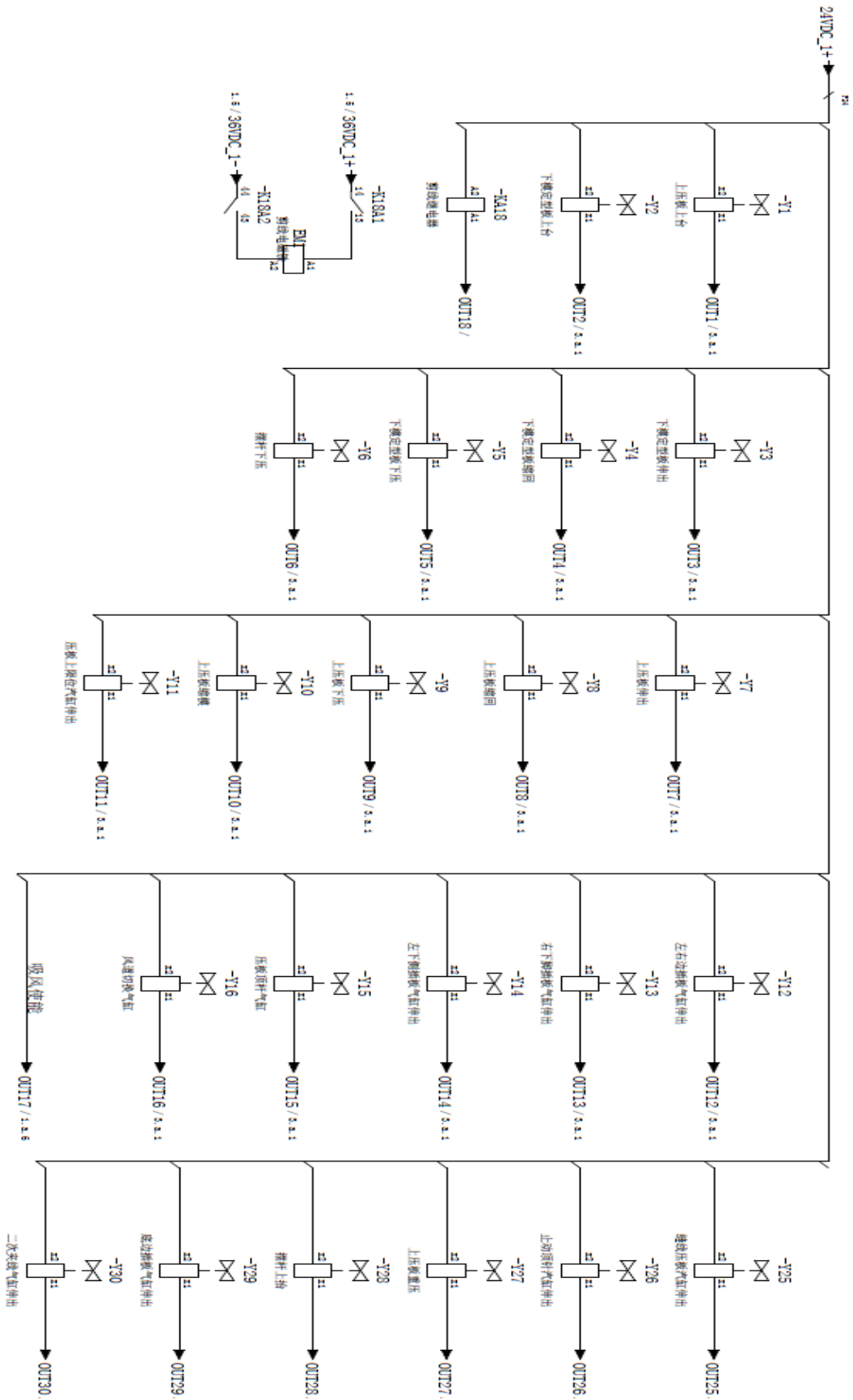


上方安置位置

A17 二次夹线气缸伸出
A16 上压板重压
A15 止动顶针汽缸伸出
A14 风道切换汽缸
A13 缝线压板汽缸伸出
A12 左侧插板汽缸伸出
A11 底边插板汽缸伸出
A10 右下脚插板汽缸伸出
A9 左右边插板汽缸伸出
A8 压板顶杆汽缸
A7 压板上限位汽缸伸出
A6 上压板增模
A5 摆杆下压
A4 下模定型板下压
A3 下模定型板伸出
A2 上压板下压
A1 上压板伸出
B5 摆杆上抬
B4 下模定型板上台
B3 下模定型板缩回
B2 上压板上台
B1 上压板缩回

下方安置位置

电磁阀排列示意





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※规格及外观经过改良可能会与图片所示有所不同