NT8710A-13095-D
User's manual

Directory

1.规格

1	Sewing range (x.y) (mm)	1300×950
2	Pressing off the cloth	Intermittent feed (pulse horse balance axis drive)
3	Pinch stroke	39.5mm
4	Maximum sewing speed	Thin material: 3000STI/min(Sewing pin2.2mmThe following) Thickness:1800STI / min (sewing pin3.5mmThe following) About other content reference map1
5	Can be set to the segment length	0.5 ~ 12.7mm
6	Use the needle	Thin material:DB× 1# 8 (# 7 ~ # 14),DP× 5# 8 (# 7 ~ # 14) Thickness:DP17# 21 Rely on model selection
7	Turpuring the ho	Total rotation of the hopper
8	Medium foot pressure	Standard4mm
9	Medium-pressure footing up	20mm
10	The appliance pressure rolled ups	15mm
11	The memory of the data	Maximum999Patterns
12	Identification of the number of patterns	Maximum999Patterns
13	Process input	USB
14	Infrared form	DXFTheAiThePLTTheDST
15	Spindle servo motor power	750W
16	Consumption power	500VA
17	Load voltage	220V ± 10%
18	Quality (total quality)	675kg (net weight)
19	Outline size: the machine is expanded Box	2450mm (w) × 2100mm (L) × 1550mm (H) 2050mm (w) x 1210mm (L) × 1755mm (H)
20	Use the temperature range	5 ~ 35 ℃
21	Use the humidity range	35 to 85%无 condensation
22	Save the temperature range	-5 ~ 60 ℃
23	Save the humidity range	10 ~ 85%无 condensed, 85%40 ℃ below)
24	Use air pressure	0.5 to 0.6MPA
25	Needle on the needle barrier stop function	After sewing, You can let the needle bar to the upper dead position.
26	Use oil	# 10 (equivalent toJukiNewDefirixOitNO1) # 32 (quiteIn theJukiNewDefirixOitNo2), lithium elements2No.Grease information Manufacturer: USA 韦namic; model: lithium group2 # grease

薄料

缝纫间距和缝纫速度			
编号	间距	旋转数	备注
1	2.8 mm	2,800 sti/min	
2	3.0 mm	2,500 sti/min	
3	4.0 mm	2,200 sti/min	
4	5.0 mm	1,800 sti/min	

注释：最高旋转数的持续时间不得超过 15 分钟。即便间距相同，由于针和布料的区别，旋转数有可能发生变动。

厚料

缝纫间距和缝纫速度			
编号	间距	旋转数	备注
1	3.5 mm	1,800 sti/min	
2	4.0 mm	1,600 sti/min	
3	4.5 mm	1,400 sti/min	
4	5.0 mm	1,200 sti/min	

注释：即便间距相同，由于针和布料的区别，旋转数有可能发生变动。

图 1

2.各部件的名称
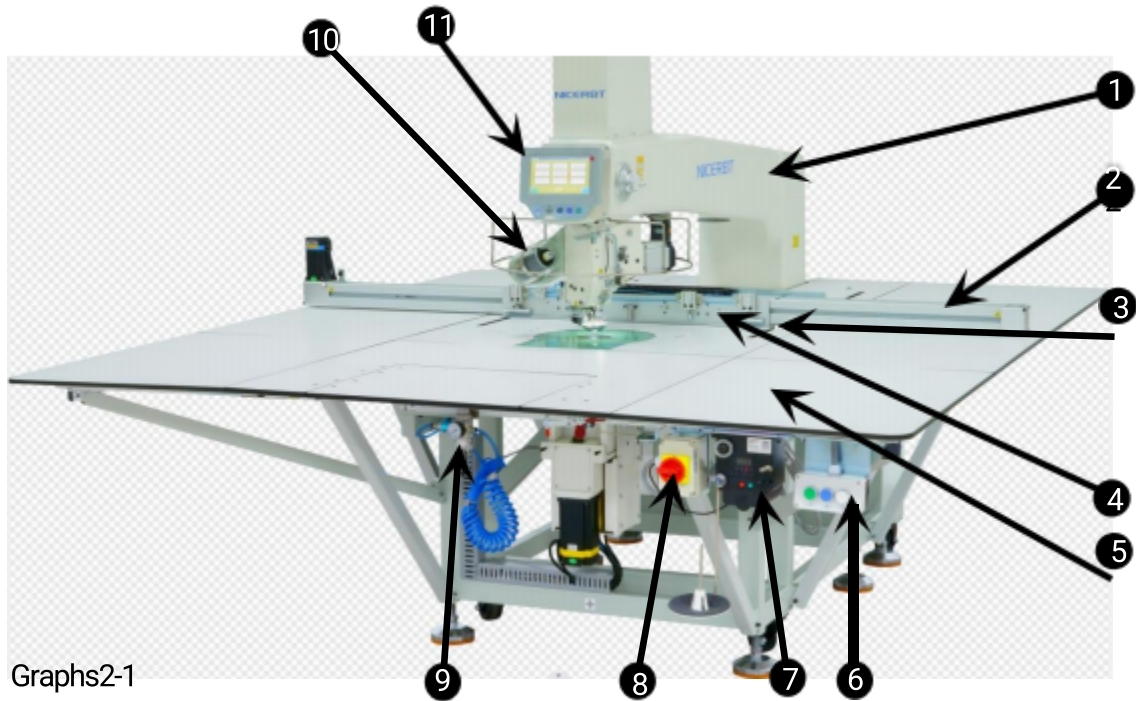
Graphs2-1

❶ 缝纫机机头

❷ X 轴传送机构

❸ Y 轴传送机构

❹ 卡夹装置

❺ 桌板

❻ 三位按钮盒

❼ 绕线装置

❽ 电源开关（兼用紧急停止开关）

❾ 空气控制箱

❿ 线架装置

⓫ 操作面板

3.安装

3-1.缝纫机的安装

3-1-1.拆下包装

Graphs3-1

1.As a map3-1Show, To enhance the clamping device ①.
2.Remove the top sealing plate, Remove the surrounding sealing plate.
3.As a map3-2ShowRemove the plastic dust bag.

Graphs3-2

4.Remove the left and right plates before and after the positioning screw ②
rear support, Remove the machine fixing plate (3)The
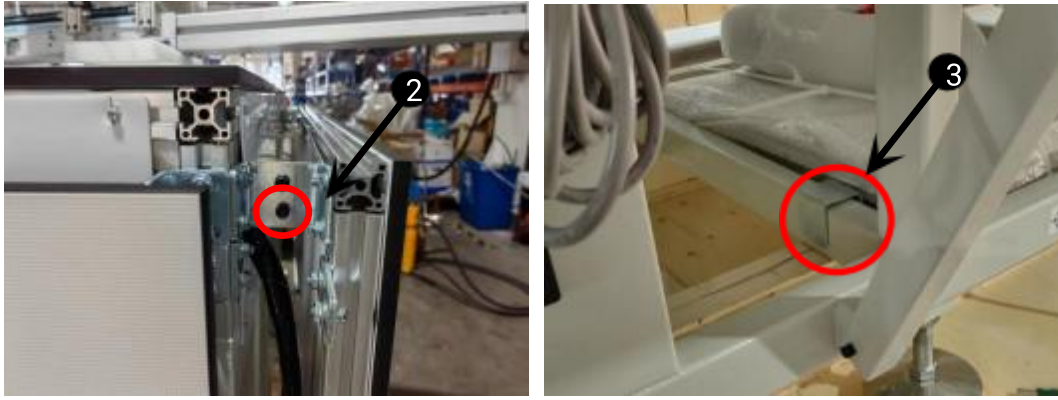
Graphs3-3

5.Please remove the parts on the wood frame and the subsidiary boxesSending mechanism and so on.

(Cut the beam band, Remove the parts)

6. Use the forklift to move the sewing machine to the specified location(Sewing machine675KG)The

※ 请将铲车插入此处。

Graphs3-5

7.MachineThe deviceFromThe endTopOn theTakeUnder the nextTime,RootAccording to the timeWaterFlatThe instrument(Front二RearFourCommonSixA)ToneSectionSupportFootHeight,
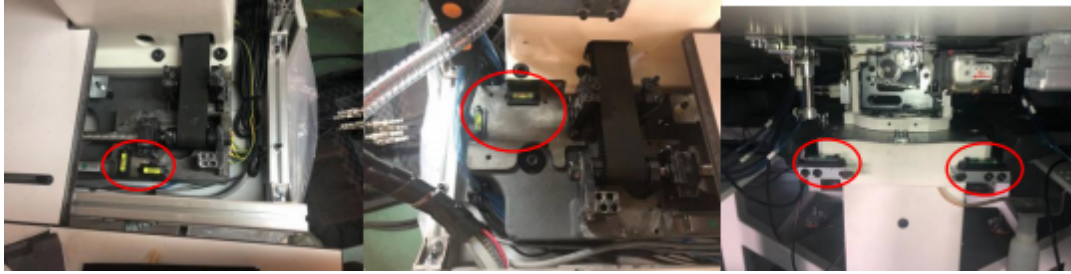
Graphs3-6

8. Adjust the support base, Make sure the balance of the sewing machine, So that it is in a sharp state.

3-1-2.X 输送装置安装

1. cut the beam band, Remove the external packaging.
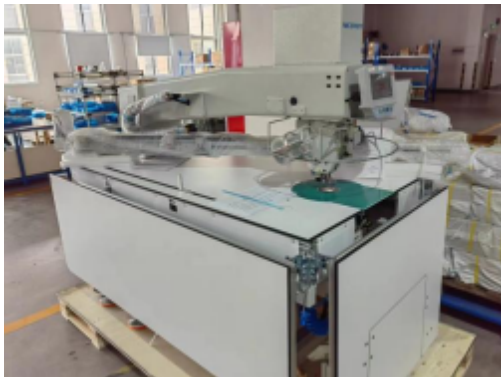
2.Remove the4Since theXThe lock nuts on the conveyance mechanism. (In the removal4A locking nut, To avoidThe interference of the installation screw, So that the clamping delivery of the middle.)

3. Remove the rubber plug ⑤,Tighten the bottom screw with a wrenchAnd then in anneaEquipped with rubber pier.Remove the nuts in the subssee box.
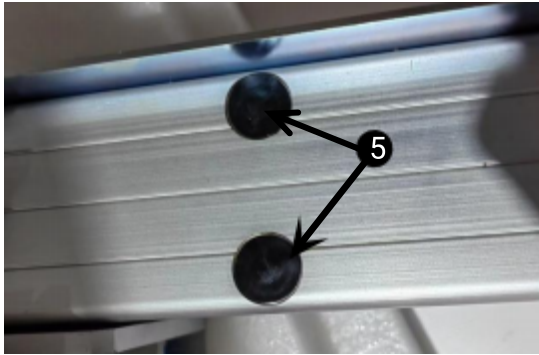
3-1-3.工作台安装

1. Install the left table, the right table, and the former tableIn the heart of the cityTime, Tighten the map1In the screws,Flat three pieces of plates.
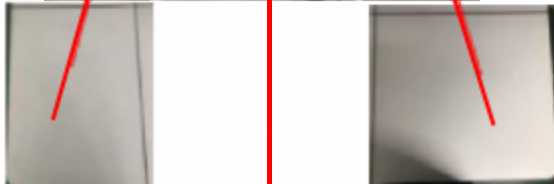
Graphs1

Graphs2

2. Install the front desk (left side) and the former table (right side)Time, Tighten the map2The aluminum frame special screwWith the nut.

3-1-4.安装开关、卷丝装置与开关按钮在（组）

1. About power switch componentsCAnd three-button box componentsD,TType boltsAAnd the nutsBTo be a minuteDo not fix the front desk(The right side)The aluminum profile.
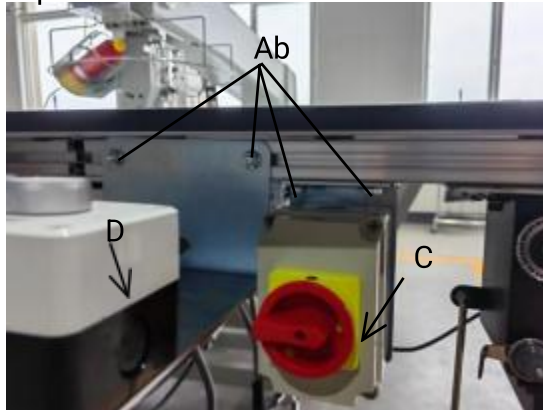
2. About the winding,UseTType screwAAnd the nutsBFix it to the aluminum type of the front desk (right side)Material.

3-1-5.打开电源前的检查以及注意事项

1. Check the balanced state of the sewing machine.

3.Check the combination of sewing machine electrical parts and air components.

4.Check the alignment of the seat machine with the center of the needle plate.
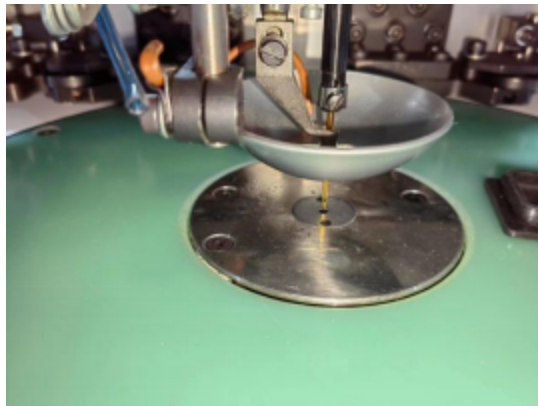
4. Remove the needle plate, Check the container alignment situation.

5. CheckXDelivery of the origin of the sensor and the optimizer gap.
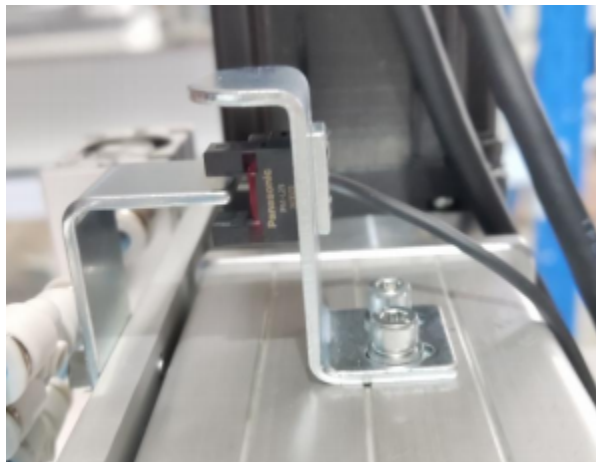
6.INSPECTIONXThe movement of the delivery.

3-2.空气软管的安装

⚠ 警告 Before you can blow the air to the body, make sure the air hose is to the air before it isDo not accurately insert the air bolt, Then and then slowly open the air bolt.

1. Pytable pyroid air
   Connect the air hose1.

2. Air pressure adjustment
   The air adjustment knobs2Pull up and rotate up, Adjust the air pressure to0.5 ~ 0.55MPAThe Then pressThe air adjustment button2.

2: Adjust the air pressure of the overshes of the sewing machine

（空气供给源）设备的注意事项

The cause of the air compressor (cylinder, air solenoid valve)90% is due to air quality, dirty, empty gas. Compressed air contains moisture, dirty, deterioration of carbon particles and other vulnerableIf you do notHandling words that use these "dirty air",Will happen to a fault,Cause the operating rate of the machine is reducedProduction.

3-3.有关压缩空气源

Set when using an air machine device, Please-Set the following standard air source devices.

用户方面需要的标准空气源设备

空气压缩机

后冷却器 — 自动排水

空气槽罐

主线过滤器 — 自动排水

空气干燥器 →

有关空气源的质量
空气源中含有大量的水分时

有关周围环境
在早晚气温差大的地方和容易发生冻结的地方设置本公司的机器时
请一定安装空气干燥器。

尘埃分离器 →

空气源中含有大量的炭尘脏污时
（大多数的空气电磁阀的故障原因是因为炭尘造成的。）
请一定安装尘埃分离器。

本公司标准装备

过滤器调节器

空气电磁阀

气缸

主配管方面的注意事项

· 主配管在空气流动方向平均 1m 应该设置 1cm 的下倾坡度。
· 从主配管安装分支时，压缩空气的取气口请用插座安装到配管上部，以防止管内积存的冷凝水流出。
· 请在所有低的部位和死端安装排水装置（自动排水），以防止冷凝水积存。
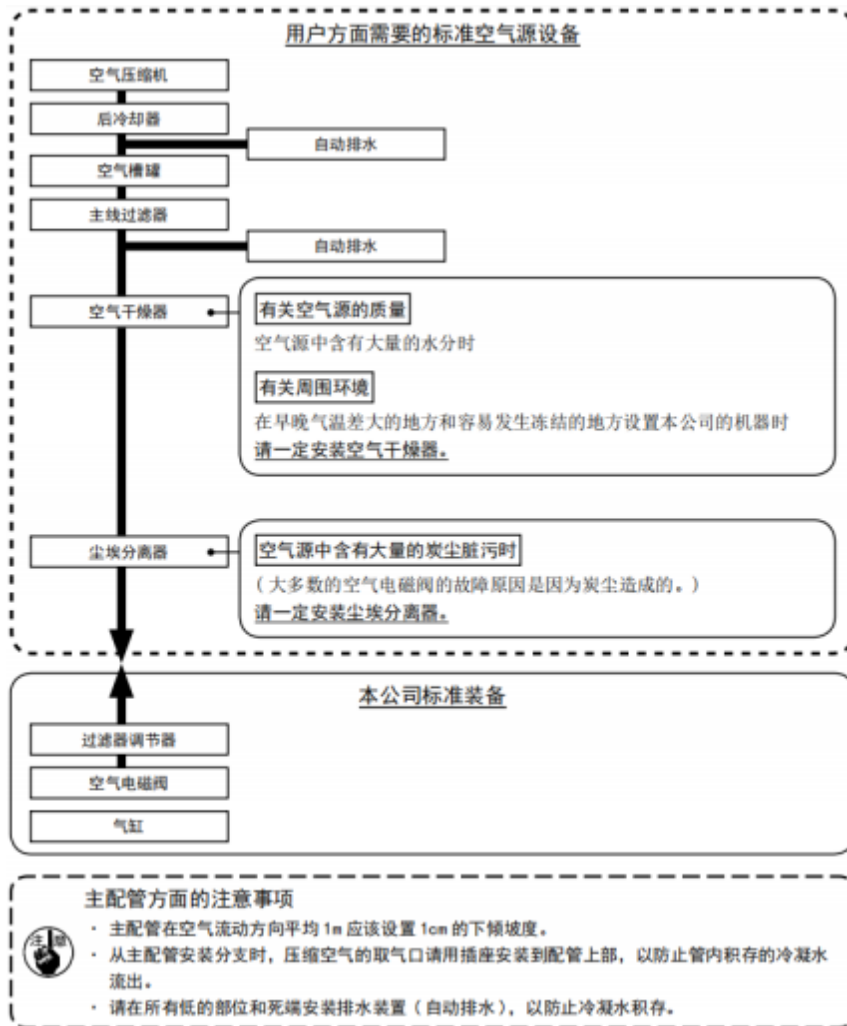
3-4.安装绕线器

Will be bounded by the wrapper1Insert the hole of the winding2In the, With the spiritMother3Fixed.

3-5 关于机械设置的注意事项

1. According to the size of the template,XThe direction may be exceeded in the sewing machine table. Please pay attention to not to be notTouching the body and triggering injury.

2. Make sure to start from the sewing machine table, Whether or so before or before and after, Have more than500mmThe space.
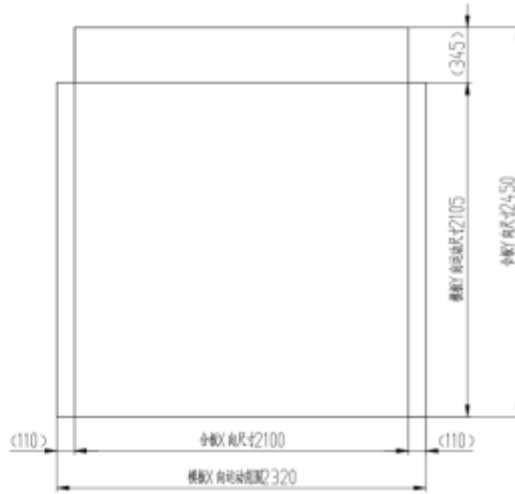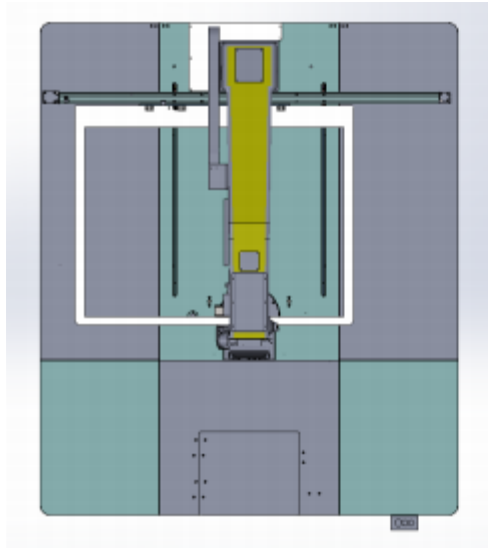
4.缝纫机的准备

4-1.加油方法和油量的确认

⚠ **警告** To prevent the incident of the accident, Please turn off the power again.1. Remove the cylinder top plate1.
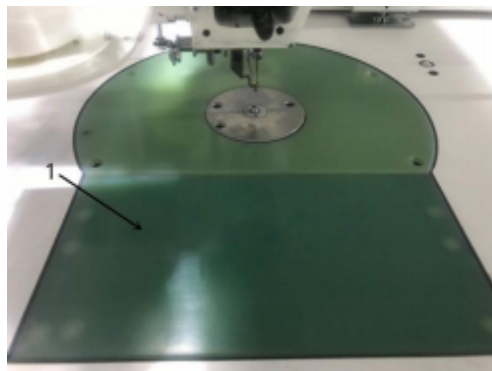
2. Remove the rubber plug of the oil box2.
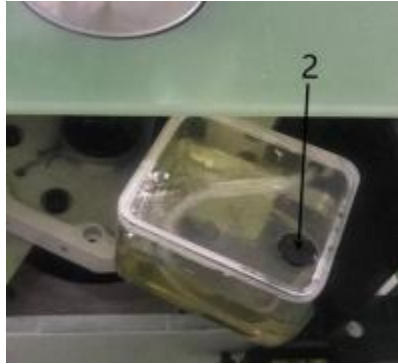
3. Injection of affiliated lubricants(10No white oilThe

4.Oil boxMinShow ~MaxThere is a reasonable amount of oil between the display.
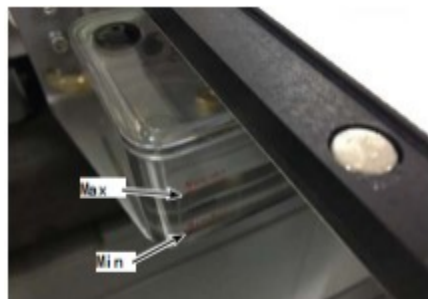
4-2.机针的安装方法

⚠️警告 To prevent the incident of the accident, Please turn off the power again.1. Loosen the screws1, Remove the needle.

Be sure to let the needle groove2Alignment of the rotary container(Turpostles)The top of the3The direction.2. Tighten the screws1.

If you want to replace to a different different needle, Be sure to re-adjust the rotary container(Turpostles)With the needleThe distance between the If forgetting to adjust, May be the following questions:1. pick-up;2. Loose loose;3. Top of the containerDecond;
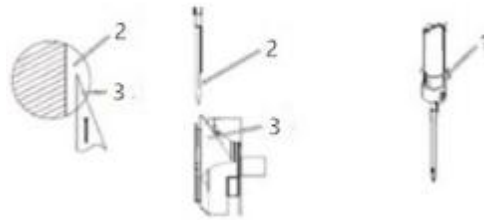
After the installation is complete, Light machine head wheel, Check whether the needle is accurate into the paper body.

4-3.上线的穿线方法

⚠️ **警告** To prevent the incident of the accident, Please turn off the power again.1. sewing the wire1Insert a fixed device2.
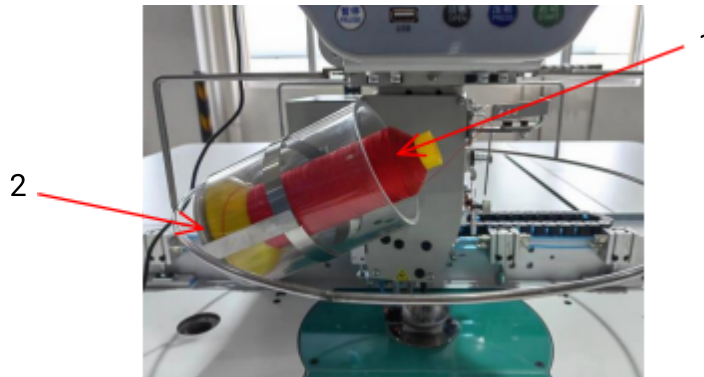
2. Through the thread of the line through, Last line out of the line through the thread50 to 60mmThe
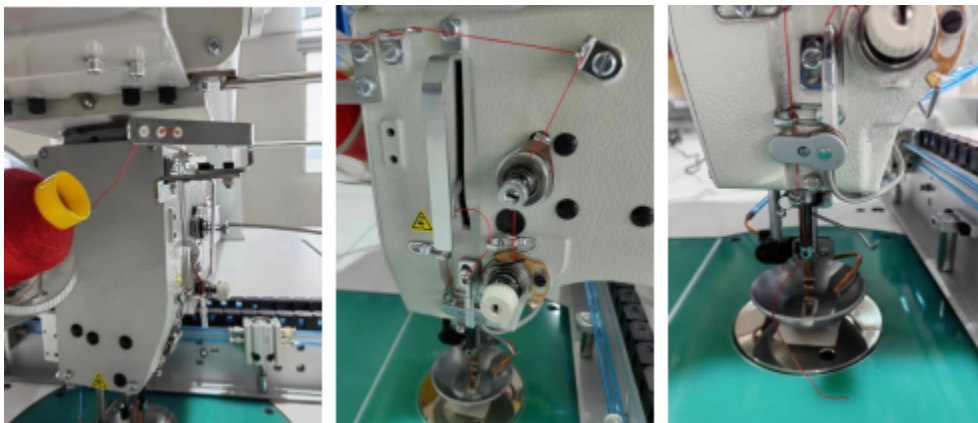
4-4.梭芯的更换流程

(1) shuttle shell removed
    1. Open the cylinder top plate1, You can replace the bobbin.
    2. Touch the offshore3The foot of the footA, Take out the shuttle3And the body of the core2.
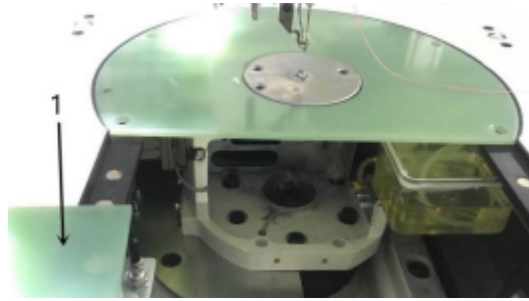
In the opening of the cover1Please confirm the position of the hand or other item before, To prevent climbing items and causedBody hurt. In addition toPlease do not put hand on the cover1Press on the press.

(2) mounting of the body

1. Burn the bobbin2Insert the shuttle housing in the direction of the illustrated3.
2. Through the line through the shuttle3The outline of the outletB, Then pull the line,The line of the line of the line tension spring below the threadingCLaw out of the pull.
3. From lineCPull out50mm.

Crystal2The direction of the opposite,
Bottom line pulls unstable.(3) mounting mounting mounting

1. When you put it, please put it back to the grainAThe state, insert the kin and the click of the clickMake sure.
2. Place the cover1Close.

If there is not been inserted, Situation of the shuttle3It may be offFalling.
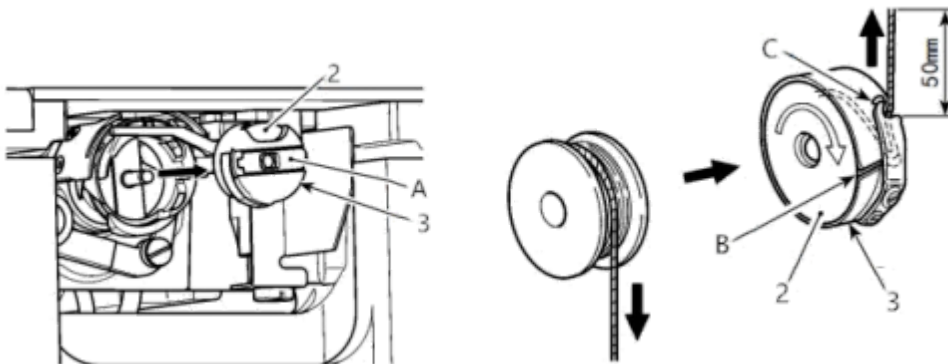
4-5.线张力的调整方法

(1)Online tension adjustment
The-Line tensioner1
In the loosening the line tensioner3When the line tension tray,Must be a little zero capable of controlling the tangentForward. Rely on line tensioner1, Resulting in the remaining tension. Can adjust the line tensionerNuts2, In the automatic tangentAfter that, Determine the length of the line at the length of the line.

If it clockwise(+) Rotating nuts2From the end of the pinWill become short.
If counterclockwise(-) Rotary nuts2, From the end of the pin out of theChannel length.

TheOne of the oneLine tensioner3

About the second tensioner3Tension(Tension of the line drawn out of the pin),As low as possible,Let the line intersect at the center of the cloth (GraphsA). If the sewing thin fabric is too tension too strong, Will lead to fabric productionFold wrinkles or break break.

If it clockwise(+) Rotating nuts4, Line of the line from the needle will become larger.

If counterclockwise(-) Rotary nuts4, The line leads the line leads to small.
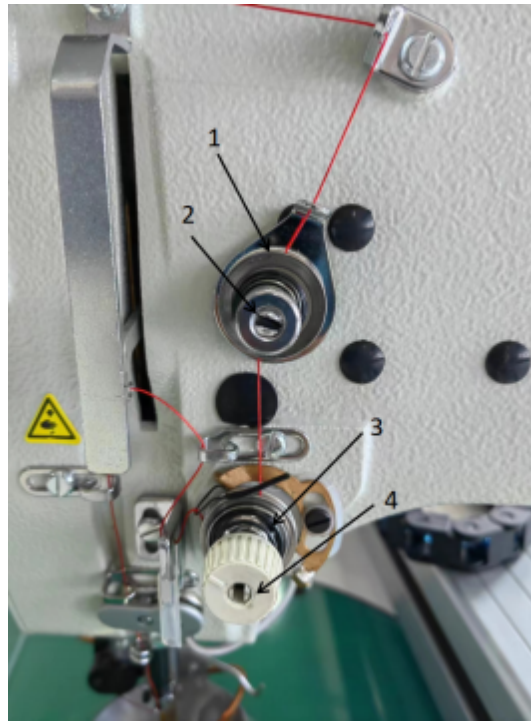
GraphsA: The line is correct in the center of the fabric
GraphsB: The line tension leads from the pin is weak, Or under the line tension too strong
GraphsC: Overlinned line of rise from the pin, Or underline the tension is weak
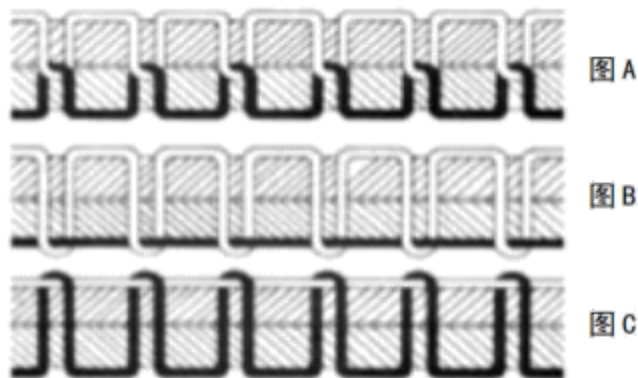
(2) the adjustment of the bottom line tension

1. to rightAThe 方向 turn the line tension screw5If, Bottom line tension strongAnd to the leftBThe 方Turn the words, The bottom line tension is weak.

Recommended value:25gOn the right
If the shuttle housing is in the state of the state, Will be sincerely slow down.
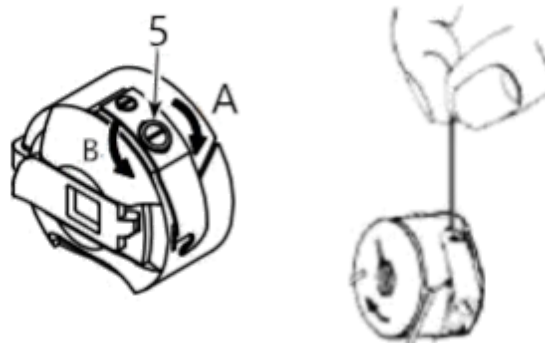
4-6.挑线弹簧和断线检测板的调整

1. Adjustment of the itinerary
   Loosen the fixed screws2, Rotate the line tensioner3.After rotating to the right, Balloon spring1The trip to theThe line volume becomes much.
2. Adjustment of strength
   Change the balloon spring1When the strength is made, please fix the screws2Tighten the state,Put the screwdriver into the lineTension rod4The missing part is adjustedTheAfter turning on right,Billings spring1The strength becomes strong, Turn to the left,Strength becomes weak.
3. Disconnect the detection board
   Loosen the fixed screw6, adjust the disconnect plate5The location of the discount,5And pick-up spring1Of theThe contact amount is0 ~ 0.2mmThe

Broken detection board5In addition to the pick-up spring1Can not be contacted with other metal parts. And it'sHe goldIs the contact words, An error occurred.

4-7 挑线杆挑线量的调整

1.When making thick material,AThe direction of the movement directed1, The slip varies more.
2.When making a thin material,BThe ingredient to the mobile line guide1, The film volume becomes less.
3.Line guide1The standard position is the standard position when the center of the long hole is aligned with respect to the screw.
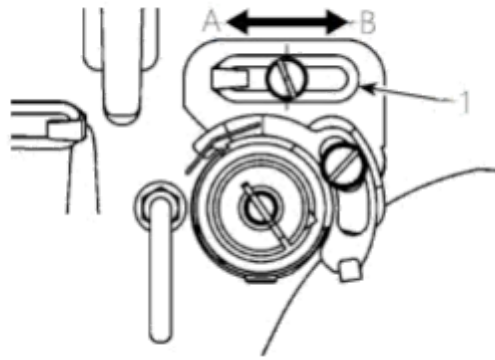
4-8 机针和旋梭的关系

⚠️ **警告** To prevent the incident of the accident, Please turn off the power again.(1) set the needle and container and angle

1.Start the dead point from the needle bar,Thin material specifications2.9 ± 0.3mmThe position of the position,Thickness specifications rise2.4± 0.3mmThe position of the position, Adjust the height and the hobbit position of the needle rod.

2.From the front view to see the center of the shuttle at the center of the pinhole and the pinhole center.

3.The gap between the shift and the recess of the needle is viewed from the side view0.05 to 0.2mmThe

2.4±0.3mm

0.05～0.2mm

正面　　　　侧面
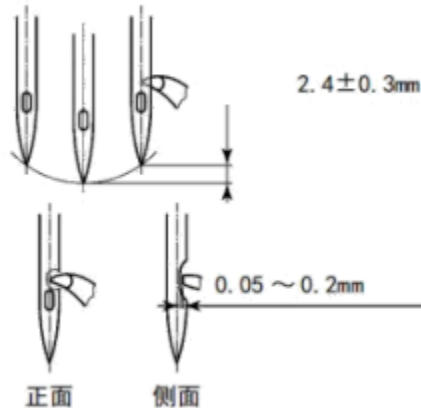
4.As shown in the figure,The angle setting of the motor shaftQEPThe value is displayed as170 to 175.
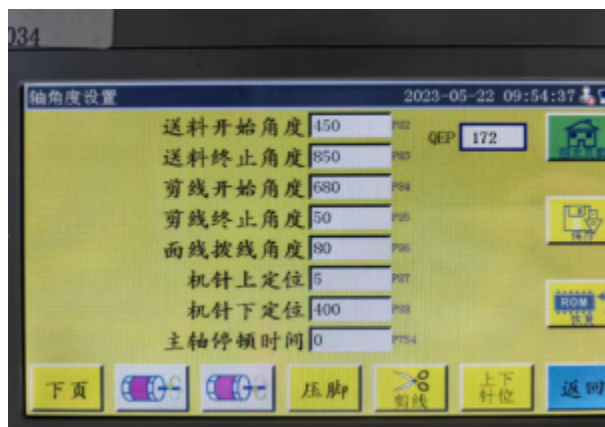
(2) the location of the container presser foot
   1. Middle of the container presser foot and the front and rear positions of the needle:The front end is aligned with the middle container.

   2. Middle of the container presser foot and the left and right positions of the needle:The right end of the positioning hook of the middle container is aligned with the right hand.

4-9.下线的卷法

   1. To the bobbin2Insert a reel coil3.
   2. Insert the sewing machine line into the line fixing bar6.
   3. Winter as shown.
   4. Rely on by clockwise direction in the bobbin2The number of thumbs up.
   5. Press the spinsoar4, Start the line.
   6.-Destroy the set of downline volumes(80%),The rotation of the coil device stops. In addition to the otherPress the pressButton5, Stop the line.
   7. With a cutting device1Carrying a cutting line, Remove the bobbin2.
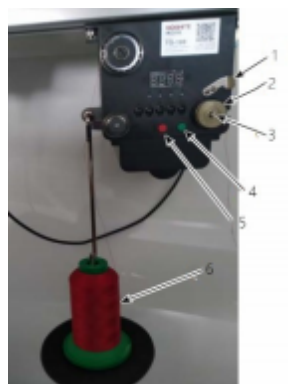
4-10.调节针杆高度

⚠️ **警告** To prevent the incident of the accident, Please turn off the power again.Rotate the handwheel in the counterclockwise direction, Let the needle barrel down to theDead.

At this time, Needles lever connecting rod and needle bar as shown in the following figure shown in the straight line.

Thin material:Let the pinhole is exposed from the shuttle1/2. (Standard location)
Thickness:The distance from the plane of the needle rod to the needle plate is set18.4 ± 0.3mmThe Let the pinhole is exposed from the shuttle2/3.
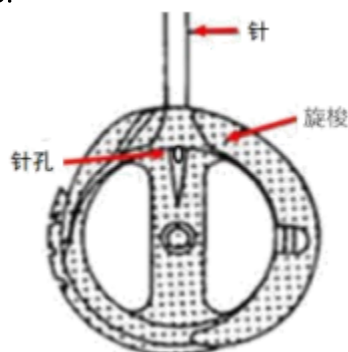
📝 Decimate the height of the needle stick according to the fabric.

1.As the ordinary fabric belongs to the 二, Three-layer structureSo,Let the pinhole is exposed from the shuttle1/2.
2.Fabrics and other thicker fabrics with knitted fabrics, Let the pinhole exist from the suspension2/3.
3.Depending on the fabric and fabric thickness, The needle galls will change.

4-11.调节剪线的位置

⚠️ **警告** For preventing personal inaccution of,
Please turn off the power again.(1) adjust the position of the cutting cam

    1. Rotate the synchronous wheel1, Let the triangular cam groove2And scroll connecting rod needle bearings3Bite.

    Angle setting the parameter on the motor shaftQEPValue, 170Belong to the shipper standards,Different from the fabricYes
Parameters tightly tone.
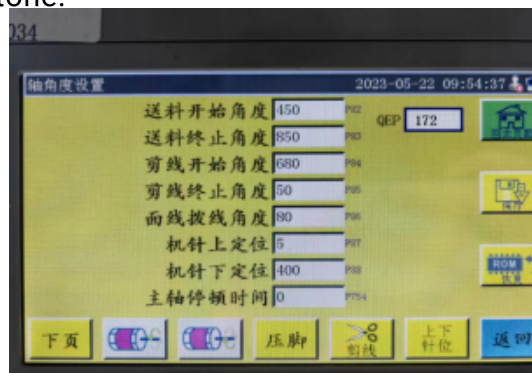
(2) Adjust the position of the movable blade and the fixed blade

    1. Install the fixed blade
In the fixed telles of the tailOne of the oneA hole,2.5Hexagonal pullHand2Insert the tail of the fixed bladeQuartet hex wrench, Tighten the fixed screws for fixed blade.

    2. Install the movable blade in the movable blade table, Press the movable blade to the rightLet the movable blade tail andMovable blade table parallel, At this point the movable blade top and the synchronization. TightenMovable blade tightening screws1.
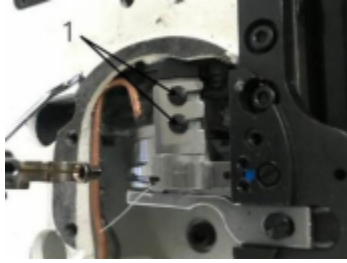
3. In the blade of the movable blade5mmMake a sign with a black pen,Adjust the screws using fixed blade pressure3Adjust the fixed blade pressure. After adjustment, Will move the blade pressure, RelaxedStyle until the black tab mark twoThe edge is accurately friction. In addition, cut off3The root has been usedPeriod of the machine,To maximize the maximumThe friction between the movable blade and the fixed blade.

用黑笔在可动刀片两边涂色

两边的黑色记号同时擦到
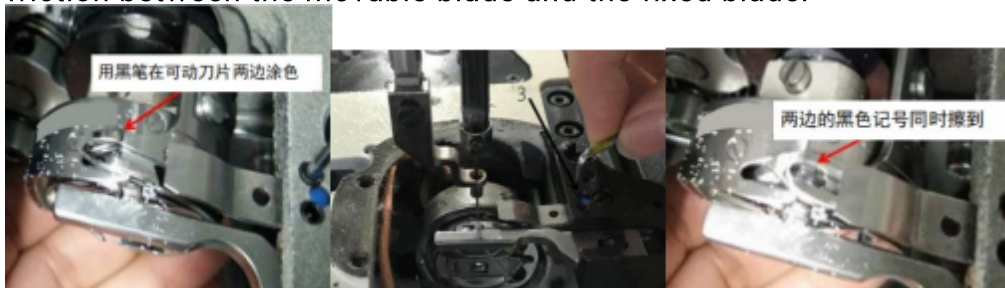
4-12.气缸顶板的拆卸方法与安装方法

1.In the case of perfused electric sewing machine, Press the switch1.
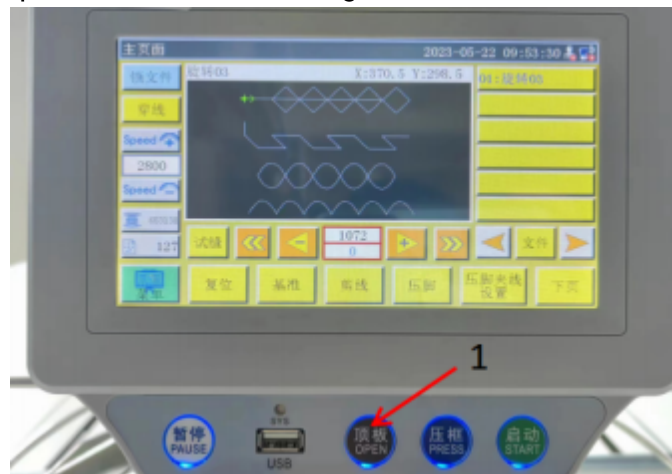
2.Cylinder top plate2Will be offset to the topSo, remove the cylinder top plate.(Cylinder for pressure)
3.In the installation of the cylinder top plate2Time,Press the switch1And installed.
(Cylinder falls,In the mountable state, Relying on magnetic fixation)

4-13.旋梭油量（油迹）的确认方法

⚠️ **警告**
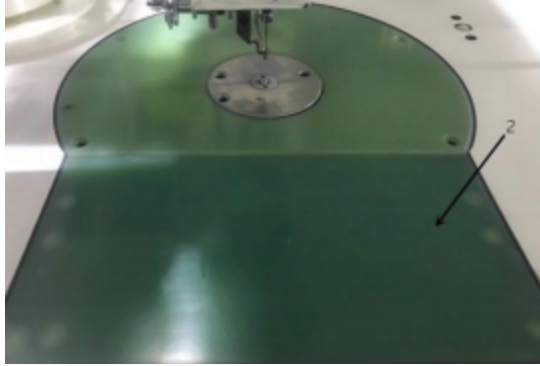
The hook is running at high speed. To prevent the amount of oil to adjust the amount of oil, please charge Take a note.

(1) oil(Incubation)Confirmation method

❶ 油量（油迹）确认专用纸

30mm 左右

100mm 左右

※ 不用考虑纸的质量。

❷ 油量（油迹）确认位置

10mm

油迹确认专用纸
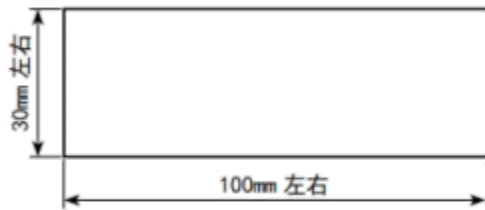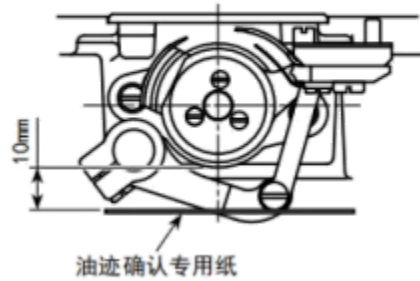
✍️ To carry outOne of the oneWhen the operation is operated, Please remove the uplink and bobbin line from the pick-up rod to the machine,Pressure foot in

The amount of oil is acknowledged at the time after removing the slide. At this time, PleaseOne of the oneMake sure not to let the hopper touches the finger.

1. Please refer to "4-1. Confirmation of oil refining methods and oil", To confirm whether the amount of oil is appropriate.2. When the head is cooled, Please make15Minutes left and right turn-free operation.

3. Please increase the amount of oil when the sewing machine is running(Tubes) confirm the dedicated paper insertion.

4. Oil amount(Tubes) confirmation time10Second.

(2) oil(Incub) is suitable for schedule

油量适当（少）

从旋梭飞溅出来的油

油量适当（多）

从旋梭飞溅出来的油

最小 0.5mm
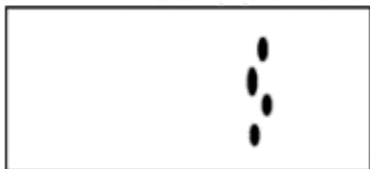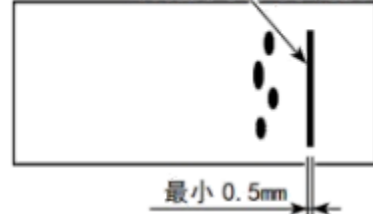
1. The above-described illustration indicates the amount of oil(Incub) the amount of state.

2. oil(Incubcut) should be confirmed3Timely 无 change.

Please note that no increase of oil or increase. Oil is too burnedTurpuring the ho(Turbine heat),Oil amountOver dirty dirty fouling.

4-14.旋梭油量的调整

1. Remove the cylinder top plate.
2. Let the screws1To the arrowA方 to the rotation, Oil will increase, To the arrowB方 to the rotation,Will be reduced.3. After adjustment, Install the cylinder top plate.
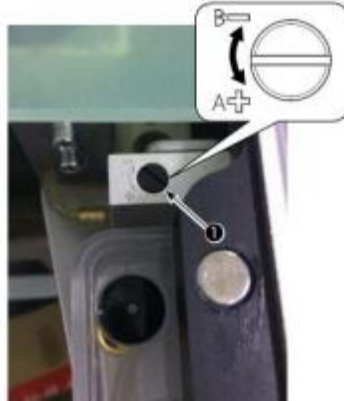
1. Adjustment1. After adjustment, please use the 鏱 鏱 鏱 空 运 运 运 运 运 运 运 运 运 运 运 运 运 运 运 1. 1. 1. 1.30After the second, the measurement was performedAnd oil and appropriate amount of standard, the confirmation of oil. (Refer to "4-13. Turpostool oil (tubes)Confirm the law)

2. Adjust the hopping tank when the amount of shuttle, Please adjust the larger oil after theAnd then make the amount of oilReduce the adjustment.

3. Turnover shipment when the shipment is adjusted according to the highest sewing speed, if the customer often uses lowSpeed sewing speed,It is possible to fail due to shortcomings of hopper,So often at low speedSewing speed,Please adjust the shuttle of oil.

4-15.调节针板的针孔和针

⚠️ 警告 For preventing personal inaccution of, Please turn off the power again.When the needle is not in the center of the needle pinhole hole, Can use screws1,2Adjust the adjustment.
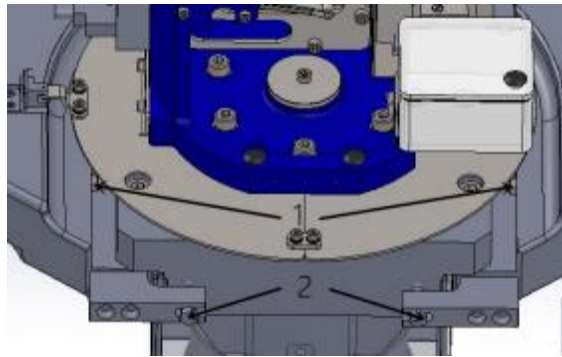
1. Install the needle board.
2. Loosen the cover plate fixing screws3, Remove the connector4.
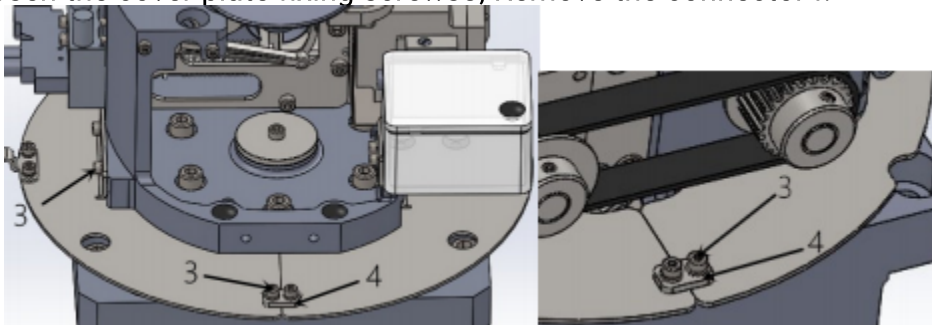
3. Remove the left and right cover5,6
   4. Reinct the spindle mounting seat fixture screws7,Adjust the screws1,2,Let the center position for the bench pinhole.
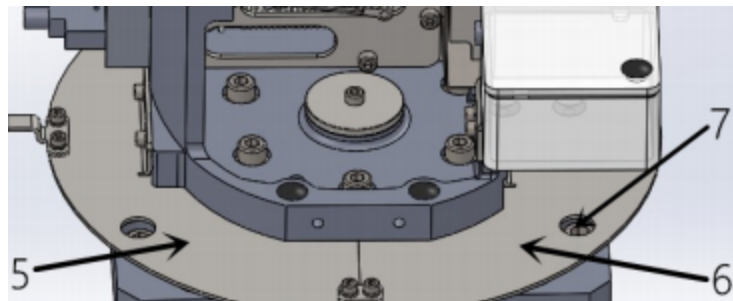
5. Tighten the spool on the mounting seat fixture7.
6. Install the left and right cover5,6.

4-16.设定机械性原点

1. Largely loosening the motor synchronous wheel to hold the screw1, Press the control interface of the control3The
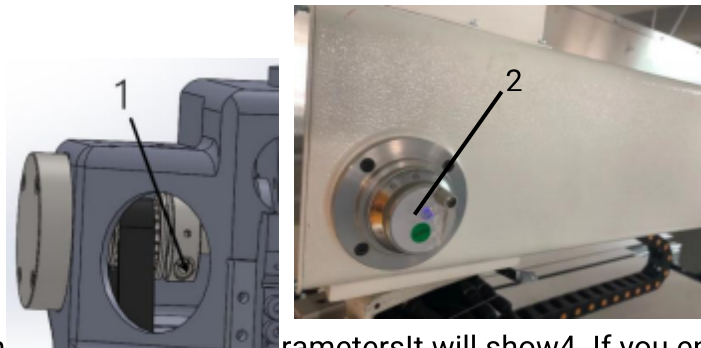
2. Press the mechanical setting parametersIt will show4. If you enter a password111111111It will show5.
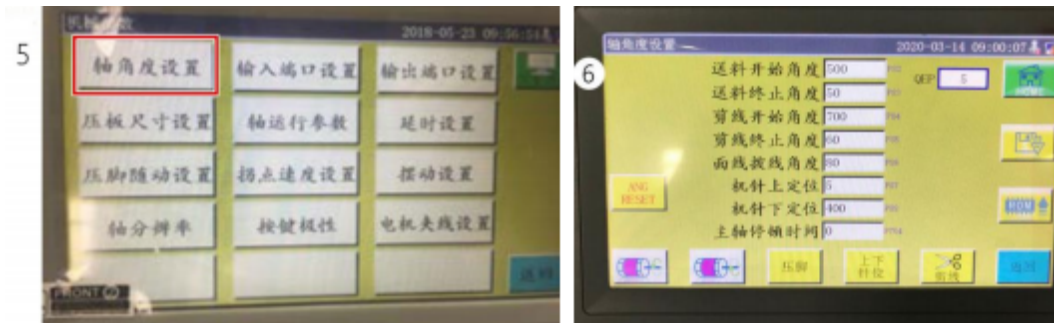
3. Press the displayed and displayed in the axis angle6On the,QEPThe value is set170, Turn the electronic handwheel2,Let the needle rows to the upper dead point.

4. Press the handwheel2 (no needle needle)Click the shaft of the picture to setThe number ofQEPValue, adjustment to0TheRear, Tighten the motor synchronous wheel to hold the screw1.

5. To this point the adjustment is completed. Re-rotate the pulley if the pellet of the needle barQEPThe value is0, origin adjustmentThere is no problem.

4-17.调节托盘压脚压力

1. In order to adjust the raised speed of the discs, On the outside of the cylinder speedThe degree of control valve is adjusted
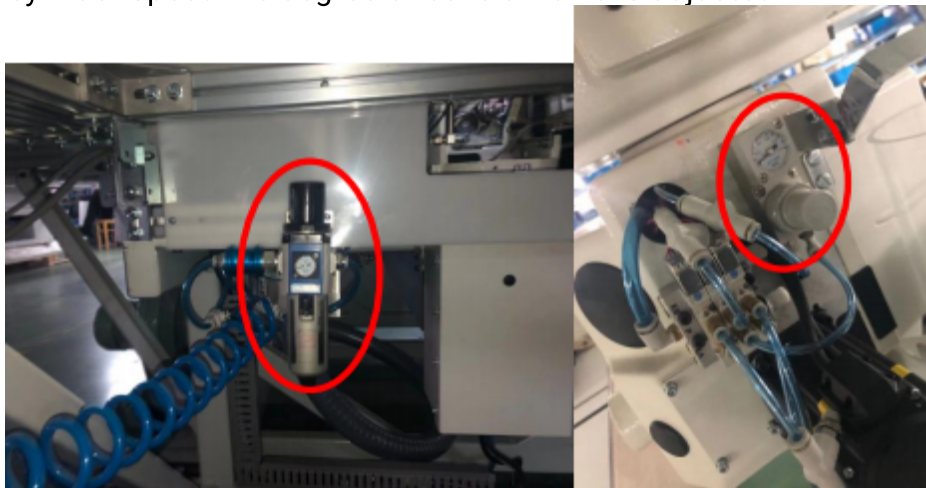
2. Replace the tray pressure
According to the actual situation of the sewing, replace the tray pressure or pallet plastic foot.

A
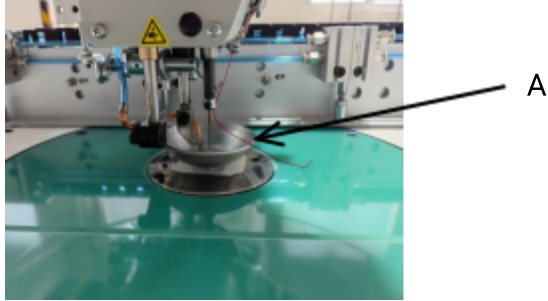
APallet pressed (installed at the time of delivery)
BTray plastic foot pressure
When replacing, adjust the adjustment, so that the foot pressure is parallel to the container safety hood. Adjust the two sides according to the actual fabricThe height, Make sure that it does not touch the middle pressure.
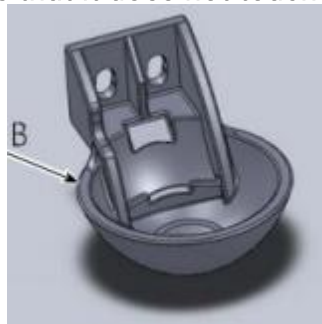
4-18.调节缝纫开始时的丝端部位置

Can set the upper end of the sewing start or when the cloth side is on1, Or under the side of the cloth2.
With regard to these two conditions, depend on the function of using the delay of the line of the line, and the road to the blowing stressSwitching.
1Let the upper end of the end of the fabric
Starting the rebounds of the pull, Hold the function of the blown stage.
2Let the upper end of the end of the fabric under the cloth
Close to rebounds to the pull ups, Hold the function of the blown stage.

布料反面
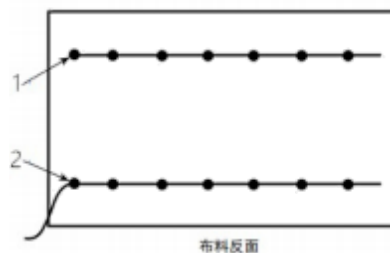
4-19.调节电子中段压脚冲程

Since it is necessary to prevent the impact of the fabric thickness and the fabric, the feet is offset, the upper part of the pressureFoot stroke(A) Adjust the.

A
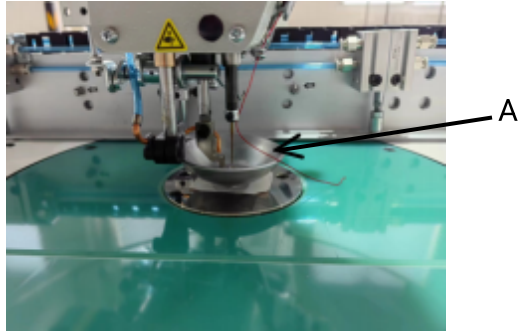
1. Press the electric mounting screen

2. If you press the machining parameter, the input password interface is displayed, Enter the password11111111, Will show
The foot pressure is set up.
3. Press the presser foot with the setup feet, You can set the parameters in the display interface(The tracking footer heavy shipping is height2mm)The

1
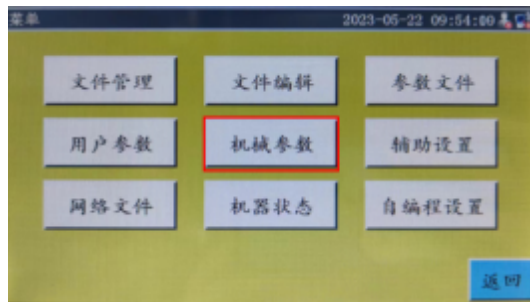
2
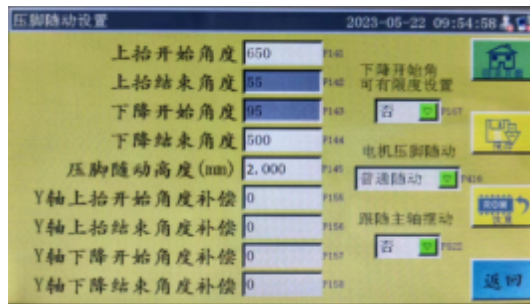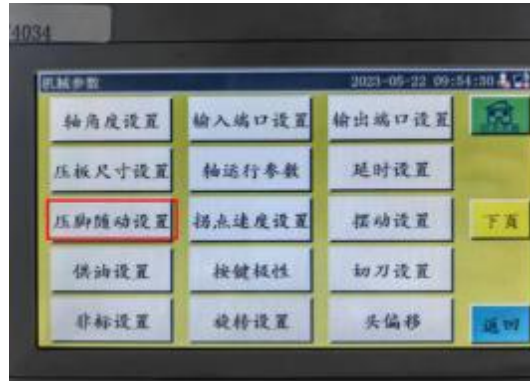
4-20.调节上吹气压线的功能

By controlling the solenoid valve of the electric shield, at the beginning of the sewingFrom the emptyAir blowing pipe1Blow out air in,Locking foot pin2The bottom of the line ends up the end of the line.
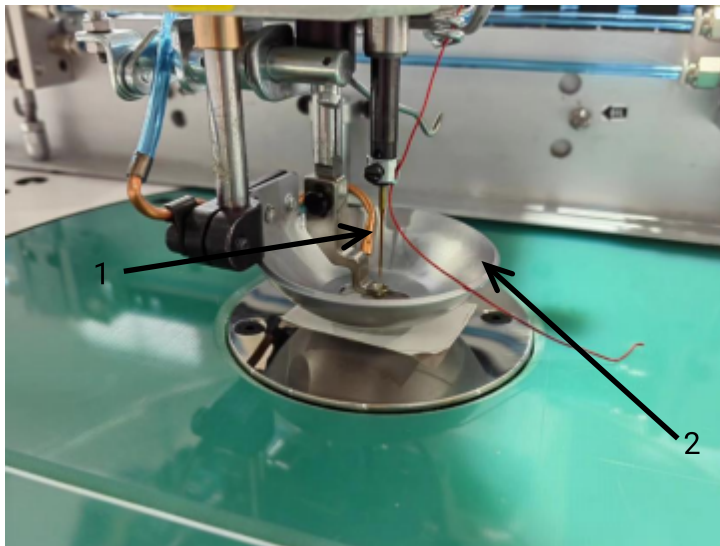
When the sewing starts, the wire end portion is pressed between the tray and foot pattern. Due to the pattern of the groove position and the direction of the directionRading can not press the end of the end, Adjust the direction of the blowing and press it.

Start the pattern making software, handle the operation of the sewing pattern.
In the click operation3And displayed on the screen, click4 (inputI / O)Will "I / 0 "change to5. Will"WaterFlat "change highOFF),Click on5 (delayed),Will "delay(CCS) "change to225.
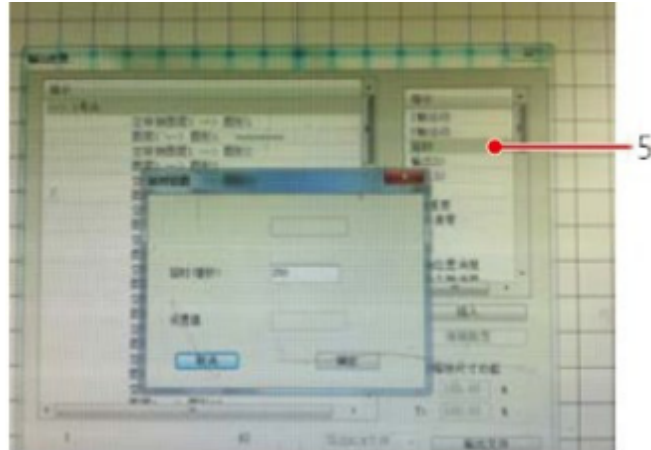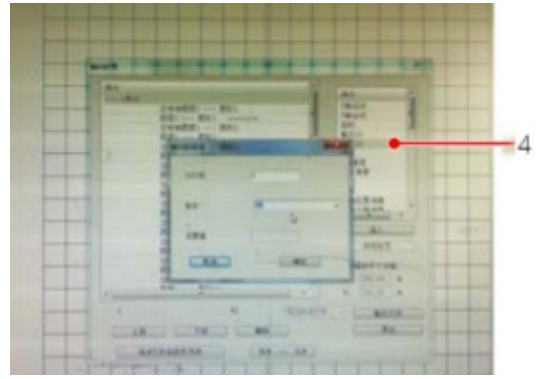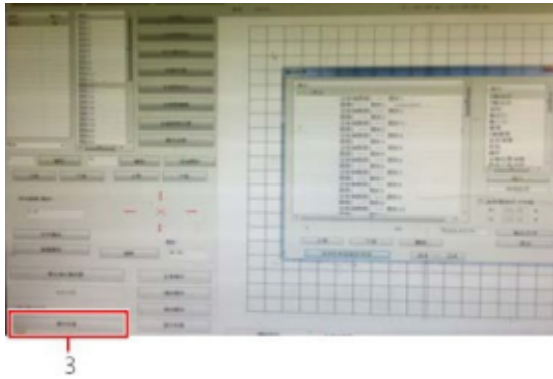
4-21.制作模板

(1) template processing
12085Model of the maximum sewing range size template
· Template material:PVCBoard
· Template thickness is2mmOf thePVCBoard
· Size the sets of sewing clothing and pattern adjustment templateThe
   That isIt is not the greatest weight of the specifications that can not be
   more than the specificationsInch.
· According to the complexity of the pattern, from6 to 8mmSelect the sewing
tank.
• The trajectory of the sewing tank in the template, designed according to
the sewing pattern and the processing.
· Select the appropriate pattern engraving machine,By the development of
qualified technology to work.
· After the upper and lower templates processing, remove the temple with
the burrs on the mounting board.

(2)Install the template
Follow the design, Processing template and lower template.
1. As shown in the figure, Place the template above the lower template, Let the upper and lower templates of the sewing slots alignment.As shown in the figure,1,2,3And4Partial stick template special tape(Wide width36mm)The
2. In the upper and lower the template slot to prevent the fabric to slip the skid, double-sided adhesive,Or in the appropriate positionOn the positioning needle, To determine the fabric location, Firmly fixed, So that sewing seams are more beautiful.

4-22 缝纫准备

1.Open the main power switch
   Press the button1, Open the main power supply.
2. Open the main air source switch

Move the main air pump for left and right2, Open the main air source.

3. Reset of equipment

If you press the reset3, Let the device reset,The needle stops stopped on the stop,Pallet presters and middle pressure fressetsWill be upgraded.

4. Can read the data that wrap the desired sewing,Or by editing the pattern data directly through the operator panel. DetailsSituation, Please visit the electronic control system instructions.

5. Install the pattern

Let the empty pattern (not found in the fabric) move the movement position of the position positioning board on the positionBit holeAHang onPosition positioning needleTheOther two auxiliary positioning holesBHanging on the positioning positioning slider,And press to the bottom.
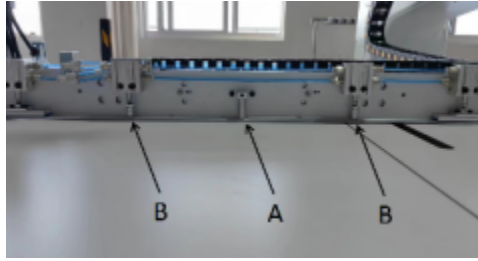
5.Read the sewing pattern data

Induction office
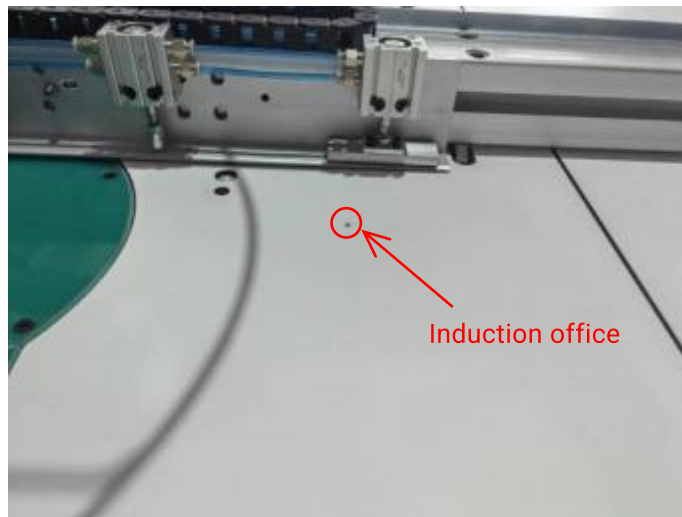
Run to the next red circle location, The scanner is induced, Read sewingPatterns of data

1). If you are on the patternICCard, on the operation screen to start the electronic scan (see the number of instructions)TheRely on electric installation automatic identificationICThe match on the card sewing pattern.

2). If the pattern is not attachedICCard, On the operation screen, manually select the sewing with the patternPatternsData.

7. Choice of the benchmark

In order to let the trajectory of the sewing pattern and the slot of the pattern, you must set the reference, alignment. SpecificThe item is based on the electric scanning operation of the scanning operation.

Enter the operation screen after the set reference. Press the button5,, The path to the pattern of the pattern is analyzed.

To carry outOne of the oneThe secondary run, confirm the trajectory of the sewing pattern and the pattern of the pattern alignment. If no alignment,Re-adjust the benchmark.

In the simulation run process, When stop running, Press the button7Stop simulation run.

8. Upload sewing fabric
1). Remove the pattern
      Let the pattern move to reset positions,Press the clamp button on the
operator panelAt this time,X方 to linearly moduloThe two cylinders on the
block will release the patternSo, Should remove the pattern.
2). Upload fabric
      The sewing fabric is uploaded on the pattern. When you are uploading, it
should be confirmed whether the fabric is flat. In addition, rely onMatch the
stress of the pattern of the pressing the cloth,Prevent fabric movement. If it
is a fabric that is feathers or cotton,As soon as possible, the air is pressed
out.
9. Set the reset, upload the pattern of the fabric, the reference
· Follow3. Steps to reset.
· Follow5TheThe process of processing the upload fabric pattern.
· Follow7. The steps set the reference.
10. Start
      Press the start button of the operator panel6,Be the beginning of
sewing, Will enter the automatic sewing mode.11. Temporary stop
      When a fault is faulty, Press the temporary stop button of the
operator panel7, Will stop running immediately.12. Restart the
      After the above troubleshooting,Rotate the temporary stop button7. The
button will promote, Emergency stop modeTo the releaseAt this time, If you
press the start button6, Will resume automatic sewing.

4-23.面板各部分的名称
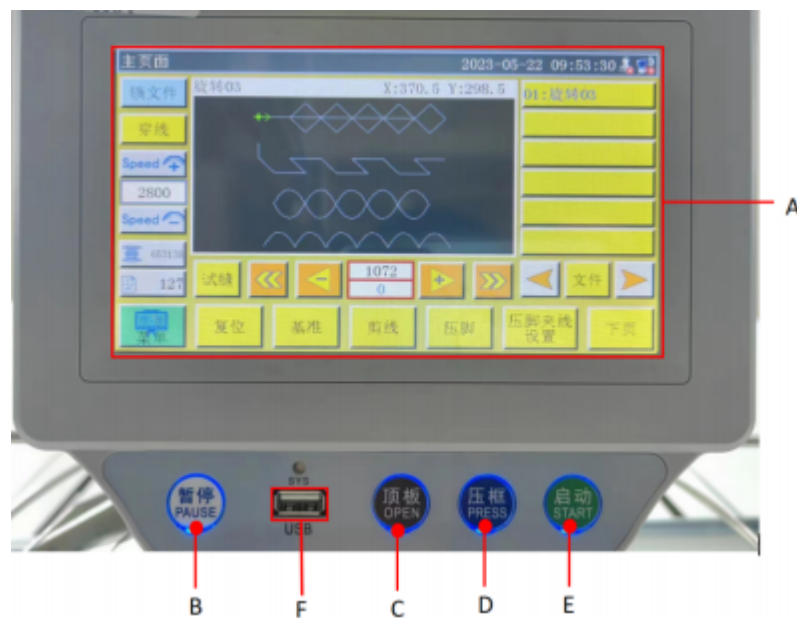
A	Touch screen, LCD display part	
B	PauseKey	Let the sewing temporary stop
C	OpenKey	Top board(Let the top pallet movement upwards)
D	PressKey	Pressure frame(Pressure template)
E	StartKey	Start sewing
F	USBEnd	
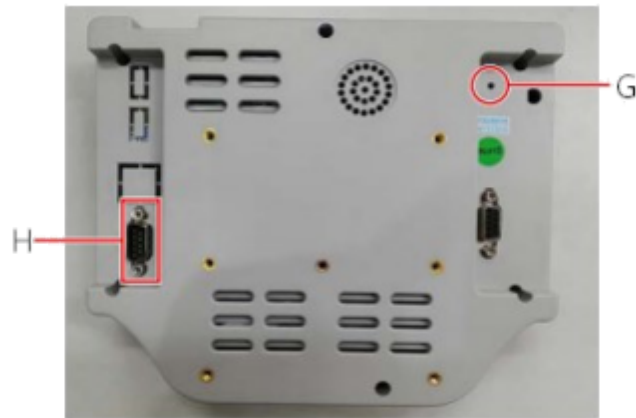
G	Reset button	Restart the panel
H	ComPort	RS232C

The screen description of the panel
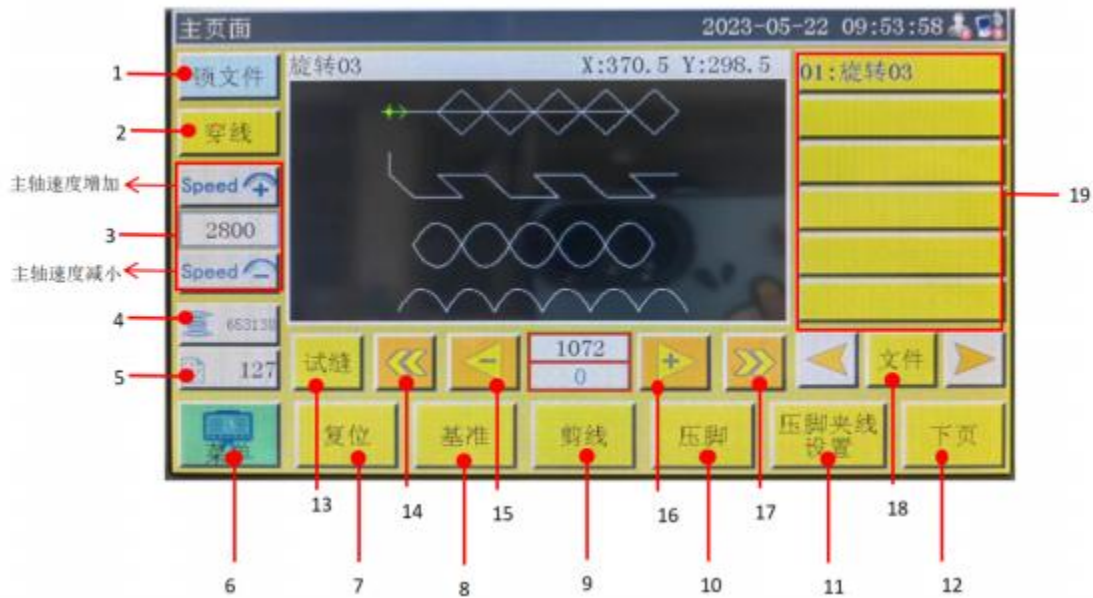
	Button,	Contents
1	Lock key	Lock the sewing pattern
2	Way to the wire	Let the silk by passing
3	Spindle speed change key	Change the spindle speed of the sewing machine
4	Underline Utilization Key	Move the display of the wire feed usage and the screening screen.※ 1
5	Sewing count key	Move to the display of the sewing count and the screening screen.※ 1
6	Menu	Move to the menu screen.※ 1
7	Preparation key	A starting point for sewing machine

8	Benching key	Move to the reference setting screen.※1
9	Scissors bond	Let the tripping line action
10	Pressure key	Let the press key action
11	Press the key setting key	Move to the presser setting screen.※1
12	Page mobile key	Move to the test mode screen.※1
13	Test key	Rely on the empty so that the sewing pattern is operated.
14	Line division reset key	Spike to-A previous continuous sewing start position.
15	Single needle reset key	Spike to1Needle before. If a touch continuouslyWill be fast
16	Single needle delivery key	Spike to1Needle before. If a touch continuouslyWill be fast
17	Line dividing the key	Spike to-A previous continuous sewing start position.
18	File key	Move to the sewing pattern selection screen
19	Select the sewing mode	Touch and select the sewing pattern used

※1. For details, Please visit the operator panel manual.

4-24.维护模式

The so-called maintenance mode refers to,In order to extend the life of the sewing machine,In reachment to be maintainedPeriod,The pattern of notification is made. A maintenance screen will be displayed on the panel.
After the maintenance of the license to pass the user password, The screen will disappear.

1. During the period where you must maintain, the maintenance screen is displayed.(About3Or left or so) if you pressCancel buttonA,Will return to the sewing screen. If it is passed1Hour, Will re-display the maintenance screen.
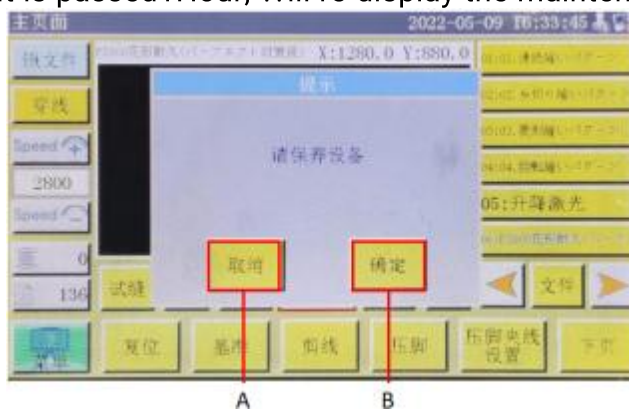
2.-Press the OK button next timeB,If you have set the user password in advance,The user password is displayed.

3. Reference "5. Maintenance of sewing machine", SmearGrease.
4.-Determinal user password, will return to the sewing screen.

4-25.参数一览

Parameter classification	Parameter name	Scope	Standard value	The meaning and comments of parameters
Automatic processing	Automatic processing automatic processing completedAfter that, To enhance the pressure plate	There is no / no	Have	Continuous sewing end1Times, improve the darkBox clamping device
	The first sealing sewing machine pin	0 ~ 8	2	Sewing start and sewing endsPressure foot press Next needle
	After the automatic processing is complete	There is no / no	Have	Continuous sewing end1Times, cutSilk
Automatic processing	After the automatic processing is completePosition also	Original / 二 origin	Origin	"Original" is absolute coordinate origin "The original point" is an additional manipulation to the pattern The original original Point (offset)
	The gap of the space	There is no / no	No	Whether the gap is made when the spaceOFF
	Bench sewing machine settings remain unsatisfactoryVariable	There is no / no	No	
	The cartridge clamping at the beginning of the sewingDrive	There is no / no	No	Whether the dark box is plotted when the sewing startsTight deviceOn
	Pipe the first time when the manual deliveryDrive	There is no / no	No	When do the manual conveyance actionFirst let the cartridge clamping deviceOn
	Repeat sewing at the beginning of the sewing	OFF / 1/2	OFF	About"1 "and"2", when starting,

	Pin			Repeat the initial pin positionRow1Time or2Slim sewingAnd thenTo carry outOne of the oneNeedle pitch positioning.
				Sets the needle needle when the sewing startThe number.
				"OFF" does not repeat sewing
	The number of grasping needles at the beginning of the sewing	0 ~ 255	0	From the sewing to the number of settings needleRoom, let the catch SilkOFF
	The segment pressure presence at the beginning of the sewingHeight	0 ~ 4	0.5	The segment pressure presence at the beginning of the sewingSection
	The segment pressure presence at the end of the sewingHigh	0 ~ 4	0.5	The segment pressure presence at the end of the sewingSection
	Set the initial and last presser foot	Normal / cuttingOne of the oneSemi / increaseAdd	Normal	
	The coating machine at the end of the sewingReset	There is no / no	Have	When the sewing ends the cutting machine is reset
	The intermediate pressure segment is closedMotivation reset	There is no / no	Have	The segment pressure presses at the end of the sewingReset

Parameter classification	Parameter name	Scope	Standard value	The meaning and comments of parameters
Start speed	The1NeedlesEnableMoveSpeedSection(STI / min)	100 ~ 3000	400	The1The speed of the needle
	The2NeedlesEnableMoveSpeedSection(STI / min)	100 ~ 3000	600	The2The speed of the needle
	The3NeedlesEnableMoveSpeedSection(STI / min)	100 ~ 3000	900	The3The speed of the needle
	The4NeedlesEnableMoveSpeedSection(STI / min)	100 ~ 3000	1200	The4The speed of the needle
	The5NeedlesEnableMoveSpeedSection(STI / min)	100 ~ 3000	1500	The5The speed of the needle
	Pour downSeamRotateTransferSpeedSection(STI / min)	100 ~ 3000	700	The speed of the dive
	Low speed start	There is no / no	Have	Is it a low speed
	Sewing start2The speed of the needle	There is no / no	No	The2Whether the needle is low
	The sewing ends2The speed of the needle	There is no / no	No	The last two steps are slower
Speed parameter	MasterShaftOf theThemostFastRotateTransfer(STI / min)	100 ~ 3000	1800	The maximum rotation of the spindle
	Air delivery speedmm / min)	100 ~ 30000	20000	The speed of the space
	Sewing conveyance speed (Mm / min)	100 ~ 20000	8000	Fixed and the movement speed when making the patternSection

	Demo Speedmm / min)	100 ~ 60000	8000	Demo Speed
	PressButtonSpeedSection1	100 ~ 20000	500	Rely on manual move control box,Acquisition file

Parameter classification	Parameter name	Scope	Standard value	The meaning and comments of parameters
	(Mm / min)			Time,In the8Turn rights in the direction of the key
				The speed of the action in the icon
	PressButtonSpeedSection2 (Mm / min)	100 ~ 20000	1500	Copying8A direction key
				The speed of the action in the icon
	PressButtonSpeedSection3 (Mm / min)	100 ~ 20000	1000	Copying8A direction key
				The speed of the action in the icon
	HeadDepartment2Speed Section (Mm / min)	0 ~ 2000	0	When using laser lightsXYThe speed of the shaft
	HeadDepartment3Speed Section (Mm / min)	0 ~ 2000	0	When using laser lightsXYThe speed of the shaft
	Continuous dynamic speed	ReduceLittle less/The mostSmall/Normal	Reduce	The movement speed when making a pattern
	Reverse speedRMP)	100 ~ 60000	0	The speed of the dive
	No brake air plow outputIO	Out1~ Out	No	
	Post-numbered quantity velocity	0 to 30	0	
	Record limit specifies speed	100 ~ 1800	0	

Parameter classification	Parameter name	Scope	Standard value	The meaning and comments of parameters
Set the pressure plate	The clamping device risesProhibited sewing	There is no / no	Have	The dark box box clamping device is ignored when sewing
	Pedal operation order	Normal / special	Normal	Pedal operation order
	Pedal operation mode	Ista/Istb/ISTC/ 2St/3St	2St	According to the mechanical structure(With auto locking /No automatic locking),Foot switch switchThe way is different.
	The segment of the segmentSilk start angle	1 to 990	1	Sewing the beginning of the graspingOnPerspective
	The segment of the segmentSillength end angle	1 to 990	1	Sewing the beginning of the graspingOFFPerspective
	Crane when the wipes are openAttitude	1 to 990	950	Cross the widening angle of the wipe
	Catch the silk jump at the time of the tankBeam angle	1 to 990	50	Cross the width of the width angle
Set the line	Utilist status	License / prohibition	License	Cue wire device
				Default state
	VolumeTakeThe deviceSpeedSection(STI / min)	100 ~ 4500	2200	Roll speed
	The application time limit (S)	1 to 63000	200	Set the line of time

Speed downLarge	High speed magnification rate (%)	1 to 100	100	Direct □ spindle actual speed=Set the speed

				× high speed magnification
Rate	In theHighSpeedPutLargeRate(%)	1 to 100	90	Appeals refer to
	Low high-speed magnification rate(%)	1 to 100	80	Appeals refer to
	Low speed amplification rate (%)	1 to 100	70	Appeals refer to
Set reset	When setting reset resetThe clamping device drops	There is no / no	No	When the origin is reset, the cartridge clamping device drops
	After manual reset,Tight device rise	There is no / no	Have	Press the reset button, the origin is reset, the cartridgeThe clamping device rises
	Original reset mode	XYWith the sameTime/ xSuchFirst/ YSuchFirst	XYSimultaneously	"XYAt the same time "mean the beginning of the original pointSet,"XPriority "refers toXThe axis initially carried outOriginal reset,Then thenYThe axis is the original weightSet up.
	The originalPointComplexBitSpeedSection(Mm / min)	100 ~ 20000	15000	When the origin is resetXYShaft speed
	Line reset speed(Mm / s)	1 to 2000	80	OPReset speed of the shaft
	Set the reputation beforeOut ofIO	Out1 ~ OUT6 / no	No	Set the reset beforeIO
		High level / low level	High level	
	HeavySetTimeXYShaft0Bit number buffer	XYShaft / xShaft / yShaft / do not	XShaft	Set the reset beforeIO
Pause settings	Sily automatically cut the line	There is no / no	No	
	Pause the timer pin position	On the positioning / positioning	On the positioning	
	Pause the pressure plate to rise	There is no / no	No	
	Pause switch type	Self-lock / ordinary	Self-lock	"Self-locking "can not be automatically bounced after the switch is pressedFrom the
				"Ordinary" can be pre-bounce after pressing

Parameter classification	Parameter name	Scope	Standard value	The meaning and comments of parameters
Statistics set	Clear the power supplyThe bottom margin	There is no / no	No	When the power is turned on,Does the letters are marginIn the0
	Stop the lower wire shuntOf the operation	There is no / no	Have	"" There is a lower length to use the length of the wireAfter the stop stop
	Set the lower meter count	There is no / no	Have	"There are" means that automatic statistics of the wireframe when the operationWith the length
	Clear the power supplySewing counter	There is no / no	Have	When the power is turned on, Do so that the sewing counterIn the0

	Continue sewing counterSet the value after the arrivalOperation	There is no / no	Have	The sewing counter reaches the set value, Are itContinue to operate
	Sewing counter function	There is no / no	Have	Whether to sew the counter counter

	Operation time	There are / 无	Have	There is "refers to itLet the processing time statistics featureEffective
	Underwater metering	In1 ~In4 / default	By default	Underwater scale statistics
	Under the nextSilkLeftYuLongSection(Mm)	0 ~ 600000	0	The bottom of the balance of the margin
Set the grasping	Craft when the catchingSet	0 to 200	0	Craft when the yarn position
	The segment of the segmentSilk position	0 to 200	0	The grasping position of the sewing start
				Output laser
Check out the wire	Automatic detection of wire	There are / 无	Have	"There is" meansAfter the fabric is broken, Stop the operationMake and prompted
				Broken test function
	The automatic cutting of the wireSilk	There are / 无	Have	"There is" meansAfter the fabric is broken,AutomaticCrossing.
				From the detection wire to start the cutting.
	On the Icon of the Spirit	1 to 255	3	The initial set of pin numbers does not mean wire
	Effect of the needle when the wireNumber	1 to 255	2	If a wire set is set for the number of pin,Can consider it really fabric
	When the wire is threadedProcessing (S)	0.01 to 255	0.2	After confirming the break, Delayed time andFor the wire processing
Check out the wire	Idea bottom lineOpenQEP2	There are / 无	无	Part of the machinery willBThe encoder as the bottom of the wireRing measurement
Set the cutting wire	Cross the main axis of rotationDegree (STI/min)	10 ~ 2000	260	Cross the spindle speed of the
	YaoLateCutSilkEnableMove(S)	0.01 to 6.55	0.12	The delay time of the cutting start
	Dial machine action time(S)	0.01 to 6.55	0.12	Dial machine action time
	The dial side stops delayTime (s)	0.01 to 6.55	0.1	DialOFFDelay time
	GrabSilkEnableMoveYaoLate(S)	0.01 to 6.55	0	Catch the filament0NDelay time
	Whether the time is in the time of deliverySilk	There are / 无	Have	Whether the wire is shifted when the space
	Double function	There are / 无	Have	Whether to use the dial
	Motor Craft Mode	Ride / /	Round to the round	Motor Craft Mode
	Motor shuttle stroke	1 to 100	25	Motor shuttle stroke
	TransferYaoCutSilkReceiverTight(CM / sec)	1 to 350	1	Cascade filament time
	Return speed ratio	10 to 100	100	Rotate the speed of the velocity
	Line relaxation start mode	Angle / delay	Perspective	Catch the filamentOFFThe start time of the machine
	Line relaxation angle	0 ~ 999	850	Catch the filamentOFFThe angle

	Set the velocity of the stage	There are / 无	无	Whether the stage is formed to launch the speed of the ingredients

	Section			
	刀 sheet length1Stage	0 ～ 100000	0	1Stage launch length
	刀 刀 (cm /Seconds)1Stage	0 ～ 100000	10	1Stage launch speed
	刀 刀 (cm /Seconds) 2Stage	0 ～ 100000	10	2Stage launch speed

Parameter classification	Parameter name	Scope	Standard value	The meaning and comments of parameters
Power setting	Push the needle on the needleStop	There are / 无	Have	When the power is turned on, the needle bar is located on the upper 方
	Item automatic automaticOriginal reset	There are / 无	无	When the power is turned on,Cartridge automatic, origin resetAutomatic
	Turbomatic excitation	There are / 无	Have	When the power is turned on, Motor excitation
	Extraction of the foot pressure	There are / 无	Have	When the power is turned on, Foot pressure
Other settings	Identify air pressure	There are / 无	无	"There is" when the operation,Determine the pressure of theMore about Low, Will stop and alarm
	Repeat the operation	There are / 无	无	"There is" after the start, Began to sameOne of the oneFileCirculation processing
Other settings	CircleRingAddWorkingNumberQuality(Min)	1 to 65535	1440	CircleRingAddWorkingGeneral withTimeRoomAndTimeRoomOne of the oneDeterJunctionBunch, Will stop cycle processing
	CircleRingAddWorkingRoomSeparation(S)	0 to 20	2	After the loop processing, after processing ending to the processingRestart between the intervals
	Operation end position	BackTo0 /Right/From theSiteMountingLocation / default	To return to0	To return to0Point: xyShaft coordinates all0Point,The sewing ends, Reset point Right side: the right side of the processing range Start sewing position: the original in the processing of the processSewing point Default: processingOne of the oneThe end of the end
	RFIDIdentify the law	Barcode / electronic tag	Electronic tags	Press the document to be sub-coded:Mode Press the file name: the identification of the electronic tagFormula
	Access	Classic / singleOne of the one	Classic	Classic: assume the body's button Refreshing: flat button holder
	Start the movement before movementMode	XYAt the same time / xPriority / ySuchFirst	XYSimultaneously	
	Operation of the empty transferDynamic mode	XYAt the same time / xPriority / ySuchFirst	XPriority	The air movement mode

	Connect the enlarged picture	There are / 无	无	"There is" on the display to operate the fileWait for information,Show external amplification displayOn the on
	The spindle is back after returning	0 ~ 160	0	

	Sound tips	High / medium / low /OFF	OFF	Show"High" """ Low "volume of the sound of the soundSize
	Let the power out memory are valid	Is / no	Is the	After re-energizing,The sewing before the power is offStatus continues to sewing
	When the electronic label is leftThe file is valid	Is / no	No	

4-26.错误编码一览

Error encoding	Error content	Solve the law
E001	无 reset	Click on 【Reset】 Button, reset
E002	无XZero signal	INSPECTIONXIs the sensor to be bad or damaged
E003	无YZero signal	INSPECTIONYIs the sensor to be bad or damaged
E004	无ZZero signal	INSPECTIONZIs the sensor to be bad or damaged
E005	无UZero signal	INSPECTIONUIs the sensor to be bad or damaged
E006	When large axisBitSignal	Confirm whether the shaft sensor is inaddy or damaged
E007	无 textile zero signal	Confirm whether the spindle encoder is broken
E020	XAxuron overvoltage	
E021	XShaft deficiency voltage	
E022	XShaft hardware overcurrent	
E023	XShaft software overcurrent	
E024	XShaft encoder fault	
E025	XThe shaft opens the road	
E026	XShaft overload	
E027	XAxis permutable range of space	
E028	XShaftADSampling failed	
E029	XThe axis is overheat	
E030	YAxuron overvoltage	
E031	YShaft deficiency voltage	
E032	YShaft hardware overcurrent	
E033	YShaft software overcurrent	
E034	YShaft encoder fault	
E035	YThe shaft opens the road	
E036	YShaft overload	
E037	YAxis permutable range of space	
E038	YShaftADSampling failed	
E039	YThe axis is overheat	
E040	ZAxuron overvoltage	
E041	ZShaft deficiency voltage	
E042	ZShaft hardware overcurrent	
E043	ZShaft software overcurrent	
E044	ZShaft encoder fault	

Error encoding	Error content	Solve the law
E045	ZThe shaft opens the road	
E046	ZShaft overload	
E047	ZAxis permutable range of space	
E048	ZShaftADSampling failed	
E049	ZThe axis is overheat	
E050	Camerane overvoltage	
E051	Crane shaft is less than voltage	

Error encoding	Error content	Solve the law
E052	Crane shaft hardware overcurrent	
E053	Crane shaft software overcurrent	
E054	Cameron shaft encoder fault	
E055	Cut the shaft opened the road	
E056	Crane shaft overload	
E057	Cut the axis of the exclusive range of space	
E058	CraftsADSampling failed	
E059	Camera isother heat	
E060	Spindle overvoltage	
E062	The brand is not under pressure	
E062	Spindle hardware overcurrent	
E063	Spindle software overcurrent	
E064	Tinning of the spindle encoder	
E065	Spindle 无 method rotation	
E066	Spindle hamming method of rotation	
E067	YServo hardware protection	
E068	YServoHoc	
E069	YServoADThe initial correction of the module is not exceeded	
E070	YServo parameter finishing exception	
E071	YServo series parameters abnormal	
E072	YServoADSampling module failure	
E073	YThe servo encoder cuts	
E074	YServo encoderAbInterference	
E075	YServo encoderZInterference	
E076	YLED serviced voltage	
E077	YServo with - side voltage overvoltage	
E078	YServo software overcurrent	
E079	YServo motor overload	
E080	YServo drive overload	
E081	YServo motor overheating	
E082	YServo drive is overheat	
E083	YServo fan exception	
E084	YServo speed	
E085	YServe all over the range of space	

E086	YThe bit phase loss of the servo bypass voltage	
E087	YServo motor bits sequencer error	
E088	YServo drive rated current infusion error	
E089	YServo brake resistor load	
E090	YServo absolute encoder overheating	
E091	YServo battery voltage is low	
E092	YServo location information loss	
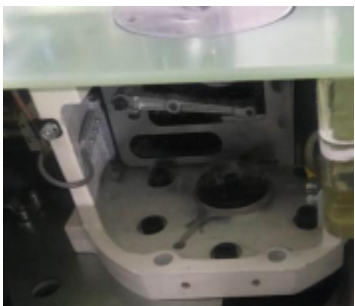
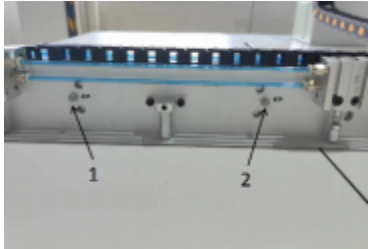| Error encoding	Error content	Solve the law
E093	YServo drive and motor does notOne of the oneCause	
E094	YServo origin reset failed	
E095	YServo main power supply	
E096	YServo bias angle learning failed	
E097	YServo power supplyOFFRestart	
E098	YServo initializationLAN9252Error	
E099	YServoDSPAnd withESCCommunication interrupt	
E100	YServo 网络 cable andHSTCommunication interrupt	
E101	YServoPDCommunication parameters read dedicated	
E102	YServoPDCommunications 方 无 index	
E103	YServoPD0Communication synchronization time is fanWell	
E104	YServoPDOThe range of communication data	
E105	YServoUVWShort circuit road	
E106	YServo inertia recognition failed	
E107	YServo encoderEepromRead and write failed	
E108	YServo active position limit	
E109	YServo position negative boundary	
E110	YServo electronic gear ratio range	
E111	YServo input pulse frequency is too high	
E200	XYDrive alerts	
E201	XDrive alerts	
E202	YDrive alerts	
E203	The spindle back to the original location	
E204	The main motor is to the error	
E205	The pressure frame does not fall	Click the "Press the lower box" button, Place the outside
E206	Machinery head track fault	Machinery head tray breakage. You must replace the new mechanical headproof
E207	LoadingIOTimeout error	Confirmation in the deliveryIOIs there a high or low of the input signal
E208	Not sufficient air pressure	Verify that the air supply unit is air supply air
E209	The motor is not in the cross position	Verify that the zero signal of the cross motor is normal
E210	The motor pressing device is not in a predetermined position	Confirm whether the zero signal of the pressing motor is normal
E211	Catch the motor does not specify the position	Confirm whether the zero line of the tension motor is normal
E212	The cutting machine is not in a predetermined position	Make sure the zero signal of the cutter motor is normal
E213	Line break	Before performing the operation, the thread is re-executed, or let the break disc

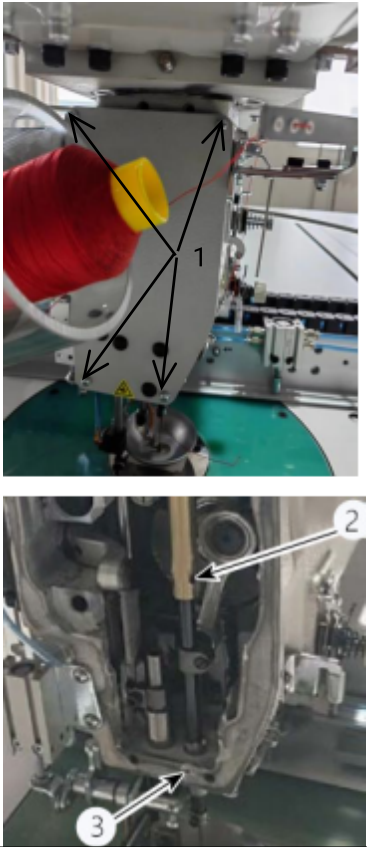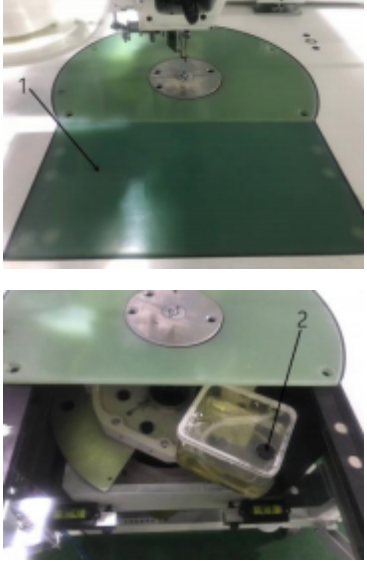|		FeaturesOFF
E214	The number of work is full	Updated the total number of calculated. If you start the operation, it will beClearAnd then start again
E215	The bottom line has been finished	Must be changed below the wire
E216	The file is too	The number of images filters exceeds the most ranging rangeTheMust be replaced with image textParts
E217	There is no operation file	You must re-scan the image file or switch the image file
E218	Hold the work data	The processing of the data processing time will be based on the size of the imageVariety
E219	The fault of the electricityPlease contact the manufacturer	Contact the equipment manufacturers
E220	Error upgrade file	You must replace the new upgrade file

Error encoding	Error content	Solve the law
E221	An error occurred during the type of file type	You must select the type of upgrade file to be upgraded
E222	Not upgrade	Contact the equipment manufacturers
E223	It's not toOEMManufacturers' upgrade files	Contact the equipment manufacturers
E224	无 method connected to the mechanical headproof	Check the connecting line or the work of the mechanical head of the pocket and the workpiece of the workpieceNo exist contact or damage
E225	Connect with the motherboard	If the screen line is inductive or a breakage occurs, In the display or electricityLine of the motherboard is damaged, To confirm the replacement of the necessary
E226	The current file is valid	If the graphic file is broken,Or use a non-system type fileTime, You must change the graphic file
E227	File forwarding failed	If the screen line is not connected, Or damage to the display or electricityLine of the motherboard is damaged, To confirm the replacement of the necessary
E228	Foreign data	The current graphic file data exceeds the limit range,The number of graphs should be confirmedIs it existing abnormal
E229	The adjustment angle is too	Has been amended graphic angle too Reduced the angle value of the change
E230	Image reading 入	Handle the necessary graphic data, Have a wait and after operation
E231	Press the error	Confirm whether the pressure footing motor is normal
E232	UDisk is not good	Reinsert theUDisk, Or replaceUDisk
E233	The reader of the file	1. Replace the graphic file
		2. reinsert theUDisk, Or replaceUDisk
E234	Forest images or mechanical head bias	1. Reset the location of the reference point
		2. Machinery head2Or the mechanical head3The mechanical head bias value reset
		3. Replace the slight and width of the width
E235	The file does not belong to the handling of files	Replace the graphic file
E236	Straight of electricity	Contact the equipment manufacturers
E237	Set the management password	Initially set the management password
E238	Editors are not supported	No indicators or files that are required to edit
E239	Please consult the manufacturer	Contact the equipment manufacturers
E240	Communication disorder2	This isCanCommunication error or motherboard program is more oldProgram

E241	When exceeded	1. Time is illegally corrected
		2. Motherboard battery low
E242	无 workIO	1. Work enable inputIOSignal abnormality
		2. Close the "work enabled linerIO "function, set the parameter value toO
E243	Waiting for the inputIO	Waiting for the loss of the literal fileIOSignal
E244	Perform a delay	Rely on the graphic file executing a delay command
E245	The file name is too long	Must let the length of the file name becomes short
E246	Please first fill the presser foot	You must click the "Press the foot" button, Improve the foot
E247	The frame is not pressed	Press the frame in advance
E248	The auxiliary pressure frame is not pressed	Must first press the auxiliary pressure frame
E249	Pressure frame and auxiliary pressure frame are not pressedStay	The total ending of the substrate must be pressed
E250	Get the bottom material of the stamping to disappear	You must replace the new stamping fabric

5.缝纫机的维修保养

Numbering	Parts	Description	Operating hours
1	Needle under the area, container peripheral area, spinningBox and internal, cutting parts, needle bar regions,Inner and outer presterial area of electronic control box suction,Exhaust 口 , etc., broken wire, wire, and other residuesQuality of the accumulated part.	Please use the air jet guns and other tools to the machineThe surface of the surface is cleared. Especially in the aboveBroken wires and wires, as well as other residuesQuality of the most accumulated part,Please note the clearSweep.	8When you are

| 2 | To2RootYDirectional linear guide slider□ oilTotal2At the place.

 | 1. Use probe chips, AlignmentYDirectionOf a linear guide1The location, TightenInjection cylinder, To the oil and oil.
2. At least one oil at this site5The second time,It is not less than every time5cm^{3}The
3. When the oil is refined, Let the linear guideThe slider moves a number of times to let the lunThe grease sufficiently reaches the cylindrical gap.
4. After the full oil, Loam greaseFrom linear guide and sliderSeepage Out of.
5. About grease,Lithium series should be used2No.,Should not be mixed with other greases. | 1. Machinery runs6400KMOr5After the year,Should be re-noteLong grease.
2.In theTheOne of the oneThe second timeNote入 RunningSlideLipidAfter that,According to the use of environmentWith the same,In the3Months or rotate
1After the pin, should be heavily added入 One of the oneLost grease |
| 3 | To1RootXDirectional linear guide slider□ oilTotal2At the place.
 | 1. Let the top of the injection of the injection of the oil1,2, Tighten the blanks, Let the oil□, Is fullOne of the oneThe
2. At least oil in each part5The second time,Note not every lesson5cm^{3}The
3. When the oil is refined, Let the linear guideThe slider moves in a rail several timesLet'sletGublier fully reaches the cylindrical gap.
4. After the full oil, Loam greaseFrom linear guide and sliderSeepage Out of.
5. About grease,Lithium series should be used2No.,Should not be mixed with other greases. | 1. Machinery runs6400KMOr5After the year,Should be re-noteLong grease.
2.In theTheOne of the oneThe second timeNote入 RunningSlideLipidAfter that,According to the use of environmentWith the same,In the3Months or rotate1After the pin, should be heavily added入One of the oneLaters grease. |

4	Held and bottom hoods around the needle rod,Needle rodsGroove, pressure lever rack frame slot, press foil and so onPost the grease. 	1. Loosen the panel screws1, Remove the surfaceBoard. 2. Loosen the screws of the metal pieces above the needle2The screws of the metal pieces below the needle3,And removed. 3. Make the grease the ejector of the gun of the gunQuasi-needle and bottom of the metal piecesScrew hole2And3, Then note the rubSelf-grease. 4. Pot oil is not less0.5cm^{3}The 5. After oil after oil, Tighten the needle below the needleMetal pieces of screws. 6. At the same time, Slice slot to the needle sticks,Foot rail frame rack, pressing rods and so onPlus the appropriate amount of grease. 7. About greases should be lithium series2Should not be mixed with other greases.	1. Machinery runs6400KMOr5After the year,Should be re-notedGrease. 2.In theTheOne of the oneThe second timeNote入RunningSlideLipidT h e R e a r, According to the use of the environmentN o And, the same3Months or rotate1After the pin,Should be re-addOne of the oneLaters grease.
5	Oil to the container tank oil. 	1. Remove the cover 2. Remove the tank of the rubber thrombo2. 3. From the tank of the rubber pin hole to be affordable(Or specified) of the lubricating oil. 4.Such asFruitOilUp toToOilBoxOf theOn thePartyEngravingSection, I stop oil. 5Let the rubber thread reset, So that the safety hoodBit.	The oil in the tank is less than the amount of oilUnder the nextSquareTimePlea se add affiliated(Or specified) of the lubricating oil.

| 6 | Lubricate the gearbox.
 | 1. Remove the5Square screws1, Remove the needleBoard2.Remove the6Root screw3,Lower gearbox cover and gasket.
2.To the gear to slowly injection32No. whiteLubricing oil.
3.When oil oil scale oil is reached up aboveDecreased, Stop oil.
4. The cover of the gear box, Big tablet,Safety hood reset, Tighten the screws. | When the oil scale is lower than the lowerEngravingDecreased, Please add32No. whiteLubricants. |

5-1.缝制时的故障。原因和对策

Phenomenon	Cause	Countermeasures
1. Start the time outline.	1. Timeline jump. 2. After the tangent line is short 3. The bottom line is too short 4. The1The needle of the line tension is high. 5. The1The needle sewing pin is small.	1. Adjust the voids of the needle and the container 2. Set the soft start when the sewing 3. Weaken theOne of the oneLine tensioner tension. 4. Enhance the pick-up spring. 5. Weaken the bottom line tension. 6. Balance the wool of the needle and fixed 刀.

		7. Weaken the1Needle on the line tension, Extend the liftingATAction.
		8. Growth1The needle sewing pitch.
		9. Weaken the1Needle on the line tension.
2. Regularly broken. Fluid filament pull.	1. Turput, Siotou positioning hook has scars. 2. Pinhole guide has scars. 3. The line is in the trench of the holes. 4. Online tension is too strong. 5. The balloon is too strong. 6. Fluid fiber hot and dry. 7. When pulling the line, the tip is tilted to the sewing machine line.	1. Remove the hook, smooth with fine grinding or file.2. Grinding the pinhole guide or replacement with the crest. 3. Remove the hook, clear the line. 4. Weaken the tension. 5. Weaken the pick-up spring. 6. Use the machine needle cooling device. 7. Confirm whether the tip is blunt. 8. Use the ball pin.
3. Regularly broken	1. Needles. 2. The needle touches the presser foot. 3.3The machine is too thick. 4. The gap between the machine and the hopper is too small.	1. Replace the needle. 2. Adjust the position of the presser foot. 3. According to the sewing object to use the appropriate needle. 4. Adjust the gap of the needle and the hopper.
4. Cancel continues to (Only bottom line)	1. Fixed 刀 unsuccessful. 2. The pressure of fixed fixed 低 is low. 3. Fixed position is not good. 4. Finally needle jumper. 5. The bottom line is low. 6. Fabrics are suspected.	1. Replace the fixed 刀The 2. Adjust the pressure of fixed 刀. 3. Adjust the fixed 刀 position. 4. Adjust the synchronization of the needle and the hopping. 5. Improve the bottom line tension. 6. Drop the pressure height.
5. Regular jump.	1. The gap between the machine and the hopper is not good. 2. The location of the Zun closure position is not good for the needle.3. Needs. 4. The trough is too long after the trough.	1. Adjust the gap of the needle and the hopper 2. Adjust the location of the hobbing position hook relative to the needle3. Replace the needle. 4. Weaken the pick-up spring. 5. Enhance theOne of the oneLine tensioner tension.
6.On theLineFromCloth Of theIn theSide of the exposed	1. Online tension is not good. 2. The trough is too long after the line.	1. Weaken the tension. 2. Enhance theOne of the oneLine tensioner tension.
7. Bread when the tangent is broken	1. The location is not good.	1. Adjust the 刀 position
8. On the surface of the fabric,The1Needle sOf theLineHeadExpos ureOut ofCome.	1.1Pin needle jump. 2. Use the needle and line over the same as compared with the internal diameter of the middle pressure foot.3. Medium-pressure foot with different needle. 4. The air blowing is not good, the discs fell off the needleOnline.	1. Length the length of the line after the tangent. 2. Replace the large-scale pressure in the diameter. 3. Adjust the heart-tolerant of the needle and the middle pressure, Let the needleFalls in the center of the foot center. 4. Follow the sewing direction to adjust the air blowing,Let the discs fell the online that needle.
9.On theLineWrappedW ound aroundToIn theShutin positioning hook.	1. Sinsels positioning hooks and the hopping spots of the spot is too small.	1. According to the use of the line of the thickness,Adjust the suspension of the closureHook and the spinning of the gap.
10. Stitching starts2Needle bottom line segmentExpos ed the surface.	1. Circle cylinder is large 2. Bottom line is low. 3.3The1Needle of the line tension too strong.	1. Adjust the height of the shuttle of the spot 5 to prevent the height of the air split spring.2. Enhance the bottom line tension. 3. Weaken the1Needle on the line

		tension.