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1002B

全自动衬衫冷折贴袋机  
使用说明书

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**CHANGZHOU WISDOM & VALLEY  
ELECTRICAL TECHNOLOGY CO., LTD**

Please read this manual before using the computer pattern machine.  
Please keep this instruction in a convenient place

版本信息

2018.6.23

**Thank you for purchasing this industrial sewing machine from IMB**  
**Before using this automatic unit, please read the following instructions, which will help you to understand how the machine operates.**  
**These instructions illustrate the correct working methods to comply with current regulations.**

**No part of this manual may be copied or transcribed without requesting prior authorization from IMB**  
**The contents of this manual may be subject to change without advance notification.**




**We are happy to receive suggestions and/or indications on ways we could improve this manual.**

# Safety Using Instructions











Due to the specific situation of sewing operations, workers need to be close to the rotating spare parts which will touch the parts. In this case, operators and serviceman must read and understand **Safety Notice** carefully before operating. Some of this **Safety Notice** is not the content of the product specification that the user purchased.

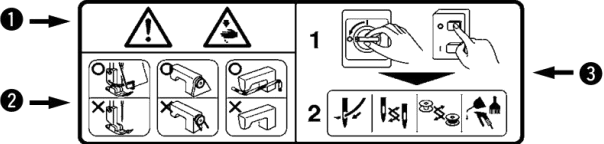
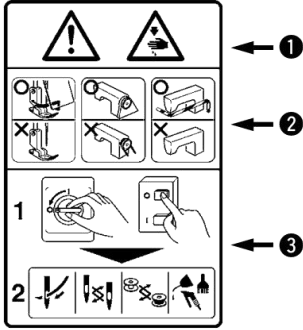
In addition, warnings are classified into the following categories to help user fully understand this instruction and warning label. Please fully understand these contents and follow the instructions.

## (I) Description of hazard levels

 <b>Danger</b>	There is a risk of death or serious injury if the party or third party, makes a mistake or fails to avoid the situation when operating or maintaining machines.
 <b>Warning</b>	There is a potential for death or serious injury if the party or third party, makes a mistake or fails to avoid the situation when operating or maintaining machines.
 <b>Notice</b>	There is a possibility of minor injuries if the party or third party, makes a mistake or fails to avoid the situation when operating or maintaining machines.

## (II) Warning icon and indication label instructions

Warning icon		Risk of injury if touch rotating parts	Warning icon		Danger of hand injury if taking machine during work
		Risk of electric shock if touch high voltage part			Danger of injury if involved in the belt
		Risk of scald if touch high temperature part			Danger of injury if touch the button conveyor
		Danger to eyes if look directly to the laser			Indicating correct rotation direction
		Danger of head touching the machine			Indicating ground connection

Warning Label		
	<p>① ▪ Danger of minor , serious injury or death.</p> <p>② ▪ Danger of injury if touching the working part.</p> <p>③ ▪ Safe guard should be assembled before sewing.</p> <p>▪ Safe shield should be assembled before sewing.</p> <p>▪ Protector should be assembled before sewing.</p> <p>④ ▪ Operation including 「Threading」 、 「Needle exchange」 、 「Bobbin exchange」 &amp; 「Add oil、Cleaning」 should be done after turn off the power.</p>	

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	 <b>危険</b>	 <b>DANGER</b>
	高電圧部分に触れて、大けがをすることがある。 電源を切って、5分以上たってからカバーをはずすこと。	Hazardous voltage will cause injury. Turn off main switch and unplug power cord and wait at least 5 minutes before opening this cover.

# Safety Notice



**1. Power must be turned off and wait at least 5 minutes before opening the electrical cabinet to prevent electric shock.**



## Basic notes

1. Before use this machine, please be sure to read the instruction manual and all supporting documents. In addition, please keep this manual in a safe place so that you can refer to it at any time.
2. Some of this Safety Notice is not the content of the product specification that the user purchased.
3. Please wear safety glasses to operate to prevent accidents caused by needle breakage.
4. If you use a pacemaker, please consult with a specialist before operating the machine.

## Safety device、 Warning label

1. In order to prevent accidents caused by the absence of a safety device, please make sure that the safety device is properly installed in the specified position before operating.
2. In order to prevent personal accidents, be sure to install the safety device again to the original position after removing it and confirm that the function is normal.
3. To prevent personal accidents, please keep warning labels always to machines that are clearly visible.

Replace it immediately with a new label if it falls off or becomes dirty.

## Purpose, modification

1. Please do not operate this machine other than its original purpose and the method specified in the instruction manual to prevent personal accidents.

IMB will not be held liable if it is used other than the specified purpose.

- 2., Please do not modify the machine in order to prevent personal accidents. IMB will not be held liable if any accidents caused by modification.

## Training

1. Employer should train the operator about the operation method and safety notice to prevent accidents caused by inexperience and can only used by the operators which possess expertise and operational skills. At the same time, the employer must prepare an education and training schedule for operators before operating and implement it in a practical way.

## Note about power must be turned off

Accident means damage to people and property.

1. Please turn off the power immediately after confirming the abnormality, failure and power failure to prevent personal injury.
  2. In order to prevent accidents caused by sudden start of the machine, please make sure to turn off the power before operating in the following situations. Please must be confirmed that the sewing machine stops completely before operation after power off especially when using clutch motor
- 2-1. For example, parts like needles, loopers and splitters need to be threaded when threading or changing the bobbin.

- 2-2. For example, when changing or adjusting the spare parts.
- 2-3. For example, when checking, repairing, cleaning or when leaving the machine.
3. Please must make sure to pull out the wire with hand instead of pulling the wire when unplugging the power plug to prevent electric shock, leakage and fire accident.
4. Be sure to turn off the power when not using the sewing machine.
5. In order to prevent accidents caused by damage of electrical parts, please turn off the power after power failure.

## **Notice for each using phase**

### **Movement**

1. In order to prevent personal accidents, when lifting the sewing machine to move, be sure to carry it safely according to the weight of the machine.
2. In order to prevent personal accidents, when lifting the sewing machine to move, take measures to ensure safety and prevent falling.
3. In order to prevent unforeseen accidents, falling accidents, and machine damage, please do not repack the machine for moving.

### **Package opening**

1. In order to prevent personal accidents, please open the boxes from the topside.
2. When packing wooden frames, be careful not to get punctured by nails. Please pull the nail off the board.

### **Installation**

#### **( I ) Machine table, stand**

1. In order to prevent personal accidents, please use the original machine table and table stand. If you use non-original parts, be sure to use a machine stand that can fully withstand the weight of the machine and the reaction force during operation.
2. To prevent personal accidents, use casters with sufficient strength with locking device when installing casters on the foot. Lock the machine when it is operating, do not shake the machine during maintenance, inspection, or repair.

#### **( II ) Cable, wiring**

1. To prevent electric shock, electric leakage, or fire, do not apply excessive force to the cable when using the cable. Also, when laying cables near rotating parts such as V-belts, let the cables be 30 mm or more away from them.
2. In order to prevent electric shock, electric leakage, or fire accidents, do not perform branching wiring.
3. To prevent electric shock, electric leakage, or fire, be sure to firmly secure the connector. In addition, when pulling the connector, please hold the connector and pull the cable.

#### **( III ) Grounding**

1. In order to prevent accidents caused by electric leakage and insulation withstand voltage. Always have a

person with electrical expertise to install the power plug. Also, be sure to connect the power plug to a grounded power outlet.

2. In order to prevent accidents caused by electric leakage, please be sure to ground the ground wire.

#### (IV) Moto

1. In order to prevent accidents caused by motor burnout, please use the specified rated motor (original).

2. When using a commercially available clutch motor, it is easy to get caught in a V-belt and cause an accident. Be sure to use a clutch motor with a belt guard that prevents the entanglement function.

#### Before operation

1. In order to prevent personal accidents, be sure to check that connectors, cables, etc. are not damaged, or loose before turning on the power.

2. In order to prevent personal accidents, please do not touch active part. Also, check that the direction of rotation of the pulley matches the arrow mark.

3. When using the table stands with casters, in order to prevent accidents caused by sudden start, please lock the casters. When using the adjuster, adjust the stands and fix it.

#### In operation

1. In order to prevent accidents, please be careful not to let your fingers, hair, and clothes get close to the rotating parts such as the pulley, flywheel, motor, etc., and do not put the items on them.

2. To prevent personal accidents, do not put your fingers near the needle when the power is turned on or during machine operation;

3. When the sewing machine is rotating at high speed. In order to prevent injury to the hand, the hand must not be placed close to the curved needle, the splitter, the needle bar, the hook, the cloth cutter and other active parts. Also, when replacing the sewing machine thread, turn off the power and check that the sewing machine and motor are completely stopped before replacing.

4. To prevent personal accidents, be careful not to pinch your fingers when removing the sewing machine from the machine or when returning to the original position.

5. In order to prevent accidents caused by sudden start, please turn off the power when removing the belt guard and the V-belt., Confirm that the sewing machine and motor are completely stopped before disassembling.

6. When using a servo motor, the motor does not make a sound when the machine is stopped. In order to prevent accidents caused by sudden start, please be careful not to forget to turn off the power.

7. In order to prevent fire accidents caused by overheating, please do not block the cooling port of the motor power box when using.

#### Lubricate

1. Please use the original oil and grease to refuel and apply grease to the specified parts.

2. In order to prevent inflammation and abscess, please wash immediately when oil adheres to your eyes and body.

3. In order to prevent diarrhea and vomiting, if you accidentally drink oil, please take medical treatment immediately.

#### Maintenance

1. In order to prevent accidents caused by unskilled. Be sure to have the maintenance personnel familiar with the machine repair and adjust it according to the instructions in the instruction manual. Also, when

replacing parts, be sure to use our origin parts. The company is not responsible for any improper repairs and adjustments and accidents caused by the use of non-origin parts.

2. In order to prevent accidents caused by unskilled and to prevent electric shocks, please be sure to have electrical expertise or entrust the technicians of our company or agency to carry out electrical repairs(including wiring).。

3. In order to prevent accidents caused by sudden start-up, when repairing a machine that uses high-pressure air such as a cylinder, be sure to remove the air supply source pipe and discharge the residual air before repairing.

4. In order to prevent personal accidents, after repairing and replacing parts, be sure to check that the screws and nuts are not loose.

5. During the use of the machine, be sure to clean it regularly. In this case, in order to prevent an accident caused by a sudden start, be sure to turn off the power and check that the sewing machine and motor are completely stopped before cleaning.

6. When performing maintenance, inspection, or repair, be sure to turn off the power and check that the sewing machine and motor are completely stopped before operating. ( When disengaging the motor, please note that the motor will continue to rotate for a certain period of time due to inertia after the power is turned off.)

7. In order to prevent personal accidents, if the machine fails to operate after repair and adjustment, please stop the operation immediately, contact the company or the agent to arrange the relevant technical personnel to repair.

8. In order to prevent personal accidents, please cut off the power after the fuse is blown. After eliminating the cause of the fuse blow, replace the new fuse of the same specification.

9. In order to prevent a motor fire accident, please periodically clean the fan vent and check the wiring.

#### Use environment

1. In order to prevent accidents caused by malfunctions, use the sewing machine in an environment where there is no strong noise source (electromagnetic wave) such as a high-frequency welding machine.

2. In order to prevent accidents caused by malfunctions, do not use the sewing machine in places where the rated voltage exceeds  $\pm 10\%$ .

3. In order to prevent an accident caused by a malfunction, use a device that uses high-pressure air such as a cylinder, and check that the pressure meets the requirements before using it.

4. In order to use the sewing machine safely, be sure to use it in the following environments.

Temperature during operation  $5^{\circ}\text{C} \sim 35^{\circ}\text{C}$

Relative humidity during operation 35% to 85%

5. In order to prevent accidents caused by damage or malfunction of electrical components, condensation may easily occur from a cold environment to a warm place. Wait until the water droplets are completely dry before turning on the power.

6. In order to prevent accidents caused by damage or malfunction of electrical components, stop operation and turn off the power when thundering for safety.

7. In the presence of radio waves, it may cause noise to nearby TV sets and radios. In this case, use a TV or radio at a distance from the sewing machine.



8. For those who operate the sewing machine in an environment where the noise level of the working environment is 85dB to 90dB. In order to avoid health injury, please advise the operator to use soundproof protective equipment. For those who operate the sewing machine in an environment where the noise level



of the working environment is more than 90 dB, in order to avoid health damage, please let the operator use the soundproof protective equipment. And post the use of soundproofing protection products to places that are easy for operators to see.

9. Disposal of products, packaging, and used lubricants should be handled in accordance with the laws and regulations of each country.

## Precautions for safe use of the MB1002B

 <b>Danger</b>	<ol style="list-style-type: none"> <li>1. In order to prevent accidents caused by electric shock, do not open the cover of the motor electrical box and do not touch the parts inside the electrical box while the power is turned on.</li> </ol>
 <b>Notice</b>	<ol style="list-style-type: none"> <li>1. In order to prevent personal injury, do not operate the machine with the safety device such as the belt guard or finger guard removed.</li> <li>2. In order to prevent accidents, please be careful not to let your fingers, hair, and clothes get close to the rotating parts such as the pulley, flywheel, motor, etc., and do not put the items on them.</li> <li>3. To prevent personal injury, do not put your fingers near the needle when turning on the power or while the sewing machine is running.</li> <li>4. In order to prevent personal injury, do not put your fingers in the thread guard during the operation of the sewing machine.</li> <li>5. When the sewing machine is running, it is rotated at a high speed. In order to prevent injury to the hand, please never let your hand close to the cloth cutter during operation. Also, be sure to turn off the power when replacing the cable.</li> <li>6. In order to prevent personal injury, when the sewing machine moves up or down or returns to the original position, be careful not to pinch your fingers.</li> <li>7. Do not turn off the power or cut off the air supply while the sewing machine is running.</li> <li>8. In order to prevent an accident caused by a sudden start, when the preparation is completed and the sewing is ready, remove the cloth guide.</li> <li>9. In order to prevent accidents caused by electric shock, do not operate the sewing machine while the power cord is removed.</li> <li>10. In order to prevent accidents caused by electric shock and electrical parts damage, please turn off the power switch before plugging or unplugging.</li> <li>11. In order to prevent accidents caused by damage to electrical parts, stop operation when thundering for safety and unplug the power cord.</li> <li>12. In order to prevent accidents caused by damage to electrical parts, condensation may occur when moving from a cold place to a warm place. Therefore, wait until the water droplets are completely dry before turning on the power.</li> <li>13. Because this product is a precision machine, please pay full attention to the operation, do not splash water or oil on the machine, and do not let the machine fall down.</li> <li>14. This machine is a Class A industrial machine. When using this machine in a home environment, there may be radio wave interference. In this case, the user should take appropriate measures to solve the problem of radio wave interference.</li> <li>15. The source of compressed air shall not be lower than 0.5Mpa, and shall not be higher than 0.6Mpa after pressure regulation.</li> <li>16. To repair or relocate the equipment, before turning on the electrical box, you must turn off the power to and ensure that the incoming power has been cut off. (Internal control circuit is directly connected to 220V AC. If the battery</li> </ol>

	<p>box is opened without turning off the power, the internal 220V AC may cause damage to the human body and key components.)</p>
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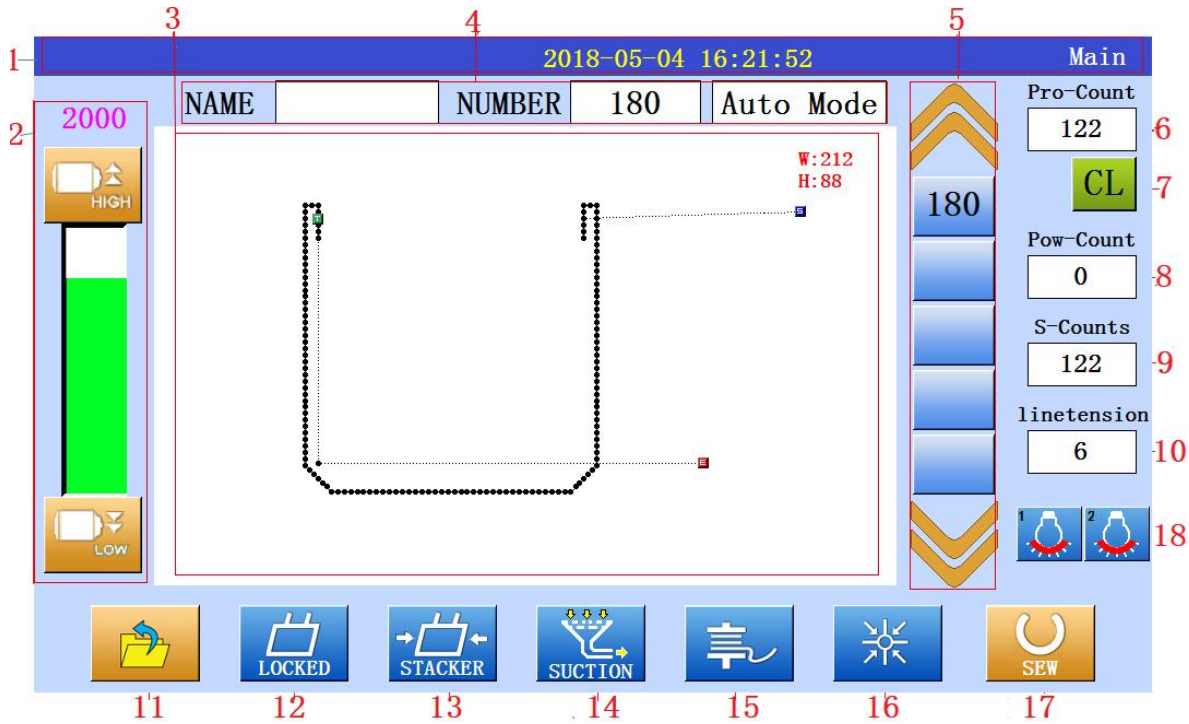
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# 1. Operation panel description

## 1.1 Main interface description

System icon is expressed by international language& habit which will be much easy for usage and for button function identification.



Advanced touch screen technology has been applied to operation panel, to offer revolutionary improvement in terms of operation and screen flexibility.

It is strictly forbidden to touch screen with sharp stuffs to avoid a permanent damage to screen.

Following is the description to main operation panel.

### 1. Title bar

Showing information of manufacturer, time and present interface status.

### 2. presser moving speed gain

Minimum feed unit is 100up/down.

### **3. Pattern display area**

To show you how present pattern looks like and what pattern size is marked with red number right upper area.

### **4. Pattern property**

To show you present pattern name and pattern NO.

### **5. pattern selecting button**

Press upside or downside to select the exact pattern you need according to its pattern name.

### **6. Production counter**

To show you machine total production. (This number will be kept within system always and increasing following daily production changes if without pressing clear button).

### **7. Clear button**

To clear machine total production into zero.

### **8. Power on production counter**

To show you machine production counting from present power on.

### **9. bobbin thread counter**

To count usage of bobbin thread

### **10. production counter**

To show you machine total production. (This number will be kept within system always and increasing following daily production changes if without pressing clear

button).

#### **11. menu button**

Sub Button list:

Compact flash, system pattern, new pattern, modify pattern, convert pattern, Parameter management, device inspection, auxiliary function, power off, fabric catching inspection, presser plate alignment.

#### **12. Locked mode**

Fixed mould.

#### **13. Stacker controller**

To close/open stacker

#### **14. Suction motor controller**

To close/open suction.

#### **15. Bobbin thread winder**

Press this button to enter into thread winding page, winding through pressing pedal.

#### **16. Origin coordinate setting.**

To achieve mechanical origin.

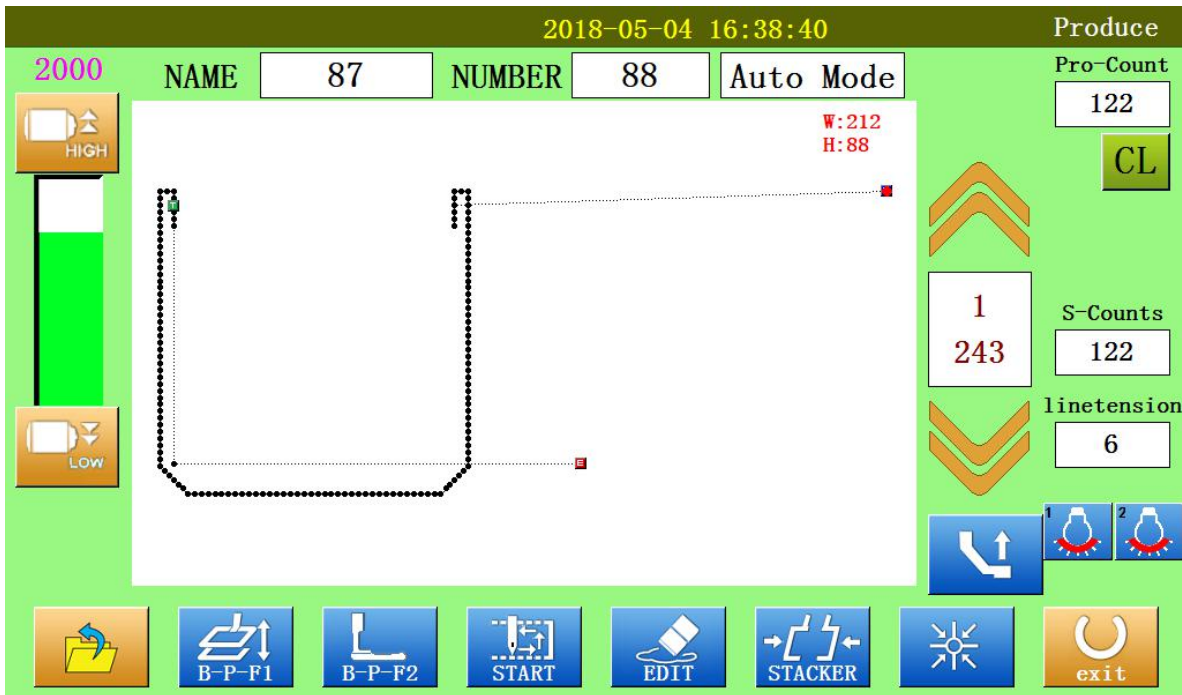
#### **17. ready key.**

To upload sewing pattern data to system and make machine ready for sewing status.

#### **18. laser light**

To help position fabric loading

## 1.2 Sewing screen description





## 2. Hardware setting description

### 2.1. Machine origin coordinate setting

Machine origin status setting is deeply required as for the first time installation the direct drive motor mounted to sewing machine head (this step is usually done by manufacturer before issuing to customer factory, just for learning).

#### 2.1.1. Upper needle position setting of main shaft of sewing machine head

(1): press  to enter into main menu, press  to enter into device checking page,

Before doing device checking, set machine head into original status which requires operator to rotate main shaft clockwise one cycle first then continue rotation to



guarantee needle bar reaching to mechanical upper needle position.

(2): press save button after adjusting.

### 2.1.2. Origin coordinate setting of axis X/Y/U.

(1): After finishing adjustment the position of axis X/Y/U into right status, press




standby button to make machine attachment & machine sewing head into

standby mode. ( Note: After press the standby button, position of machine sewing

needle is supposed to be at upper needle position, otherwise origin movement failure,

machine not ready for coming sewing. )

## 2.2. Function of main menu

Press  to access to the main menu content shown below:



Function of each button specify below:



*flash pattern*, to upload/download existing pattern from system or compact

Flash.



*system pattern*, to edit system existing pattern.



*new pattern*, to draw new pattern.



*pattern edit*, to modify existing pattern.



*parameter management*, to set system parameter of each items.



*auxiliary function*, to achieve system upgrade, time sync, usage limitations.



*fabric catching testing*, to check movement of fabric catching process step

by step.(It applies to the situation that there is already existing pattern in the system )






*fabric catching testing*, to check movement of fabric catching process step

by step.(It applies to the situation that there is no existing pattern in the system )

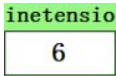
## 2.3 Sewing data setting

### 2.3.1. Maximum sewing speed setting

Maximum sewing speed can be set in  page, if present sewing speed doesn't exceed maximum sewing speed which has been set in the parameter management page, present sewing speed can be simply adjusted through pressing the speed adjusting button  &  which are located in left side of sewing screen.

(Note: Difference between Display screen and sewing screen is : the background color of page of sewing screen turns green after pressing ready key to upload sewing pattern data into system, simultaneously , machine is ready for coming sewing).


### 2.3.2. Bobbin thread counter



Press  this button to activate this page to set one full bobbin thread production to notify operator the surplus of bobbin thread..



If you set Current value 0, there will be no warning about bobbin thread.

### 3. Alignment of folding group.

Note: as we mentioned in the former chapter 2.2,  icon applies to the situation that there is already at least one pattern existing in the system.

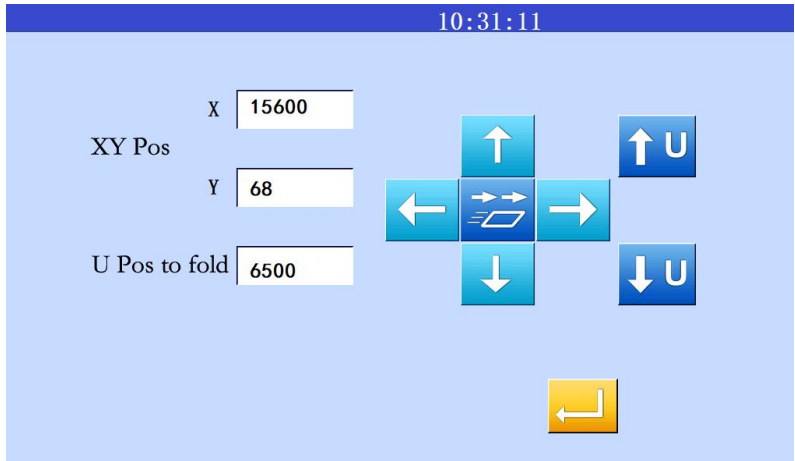
A. Press  to enter into main menu from display screen, press  to activate system into fabric catching testing mode




NOTE:



After entering into fabric catching testing mode, the machine attachment and sewing machine head will be into standby status simultaneously. Pocket presser and foot lifter and need bar will be lifted up automatically.

Page 'step 0' won't show out in the screen if 'hardware origin coordinate setting' is not in proper.









During step 3--step 5, you are allowed to move pattern plate  forward or

backward via press travel button  and .




You are allowed to adjust position of pocket presser  via press travel .

It's absolutely forbidden to break/return back from above adjusting process to avoid machine damage.

#### 4. Code function description during new pattern drawing





Code function	Code illustration	Code function specification
Idle needle		To drive the pocket presser with machine needle in idle mode  (this function is to help drawer draw the needle starting sewing point and needle ending sewing point)
Straight		To draw a new line between two existing dots.
Code		To add the code , the code which is to retract the retractable plate to
		To add thread trimming code at last stitch
		To increase tension of needle thread to offer a pliant stitch
		To set different sewing speed in different lines of one common pocket.  This code allows operator to set the different sewing

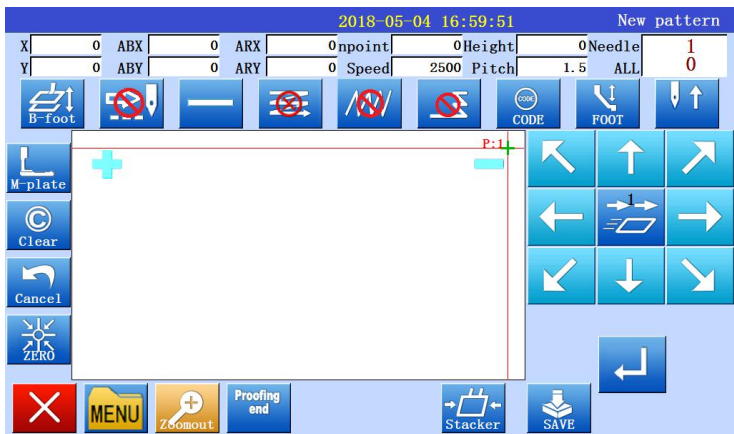
##### 4.1 The way to confirm the needle starting sewing point.

Press  , then select  to activate the specific page to do the basic data setting (these data following the crafts requirement), after done with basic data setting, press  to enter into the main page(shown below):

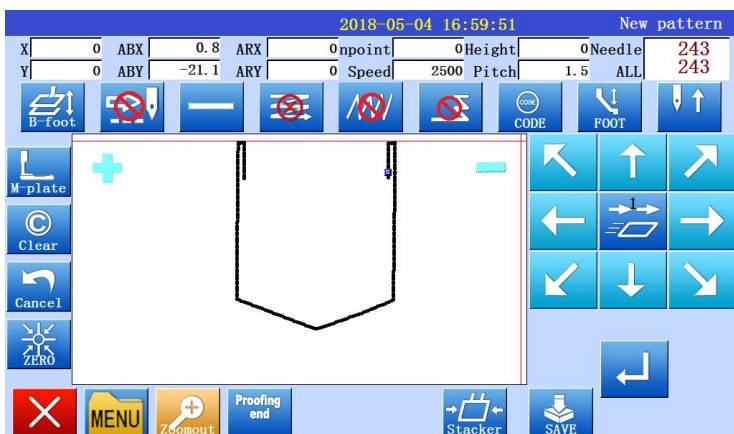
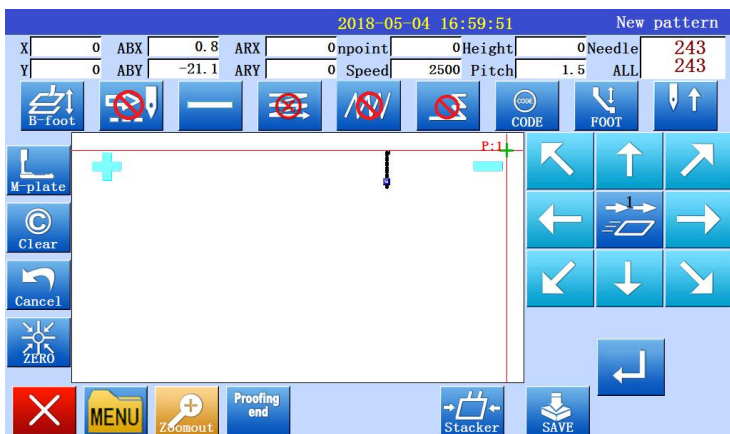
Firstly, press the press button to give a slight movement of presser plate in any

direction is okay,


After done with this, press  to confirm one dot, then press  to clear the former confirmed dot, simultaneously,  will change over to .

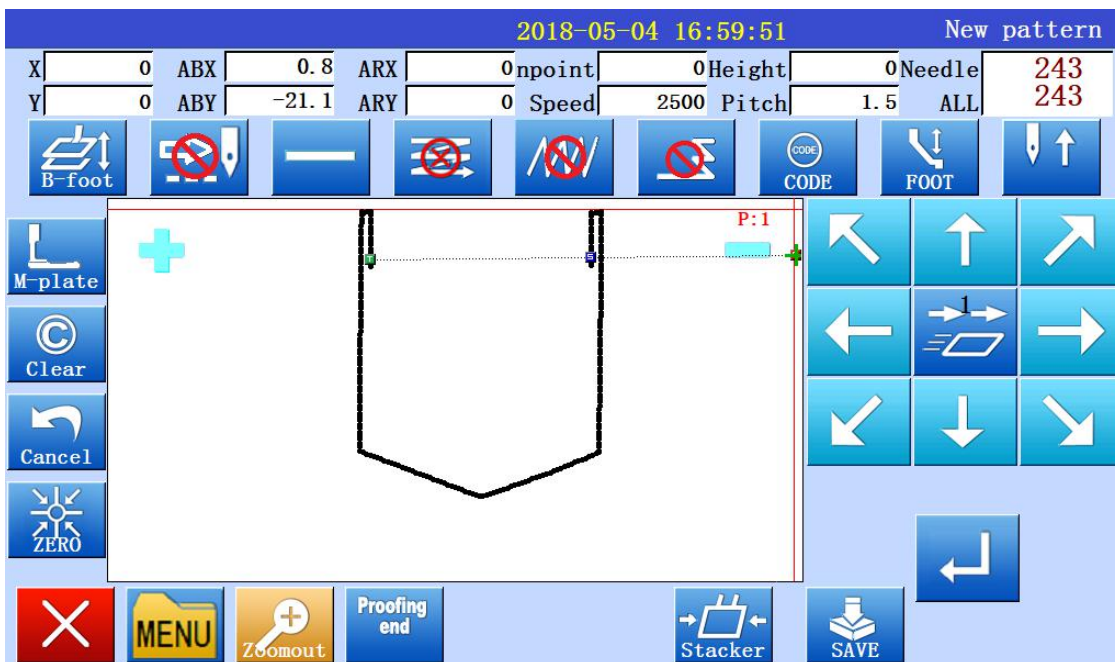


After done with above basic operation, machine is now ready for new pattern drawing.



Control the movement of presser plate through press travel, after finishing aligning press plate with

needle tip, press  to confirm the first dot, then continue with next dot confirming, process following the same way. After done with basic pattern drawing, put the needed code like thread trimming code at the final stitch. And keep this always in mind: after adding thread trimming code, do add idle needle code to allow the machine presser plate move to origin standby position without crashing needle bar/ presser bar(showing below).



### 4.3 pattern save operation

After done with new pattern drawing, press  to save the pattern. There are three different options.

A. First one is to save as new pattern , in the meantime, you are allowed to

name and number new pattern 

NAME	RUANBU	NUMBER	4
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B. Second one is to cover the existed pattern.





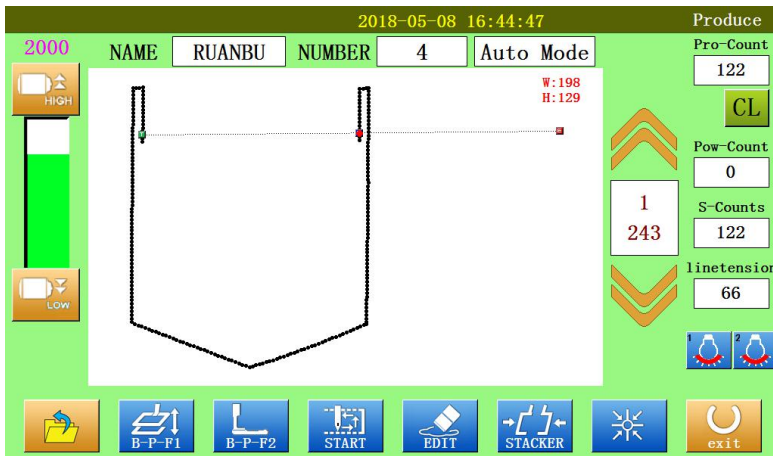
C. Third one is to quit new pattern drawing.

During saving process , some notification may come out from screen to notify you the saving process details.





#### 4.4. Pattern final confirming

After done with new pattern process, upload the new pattern to system , in the meantime, the screen will change from display screen to sewing screen. You are allowed to press up scroll button  and down scroll button  to analog the sewing process in advance seeing if pocket presser strictly moves in alignment with needle tip.



## 5. Electromagnet valve testing & Parameter configuration

Press  , select  Device Check to enter into the specific page shown below:



*<Electromagnet testing>*: to test operability of magnetic valve of each control unit.



*<Stepping motor testing>*: to test stepping motor function.



*<Servo motor testing>*: to test machine head main shaft servo motor

function.



<Signal testing>: to test signal of each switch and sensor.



<Origin coordinate adjusting>: to set machine mechanical origin.




< Burn-in test >: to do machine aging test, function forbidden.

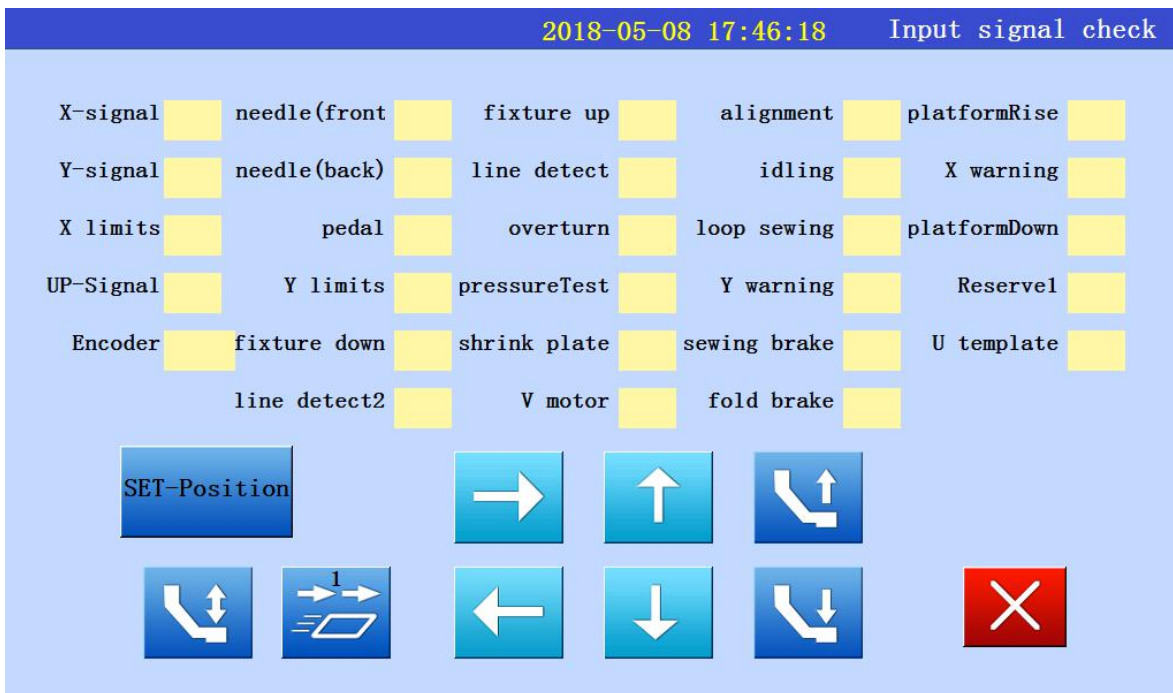


<Screen setting>: to adjust brightness of background screen.

## 5.1. Sensor/ switch testing



Press  to activate the page shown below(The below page is the standard status of the machine sensors & switches after setting machine status into origin standby status which is only used for comparison reference). The main function of this page is to allow operator to do fundamental testing of each sensor& switch of this machine, seeing whether these sensors& switches are in proper or not.



5.1.1 The status of different sensors & switches are normally marked with L/H, ON/OFF, 0/1.

Note: when there is light on the sensor which doesn't mean the status of sensor is in proper, it only proves that the power connection is in proper. Sensor signal status changes following the change of sensor position, which means the sensor function complete.

The way to test sensor is shown below:

Activate out the above page, change the relative position of the specific sensor mounted on the cylinder, the one that you are planning to test, then notify the signal changes from the screen, if signal changes, which proves the sensor function is in proper, otherwise sensor issue.

5.1.2. As for button switch, there are normally two different standard status of it:


ON/OFF.

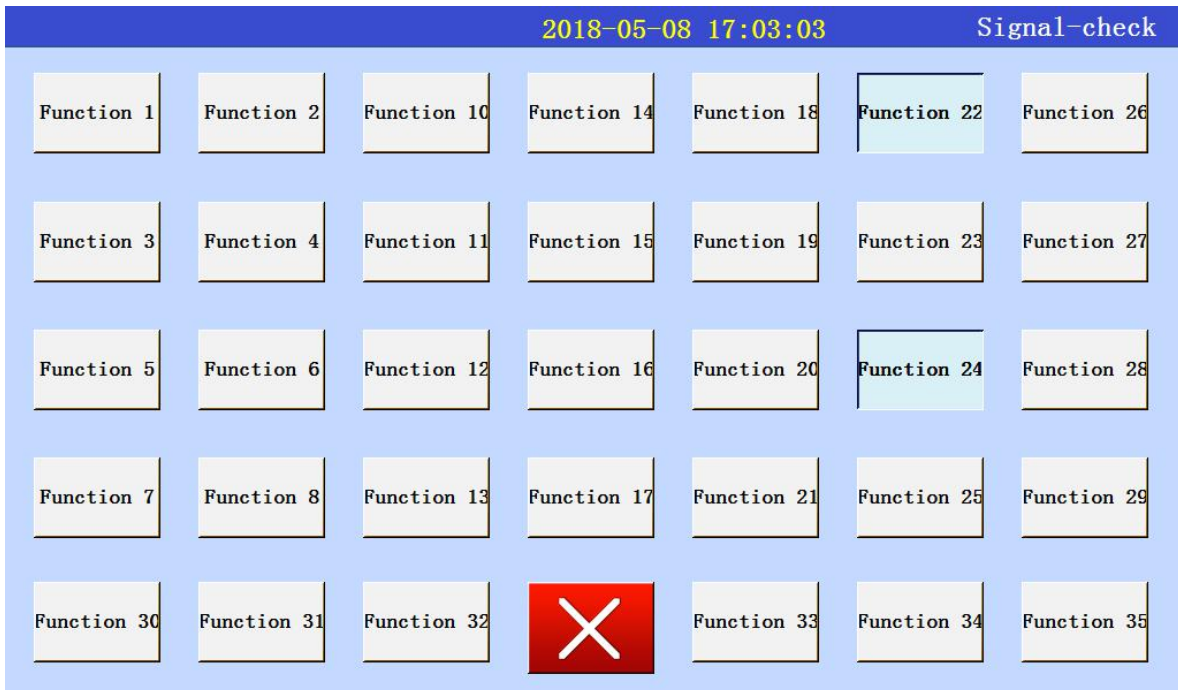
5.1.3 During proper running cycle of main shaft, the main shaft code will gradually decrease from 0~4220.the sensor status will change over from ON to OFF after main shaft runs within a cycle needle position runs up to upper level meanwhile.

5.1.4 As for thread breakage testing, the thread tension differs always, it's acceptable to adjust the tension to an appropriate extent when dragging thread follows with a slight signal changes in the screen.

## 5.2. Electromagnetic valve testing.




Press  to activate page shown below to allow the operator to test each valve function to see whether they are in proper status or not.



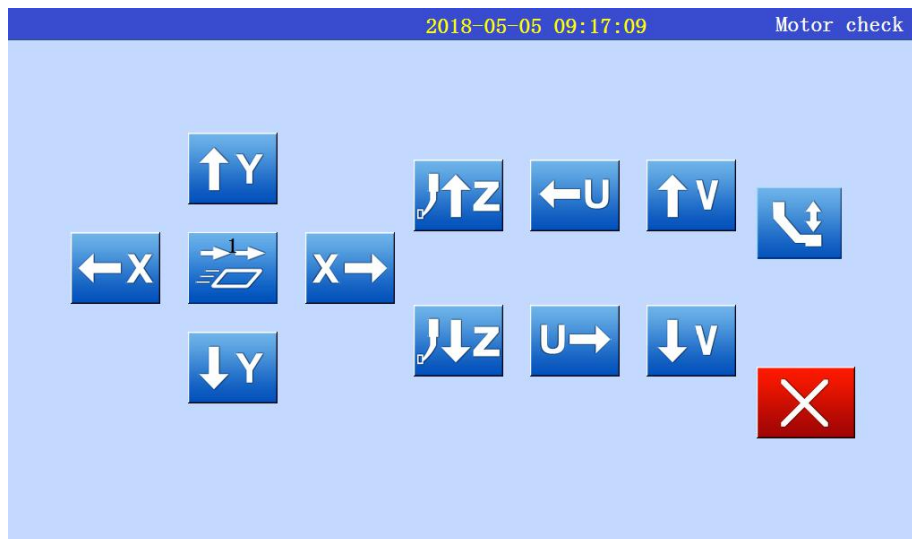
Note:

1. Do keep this always in mind: the timing sequence of each hardware parts might be set in order to avoid some unreparable damages coming out.
2. Do not make long time running testing on these valves to avoid valve burning to damage.
3. Recheck fuse/cable connection/valve normality if there is no response to valve parts testing.

### 5.3. Stepping motor testing.

Press  to activate page shown below.

This page is to allow the operator to test the stepping motor and stepping drive.



## 6.TROUBLE SHOOTING

<b>Phenomenon</b>	<b>Cause</b>	<b>Corrective measure</b>
<b>System locked</b>	Emergency button pressed down	Check emergency button /cable connection
<b>Overload of main shaft</b>	Overload of main shaft	Check if main shaft is stuck
	Low voltage	Check external power supply / plug connection
	Encoder trouble	Check if encoder cable connection is in proper
	Coming out during thread trimming	Trimming crankshaft not in the right position
<b>X axis origin setting Failed</b>	X axis origin setting abnormal	X axis sensor not in right position/sensor connection issue
	No response from X axis stepping motor	motor cable connection issue/motor drive issue
	Confirm via input and output	
<b>Y axis origin</b>	Y axis origin setting	Y axis sensor not in right

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<b>setting Failed</b>	abnormal	position/sensor connection issue
	No response from Y axis stepping motor	motor cable connection issue/motor drive issue
	Confirm via input and output	

m is still hanging there after trying all the solutions listed above in term of the alarm 'overload of main shaft', please open the cover of control box gently, find out the alarm code showing in the LED display and send it back to machine manufacturer for further help.

Do switch off machine and keep it away from line production awaiting for further help when machine comes out alarm 'overload of main shaft'.

