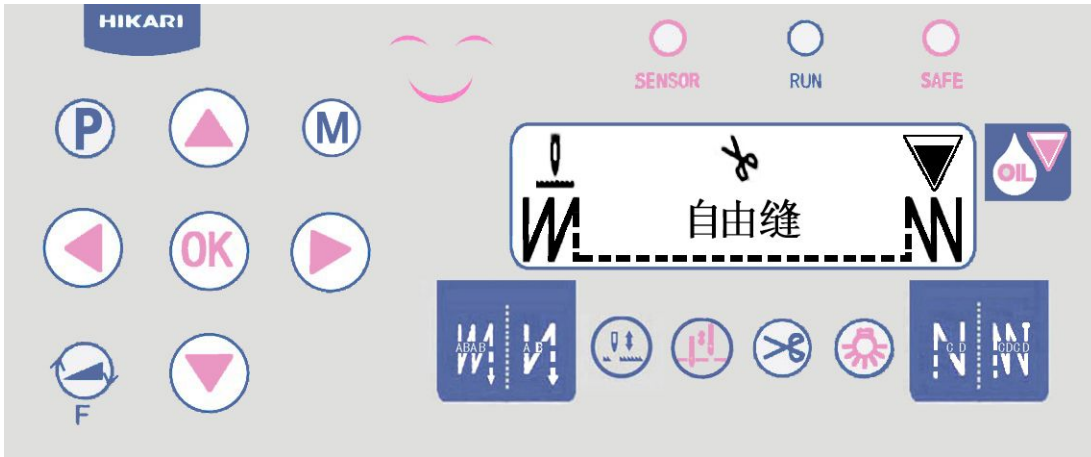


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1. 显示面板区域说明



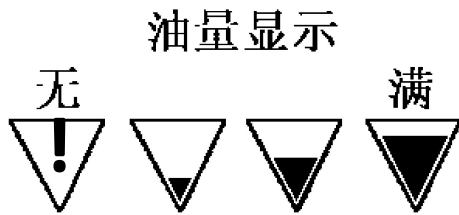
2. 操作面板按键说明

- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8
- 9
- 10
- 11

- 1.
2. 3 /

- 1.
- 2.

3. 油量显示图示









4. 缝纫模式

1		
2		
3		
4		
5		定长缝针数: 15
6	w	



5. 组合键定义





1			
2			
3			
4			
5			/
6			/



- 7  
- 8  
- 9   /
- 10   /

6. 显示模式及操作方法

6.1 工艺参数设定

 + 

2222     

6.2



w

6.3

w 

6.4

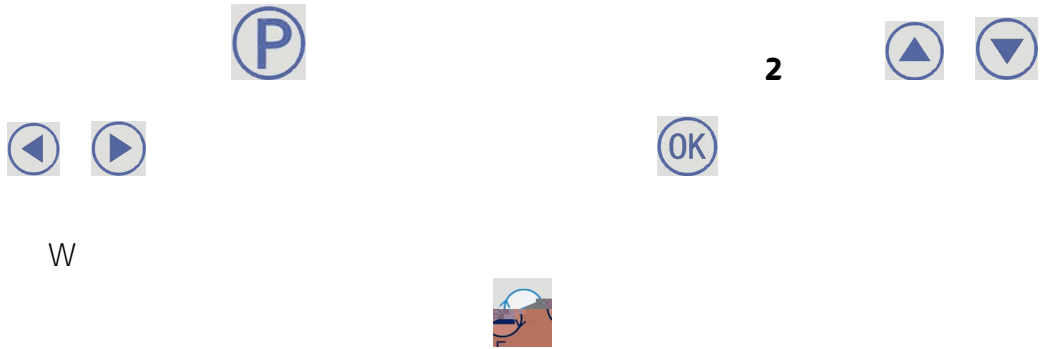
w 

6.5

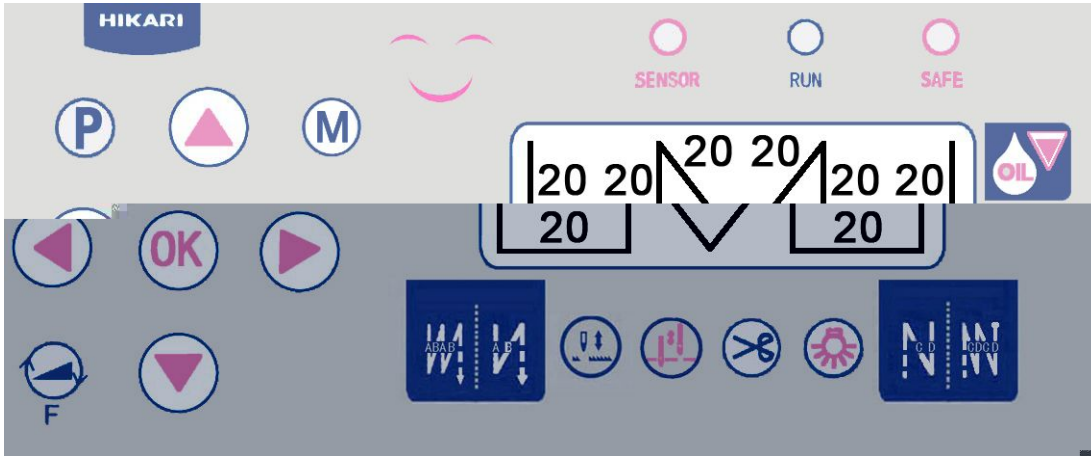
  



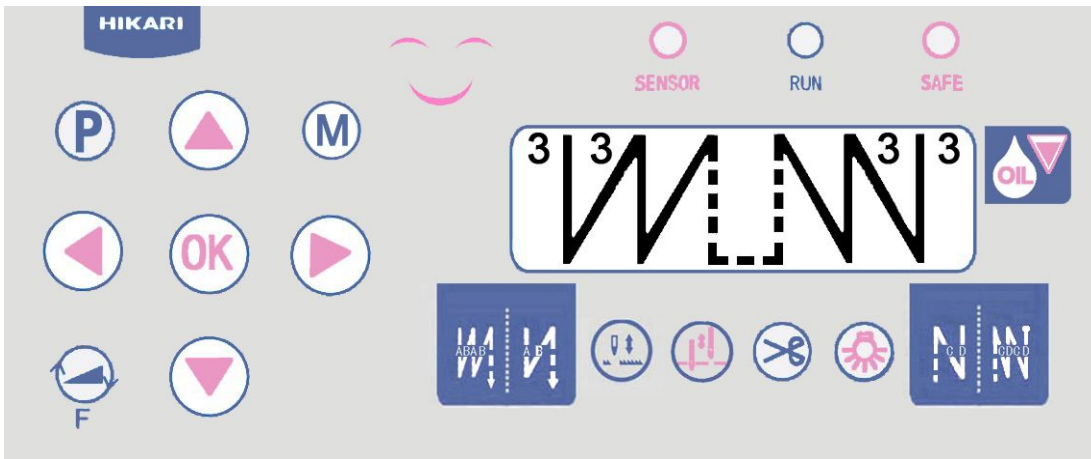
6.6



1 — 1 2



2 —



6.7



6.8



6.9



4

7.

7.1

1.

3mm

2.5mm

2.

7.2

1

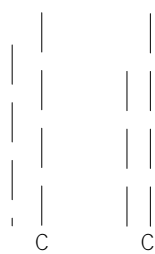
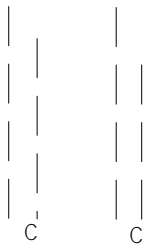
c

4

4

c
c

11
12



11

12

p42

p42

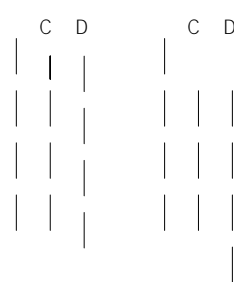
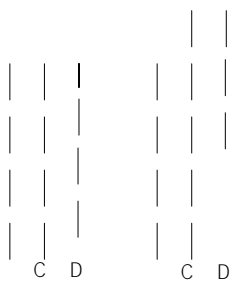
d

4

2

d
d

13
14



5



13

p43
p43

14

P40 P44 P43 P41 P45

W

P42
W

8. 操作面板参数说明表



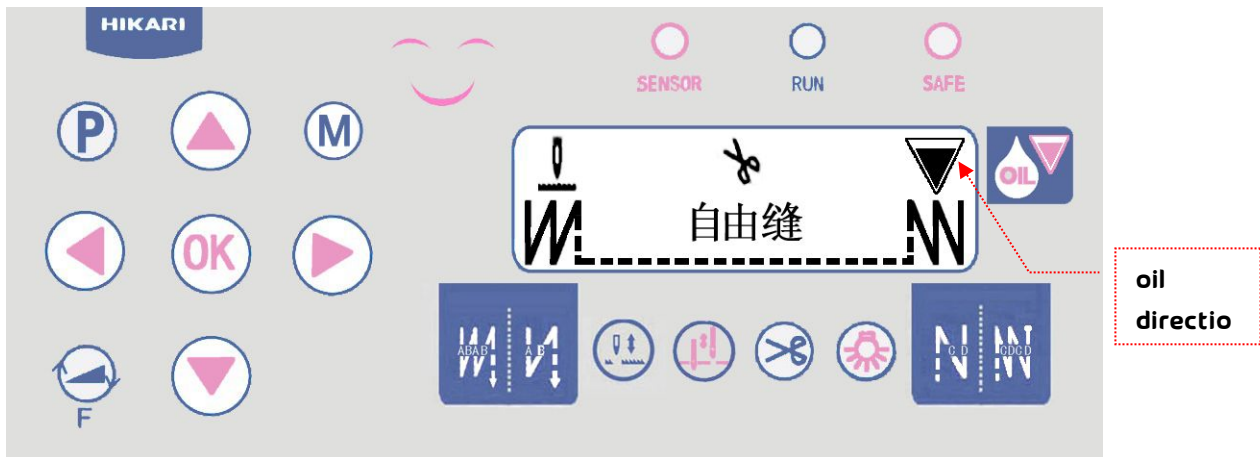
p23		500	200 300 0	rpm	
p24		10	1100		1
p25		2000	19999		
p26		2000	0 9999		
p27		200	20 500	ms	
p28		2	150	ms	
p29		2	150	ms	
p31		1	0 1		0 1
p34		on	onoff		
p36		250	200 500	rpm	
p37		on	onoff		
p40	1	7	0 16		1
p41	2	5	0 16		2
p42	1	7	0 16		1
p43	2	5	0 16		2
p44	w	1	7	0 16	w 1
p45	w	2	5	0 16	w 2
p46		0	0 1		0 1
p47		2000	100 999 9	ms	
p48		2000	100 9999	ms	
p54		0	0 1		0 1
p55		1	0 1		0 1
p57		250	20 1000	ms	
p58		2	150	ms	
p59		3	150	ms	
p60		20	1120	s	

p61		50	20 800	ms	
p62		50	20 800	ms	
p64		0	0 900	s	
p65		0	0 1		0 1
p67		800	200 500 0	rpm	
p69		1000	100 999 9	ms	
p73		off	onoff		
p74		0	0 3		0 1 2 3
p76		0	0 9999		1
p98		0000h	0 9999		
p99		2222h	0 9999		

1. : rpm ms s hour
1. .








1. Instruction of the panel display region

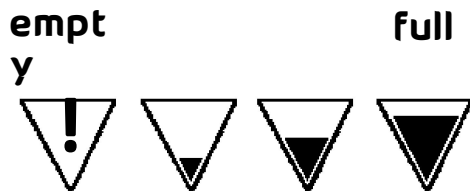


2. Button instructions of the panel

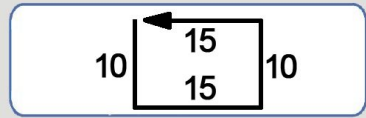
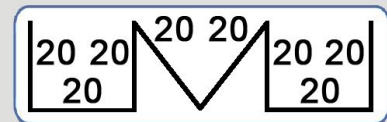
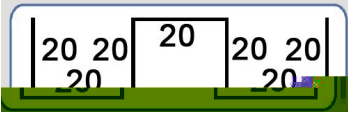

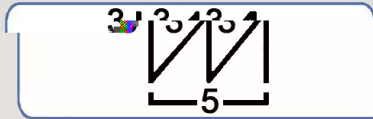
NO.	Icon	Key name	Button function description
1		Parameter set	1. Press once enter the technical parameter adjustment mode; 2. Holding the button 3s Turn on/off the thread clamp
2		Left button	Left move editing area
3		Multi-function button	1. Continuously press the button twice enter sewing speed adjustment mode; 2. Press the button once ,switch parameter display when machine is sewing.
4		Increase button	Increase parameter
5		OK button	saving confirm
6		Reduce button	Reduce parameter
7		Sewing mode	Select sewing pattern.
8		Right button	Right move editing area
9		Fore-tacking sewing	Circulate selection of non- single- double- four- fore-tacking sewing

10		Mending stitch	Mending half stitch when pressing the key once, it will continuously mend stitch while holding press.
11		Needle stop position	Selection of needle up position or needle down position when stopping the needle.
12		Thread trimming set	Trimming and sweep when pattern operation finished once or canceling the function.
13		LED brightness adjust button	
14		Back-tacking sewing	Circulate selection of non- single- double- four- ,back-tacking sewing





















3. Oil display icon



4. Sewing pattern










NO.	Pattern name	For example
1	Four-section sewing	
2	Eight-section sewing	
3	Seven-section sewing	
4	Free sewing	
5	Fixed sewing	
6	W sewing	

5. Definition of key combination


- | | | | |
|----|---|---|---|
| 11 |  |  | Enter or exit the technical parameter set. |
| 12 |  |  | Display the version of the panel software. |
| 13 |  |  | Display the version of the main control box software. |
| 14 |  |  | Display the type of the machine. |
| 15 |  |  | Turn on/off the function of foot. |
| 16 |  |  | Turn on/off the slow-startup |
| 17 |  |  | Display the current amount of lower thread. |
| 18 |  |  | Reset the lower parameter will. |
| 19 |  |  | Turn on/off the oil alarm |
| 20 |  |  | Turn on/off the auto sewing. |

6. Display mode and operating method


6.1 Technical parameter set

Press  and  at the same time it will enter the technical parameter adjustment mode showing "PSD-0000". Then input the password (the password is stored in the control box, the default password is 2222). Through pressing the   we can change the corresponding number. Through pressing the   will switch editing area then pressing . If the password is correct it enters the technical parameter adjustment mode. Press  saving confirm, Press  exit the technical parameter adjustment mode.


6.2 Sewing pattern set

Press Sewing mode , will be select sewing pattern. Circulate selection of four-section sewing, eight-section sewing, seven-section sewing, free sewing, fixed sewing, W sewing.




6.3 Fore-tacking sewing mode

Except W mode press the fore-tacking sewing button  the fore-tacking sewing symbol at the corresponding region will be lighted up according to the fore-tacking sewing parameter. Circulate selection of non- single- double- four-, fore-tacking sewing.







6.4 Back-tacking sewing mode


Press the back-tacking sewing button  the back-tacking sewing symbol at the corresponding region will be lighted up according to the back-tacking sewing parameter, except W sewing mode. Circulate selection of non- single- double- four- back-tacking sewing.

6.5 Thread trimming set

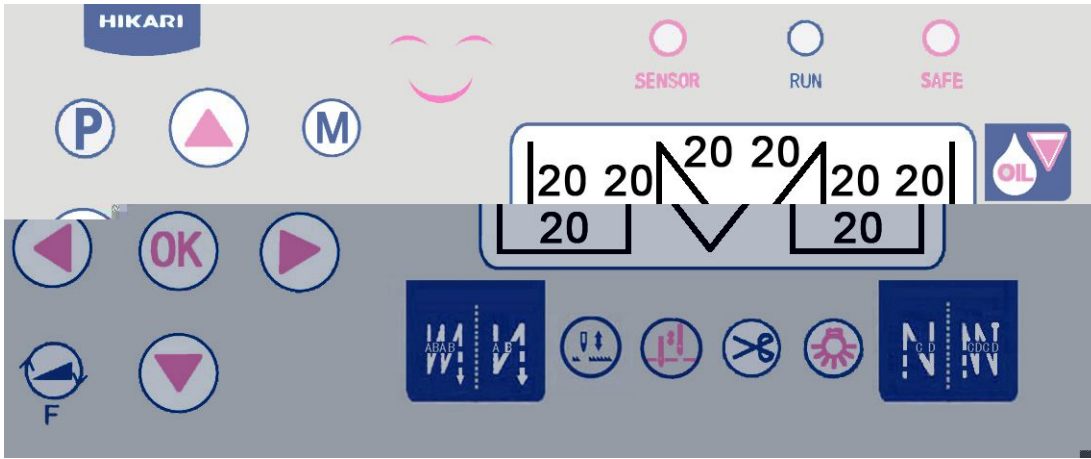
Press the  once the  will be lighted up It means the trimming function is startup then pressing it again the function will be off and  will disappear.

6.6 User parameter set

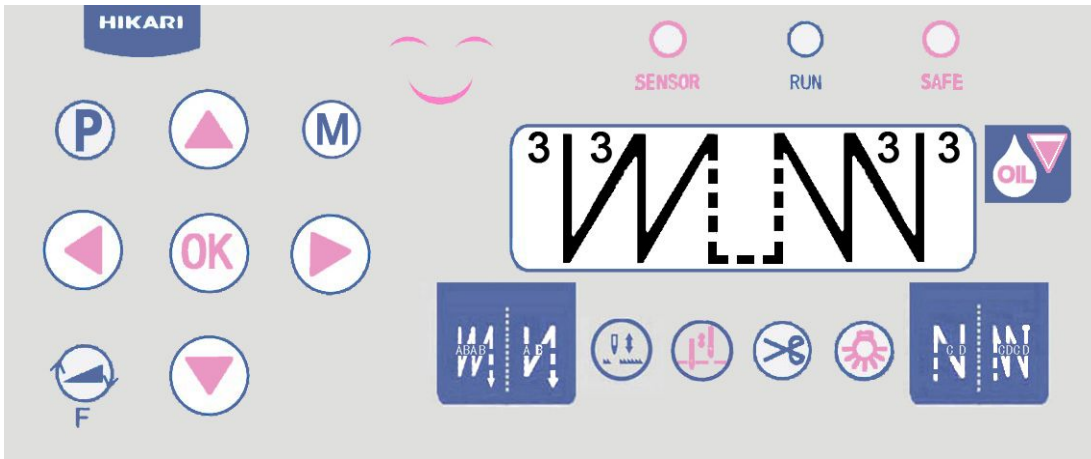
Without the non- Free sewing press once  it will enter the user parameter adjustment mode(picture2) Through pressing the   to modify parameter number through pressing the   will switch editing area Press  saving confirm and exit the user I parameter adjustment mode

If there are fixed-parameters, not all parameters can be shown at the same time except free sewing and W sewing meanwhile if you want to check other parameter press the  to switch display window. Then you can see fixed sewing parameters or sewing stitches. for example Picture1 and Picture12.




Picture1




Picture2



6.7 Adjusting the speed

At the non-adjustment parameter mode press twice  it will enter the speed adjustment mode. Through pressing the   to modify speed.

6.8 Needle stop position set

At the non-adjustment parameter mode press once , Selection of needle up position or needle down position when stopping the needle. the symbol at the corresponding region will be lighted up

6.9 LED brightness adjust

Press  button will adjusting LED brightness Circulate selection 5 mode.

7. Stitch tracking compensation adjustment

7.1 Preparation before adjustment

1. Check the default distance of machine head needle.
2. Take the manual reverse sewing mode, sewing eight stitches and check the overlap effect of stitch tracking. If it is fine, carry on to adjust.

7.2 Adjustment step

1. Set the sewing mode to be fixed mode after power on, shut the fore-tacking sewing, set backward single-reinforcement sewing, set the parameter of C to be 4 stitch and fixed stitch to be 4 stitches, startup the auto-trigger. Step the pedal forward and check if the stitch tracking is overlap. If overlaps, it indicates that the parameter is suitable. Otherwise it will cause two situations, and then adjust the parameter according to the situations.

First situation: C section is shorter than normal, as is shown in Figure 1-1

Second situation: C section is longer than normal, as is shown in Figure 1-2

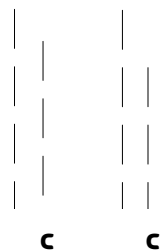


Fig 1-1

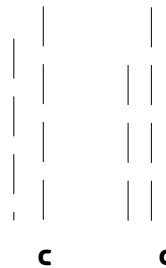


Fig 1-2

For the first situation, we can achieve fully overlap through increasing the value of the technical parameter P42 .

For the second situation, we can achieve fully overlap through decreasing the value of the technical parameter P42.

2. Change the back-tacking sewing mode to double back-tacking sewing mode, set the parameter of D to be 4 stitches. Step the pedal forward and check if the stitch tracking is overlap. If overlaps, it indicates that the parameter is suitable. Otherwise it will cause two situations, and then adjust the parameter according to the situations.

First situation(less needle): the last section of D is shorter than normal, as is shown in Figure 1-3

Second situation(multi-stitch): the last section of D is longer than normal, as is shown in Figure 1-4

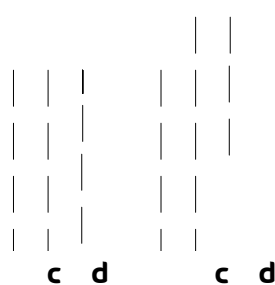


fig 13

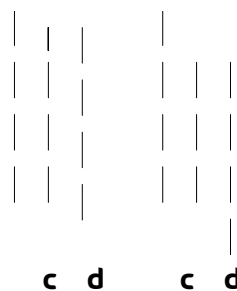


fig 14

For the first situation, we can achieve fully overlap through increasing the value of the technical parameter P43.

For the second situation, it can achieve fully overlap through decreasing the value of the technical parameter P42.

The adjusting way for the forward and backward reinforcement sewing is equal to the way of W sewing. The parameter of P42 can be copy to the P40,P44. and the parameter of P43 can be copy to the P41,P45.

8. Description table of operating panel parameter

Sequence	Function parameter	Default	Setting range	Unit	Parameter description
P0	pedal slope	50	1~100	%	The bigger the slope is, the larger the low-speed region is, and the faster the speed change is; the smaller the slope is, the narrower the low-speed region is, and the lower the speed change .
P1	Speed proportion	8	1~8		Presser proportion of the maximum speed of reverse sewing. The maximum seed is equally divided into eight parts, current speed can be modified through adjusting parts.
P2	System minimum speed	200	150~500	RPM	The minimum speed of motor when sewing.
P3	Maximum speed of the free sewing	3600	150~5000	RPM	The maximum speed of motor at the free sewing.
P4	Fixed sewing speed	3000	150~4000	RPM	Auto-trigger speed of fixed sewing.
P5	Fore-tacking sewing speed	1600	200~3000	RPM	Sewing speed of fore-tacking during operation.
P6	Back-tacking sewing speed	1600	200~3000	RPM	Sewing speed of fore-tacking during operation.
P7	Suspend when the fore-tacking finished.	off	On/off		Pedal trigger is needed to continue operating when suspend at fore-tacking finishing.
P8	Suspend when the	off	On/off		Pedal trigger is needed to continue operating when

	back-tacking finished.				suspend at back-tacking finishing.
P9	W sewing speed	1600	200~3000	RPM	Sewing speed at W sewing mode.
P15	Maximum speed of reverse sewing	2500	200~3000	RPM	Maximum speed of reverse sewing.
P16	Working time of thread sweep	50	20~1000	ms	Working time of thread sweep electromagnet.
P17	Whether the reverse sewing key will be absorbed when the motor stops.	on	On/off		When the motor stops, and the key pressed, whether the electromagnet acts or not.
P18	Stitch/speed priority	0	0~1		Stitch or speed priority setting during sewing: 0:stitch priority 1:speed priority
P19*	Foot presser switch	On	On/off		Turn on/off the function of foot presser.
P21	Selection of counting function	0	0~2		0:Non-counting function 1:Bobbin thread counting function 2:Trimming thread counting function
P22	Slow-startup counting	2	0~15		Stitches when sewing at slow-startup speed
P23	Slow-startup speed	500	200~3000	RPM	The sewing speed at slow-startup.
P24	Lower thread base number	10	1~100		How many stitches changes on lower thread, the current count change one unit.
P25	Total number of Lower thread	2000	1~9999		Total number of lower-thread setting.
P26	Current counting	2000	0~9999		Current amount of lower thread.
P27	Full PWM on time of reverse	200	20~500	ms	Initial startup time of reverse sewing electromagnet.
P28	PWM on time of reverse sewing	2	1~50	ms	PWM on time of reverse sewing when the electromagnet holding on.
P29	PWM off time	2	1~50	ms	PWM off time of reverse sewing

	of reverse sewing				when the electromagnet holding on.
P31	The thread tension switch	1	0/1		Set the electric thread tension. 0 turn off 1 turn on
P34*	Automatic finding needle position	On	On/off		Whether automatic finding the needle up position at PWM on time
P36	trimming speed	250	200~500	RPM	Operating speed when trimming.
P37*	Automatic lift foot presser of half back step	on	On/off		Start or cancel automatic lift foot presser of half back step.
P40	Fore-tacking sewing compensation parameter 1	7	0-16		Fore-tacking stitch sewing compensation parameter 1.
P41	Fore-tacking sewing compensation parameter 2	5	0-16		Fore-tacking sewing stitch compensation parameter 2
P42	Back-tacking sewing compensation parameter 1	7	0-16		Back-tacking sewing stitch compensation parameter 1
P43	Back-tacking sewing compensation parameter 2	5	0-16		Back-tacking sewing stitch compensation parameter 2.
P44	W sewing compensation parameter 1	7	0-16		W sewing stitch compensation parameter 1
P45	W sewing compensation parameter 2	5	0-16		W sewing stitch compensation parameter 2
P46	Manual test mode switch	0	0/1		0 normal operation mode 1 test mode
P47	senescent pause time	2000	100-9999	ms	The interval between each operation
P48	Operating time of test mode	2000	100 9999	ms	Each operating time of the test mode.(valid at no localizer)
P54	safety switch signal type	0	0/1		0: open 1 shut

P55		1	0/1		
P57	Startup time of lifting foot presser	250	20~1000	ms	Initial startup time of lifting foot presser electromagnet.
P58	PWM on time of lifting foot presser	2	1~50	ms	PWM on time of lifting foot presser when the electromagnet holding on
P59	PWM off time of lifting foot presser	3	1~50	ms	PWM off time of lifting foot presser when the electromagnet holding on.
P60	Protection time of foot presser lifting	20	1~120	s	Protecting time of foot presser lifting during working
P61	Delay time of lifting foot presser	50	20~800	ms	How long will it be to start to lift foot presser after the motor stops.
P62	Delay time of downing foot presser	50	20~800	ms	How long is it allowed to startup after foot presser is down.
P64*	Automatic lifting foot presser time after power on	0	0-900	s	Time of automatic lifting foot presser after power on.
P65	Function selection of cloth edge sensor	0	0 1		0 no cloth edge sensor 1 cloth edge sensor
P67	Speed of cloth edge	800	200-5000	RPM	Operating speed when detecting cloth edge signal.
P69	Delay-startup time of cloth margin	1000	100-9999	ms	Delay-startup time when detecting cloth head signal.
P73	Cloth edge sensor	off	On/off		Whether there is an external cloth edge sensor.
P74	Selection of back stitch/ foot presser lifting pneumatic	0	0 3		0 all electromotion 1 backstitch pneumatic 2 presser foot pneumatic 3 all pneumatic
P76	Number of trimming	0	0-9999		Adding 1 to the counter after trim, clear the counter to zero when it reaches max.
P98	Parameter recover to default	0000h	0-9999		

P99	Technical parameter password	2222h	0-9999		
-----	------------------------------	-------	--------	--	--

Note 1 common parameter description RPM: round per minute; MS: millisecond S :second
H :hour

2 The parameters marked with *means that they should re-power after amended.

