

上下复合送料厚料平缝机系列 TOP-BOTTOM FEED LOCKSTITCH FOR HEAVY DUTY MATERIAL

产品使用说明书 Product instruction manual

开车前的注意事项: BEFORE OPERATION

1. 油盘内未加油绝不能开车。
 2. 机器运转时，从手轮外侧看转向应为逆时针方向。注意，不能倒转。
 3. 确认电控标识上的电压及相位是否正确。
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1. Never operate the machine unless its oil pan has been filled with oil.
 2. After setting up the machine, check the direction of motor rotation. To check it, turn the handwheel by hand to bring the needle down, and turn the power switch ON while observing the handwheel. (The handwheel should turn counterclockwise as observed from the handwheel side.)
 3. Confirm that the voltage and phase (single or 3-phase) are correct by checking them against the ratings shown on the electronic identification.

使用注意事项: OPERATION PRECAUTIONS

1. 接通电源开关或机器运转时，请勿将手放到针的下部。
 2. 机器运转时，请勿将手指伸入挑线杆护罩内。
 3. 机头翻动时，一定要切断电机开关。
 4. 操作者离开机器时，必须切断电源。
 5. 机器运转期间，注意不允许任何人的头或手以及任何东西靠近绕线轮和手轮。
 6. 装拆防护罩、或者其它保护装置时，请勿开动机器。
 7. 不要用香蕉水等油漆稀释剂擦洗机头表面。
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1. Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
 2. Do not put your fingers into the thread take-up cover while the machine is operating.
 3. Be sure to turn the power switch OFF before tilting the machine head.
 4. When an operator leaves from the machine, make sure to turn off the power.
 5. During operation, be careful not to allow your or any other person's head or hands to come close to the bobbin winder or handwheel. Also, do not place anything close to them. Doing so may be dangerous.
 6. If your machine is provided with a finger guard or any other protectors, do not operate your machine with any of them removed.
 7. Don't clean the face of machine head with thinner.

1. 机器简介/Profile of the machine

本系列平缝机 自动剪线 单直针 采用连杆式送料 挑线杆挑线 旋梭勾线 形成301线迹。机头加长设计 令操作回转空间更宽敞。超长针杆行程 大互动量交替压脚 使缝厚能力更出色。

本机采用油泵自动润滑,运转轻滑、噪音低、振动小,特别适合手箱包、汽车坐垫、帐篷、沙发等皮革、帆布、厚重装饰布、织带类物品的缝制。

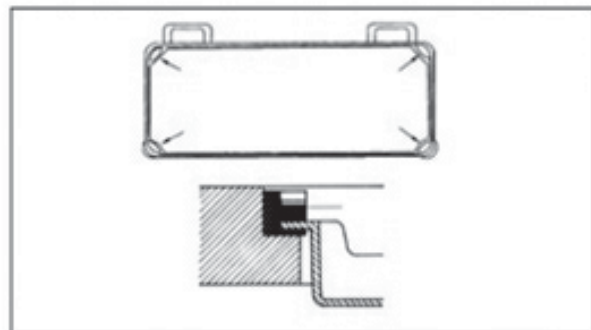
Thick material up and down feeding (auto trimming) a single straight needle sewing machine system, using the link type feed, thread take-up pick-line, Rotating hook line, form 301 stitch. Extended nose design, make operation more spacious space rotation. Long needle bar stroke, a large amount of interaction alternating presser foot, so that Seam thickness capacity is even more remarkable.

This machine adopts oil pump auto lubrication, smooth running light, low noise, vibration, especially for hand luggage, car seat, tents, sofas and other leather, Canvas, heavy fabrics, sewing items like ribbon.

2. 规格 / SPECIFICATIONS

| 型号 Type | JK-2030GHC-Q/2060GHC-Q | JK-2030GHC-3Q/2060GHC-3Q |
|---|--|--|
| 用途 Tailor | 中厚料~厚料 Thick | |
| 最高转速 Sewing speed | 2200rpm | |
| 最大针距 Stitch length | 9mm | |
| 针杆行程 Needle | 38mm | |
| 挑线杆行程 Thread take-up | 73mm | |
| 压脚交互量 Presser foot interactive quantity | 2. 0-5. 5mm | |
| 外压脚操作系统 The presser foot operating system | 标盘 Standard plate | |
| 机针 Needle | DPx17 20#-23# | |
| 旋梭 Hook | 全自动润滑大旋梭 Auto-lubrication with big hook | 全自动润滑大旋梭(剪线) Auto-lubrication with bighook (auto-trimmer) |
| 润滑系统 Lubrication system | 自动供油 Auto-lubrication | |
| 绕线方式 Type of winding | 内置绕线器 Built-in winding device | |
| 剪线装置 Trimming device | 无 × | 有 ○ |
| 倒缝装置 Reverse stitching device | 无 × | 有 ○ |
| 自动抬压脚装置 Footlifter | 无 × | 选配 Optional |
| 电子夹线器装置 Electrical tread nippe | 有 ○ | 有 ○ |
| 压脚提升高度 Press foot hoisting height control | 手提 Hand control | 8mm |
| | 膝提 Knee | 16mm |
| 配套电机功率 W | 750W | 750W |

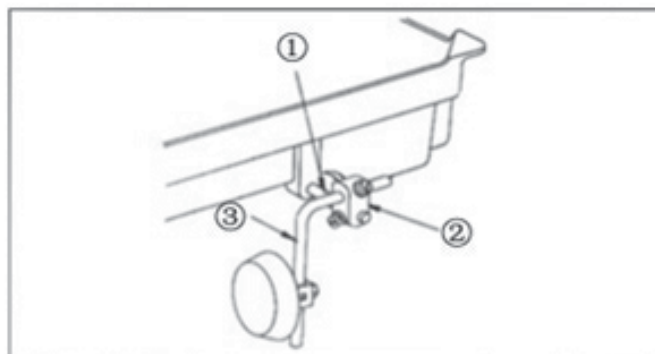
3. 缝纫机的安装 / INSTALLATION



- 1) 将机头支座固定在工作台凹槽四角。
- 2) 将油盘四角搁在机头支架的中间。
- 3) 将机头连接钩放入底板孔内 与台板的机头铰链相嵌合 再将机头放到四只角的机头支座上。

1. Put the rubber cushion on the four corner of the tale socket.
2. Hold the oil reservoir in the middle of the rubber cushion.
3. Put the head connecting hook socket into table, then connect the head connecting hook socket and the head connecting hook which should be on the head, and the machine head will be put on the oil reservoir.

4. 膝控装置安装 / Install the knee-control device



1. 尽量拉出膝控铰链轴① 进行适当安装。
2. 在轴上装上膝控碰块接头②。
3. 在膝控碰块接头上装膝控碰块弯轴组件③。

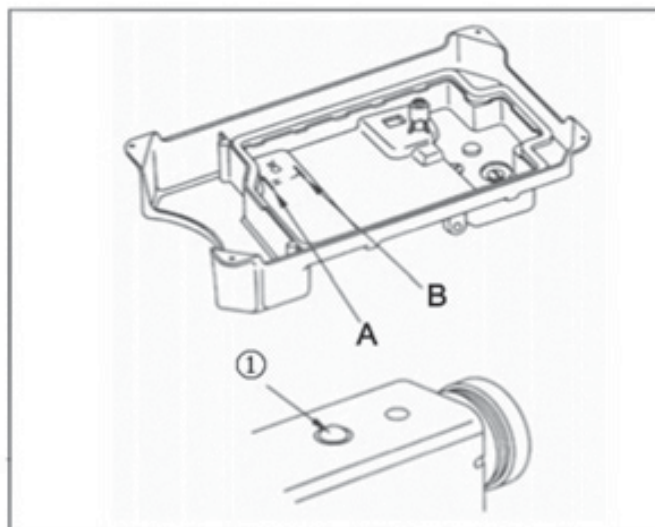
1. Pull the device ① and adjust it.
2. Install the joint ②.
3. Install device ③.

5. 润滑 / Lubricating



注意
CAUTION

加油结束之前 不能接触电源开关 否则误踩踏板启动 可能会受伤事故
加润滑油时 请使用保护身体的眼镜。手套防止与眼或皮肤接触 同时应放在小孩碰不到的地方。
首次使用机械时 或长时间不使用时 必须加油。
Plug in only after oil supply is finished. If the operator mistakenly steps on the pedal with the plug in, the machine will start automatically and can cause severe injuries.
When handling lubricants, wear protective glasses or gloves to avoid contact with your eyes or skin. Inflammation may be caused otherwise. Never drink lubricants since they can cause vomiting or diarrhea. Keep out of the reach of children.
Operate the machine only after adding oil when the machine is being used for the first time or has been left unused for a long time.



将油注入油盘A位置。
在操作过程中, 需经常检查油位高度, 如油位低于B位置时须加油至A位置。
注意: 操作机器时, 可以通过油窗①检查油润滑情况。

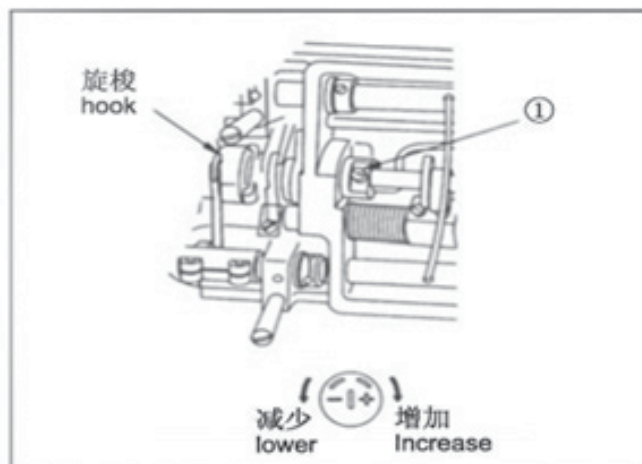
Fill oil pan with new special oil up to A .
In the operating process, need to check the level of the oil level. After filling the oil pan, the oil surface should lie A lines.
Note: Operating machine, Can through the oil window ① check the oil lubrication condition.



注意
CAUTION

在以下机器的调整时 请关闭电源开关。误踩踏板机械启动时 可能会发生身体损伤事故。
使用离合式马达时 关闭电源后 由于惯性 马达会暂时旋转。马达完全停止后 进行操作。
Always turn off the power when mounting a needle. If the operator mistakenly steps on the pedal while the power is on, the machine will start automatically and can result in physical injuries.
When using clutch motor, be aware that the motor will continue to rotate for a while even after the power is switched off due to inertia. Start to work on the sewing machine only after the motor has come to a complete stop.

6. 旋梭润滑的调整 / Rotary hook lubrication adjustment



顺时针 + 转动油量调整螺丝①，出油量会增加，相反逆时针 - 转动油量调整螺丝①时，出油量会减少。

注：调整该螺钉后，机器应至少运转30秒钟，然后检查旋梭出油量。

When you turn clockwise (+) the lubrication adjustment screw① inserted in the front bushing of the lower shaft, the amount of oil will increase while turning to counterclockwise (-) will decrease the amount.

Note: Adjust the screws, the machine should be running at least 30 seconds, then check whether the oil into the hook.

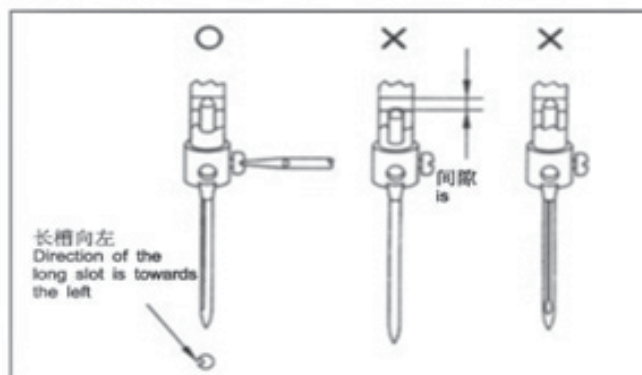
7. 安装机针 / Replace needles



注意
CAUTION

为了防止缝纫机的意外启动 请关掉电源之后进行操作

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

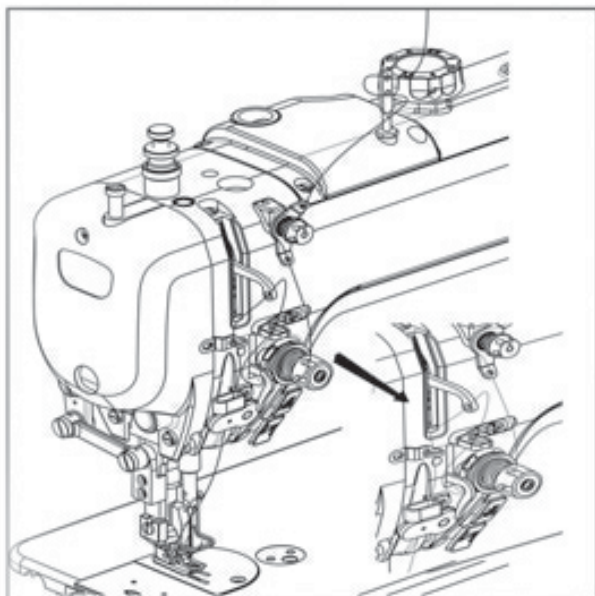


插入机针至底部，拧紧螺钉，保持长槽方向向左。

注意：用涤纶线倒缝时若发生断线，前机针的长槽向前侧转，有可能会避免该情况发生。一般避免将长槽朝向后侧。

Needle should reach the bottom of needle bar, and then tighten the screw. Direction of the long slot is towards the left.

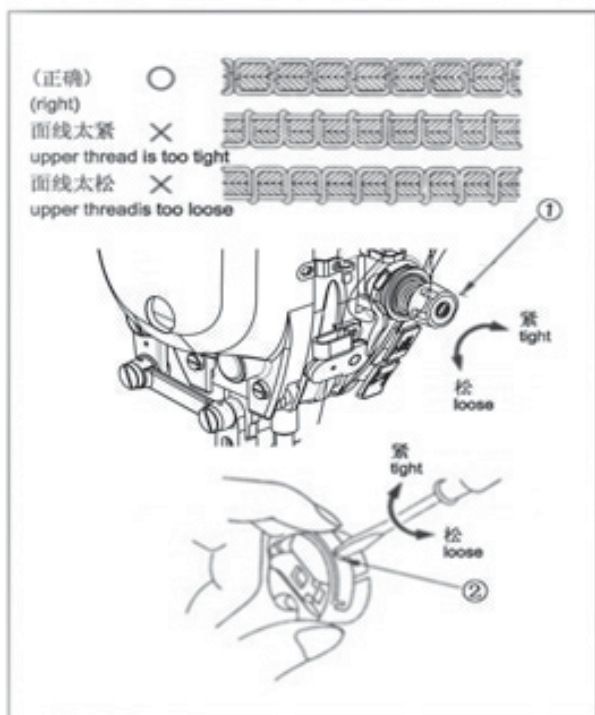
8. 穿面线 / Routing upper thread



将挑线杆转到最高位置, 然后如图所示穿线.

Into the thread take-up position, then as shown threading.

9. 线张力调整 / Adjusting the thread tension



1. 线调整装置

如图所示 顺时针转动压线螺母① 面线张力会变强 相反则会变弱。根据布料、缝线、线距等缝纫条件 线的张力会有所不同

因此需要按照不同情况 进行调整。

2. 底线张力调整

如图所示 在线调整螺钉②上利用起子 顺时针转动 底线张力会变强 相反则会变弱。

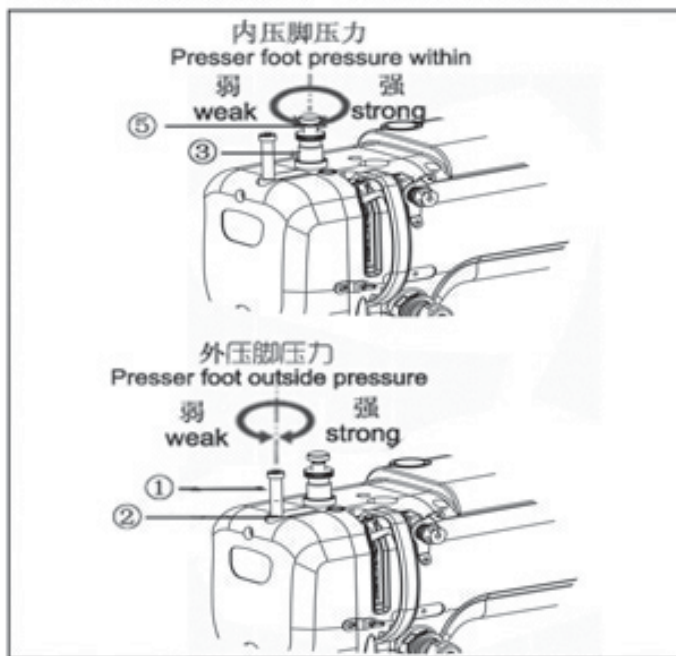
1. Thread control assembly

Like in Figure , turning the tension adjustment nut ① of the thread tension control assembly clockwise makes the upper thread tension stronger and counterclockwise makes it weaker. The result of the needlework depends on the sewing conditions such as the sewing material, used thread and stitch length. So please adjust as desired.

B. Adjusting the thread take up tension

As in Figure 27, insert the driver into the groove ② of the thread tension control assembly. Turn clockwise to make the spring tension stronger and counter clockwise to make it weaker.

10. 压脚压力的调整 / Presser foot pressure



要调整内压力时 顺时针转动压力调整螺丝① 压力会变强 相反则会变弱。调整后 必须完全拧紧固定螺丝②。

外压脚也同样 顺时针转动压力调整螺丝③ 压力会变强 相反则会变弱。调整后 必须完全拧紧固定螺丝④。此外 左右转动辅助压力调节螺丝 进行微细调节。

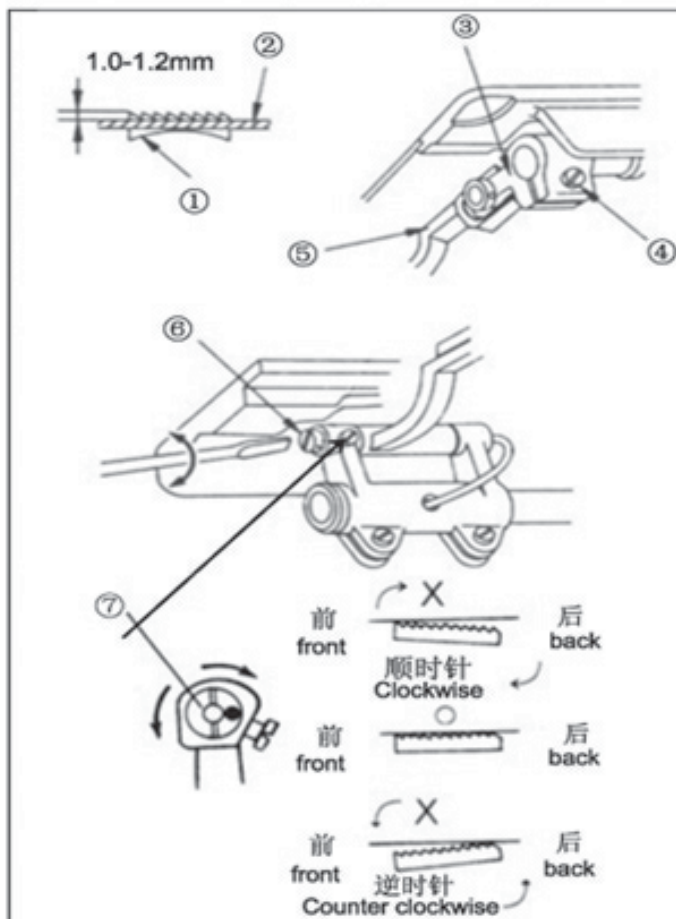
The pressure of the upper feed presser foot becomes stronger when you turn the pressure adjustment screw① clockwise, and becomes weaker in case of turning it counterclockwise.

After the adjustment, be sure to tight the fixing nut②.

The auxiliary presser foot is same to the upper feed presser foot: the pressure increases when you turn the pressure adjustment screw③ clockwise, and becomes weaker in case of turning it counterclockwise.

After the adjustment, be sure to tight the fixing nut④. In case of fine adjustment, use the auxiliary pressure adjustment screw⑤.

11. 调整送布牙 / Adjusting the feed dog



1. 送布牙高度

(1)送布牙①应高于针板②平面1.0-1.2mm为宜。

1)放松抬牙曲柄(前)③上的螺钉④,然后将牙架⑤上下移动。

2)调整结束后,旋紧螺钉④。

2. 调整送布牙倾角

(1)旋松螺钉⑦。

(2)用螺钉刀左右旋转牙架曲柄偏心轴⑥进行整。若顺时针转动 牙架曲柄偏心轴⑥、牙齿前高后低 若按相反方向逆时针转动牙架曲柄偏心轴⑥、牙齿前低后高。

(3)调整结束,旋紧螺钉⑦。

1. Feed dog height.

(1)feed dog ① should higher than ② 1.0mm.

(2)adjust the feed dog height.

1)loose the screw ④ in crank ③ and lower down ⑤ .

2)after adjust,tight the screw ④.

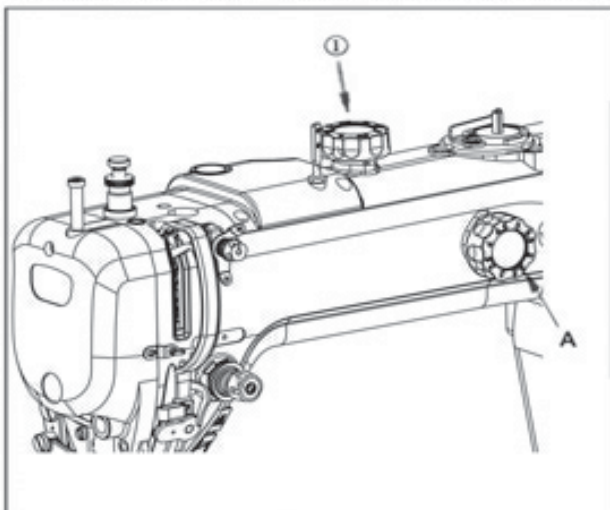
2. Adjust the feed dog angle.

(1)loose screw ⑦.

(2)adjust ⑥.

(3)finish and tightening ⑦.

12. 内外压脚的调整 / Adjusting the auxiliary and upper feed presser foot

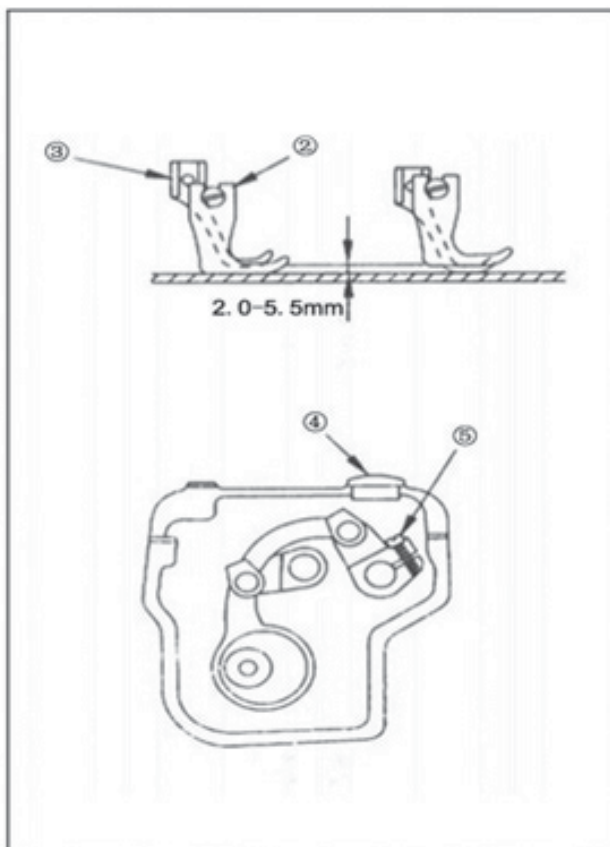


1. 交互运动的调整

- (1) 内外压脚的交互量调整范围为2mm-5.5mm。
 - (2) 内外压脚的交互运动量可通过机壳上的提升压脚标盘A来调节。
 - (3) 上盖板的标盘①是限制提升压脚标盘A的。
- 注 由小到大进行调整时 先调整标盘① 再调整标盘A 相反 由大到小进行调整时 先调整标盘A 再调整标盘①。

1. Interactive motion adjustment

- (1) The vertical running range of the auxiliary presser foot and the upper feed presser foot is from 2 to 5.5 mm.
 - (2) The vertical running amounts of the auxiliary presser foot and the upper feed presser foot are easily adjustable from the climb device dial attached to the front side of the machine.
 - (3) The dial ① attached to the upper cover is a dial which controls the running amount dial A.
- Caution: When you adjust the number from lower one to a higher, you should adjust the dial ① reverse case, the adjustment of the dial A should be done first.



2. 改变内外压脚的交互运动的平衡

- (1) 增加外压脚②的提升量并减少内压脚③提升量。
- 1) 取下上盖板上的橡皮塞④。
- 2) 旋转主动轮直到内压脚③从针板上抬起。
- 3) 旋松螺钉⑤。
- 4) 将内压脚向下调到接触针板 再旋紧螺钉⑤。
- 5) 这样, 内压脚的提升量就减少一定的值 而外压脚的提升量则增加同样的数值。
- (2) 与上面相反的情况 减少外压脚的提升量 增大内压脚提升量的调整如下
- 1) 首先 旋转主动轮直到外压脚抬高针板。
- 2) 旋松螺钉⑤。
- 3) 调好后 旋紧螺钉⑤。这样将减少外压脚的提升量。

2. To change the balance the interactive movement of inner and outer presser foot

- (1) Increase the height of outer presser foot ② and decrease the height of inner presser foot ③.
- 1) Remove rubber stopper ④ from the upper back cover.
- 2) Rotate the hand wheel until inner presser foot ③ lift from the needle plate.
- 3) Loosen the screw ⑤.
- 4) Lower the inner presser foot to the needle plate and tighten screw ⑤.
- 5) In this way, the height of the inner presser foot decreased by a certain value and the outer increased by the same value.
- (2) Contrary to the above, to decrease the height of the outer presser foot and increase the height of the inner presser foot, the adjustment is as follows:
- 1) Firstly, rotate the hand wheel until the outer presser foot lifted from the needle plate.
- 2) Loosen screw ⑤.
- 3) After adjustment, tighten screw ⑤, thus decreasing the height of the outer presser foot.

13. 工业缝纫机安全使用注意事项/Notes for safe use if industrial sewing machines

1. 必须遵守基本措施;
 2. 必须经过专业培训, 对缝纫机设备性能、
 3. 使用前应检查所有安全装置;
 4. 在安装机针、更换机针、压脚、针板、送布牙、弯针、旋梭或修理时, 应立即关闭电源;
 5. 离开缝纫机或工作场所时应关闭电源;
 6. 使用离合马达时, 要等待马达完全停止后再进行;
 7. 缝纫机及附属装置使用的机油, 润滑油等液体流入眼睛或沾到皮肤上应立即清洗;
 8. 禁止用手触摸缝纫机通电时的零件或装置;
 9. 有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行;
 10. 一般的维修保养由专人进行;
 11. 在电气方面的修理应在电气技术员的监督和指导下进行;
 12. 缝纫机使用期间应定期清扫;
 13. 为了正常安全运转, 应安装地线, 同时应在不受高频焊接机等强噪声源影响的环境下使用;
 14. 电源插头应由专人安装, 机油更换周期为六个月。
 15. 工业用平缝机、包缝机在指定用途以外不能使用。
1. Basic measures must be observed.
 2. Pass the specialized training and master sewing machine equipment performance.
 3. All safety devices should be checked before use.
 4. When installing needle, and changing needle, presser foot, plate, feed dog, bent needle, hook or repairing, the power supply should be turned off immediately.
 5. Power should be turned off when leaving the sewing machine or workplace.
 6. When using the clutch motor, please wait until the motor stops completely.
 7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
 8. Do not touch the parts or devices when the machine is powered by hand.
 9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
 10. General maintenance is carried out by specially-assigned persons. The oil replacement period is six months.
 11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
 12. The machine should be cleaned regularly during operation.
 13. In order to operate normally and safely, ground lines should be installed, and they should be used in an environment free from strong noise sources such as high frequency welding machine.
 14. Power plug should be installed by specially-assigned person.
 15. Industrial lockstitch sewing machine and overlock sewing machine can not be used except the designated use.

14. 环保要求/Environmental requirements

- 1、使用过程中产生的废油及其他废弃物请根据当地环保的要求进行合理的处置。
 - 2、请在使用完后及时关闭电源, 减少电能的消耗。
 - 3、请在说明书要求的电压及环境下使用, 已延长产品的使用寿命, 减少废弃物的产生。
 - 4、机器报废后请勿将本机器及其附件作为普通的生活垃圾处理。请遵守本设备及其附件处理的本地法令, 并支持回收行动。
- 1、Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
 - 2、Please turn off the power after use to reduce power consumption.
 - 3、Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
 - 4、Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories and support recycling operations.



- 1) When installing or using this product, the user must read this instruction manual thoroughly and carefully.

When installing or using this product, the user must thoroughly and carefully read the manual.

- 2) All instructions marked with symbols must be paid special attention to or followed, otherwise physical injury may result.

All instructions/symbols must be given special attention or execution, otherwise it may cause physical injury.

- 3) This product must be installed or operated by properly trained personnel.

- 4) For safety reasons, it is prohibited to use an extension cord as a power socket to supply more than two electrical products.

For the sake of safety, it is forbidden to supply two or more electrical appliances with extension cord.

- 5) When connecting the power cord to the power socket, make sure that the voltage is lower than AC 250V and meets the voltage indicated on the motor nameplate.

Specify voltage.

When connecting the power cord to the power base, it must be determined that the voltage is lower than AC 250V and that the specified voltage is specified on the motor nameplate. Note: If the power specification of the electric control box is AC220V, do not plug it into an AC380V power socket, otherwise

If the motor fails to work, an abnormality will occur. Please turn off the power switch immediately and recheck the power supply.

If 380V is on for more than five minutes, the fuse F2, electrolytic capacitors (C58, C59) and

The power module U14 may be damaged, which may endanger personal safety.

Note: if the power supply specification of the electric control box is AC220V, please do not plug it into the power socket of AC380V, otherwise it will be abnormal and the motor will not be able to move. Turn off the power switch immediately and recheck the power. Continuous supply of 380V for more than five minutes will likely damage the fuse F2, electrolytic capacitor (C58, C59) and power module U14, and endanger the safety of the person. Do not operate the product in a place exposed to direct sunlight, outdoors, or in a place where the room temperature is above 45°C or below 5°C.

Please do not operate in direct sunlight place, outdoor and room temperature above 45 °C or below the 5 °C site .

- 7) Please do not use the device near heaters (electric heaters), in places with dew, or in places with relative humidity below 30% or above 95% operate.

Please do not operate in places where the heating (electric heater) is nearby, where there is dew, or where the relative humidity is below 30% or above 95%. 8) Please do not operate in dusty places, places with corrosive

substances or places with volatile gas.

- 9) Please be careful not to stress or over-twist the power cord.

Please note that the power cord should not be subjected to pressure or excessive distortion. 10) The grounding wire of the power cord must be connected to the system ground wire of the production plant with an appropriately sized wire and connector. This connection must be

Permanently solid.

The grounding wire of the power cord shall be connected to the system ground wire of the production plant with a suitable size of wire and joint. This connection must be permanently fixed

- 11) All rotating parts must be protected from exposure by the parts provided.

All rotatable parts must be guarded against the supplied parts. 12) After turning on the power

for the first time, operate the sewing machine at a low speed and check whether the rotation direction is correct.

After the first charge, operate the sewing machine at a low speed and check if the rotation

direction is correct.

13) Before operating the following actions, turn off the power:

1. Insert or unplug any connection plug between the control box and the motor.

between the control box and the motor.

2. When Wearing a needle and thread 3. When turn up machine head

4. When adjust or repair machine 5. When machine rests

14) Repairs or high-level maintenance work should only be performed by properly trained electromechanical technicians.

15) All parts used for maintenance must be approved by our company before they can be used.

15) All repair parts must be approved by the company before use. 16) Please do not knock or hit this product and its devices with inappropriate objects.

warranty period

The warranty period for this product is one year from the date of purchase or two years from the month of manufacture.

Warranty Content

Please do not knock or impact this product and devices with inappropriate objects. Warranty period of this product is within one year from the purchase date or in the factory within two years.

The content of the warranty This product is

operated under normal conditions and without human error. During the warranty period, we will repair it for customers free of charge to restore it to normal operation.

However, repair fees will be charged during the warranty period in the following situations:

This product is in normal condition and without human error operation, during the warranty period free of charge for customer maintenance to be able to operate normally. The maintenance fee will be charged during the warranty period: 1. Improper use includes misconnection to high voltage power supply, use of the product for other purposes, self-disassembly, repair, modification, or non-compliance with regulations.

Do not use within the specified range, do not allow water or oil to enter, or insert foreign objects into the product.

1. Improper use of the products shall include the misuse of the high voltage power supply, the removal of the product for other purposes, self-disassembly, maintenance, change, or the use of the product without the scope of specification, water inlet and insert foreign material.

2. Damage caused by fire, earthquake, lightning, wind disaster, flood, salt corrosion, humidity, abnormal voltage and other natural disasters or improper location.

Harmful.

2. Damage caused by fire, earthquake, lightning, wind, flood, salt erosion, humidity, abnormal voltage and other natural disasters or inappropriate sites. 3. Damage caused by the customer dropping the product after purchase, or the customer transporting the product by himself (or entrusting a transportation company to do so).

3. After customers buy this product, or customers to transport (or entrust the transport company) damage. * This product is produced and tested with

the utmost efforts and strict control to achieve high quality and high stability standards, but external

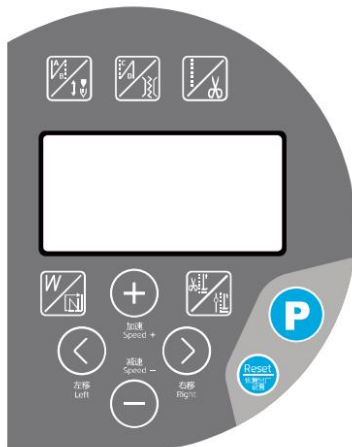
Electromagnetic or electrostatic interference or unstable power supply may still affect or damage this product, so the operating environment

The grounding system must be well done, and users are advised to install fail-safe protection devices (such as leakage protectors)

This product on the production and test all try our best and strict control to the standard of high quality and high stability, but external electromagnetic or electrostatic interference or unstable power supply, may affect or damage caused by our product, therefore the operation place of grounding system must do well, and suggested the user install fail safe protection devices (such as leakage protector)





1Button display and operation instructions

1.1 Operation panel diagram panel introduction



1.2Key IntroductionKey Introduction

| Namemodel | key | Note introduction |
|--|-----|--|
| Enter parameter area function key Enter parameter key | | <p>1. In normal mode, long press the P key to enter the user parameter setting mode;</p> <p>2. In the off state, press and hold P to turn on the power and enter the technician parameter mode;</p> <p>3. View and save the selected parameter number: After selecting the parameter number, press this key You can view and modify the parameters. After modifying the parameter value, press this key to exit and save the parameter.</p> <p>number</p> <p>1.After open machine, press P key long time to enter Users parameter mode 2.when machine off ,press P and turn on the machine to enter technician parameter mode. 3.check all the parameters context and save value, after choose one parameter, press this key to read and modify, after modify press this key exit and save the value</p> |
| Factory reset button Factory reset | | <p>Long press for 3 seconds to restore to factory settings</p> <p>Press 3 seconds then back to factory reset</p> |
| Left Shift Key Left move key | | <p>Select Content Parameters on the left</p> <p>Move to left choose the parameters</p> |
| Right Shift Key Right move key | | <p>Select Content Parameters on the right</p> <p>Move to right choose parameters</p> |
| Speed plus Speed up key | | <p>1. If clicked, the current running speed will be increased;</p> <p>2. In the parameter content area, when setting the value increment key</p> <p>1.press it to increase the current speed 2.Increase all the parameter value 1. If clicked, reduce the current</p> |
| Speed reduction Speed down key | | <p>running speed;</p> <p>2. In the parameter content area, when the value is set to decrease, press the</p> <p>1. Press it to reduce the current speed 2. Decrease all the parameter value 1. If clicked, switch the start back sewing</p> |
| Start back sewing key, up and down Needle stop button Start back tacking/needle position key | | <p>(A, B segment) 1 time, start back sewing (A, B segment) 2 times or off;</p> <p>2. If you press and hold, the stop position of the needle after sewing will be switched (upper stop position/lower stop position)</p> |

| | | |
|--|---|---|
| | | 1. press it to set the start back-tacking 1time,2 times or off 2. press it long time, change the needle position (up needle position/down needle position) |
| End backstitch key, thread clamp Function keys End bar-tacking/nipper key |  | 1. If clicked, switch the end back sewing (C, D segment) once, the start back sewing (C, D segment) 2 times or off; 2. If you press and hold, the automatic thread clamping action will be switched (yes (the corresponding icon is on) / no (the corresponding icon is on) mark off)). 1. press it to set end back-tacking 1 time,2 times or off 2. press it long time,turn on nipper (with the mark on panel)or off(without the mark on panel) |
| Free sewing key, thread trimming function Power key Free sewing/trimmer key |  | 1. The default free sewing mode is on. Once the pedal is pressed forward, sewing will proceed normally. When the board returns to neutral, stop sewing immediately; 2. If you press and hold, the automatic thread trimming action will be switched (yes (the corresponding icon is on) / no (the corresponding icon is on) mark off)). 1. free sewing is open by default setting, when press the pedal machine work, when pedal back to middle, stop sewing immediately. 2. If press it long time, turn on (with mark on panel) trimmer or off (without mark on panel) 1. If clicked, switch to continuous back sewing (W |
| Continuous back stitch (W stitch) Key, multi-stage fixed needle sewing key W sewing / multi-stitches sewing |  | sewing) mode; 2. If you press and hold, it will switch to multi-stage fixed needle sewing mode. 1. Press it to change to W sewing mode 2. Press it long time, change it to multi-stitches sewing mode 1. If you click, the presser foot will automatically |
| Automatic lifting and pressing after thread cutting Foot button, automatic stop Presser foot lift button Footer lift after trimmer/footer lift in middle sewing |  | lift after thread trimming (yes (the corresponding icon is lit))/None (the corresponding icon is off); 2. If you press and hold, the presser foot will be automatically lifted when the machine stops. (There is a corresponding icon on)/off (the corresponding icon is off). 1.press it to turn on footer lifter after trimmer(with the mark on panel) or off(without mark on panel) 2.press it long time,turn on footer lift in middle sewing(with the mark on panel) or turn off(without the mark on panel) |

2 parameter sheet

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|--|----------------|-----------------------------------|---|
| P01 | Maximum speed (r/S) max speed | 100-3500 2000 | The maximum speed | speed during sewing |
| P02 | Acceleration curve adjustment (%) Speed curvilinear path adjust | 10-100 | 80 | Speed controller climbing slope setting The larger the slope value, the steeper the speed; the smaller the slope value, the slower the speed Speed control slope setting Slope value bigger, speed faster, slope value smaller, speed slower |
| P03 | Needle stop positioning selection Needle position | UP/DN DN | | UP: Up needle position DN: Down needle position 1000 Speed setting for the front back sewing (starting |
| P04 Initial | back sewing speed (r/S) | 200-3200 | back sewing) | |

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|--|----------------|-----------------------------------|---|
| | Start back tacking speed End back | | | Set the start back-tacking sewing speed |
| P05 | tacking speed (r/S) End back-tacking speed Continuous | 200-3200 | 1000 | Set the end bac-tacking sewing speed |
| P06 | back-tacking speed (r/S) Multi stitches sewing speed Slow | 200-3200 | 1000 | Speed setting for continuous back sewing Set Multi sewing speed Speed |
| P07 | sewing speed (r/S) Slow start sewing speed Slow start | 200-1500 | 400 | setting for slow sewing Set slow start sewing speed Set the |
| P08 | sewing stitch number (needles) Stitches | 0-99 | 2 | number of stitches when sewing at slow speed, each unit represents half a stitch Set the stitches, every unit means half stitch Set the stitches, |
| P09 | Automatic needle speed (r/S) Automatic multi stitch sewing | 200-4000 2000 | | every unit means half stitch [P34.SMP] Set the speed setting in state A (or needle selection box) The AUTO button has a speed setting when it is pressed) Under A situation set the speed ON: After the |
| P10 | Automatic termination after fixed needle sewing Back sewing function (no stitching function) set up) After multi stitch sewing, stop add stitches function | ON/OFF ON | | last fixed needle sewing is completed, the back sewing action will be automatically terminated. Note: In other words, the add stitch function is not available in any sewing mode. OFF: After the last fixed needle sewing is completed, the termination will not be executed automatically. The back sewing function can be used when the forward or full backward pedaling action must be performed again. After the last stitch, continue add stitches, must press pedal backward to stop Press the back sewing holder J: |
| P11 | Manual back sewing function mode selection select Munal back sewing mode | J/B | J | JUKI method (during sewing or stop in the middle have action) B: BROTHER method (during sewing has action) |
| P12 | Start back sewing motion mode selection Start back sewing mode | 0-1 | 1 | Initial return seam section, reverse electromagnetic coil action timing: 0: Controlled by pedal, can be stopped and started at will; 1: Touch the pedal lightly to automatically perform the back sewing action; Start back tacking solenoid action time 0: control by pedal, can stop and start easy 1: press pedal, automatic back sewing CON: After the start back sewing section is |
| P13 | Start and end point operation mode Style Selection Operation mode choose after back sewing | CON/STP CON | | completed, the next section will be automatically continued After start back sewing, continue to next function STP: Automatically stop after the number of stitches in the initial back sewing section is completed After finish the start back sewing stitches, then stop |
| P14 | Slow Start Slow speed start | ON/OFF ON | | ON: Slow start function is on Function open OFF: Slow start function is off Function off 0: half |
| P15 | Needle filling method Add stitches mode | 0-4 | 2 | stitch; 1: one stitch; 2: continuous half stitch; 3: continuous one stitch; 4: continuous Continue to make up the needle, quick stop 0:half stitch 1:1stitch 2:continue half stitch 3:continue 1 stitch 4:continue half stitch, then stop Compensation for stitching of section A |
| P18 | Start back seam compensation 1 Start back sewing compensation 1 | 0-200 | 164 | of the initial backstitch, 0~200, the action is gradually delayed; the larger the value, the slower the , the shorter the last stitch of A is, the shorter the first stitch of B is. After A period,0-200 means speed slowly gradually, value bigger, the last stitch of A is longer, the first stitch of B is shorter |

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|--|----------------|-----------------------------------|---|
| P19 | Start back seam compensation 2 Start back sewing compensation 2 | 0-200 | 151 | Compensation for the stitch of the B section of the initial back sewing, 0 to 200, the action is gradually delayed; the larger the value, the slower the action. , the longer the last stitch of section B is After B period, 0-200 means speed slowly gradually, value bigger, the last stitch of B is longer |
| P20 | End back sewing motion mode selection End back sewing mode | 0-2 | 1 | End the back sewing section, the timing of the reverse electromagnetic coil action: 0: Controlled by pedal, can be stopped and started at will; 1: Touch the pedal lightly to automatically perform the back sewing action; 2: Pause mode End back sewing solenoid action time 0: control by pedal, can stop and start easy 1: press pedal, automatic back sewing 2: pause mode |
| P21 | Pedal front step voltage Press pedal forward voltage | 30-1000 | 520 | |
| P22 | Press pedal middle voltage | 30-1000 | 480 | |
| P23 | Press pedal half backward voltage Press | 30-1000 | 240 | |
| P24 | pedal backward voltage | 30-1000 | 110 | |
| P25 | Termination back seam compensation 3 End back sewing compensation 3 | 0-200 | 165 | End back sewing C section stitch compensation, 0-200 action gradually lags behind; the larger the value, the slower the action. , the shorter the first stitch of segment C After C period, 0-200 means speed slowly gradually, value bigger, the last stitch of C is shorter. |
| P26 | Termination back seam compensation 4 End back sewing compensation 4 | 0-200 | 151 | , the longer the last stitch of section C, the shorter the first stitch of section D After D period, 0-200 means speed slowly gradually, value bigger, the last stitch of C is longer, the first stitch of D is shorter |
| P28 | Continuous back sewing motion mode selection Continuous back sewing mode | 0-2 | 1 | Continuous back sewing section, reverse electromagnetic coil action timing: 0: Controlled by pedal, can be stopped and started at will; 1: Touch the pedal lightly to automatically perform the back sewing action; 2: Pause mode Continuous back sewing solenoid action time 0: control by pedal, can stop and start easy 1: press pedal, automatic back sewing 2: pause mode |
| P29 | Braking force after cutting Braking force after trimmer | 1-45 | 23 | |
| P30 | Add power for thick fabric | 0-100 | 10 | The larger the value, the greater the force. Adjusting too much may cause motor abnormality. Value bigger, more power, too big value may make motor abnormal. |
| P31 | Thread trimming force Add power for trimmer | 0-100 | 40 | Value bigger, more power, too big value may make motor abnormal. |

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|---|----------------|-----------------------------------|---|
| P32 | Continuous backstitch compensation 5 Continuous back sewing compensation 5 | 0-200 | 164 | Initial backstitch A (C) section stitch compensation, 0~200 action gradually delayed; value The bigger it is, the longer the last stitch of section A (C) is; the shorter the first stitch of section B (D) is. After A@ period,0-200 means speed slowly gradually, value bigger, the last stitch of A(C) is longer, the first stitch of B(D) is shorter Start back stitch B(D) stitch |
| P33 | Continuous back seam compensation 6 Continuous back sewing compensation 6 | 0-200 | 161 | compensation, 0~200 Action is gradually delayed; The larger the value, the longer the last stitch of segment B (D) and the shorter the first stitch of segment C. After B(D) period,0-200 means speed slowly gradually, value bigger, the last stitch of B(D) is longer, the first stitch of C is shorter |
| P34 | Fixed needle sewing motion mode selection Multi stitches sewing mode | A/M | A | A: Touch the pedal to automatically perform fixed needle sewing M: Controlled by foot pedal, can be stopped and started at will A: press pedal, automatic enter multi stitches sewing M: control by pedal, can stop and start easily 0: manual piece |
| P35 | Piece counting mode selection Counter mode | 0-1 | 0 | counting 1: automatic piece counting 0:manual counter 1:automatic counter 0: no |
| P37 | Dial-up output function setting (Tensioner force setting) Nipper power setting | 0-11 | 8 | action; 1: unplug action 2~11 Clamping action, the action strength gradually increases 0:no action 1:spreading function 2~11:clamp thread, power stronger step by step |
| P38 | Trimmer power setting | ON/OFF ON | | ON: With thread trimming action OFF: Without thread trimming action ON: trimmer OFF: no trimmer Same as |
| P39 | When the sewing stops, the presser foot Output selection Footer lift power mode when stop sewing before trimmer | UP/DN DN | | the quick function on the keypad UP: When sewing stops, the presser foot is automatically raised DN: When sewing stops, there is no automatic presser foot lift (controlled by back pedal) Same as panel button function UP: when stop sewing, footer lift DN: when stop sewing, No footer lift (controlled by pedal) Same as the quick |
| P40 | When the thread is cut and the presser foot stops, Force Selection Footer lift power after trimmer | UP/DN DN | | function key on the keypad UP: After cutting the thread, the presser foot will be automatically raised DN: After cutting the thread, there is no automatic presser foot lift (controlled by pedal back) Same as panel button function UP: after trimmer, footer lift DN: after trimmer, No footer lift (controlled by pedal) The number of |
| P41 | Display of the number of completed sewing pieces Pieces display | | 0 | completed sewing pieces is displayed; long press the minus key to reset the count; Display the fabric pieces, press mins key long time can clear value to 0 |
| P42 | the message says Information display | | N-01 | N01 Electronic control version number serial number N02 Needle selection box version number N03 Speed N04 Pedal AD N05 upper positioning angle N06 bottom positioning angle N07 Bus voltage AD N01:control box version series No N02:panel version No N03:speed N04: pedal AD N05:up needle position angle |

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|--|----------------|-----------------------------------|--|
| | | | | N06:down needle position angle N07:wire voltage AD |
| P43 | Motor rotation direction setting (positive Reverse Motor rotate direction setting | CCW/CW CCW | | CW: Clockwise CCW: Counterclockwise CW: clock direction CCW: anti-clock direction |
| P44 | Braking force Braking force Cycle | 1-45 | 18 | Selection of force when the machine stops. When machine stop, the force choose |
| P45 | signal of back-seam force (%) Frequency signal for back sewing power After thread | 10-50 | 30 | When the sewing action is in progress, the output is periodic and power saving. When back sewing, frequency output save electricity |
| P46 | cutting, reverse the needle lifting angle Function selection After trimmer, anti-clock needle up angle function | ON/OFF OFF | | ON: After cutting, the function of automatic reverse is performed. (The angle is determined by [P47.TR8] Adjustment decision) OFF: No effect ON: after trimmer, automatic start anti-clock OFF: No use |
| P47 | Adjustment After trimmer, anti-clock needle up angle adjustment low speed | 50-200 | 160 | After cutting the thread, start from the top of the needle and move in the reverse direction to adjust the needle lifting angle. After trimmer, as per anti-clock needle up angle adjustment |
| P48 | (positioning speed) (r/S ȳ Low speed | 100-500 | 210 | Positioning speed setting Needle position speed setting |
| P49 | tangent speed (r/S) Speed for trimmer Lifting | 100-500 | 250 | Adjust the motor speed during the thread cutting cycle Can adjust the speed for trimmer |
| P50 | time of presser foot (ms) The time that presser foot go up | 10-990 | 250 | Adjustment items when the presser foot is lifted Can adjust the time that it goes up |
| P51 | Cycle signal of presser foot force The signal cycle when presser foot workȳ% ȳ | 10-50 | 25 | When the presser foot is in motion, it uses periodic power saving output to prevent the presser foot from getting hot. When presser foot works, the power work as signal cycle, to sane power and avoid presser foot hot |
| P52 | Presser foot lowering time (ms) The time that presser foot go down | 10-990 | 300 | Adjustment item for delayed lowering of presser foot Can adjust the time |
| P53 | Half-step back to cancel the presser foot lifting function Cancel the function when push the second half pedal | ON/OFF OFF | | ON: When half-stepping backward, there is no presser foot lifting force OFF: When half-stepping backward, there is presser foot lifting force On: when push the second half pedal,presser foot no work Off: when push the second half pedal,presser foot work |
| P54 | Tangent action time (ms) Cutter time | 10-990 | 200 | Action time required for thread cutting sequence The time that cutter need when it works |

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|--|-------------------------------------|-----------------------------------|---|
| P55 | Dial/Sweep action time/ Time that wiper work | 10-990 | 30 | Action time of dial/sweep sequence Time that wiper work 0: Still |
| P56 | Automatically locate the position after power on Find needle position by itself when turn on | 0-2 | 1 | can't find the location 1: Always find your position 2: If the motor is already in the upper position and no longer seeks the upper position (only for magnetic steel Motor) 0 : never find needle position 1: find needle position forever 2:when it is in up needle position, no need to find(just for the machine with Magnetic steel) |
| P57 | Presser foot lifting protection time (s) Protect time for presser foot | 1-60 | 10 | Forced to close after the presser foot is lifted for a certain period of time Will make presser foot down after this time |
| P58 | Upper positioning adjustment Adjust up needle position | 0-1439 | 40 | Upper positioning adjustment, the needle will stop early when the value decreases, and will be delayed when the value increases Stop needle When adjust up needle position, the reduce the number means will stop in advance . add number means will stop later |
| P59 | Lower positioning adjustment Adjust down needle | 0-1439 | 650 | Lower positioning adjustment, the needle will stop early when the value decreases, and will be delayed when the value increases Stop needle |
| P60 | positionTest speed (r/S) Test speed | 100-3700 2000 | | Setting the test speed Set speed for testing speed A test |
| P61 | Test A A test | ON/OFF OFF | | option, after setting, will continue at the speed set by [P60. TV] run About A test, after setting, machine will work by itself under the speed as P60.TV set About A test, after setting, machine |
| P62 | Test B B test | ON/OFF OFF | | will work by itself under the speed as P60.TV set Cycle of start-sewing-stop-thread trimming About B test, after setting, machine will start-sew-stop- trimmer work under the speed as P60.TV set |
| P63 | C Test C test | ON/OFF OFF | | C test option, after setting, will be executed at the speed set by [P60. TV] Start-sewing-stop cycle without positioning kinetic energy About C test, after setting, machine will start-sew-trimmer work under the speed as P60.TV set B, C test, set the conduction time |
| P64 | Test B, C conduction time Test B.C work time | 1-250 | 20 | When BC test, can set work time B, C test, set |
| P65 | Test B, C Stop Time Test BC stop time Head | 1-250 | 20 | parking time When BC test, can set stop time 0: No |
| P66 | protection switch detection Test for safety switch P67 | 0-2 | 1 | detection 1: Detect zero signal 2: Detect positive signal 0: no test 1: test 0 signal 2: test 1 signal |
| Wire trimmer | protection switch detection ON/OFF | OFF OFF: No detection ON: Detection | | |

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|---|----------------|-----------------------------------|---|
| | Test for trimmer protection switch | | | Off: no test on: test |
| P70 | factory model selection Machine mode choose | | 41 | |
| P71 | Presser foot release buffer (ms) The time when presser foot prepare | 0-50 | 1 | Relieve the pressure on the presser foot To buffer the power when presser foot down |
| P72 | Upper stop needle position correction up needle position correction | 0-1439 | | Adjust the upper stop needle position. The displayed value will change with the handwheel position. Press the "P" key to save the current position (value) as the upper stop needle position When adjust up needle position ,the number will change from the position of hand wheel position, then press P to save the number you want |
| P73 | Lower stop needle position correction Down needle position correction | 0-1439 | | Press the "P" key to save the current position (value) as the lower stop needle position When adjust Down needle position ,the number will change from the position of hand wheel position, then press P to save the number you want |
| P74 | Machine Code 1 Machine code 1 | | | |
| P75 | Machine Code 2 Machine code 2 | | | |
| P76 | Backstitch full output time (ms) The time When back tack sews | 10-990 | 250 | |
| P77 | Free sewing ends and the back sewing stops Time (ms) The time when sewing finishes | 20-200 | 100 | |
| P78 | The angle when wiper begins working | 1-990 | 100 | Positioning angle of starting clamp line The angle when wiper finishes working |
| P79 | The angle when wiper finishes working | 1-990 | 270 | Positioning angle of the end of the thread clamp The angle when wiper finishes working |
| P80 | The angle When trimmer begin to work | 0-359 | 18 | Thread trimming feed angle setting (lower positioning is calculated as 0°) Setting the angle when the trimmer begin to work (angle of needle position is 0) |
| P81 | The angle When trimmer work | 1-990 | 150 | Setting the angle when the trimmer work (angle of needle position is 0) |
| P82 | Thread trimming retraction angle The angle When trimmer finishes work | 1-990 | 185 | Setting the angle when the trimmer finish and back(angle of needle position is 0) |

| parameter item numb is | Chinese instructions Chinese meaning | scope Range | Initial Value Default value | Content Value Name Description and Remarks Explanation |
|---------------------------------|---|--------------------|-----------------------------------|--|
| P83 | Stopping distance after wire cutting The distance after stopping trimmer Thick material | 10-100 | 30 | The force selection when stopping after thread trimming. The power choice after trimmer work |
| P84 | starts to increase the force angle The angle of Add power for the beginning of sewing heavy fabric | 0-330 | 9 | |
| P85 | The angle of Add power for the ending of sewing heavy fabric Upper and lower | 0-330 | 57 | |
| P86 | positioning distance Distance between up and down position Ac over voltage setting. | 100-1440 | 610 | Up and down positioning distance angle (every 4 values are 1 degree) Angel Distance between Up and down needle position(every 4 number is 1 angle) |
| P89 | | 500-1023 | 880 | |
| P92 | Encoder absolute position correction Absolute position correction of encoder. | | 160 | Read the encoder starting angle, which is factory set. Do not change it at will (parameter The value cannot be changed manually. Random changes will cause abnormalities in the control box and motor. or damaged) Read the angle of encoder, Jack already made it correct, don't change .(if change the number, will damage the control box ,motor) 1 0ÿÿÿ 1ÿÿÿ |
| P119 | Electromagnet overcurrent protection function on close Switch for protecting over current for coil | 0-1 | | 0: on 1:off |
| P125 Piece | wise thread trimming times Count for trimmer time | 1-9 | 1 When | the number of thread trimming is the set number, the piece count will add 1. When setting the number from small, will add 1 from the beginning number. |

3Error code table

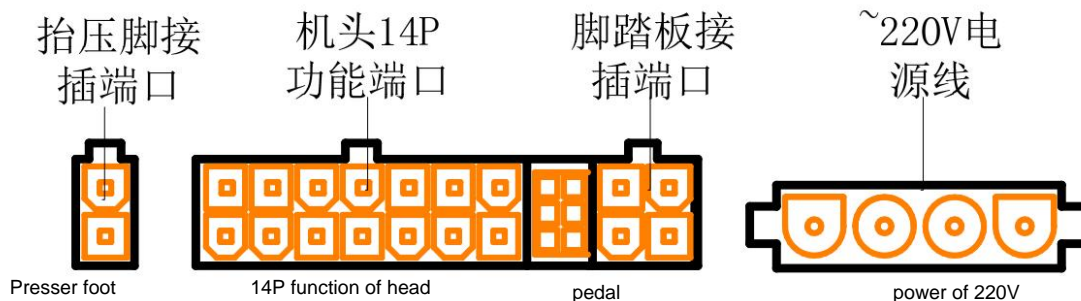
| error code | content | Countermeasures |
|------------|---|--|
| E01 | 1) When the power is on, the system is over-voltage when turn on, the voltage for machine is higher 2) Power supply overvoltage power supply is higher | Turn off the system power supply and check whether the power supply voltage is correct. (Or whether it exceeds Overuse specified rated voltage) If correct, please replace the control box and notify the manufacturer. Pls check the machine voltage,and check the power supply is higher or not.(maybe the voltage is higher than the standard one) restart the machine and see there is problem or not if still has problem, please change the control box and inform the supplier |

| | | |
|-----|--|--|
| E02 | <p>1) When the power is on, the system is undervoltage</p> <p>when turn on, the voltage for machine is lower 2) Power supply is undervoltage</p> <p>power supply is lower</p> | <p>Turn off the system power supply and check whether the power supply voltage is correct. (Or whether it is low for use with specified rated voltage).</p> <p>If correct, please replace the control box and notify the manufacturer.</p> <p>Pls check the machine voltage, and check the power supply is lower or not. (maybe the voltage is higher than the standard one) restart the machine and see</p> <p>there is problem or not if still has problem, please change the control box and inform the supplier Turn off the system power, check if the control panel connector</p> |
| E03 | <p>The control panel and CPU transmission communication is abnormal</p> <p>The signal between panel and CPU has problem</p> | <p>is loose or detached, and replace it.</p> <p>Restart the system after it returns to normal. If it still does not work properly, please replace the control box</p> <p>And notify the factory.</p> <p>Turn off, check the plug of panel is loose or fall off, make the plug correct, then turn on, if still has problem,</p> <p>please change the control box and inform the supplier Turn off the system power, check if the</p> |
| E05 | <p>Speed controller contact abnormality</p> <p>Problem for pedal</p> | <p>speed controller connector is loose or fall off, and restore it.</p> <p>Restart the system after it returns to normal. If it still does not work properly, replace the speed controller and</p> <p>Notify the factory.</p> <p>Turn off, check the plug of pedal is loose or fall off, make the plug correct, then turn on, if still has problem,</p> <p>please change the control box and inform the supplier</p> |
| E07 | <p>a) The motor plug wiring has poor contact and does not rotate</p> <p>b) The locomotive mechanism is deadlocked or the motor belt is caught and stuck by foreign objects.</p> <p>c) The workpiece is too thick and the motor torque is insufficient to penetrate it.</p> <p>d. Module drive output is abnormal</p> <p>a) The connection of motor is not good b) Stuck for machine head or there is some small fabric inside</p> <p>c) The fabric is too thick, it is difficult to sew d) Diven part of control box has problem</p> | <p>Turn the motor hand wheel of the machine head to see if it is stuck. If it is stuck, first remove the machine head machine</p> <p>Mechanical failure.</p> <p>If the rotation is normal, check whether the motor encoder connector and motor power cable connector are</p> <p>Loose. If loose, please correct it.</p> <p>If the contact is good, check whether the power supply voltage is abnormal or the speed setting is too high.</p> <p>Please adjust if necessary.</p> <p>If normal, please replace the control box and notify the manufacturer.</p> <p>See the hand wheel is stuck or not, if yes, solve it If no problem, check plug of motor and encoder is loose or not, if yes, please solve it If connection is good, please check</p> <p>the power is higher or the speed is too high or not if still has problem, please change the control box and</p> <p>inform the supplier</p> |
| E08 | <p>Continuous manual reverse stitching for more than 15 seconds</p> <p>Bartack by hand work for more than 15s</p> | <p>The reverse sewing electromagnet is on for too long. Restart the product. If E-08 is still reported after restarting the product, please check whether the manual reverse sewing switch is damaged.</p> <p>bad.</p> <p>The coil for back tack work time is too long, please restart</p> <p>If still has problem please check the switch of</p> <p>bartack is broken or not</p> |

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| E10 | Electromagnet overcurrent protection Protect for the current for electromagnet | Turn off the system power, check the solenoid (solenoid valve) connection wire or the solenoid (Is the solenoid valve damaged? Turn off, check electromagnet is broken or not Turn off the system |
| E09 E11 | Abnormal positioning signal Needle position has problem | power, check whether the motor encoder interface is loose or off, After it returns to normal, restart the system. If it still does not work properly, please replace the motor And notify the factory. Turn off, check the plug of encoder is loose or fall off, make the plug correct, then turn on, if still has problem , please change the control box and inform the supplier |
| E14 | Encoder signal abnormality Signal of encoder has problem | Turn off the system power supply and check whether the motor encoder interface is loose or detached. After it returns to normal, restart the system. If it still does not work properly, please replace the motor And notify the factory. Turn off, check the plug of encoder is loose or fall off, make the plug correct, then turn on, if still has problem , please change the control box and inform the supplier |
| E15 | Abnormal overcurrent protection of power module Protect for high current for control box | Turn off the system power and then turn it back on. If it still does not work properly, please replace Control box and notify the factory. Turn off, turn on, if still has problem , please change the control box and inform the supplier |
| E17 | The head protection switch is not in the correct position Safety switch | Turn off the system power supply, check whether the machine head is opened, and whether the ball switch in the control box is No displacement or damage. Turn off, then check machine head is overturn or not, and check switch in control box is on or not |
| E20 | The start-up motor fails Motor does not work when turn on | Turn off the system power supply and check whether the motor encoder interface and motor power interface are If it is loose or has fallen off, restore it to normal and restart the system. If the problem persists, please replace the control box and notify the manufacturer. Turn off, check the plug of encoder is loose or fall off, make the plug correct, then turn on, if still has problem , please change the control box and inform the supplier |

4- port schematic diagram plug 4.1

Names of each port



4.2

14P function port correspondence table

1. trimmer electromagnet: 1, 8 2. thread wiping electromagnet: 2, 9 3. LED: 4 (GND), 11 (+5V)
4. Switch for bartack by hand: 5, 12 (GND)
5. Batack electromagnet switch: 6, 13 6. Add stitch switch: 7, 14 (GND)

