

Preface

Welcome to use the our products, it is the right investment choices in garment industry!

This user manual is for our newly developed “All-in-one control box” products reference manual, Please read this manual carefully, hope it can give you useful help!

Before reading the manual, please note the following requirements:

The user must be grounded before operations to ensure safety

Non-professionals do not disassemble the control box

The control box and motor away from the magnetic high radiation environment

Do not work in hot environment
















Do not work in humid environments



















220V electronic control: [220V access to power supply voltage stability between (210V~240V)]


110V electronic control: [110V access to power supply voltage stability between (100V~130V)]

Introduction of display screen common Operation









The serial number	Parameters of the code	功能说明 function instruction	
1	 (Mode switch)	Press  :Auto→Semiauto→Free stitch→Full manual,switch in turn	
2	 (Sensor button)	Press  to turn on off the sensor. (Press  to confirm)	Long press  to adjust sensor:and then press  for thick material  for medium thick material;  for thin material.
3	 (Presser foot switch)	Press  to switch presser foot sensor in turn :front lift,rear lift,fort rear and offlift.	Long press  to adjust presser foot parameters (password required)
4	 (Trimmer switch)	Press  to switch cutter sensor in turn:front cutting,rear cutting ,fro+rear cutting and off cutting.	Long press  to adjust trimmer parameters.

5	(Trimmer switch) 	Press  to switch suction device in turn: front suction, rear suction, fro+rear suction and off suction.	Long press  to adjust parameters of suction device.
6	(Stop pin position adjustment button) 	Press  to switch up or down stop pin position.	Long press  to adjust pin position parameter.
7	(Speed adjustment button) 	Press  to enter speed parameter and press  ,  to change the speed value (value automatically saved)	Long press  to lock speed parameter (password required)
8	(Machine LED button) 	Press  button to enter into the adjustment of the LED light (1-5 degree)	
9	(Menu button) 	Press to enter user parameters	Long press to enter system parameters (password required)
10	(Confirm button) 	Parameter confirm button	
11	(Numerical adjustment key) 	Up key (when increasing value)	
12	(Numerical adjustment key) 	Up key (when increasing value)	
13	(Filter key) 	Left key (when adjusting items)	

14	(Filter key) 	Left key (when adjusting items)	
15	F-SENSOR	Front sensor indicator	When no cloth covers front sensor but F-SENSOR is on, check sensor sensitivity and ensure sensitivity is more than 55.
16	M-SENSOR	Medium sensor indicator	When no cloth covers medium sensor but M-SENSOR is on, check sensor sensitivity and ensure sensitivity is more than 55.
17	B-SENSOR	Back sensor indicator	When no cloth covers back sensor but B-SENSOR is on, check sensor sensitivity and ensure sensitivity is more than 55.
18	SAFE	Safety switch indicator	When the safety switch is off and the SAFE light is on, check that the safety switch is responsive.

2: How to enter parameters and how modify the parameters

System parameter entering analysis:

Long press () button for 2seconds to enter "System Parameter" list (requires a password to enter the adjustment). () () key to select to modify parameter value or menu value. Then, the selected value will be flashing. () () key to increase or decrease the value. After completing modification, press () button to save parameters and quit system parameters.

※ Above is to enter method, the details of specific parameters describe as followings:

※ Factory default password: 2014

Technician system parameter list

System parameter list	Function description	Parameter default values	Parameter Adjustment range	Parameter description
S01	Thread track	3	1~4	
S02	Stitch number between two sensors	20	1~50	Set stitch number between two sensors
S03	Delay stitch number to cut thread after front sensors	4	0~50	Set delay stitch number after passing front sensors.Auto cut thread after stitches
S04	Delay stitch number to cut thread after two sensors	06	0~50	Set delay stitch number after passing two sensors.Auto cut thread after stitches
	Delay stitch number to cut thread after three sensors	0	0~50	
S05	Delay stitch number for starting front air suction	2	1~50	Set delay stitch number for starting front air suction after triggering first sensor
S06	Front suction close stitches no.	14	1~50	Account how many stitches begin to close former suction
S07	back suction start stitches no.	2	1~50	After leaving latter photo-eye,how many stitches begin suck
S08	the delay of back suction close	200	100~5000MS	After leaving latter photo-eyes,count how many milliseconds off suction
S09	front thread loose delay	00		
S10	Front thread loose stitches	12		
S11	Back thread loose start	00		
S12	machine stop delay stitches no.	2	1~99	How much stitches auto parking after trimmer
S13	middle suction start stitches no.	50	1~250	How many needles to breathe before leaving the light eyes
S14	middle suction close stitches no.	20	1~100	Inspiratory pin count

S15	the needle no. of the delay of back cutting line	25	1~100	Leave in the light eye after much after the needle cannot detect the third eye signal begins to cut the line
S16	front sensor respond time	40	1~100MS	The response time when former photo-eye sense
S17	front sensor sensitivity degree	55%	20~175	Setting photo-eye through the fabric strength,to adapt to different fabrics
S18	Back sensor sensitivity degree	55%	20~175	Setting photo-eye through the fabric strength,to adapt to different fabrics
S19	foot presser lift retaining time	220	100~2000MS	Duration Duration after lift foot
S20	foot presser lift start time	0	0~2000MS	The lift foot response time after latter foot pedal
S21	foot presser protection time	6	1~120S	How much time sustained after Manually lift presser foot
S22	release foot presser protection time	20	20~800MS	The time down presser foot
S23	continue feed cloth suction cutting line	0	0~1	0:Close 1:Open
S24	operate manual switch action	1	0~1	0:When the motor is running, tuch manual switch no cutting, 1:Have cutting
S25	safe switch choice	3	0~3	0:off safety switch 1:Seam safety switch 2:Foot safety switch 3: open the safety switch
S26	the knife retaining time	35	1~1000MS	Cutting action time (basically no adjustment)
S27	recover time	5	5~100S	After entering the control panel ,how much time to jump back to the main menu interface
S28	sensor mode (number choice)	2	1~2	1:single photo-eye 2:double photo-eye
S29	front sensor polarity	0	0~1	Opposite polarity opposite
S30	back sensor polarity	0	0~1	Opposite polarity opposite

S31	foot presser full power time	180	10~990MS	Time of full power operation
S32	foot presser full power	100	20~100%	When the foot starts to move, the instantaneous output power
S33	foot presser retaining power	25	10~90%	Pressure foot lift after the maintenance of the power to live (not more than 50)
S34	back cutting line sensor sensitivity degree	55	5~99%	
S35	back cutting line sensor start	1	0~1	0: closed 1: open
S36	obligate	01		brand name choice
S37	language choice	0	0~2	0:Chinese 1:English 2: Turkish
S38	the max speed locked	4800	250~6500	Maximum adjustable speed limit for motor
S39	parameter reset	0	0~1	Transferred to 1 long-press the OK button to effective

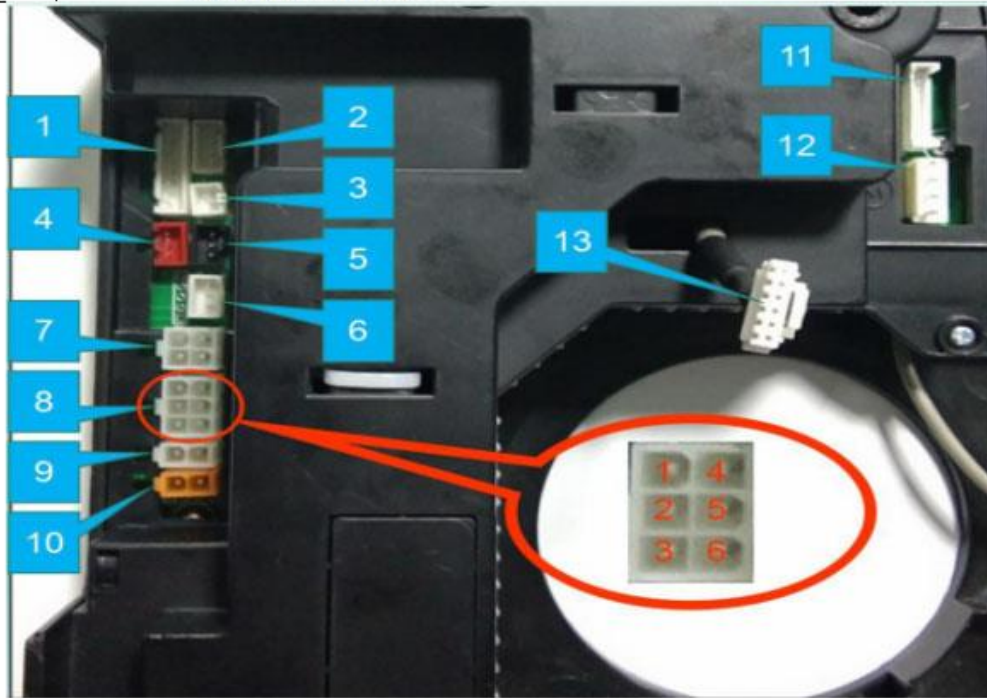
The workers system parameter list (point  enter)

System parameter list	Function description	Parameter default values	Parameter Adjustment range	Parameter description
P-01	Operate mode	0	0~1	0: semi automatic 1: fully automatic
P-02	sensor switch	1	0~1	0:Closed 1:Open
P-03	cutting line	3	0~3	0: close 1: before the cut line 2: after the cut line 3: before and after the shear line
P-04	suction	3	0~3	0: closed 1: before the inspiration 2: after the inspiration of 3: before and after the inspiration
P-05	back pulley wheel	0	0~2	0: close 1: sewing in 2: after sewing

P-06	foot presser	3	0~3	0: no lifting of the foot 1: front lifting foot 2: after the lifting of the foot 3: before and after the lifting of the foot
P-07	start speed mode	1	0~1	0: automatic 1: pedal
P-08	needle positio	0	0~1	0:Upper pin position 1: a needle
P-09	machine stop auto foot presser lifting	0	0~1	0:Closed 1:Open
P-10	suction by hand	1	0~1	0:Closed 1:Open
P-11	start sewing speed	4800	200~5500	
P-12	Max speed	5000	200~5500	
P-13	the degree of the working LED light	4	0~5	
P-14	the backlight degree	1	0~1	0:Closed 1:Open
P-15	semi-auto continue sewing	0	0~1	0:Closed 1:Open
P-16	semi-auto constant sewing	0	0~1	0:Closed 1:Open
P-17	front foot presser lift	0	0~1	0: automatic mode 1: manual mode
P-18	foot controller cutting line	0	0~2	0:closed 1: full manual 2: free stitch semi-automatic
P-19	middle suction	1	0~1	0:Closed 1:Open
P-20	half back foot resser lift	0	0~1	0:Closed 1:Open
P-21	foot presser lift after cutting	0	0~1	0:Closed 1:Open
P-22	close manual foot presser lift	0	0~1	0:Closed 1:Open
P-23	start free sewing	0	0~1	0:Closed 1:Open
P-24	back cutting line sensor delay check	1	0~1	0:Closed 1:Open
P-25	thread tension releasing	3	0~3	0: close 1: front thread tension releasing 2: back thread tension releasing 3: front and back thread tension releasing
P-26	auto running	0	0~1	0:Closed 1:Open
P-27	auto runningn time	4	3~20	The time unit is: Second
P-28	auto running stop time	2	2~20	The time unit is: Second
P-31	volume adjustment	020	020	
P-32	close the start voice	0	0~1	0: close 1: open

3: Control box interface instruction

interface number	the parts name which connect the interface
1	upper sensor and LED light and cutting line
2	down sensor wire
3	the third sensor(knife sensor)wire
4	sewing plate safe switch wire
5	the foot presser safe switch wire
6	oil switch wire
7	foot controller wire interface



§ 8 6P full fuction interface

8 6P full fuction interface mark number	FUCTION	
1, 4	1: knife output	4: 30V
2, 5	2: suction output	5: 30V
3, 6		
9	side suction knife power interface	
10	the foot presser lifter magnet wire interface	
11	motor signal wire interface	
12	motor wire interface	
13	panel signal interface	