

***ENGLISH***

**K-1E  
INSTRUCTION MANUAL  
(CONTROL PANEL)**

# Foreword






Thank you for using our Computerized Control System for Special Sewing Machine.

It is appreciated that you do read this manual carefully in order to operate the machine correctly and effectively. If the user operates the machine contrary to regulations herein, thus cause loss to user or third party, we will not take responsibility. Besides, you should keep this manual for future use. For any fault or problem of machine, please ask the professionals or the technicians authorized by us for repair service.












# Safety Matters for Attention


















## 1. Signs & Definitions of Safety Marks

This Operation Manual and the Safety Marks printed on the products are to enable you to use this product correctly so as to be away from personal injury. The signs and definitions of Marks are shown in below:

 <b>Danger</b>	The incorrect operation due to negligence will cause the serious personal injury or even death.
 <b>Caution</b>	The incorrect operation due to negligence will cause the personal injury and the damage of mechanism.
	This kind of mark is “Matters for Attention”, and the figure inside the triangle is the content for attention. (Exp. The left figure is “Watch Your Hand!”)
	This kind of mark is “Forbidden”.
	This kind of mark means “Must”. The figure in the circle is the contents that have to be done. (Exp. The left figure is “Ground!”)

## 2. Safety Matters for Attention

 <b>Danger</b> <b>Danger</b>	
	For opening the control box, please turn off the power and take away the plug from socket firstly, and then wait for at least 5 minutes before opening the control box. Touching the part with high voltage will cause the person injury.
 <b>Caution</b> <b>Caution</b>	
<b>Usage Environment</b>	
	Try not to use this sewing machine near the sources of strong disturbance like high-frequency welding machine. The source of strong disturbance will affect the normal operation of the sewing machine.
	The voltage fluctuation shall be within 10% of the rated voltage. The large fluctuation of voltage will affect the normal operations of sewing machine, Therefore a voltage regulator is needed in that situation.
	Working temperature: 0℃~45℃. The operation of the sewing machine will be affected by environment with temperature beyond the above range.
	Relative Humidity: 35%~85%(No dew inside the machine), or the operation of sewing machine will be affected.
	The supply of compressed gas shall be over the consumption required by the sewing machine. The insufficient supply of compressed gas will lead to the abnormal action of sewing machine.
	In case of thunder, lightning or storm, please turn off the power and pull plug out the socket. Because these will have influence on the operation of sewing machine.
<b>Installation</b>	
	Please ask the trained technicians to install the sewing machine.
	Don't connect machine to power supply until the installation is finished. Otherwise the action of sewing machine may cause personal injury once the start switch is pressed

	at that situation by mistake.
	When you tilt or erect the head of sewing machine, please use both of your hand in that operation. And never press the sewing machine with strength. If the sewing machine loses its balance, it will fall into floor thus causes the personal injury or mechanical damage.
	Grounding is a must. If the grounding cable is not fixed, it may cause the electric-shock and mis-operation of machine
	The entire cables shall be fixed with a distance at 25mm away from the moving component at least. By the way, don't excessively bend or tightly fixed the cable with nails or clamps, or it may cause the fire or electric shock.
	Please add security cover on the machine head.
<b>Sewing</b>	
	This sewing machine can only be used by the trained staff.
	This sewing machine has no other usages but the sewing.
	When operating the sewing machine, please remember to put on the glasses. Otherwise, the broken needle will cause the personal injury in case the needle is broken.
	At following circumstances, please cut off the power at once so as to avoid the personal injury caused by the mis-operation of start switch: 1. Threading on needles; 2. Replacement of needles; 3. The sewing machine is left unused or beyond supervision
	At working, don't touch or lean anything on the moving components, because both of the above behaviors will cause the personal injury or the damage of the sewing machine.
	During working, if the mis-operation happens or the abnormal noise or smell is found at the sewing machine, user shall cut off the power at once, and then contact the trained technicians or the supplier of that machine for solution.
	For any trouble, please contact the trained technicians or the supplier of that machine.
<b>Maintenance &amp; Inspection</b>	
	Only can the trained technicians perform the repair, maintenance and inspection of this sewing machine.
	For the repair, maintenance and inspection of the electrical component, please contact the professionals at the manufacturer of control system in time.
	At following circumstances, please cut off the power and pull off the plug at once so as to avoid the personal injury caused by the mis-operation of start switch:. 1. Repair, adjustment and inspection ; 2. Replacement of the component like curve needle, knife and so on
	Before the inspection, adjustment or repair of any gas-driven devices, user shall cut off the gas supply till the pressure indicator falls to 0.
	When adjusting the devices needing the power supply and gas supply, users can't be too careful to follow the entire Safety Matters for Attention.
	If the sewing machine damages due to the unauthorized modification, our company will not be responsible for it.

# CONTENTS

Foreword .....	i
Safety Matters for Attention .....	ii
<b>1 General Information .....</b>	<b>1</b>
1.1 Technical Parameters .....	1
1.2 Matters for Safe Using .....	2
1.3 The Preventions on Usage .....	3
1.4 Input Mode .....	4
1.5 Display Method .....	4
1.6 Panel Layout .....	4
1.7 Standardization .....	4
1.8 Operation Mode .....	4
<b>2 Operation and Debugging .....</b>	<b>5</b>
2.1 Instructions of Operation Panel .....	5
2.2 Installing the Main Shaft Motor .....	6
2.3 Text Mode .....	6
2.3.1 01 System Input Test .....	7
2.3.2 02 XY Origin Adjustment .....	7
2.3.3 03 Aging Mode .....	8
2.3.4 04 Main Shaft Detection .....	9
2.3.5 06 Presser Foot Motor Detection .....	9
2.3.6 08 System Output Test .....	10
2.3.7 09 Panel Test .....	10
2.3.8 11 Main motor origin adjustment .....	11
2.4 Basic Operations .....	11
2.4.1 Pattern Number Setting .....	11
2.4.2 Item Data Setting .....	11
2.4.3 Pattern Shape Confirmation .....	13
2.4.4 Sewing .....	14
2.4.5 Change to Other Pattern .....	14
2.4.6 Bobbin Thread Winding .....	15
2.4.7 Sewing with Counter .....	15
2.4.8 Pause .....	17
2.5 P Pattern and C Pattern Setting .....	18

2.5.1 Use Pattern Key to Sew .....	18
2.5.2 Group Sewing (Cyclic Sewing).....	20
2.6 Copy/Delete P Pattern and C Pattern .....	21
2.6.1 Copy/Delete P Pattern .....	21
2.6.2 Copy/Delete C Pattern.....	22
2.7 Memory Switch Activation and Change .....	23
2.7.1 User Parameter Setting List .....	23
<b>3 Service Parameter Setting .....</b>	<b>27</b>
3.1 Service Parameter Activation and Change .....	27
3.2 Service Parameter List .....	27
3.3 Restore Default Setting .....	31
3.4 Software Version Display .....	32
3.5 Check Total Number of Stitches and Clear Lubricating Alarm .....	32
3.6 Password Setting and U/K Parameter Lock .....	32
3.7 Change Password .....	32
3.7.1 Set U/K Parameter Lock.....	33
<b>4 Button Sewing Function .....</b>	<b>34</b>
4.1 Button Sewing Function Setting.....	34
<b>5 USB Communication Function.....</b>	<b>35</b>
5.1 Upgrade patterns via USB stick.....	35
5.1 Upgrade patterns via USB stick.....	37
5.3 Upgrade Step Parameters and Step Curves via USB Stick.....	38
<b>6 Appendix 1 .....</b>	<b>39</b>
6.1 List of Patterns in Controller.....	39
6.2 List of Patterns for Button-sewing in Controller.....	43
6.3 Main Control Error List .....	45
6.4 Operation Panel Error List .....	50
<b>7 Appendix 2 .....</b>	<b>53</b>
7.1 Installation Size of Control Box .....	53
7.2 Installation Size of Operation Panel .....	54
7.3 System Diagram .....	55

# 1 General Information

## 1.1 Technical Parameters

No.	TYPE ITEM	K-1E
1	Purpose	Bar tacking / Button Lock stitch
2	Sewing Area	X(lateral) direction 40mm × Y(longitudinal) direction 30mm
3	Max. Sewing Speed	3200rpm
4	Stitch Length	0.1mm – 10.0mm (adjustable by 0.1mm)
5	Cloth Feed	Intermittent Feed(2-axis drive by pulse motor)
6	Needle Bar Stroke	41.2mm
7	Needle	DP ×5 #14 (DP×5 #11(F,M), (DP×17#21 thick cloth))
8	Type of Lifting Presser Foot	Driven by pulse motor
9	Height of Presser Foot	14mm (Standard), Max. 17mm
10	Total Number of Standard Patterns	100
11	Wiper Type	To work together with Presser Foot driven by Pulse Motor
12	Thread Catching Device	Standard : 0
13	Needle Thread Tension	Electrical Thread Tension Release
14	Shuttle	Standard Semi-rotary Hook or Semi-rotary Double Hook
15	Lubricating Method	Rotary Part: Lubricate with minimum amount
16	Lubricating Oil (Liquid)	Ordinary Sewing Machine Lubricating Oil (Liquid)
17	Grease	Ordinary Sewing Machine Grease
18	Data Memory	Flash Memory
19	Scaling Facility	20%~200%(by 1%) in X direction and Y direction respectively
20	Scaling Method	By increasing/decreasing the stitch length
21	Max. Sewing Speed Limitation	400-3200rpm (by 100rpm)
22	Pattern Selection	Specifying Pattern No. Type (1-200) The total number of stitches for self-made patterns is 13000
23	Bobbin Thread Counter	Up/Down Type (0 – 999999)
24	Sewing Machine Motor	500W Compact AC Servomotor (Direct Drive)
25	Dimensions	263mm×153mm×212mm
26	Weight	10 Kg
27	Rated Power	600W
28	Operation Temperature Range	0°C - 50°C

29	Operation Humidity Range	35% - 85% (No Dew Condensation)
30	Line Voltage	AC 220V $\pm$ 10%; 50-60Hz

※ Please reduce the max sewing speed in accordance with the sewing conditions.

※ Effective standard for product: QCYXDK0004—2023 “Computerized Control System for Industrial Sewing Machine”

## 1.2 Matters for Safe Using

### ● Installation

- Control Box
  - ◆ Please install the control box according to the instruction
- Attachments
  - ◆ If other attachments are needed, please turn off the power and pull off the power plug.
- Power Cable
  - ◆ Do not press power cable with force or excessively twist power cable.
  - ◆ The power cables shall be fixed with a distance at 25mm away from the rotating component at least
  - ◆ Before powering the control box, user shall carefully check the voltage of power supply and position of power input on control box. If the power transformer is used, user should also check it before powering the machine. At this moment, the power switch of sewing machine must be set as “Off”.
- Grounding
  - ◆ In order to avoid the noise disturbance and shock caused by electrical leakage, user should ground the grounding cable.
- Attachments
  - ◆ If the electrical attachments are needed, please connect them to the proper positions.
- Disassemble
  - ◆ When removing the control box, user should turn off the power and pull off the power plug.
  - ◆ At pulling off the power plug, user should hold the plug and remove it, instead of pulling the power cable only.
  - ◆ The control box contains the dangerous high voltage power. For opening the control box, please turn off the power and take away the plug from socket firstly, and then wait for at least 5 minutes before opening the control box.

### ● Maintenance, Inspection and Repair

- Only can the trained technicians perform the repair and maintenance of this machine.
- When replacing the needles and shuttles, user has to turn off the power.
- Please use the spare parts from the authorized manufacturers

### ● Others

- Do not touch the rotating or moving part of the machine, especially the needle and belt, when the machine is working. User should also keep his/her hair away from those moving parts, so as to avoid the danger.
- Do not drop the control device on the floor, nor insert ant stuff into the slot on the control box.
- Do not run the machine without the cover shells



- If this control device is damaged or unable to work normally, please ask the technicians to adjust or repair it. Do not run the machine when the problem is not solved
- Please do not change or modify the control device without authorization

## ● Abandonment






- Dispose it as common industrial trash.

## ● Warning and Danger

- The mistake operation may cause danger. For the serious level, please refer to the figure at below


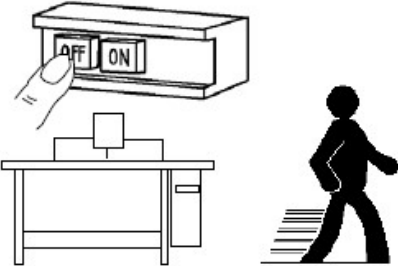
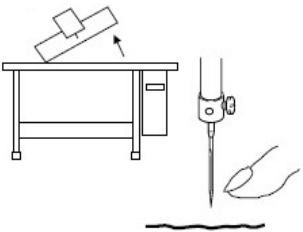
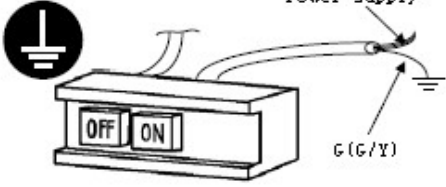
 <b>Warning</b>	The wrong operation may cause serious injury or death
 <b>Caution</b>	The wrong operation may cause personal injury or loss of property

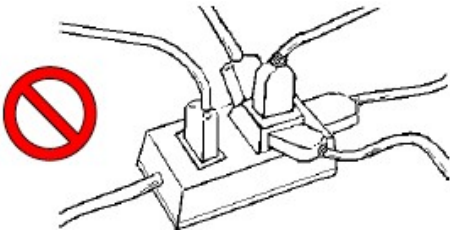
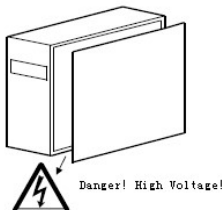
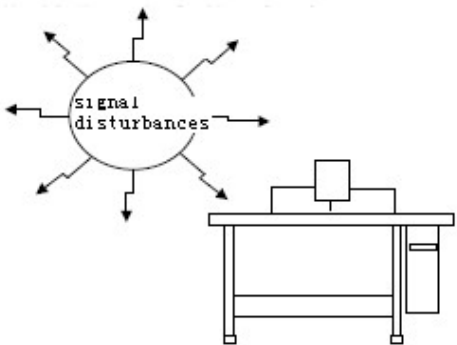
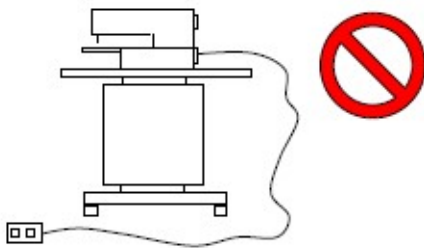
- The meaning of the figure are shown at below:

	Please operate machine according to instruction		Caution: High Voltage
	Caution: High Temperature		Grounding is a must
	Never do this.		

## 1.3 The Preventions on Usage

### Warning

<p>1、 When you press [ON], leave the feet from pedal.</p> 	<p>2、 When you leave the machine, please turn it off.</p> 
<p>3、 If user needs tilt the head or replace the needle or thread the Needle thread, please turn off the power</p> 	<p>4、 Ground the machine with ground cable</p> 

<p>5、 Do not use the household terminal block to let machines to share one power supply</p> 	<p>6、 For opening the control box, please turn off the power and take away the plug from socket firstly, and then wait for at least 5 minutes before opening the control box</p> 
<p>8、 Please keep it away from the machine creating the high cyclic disturbance</p> 	<p>9、 If user needs the external signal socket to connect the attachments, the connecting wire shall be as short as possible. The long cable may cause the wrong operation. And the connection cable shall be the isolated cable</p> 
<p>10、 If the fuse is burnt, please solve the problem before replacing a new one with same capacity</p> <p>11、 After the system is shut down, you need to wait for about 2s to turn on again, not to turn it on and off in a short time, or by observing the indicator light on the panel, that is, when the indicator light on the operating head is completely off, it can be turned on.</p>	

## 1.4 Input Mode

Use keys to input.

## 1.5 Display Method

Use black and white lattice LCD and LED to display all the information.

## 1.6 Panel Layout

The quadrate Panel can be divided into two parts, the display part and the operation part. The display part consists of 1 lattice LCD and 2 LED and the operation part consists of 17 keys. Refer to the picture of the panel.

## 1.7 Standardization

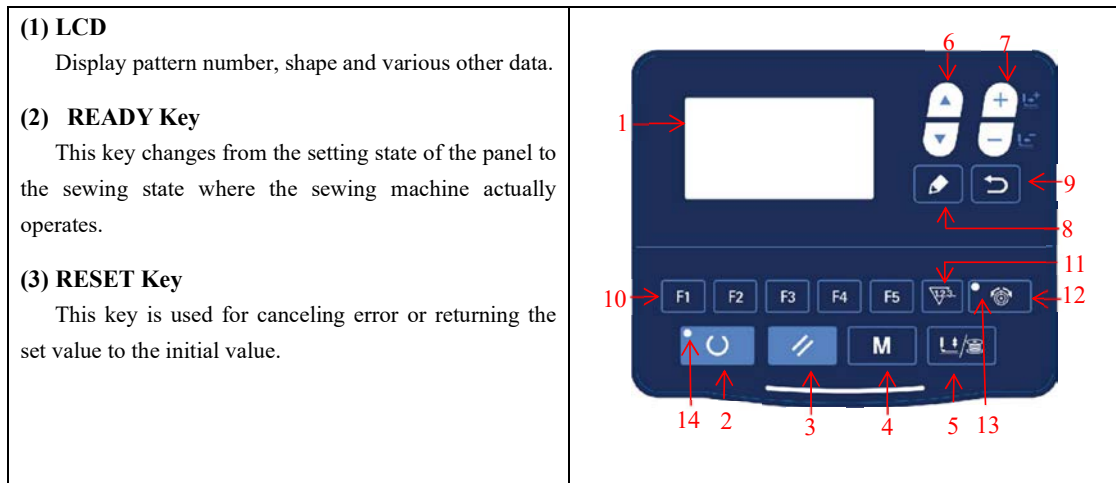
The function keys use standard images recognizable and popular within the industry. Image is an international language that can be understood by any nation.

## 1.8 Operation Mode

Function keys include prepare key, reset key, mode key, thread/winding key, select key, add and subtract key, edit key, return key, and line length force key. For specific operation methods, please refer to Section 2 "Operation Instructions".

## 2 Operation and Debugging

### 2.1 Instructions of Operation Panel



**(4) MODE Key**

This key initiates the setting of parameters or stored patterns.

**(5) PRESSER FOOT/WINDING Key**

This key is used to lift or lower the presser foot. When presser foot is up, move the needle bar back to origin; when the presser foot is down, moving the needle bar to the right. Press this key when winding.

**(6) SELECTION Key**

This key is used to select among various pattern types, menu items or parameters.

**(7) DATA SETTING Key**

This key is used to modify the pattern number or parameter value. Under trial sewing mode, this key is used to move single needle and feed cloth.

**(8) EDIT Key**

This key is used to display editing interface, select item or display detailed information.

**(9) RETURN Key**

This key is used to return to the previous interface.

**(10) DIRECT PATTERN (P Pattern)**

Register P patterns. After registration, press the key to make immediate selection for sewing.

**(11) COUNTER Key**

Under sewing editing mode (unready for sewing), press it to enter counter setting mode.

**(12) LINE LENGTH FORCE Key**

Set the line tension.

**(13) LINE LENGTH FORCE LED**

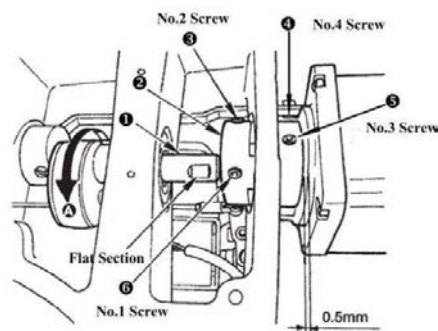
The LED lights up after entering the line tension function.

**(14) SEWING LED**

Under sewing mode, LED lights up.

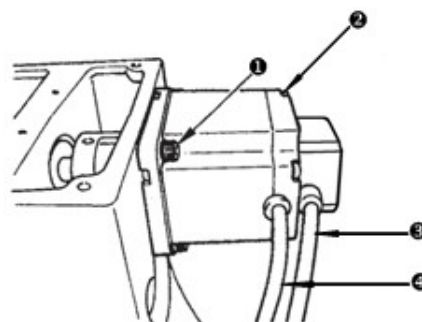
## 2.2 Installing the Main Shaft Motor

Assemble the main motor to the main shaft ❶ through the coupling ❷. And you need 4 screws to fix the coupling to the upper shaft and the main shaft. Fix the coupling with No.1 Screw ❸ and make sure that it is vertical towards the Flat Section, and then screw No.2 screw ❹. Fix the coupling to the main shaft motor with No.3 screw ❺, and make sure it is vertical to the flat section of the main shaft motor. Then screw the No.4 screw ❻ to finish the assembling task. The right diagram shows you the details:






This right diagram shows you the directions of external cables of the main shaft motor (look from back, and the line is on your left-hand side):

❶ Screws for fixing the main shaft motor, totally 4; ❷ Screws for fixing the back cover of the motor, totally 4; ❸ main shaft motor encoder signal cable; ❹ power line for the main shaft motor.





## 2.3 Text Mode

This mode is activated to conduct maintenance operation.



1) When the sewing LED is off, hold pressing  key for 3 seconds, and you would hear the ring of the buzzer. Then select item “11 system test” by pressing  key and press  key to enter test mode.





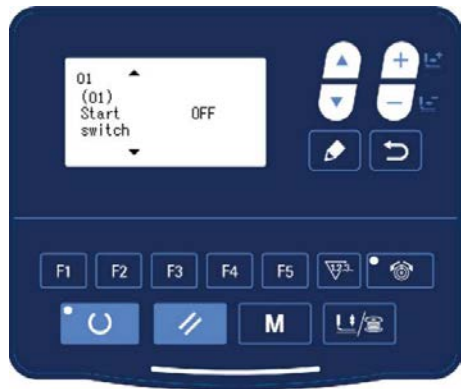
2) Press  key to change the function item for test and press  key to enter the item for test. The functions represented by each number are as follows:

Function Test Item	Function	Description
01 System Input Test	Input signal test	LED light as the indicator to show the status of sensor input
02 X Y Origin Adjustment	XY motor/origin sensor test	Display inching operation, origin searching operation and the status of X/Y origin sensor of X/Y motor
03 Aging Mode	Continuous running	Change to continuous running mode after setting the conditions of continuous running
04 Main Shaft Test	Main motor rotation number test	Set up the rotation number, start machine and display the actual

		rotation number.
06 Presser Foot Motor Test	Presser foot, thread-trimming motor/origin sensor test	Display inching operation of presser foot and thread-trimming motor, origin searching operation and the status of presser foot origin/presser foot sensor.
08 System Output Test	Output signal test	Drive the movement of output solenoid/air valve.
09 Panel Test	LED and LCD test	Test the status of panel display and LED light.
11 Main motor origin adjustment	Corrects the spindle origin position	The origin position of the spindle motor can be corrected according to the mechanical assembly error







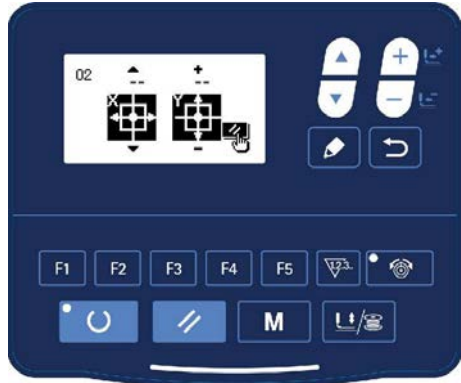
- 3) During the function test, if user presses  key or  key, the test will be terminated and the system will return to the status of step 2); however, if the aging mode has been used once, the aging mode can't be released unless the power supply is shut off.







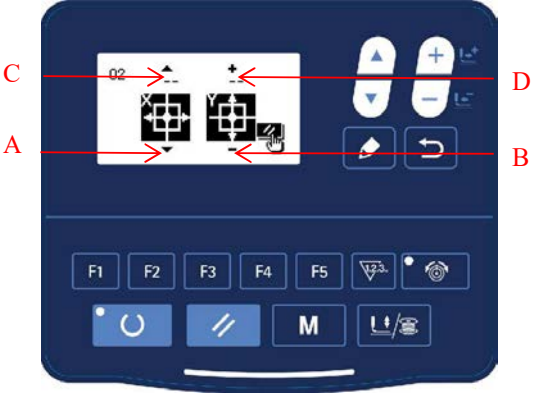
### 2.3.1 01 System Input Test

<p>1) This function is used to test the input status of panel keys, pedal switch and various sensors. Select “01 System Input Test” and press  key to enter.</p> <p>2) Under this mode, press  key to change test item and the status of the test signal is displayed at the right side of the screen.</p>	
--	---


### 2.3.2 02 XY Origin Adjustment



This function is to display the inching operation, origin searching operation and the status of X/Y origin sensor of X/Y motor.

<p>1) XY Motor Single Step Running Test</p> <p>If after machine start, user has never pressed  key to enter ready status but rather directly pressed  key to enter system test mode, enter “02 XY Origin Adjustment” and then user can directly press  key and  key to move XY motors step by step respectively. If user has ever pressed  key to enter ready status after machine start, every time user enters “02 XY Origin Adjustment” mode, user need press  key to search XY origin before moving motor step by step. Under this situation, this item indicates XY motor origin adjustment function.</p>	
--	--


<p>During moving XY motors, if the signal of the origin sensor changes, the icon displayed on the screen will become shadowed.</p>	
<p>2) XY Motor Origin Adjustment</p> <p>First press  key to conduct XY origin search. On the screen will be displayed the origin sensor status A of X motor and the current adjustment value C, as well as the origin sensor status B of Y motor and the current adjustment value D.</p> <p>Press the  key and  key to move X/Y motors respectively step by step and the adjustment value will change simultaneously. Observe the center of the presser foot and the position of needle hole. When they overlap, press  key to save the adjustment value and return. If user doesn't want to save the adjustment value, press  key or  key to give up the saving.</p>	

### 2.3.3 03 Aging Mode

After selecting “03 aging mode”, press  key to enter continuous running mode. After setting its conditions, activate the continuous running mode; turn off the power to release the continuous running mode.


<p>1) Interval Time Setting</p> <p>When the screen displays “(01) aging interval”, press  key to set the interval time between two operations.</p> <p>The setting range: 0~9900ms (by an increment of 100ms); default value: 2000ms.</p>	
---	--

#### 2) Origin Search at Sewing End

Press  key to shift to “(02) origin search” to set the origin search at sewing end.


OFF: invalid (default)

ON: valid (origin search at each sewing end)

After setting, press  key to save and enter the main interface of normal sewing mode.


#### 3) Continuous Operation

Under sewing mode of normal patterns, user can set pattern No., X/Y scale rate, max. rotation speed and other

will conduct the origin search of X/Y presser foot and thread-catching/trimming motors. After the set interval time, the system will automatically start sewing again. If user need stop continuous sewing, press  key at sewing end to pause and turn off the power to terminate the continuous sewing.








### 2.3.4 04 Main Shaft Detection

Set the rotation speed of the machine, and then drive the main motor of the machine to display the actual rotation speed under the set rotation speed.

- 1) Preparation  
Select “04 main shaft detection” and then press  key to enter. Each motor will automatically execute origin research. The screen will display the “target rotation speed”, “actual rotation speed” and “main shaft angle” of the main shaft motor.




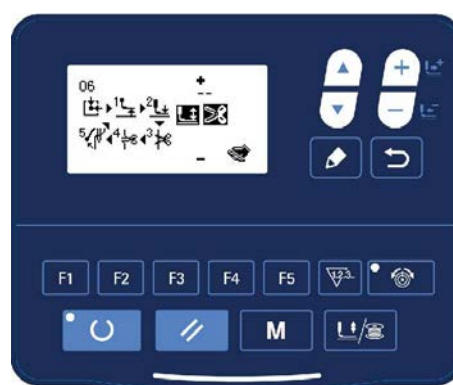
- 2) Operation


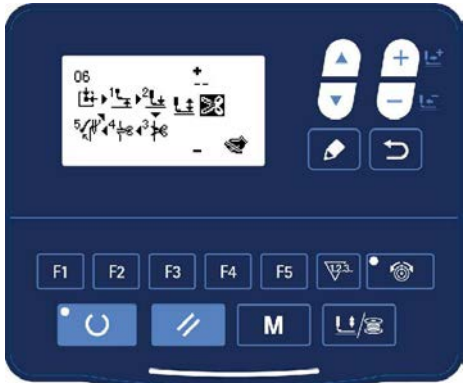





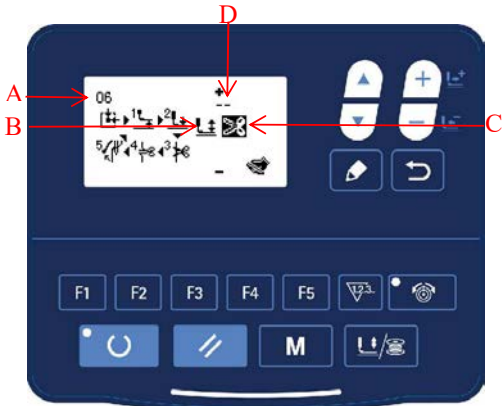
Press  key to change the target rotation speed of the main shaft, and then press  key to operate the machine at the set rotation speed. If the set rotation speed needs to be changed again, user can continue pressing  key during the operation to set the rotation speed and then press  key again to operate the machine at the new set rotation speed. Press  key to stop the machine. After machine stops, press  key or  key to quit.

### 2.3.5 06 Presser Foot Motor Detection



This function can be used to display the inching operation, origin search operation of the presser foot/thread-trimming motors and the status of presser foot origin sensor and thread-trimming sensor.

- 1) Presser Foot Motor Running Test  
The operation is similar to [2.3.2 02 XY Origin Adjustment]. If the machine hasn't entered sewing ready status after power on, user can just enter “06 presser foot motor test” and press  key to execute single step movement test of presser foot motor. At that time, the screen will display the signal status of the two sensors at the presser foot origin position and cutter position. Once origin search is made, user need step pedal to level 2 to execute origin search before moving the motor.





<p>2) Simulation Operation Test of Presser Foot Motor</p> <p>Under this mode, step pedal to level 2 to execute origin search, and then press  key to make simulation operation of the motor at various work operation such as lifting up or lowering down.</p>	
<p>3) Presser Foot Motor Origin Adjustment</p> <p>Under this mode, stepping the pedal to level 2 to execute the origin search. Without pressing  key, the motor will remain at the origin position A.</p> <p>Press  key to change the origin adjustment value D, and at the same time presser foot origin sensor signal B and cutter position sensor signal D will change correspondingly. After setting the value, press  key to save and return. User can also press  key or  key to quit saving and return.</p>	




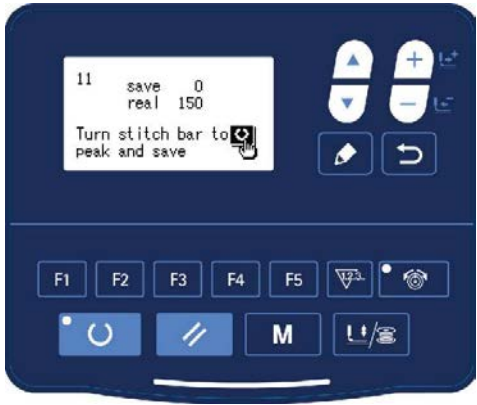
### 2.3.6 08 System Output Test

Under this mode, press  key to shift and select the device to be tested, and press  key to drive that device.

### 2.3.7 09 Panel Test




Under this test, press  key to light up all LED lights on the panel and the full screen of LCD, and press  key to return to normal display status.

### 2.3.8 11 Main motor origin adjustment


<p>System Check</p> <p>When "11 Main motor org adj" is selected, Press the  Edit key  Enter the mode, Spindle origin correction can be performed, after turning the needle bar to the highest point, Press the Prepare key  to save back to the previous screen.</p>	
---	--

## 2.4 Basic Operations




### 2.4.1 Pattern Number Setting






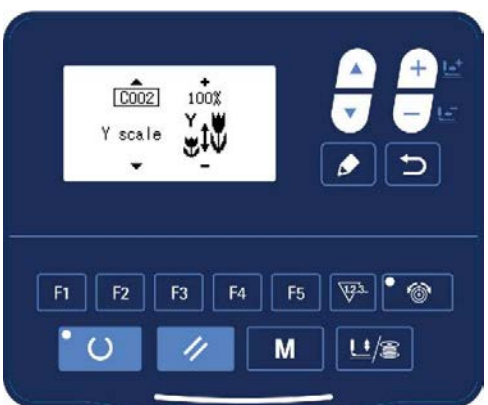


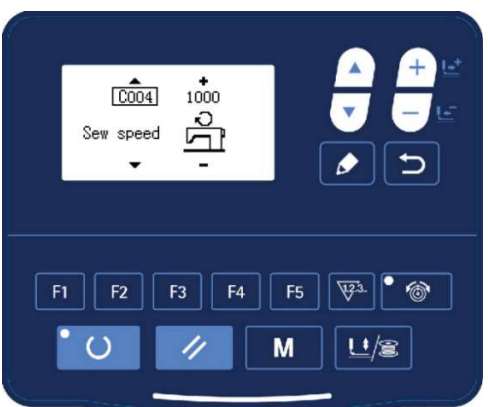




<p>Open power switch.</p> <p>On the left upper side of the screen will be displayed the pattern No., as well as pattern shape, X/Y scale rate, thread tension and sewing speed.</p> <p>Press  key to change pattern No. and press  key to shift pattern mode, that is, memory pattern, P pattern and C cyclic pattern.</p>	
--	---

### 2.4.2 Item Data Setting

Press  key and the item data input interface will be displayed.

On the left side is the item to be edited and on the right side is the content of setting.

Press  key to select item, press  key to change the content and press  to save and return.


<p><b>(1) X Size Input</b></p> <p>Press  to display C001 X size.</p> <p>Press  key to display the intended value.</p> <p>X/Y size can be inputted by % or by actual size (set by parameter U063) and the default setting is % input.</p> <p><b>Note: if the set value is beyond the sewing range allowed by the presser foot, the needle may collide with the presser foot and thus cause needle breakage which is very dangerous.</b></p>	
<p><b>(2) Y Size Input</b></p> <p>Press  to display C002 Y size.</p> <p>Press  key to display the intended value.</p> <p>X/Y size can be inputted by % or by actual size (set by parameter U063) and the default setting is % input.</p> <p><b>Note: if the set value is beyond the sewing range allowed by the presser foot, the needle may collide with the presser foot and thus cause needle breakage which is very dangerous.</b></p>	
<p><b>(3) Sewing Speed Input</b></p> <p>Press  key to display C004 sewing speed.</p> <p>Press  key to display the intended value.</p> <p>The inputted value is limited by the max. Sewing speed set by parameter U001.</p>	
<p><b>(4) Line length force Setting</b></p> <p>Press  key to display C003 thread tension.</p> <p>Press  key to display the intended value. (input range: 0~200)</p> <p>Press  to confirm and return to the input interface.</p>	


## (5) Setting Completion

Press  key.


Presser foot moves and lifts and sewing LED lights up to enter sewing status.

**Note: press READY key and the presser foot will return to the sewing start. The presser foot will lower down before moving. Therefore, please watch your fingers.**

\* Press  key to save the set value of pattern No., XY scale rate, etc.

\* Press  key again, and sewing LED will be off. At that time, user can change the setting of each item.

\* Please confirm the pattern No. first. Otherwise, press  key will initiate error M-306. At that time, user need reset the pattern No.




**Note: if user turns off power before pressing  key, the set value of pattern No., XY scale rate, max rotation speed and thread tension will not be saved.**

### 2.4.3 Pattern Shape Confirmation




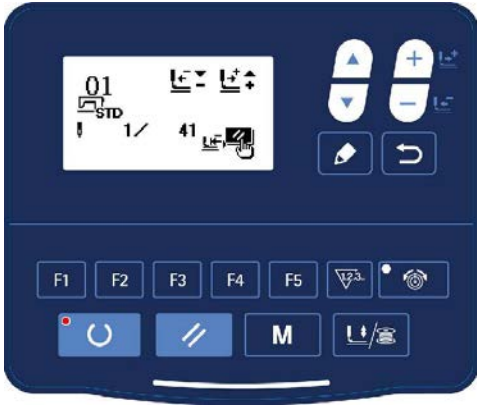
**Warning!**

1. After selecting the pattern, user must confirm the pattern shape. If the pattern shape is away from the presser foot, the needle may collide with the presser foot and break.

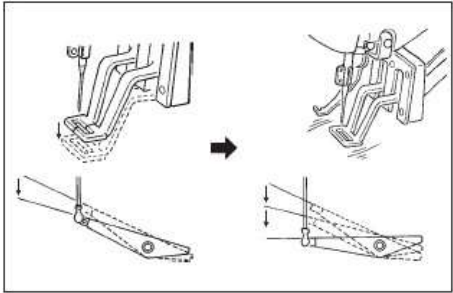
2. When confirming the pattern shape, please note that if user press +/- keys when the needle bar is down, the needle bar will lift automatically before the presser foot moves.

- 1) Press  key and sewing LED will light up.
- 2) Press  key to display “presser foot lowering interface”.
- 3) Press  key to display the shape confirmation interface.  
Under this mode, to step the pedal will not start sewing.




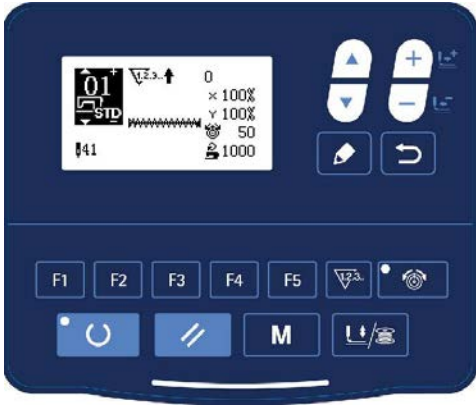


<p>4) Press  key to confirm the pattern is within the range of presser foot.</p> <p>5) Press  key to return to sewing start position and lift the presser foot.</p> <p>Press  key to display the sewing interface at the present position.</p> <p>At that time, to step the pedal will start sewing from the present position.</p>	
---	--









## 2.4.4 Sewing

<p><b>Sewing:</b></p> <ol style="list-style-type: none"> <li>1. Put sewing material under presser foot.</li> <li>2. Step pedal to level 1 to lower the presser foot and release the pedal to lift the presser foot.</li> <li>3. Step pedal to level 2 to start sewing.</li> <li>4. At sewing end, presser foot will lift and return to sewing start.</li> </ol>	
---	---

## 2.4.5 Change to Other Pattern





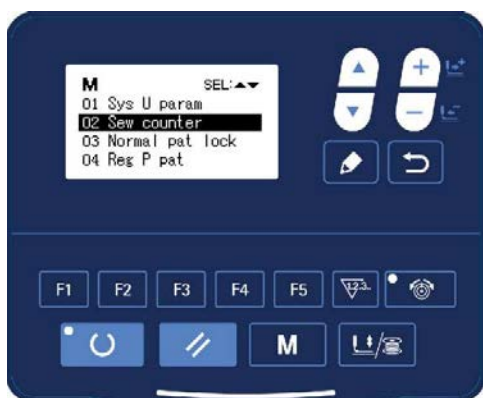
<p>Press  key and sewing LED is off.</p> <p>Press  key to set pattern No.</p> <p>XY scale rate, speed, etc. can be set in the same way as [2.4.1 item data setting].</p> <p>Press  key and sewing LED lights up to enter sewing status.</p> <p>Please confirm the pattern shape after pattern selection, in case the pattern is away from presser foot and needle will collide with presser foot and break during sewing.</p>	
--	--





## 2.4.6 Bobbin Thread Winding

<ol style="list-style-type: none"> <li>1) Press  key and sewing LED is off.</li> <li>2) Press  key to lower the presser foot.</li> <li>3) Press  key to display winding interface.</li> <li>4) Step the pedal to run the sewing machine.</li> </ol>	
<ol style="list-style-type: none"> <li>5) Step the pedal again or press  key to stop the sewing machine.</li> <li>6) Press  key and  key to finish the winding interface.</li> </ol>	



## 2.4.7 Sewing with Counter

### (6) Counter Setting Method




<ol style="list-style-type: none"> <li>1) Enter counter setting interface Under input mode, when sewing LED is off, press  key to display the mode interface. Press  key to select “02 counter setting”. Press  key to display counter interface A. Or, under input mode, when sewing LED is off, press  key to directly enter counter interface</li> </ol>	
---	--

<p>A.</p> <p>When counter interface A is displayed, counter can be set under input mode. If the system is under sewing mode, press  key to turn off the sewing LED.</p> <p>2) Select counter type</p> <p>Press  key to shadow the counter type icon</p> <p>B. Press  key to select the proper counter type.</p>	
--	--

### 3) Change counter value

Press  key to shadow the counter value C. Press  key to input the set value.

### 4) Change the present counter value

Press  key to shadow present counter value D. Press  key to clear the present counter value and press  key to edit the present value.

## (7) Counter Type

### B01 Sewing Plus Counter

The present value will add 1 after sewing 1 shape.

Present value and set value.

### B02 Sewing Minus Counter

The present value will deduce 1 after sewing 1 shape.

When present value reaches 0, minus counter interface will be displayed.

### B03 Piece Number Plus Counter

Calculate present value of 1 cyclic sewing by adding number. When present value equals with set value, counter interface will be displayed.

### B04 Piece Number Minus Counter

Calculate present value of 1 cyclic sewing by deducing number. When present value reaches 0, counter interface will be displayed.

### B05 Bobbin Thread Plus Counter



Add to the present value after every 10 stitches. When present value equals set value, counter interface will be displayed.

### B06 Bobbin Thread Minus Counter

Deduce the present value after every 10 stitches. When present value reaches 0, counter interface will be displayed.

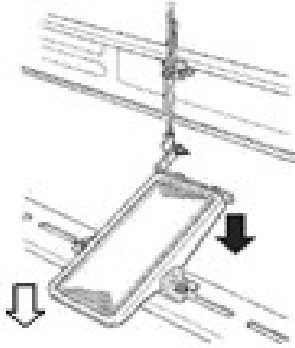
### B07 Counter Nonuse

## (8) Counter Release




<p>When the counter value is exhausted, counter interface will be displayed. Press  key to reset the counter and then the counter will start counting again.</p>	
---	--

### 2.4.8 Pause

Pedal has three levels: level 1 to lower the presser foot, level 2 to start sewing and level 3 (to step backward with heel) for emergency stop.



<ol style="list-style-type: none"> <li>1) Press the READY key and then step forward ↓ the pedal to lower the presser foot;</li> <li>2) Step forward ↓ the pedal again to start sewing;</li> <li>3) During sewing, user can step backward ↰ the pedal to stop the machine emergently and the panel will display “E-002”.</li> </ol>	
--	---



## (9) Emergency Stop by Panel

<ol style="list-style-type: none"> <li>1) Use parameter U031 to set the RESET key as 1 and the RESET key will be changed into pause key to stop the machine during sewing.</li> <li>2) Press  to stop the machine and “E-002” will be displayed. Press  key again to release the error and the interface to feed cloth forward/backward will be displayed.</li> </ol>	
---	--

3) Then, 3 operations are available:

1. Use starting switch to start sewing.

2. Press  key to trim thread and use  key to adjust position. Then use starting switch to start sewing.




3. Press  key to trim the thread and press  key again to return to origin.

4. After pressing RESET key to trim thread, user can step the pedal again to continue sewing.

## 2.5 P Pattern and C Pattern Setting

### 2.5.1 Use Pattern Key to Sew




User can register patterns (No.1~200) to P1~P99. Patterns can be registered after changing scale rate, max rotation speed, thread tension and sewing position. User can also use pattern No. rolling window to register pattern. P1~P25 can be displayed at the same time.

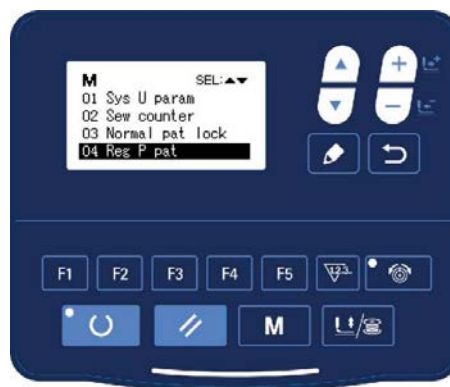
\* When selecting P6~P25, user can use the combination of      keys (press simultaneously) to sew.





P-No.	Selection Key	P-No.	Selection Key	P-No.	Selection Key	P-No.	Selection Key
P1	P1	P8	P1+P4	P15	P4 +P5	P22	P2+P3+P4
P2	P2	P9	P1+P5	P16	P1+P2+P3	P23	P2+P3+P5
P3	P3	P10	P2+P3	P17	P1+P2+P4	P24	P2+P4+P5
P4	P4	P11	P2+P4	P18	P1+P2+P5	P25	P3+P4+P5
P5	P5	P12	P2+P5	P19	P1+P3+P4		
P6	P1+P2	P13	P3+P4	P20	P1+P3+P5		
P7	P1+P3	P14	P3+P5	P21	P1+P4+P5		

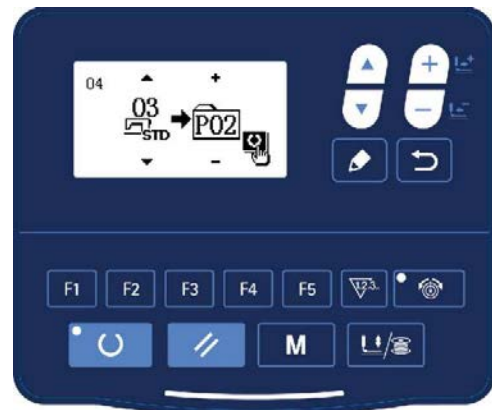
#### (1) Register to Pattern Key










Example: register pattern No.3 to P2, with X scale rate as 50%, max speed of 2000sti/min, thread tension as 50 and pattern position as 0.5mm to the right and 1mm forward.

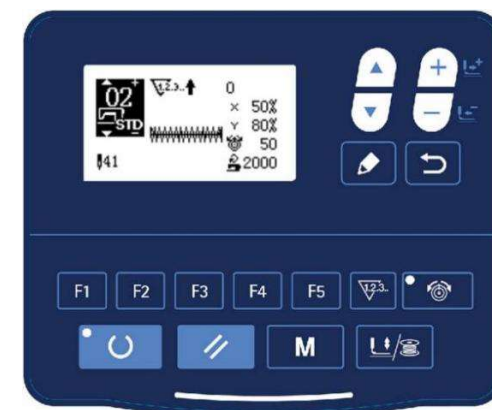
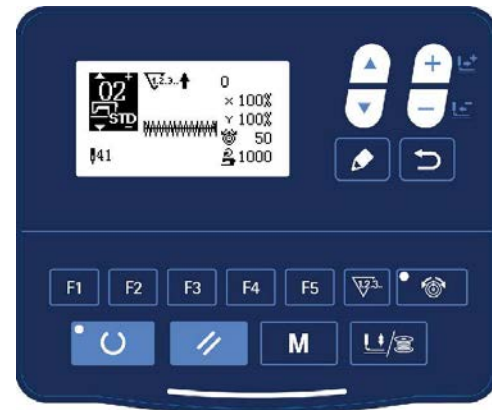
- 1) Turn on the power and then press  key. (Sewing LED is off.) Enter mode setting (memory switch setting). Press  key to select “04 register P pattern” and press  key to enter pattern register mode.



- 2) Press  key to set the standard pattern as No.3.
- Press  to set P-No. as 2. Press READY key to register P2 and the mode interface will be displayed.
- Then press  key or  key.



- 3) Press  key and then press  key to edit item data.
- 4) Set separately the X scale rate as 50%, Y scale rate as 80%, sewing speed as 2000 sti/min and thread tension as 50.
- 5) Press  key and X scale rate will be displayed as 0.0. the increment of X direction movement can be set as 0.1mm. Press  key to change the data into 0.5.
- 6) Press  key and X scale rate will be displayed as 0.0. The increment of X direction movement can be set as 0.1mm. Press  key to change the data into 1.0.
- 7) Press  key to complete setting.
- 8) Press  key to complete pattern registering method.
- 9) Press  key to complete setting and return to normal mode.






## 2.5.2 Group Sewing (Cyclic Sewing)


This machine can be used to sew several patterns in order cyclically.

Up to 99 patterns can be inputted. In addition, 99 data of group sewing can be registered. If necessary, please make a copy for future use.




### (1) Cyclic Data Selection

<p>1) Set as input mode Under input mode, when sewing LED is off, select cyclic sewing data. If the system is under sewing mode, press  key to change into input mode. The cyclic sewing data can only be selected under data mode.</p> <p>2) Select cyclic sewing data Press  key to shift among the registered cyclic sewing data No. and continuous sewing data No. At this time, user can select the intended cyclic sewing No.</p>	
---	--


### 3) Conduct sewing



After selecting the continuous sewing data, press  key and sewing LED lights up, ready for sewing. Only cyclic data No.1 is registered without sewing patterns and therefore cannot be used for sewing. Please follow the following editing method to input patterns.

### (2) Cyclic Sewing Data Editing Method


<p>1) Set as input mode Under input mode, when sewing LED is off, user can input continuous sewing data. If the machine is under sewing mode, press  key to change into input mode.</p> <p>2) Set cyclic sewing data as editing status Press  key to enter editing status and the selected pattern No. for editing will become shadowed. At that time, data can be edited.</p>	
--	--


### 3) Select editing content

Press  key to change the editing content and when user move to the last pattern, they can add patterns.


After selecting the editing content, press  key to display the icon  which means pattern data can be inserted.

4) Change data of editing content




Press  key to change data of the editing content.  
The registered pattern No. will be displayed for editing.

Press  key to delete the pattern data. User can repeat steps 3 and 4 to edit data.

5) Cancel pattern data input

Press  key to cancel pattern data input and return to input mode.

### (3) Sewing Operation




- 1) Turn on the power.
- 2) Press  key to select cyclic pattern and press  key to select the pattern No.
- 3) Press  key and sewing LED lights up. Presser foot will move and then lift.







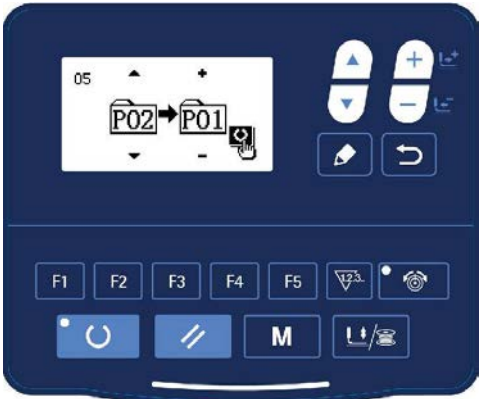




## 2.6 Copy/Delete P Pattern and C Pattern

Registered P patterns can be copied into new P patterns, so are C patterns. Existing P patterns or C patterns can also be deleted (the last C pattern cannot be deleted).







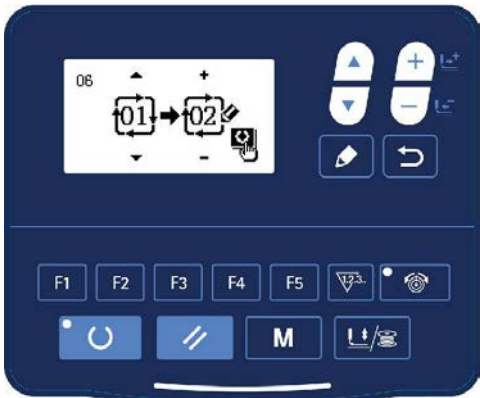
### 2.6.1 Copy/Delete P Pattern

- 1) When sewing LED is off, press  key to enter system menu, press  key to select "05 copy/delete P pattern" and then press  key to enter this mode.










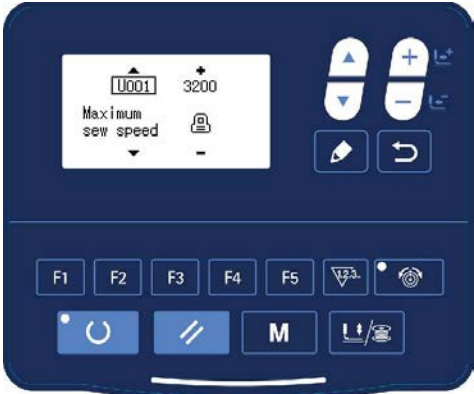


<p>2) Press  key to shift to the P pattern number (existing) to be copied, and press  to shift to a new P pattern number (new). After confirmation, press  key to save and return. Press  key to quit saving and return.</p>	
<p>3) When pressing  to shift to new P pattern number, user can select icon , and if user press  at that time, the existing P pattern will be deleted.</p>	

## 2.6.2 Copy/Delete C Pattern

<p>1) Under the system menu, press  key to select “06 copy/delete C pattern” and press  key to enter this mode.</p> <p>2) Similar to the operation to copy/delete P pattern, press  key to shift new C pattern number to execute copying operation or press  key to delete C pattern.</p> <p>When press  key to shift to the icon , it means to register a new empty C pattern.</p>	
---	--

## 2.7 Memory Switch Activation and Change

<p>1) Set input mode When sewing LED is off, memory switch data can be changed. Under sewing mode, press  key to shift to input mode.</p> <p>2) Enter data editing interface Press  key to display the mode interface (operator level). Press  key to select “01 U parameter” and press  key to enter memory switch data interface.</p>	
<p>3) Select data to be changed Press  key to select the data item to be changed.</p> <p>4) Change data Press  key to increase or decrease the set value.</p> <p>5) Save and quit After completing data change, press  key to save and quit, and return to mode interface. Press  key again to return to sewing interface.</p>	

### 2.7.1 User Parameter Setting List

No.	Function	Adjustment Rang	Default Value	Remarks
U001	Maximum sew speed	400~3200	3200	
U002	1st stitch sew speed with clamp	400~1500	1500	
U003	2nd stitch sew speed with clamp	400~3200	3200	
U004	3rd stitch sew speed with clamp	400~3200	3200	
U005	4th stitch sew speed with clamp	400~3200	3200	
U006	5th stitch sew speed with clamp	400~3200	3200	
U007	1st stitch tension with clamp	0~200	200	
U008	Trimming tension	0~200	0	

U009	Trimming tension angle adj	-6~4	0	
U010	1st stitch sew speed	400~1500	400	
U011	2nd stitch sew speed	400~3200	900	
U012	3rd stitch sew speed	400~3200	3200	
U013	4th stitch sew speed	400~3200	3200	
U014	5th stitch sew speed	400~3200	3200	
U015	1st stitch tension	0~200	0	
U016	Sew Start tension angle adj	-5~2	0	
U025	2-step presser	0: Divided 1: Not divided	1	
U026	Height of 2-step presser	50~90	70	
U031	Pause enable when sew	0: Invalid 1: Operation disk reset button 2: External emergency stop switch	0	
U032	Buzzer disable	0: no voice 1: panel operation voice 2: panel operation voice and alarm voice	2	
U033	Clamp loosen stitch	1~7 stitches	2	
U034	Clamp angle adjust	-20~0	0	
U035	Clamp disable	0: Normal 1: Forbidden	1	
U036	XY feed move angle adjust	-8~16	12	
U037	Sew finish presser state	0: Back to sewing start and then lift 1: Back to sewing start and at the same time lift 2: lift the presser foot manually by stepping the pedal	1	
U038	Presser lift disable	0: Normal 1: Forbidden to lift presser foot	0	
U039	Sew finish origin search	0: Normal 1: It is forbidden to	0	


		lift and press the foot		
U040	C Pat sew finish org search	0: Not Search origin 1: Search origin after the finish of each pattern	0	
U041	P Pat sew finish org search	0: Not search origin 1: Search Origin	0	
U042	Needle bar stop position	0: upper position 1: highest position	0	
U046	Trimming thread disable	0: normal 1: forbid thread-trimming	0	
U049	Coiling speed	800~2000	1600	
U063	XY scale setting mode	0: by percentage 1: by size	0	
U135	Presser wait position	0: stand-by at the sewing start 1: stand-by at the origin	0	
U200	Select language	Set language	Chinese	
U212	Pneumatic presser down order	0: lower at the same time 1: lower left presser first and then right presser 2: lower right presser first and then left presser	0	
U213	Pneumatic presser lift order	0: lift at the same time 1: lift left presser foot first and then right presser foot 2: lift right presser foot first and then left presser foot	0	
U214	Clamp inversion enable	0: forbidden 1: available	1	
U220	Auto oil stitch	0~9999	0	Unit: x100 pins 0 indicates that the function is off
U221	Auto oil time	1~120	20	Unit: mS

U245	Clear oil counter	Press the Reset key to clear	Displays the cumulative number of machine running pins	
------	-------------------	---------------------------------	--	--

## 3 Service Parameter Setting

Service parameters are different from normal parameters and usually are not allowed to change by users. These parameters are for technicians to debug the machine.

### 3.1 Service Parameter Activation and Change

When sewing LED is off, hold pressing  key for 3 seconds until the buzzer rings so as to activate and change the service parameter.

The operation of service parameter change is the same with that of normal parameter, please refer to [2.7 memory switch activation and change].

### 3.2 Service Parameter List

No.	Function	Adjustment Range	Default Value	Remarks
K001	Pedal type	0: Analog Single Pedal 1: Digital Single Pedal 2: Double Pedals 3: Double Pedals, but only the operation pedal controls	0	
K002	Inter presser setting	0: no control 1: not used 2: solenoid control 3: mechanical control	0	
K019	Pneumatic presser lift delay	0~90	30	
K021	Pedal presser position	50~200	70	
K023	Pedal start sew position	50~200	185	
K027	Presser down speed when pedal	100~4000pps	4000	
K028	Presser lift speed when pedal	100~4000pps	1500	
K029	Presser lift speed sew finish	100~4000pps	3000	
K036	Sew end 4th sew speed	400~3200	3200	
K037	Sew end 3h sew speed	400~3200	3200	
K038	Sew end 2nd sew speed	400~3200	3200	
K039	Sew end 1st sew speed	400~2500	2500	
K043	Trimming thread speed	300~800	800	
K044	XY feed when trimming	0: No cloth feed 1: There is a cloth delivery	0	
K045	XY feed distance when trim	16~40 (1.6mm~4.0mm)	16	
K046	Main motor start faster	0~1	1	
K056	+X feed sew range limit	0~50mm	20	
K057	-X feed sew range limit	0~50mm	20	
K058	+Y feed sew range limit	0~30mm	15	
K059	-Y feed sew range limit	0~30mm	15	

K064	Wiper setting	0: solenoid 1: motor	1	
K066	Presser-wiper pulse	30~60	45	
K074	Presser mode setting	0: air valve control 1: motor control	1	
K095	Trimming thread angle	-10~10	0	
K097	Trimming thread when pause	0: automatic thread-trimming 1: manual thread-trimming	1	
K102	X motor full current	0~15	8	Effective after restart
K104	Y motor full current	0~15	9	Effective after restart
K106	Clamp motor full current	0~15	7	Effective after restart
K108	Presser motor full current	0~15	9	Effective after restart
K109	X motor half current	0~15	7	Effective after restart
K110	Y motor half current	0~15	6	Effective after restart
K111	Presser motor half current	0~15	5	Effective after restart
K112	Main motor stop angle adjust	-10~10	0	
K120	Add oil warning stitches	3000~12000	4000	Unit: ten thousand stitches
K121	Sewing counter lock	0: Clear and Plus/Minus; 1: Clear Only; 2: Plus/Minus Only; 3: Neither Clear nor Plus/Minus	0	
K122	OC length adjust	-128~128	0	
K123	OD length adjust	-128~128	0	
K124	BD length adjust	-512~512	0	
K125	OC length setting	1780~2380	2080	
K126	OD length setting	1440~2040	1740	
K127	BD length setting	430~630	530	
K128	Step motor driver type	0: DSP1 Close DSP2 Close 1: DSP1 Open DSP2 Open 2: DSP1 Close DSP2 Open 3: DSP1 Open DSP2 Open	0	Effective after restart
K129	Stepper driver mode	0~15	12	A new power-up is required to take effect
K130	XY feed sync mode	0: OFF 1: ON	1	
K135	Trimming device delay	-10~30	0	
K136	XY feed start angle limit	-10~30	0	
K137	Sew start clamp angle adj	-150~150	0	

K138	Trimming clamp delay	-2~1	0	-2 means thread holding action prohibited after thread-trimming at sewing start
K139	Needle cooling	-1: OFF 0~30: ON	0	The on value indicates the delayed shutdown time in 100mS
K140	Tension mode setting	0: electronic 1: mechanical	0	
K141	Loosen tension on power	-20~20	0	
K142	Loosen tension hold power	-40~40	0	
K144	Tension adjust	-100~100	0	
K150	Safe switch disable	0: Normal 1: The safety status of tilt head is invalid.	0	
K151	Cloth thickness detection enable	0: OFF 1: ON	0	
K152	Cloth thickness adjust	-100~100	0	
K160	Disable pedal pause	0~1	0	0:Allowed 1:Prohibited
K161	Cut cloth settings	0: When pedaling in first gear 1: When pedaling in second gear	0	For Automatic Suction Shearing Models (1900GMC)
K162	Inhale time after cut	0~30	0	For automatic suction shearing machine (1900GMC), unit: 100mS
K163	Delay before feed	0~30	0	For automatic suction shearing machine (1900GMC), unit: 100mS
K169	Jump speed	0~10	10	1: Pedal 1 medium press foot lift"
K170	Internal presser delay before wipe	0~20	0	The bigger the faster
K171	Internal presser down before wipe	0: Does not fall 1: decline	0	Unit: 50mS
K172	Thread break stitch	0~10	0	Value bigger than 0 means the stitch number after thread breakage before

				emergency stop 0 means thread breakage detection is off.
K174	Trimming position detection	0: Disabled 1: On	0	
K177	Trimming stop position	0~40	0	
K180	(X) Motor go origin mode	0~4	0	
K181	(Y) Motor go origin mode	0~4	0	
K182	(C) Motor go origin mode	0~4	0	
K183	(P) Motor go origin mode	0~4	0	
K190	XY feed sync.settings	0: Start at the same time 1: End at the same time 2: Start and end at the same time 3: Midpoint coincidence	0	
K191	Sew start 1st feed angle adjust	-30~30	0	
K192	Sew start 2nd feed angle adjust	-30~30	0	
K193	Sew start 3rd feed angle adjust	-30~30	0	
K194	Sew end 3rd feed angle adjust	-30~30	0	
K195	Sew end 2nd feed angle adjust	-30~30	0	
K196	Sew end 1st feed angle adjust	-30~30	0	
K197	XY feed start angle adjust	-30~30	0	
K198	XY feed ed angle adjust	-30~30	0	

K227	Main motor type	0: 0830-F11 1: 0830-F01	0	A new power-up is required to take effect
K228	Main motor stop lock enable	0~1	0	A new power-up is required to take effect
K229	Main motor piercing mode	0: OFF 1: ON	0	A new power-up is required to take effect
K231	Pedal continuous sew	0~255	0	A new power-up is required to take effect
K240	Expansion peripheral	0: OFF 1: Built-in timing without external expansion system 2: Built-in timing has an external expansion system	0	A new power-up is required to take effect
K241	Machine type	0: Nesting (reinforcement) 7: Nail buckle	0	
K242	Extend machine type ID	0~255	0	Set the extended model features






**Note:** the above parameters are for the use of repairers only and user should not change them without caution.

### 3.3 Restore Default Setting

If the user changes some parameters by mistake, which are properly set at delivery, the function of “recovery to default setting” can be used to restore the system.








**At recovering the default settings, the entire parameters that are set by user before will be covered. Therefore, please take caution in using this function. If necessary, please contact the technicians of the manufacturer, and operate the machine with the instruction from the professionals.**

The specific operation procedure is as follows:

When the sewing LED is off, hold pressing  key for 3 seconds until the panel buzzer rings. Press  key to select “13 recovery to default setting”, and then press  key to enter the menu for restoring default setting. Press  key again to select the item to be restored and then press  key to execute the recovery operation. The panel will hint “executing, please do not turn off the machine”, which means the recovery operation is undergoing and the power supply shall not be shut down. When the operation is completed, the panel will hint “please turn off the machine” and then you can shut down the machine and restart it to restore the default setting.

**Note:** During the restoring process, if the power supply is shut down by accident, the restoring process has to be aborted and you failed to restore the default setting. The software will return to the former state before restoring.

### 3.4 Software Version Display

When sewing LED  is off, hold pressing  key for 3 seconds until the buzzer sings. Release  key and then press  key to select “08 inquire software version”. Press  key to enter the software version inquiry interface, where user can press  key or  key to select the version to be inquired. The software version will be displayed in the following order:






Main control: machine type-MC-manufacturer code-version number

Operation panel: machine type- LKD2-manufacturer code-version number

Stepping 1: machine type- MD1-manufacturer code-version number

Stepping 2: machine type- MD2-manufacturer code-version number




### 3.5 Check Total Number of Stitches and Clear Lubricating Alarm




After the machine runs for a period of time, the system may hint “M-333 machine needs lubricating”, which means lubricating is needed. Under this situation, press  key first to clear the lubricating alarm, and then press  to enter system menu. Select “01 system U parameter” and press  key to enter U parameter setting mode. Then press  key to select “U245 clear stitch number for lubricating” and press  to clear the total number of stitches, to stop displaying the same message.

### 3.6 Password Setting and U/K Parameter Lock

The system provides users with password management function for them to set password by themselves. After inputting the set password, user can unlock certain advanced functions. User can lock system parameters to prevent change of key parameters by mistake so as not to cause problems.

### 3.7 Change Password

If user need change password, first enter password management mode and then change the password by the following method: when sewing LED is off, hold pressing  key for 3 seconds until the buzzer rings, press  key to select “14 password setting” and press  key to enter password input interface.

Press  key to move backward or forward to delete the password position to be inputted. Press  key to input the password character for the selected position. The available password characters are “0~9”, “A~Z”. After completing input, press  to confirm and enter the new password input interface. Otherwise, the system will report error and return to the system menu.

**Note: the default password is fixed; for more information, please contact your machine manufacturer or its agents.**



User need input the new password in the first line and re-input the same password to confirm it. Then press



to confirm the password change. Otherwise, the system will hint “wrong password”. If user will give up

the password change operation, press



key or



key to quit.  
**Note: after successful change of password, please remember the password and keep it secret!**



### 3.7.1 Set U/K Parameter Lock

This function allows user to lock or unlock parameters that need protecting. Every U parameter and K parameter can be set to be locked or unlocked. The setting method is the same for U parameter and K parameter, and here take U parameter lock for example.

Under the system menu, press



key to select “15 U parameter lock” and press



key to enter password input interface. Input the right password and press





key to enter U parameter lock setting interface. The password has to be corrected, otherwise user cannot enter this interface.

Under this interface, press



key to select the U parameter that need change its locked/unlocked status, and press



to change the locked/unlocked status. The symbol  means locked and  means unlocked. When parameter is locked, user need input password to change its set value. When user quit the parameter setting interface and enter it again, the locked parameters will remain locked.



After completing the parameter lock setting, press






key or






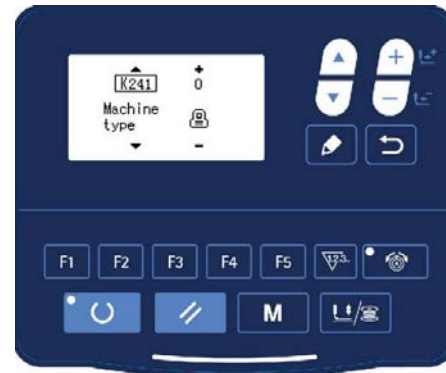
key to save and quit.



## 4 Button Sewing Function

### 4.1 Button Sewing Function Setting

- 1、 When sewing LED  is off, hold pressing  key for 3 seconds until the buzzer rings, and release  key to activate service parameter medication;

- 2、 Press  key to select “12 system K parameter”, press  key to enter and then press  key to select parameter K241;



- 3、 Press  key to change the parameter value into “7” and press  key to confirm the change. At this time, the panel will hint “operation executing, please do not turn off the machine”, and user must not cut off the power supply. When the panel hint “please turn off the machine” after a while, user can cut off the power supply.
- 4、 Then power the machine again and the function changes into button sewing.

**Note: the button sewing function of the machine requires special presser foot and other auxiliary external devices. For more information, please contact your machine manufacturer or its agents.**

## 5 USB Communication Function

### 5.1 Upgrade patterns via USB stick


Support import (addition) of single VDT pattern:




(01) Import pattern: import (add) pattern, and cover the pattern of the same number with imported pattern;


(02) Export pattern: export all external patterns to USB storage device;


(03) Delete pattern: clear (format) the panel's storage area for external patterns;

User can import VDT format patterns to the control system via U disk, with the updated pattern number from 101 to 200. User can also export existing patterns numbered 101~200 that are stored in the control system to U disk.

<ol style="list-style-type: none"><li>1) Use pattern-editing software to make pattern file in VDT format and name it by "XXX.VDT". (Note: XXX shall be a number between 101~200 which at the same time is the updated pattern number.)</li><li>2) Create a new file folder named DH under the root directory of U disk, and save the pattern made in the previous step under the directory of DH (many patterns at one time).</li></ol>	
---	--

3) When the sewing LED is off, press  key to enter system menu. Press  key to select "10 pattern import/export" and then press  key to enter this mode.

4) Press  key to select "01 import pattern" and insert the U disk containing patterns to the USB interface at the right side of the panel.




5) Press  key, and when the panel hint "operation executing, please do not turn off the machine", the patterns are starting to be imported.


**Note: before this operation, please confirm the U disk having been connected to USB interface; if not, this update operation cannot be done and the panel will hint "M-324 U disk not found".**

6) After the update, the panel will display "Operation succeeded!" and the system will automatically return to the interface for importing patterns.

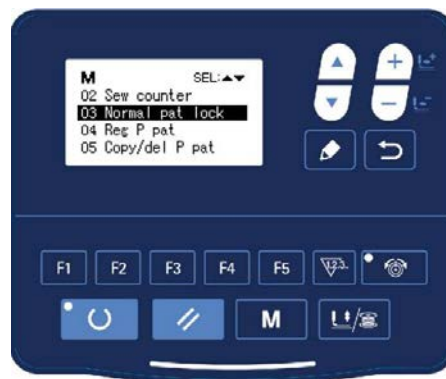
**Note: if there are already patterns numbered 101~200 in the panel, patterns named with different numbers can be added to the system via U disk following the above operations; if the pattern numbers in the U disk are the same with those in the panel, the patterns with the same number in the panel will be replaced. In addition, apart from the pattern update import operation under function number "01", user can also change the function number to "02" and "03" to export and delete patterns respectively. To change function number to "02" means to back up imported patterns, while to change function number to "03" means to delete all patterns numbered 101~200, which may be done when external pattern storage area is full or the data format of the external pattern storage area is abnormal.**





7) Open pattern lock: after update, if the patterns updated via U disk cannot be selected on the sewing interface, the possible reason is that the pattern lock is unopened, for the default setting of patterns number 101~200 is locked and unable to be selected. User need make the following operation:

When sewing LED is off, press  to enter system menu, press  key to select “03 normal pattern lock” and press  key to enter.

Under this mode, the left part A displays the normal pattern number, and user can press  key to change from 1~200; the right part B display the pattern status, “ON” for open and “OFF” for lock.

User can press  to open or lock the pattern.



8) Use  key and  key to open the pattern, press  key to save and return to the system menu, and then press  key again to return to the normal sewing mode.

## 5.1 Upgrade patterns via USB stick

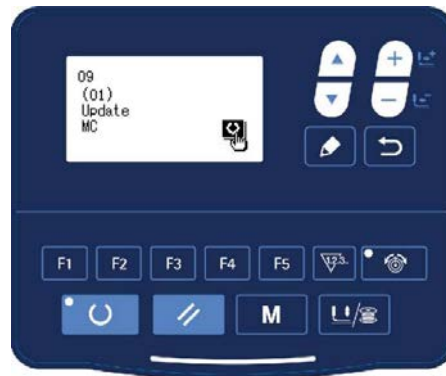
The master, panel and stepper can be upgraded through a USB stick. The program needs to be placed in the update directory of the USB flash drive.

(01)Upgrade the master: The file name is“m Control\_6GR”;

(02)Upgrade steppingDSP1: The file name is“dsp1\_6GT”;

(03)Upgrade steppingDSP2: The file name is“dsp2\_6GT”;

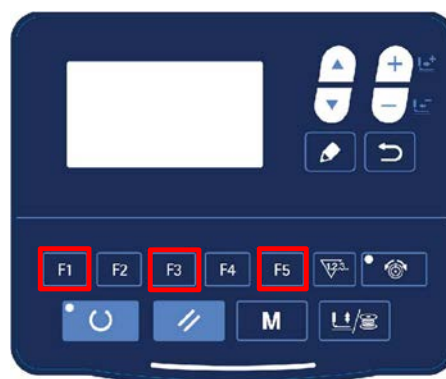
Press the Prepare key  Start the upgrade.



The upgrade progress percentage is displayed during the upgrade process.






The upgrade progress percentage is displayed during the upgrade process. The upgrade of the panel program, the file name is "LCDpanel-2021", also needs to be placed in the U disk update directory, access the U disk to the panel USB interface under shutdown, and then press and hold the F1, F3, F5 keys at the same time to turn on, you can enter the upgrade interface to automatically complete the upgrade.



## 5.3 Upgrade Step Parameters and Step Curves via USB Stick





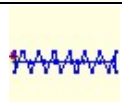
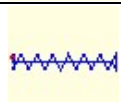
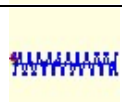
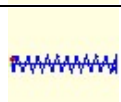
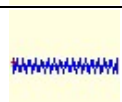
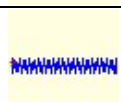
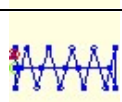
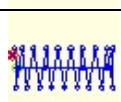
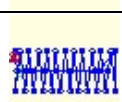

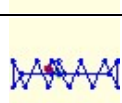

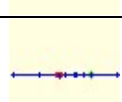
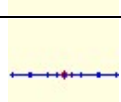
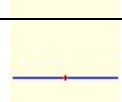
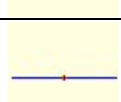
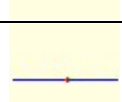
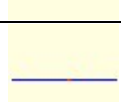
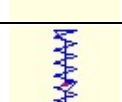
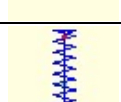
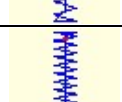

The parameters and curves of the stepper drive can be upgraded through the USB stick. The data files need to be placed in the update directory of the U disk.

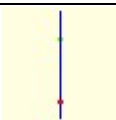
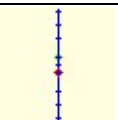
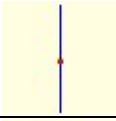
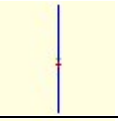



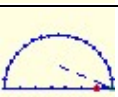
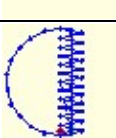
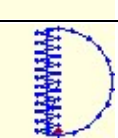

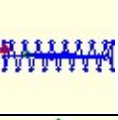
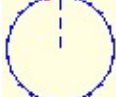
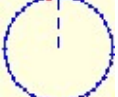
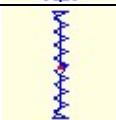
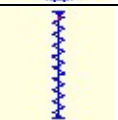
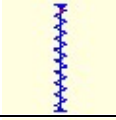
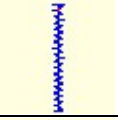
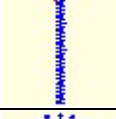
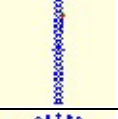


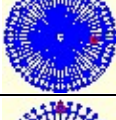
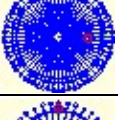
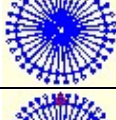




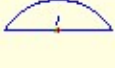
- (01) Import DSP1 configuration parameters: The file name is "Dsp1StepPara\_6G";
- (02) Import DSP2 configuration parameters: The file name is "MStepPara\_6G";
- (03) Import DSP1 configuration parameters: The file name is "Dsp1StepCurve\_6G";
- (04) Import DSP2 configuration parameters: The file name is "MStepCurve\_6G";





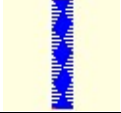
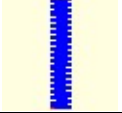
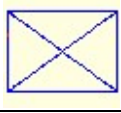

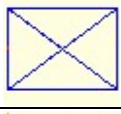
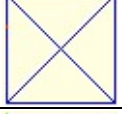
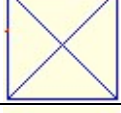
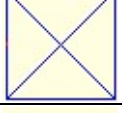



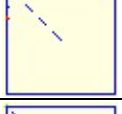

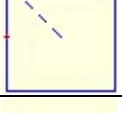
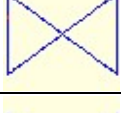
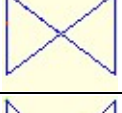
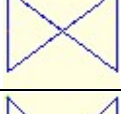
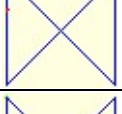
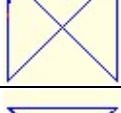
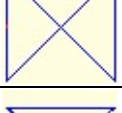
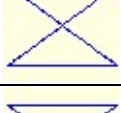
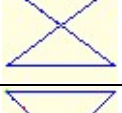
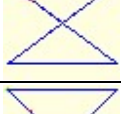
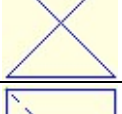
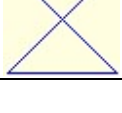
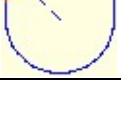
<p>Press  the Prepare button to start the upgrade.</p>	
<p>After the upgrade is complete, it prompts "Operation successful!" , no need to reboot to take effect new data.</p>	


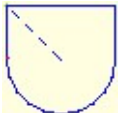
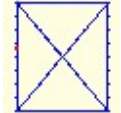
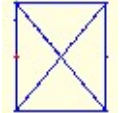
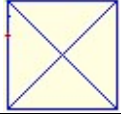
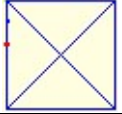
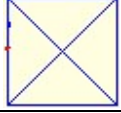
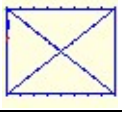
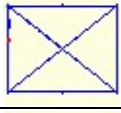
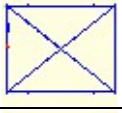
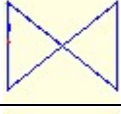
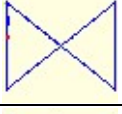
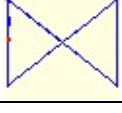
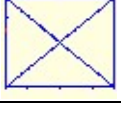
## 6 Appendix 1

### 6.1 List of Patterns in Controller



























NO .	Patterns	Stitch Number	Length × Width (mm)	NO .	Pattern	Stitch Number	Length × Width (mm)
1		41	16.1×2	2		41	10.2×2
3		41	16×2.4	4		41	24×3
5		27	10.1×2	6		27	16×2.4
7		35	10.1×2	8		35	16×2.4
9		55	24×3	10		63	24×3
11		20	6.1×2.4	12		27	6.2×2.4
13		35	6.1×2.4	14		14	8×2
15		20	8×2	16		27	8×2
17		20	10×0	18		27	10×0
19		27	25.2×0	20		35	24.8×0
21		40	25.2×0	22		43	35×0
23		27	4×20	24		35	4×20
25		41	4×20	26		55	4×20








27		17	$0 \times 20$	28		20	$0 \times 10$
29		20	$0 \times 20$	30		27	$0 \times 20$
31		51	$10.1 \times 7$	32		62	$12.1 \times 7$
33		23	$10.2 \times 6$	34		30	$12 \times 6$
35		47	$7 \times 10$	36		47	$7 \times 10$
37		89	$24 \times 3$	38		27	$8 \times 2$
39		25	$11.8 \times 12$	40		45	$12 \times 12$
41		28	$2.4 \times 20$	42		38	$2.4 \times 25$
43		38	$2.4 \times 25$	44		57	$2.4 \times 30$
45		75	$2.4 \times 30$	46		41	$2.4 \times 30$
47		89	$8 \times 8$	48		98	$8 \times 8$
49		147	$8 \times 8$	50		163	$8 \times 8$
51		110	$7.9 \times 7.9$	52		120	$7.9 \times 7.9$
53		130	$7.9 \times 7.9$	54		51	$12.4 \times 10.2$
55		50	$12.4 \times 10.2$	56		52	$21 \times 6$

57		57	21×6	58		102	19×3
59		115	40×5	60		115	40×5
61		93	5×30	62		109	5×30
63		108	40×30	64		80	40×30
65		64	40×30	66		96	30×30
67		76	30×30	68		60	30×30
69		52	40×30	70		40	40×30
71		32	40×30	72		44	30×30
73		36	30×30	74		28	30×30
75		60	40×30	76		48	40×30
77		36	40×30	78		56	30×30
79		44	30×30	80		36	30×30
81		67	40×30	82		51	40×30
83		39	40×30	84		55	30×30
85		35	30×30	86		42	30×30

87		32	30.1×30	88		26	30×30
89		74	20×24	90		54	20×24
91		65	20×20	92		49	20×20
93		39	20×20	94		63	25×20
95		51	25×20	96		45	25×20
97		42	25×20	98		33	25×20
99		27	25×20	100		88	30×25

## 6.2 List of Patterns for Button-sewing in Controller

No.	Pattern	Thread Number	Standard Sewing Length X(mm)	Standard Sewing Length Y(mm)	No.	Pattern	Thread Number	Standard Sewing Length X(mm)	Standard Sewing Length Y(mm)
1 34		6-6	3.4	3.4	18 44		6	3.4	0
2 35		8-8			19 45		8		
3		10-10			20		10		
4		12-12			21		12		
5 36		6-6			22		16		
6 37		8-8			23 46		6	0	3.4
7		10-10			24		10		
8		12-12			25		12		
9 38		6-6			26 47		6-6	3.4	3.4
10 39		8-8			27		10-10		
11		10-10			28 48		6-6		
12 40		6-6			29		10-10		
13 41		8-8			30 49		5-5-5	3.0	2.5

No.	Pattern	Thread Number	Standard Sewing Length X(mm)	Standard Sewing Length Y(mm)	No.	Pattern	Thread Number	Standard Sewing Length X(mm)	Standard Sewing Length Y(mm)
14		10-10			31		8-8-8		
15 42		6-6			32 50		5-5-5		
16 43		8-8			33		8-8-8		
17		10-10							

## 6.3 Main Control Error List

Code	Name	Content	Solution
E-001	Pedal not in the middle position	Pedal is stepped down when entering the ready sewing status	Make sure the pedal is not stepped down when entering the ready sewing status
E-002	Pause	RESET key is pressed while sewing machine is running. The machine pauses.	Restart or return-to-origin after pressing RESET key for thread-trimming.
E-003	Head Tilt Error	Head tilt detection switch is set as ON.	The sewing machine cannot be operated with the head tilted. Return the sewing machine head to its proper position. Technicians can use short circuit board to short circuit the 2P blue plug on the head board.
E-007	Main shaft driver abnormal	The error is detected in main shaft driver.	Turn off the power and repower the machine after a while.
E-008	24V power supply error	24V over-current	Turn off the power supply and then turn it on again after a while.
E-010	Air valve (fan) problem	After start, the system detects abnormal signal about the voltage of the air valve or fan.	Shut down the machine to check if there is any short circuit
E-012	Presser Foot Position Error	Presser foot is not at proper position.	Turn off the power and check connection of the CZ025 at the head signal circuit board. If the connection is ok, check the optocoupler.
E-013	Encoder Disconnection	The system can't detect ADTC signal.	Turn off the power, and confirm whether plug X5 is connected properly.
E-014	Motor Running Abnormal	When the main shaft motor is running, the range of the electrical angle is abnormal at 0°	Shut down the machine to check the motor encoder.
E-015	Beyond Sewing Area	The sewing area is beyond the limit.	Press RESET switch to confirm the pattern and its X/Y scale rate. Triggering condition: pattern computation error.
E-016	Needle Bar Up Position Error	The needle bar is not at UP position.	The main shaft stop position error may be caused by main shaft drive, or may be caused by human error. Turn the hand wheel to return the needle bar to its UP position.
E-017	The thread is interrupted during the sewing process	The pin bar is not in the upper position.	The spindle parking position is wrong, which may be the cause of the spindle drive, or it may be caused by human rotation. Turn the handwheel to return the pin holder to the upper position.
E-018	Cutter Position Error	The cutter is not at the right position.	Turn off the power and check the connection of the CZ024 at the head signal circuit board. If the connection is ok, check the optocoupler.

Code	Name	Content	Solution
E-020	Stepping Software Version Error	The software version for the stepping board is false.	Change the stepping board or update the stepping board program.
E-022	Machine Stop Due to Aging	After entering aging mode, the machine stops.	Shut down the machine
E-025	X Origin Search Error	X origin sensor doesn't change.	Turn off power and check the connections of CZ021 on head signal circuit board and X9 on control box.
E-026	Y Origin Search Error	Y origin sensor doesn't change.	Turn off power and check the connections of CZ022 on head signal circuit board and X9 on control box.
E-027	Presser Origin Search Error	Presser origin sensor doesn't change.	Turn off power and check the connections of CZ025 on head signal circuit board and X9 on control box.
E-028	Thread-catching Origin Search Error	Thread-catching origin sensor doesn't change.	Turn off power and check the connections of CZ026 on head signal circuit board and X9 on control box.
E-032	Spindle motor encoder Z signal anomaly	Encoder Z phase has no signal.	Check whether the spindle motor encoder cable is complete and the connection is secure.
E-035	Main Board IPM Sudden Over-current	The current for the main board IPM drive module is too much within a short period of time	Turn off the power and repower the machine after a while. Change the main shaft motor to check if the motor is damaged; if problem remains, change the main board.
E-036	Main Board IPM Multiple Over-current	Over-current happens repeatedly to the main board IPM drive module after power on	Turn off the power and repower the machine after a while. Change the main shaft motor to check if the motor is damaged; if problem remains, change the main board.
E-037	Main Shaft Over-current	Motor stops.	If there is no mechanic problem, check the connection of the main shaft encoder
E-038	Machine Lock Error	The main-shaft of sewing machine can't rotate due to some problem.	After user sending order to rotate the main shaft, the main shaft motor doesn't respond. Check the PWM curve of the main shaft motor, the signal of the encoder and whether there is mechanic problem.
E-039	Main Shaft Over-speed	The system detects the actual speed of the main shaft motor exceeding the speed limit	Turn off the power and repower the machine after a while.
E-044	Machine Head Board Parameter Abnormal with Lower Computer	The lower computer read abnormal parameter from the machine head board.	Check the machine head board and the connection of X9 cable. Press RESET key to use parameter No. 67 to restore the parameters of the machine head board.

Code	Name	Content	Solution
E-047	The number of sewing needles exceeds the total number of stitches	The number of sewing needles exceeds the total number of stitches of the current pattern.	Check whether the spindle motor and cable are normal, and check whether the spindle encoder is subject to external interference.
E-056	Stepping Close Loop DSP1(X25/X27) Communication Error	The verification of the received order at stepping board is failed	Check the connection of SPI communication cable
E-057	Stepping Close Loop DSP1 1 <sup>st</sup> Route (X27) Over-Current	Large current is detected by hardware	At first, please check motor. Then check the resistance and sensor value. If the motor is ok, user should check the hardware on stepping board
E-058	Stepping Close Loop DSP1 1 <sup>st</sup> Route (X27) Position Error	The detected encoder response position is not consistent with the position set in the order.	Change the stepping motor to open loop mode and run it. If the motor can work normally, the motor is ok. If the motor can't work normally, user should check the driving part on the stepping board and the motor itself. After the above operations, user should check the encoder. Make sure the connection and the condition of the encoder cable is ok. And make sure the signal response part on the stepping board and the encoder itself is ok.
E-059	Stepping Close Loop DSP1 1 <sup>st</sup> Route (X27)Over- speed	The system will give this warning when it detects the abnormal motor speed via the encoder response signal.	The checking method is the same with that for Position Error
E-060	Stepping Close Loop DSP1 2 <sup>nd</sup> Route (X25) Over-Current	Large current is detected by hardware	At first, please check motor. Then check the resistance and sensor value. If the motor is ok, user should check the hardware on stepping board
E-061	Stepping Close Loop DSP1 2 <sup>nd</sup> Route (X25) Position Error	The detected encoder response position is not consistent with the position set in the order.	Change the stepping motor to open loop mode and run it. If the motor can work normally, the motor is ok. If the motor can't work normally, user should check the driving part on the stepping board and the motor itself. After the above operations, user should check the encoder. Make sure the connection and the condition of the encoder cable is ok. And make sure the signal response part on the stepping board and the encoder itself is ok.
E-062	Stepping Close Loop DSP1 2 <sup>nd</sup> Route (X25) Over- speed	The system will give this warning when it detects the abnormal motor speed via the encoder response signal.	The checking method is the same with that for Position Error
E-063	Stepping Close Loop DSP2(X21/X23) Communication Error	The verification of the received order at stepping board is failed	Check the connection of SPI communication cable

Code	Name	Content	Solution
E-064	Stepping Close Loop DSP2 1 <sup>st</sup> Route (X23) Over-Current	Large current is detected by hardware	At first, please check motor. Then check the resistance and sensor value. If the motor is ok, user should check the hardware on stepping board
E-065	Stepping Close Loop DSP2 1 <sup>st</sup> Route (X23) Position Error	The detected encoder response position is not consistent with the position set in the order.	Change the stepping motor to open loop mode and run it. If the motor can work normally, the motor is ok. If the motor can't work normally, user should check the driving part on the stepping board and the motor itself. After the above operations, user should check the encoder. Make sure the connection and the condition of the encoder cable is ok. And make sure the signal response part on the stepping board and the encoder itself is ok.
E-066	Stepping Close Loop DSP2 1 <sup>st</sup> Route (X23) Over- speed	The system will give this warning when it detects the abnormal motor speed via the encoder response signal.	The checking method is the same with that for Position Error
E-067	Stepping Close Loop DSP2 2 <sup>nd</sup> Route (X21)Over-current	Large current is detected by hardware	At first, please check motor. Then check the resistance and sensor value. If the motor is ok, user should check the hardware on stepping board
E-068	Stepping Close Loop DSP2 2 <sup>nd</sup> Route (X21) Position Error	The detected encoder response position is not consistent with the position set in the order.	Change the stepping motor to open loop mode and run it. If the motor can work normally, the motor is ok. If the motor can't work normally, user should check the driving part on the stepping board and the motor itself. After the above operations, user should check the encoder. Make sure the connection and the condition of the encoder cable is ok. And make sure the signal response part on the stepping board and the encoder itself is ok.
E-069	Stepping Close Loop DSP2 2 <sup>nd</sup> Route (X21) Over-speed	The system will give this warning when it detects the abnormal motor speed via the encoder response signal.	The checking method is the same with that for Position Error
E-072	The origin of the follower medium voltage foot motor retrieves the abnormality	The motor could not find the origin.	It is necessary to enter the detection mode to check whether the motor power line or encoder line is connected stably and whether the motor is running normally.
E-073	XY needle pitch is abnormally large	XY needle pitch is more than 12.7mm.	Reduce the pattern pitch.
E-090	USB upgrade stepping error	The query stepping status timed out.	Check that the stepper board program is correct.
E-093	Step closed-loop DSP1 (X25/X27)	Master and stepper communication error.	Check whether the main control and stepper communication lines are stable and reliable.

Code	Name	Content	Solution
	communication packet validation error		
E-094	Step closed-loop DSP1 (X25/X27) traffic packet illegal command	Master and stepper communication error.	Check whether the main control and stepper communication lines are stable and reliable.
E-095	Step closed-loop DSP2 (X21/X23) communication packet validation error	Master and stepper communication error.	Check whether the main control and stepper communication lines are stable and reliable.
E-096	Step closed-loop DSP2 (X21/X23) traffic packet illegal command	Master and stepper communication error.	Check whether the main control and stepper communication lines are stable and reliable.
E-097	The master software does not match the motherboard hardware type	The master board is using the wrong part.	Replace the main control board of the corresponding product.
E-098	Stepping DSP1 curve data CRC check error	The stepper curve data is abnormal.	Re-upgrade the step curve of DSP1.
E-099	Stepper DSP2 curve data CRC check error	The stepper curve data is abnormal.	Re-upgrade the step curve of DSP1.
E-102	Motherboard FLASH data check error	The motherboard data store is abnormal	Replace the motherboard
E-103	Extended peripheral communication exception	The communication between the electronic control of the sewing machine and the electronic control of the extension peripheral is abnormal	Check the CAN communication cable between the electronic control of the sewing machine and the electronic control of the expansion peripheral.
E-104	The extension peripherals are running abnormally	Extended peripherals electronically report errors	Connect the panel to the extended peripheral electronic control to observe the error message.
E-105	Stepper closed-loop DSP1 (X25/X27) spindle synchronization mode error	The stepping action in spindle synchronization mode is abnormal	Check whether the spindle motor is running normally and smoothly, and whether there is jitter.
E-106	Stepper closed-loop DSP2 (X21/X23) spindle synchronization mode error	The stepping action in spindle synchronization mode is abnormal	Check whether the spindle motor runs normally and smoothly with or without jitter.

## 6.4 Operation Panel Error List

Code	Name	Content	Solution
M-300	Memory Abnormal	There exists error with the data defined by the operation panel.	Internal error: user need update the panel program.
M-301	Memory Abnormal	Panel memory data abnormal	Internal error: user need update the panel program.
M-302	Machine Type Parameter Error	The machine type data read by the operation panel is not within the set range.	Press RESET key to automatically enter parameter No. 241 to select and save the defined machine type.
M-303	UK Parameter Abnormal	Abnormal range of the parameter read by the panel from EEPROM	Press RESET key to enter the system menu and recover the default setting.
M-304	Head Board Parameter Abnormal	Abnormal range of parameters received by panel from down computer	Press RESET key to enter the system menu and recover the default setting.
M-305	Normal Pattern Parameter Abnormal	When using pattern parameter, the panel detects abnormal parameter range.	Press RESET key to enter the system menu and recover the default setting.
M-306	Pattern Not Found or Locked	The prepared pattern No. hasn't been registered to ROM or set as not to be read. The pattern No. is displayed as 0.	Press RESET key, confirm the pattern No. and make sure the pattern is unlocked.
M-307	Pattern Data Abnormal	When the panel reads the sewing data of the pattern, the data format is found to be abnormal.	Select other patterns.
M-308	Sewing Data Too Large	When being computed, the size of the pattern data is found to be too large and beyond normal range.	Select other patterns for sewing.
M-309	Pattern beyond Sewing Range	When being computed, the pattern is found to be beyond sewing range.	Press RESET key, confirm the size of the pattern is within the set range of parameters K056, K057, K058 and K059.
M-310	Stitch Length beyond Normal Range	When being computed, the stitch length is found to be beyond normal range.	Press RESET key, confirm the pattern and X/Y scaling up rate.
M-311	Pattern Data Communication Abnormal	Error occurs when the panel sends pattern data to the main control.	Check the pattern and the cable connection between the panel and the main control.
M-312	Normal Pattern Lock Abnormal	The panel can't read the normal pattern lock data from EEPROM.	Press RESET key to enter the system menu and recover the default setting.
M-313	Present Pattern Parameter Abnormal	The panel can't read the pattern parameter data from EEPROM.	Press RESET key to enter the system menu and recover the default setting.
M-314	Parameter Setting beyond Normal Range	The set value of the parameter exceeds normal range.	Press RESET key and change the set value.
M-315	Counter Abnormal	The panel can't read the counter data from EEPROM.	Press RESET key to enter the system menu and recover the default setting.
M-316	Counter Exhausted	The counter has reached the upper limit after the sewing.	Press RESET key.
M-317	Communication Error between Main Board and the Panel	There is no communication or communication error between main board and the panel.	Turn off the power and repower the machine after a while. Check the communication cable, the main board and the panel.

Code	Name	Content	Solution
M-318	The Storage Space for External Patterns Full	When patterns are imported to the control panel via USB, the storage space for such patterns is found full.	First export the internal patterns before deleting them, and then import patterns again.
M-319	External Patterns Format Abnormal	Pattern data is found abnormal when its format data is read by the control panel	Enter the parameter import/export mode of the system and delete such patterns.
M-320	Imported Pattern Already Exist	When importing pattern from USB storage device, pattern with the same number is found to exist already in the panel.	Change the number of the pattern in the USB storage device to be imported.
M-321	Imported Pattern Not Found	When importing pattern from USB storage device, the pattern to be imported is not found.	Select existing patterns in the USB storage device.
M-322	Pattern Deletion Error	When deleting external pattern, it is found to be not exist.	Select existing pattern for deletion.
M-323	Pattern Read Error	There is problem with reading pattern data from external pattern storage area.	Please select other patterns.
M-324	USB Device Not Connected	When importing or exporting patterns, the panel detects abnormal USD storage device.	Change another USB storage device
M-325	The Size of Imported Pattern Too Large	When importing patterns, the panel detects that the imported pattern is too beyond the size limitation.	Make sure the imported pattern is within the size range.
M-326	External Pattern Not Found	Under sewing ready status, the external pattern to be read is not found.	Please select other patterns.
M-327	P Pattern to Be Deleted is Cited by C Pattern	When being deleted, the P pattern is found to have been added to certain C pattern.	First delete the P pattern from the C pattern and then delete the P pattern.
M-328	USB Patterns Not Found	The pattern number to be imported can't be found after USB connection	Make sure the pattern is correctly named and saved under the designated directory of the USB storage device.
M-329	No Registered P Pattern	Before entering the P pattern or C pattern copy/deletion mode, no P pattern has been registered.	Please register P patterns before entering those modes.
M-330	All Normal Patterns Shut Down	Before entering P pattern registration mode, all normal patterns are found to have been shut down.	Please unlock normal patterns.
M-331	No More Registration of P Patterns	Before entering P pattern registration mode, it is found that all P patterns have been registered.	Please delete some P patterns before registering new ones.
M-332	No Deletion of the Last C Pattern	The C pattern to be deleted happens to be the last one.	The deletion of the remaining last C pattern is prohibited.

<b>Code</b>	<b>Name</b>	<b>Content</b>	<b>Solution</b>
M-333	Alarm to Lubricate the Machine	It is time to add lubricating oil to certain parts of the machine, so the machine stops working.	Restart the machine, enter parameter No. 245 and press RESET key, and then power on again
M-999	Undefined Error	Undefined error of the operation panel	Shut down the machine and update the control panel program.

## 7.1 Installation Size of Control Box



## 7.2 Installation Size of Operation Panel



### 7.3 System Diagram

