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Chapter 1: Boot interface

This machine supports multiple languges and cn switch system langhuages accordi to the user. After turning on the power ,click on the foreigin or Chinese button accoding to user needs to enter the opation interface.



Function Descrption:

| order | function | content |
|-------|-------------------|---|
| A | Foreigin language | This dispaly cna be dispalyed in the system parameters->Main interface set->Parameter 1 |
| В | Chinese | Display Chinese |

Chapter 2: Setings and functions related to large



Mian interface function descripation:

| order | function | content |
|-------|---------------------------|--|
| A | circularbottomhemmer | Click here to enter the startup interface |
| В | Speed and its prompt text | Set running speed prompt text displays |
| C | Style information and | Click on the style number and size to enter the |
| | sewing iterfacee | sewing interface |
| D | Style List | Style List, choose aa larger style |
| E | New and Delete | Create and delete style |
| F | Production count | Count addition/subtraction, clear to zero, click to |
| G | Signaltest | Input or output signal interfaces |
| | A | Display Automatic expansionof the naddage , chilk to |
| | Automatic expansion | enter the interface |
| | | |
| I | Wheel speed | Ste hel speeds value |
| J | Inverted stock | Display the duration of inverted blowing, click to |
| | | enter intered interface |
| K | Seam postion | Display the detected stock posttion value and enter |
| | | the stock position interface |
| | | |
| L | Frontoverlapstitches | Set running speed prompt text displays |
| | | |
| M | Ackover lapstitches | Set value Ackover lapstitches |
| N | Bottomhemmer widt | Display the bottonhemmer width value,click to |
| | | enter the hem width setting interface |
| 0 | Idling | Idling: OFF\ON |
| Р | Device detect | Click to enter the device detection |
| Q | SystemParameter | Click to enter the system para |
| R | Origin | Home return funtion |
| s | Presser foot | Reewer the presser foot |

2.1 Sewing interface

Click on the style button $_\circ~$ As shown in the figures $_\circ~$

打版款式相关设置及功能



Function Descriptions:

| order | function | content | | |
|-------|----------|--|--|--|
| Α | Exit | Click to eixt and enter the main interface | | |
| - 6 - | | | | |

打版款式相关设置及功能

| В | Sean point | Display sean point |
|---|---------------------|---|
| С | Process time | Display Preocess time |
| D | Feeding | Set material placement values,with different size parameter values tips:Automatic expansion->Whether to open automatic stretch mode /Turn on control parameter display and hide |
| E | Stetching width | Set hetension value, different sizes have different |
| F | Feeding | Set feed values continuoush adh |
| G | Automatic expansion | Automatic expansion |

2.2 New style

Click the button "New Settings " on the main interface to enter the interface and set the style and number, Click Cancel to exit the New Style interface. As shown in the figures.

| | | | 5 | £ | 2023-1 | 0-27 15:18:16 |
|-------|-----|------------|------|----|----------|---------------|
| | Na | ame 0. 003 | | | | |
| ~~ | | | | | | »» |
| | 1 | 2 | 3 | 4 | 5 | |
| | 6 | 7 | 8 | 9 | 0 | |
| | a | b | С | d | е | |
| | f | g | h | i | j | |
| | k | | m | n | 0 | |
| | р | q | r | S | t | |
| | u | v | w | x | у | |
| | z | | Caps | EN | Delete | |
| | Spa | ce | | B | ackspace | |
| Cance | 1 | | | | | OK |

2.3 Delecte Style

Click the delete button on the main interface and a prompt box will $popup_{\circ}$ Click to confirm the successful deletion the style, click Cancel to exit the delection of the style.



2.4 Productioncount

Click the button on the main interface called Production count value, enter the countup setting interface. As shown in the figures \circ

| 📕 Up Counter Set | | | 1 | | 2023-10-27 15:21:17 |
|------------------|---------|--------|----------|--------------|---------------------|
| | | | | | |
| | | | | | - |
| | 1 | | 9 | 9999 | |
| | SET | | | | |
| | CUR | NOW | 0 | 0001 | |
| l. | | | | | |
| | 4 | 2 | 4 | | |
| | Counter | r-open | Clear of | .R urrent | |
| | | | Val | ue | |
| | | | | | |
| | | | | | |
| | | | | | 71 |
| | | 1 | 2 | 3 | |
| | | | - | e | |
| | | 4 | | | |
| | | 7 | 8 | 9 | |
| | | | | | |
| | CLR | + | - | U | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

Contain:

1. Production count setting value (total count seting) $_{\circ}$

2. Production Count Current Value Seting .

3. Counter function switch button $_{\circ}$ 4.Clear current value button .

2.5 Input Deaction

Click the input deaction button on the main interface the to enter the signaal detection interface . Ask for communication to cpntrol signal off/on . As shown in the figures .

打版款式相关设置及功能

| 🔋 Input Dectection 🗂 | 2023-10-27 15:32:12 |
|--------------------------|--------------------------------|
| ES-Reserved keys OFF | Correction inner sen OFF |
| BKI-cutter safety | Correction external OFF |
| switch Left expansion | Discourse in 1 |
| origin | Disconnection 2 OFF |
| Z-Bottom hem width o OFF | |
| Y-seam inspection se OFF | Disconnection 3 OFF |
| | Disconnection 4 OFF |
| Emergency Button OFF | |
| Start Button OFF | Jisconnection 5 OFF |
| P3-Reserved keys OFF | Wedium deviation cor OFF |
| | |
| IN1-Correction middl OFF | |
| IN2-Reserved input OFF | ADC-Reserved 0 |
| IN3-Reserved input OFF | |
| | |
| P-Presser foot cylin OFF | seam fips OFF |
| T-Trim cylinder OFF | Locking cylinder |
| C-Reserved port OFF | Locking stroke OFF |
| W-Wire pulling elect OFF | off ovlinder |
| L-Reserved port OFF | blow OFF |
| | Second blow OFF |
| draging cylinder OFF | seam flips OFF |
| Press material blow OFF | seam fips OFF |
| Synchronize waste su OFF | seam fips pressing |
| Delayed waste suctio | receiving |
| First blow | material OFF |
| Front hemming OFF | Traverse OFF |
| Inspect seam OFF | Bracket OFF |
| | |
| | |

2.6 Automatic perimeter calculation Click on the main intn toenter the textedit formtice perimer calculation ,and enter the corresponding value of relativeprinting expansion . As shown in the figures .

S



contains:

1.Automatic expansion->Whether to open automatic stretch mode /Turn on control parameter display and hide

2. Automatic strecching and epansion parametr settingss

2.7 Seam flips

Click the Seam flips button on the main interface the to enter the seam flips interface. As shown in the figures.



1.Seam position switch 1. No seam flips/Need to seam filipss. 2.Inside duration of seam fips blow.

2.8 Seam postions

Click the stock position button on the main interface to enter the stock position interface . As shown in the figure.

| seam position | i. | | 2023-10-27 15:36:34 |
|---------------|-------------------------------------|----------------|--------------------------------|
| | | | |
| | Current garment seam position ha | s 3500 |], |
| | at the 3500 speed of | gears detectio | n the seam |
| | After detection the No | 0 seam, | |
| | forward 0 | to reach seam | position |
| | when detected the | last seam posi | tion, |
| | forward 2100 | to reach the a | eam position |
| | | | |
| | | | |
| | | | |
| | | | |
| | | | |
| | | | |
| | | | 0 seam positicn calibration |
| | | | |
| | | | |
| | | | |
| | | | |
| × | Inspect seam test | Do | not use dual speed |
| | | | |

contains:

1.Series parameters of stock positons.

2.Inspace seam test.

3.Dual speed switch. Control the wheel speed display on the main interface.

Do not use dual speed: The main interface displays a wheel speed parameter; Use dual speed: The main interface displays the speed parameters of the front and rear wheels.

Chilck on the [0 stock postion calibartion] button to enter the sub interface. This interae allows you to save samll size save calibration and large size save caliation. As shown in the figure.

| 📮 seam position | 1 | 2023-10-27 15:37:17 |
|------------------------------|-------------------------|-------------------------|
| | | |
| 0 se | am positicn calibration | 1 |
| The last | sewing width 0. | 0 |
| The last | running diameter 0 | |
| I | | |
| Small size save calibrati | on Lar save o | rge size calibration |
| Width 35 | 0.0 Width | 350.0 |
| Diameter 35 | 00 Diameter | 3500 |
| | | |
| | | |
| | | |
| | | |
| | | |
| | | |
| | | |
| | | |
| | | |
| | | |
| X | | |
| | | |

2.9 Bottom hemmer with sets

Click on the bottom width buttons , enter the bottom hemmer withs sets.sAs shown in the figure.



contains:

1.Lower pendulum $_\circ~$ Bottom swing width motor sensor switch , Bottom swing width motor forward rotation reverse control current coordinates $_\circ$

 $\label{eq:setting} \text{parameters for hem width}_\circ \ \text{Click on "Save current coordinates"}, \ \text{Save the current coordinates of the swing width motor to the loswer swing width setting parameter}_\circ$

3.Machine origin distace .

Chanptr 3:Device detection

3.1 Motor debug

Click the button named Device Detection on the main intserface to enter motor configuration interface. In this interface ,functions such as motor debuge ,thread cutting cutter testing and reset cna be acheved. As shon in the figures.

Hi. 💂 motor debug 2023-10-27 15:39:39 Current Left wheel 0.00 OFF coordinates sensor Loose Current shaft Right wheel 0.00 0.00 coordinates coordinates Left Expand Left Expand Left wheel Right wheel left shift right shift Inner sensor OFF External Conveying Conveying OFF sensor forward reverse Correction Correction edium Correctio edium Correctio inward outward inward outward Current OFF sensor Current 0.00 Current coordinates OFF sensor t point of a 0.00 Save Current 0.00 coordinates st point of c 0.00 Save Swing width Swing width forward reverse Cut forward Main motor Main motor test System and update fixed needle Cylinder debugging

3.2 Cylinder debug

Click the "Cylinder debug" button on the motor debug tface to enter the debug infterface. In this interface , the cylinder button status , cylinder debugging , strand inversion material receiving test, reset, and other functions cna be achieveds. As shown in the figure.



设备检测

3.3 Servo Speed Detection

Chick the "Servo Speed Detection" button on the motor debugging interface to enter the spindle testingf interfaces. On this interface, you can debug the spindle speed. As shown in the figure.



3.4 mainaxle motor Angle Correction

Click the button named "Servo angel Detection " on the device detection and debug interfacen to eenter

💂 Servo motor Angle Correct 1 2023-10-27 15:44:46 180 Electric value 000 270) ----000 Mechanical value deg 0 Mechanical value OFF **∠0°** Take-up-lever highest 000 position check X L MAIN 1 Servo Motor Free

Mianaxle motor angle correction $\ _\circ$ This interface allows ffor mainale motor Angle Corrextion $_\circ$ As shown in the figure $_\circ$

Chapter 4:Systerm upgrade and functions

4.1 System upgrade Mode

Clink on the tsesting interface [System update]->[Upate], enter the Version Mode interface. Used to view the version number of the control ststem. For exmple: MCtrl version, Panel information, LOGO version, Stepping motor1 version, etc information.

Click the upgrade btton to enter the system upgrade interface \circ This interface allows for version upgrader and system restore function \circ As shown in the figure \circ

系统升级及功能设置

| 📕 Version Mode | ± | 2023-10-27 15:45:33 |
|----------------|------------------------------|---------------------|
| | Panel version: | |
| UI05 7.1-KD-V | /92-04-10-9999(2023102715312 | 21) |
| | MCtrl version: | |
| | | |
| | UBoot version: | |
| UIOS 7.1-UB-1 | .0.0 | |
| | UBoot version: | |
| UIOS 7.1-UL-1 | .0.0 | |
| | LOGO version: | |
| UIOS 7.1-LOG | 0-1.0.0 | |
| | MCtrl version: | |
| UIOS 7.1-MC- | V92-04-01-001 | |
| | Expand version: | |
| UIOS 7.1-EX-V | /092-04-01-001 | |
| | External keyboard: | |
| UIOS 7.1-KB-V | 1.01ZZ_ | |
| | Main axle version: | |
| UIOS 7.1-MM- | V92-04-01-001 | |
| | Stepping motor1 version | |
| UIOS 7.1-MD1 | -V92-04-01-001 | |
| | Stepping motor2 version | |
| UIOS 7.1-MD2 | | |
| | | |
| | | |
| | | |
| X | | Update |
| | | |
| | | |

1.Upgrade:Serch for USB drive upgrade files and select the upgraded system. Click on the oneupgrade button to proceed with the updagrde process. Don't turn off the power during the upgrade process. Afer upgrading, a prompt box will pop up ,please restart the power supply.

2.Restore: Click the one click recovery buttonto enter the system restore. As shown in the figure. You can restore all parameters with ine click or sekect the parameter items that need to br restored. Restore the operation to the original defualt values. After the system is restored , a prompt box will pop up, please restart the power supplys.

系统升级及功能设置



4.2 Functionmode

Click on the motor debug [system Maintain] -> [Function mode] button, enter the function mode interface. This interface is divided into 10 modules. As shown in the figure $_{\circ}$

系统升级及功能设置



Chapter 3:Systemparameters

Parameter List:

| Parameter Name | Delault | Range |
|---|------------|------------------------|
| Syncscale (1 Set) | | |
| Whether automatic start avaiable | 0FF | OFF、 ON |
| How long does it start | 350 | 1-3000ms |
| Switch sensor timing | 5800 | 100-15000 |
| Switch children's wear equipment | Adult | Adult、Children's wear |
| Switch the deviation correction method | Sensor | Sensor switching. |
| | switching | Formula switching |
| | | |
| Cutter (2 Set) | | |
| Whether the cutter is used | Use, Not | Use, Not used |
| | used | |
| Cutter origin signal polarity | 0 | 0, 1 |
| Advance cutter position | 0 | 0-100% |
| Number of stitches to stop the cutter in | 0 | 0-50 |
| | | |
| Port (3 Set) | | |
| Automatic expansion port replacement with IN2 | Notenabled | Notenabled, Enabled |
| Locking cylinder (4 Set) | | |
| Whether ocking cylinder is ok | Invalid | Invalid, Valid |
| Needle high position angle | 10 deg | 0-500 |
| Delayed of needle high locking wire | 10 ms | 0-500 |
| Locking wire mechanical angle | 125 deg | 0-360 |
| Needle low position delay | Oms | 0-500ms |
| Lock wire travel delay | 200ms | 0-500ms |
| Receive material(5 Set) | | |
| Whether material receipt is open | OFF | OFF, Method1, Method 2 |
| Receiving delay | 350ms | 100-2000ms |
| Material receiving delay | 700ms | 100-4000ms |
| Pallet delay | 1500ms | 0-5000ms |

| Rectification motor(6 Set) | | |
|--|------------|-----------------------|
| Deviation correction motor default | Forward | Forward, Reverse |
| End idling distance(7 Set) | | |
| End idling distance | 1000 | 1-30000 |
| Boneless end error compensation | 0FF | OFF、 ON |
| Size code error value for boneless endings | 200 | -500-500 |
| Speed of left and right wheel idling and | 50 | 0-100 |
| retraction after bone turnover | | |
| Setlanguage (8 Set) | | |
| Language | Chinese | Chinese、English、 |
| Advancedpara (10 Set) | | |
| Servo enable signal delay | 100 | 100-999ms |
| Time delay after servo ban | 100 | 100-999ms |
| HALT switch type | ON | OFF、 ON |
| Trim switch type | ON | OFF、 ON |
| Pneumatic check switch type | ON | OFF、 ON |
| Trim (11 Set) | | |
| Whether the thread trimming cylinder is | Valid | Invalid, Valid |
| Delay from thread trimming opening to | 350 | 10-3000ms |
| Delay from thread triming closing to hook | 50 | 10-3000ms |
| Whether the hook line is effective | Invalid | Invalid, Valid |
| The delay from hooking on to hooking off | 120 | 10-3000 |
| The delay from hooking close to subsequent | 120 | 10-3000 |
| Swing width motor (12 Set) | | |
| Whether the swing width motor is used | 0: Use | |
| | 1:Not used | 0 |
| Default direction of swing width motor | Forward | Forward, Reverse |
| Dense needle (13 Set) | | |
| Dense needle switch | 0 | OFF, conventice, DAHE |
| Dense needle stitches | 3 | 1–10 |
| Main interface setting (14 Set) | | |

| Display language of icon on the left of main interface | | Chinese、English、 Vietnamese、korean、 Turkish |
|--|-----------|---|
| Starting to suck waste (15 Set) | | |
| Initial waste suction duration | 200 | 0-1000 |
| Slow start stitch (16 Set) | | |
| Start slow needle | 2need I e | OFF, |
| | | 1needle, 2needle, 3needl |
| | | е. |
| Slow stitch first stitch speed | 200 | 0–9999 |
| Slow stitch second stitch speed | 400 | 0–9999 |
| Slow stitch third stitch speed | 600 | 0–9999 |
| Slow stitch four stitch speed | 800 | 0–9999 |
| Slow stitch five stitch speed | 1000 | 0-9999 |
| Slow stitch six stitch speed | 1200 | 0-9999 |
| Counter (17 Set) | | |
| Sets function of UP counter | ED | , ED, CY |
| Sets function of DOWN counter | ED | , ED, CY |
| Method of clearing (UP) counter setting | | , IT, CL |
| Method of clearing (DN) counter setting | | , IT, CL |
| Initialize UP/DN counter or not at power on | HOLD | HOLD, CLEAR |
| Prohibition of UP counter current value | ALLOW | FORBID, ALLOW |
| Prohibition of DOWN counter current value | ALLOW | FORBID, ALLOW |
| ON/OFF of stitch counter function 1 | 0FF | OFF、ON |
| Setting for warning stitch number of counter | 1000 | 0-9999 x100000 stitches |
| ON/OFF of stitch counter function 2 | 0FF | OFF、 ON |
| Setting for warning stitch number of counter | | |
| 2 | 1000 | 0-9999 x100000 stitches |
| | | |
| Reserved Para5(18 组) | | |
| Reserved Paraó(19 组) | | |
| Reserved Para7(20组) | | |
| Reserved Para8(21 组) | | |
| Reserved Para9(22组) | | |
| Reserved Para10(23 组) | | |

系统参数

| 1 | 1 |
|---|---|
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