

# MANUAL FOR AUTOMATIC CUFF COVERSTITCH MACHINE( SINGLE CUFF/ WHOLE PIECE)



## **Preface**

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1.Thank you for purchasing our products, be sure to read and understand the instructions carefully before use so that you can quickly grasp the correct way of use. Incorrect use will result in abnormal operation, which may cause malfunction or reduce the quality of the product. If you have any questions about this manual, please contact us.

### **2 Precaution**

2.1 It is forbidden to start the machine until you are aware of its proper operation and safety rules. For untrained or unauthorized personnel, it is forbidden to use the machine.

2.2 Before using the machine, you must read this manual carefully and understand all contents and instructions.

2.3 After ensuring that the machine has been installed and all necessary commissioning has been completed, you can operate the machine

2.4 Before starting, it is important to make sure that all surface of the machine are free of any tools or equipment.

2.5 If the power supply is interrupted, the inside of the machine or appliance should not be touched.

2.6 The operator should not leave the working area of the machine during its operation

2.7 No touching of sensors and moving parts during machine operation

2.8 When electrical control circuits need to be inspected and repaired, they must be handled by an electrical professional.

2.9 Do not modify the machine or install unauthorized equipment, cutters or peripherals without our authorization to avoid danger.

2.10 If you are unable to solve the problem in accordance with this manual, please consult us or an authorized dealer, and unauthorized operation is prohibited.

2.11 Do not use the machine under unspecified environments and conditions

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## Equipment introduction

This equipment is designed for single-tube cuff sewing (adult garments) on round-neck shirts. When paired with a two-needle, three-thread left-side trimmer coverstitch machine, it enables fully automated sewing processes including automatic edge folding, automatic stitching, and automatic thread trimming.

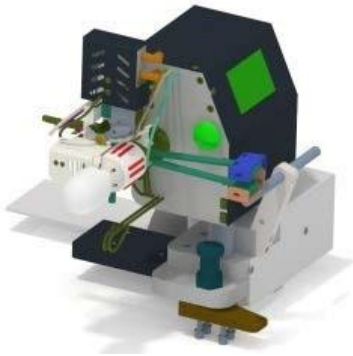


## Major components



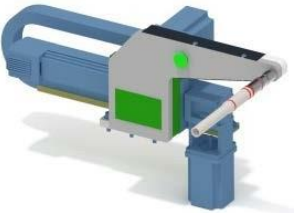
The sewing table assemble

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The front wheel component

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The rear wheel component

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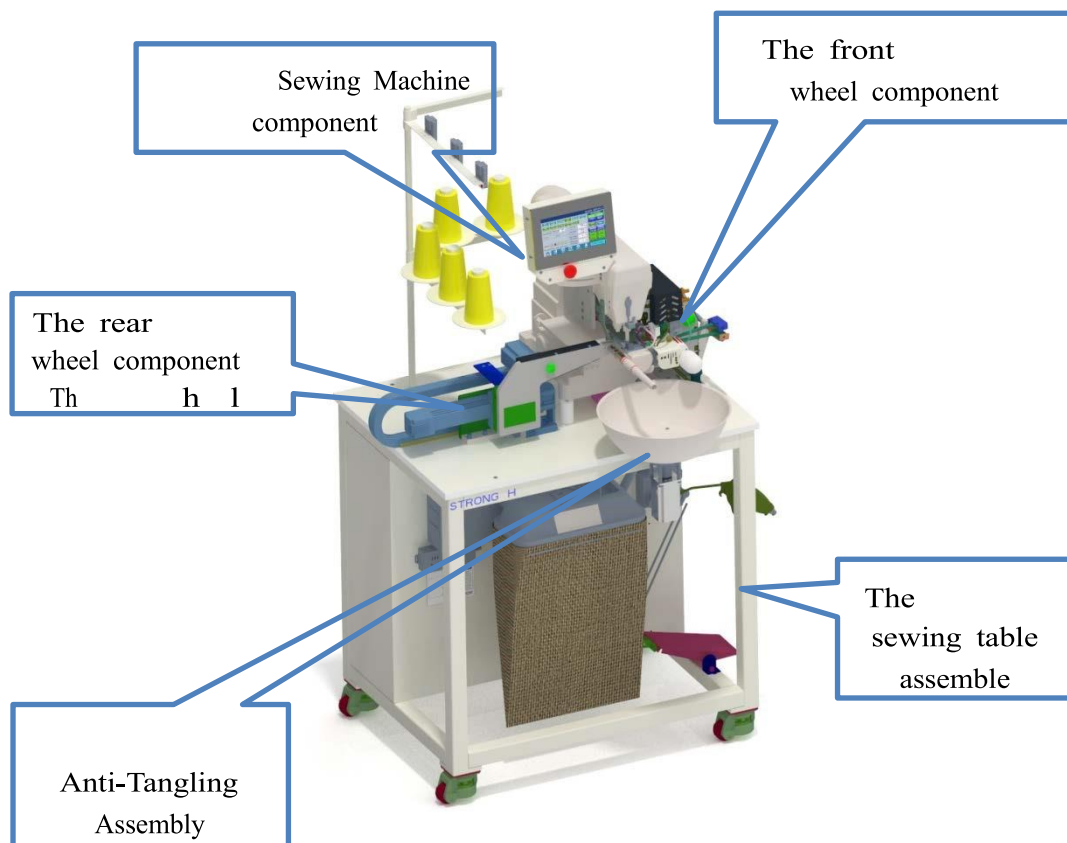


Anti-Tangling Assembly

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Sewing Machine component



# Operation interface buttons and their meanings

## 1. Home



Light fabric mode: **Switch**, click to switch heavy material mode.

Tension mode: **Switch**, Click into it to change the mode in the tension mode or position mode, in the tension mode the rear wheel stretches to the set tension stop, and in the position mode, the rear wheel stops to the set position.

Alternate Seaming: **Switch**, click to turn ON/OFF. When enabled, cycles between seamed and non-seamed operations.

Cutter ON: **Switch**, click to switch on or off. Independent cutter cutting action after opening.

Lock-thread ON: **Switch**, click to switch on or off. (Only for the lock thread function of the machine head).

Test mode off: **Switch**, Click into change the mode on/off, that when it is on test mode, now in testing mode, sewing machine needle can't work; the test mode should be off when the machine is sewing normally.

Seam switch ON: **Switch**, Click into to change the mode on/off, the switch on when sewing fabric with seam; switch off when cylindrical shirt without seam.

Seam reserve ON: **Switch**. Click into to change the mode on or off, that is to switch seam reserve or not.

Seam reserve increase pressure ON: **Switch**. click to switch on or off. Open to increase the seam reserve blow.

Turntable ON: **Switch**. Click to turn on or off. When on, the turntable activates.

External trimming ON: **Switch**. Click to switch on or off.

Size: **Display Settings**, click size no to change size no.

Tension set: **Display Settings**, click set tension to set the tension value of the current material when sewing, reach the set value in tension mode to start sewing, adjust the settings according to different material size elasticity

Actual tension: **Displays** the current actual tension value.

Setting needle speed: **Display Settings**, setting the sewing machine speed needs to match the sewing machine electric control.

Current needle speed: **Display** the actual speed of the sewing machine.

Needle gauge setting : **Display Settings**, set needle gauge when machine is sewing, front and rear wheel feeding and sewing machine matching needle gauge, used to ensure that sewing and sewing machine synchronization

Start sewing fine adjustment: **Display Settings**, fine adjustment of start-sewing-time needle gauge.

Overlap-sewing fine adjustment: **Display Settings**, fine adjustment of overlap-sewing-time needle gauge

Total output: **Display** the current processing quantity; Clear: **Button** long pressing quantity to clear and quantity is 0.

Presser Foot Lift: **Button** Click to raise or lower the presser foot.

Sewing: **Button** Click to perform a test stitch over a short distance.

Warning message: Click into enter the alarm information display.

Sewing abnormal: Click into display sewing exception information

Start (No Seam): **Switch** - Click to start the device

Start (With Seam): **Switch** - Click to start the device

Button Start Mode: Long press to switch to eyelet detection auto mode



Size selection : Button Click to enter the size selection interface.

Monitor I/O : Button Click to enter the I/O Input/output monitoring interface.

Manual operating mode: **Button** Click to enter the manual operating mode interface.

User login: Button Click to enter the user login interface

System parameters: **Button** click to enter the System parameters interface.

2. The alarm information enters interface



Historical alarm information can be viewed.

On the right side, press and hold the 5 disconnection alarm switches to switch the disconnection alarm on and off.

3. Sewing abnormal enters interface



Overlap-sew deviation: can adjust the difference of overlapped thread, enter the end-sewing stitch and start-sewing stitch left or right value, and press the confirm button, the system will automatically correct the difference of overlapped thread.

Edge cutting width deviation: The width of the cutting cloth edge can be adjusted. For example, if the actual cut edge size is too wide, enter the size of the cut edge width and press the confirm key. If the cutting cloth edge is too narrow, enter the size of the cutting edge is too narrow and press the confirm key.



## 4. Size select interface



Size setting

Size No.: **Button** Click to select sewing hemming type;

XX S **Setting**: Click the drop down arrow to select the sewing hemming size;

Move to material loading position **Setting**: Displays the distance from the loading position.

Writing current: **Button** Saves the current location.

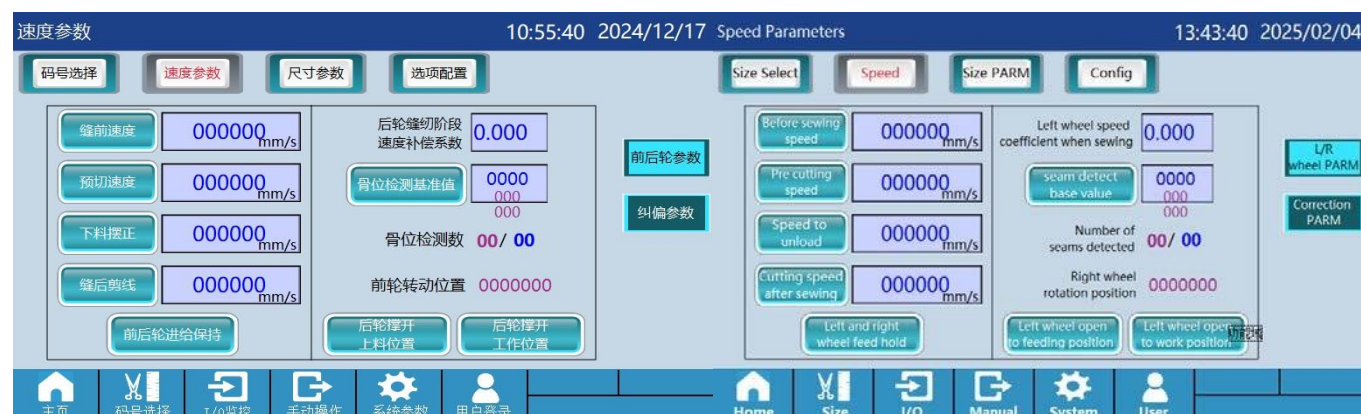
Move to working position **Setting**: Displays the distance from the working position.

Writing current: **Button** Saves the current location.

Learn Material / Executing learning: **Button** Access the material learning function.

Arc sewing function/Parameter setting: **Button** Enter parameter setting.

## 5. Speed parameter list



Before speed sewing **Setting**: rotation speed of front and rear wheels before sewing.

Pre-cutting speed **Setting**: the feeding speed of the front and rear wheels when pre-cutting is performed before starting the sewing machine.

Material receiving set right **Setting**: the feed speed of the front and rear wheels before receiving the material after sewing.

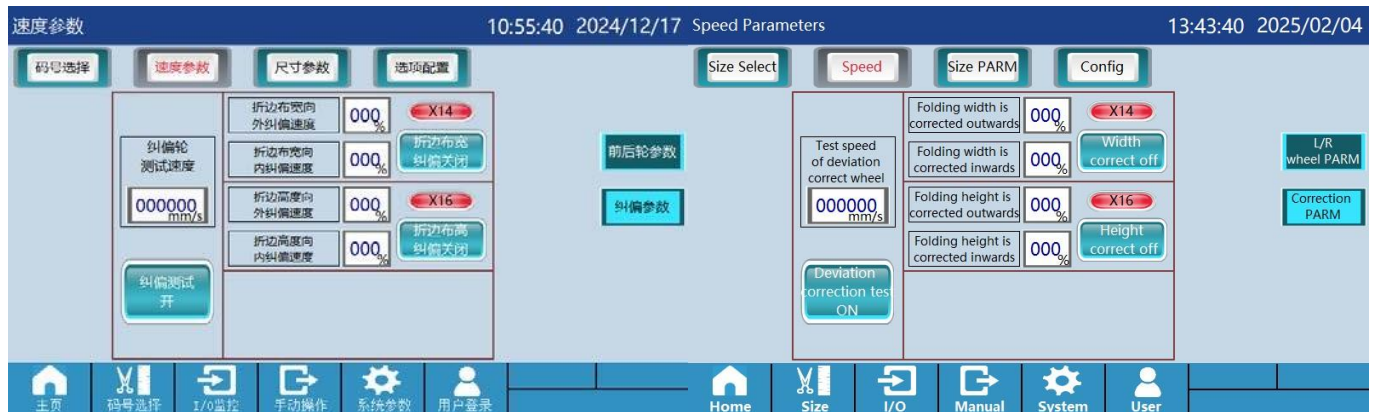
Trimming after sewing **Setting**: After sewing, perform the trimming of the material, the feeding speed of the front and rear wheels.

Left and right wheel feed holding **Button**: This button is the point and continuous switch key of the above four keys, used to adjust the testing.

Seam detect base value **Setting**: Setting the zero position of seam position, put the material on the seam position detection roller, press this key, the seam position detection roller will automatically fall, and the value below the right side will automatically clear to zero. Pulling the material so that the seam position is under the detection wheel, and the displayed

value below the right side is the seam position height. Take 1/2 of the displayed value and input it above the displayed value. The seam position detection setting is complete.

## 6. Speed parameter interface



Deviation wheel test speed **setting**: Sets the reference value for deviation correction speed.

Deviation test ON button: Master switch for deviation correction function test

Outward hem width deviation correction speed **setting**: Sets the speed multiplier for outward deviation correction during finishing phase and sewing phase (when middle sensor is not exposed)

Inward hem width deviation correction speed **setting**: Sets the speed multiplier for inward deviation correction during finishing phase and sewing phase (when middle sensor is not exposed)

Outward hem height deviation correction speed **setting**: Sets the speed multiplier for outward deviation correction during sewing phase (when middle sensor is exposed)

Inward hem height deviation correction speed **setting**: Sets the speed multiplier for inward deviation correction during sewing phase (when middle sensor is exposed)

Hem width deviation correction OFF **button**: Manually tests if hem width deviation correction speed is set correctly (active when deviation test switch is ON). Direction test can block inner sensor (X14)

Hem height deviation correction OFF **button**: Manually tests if hem height deviation correction speed is set correctly (active when deviation test switch is ON). Direction test can block outer sensor (X16)

## 7. Size parameter list



Edge folding height **Setting**: Set the edge folding width of material. After entering the actual folding width, press the **confirm** button and the front wheel will automatically move to the set position

Cutting width **Setting**: Fine adjustment the cutting edge size, enter the value and press the confirm key, and the sensor will automatically **move to** the adjusted position

Number of the start-sewing seam **Setting**: Set the number of seam at the start-sewing

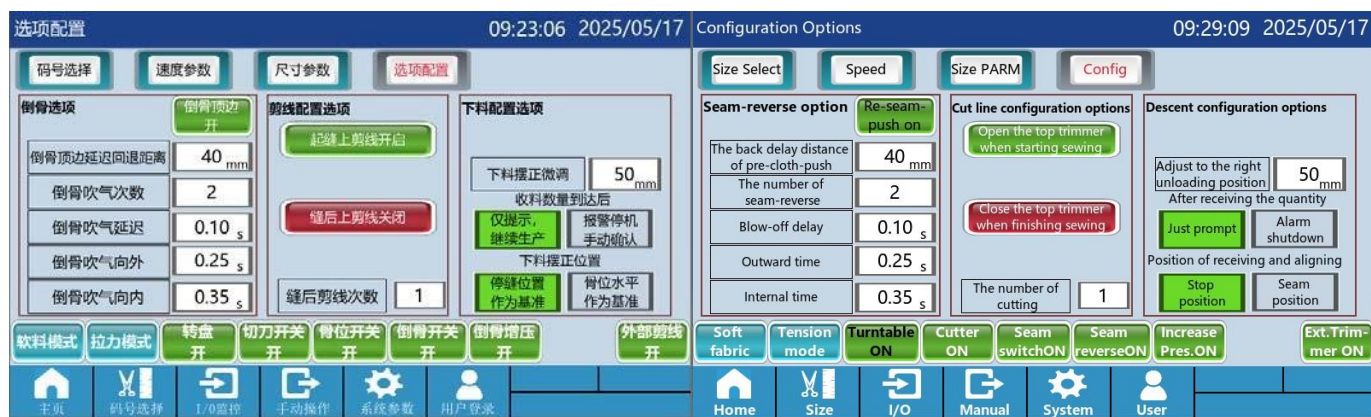
Seam-reverse back distance **Setting**: Set start-sewing position after seam reversed.

Overlap-sewing seam number **Setting**: Set the number of seam number at the end of the sewing.

Number of seam reserve **Setting**: single seam reserve or multi-seam reserve can be set

Lock Stitch Pitch **Button**: Lock stitch function pitch switch. (Available when sewing machine has lock stitch function)

## 8. Configuration option interface



Seam reserve folding device off **Button**: Turn on this switch before the end of sewing, the front folding device will be returned and then delayed back. Turn off this switch and the reverse back seam blowpipe will be returned after the seam reverse.

The back delay distance of Seam reserve folding device **Setting**: After the front folding device is returned, the delay distance of the back seam tube is valid when the back-up top edge switch is turned on.

Seam Air Blow Count **Setting**: Sets the number of air blow actions for seam finishing.

Seam reserve blow delay **Setting**: seam reserve blow delay time

Seam reserve blow outward time **Setting**: The delay time of the outward action of the reverse seam cylinder.

Seam reserve blow internal time **Setting**: The delay time of the inward action of the reverse seam cylinder.

Open the top trimming when starting sewing **Button**: Control the On or Off of the top trimming when starting sewing.

Open the top trimming after sewing **Button**: Control the On or Off of the top trimming when starting sewing.

The number of trimming after sewing **Setting**: The number of times of the trimming after sewing

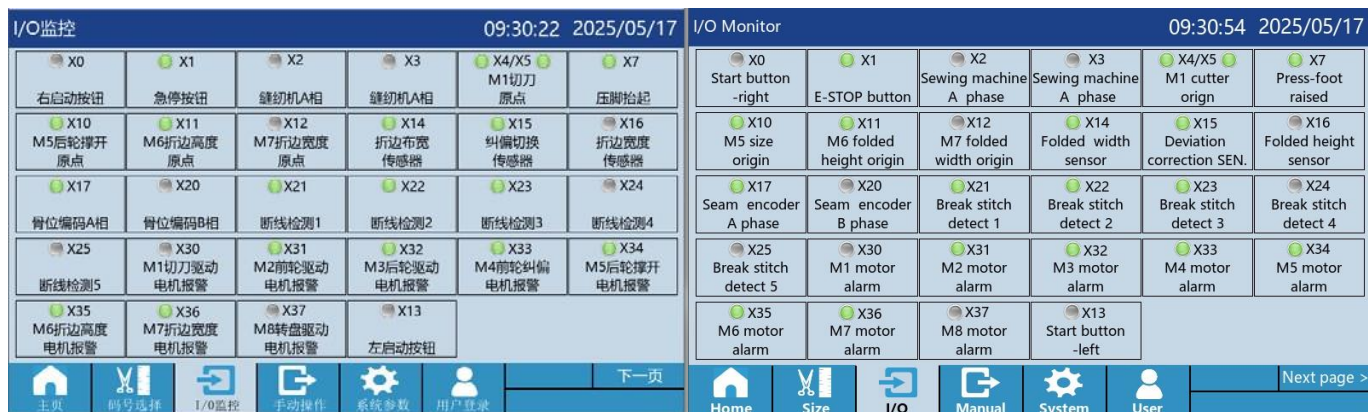
Position of receiving and aligning **Setting**: You can choose the stop position of clothing rotation after sewing "stop position" or "seam position".

Button: Executes action with current parameter settings.

Button: Executes action with current parameter settings

Button: Executes action with current parameter settings.

## 9. I/O Monitor interface



Real-time display of device input and output signal working status, used to detect whether the input signal is abnormal



## 10. I/O Monitor interface



Real-time display of device input and output signal working status, used to detect whether the output signal is abnormal

## 11. Manual mode interface

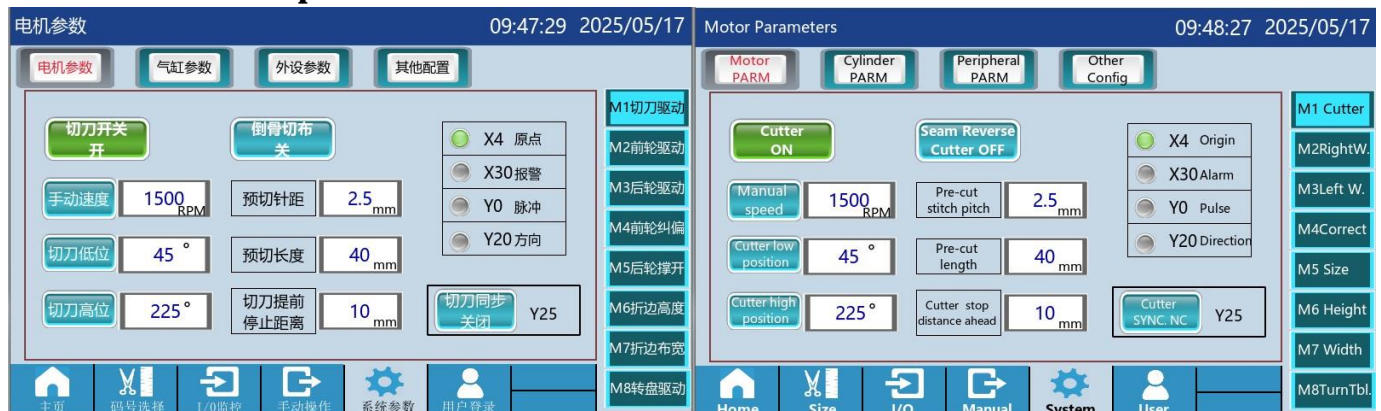


Right Sewing **Setting**: Sets the action duration.

Left Sewing **Setting**: Sets the reset duration.

Cylinder Delay Test Button: Click to cycle-test cylinder movement and verify timing settings. Click again to deactivate.

## 12. Cutter motor parameter interface



Cutter ON **Button**: The left cutter function can be turned off and on.

Manual speed **Setting**: Manual cutter speed can be set.

Cutter low position **Setting**: Set the cutter low position.

Cutter high position **Setting**: Set the cutter high position.

Pre-cut needle gauge **Setting**: The larger the value, the pre-cut speed is slower. Conversely, the speed is faster.

Pre-cut length Setting: The pre-cutting distance of the cutter can be adjusted before starting the seam. The larger the value, the cutter will start earlier.

Cutter stop distance ahead Setting: At the end of sewing, the cutter stops ahead of the distance from the seam position. the value is higher, the cutter stops earlier.

Cutter SYNC. Button: Turn on this switch and manually turn the sewing machine to test whether the cutter is synchronized.

X4 Input: Cutter motor origin indicator light.

X30 Input: Cutter motor status (normal/abnormal).

Y0 Output: Cutter motor pulse operation status.

Y20 Output: Cutter motor running direction status.

Y25 Output: Cutter motor synchronization output status.

## 13. Front wheel drive interface

The screenshot displays the 'Motor Parameters' interface for a sewing machine. It is divided into two main sections: '电机参数' (Motor Parameters) on the left and 'Motor Parameters' on the right. Both sections show a grid of settings for various components like the cutter, front wheel, and back wheel. The settings include parameters like 'Seam shielding distance of feeding', 'Seam detection filtering distance', 'Correct-change filtering distance', 'Auto-stop distance for out of sewing', 'Pre-cloth push forward delay distance', 'Post-cloth-push forward delay distance', 'Pre-cloth-push back delay distance', 'Wire breakage induction 1 filtering', 'Wire breakage induction 2 filtering', 'Wire breakage induction 3 filtering', 'Wire breakage induction 4 filtering', 'Wire breakage induction 5 filtering', 'Left wheel diameter coefficient', and 'Rear wheel diameter compensation coefficient'. The interface also includes a top bar with the date and time (09:49:02 2025/05/17) and a bottom bar with navigation icons for Home, Size, I/O, Manual, System, and User.

Material loading seam position shielding distance Setting: Controls when the seam position detection switch drops before sewing.: Seam detection sensitivity Setting:

Seam detection filtering distance Setting:

Correction-change filtering distance Setting:

Auto-stop distance for out of sewing Setting: Set the actual sewing distance of the material to prevent the machine from not stopping and sewing the material damaged when the equipment fails.

Basic distance without seam start sewing Setting: Sewing position can be set for seamless material.

Basic distance without seam overlapped Setting: Overlap-sewing position o can be set for seamless material.

Basic distance with seam start sewing Setting: The sewing position of seam material can be set, the distance between the seam position switch and the needle of the sewing machine.

Basic distance with seam overlapped Setting: Overlap-sewing position of seam material can be

Front folding device forward delay distance Setting: Set when the front folding device moves.

Back folding device forward delay distance Setting: Set when the Back folding device moves.

Front folding device back delay distance Setting: Set when the front folding device moves.

Thread breakage shielding time of start sewing Setting: Breaking response time at the start-sewing.

Rear Wheel Diameter Compensation Coefficient Setting: Adjusts rear wheel speed to achieve speed ratio switching between front and rear wheels.

Thread breakage induction filtering Setting: Thread break induction response time can be set to avoid false induction.



## 14. Rear wheel drive interface

电机参数

08:04:29 2025/06/07

电机参数

气缸参数

外设参数

其他配置

光眼启动延时

0.0 s

起缝针距补偿

-0.100 mm

重缝针距补偿

2.500 mm

延时落压脚

0.1 s

起缝针距转换距离

20.00 mm

重缝针距转换距离

25.00 mm

落压脚后延时缝切

0.1 s

起缝转速补偿

100.00 mm/s

前轮直径

45.10 mm

防坠布吹气起缝延迟关

0.20 s

重新上电后生效

后轮直径

24.00 mm

防坠布吹气重缝延迟开

60 mm

重新上电后生效

主页

码号选择

I/O监控

手动操作

系统参数

用户登录

M1切刀驱动

M2前轮驱动

M3后轮驱动

M4前轮纠偏

M5后轮撑开

M6折边高度

M7折边布宽

M8转盘驱动

Motor Parameters

08:05:11 2025/06/07

Motor PARM

Cylinder PARM

Peripheral PARM

Other Config

Sensor start delay

0.0 s

Start sewing stitch pitch compensation

-0.100 mm

Overlap-Sew stitch pitch compensation

2.500 mm

Delay begins to foot down

0.1 s

Start sewing stitch pitch distance

20.00 mm

Overlap-Sew stitch pitch distance

25.00 mm

Foot down delay sewing

0.1 s

Start sewing speed coefficient

100.00 mm/s

Right wheel diameter

45.10 mm

Prevent-sag blow off delay while sewing

0.20 s

Valid after re-powering on

Left wheel diameter

24.00 mm

Prevent-sag blow on delay while overlap

60 mm

Valid after re-powering on

Home

Size

I/O

Manual

System

User

M1 Cutter

M2RightW.

M3Left W.

M4Correct

M5 Size

M6 Height

M7 Width

M8TurnTbl.

Optical Sensor Start Delay **Setting**: In auto mode, sets delay time after fabric loading before starting.

Presser Foot Lowering Delay **Setting**: Sets delay time after seam finishing before presser foot lowers.

Sewing Delay After Presser Foot Lowering **Setting**: Sets delay time after presser foot lowers before sewing starts.

Front Wheel Diameter **Setting**: Sets diameter for sewing synchronization (takes effect after reboot).

Rear Wheel Diameter **Setting**: Sets diameter for sewing synchronization (takes effect after reboot).

Initial Stitch Pitch Compensation **Setting**: Sets compensation value within transition distance for main stitch pitch

Initial Stitch Pitch Transition Distance **Setting**: Defines range from starting point for pitch transition.

Initial Speed Compensation **Setting**: Sets linear speed compensation for front/rear wheels within transition distance.

Anti-Dropping Air Blow Off Delay **Setting**: Sets time delay to turn off air blow after sewing starts.

Anti-Dropping Air Blow On Delay for Re-stitch **Setting**: Activates air blow when retreating from end point by set distance.

Re-stitch Pitch Compensation **Setting**: Sets compensation value within transition distance for main stitch pitch.

Re-stitch Pitch Transition Distance **Setting**: Defines retreat distance from end point for pitch transition.

## 15. Front wheel deviation correction parameter interface

电机参数

09:50:29 2025/05/17

电机参数

气缸参数

外设参数

其他配置

纠偏测试关

折边布宽向外纠偏速度

800%

折边布宽向内纠偏速度

600%

折边高度向外纠偏速度

800%

折边高度向内纠偏速度

600%

下料外纠偏行程

0 mm

下料外纠偏速度

200%

下料外纠偏测试

纠偏测试关

纠偏轮测试速度

200 mm/s

X14

X33 报警

Y03 脉冲

Y13 方向

M1切刀驱动

M2前轮驱动

M3后轮驱动

M4前轮纠偏

M5后轮撑开

M6折边高度

M7折边布宽

M8转盘驱动

Motor Parameters

09:54:49 2025/05/17

Motor PARM

Cylinder PARM

Peripheral PARM

Other Config

Correction Test OFF

Folding width is corrected outwards

800%

Folding width is corrected inwards

600%

Folding height is corrected outwards

800%

Folding height is corrected inwards

600%

Test speed of deviation correct wheel

200 mm/s

X14

X33 Alarm

Y03 Pulse

Y13 Direction

Distance of unload correction

0 mm

Speed of unload correction

200%

Unload Correction Test

Home

Size

I/O

Manual

System

User

M1 Cutter

M2RightW.

M3Left W.

M4Correct

M5 Size

M6 Height

M7 Width

M8TurnTbl.

Deviation Correction Test **Button**: Tests the ON/OFF function of deviation correction.

Deviation Wheel Test Speed **Setting**: Sets the base speed value for deviation correction.

Outward Edge-Width Deviation Speed **Setting**: Sets the speed multiplier for outward correction during finishing phase and sewing phase (when middle sensor is not exposed).

Inward Edge-Width Deviation Speed **Setting**: Sets the speed multiplier for inward correction during finishing phase and sewing phase (when middle sensor is not exposed).

Outward Edge-Height Deviation Speed **Setting**: Sets the speed multiplier for outward correction during sewing phase (when middle sensor is exposed).

Inward Edge-Height Deviation Speed **Setting**: Sets the speed multiplier for inward correction during sewing phase (when middle sensor is exposed).

Edge-Width Deviation Test **Button**: Manually tests if edge-width deviation speed settings are correct (only active when "Deviation Test Switch" is ON). For direction test, block inner sensor (X14).

Edge-Height Deviation Test **Button**: Manually tests if edge-height deviation speed settings are correct (only active when "Deviation Test Switch" is ON). For direction test, block outer sensor (X16).

X33 Input: Deviation correction motor status (normal/abnormal).

Y03 Output: Deviation correction motor pulse status.

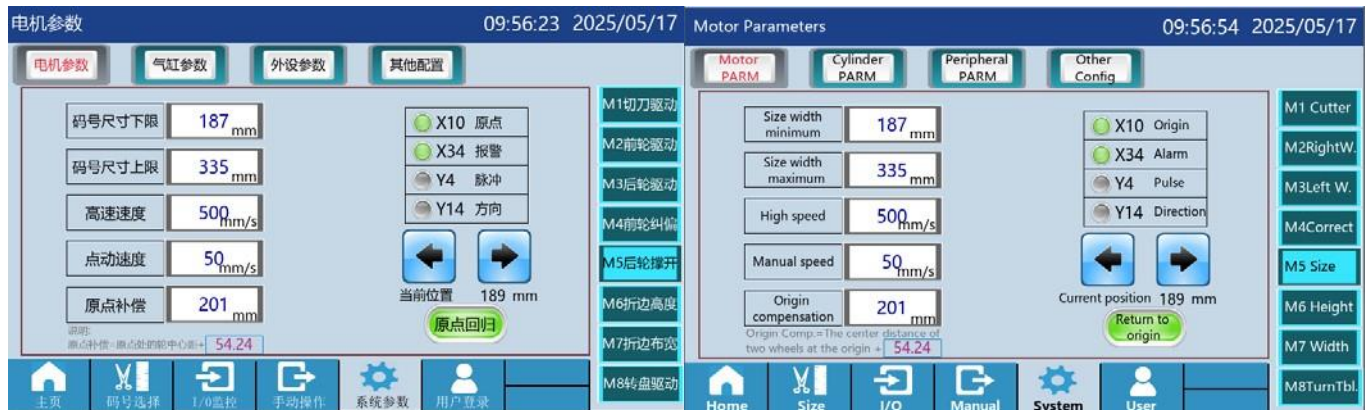
Y13 Output: Deviation correction motor running direction status.

Outward Receiving Deviation Stroke **Setting**: Sets the travel distance for outward receiving deviation.

Outward Receiving Deviation Speed **:** Sets the speed multiplier for outward receiving deviation.

Outward Receiving Deviation Test **Button**: Tests if outward deviation function works properly (only active when "Deviation Test Switch" is ON).

## 16. Rear wheel open interface



Size Code Lower Limit **Setting**: Sets the lower limit position of the expansion

Size Code Upper Limit **Setting**: Sets the upper limit position of the expansion motor

High Speed Setting: Maximum tensioning speed

Jog Speed Setting: Manual tensioning speed

Origin Compensation **Setting**: At origin position, left/right wheels can expand to half of fabric circumference

X10 Input: Origin indicator light

X34 Input: Tensioning motor status (normal/abnormal)

Y4 Output: Tensioning motor pulse status

Y14 Output: Tensioning motor running direction status

Current Position **Button**: Moves tensioning position left

Origin Return Button: Returns to origin position

## 17. Edge-folding height interface





Height Upper Limit **Setting**: Sets the upper limit value for Dimension A

Height Lower Limit **Setting**: Sets the lower limit value for Dimension A

Origin Compensation **Setting**: Sets the compensation value for Dimension A motor origin

X11 Input: Origin indicator light

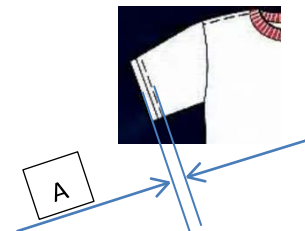
X35 Input: Motor status (normal/abnormal)

Y5 Output: Motor pulse status

Y15 Output: Motor running direction status

Current Position **Button**: Manual motor position adjustment

Origin Return Button: Motor first returns to origin switch, then reaches set value after calculating origin compensation



## 18. Edge-folding width interface



Fabric Width Upper Limit **Setting**: Motor upper limit position

Fabric Width Lower Limit **Setting**: Motor lower limit position.

Origin Compensation **Setting**: Motor origin switch compensation value.

X12 Input: Origin indicator light

X36 Input: Motor status (normal or abnormal).

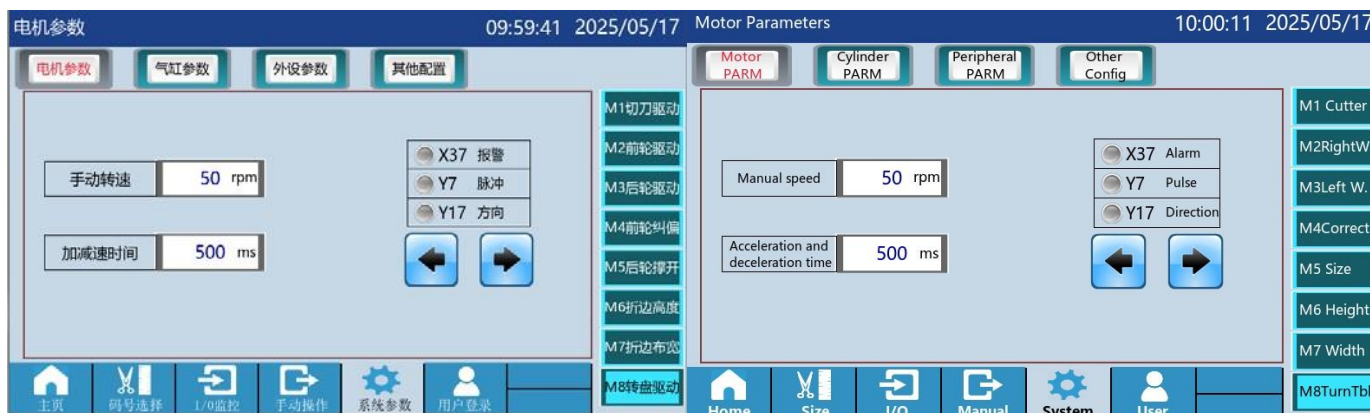
Y6 Output: Motor pulse status.

Y16 Output: Motor running direction status.

Current Position **Button**: Manually adjusts motor position.

Origin Return Button: Motor first returns to origin switch, then reaches set value after calculating origin compensation.

## 19. Turntable Drive Interface




Manual Speed **Setting**: Sets the test speed.

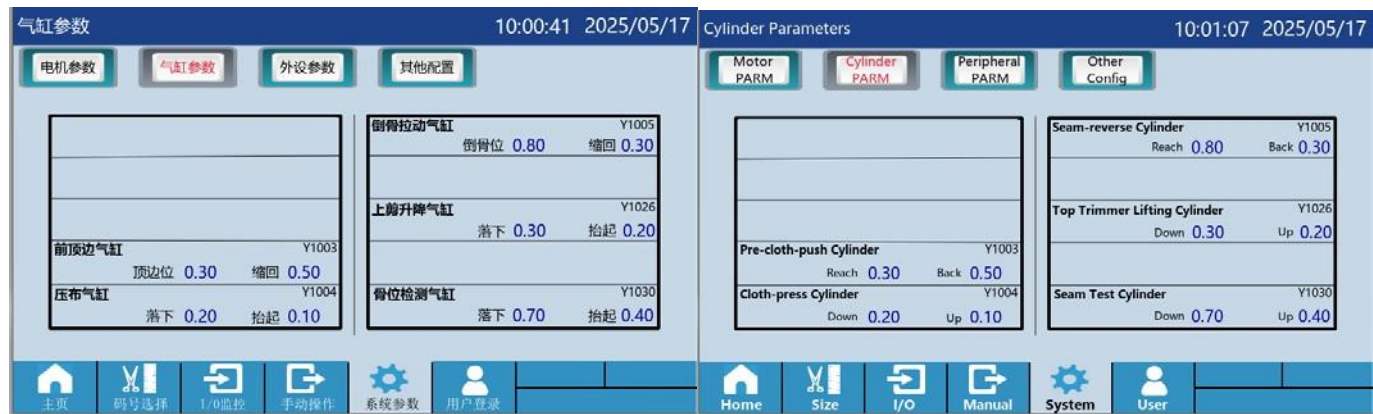
Acceleration/Deceleration Time **Setting**: Sets the duration for acceleration and deceleration processes.

X37 Input: Motor status (normal or abnormal).

Y7 Output: Motor pulse status.  
Y17 Output: Motor running direction status.

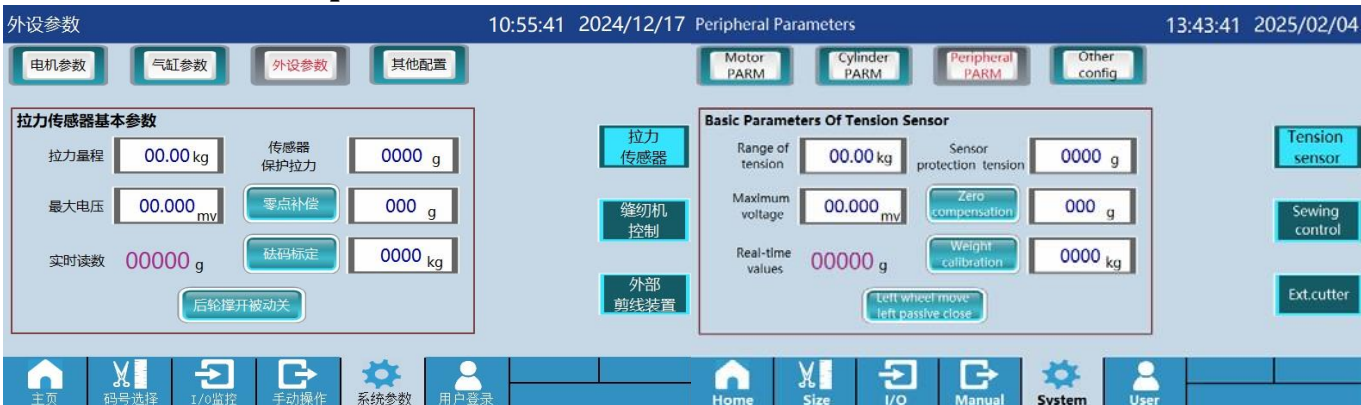
 Used for setting parameters of the turntable anti-tangling motor and conducting motor abnormality tests.

20. cylinder parameter interface



Front edge cylinder **setting**: Sets action and reset time to optimize efficiency in automatic mode.  
Fabric press cylinder **setting**: Sets action and reset time to optimize efficiency in automatic mode  
Seam pulling cylinder **setting**: Sets action and reset time to optimize efficiency in automatic mode  
Upper cutter lifting cylinder **setting**: Sets action and reset time to optimize efficiency in automatic mode.  
Seam position detection cylinder **setting**: Sets action and reset time to optimize efficiency in automatic mode.

21. Tension sensor parameter interface



Tension range **setting**: Sets the maximum measurement range of the sensor.  
  
Sensor protection tension **setting**: Sets the protection tension to prevent sensor damage from excessive tension  
Maximum voltage **setting**: Sets the voltage corresponding to the maximum range.  
Zero compensation button **setting**: Removes standby gross weight (equivalent to tare).  
Real-time reading **display**: Shows the current actual tension value.  
Weight calibration button **setting**: Calibrates using standard weights (in grams).  
Rear wheel passive **release** button: Switch for real-time rear wheel tension adjustment to maintain constant tension value.

## 22. Sewing machine control parameter interface

Maximum speed **setting**: Must match the actual speed of the sewing machine.

Minimum speed **setting**: Sets the minimum operating speed of the sewing machine.

Re-stitch low speed **setting**: Adjusts the speed for re-stitching operations.

Manual sewing speed **setting**: Configures the test sewing speed on main interface.

Manual sewing time **setting**: Sets the test sewing duration on main interface.

High-speed voltage **setting**: Default

Minimum voltage **setting**: Default

Standby voltage **setting**: Default

Actual voltage display: Default

Post-stitch thread trimming time **setting**: Sets the action interval after thread trimming

Sewing machine operation **button**: Tests sewing machine stitching function.

Thread trimming **button**: Tests sewing machine thread cutting function.

Knife suction **button**: Tests the knife waste suction function.

Knife suction **pipe cleaning button**: Tests the suction pipe cleaning function.

Sewing machine-knife sync **button**: Tests operation with synchronized knife action.

Front/rear wheel sync **button**: Tests operation with synchronized feed wheels.

Full system sync **button**: Tests operation with synchronized knife and feed wheels.

Y21 output: Sewing machine operation status.

Y22 output: Thread trimming status.

## 23. External trimming device

Upper trimming base distance **Setting**: Set the position of the suction and cutting thread under the upper thread, and adjust the material feeding position of the cutting thread.

After-Stitch trimming end position **Setting**: Set the position where the upper trimming ends and lifts

Trimming speed after sewing **Setting**: Set the speed of trimming and material feeding after sewing.

Bottom hemming set right base distance **Setting**: Set the straightening parameters after sewing.

Dust removal time **Setting**: Set the dust removal and blowing time.



Dust removal frequency **Setting**: Set the frequency of dust removal after sewing.

Upper trimming **Button**: Upper trimming working test manual switch.

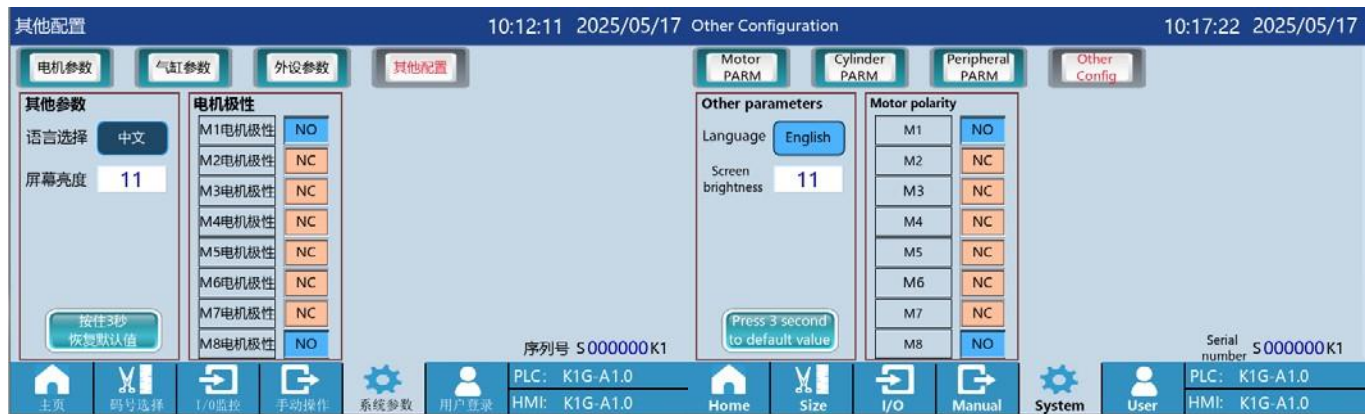
Upper trimming with lift and down dust suction **Button**: Upper trimming lift and down test suction switch.

Dust removal blowing **Button**: Upper and bottom trimming test the dust removal switch.

After-Stitch Thread Trimming Frequency **Setting**: Sets upper cutter thread trimming frequency after stitching

After-Stitch Thread Trimming Test **Button**: Tests operation according to set parameters.

## 24. Peripheral parameter interface



Language Selection **Setting**: Click to set language.

Screen Brightness **Setting**: Adjust screen brightness.

Restore Defaults Button: Press and hold for over 3 seconds to reset to default parameters.

## Function and adjustment of sensors

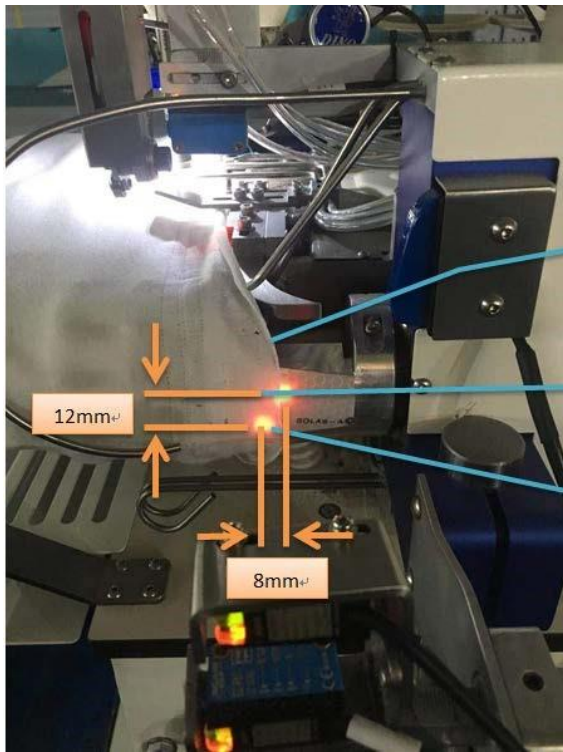
**Sensor-Inner**: After placing the material, gently push the material to cover the outer, middle and inner light eyes from outside to inside. When the eye spot of the inner light is covered, the device starts (in automatic mode), detects the signal of the scattered edge (unrolled edge) during the sewing process, and controls the size of the rolled edge and the size of the cut material edge by turning the gear inside and out.

**Sensor-middle**: Transmit the signal, when the material is half sewed (from unfolded edge to folded edge), when the material is folded, the sensor-inner facula is showed out(not covered), at this time the sensor middle transmits the signal to the sensor-outer, and sensor-outer begins to work.

Note:

1. The edge is folded again and again, adjust the sensor middle closer to the sensor-inner.
2. If the machine stops halfway (can not finish a whole circle), and adjust the sensor middle farther to the sensor-inner).

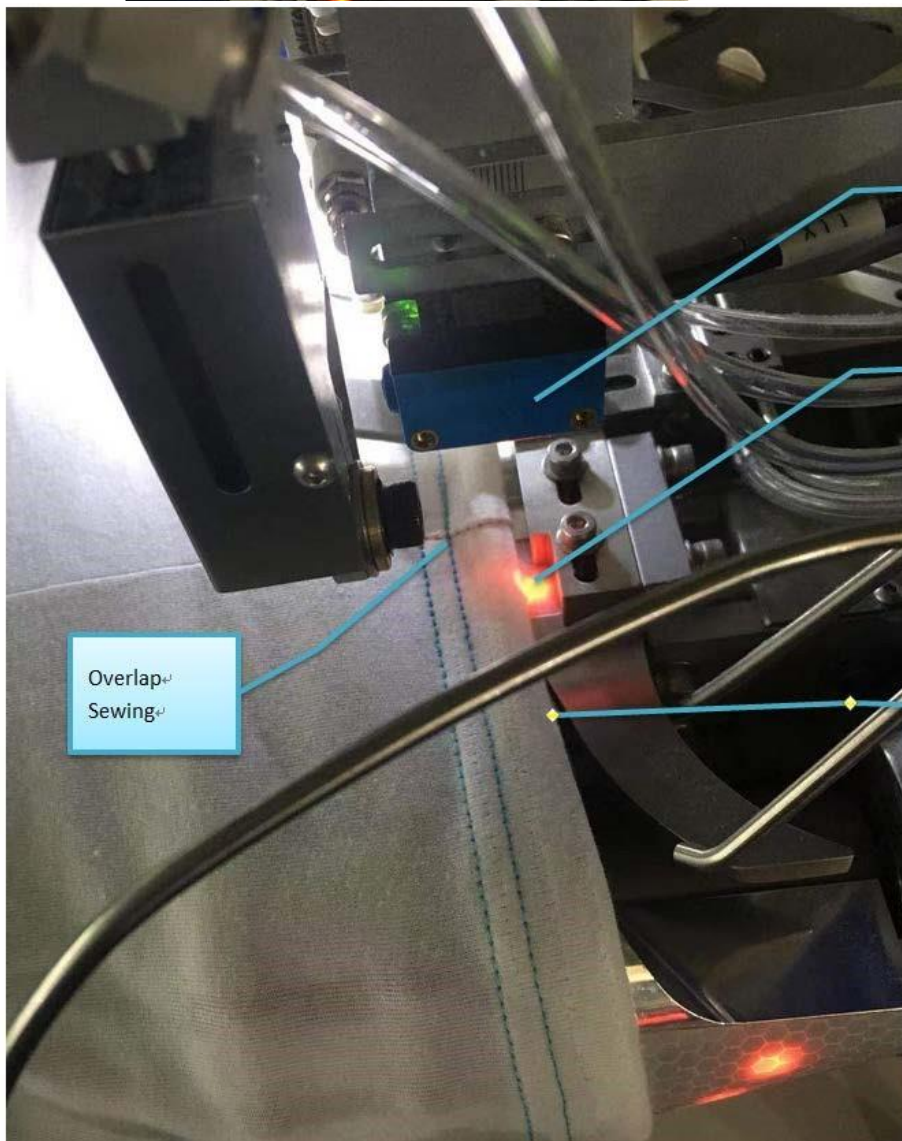
**Sensor-Outer**: After receiving the signal from the middle sensor, the sensor-outer starts to work. In this section, the sensor-inner and Sensor-middle facula is showed out(not covered), the sensor-inner and Sensor-middle is without any function, The Sensor-outer rotates inside and outside the gear to control the position after the hem and ensure the accuracy of the weight line.



Unfolded Edge runs in line with the Sensor-Inner Spot

Sensor-Inner Spot

Sensor Middle Spot



Overlap Sewing

Sensor-Outer

Outer Sensor SPOT

folded Edge runs in line with the outer sensor spot to make sure the overlap sewing exactly in line with the former path

**Seam detecting sensor:** Detect the seam sensor signal, after detecting the seam signal, the sewing machine will work after a certain distance(set on the screen) ,and detecting the seam signal again , the sewing machine will stop after a certain distance(set on the screen).

## Failure code and elimination

1. Emergency stop: Press the emergency stop switch when there is an anomaly in the sewing process, and the emergency stop will be displayed at the top of the screen, and the equipment cannot be started at this time;

Solution: Reset the emergency stop switch (rotate the switch in the direction of the emergency stop switch arrow). At this time, the red subtitles on the screen are eliminated and the device returns to normal;

2. Thread breakage alarm: During sewing process, the needle thread is broken, and the thread breakage sensor cannot detect the thread. In order to protect the material, the machine will automatically stop, and the thread breakage alarm will be displayed at the top of the screen;

Solution: After threading the thread, press the emergency stop switch and reset, the fault is removed;

3. Receiving quantity reach: When the receiving quantity of the receiving table reaches the setting quantity, the top of the screen will display the receiving quantity, prompting the collection of material; Solution: Click the key to clear the material, you can continue to sew.

4. Code to the right limit: when the left wheel is close to the machine head, after the optical sensor in the module is connected, the screen will display the code to the right limit to prevent the left wheel from continuing to move and avoid collision with the head;

Solution: Enter the code number selection interface, click the code calibration left, the alarm is lifted.

Daily maintenance and maintenance

### 1. Overall equipment maintenance requirements

Clean the dust on the surface of the equipment after work every day, and do not accumulate thread heads and cilia.

Lubricate moving parts and supporting parts of the equipment every 10-15 days.

Check the fastening and connecting parts of the equipment every month, and tighten them in time if they are loose to ensure the safe operation of the equipment.

Regular anti-rust and anti-corrosion treatment of the external and internal parts of the equipment to improve the corrosion resistance of the equipment and improve the service life of the equipment.

Periodically check the circuit of the device and clean the dust of the distribution box to avoid aging of the line or short circuit or poor contact caused by dust.

Pneumatic Circuit Diagram

