

Instruction Manual

ASK-AMT200

AUTOMATIC COLLAR SETTING MACHINE



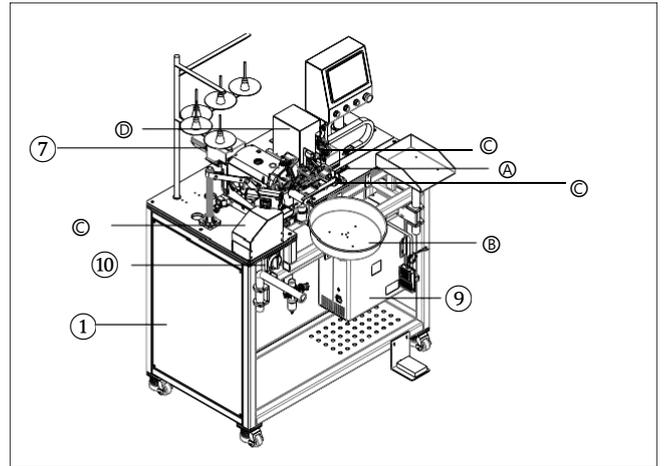
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1. Parts List

1.1. Parts List

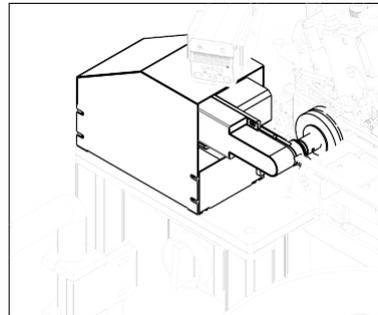
- ① Machine Frame
- ⓐ Left Roller Assembly
- ⓑ Right Roller Assembly
- Ⓐ Size Adjustment Assembly
- ⓒ Seam Seeking Assembly
- ⓓ Deviation Correcting Assembly
- ⑦ Variable Top Feed Assembly
- ⓔ Plate Assembly for Body
- ⑨ Thread Trimmer
- ⑩ Power On/Off



1.2. Parts List

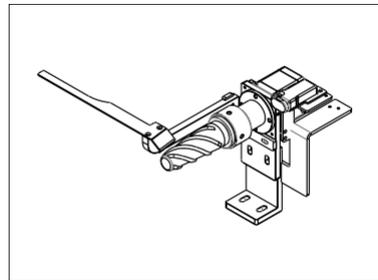
1.2.1. Left Roller Assembly

Used to synchronize stitching of body with the roller.



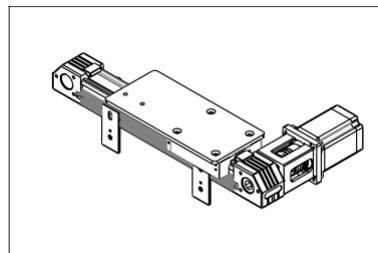
1.2.2. Right Roller Assembly

Used to synchronize stitching of body with the roller.
Actively deliver the fabrics.



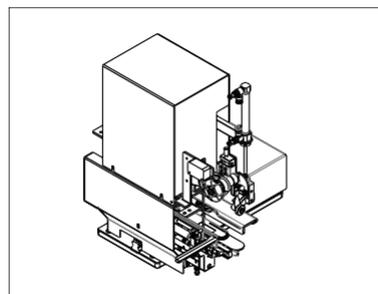
1.2.3. Size Adjusting Assembly

Used to set different sizes, and save the corresponding parameters.



1.2.4. Seam Seeking Assembly

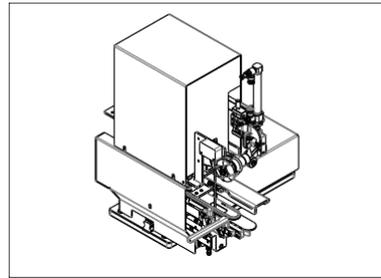
Used to seek the collar seam



1.2.5. Deviation Correcting Assembly

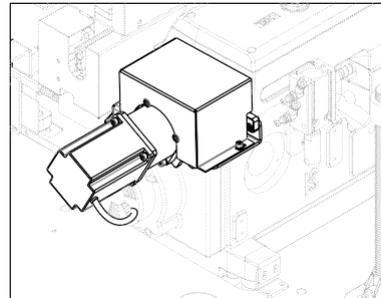
1.2.6.

Used to control the edge of the garment body



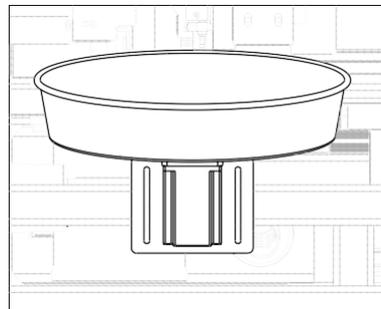
1.2.7. Variable Top Feed Assembly

Used to set the parameters of different section, Segments easing, ensure the neckline is smooth.



1.2.8. Plate Assembly for Garment Body

Used to control the synchronous rotation for garment body. Ensure smooth sewing process.



2. Technical Parameter

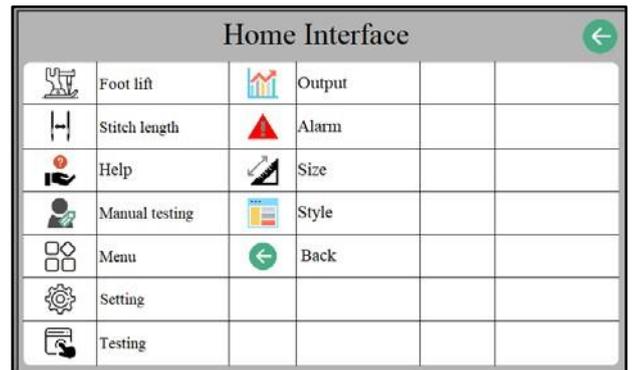
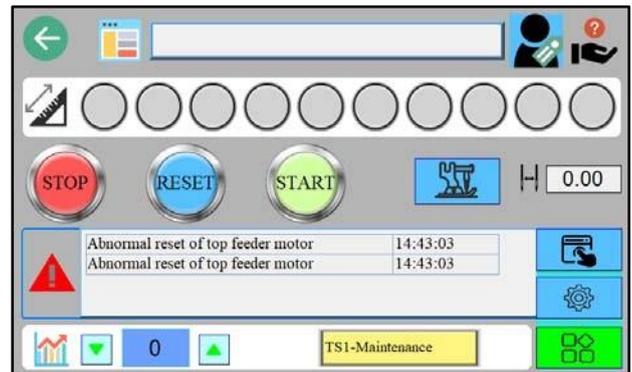
Voltage	AC 220V
Frequency	50Hz/60Hz
Power	1200W

3. Display Screen Interface Instruction

3.1. Starting Interface

Click Language icon in lower left corner to choose the needed language, then click Arrow icon in lower right corner to enter the main interface.

3.2. Main Interface



Return to last page.

Style: Click then enter the style choosing.

Manual Mode: Testing in different segments.

Help

Size

Stop, Reset, Start, Presser Foot Lift, Distance of stitches

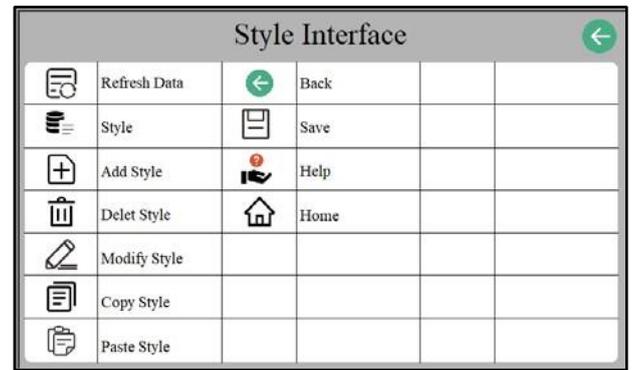
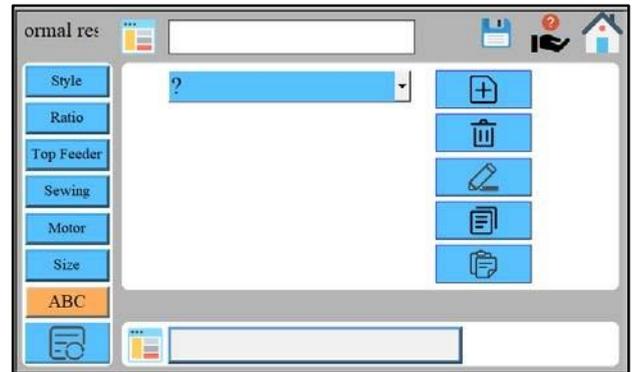
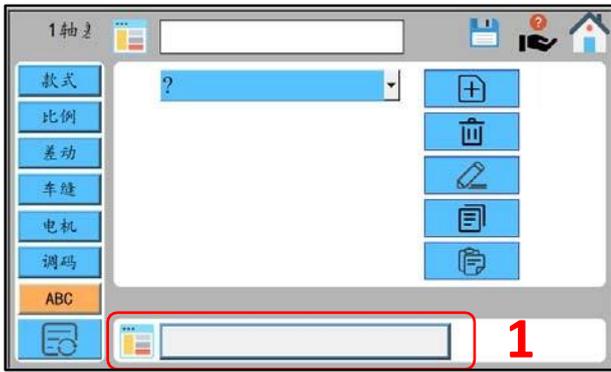
Alarm Information

Production, Adding manually, Reducing manually, Maintenance Position, Function Selection

Manual Testing, Parameter Setting

3.3. Functions Setting Interface

3.3.1. Style Setting Interface



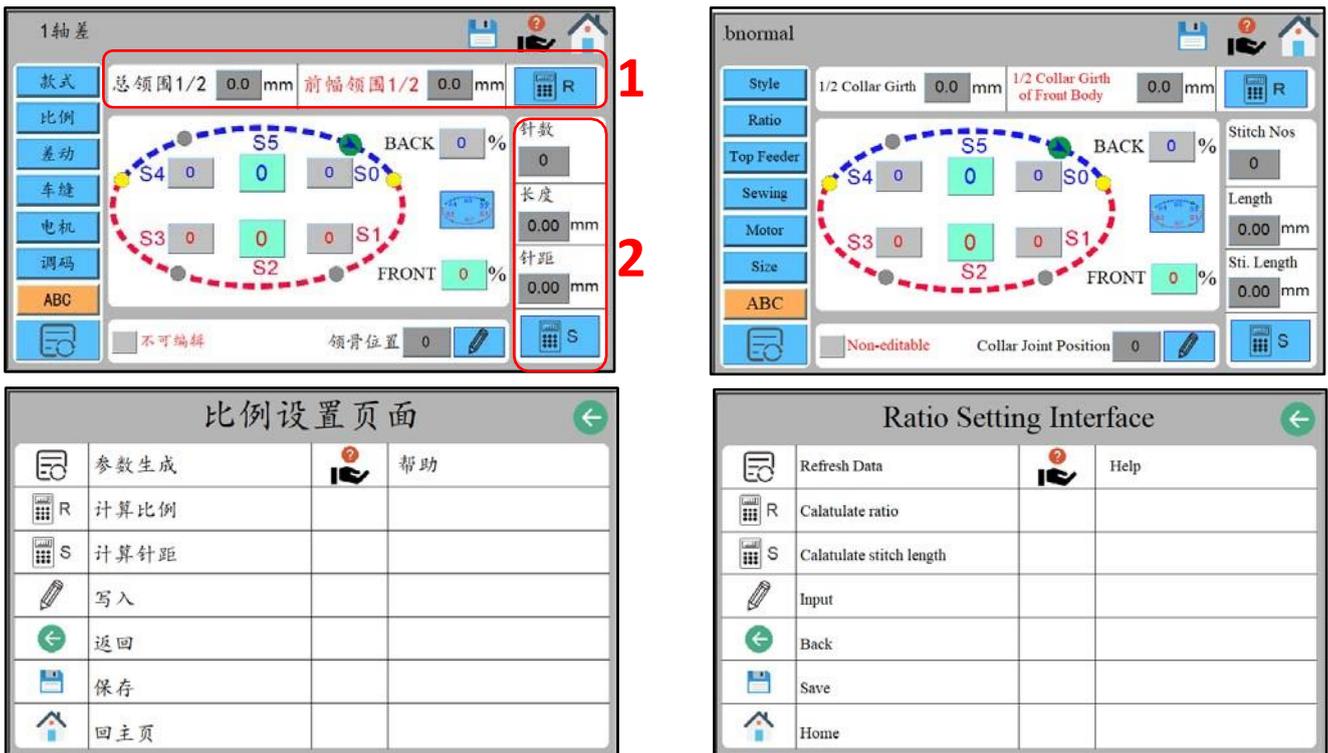
Step for adding a new style:
 Enter style name in dialog box 1
 click Add Style button
 click save button

Modify the style name:
 choose the style name that need to modify
 click dialog box 1, enter a new style name
 click the Modify Style button
 modify successfully

Step for Copying Style
 choose the style that need to be copied
 click Copy Style button
 choose the style that will be covered
 click Paste Style Button

After modifying the parameters, press the icon Identification 1, automatically generating parameters, then click Save button.

3.3.2 Ratio Setting Interface



Dialog Box 1: entering data for calculating the distance between stitches, long press corresponding button and then automatically generating parameters.

Dialog Box 2: entering data for calculating the ratio for front/back part, long press corresponding button and then automatically generating parameters.

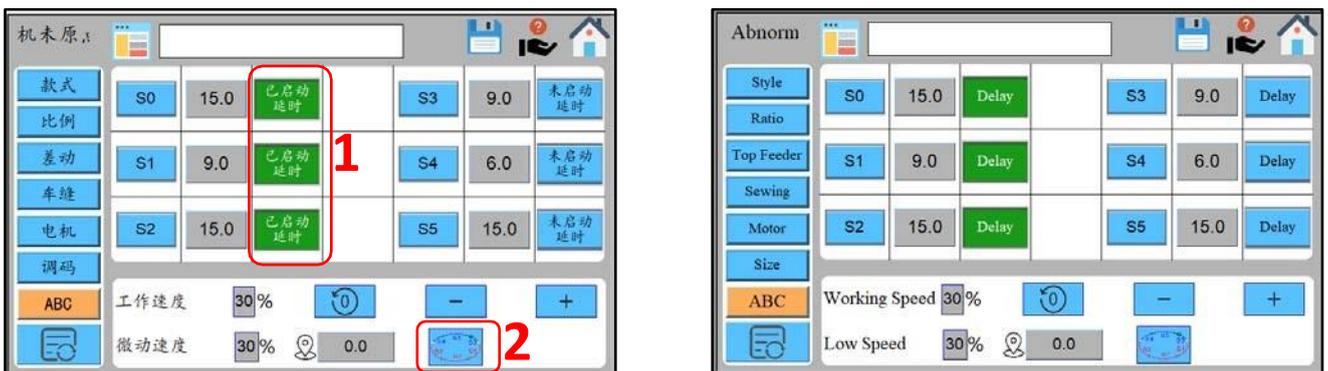
each section of front part

each section of back part

The sum of ratio for six sections is equal to 100%

After modifying the parameters, press the icon Identification 1, automatically generating parameters, then click Save button.

3.3.3 Variable Top Feed Setting Interface



差动设置页面		←
☰	参数生成	⌛ 回原点
📄	款式	
📍	当前位置	
←	返回	
💾	保存	
👤	帮助	
🏠	回主页	

Variable Top Feeder Interface		←
☰	Refresh Data	⌛ Origin Position
📄	Style	
📍	Current Position	
←	Back	
💾	Save	
👤	Help	
🏠	Home	

In dialog box 1, click can switch delay function. Blue stand for turn off, Green stand for turn on.

Default value in turn: 15、9、15、9、6、15

Running speed, top feed speed in turn: 30,30

Click dialog 2, call the layout.

After modifying the parameters, press the icon Identification 1, automatically generating parameters, then click Save button.

3.3.4 Sewing Setting Interface

动电机:												←
📄	款式	XS	S	M	L	XL	2XL	3XL	4XL	5XL	6XL	
📄	比例	S0	0	0	0	0	0	0	0	0	0	
📄	差动	S1	0	0	0	0	0	0	0	0	0	
📄	车缝	S2	0	0	0	0	0	0	0	0	0	
📄	电机	S3	0	0	0	0	0	0	0	0	0	
📄	调码	S4	0	0	0	0	0	0	0	0	0	
📄	S5	0	0	0	0	0	0	0	0	0	0	
ABC												
☰	S0	16	✎	!...	0	🕒	👤	→				

normal r:												←
📄	Style	XS	S	M	L	XL	2XL	3XL	4XL	5XL	6XL	
📄	Ratio	S0	0	0	0	0	0	0	0	0	0	
📄	Top Feeder	S1	0	0	0	0	0	0	0	0	0	
📄	Sewing	S2	0	0	0	0	0	0	0	0	0	
📄	Motor	S3	0	0	0	0	0	0	0	0	0	
📄	Size	S4	0	0	0	0	0	0	0	0	0	
📄	S5	0	0	0	0	0	0	0	0	0	0	
ABC												
☰	S0	16	✎	!...	0	🕒	👤	→				

差动转												←
📄	款式	XS	S	M	L	XL	2XL	3XL	4XL	5XL	6XL	
📄	比例	重线	45	45	45	45	45	45	45	45	45	
📄	差动	领骨	150	150	150	150	150	150	150	150	150	
📄	车缝											
📄	电机											
📄	调码											
ABC												
☰	重线针数	45	✎	!...	0							
☰	领骨位置	150	✎	!...	0							

reset of t												←
📄	Style	XS	S	M	L	XL	2XL	3XL	4XL	5XL	6XL	
📄	Ratio	Overlap Sewing	45	45	45	45	45	45	45	45	45	
📄	Top Feeder	Collar Joint	150	150	150	150	150	150	150	150	150	
📄	Sewing											
📄	Motor											
📄	Size											
ABC												
☰	Overlap Sewing Stitch Nos	45	✎	!...	0							
☰	Collar Joint Position	150	✎	!...	0							

车缝页面		←
📄	款式	🏠 回主页
✎	码数	← 返回
👤	手动测试	💾 保存
!...	针数	
☰	参数生成	
✎	写入	
👤	帮助	

Sewing Interface		←
📄	Style	🏠 Home
✎	Size	← Back
👤	Manual testing	💾 Save
!...	Stitch	
☰	Refresh Data	
✎	Input	
👤	Help	

Sewing parameter include 10 different sizes and their corresponding parameters.

Dates for S0 to S5 are automatically generated according to the pre-set parameters.

In dialog 1, after setting parameters for S0 & twice stitches, position for collar seam, hold the stroke shape button, and then the pre-set parameters will be assigned to different sizes.

Click dialog 2, call the layout.

After modifying the parameters, press the icon Identification 1, automatically generating parameters, then click Save button.

3.3.5 Motor Setting Interface

款式	名称	%	运行	纠偏方向
比例	S0-右滚轮0段	80	运行	向里
差动	S1-右滚轮1段	60	运行	
车缝	S2-右滚轮2段	90	运行	
电机	S3-右滚轮3段	70	运行	
调码	S4-右滚轮3段	80	运行	
ABC	S5-右滚轮5段	80	运行	
Icon	S6-右滚轮重线	80	运行	
	S7-纠偏速度	42	运行	
	S8-左滚轮速度	50	运行	
	S9-衫身旋转速度	12	运行	

Style	Description	%	Testing	Correction Direction
Ratio	S0-Right Roller	80	Running	CW
Top Feeder	S1-Right Roller	60	Running	
Sewing	S2-Right Roller	90	Running	
Motor	S3-Right Roller	70	Running	
Size	S4-Right Roller	80	Running	
ABC	S5-Right Roller	80	Running	
Icon	S6-Right Roller	80	Running	
	S7-Correction	42	Running	
	S8-Left Roller	50	Running	
	S9-Body Rotating	12	Running	

Default parameters for S0-S9 are shown in the figure.

After modifying the parameters, press the icon Identification 1, automatically generating parameters, then click Save button.

3.3.6 Size Setting Interface

款式	XS	S	M	L	XL
比例	0.0	0.0	0.0	0.0	0.0
差动	✎	✎	✎	✎	✎
车缝	2XL	3XL	4XL	5XL	6XL
电机	0.0	0.0	0.0	0.0	0.0
调码	✎	✎	✎	✎	✎
ABC	工作速度 50 %		微动速度 50 %		
Icon	L1-调码伸缩量 0.0 mm				

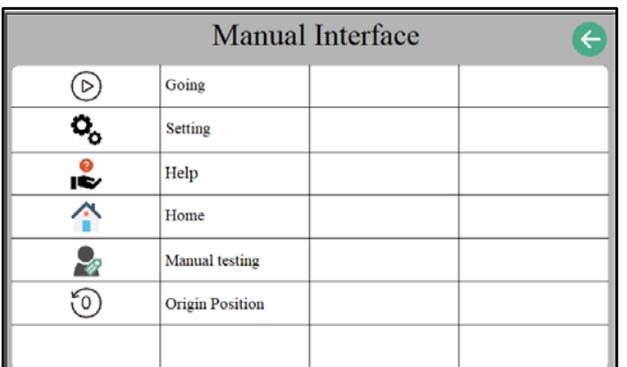
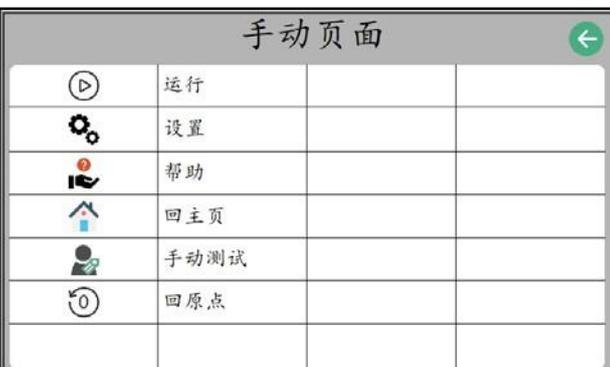
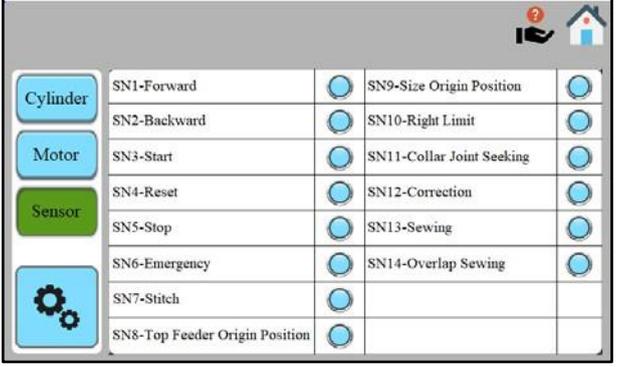
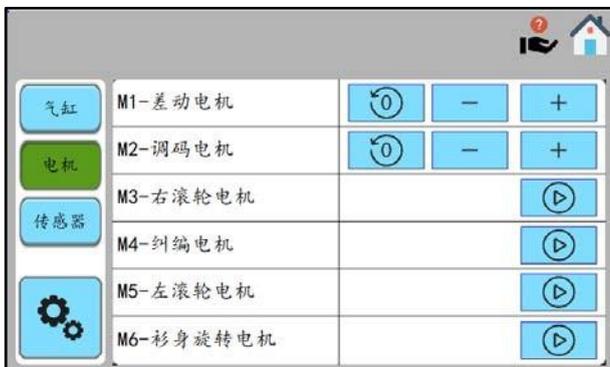
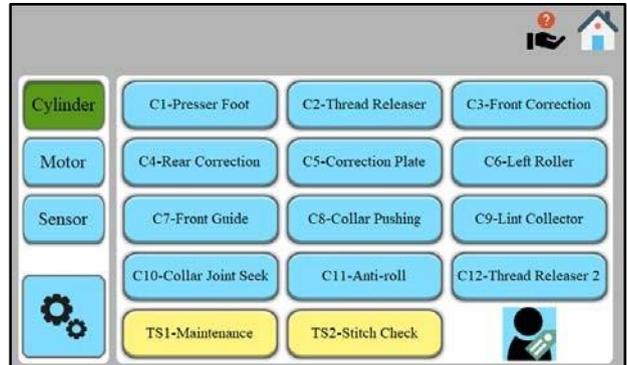
Style	XS	S	M	L	XL
Ratio	0.0	0.0	0.0	0.0	0.0
Top Feeder	✎	✎	✎	✎	✎
Sewing	2XL	3XL	4XL	5XL	6XL
Motor	0.0	0.0	0.0	0.0	0.0
Size	✎	✎	✎	✎	✎
ABC	Working Speed 50 %		Low Speed 50 %		
Icon	L1-Size Expansion 0.0 mm				

调码页面	
款式	保存
回原点	帮助
当前位置	回主页
参数生成	
写入	
修改码数	
返回	

Size Interface	
Style	Save
Origin Position	Help
Current Position	Home
Refresh Data	
Input	
Modify Size	
Back	

Long press Modify Size button, the button colour is changed from blue to green. Then click Size to modify the size name. After modifying, long press Modify Size button, then button colour is changed from green for blue. Click again Size, choose different size and corresponding setting. After modifying the parameters, press the icon Identification 1, automatically generating parameters, then click Save button.

4. Manual Interface



Used to manually test whether the operation of cylinder and motor & signal of sensor are normal or not.

4. General Faults and Solutions

Item	Faults	Solutions
1	Collar Not Good	Check the distance between the needles. Segment ratio is normal or not. Start the manual mode, and check the segment knots is correct or not.
2	Misjudgment of Collar Joint	Adjust the limit screw of the rotating cylinder. When the thickness gap of the fabric is big, it is necessary to find the height of the bone bearing detection point again.
3	Interface Error	Reset

