

Preface

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

The user manual is for our newly developed “Automatic Platform Roll Hem Machine”products reference manual,
Please read this manual carefully,hope it can give you useful help!

Before reading the manual,please note the following requirements:

- 1: The user must be reliably grounded before operation to ensure personal safety!
- 2: Non-professionals do not disassemble the control box;
- 3: The control box and the motor are far away from the strong magnetic and high radiation environment;
- 4: Do not work in an overheated environment (ambient temperature during operation: $-20^{\circ}\text{C}\sim 50^{\circ}\text{C}$);
- 5: Do not work in an excessively humid environment (humidity during operation: 20%~90%);
- 6: (1) The default power supply voltage of this device is 220V when it leaves the factory [The rated voltage is between 200V and 240V when 220V is connected to the power supply]
(2) If you need to use 110V electric control: [When 110V is connected to the power supply, the voltage is stable between (100V~120V) (need to switch through the switching power supply)]

Safety requirement:

- 1: Do not put your feet on the pedals when the motor is switched on.
- 2: Let professionals to install and debug this product .
- 3: Do not open the control box and the motor cover when energized
- 4: Please turn off the power when changing the needle,threading or replacing the bottom line
- 5: During installation and removal service,please turn off the power
- 6: Please turn off the power when turn lift sewing machine
- 7: Use this product, please stay away from high-frequency electromagnetic wave and wave transmitter, so as to avoid the electromagnetic wave interference servo driver and wrong action.

Warranty policy:

- 1、 Since from the purchase of this product,the free 1-year warranty,lifetime maintenance. During the warranty period,any quality problems the product will be free repaired,except artificial damage.
- 2、 Without our consent disassemble or modify,the damaged will not give in warranty.
- 3 、 Whenever find the problem can not be solved,you can contact with our company.

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Automatic Elastic Band Attaching Machine introduction

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Safety measures

Thank you for purchasing this equipment. Please read this manual carefully before starting any procedures.

Then use the equipment correctly and safely.

Keep this manual in a convenient place for quick reference when needed.

1. Introduction

- This manual describes the instructions for using this unit safely.
- Study this manual very carefully and understand fully how to operate, check, adjust and maintain the labor saving unit before beginning any of the procedures.
- You always perform operations close to moving parts such as needles when using industrial sewing machines. Therefore you have to keep in mind you could easily touch them. To prevent accidents, it is essential that you use the safe products supplied by Sakgo correctly.
- All the people who will use automatic unit must study this manual and the instruction manual for sewing machines very carefully and then take necessary safety measures before beginning any of the procedures.

Be sure to study very carefully for safety

2. Indications of dangers, warnings and cautions

To prevent accidents, indications (symbols and/or signs) which show the degree of danger are used on our products and in this manual.

Study the contents very carefully and follow the instructions.

Indication labels should be found easily.

Attach new labels when they are stained or removed.

Contact our sales office when new labels are needed.

Symbols, signs and/or signal words which attract users' attention.

Symbols and messages

 危険 DANGER	表示对生命或肢体的直接危害	Indicates an immediate hazard to life or limb.
 警告 WARNING	表示对生命或肢体的潜在危险	Indicates a potential hazard to life or limb.
 注意 CAUTION	表示可能导致伤害或损坏的错误	Indicates a possible mistakes that could result in injury or damage.

	Be sure to follow the instructions when you operate the machine and/or labor saving device.
	Never do this.

Safety precautions

① Applications, purpose

The automatic unit is designed to increase quality and productivity according to your needs.

Therefore never use the device for the applications, which may defeat the above purpose.

② Circumstances

Some circumstances when you are using the automatic unit may affect its life, function, performance, and safety.

For safety, do not use the automatic unit under the circumstances below.

1. Do not use the device near objects, which make noise such as a high-frequency welder, etc.
2. Do not use or store the device in the air, which has vapor from chemicals, or do not expose the device to chemicals.
3. Do not leave the device outside, in high temperatures or the direct sun.
4. Do not use the device in high humidity or ambient temperatures, which may affect them.
5. Do not use the device on the condition that the voltage fluctuation range is more than $\pm 10\%$ of the rated voltage.
6. Do not use the device at the place where the supply voltage specified for the control motor cannot be properly obtained.
7. Do not use the device at the place where the air supply specified for the device cannot be properly obtained.
8. Do not expose the device to the water.

③ Safety measures

(1) Safety precautions when you perform maintenance on the automatic unit.

- When performing maintenance such as when checking, repairing, cleaning the automatic unit, turn off the power, disconnect the power plug from the outlet and press the machine treadle in order to make sure the machine does not run.

If you have to perform maintenance on the machine and/or automatic unit with the power on, always be careful because the machine and/or device could start operating unexpectedly.

To prevent accidents caused by incorrect operation, you should establish your own procedures for safe operation and follow them.

-  • Only well-trained people should perform routine daily maintenance and/or repair the machine and/or device.

- Do not modify the machine and device yourself.

※ Consult your local Sakgo' sales office or representative for modification.



(2) Before operating the device

Before operating the device, check the machine head, machine unit and device to

If so, repair or replace any defective parts immediately.

(3) Training 

To prevent accidents, operators and service maintenance personnel should have proper knowledge and skill for safe operation.



Do not modify the equipment by yourself.

SAKGO does not assume all the responsibility caused by the

1 Machine appearance and parameters



Over-lock stitch

Sewing Size- 35-70CM Air

Pressure 0.4 Mpa

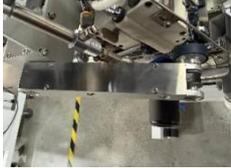
Touchscreen display

Automatic Thread Trimmer

2 Description of machine parts

NO	Part position adjustment	Function description
1		<p>Air pressure regulating valve Used to control the amount of air entering</p>
2		<p>Power switch Used to control the large-scale switching on and off of power.</p>
3		<p>Sewing machine electronic control system Used to adjust the sewing machine's motion parameters and to debug the operation.</p>
4		<p>Solenoid valve assemblies are used to control cylinder movements.</p>
5		<p>Fixing device The device is removed for threading.</p>
6		<p>Indicator lights indicate whether the touchscreen power display is normal.</p>
7		<p>Buzzer Emergency alarm function after pressing the emergency stop button</p>

8		<p>Rotary emergency stop switch Stop button is used to stop the operation during operation.</p>
9		<p>Start button (English) Starts the machine to run.</p>
10		<p>Lighting lamps are used for wiring to increase brightness</p>
11		<p>Micro motion sensor</p>
12		<p>Used for the function of a cylinder in a bone-picking device</p>
13		<p>Position sensor Used to detect the function of rubber band joints</p>
14		<p>Origin sensor</p>
		<p>proximity sensor</p>

		Material detection sensor
		Fabric pusher cylinder
		Auxiliary wheel

Main page description



NO	SETTING	SETTING DESCRIPTION
1	Stitch pitch	The distance the fabric travels when sewing one stitch (this parameter affects the overall speed of the left and right wheels at the start of sewing).
2	Right-wheeled scale	The larger the overall proportion of the right wheel synchronization during sewing, the faster the speed.
3	Needle starting position	How many more MMs will walk after bone retrieval?
4	Revolver proportions	The larger the overall proportion of the left wheel synchronizing during sewing, the faster the speed.
5	Heavy line position	Re-stitching after sewing

6	Roundabout distance	After sewing is finished, the needles are sucked up by a rotary suction device.
7	Loose line position	Distance parameters of loose line
8	Start using the scissors	How many stitches should the sewing machine perform before cutting the thread?
9	Reposition	The equipment returned to its initial point.
10	The threading loose shaft is closed	Once turned on, the motor enable will be turned off, and the motor can be pushed by hand.
11	Select type	Switch to the selection screen

Code Number Page Description

SAKGO 01/06/26 15:57:33 上腰机设备

Model selection	
brand	Yardage
0	0

Branding: 0

Yardage: 0

New

Delete

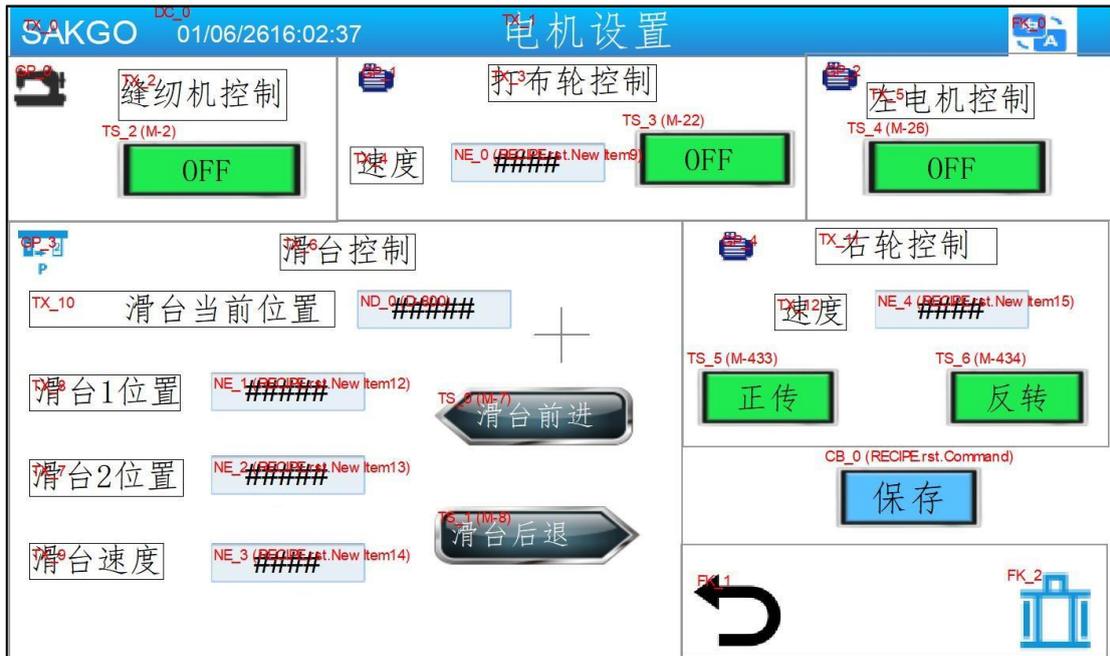
The current position of the slider: 0

Change the slide position: 0

Save

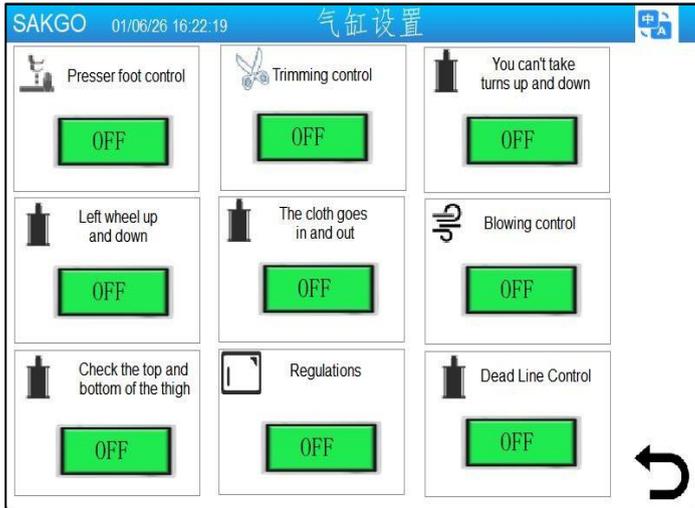
NO	SETTING	SETTING DESCRIPTION
1	Branding	Brand name change (select a style name to change)
2	Yardage	Change code name (select a code name to change)
3	The current position of the slider	Current position of the slide motor
4	Change the slide position	Initial feeding position of the slide motor
5	Save	After selecting a style, you need to save it; otherwise, the parameters will not be written to the system.

Motor settings page instructions



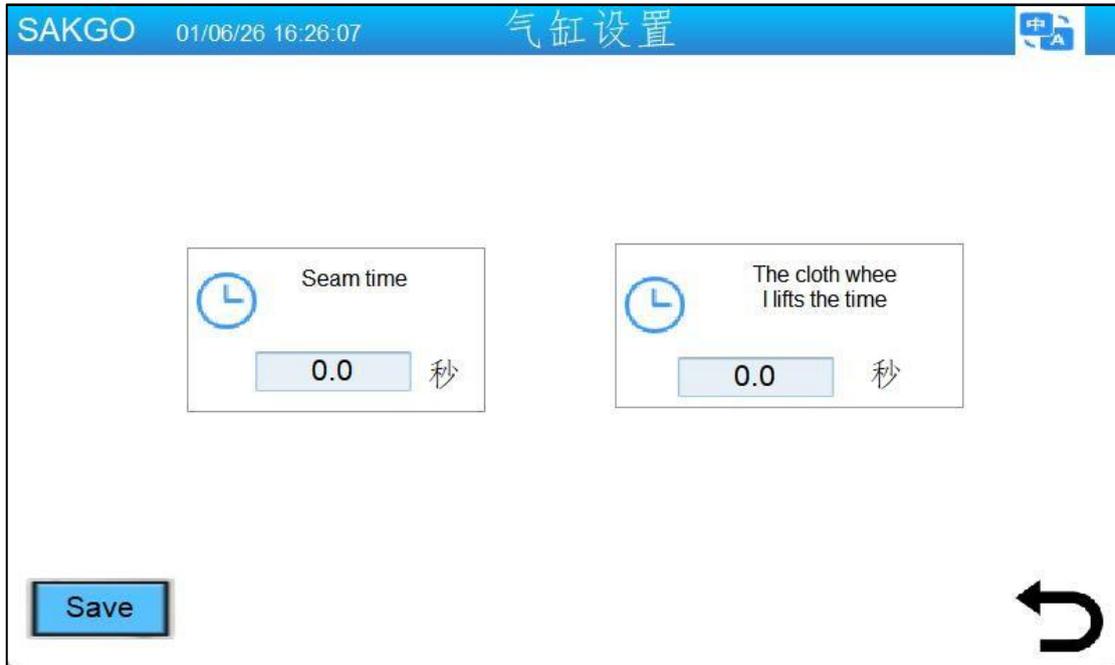
NO	SETTING	SETTING DESCRIPTION
1	Sewing machine control	Start the manual sewing machine
2	Slide 1 position	The position that automatically opens when the start button is pressed
3	Slide 2 position	The position of the stretch when sewing is almost finished
4	Slide speed	Slide speed

Cylinder Setup Instructions



NO	SETTING	SETTING DESCRIPTION
1	Presser foot control	Control the presser foot to lift/lower its position.
2	Trimming Control	Controllable cutting action.
3	Cloth Wheel Lift/Lower Control	The cloth wheel has the function of lifting/lowering.
4	Auxiliary Wheel Lift/Lower Control	The auxiliary wheel lowering/raising action.
5	Lower Cloth Feeding Position Control	It serves to end the reset process.
6	Air Blowing Control	The function of adjusting the amount of air blown through the trachea.
7	Presser Lift/Lower Control	The function of the cylinder for lifting/lowering the tube.
8	Guide Position Control	Fixing the width of the elastic band and ending the push-out function.
9	Idle Thread Control	Control wire clamp conversion

Time setting instructions



NO	SETTING	SETTING DESCRIPTION
1	Seam time	Delayed lifting time of the cloth wheel, in seconds.
2	The cloth wheel lifts the time	Time of starting the fabric rolling machine, in seconds.

How to use a machine

- 1、 Connect the air source to the circuit and press the power switch.
- 2、 Check whether the signal lights on the touch screen and the signal lights of each sensor are normal. If the signal input can be received normally and displayed as normal; you can check whether the sensor has a signal input by checking the PLC on the circuit board.
- 3、 Select the desired language to enter the main screen; enter the parameter setting, generally there are already debugged parameters by default, but the data needs to be modified in conjunction with the actual processed fabric.
- 4、 Enter manual mode and confirm that each manual function is correct.
- 5、 After making sure that there is no error,e, place the fabric to be processed on the rightmost conveyor belt, and click the start button.
- 6、 The machine will automatically detect and process the fabric, and automatically collect the material after sewing.
- 7、 Check the fabrics titch and the width of the hem, you can adjust it appropriately.
- 8、 When there is a problem in the sewing process, please press the red stop button to stop immediately.
- 9、 If there is a stall or equipment alarm, please power off and restart; if the fault persists, please contact the manufacturer for after-sales maintenance of the machine.

The device adjust description

Diagram	Explanation
	<p>Pull out the removable fixing device for threading.</p>

8、 Error code analysis

Fault code	Fault description	Causes of failure	Fault solution
ER-03	break line	break line	Check the thread and re-thread it
ER-04	break line	break line	Check the thread and re-thread it
ER-05	break line	break line	Check the thread and re-thread it
ER-06	break line	break line	Check the thread and re-thread it
ER-07	break line	break line	Check the thread and re-thread it

8、 Packing list

Name	Quantity
Hemming sewing machine	1