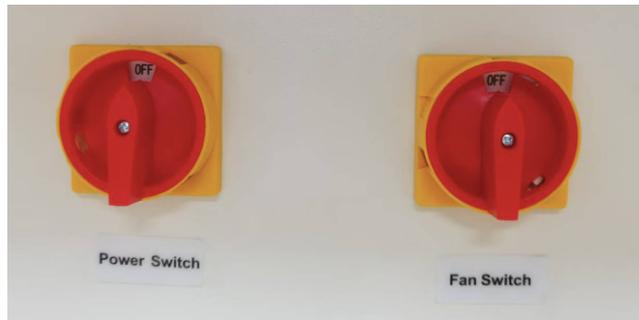


**Automatic Polo Placket Setter Machine**  
**ASL-APO200**  
**Operation Instructions**

## 1. Start the machine

- 1) Turn on the “**Power switch**” and “**Fan switch**” (for air suction function. The air pressure is set to 0.5-0.6 Mpa) → The monitor will be turned on simultaneously and enter the Home page interface.

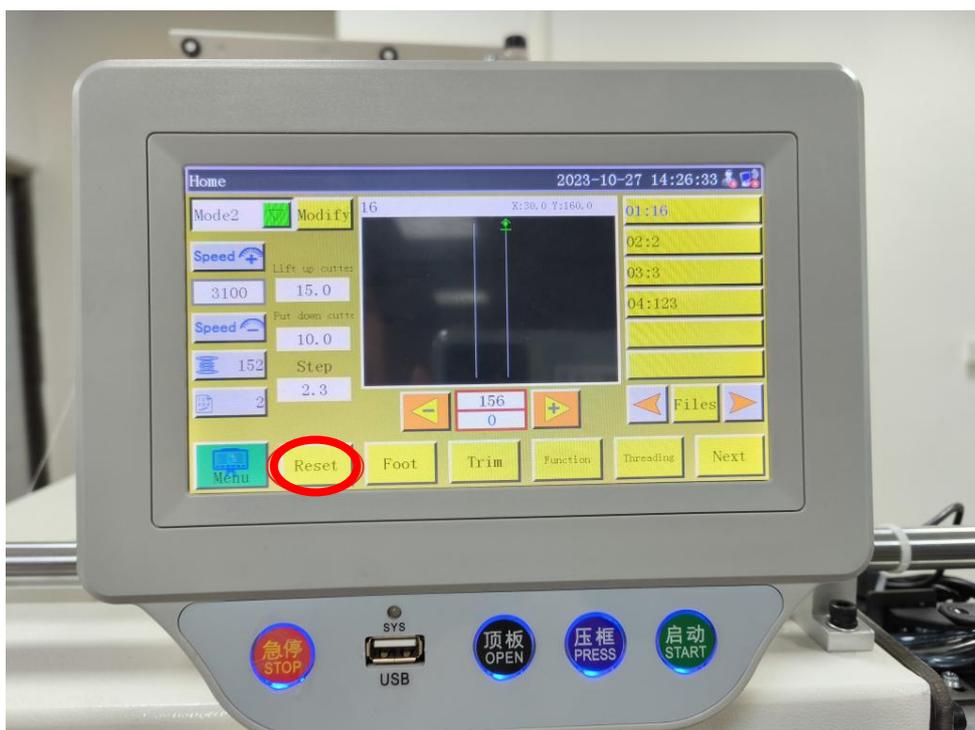


**Ensure the air go into the automatic sewing machine is clean and dry.**

**If the air come with water, it'll damage the machine seriously !!!**

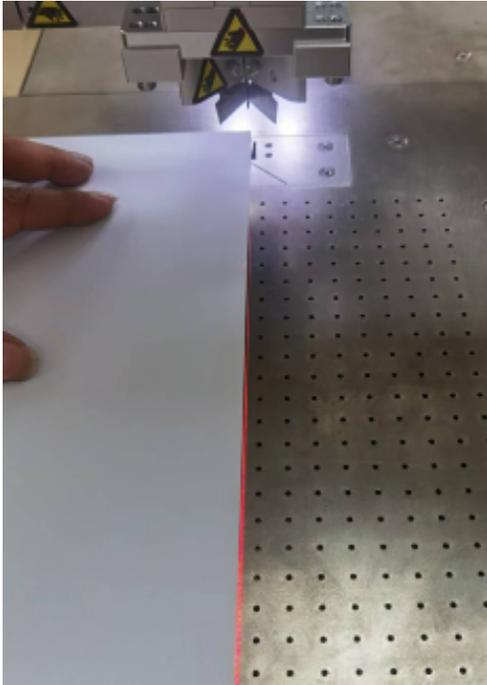
Check from the glass tan, you can see if the air with water or not.

- 2) Before production, click “Reset” every time when the machine is turned on or any data in the control system was changed. Please refer to video “1. How to start the machine.mp4”.

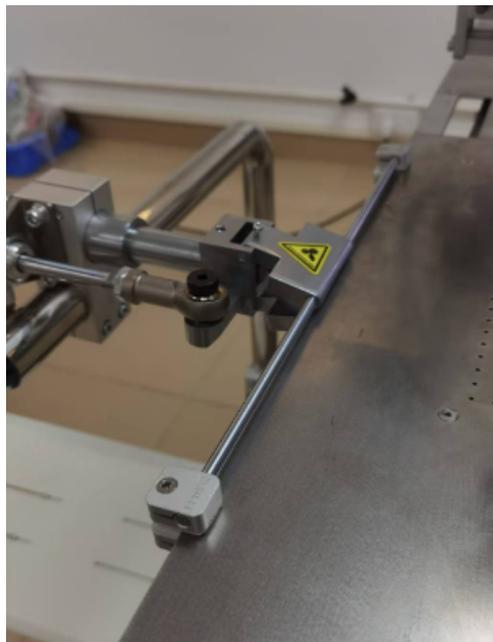


## 2. Machine debug

- 1) Infrared position. Adjusted the sewing area (left side) infrared position first. Make sure the red line is in the center of cutter. Set up this as basic position to adjust the right-side infrared later.



- 2) Adjusted the right-side infrared position. Please refer to the video "2. How to adjust the right side infrared light.mp4".
- 3) Adjusted the collecting jig position. Make sure the clamp can slightly hold the table edge parallelly.



- 4) Check the distance between feeding plate and two big pressing plates is around 1cm. Please refer to video “3. How to adjust the feeding plate position.mp4”



### 3. Start the production

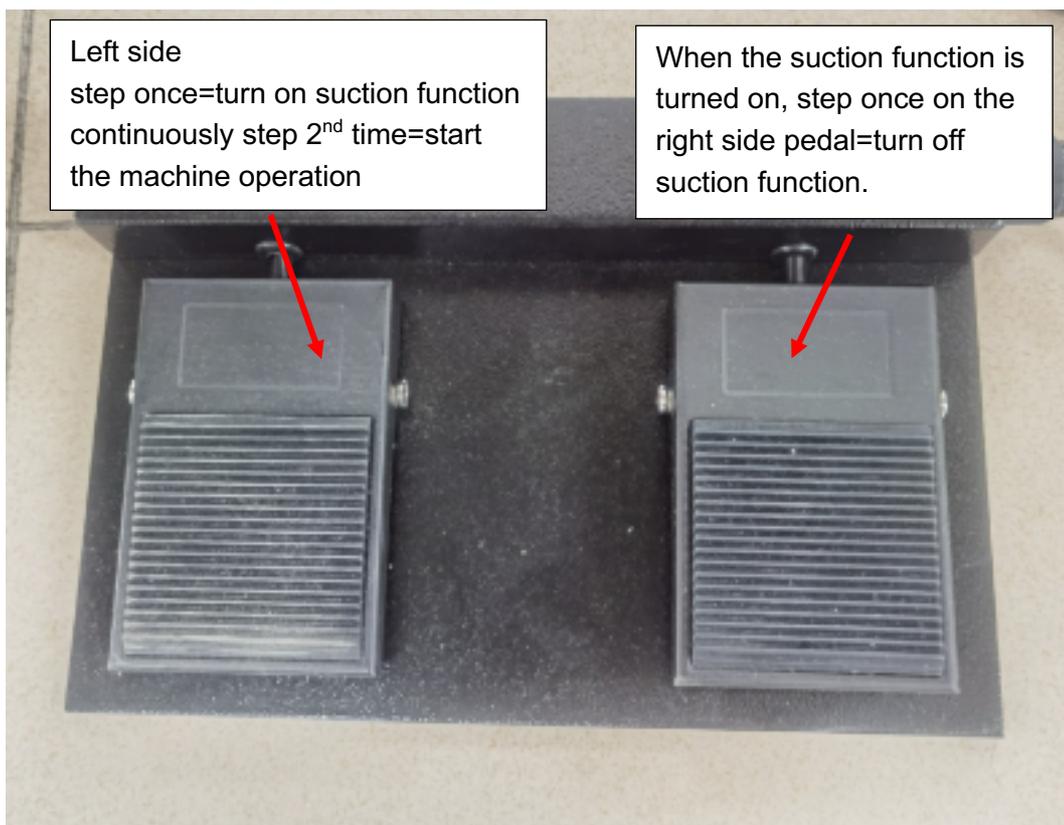
- 1) Click “Reset” on the Home Page.
- 2) Lay on the cutting piece on the working table with suction holes area.



- 3) Select the style you need from the control system, which is on the right top of the Home Page.



- 4) Step once on the left pedal, start suction function. Continuously step 2<sup>nd</sup> time on the left pedal, start the operation. The machine will automatically finish sewing, cutting and collecting. Step once on the right pedal (cancel suction function).





(sewing results)

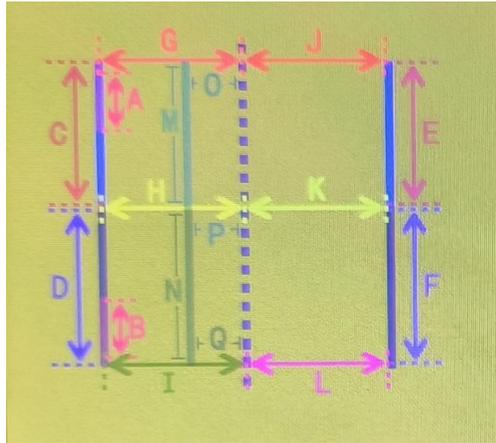
**4. Sewing patterns switch. Please refer to video “5. How to modify and create new pattern.mp4”.**

**Operation:** Select the pattern from the menu list (01, 02, 03) on the right top of the Home Page. You can check the style display on the small window. Click “Modify”, then adjust the preset parameters according to the actual requirements.



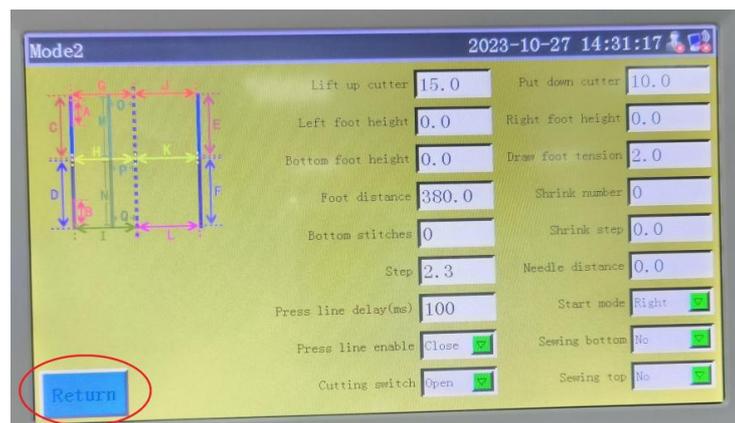
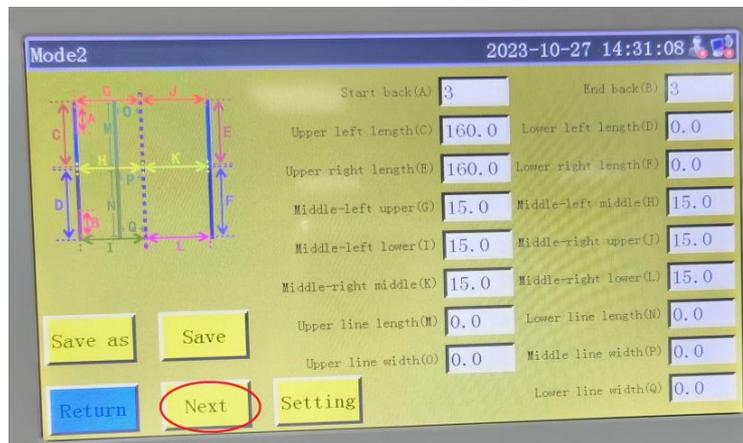


(adjust the preset parameters according to the actual requirements)

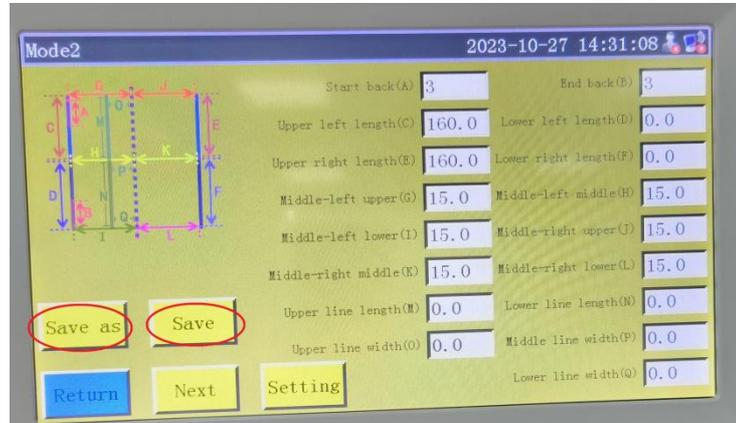


- |                        |                         |
|------------------------|-------------------------|
| (A) Start back         | (J) Middle-left upper   |
| (B) End back           | (K) Middle-right middle |
| (C) Upper left length  | (L) Middle-right lower  |
| (D) Lower left length  | (M) Upper line length   |
| (E) Upper right length | (N) Lower line length   |
| (F) Lower right length | (O) Upper line width    |
| (G) Middle-left upper  | (P) Middle line width   |
| (H) Middle-left middle | (Q) Lower line width    |
| (I) Middle-left lower  |                         |

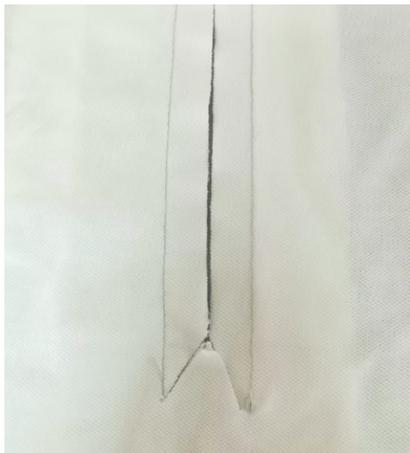
Click **“Next”** to the next page. Revised the parameters accordingly, then click **“Return”**.



After modifying the settings, click **“Save”** to save the data, or click **“Save as”** to create a new pattern. Click **“Return”**, go back to the Home Page. Click **“Reset”** to ready the machine.



The sewing results.

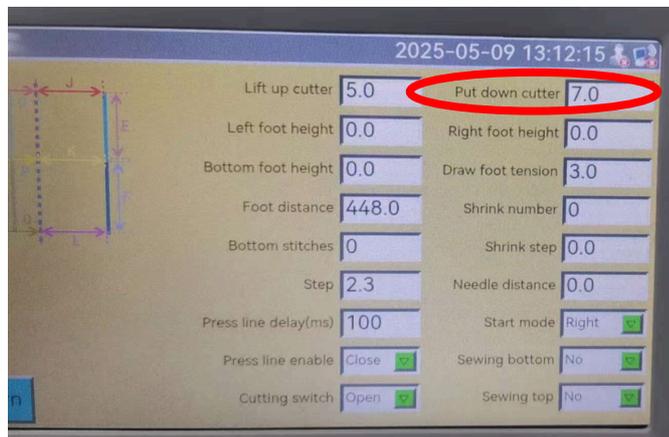
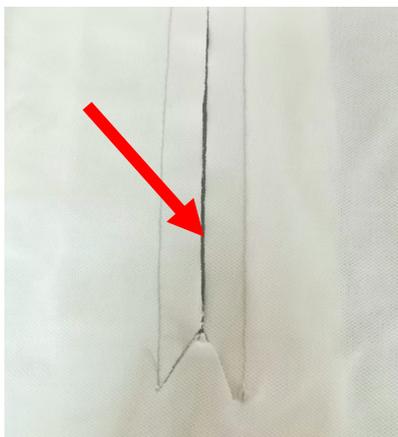


(parallel lines)



(V lines)

If you want to adjust the central knife cutting position, revise the figure in **“Put down cutter”**.

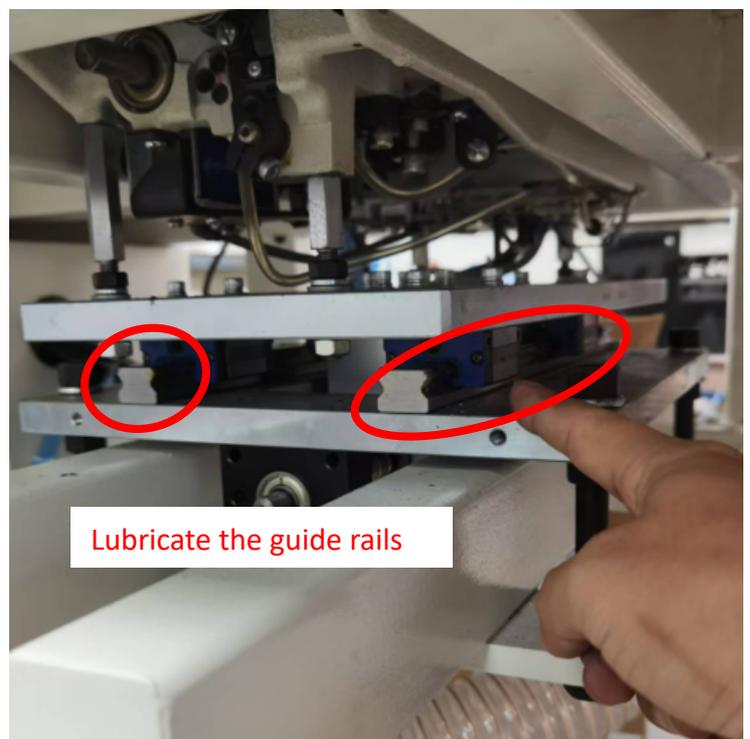
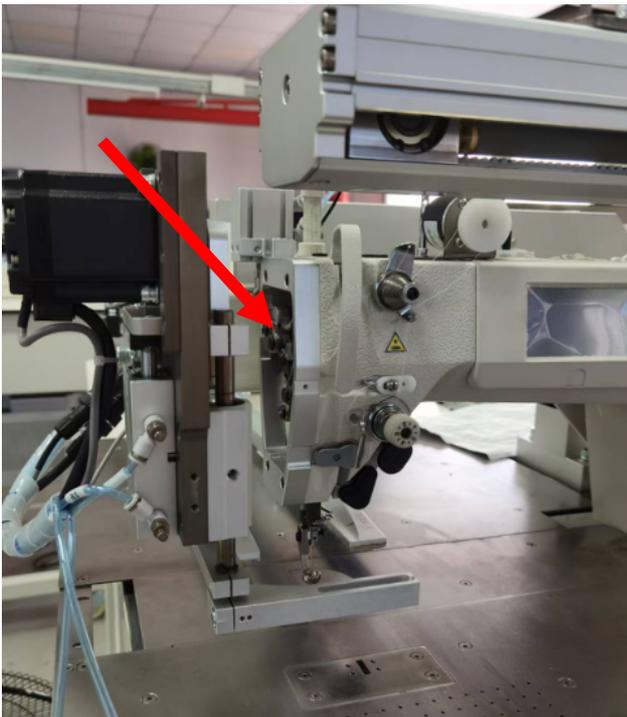


**5. It's important to set the auto counting function. (When the machine matched with bobbin thread breakage detection function, this function is optional and up to your application requirement.)**

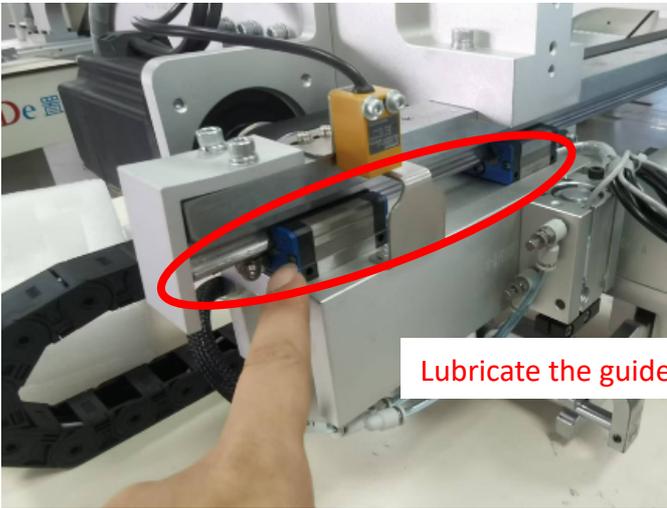
- 1) Once you set up the auto counting function, the machine will stop automatically when reach the "Total length of the bobbin thread".
- 2) Operation: please refer to video "6. How to set the auto counting function.mp4".

**6. Maintenance.**

- 1) Lubricated the machine every half year or according to your actual usage. Please add grease on the area shown in **red circles** as below.



Open the cover



Lubricate the guide rails



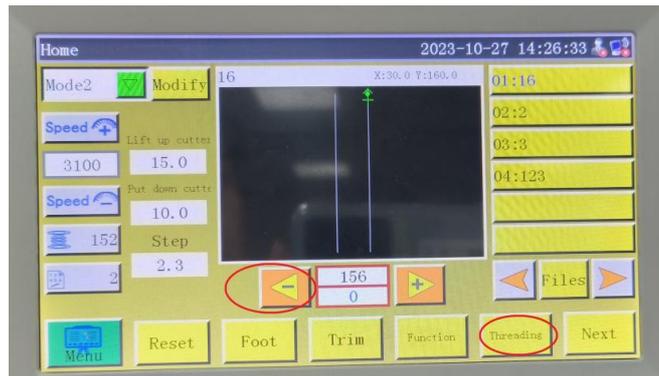
2) Open and clean the filter inside every week.



## 7. FAQ

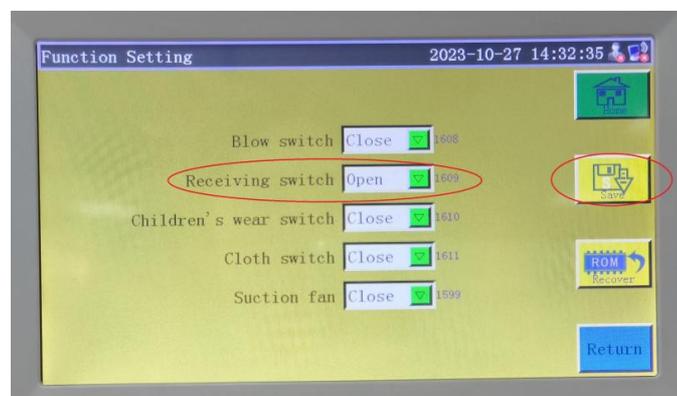
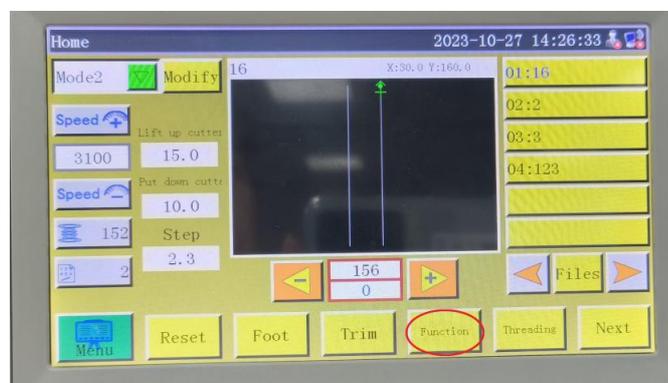
1) How to do when the machine was stopped due to thread breakage?

Click **“Threading”** on the Home Page. The needle protector will go down and expose the needle hole. After finished threading, continuously click **“←”**. The needle will go back to previous stitching stop position. Finally, click **“START”** on the monitor frame, the machine will go on unfinished process.



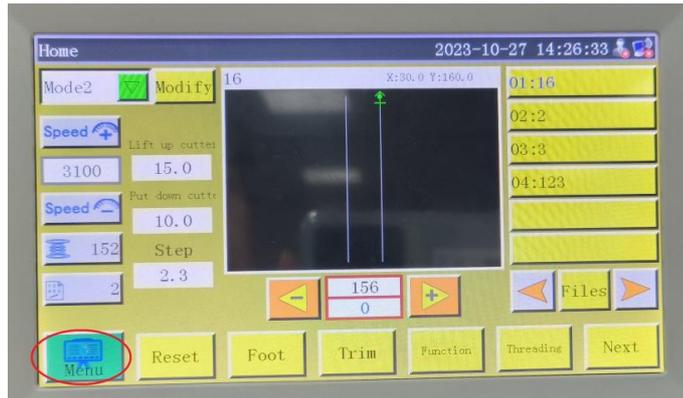
2) How to stop the auto collecting function?

On the Home page, click **“Function”**, select open/close from **“Receiving switch”**. Click **“Save”**-**“Return”**.

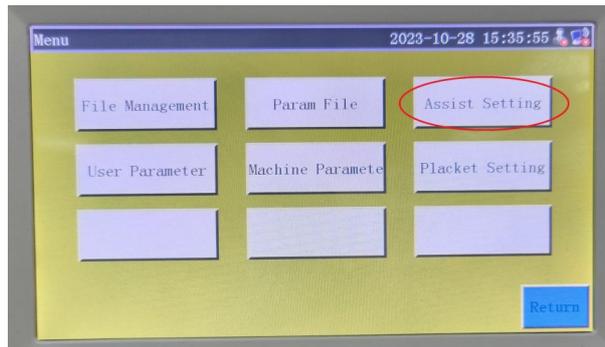


3) How to change the language?

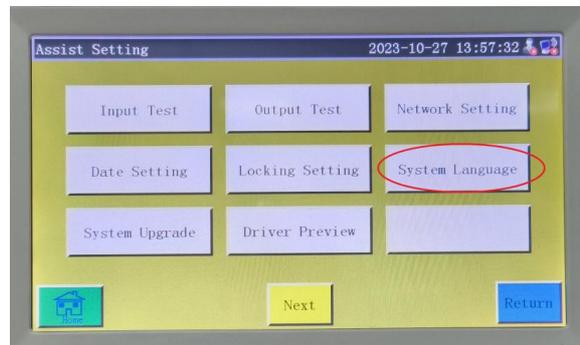
On the Home page, click **“Menu”**.



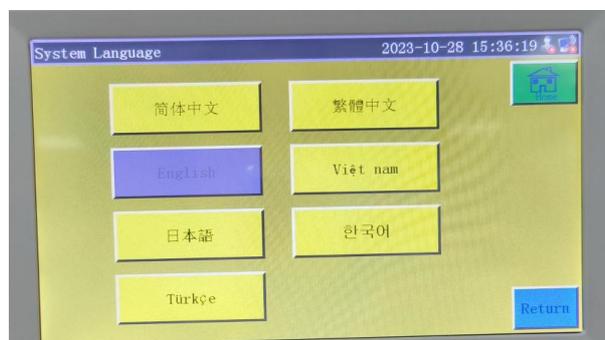
Click “Assist Setting”



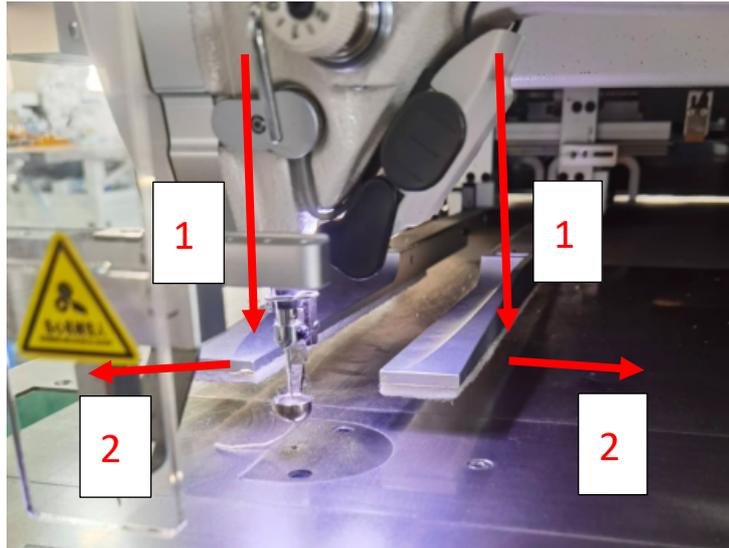
Click “System Language”



Select the language you need, then click “Save”- “Return”- “Return”- “Return”.

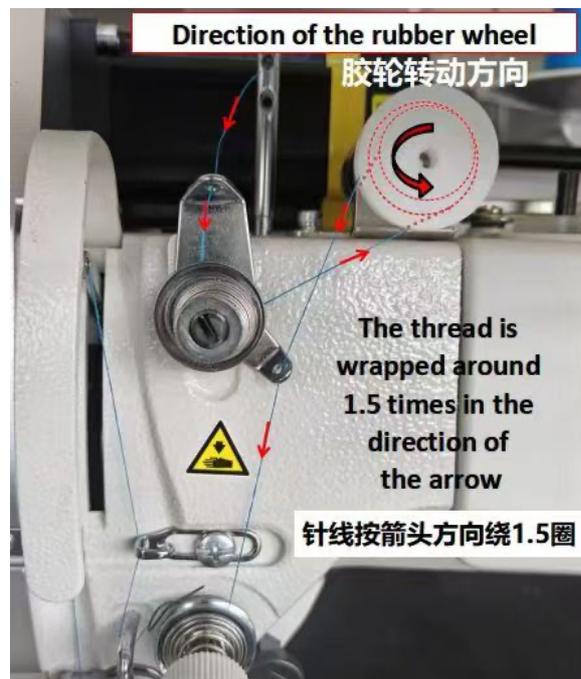


4) How to adjust the presser foot stretching distance? Please refer to the video “9. How to adjust the presser foot stretching distance?”



The presser foot will stretch the fabric a little, so the stitching and cutting will be more neatly and beautiful.

- 5) How to change from single knife to double knives? Please refer to videos “How to change from single knife to double knives.mp4(1) & (2)”.
- 6) How to thread for machine with bobbin thread breakage detection function?



Please refer to video “12. How to threading for machine with/without Bobbin Thread Breakage Detection Function.mp4.”

- 7) How to sharpen the Y cutting blade? Please refer to the video “13. How to sharpen the Y cutting blade?”
- 8) How to sharpen the upper knives?  
We use special hard material for the central single/double knives, so sharpen with sandpaper is not workable. You have to use grinding machine.



- 9) How to adjust the sensitivity of bobbin thread breakage detection? Please refer to video “14. How to adjust the sensitivity of bobbin thread breakage detection.mp4”.
- 10) How to turn on/off the pre-feeding function? Please refer to the video “15. How to turn on the pre-feeding function.mp4”.

Warranty service is limited to under normal use and maintenance, which follow the “Operation Instruction”, the “Installation Manual” and all the videos manufacturer provided.

When you have any questions or problems, please contact the sales immediately. We will try to solve your problems as soon as possible. Thanks for purchasing!