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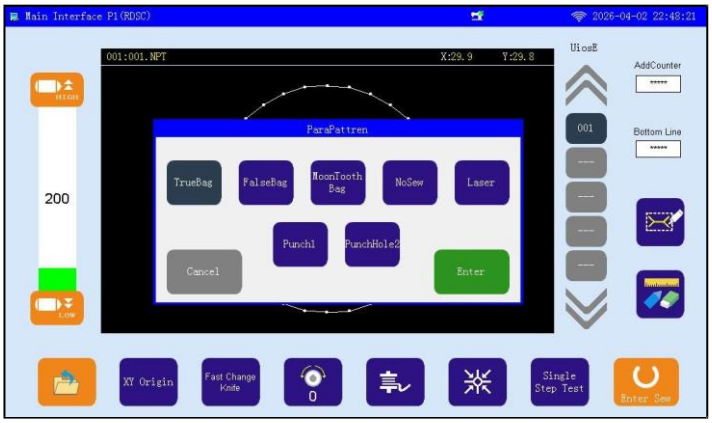
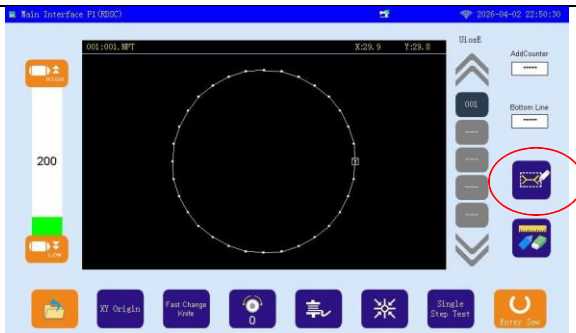
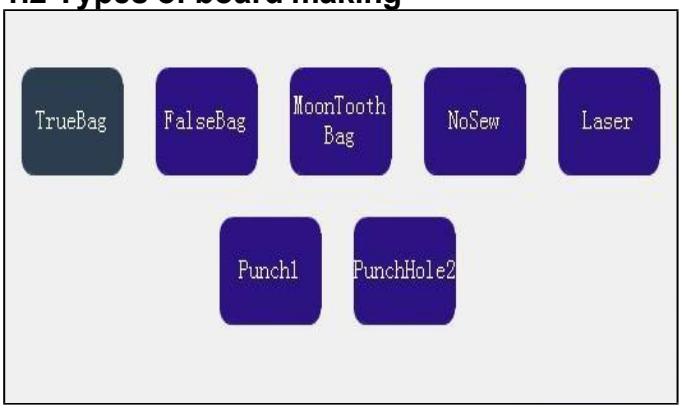
Chapter 1 Parameter Board Making



1.1 Entry Method

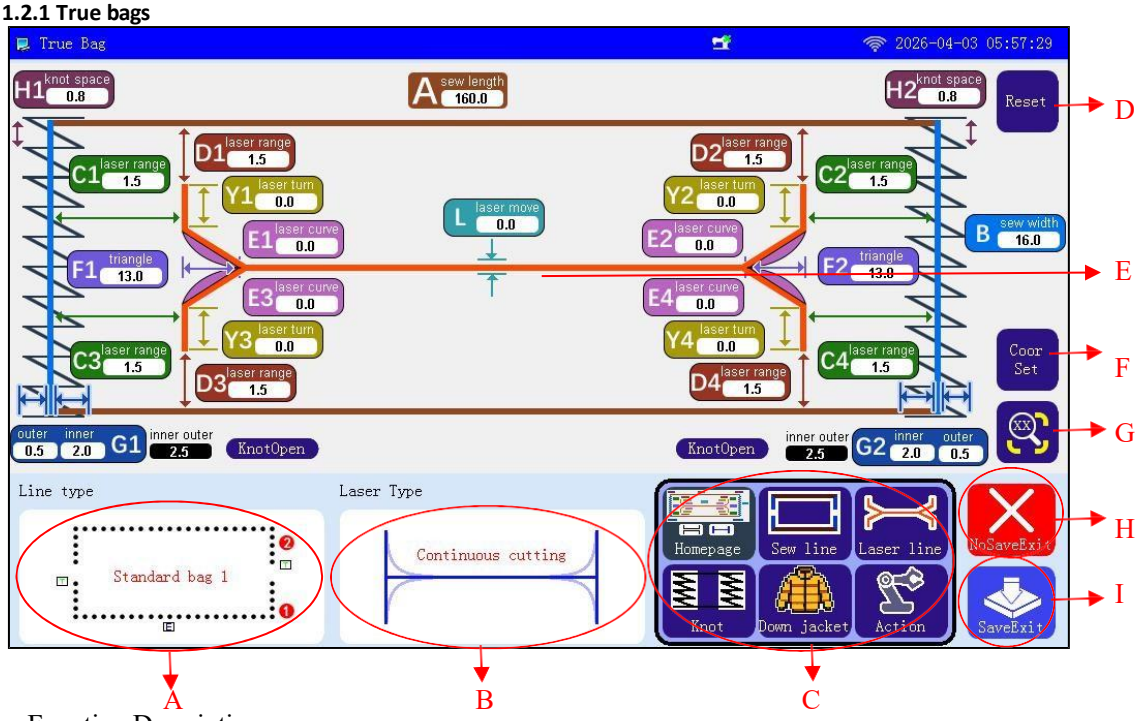
1. Click the "Parameter Printing" button on the main interface.	
2. Enter the "ParaPattren" interface.	

1.2 Types of board making



There are a total of 7 types of parameter printing: True bag, Flase bag, Moonthbag, Nosew, laser, punch1, puncHole 2.

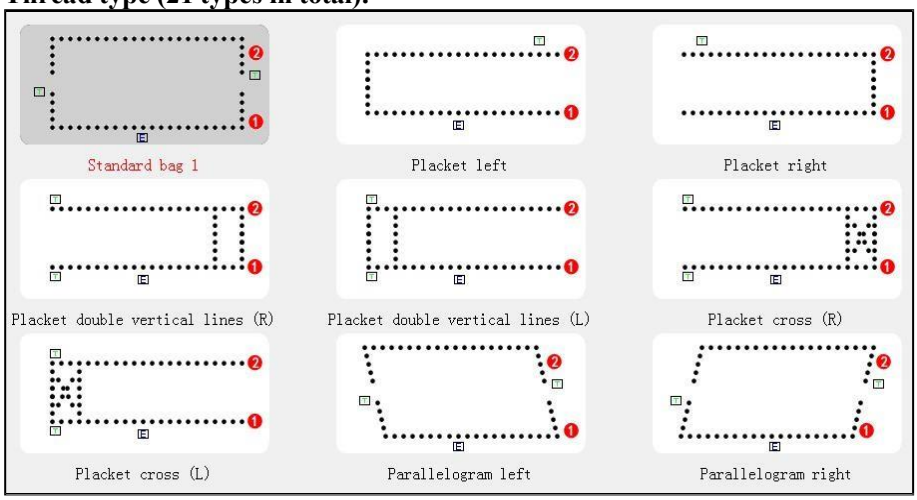
1.2.1 True bags

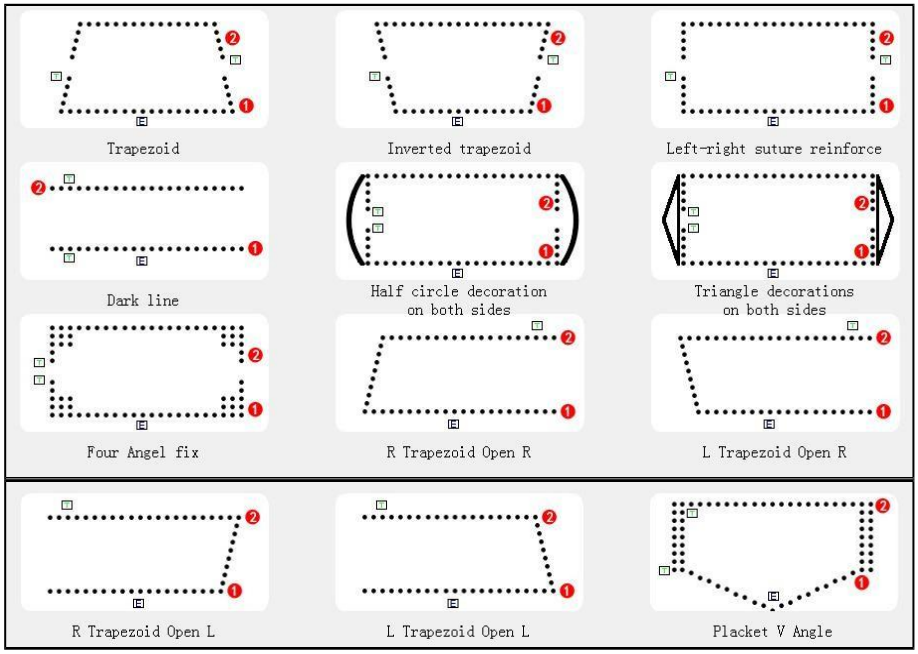


Function Description:

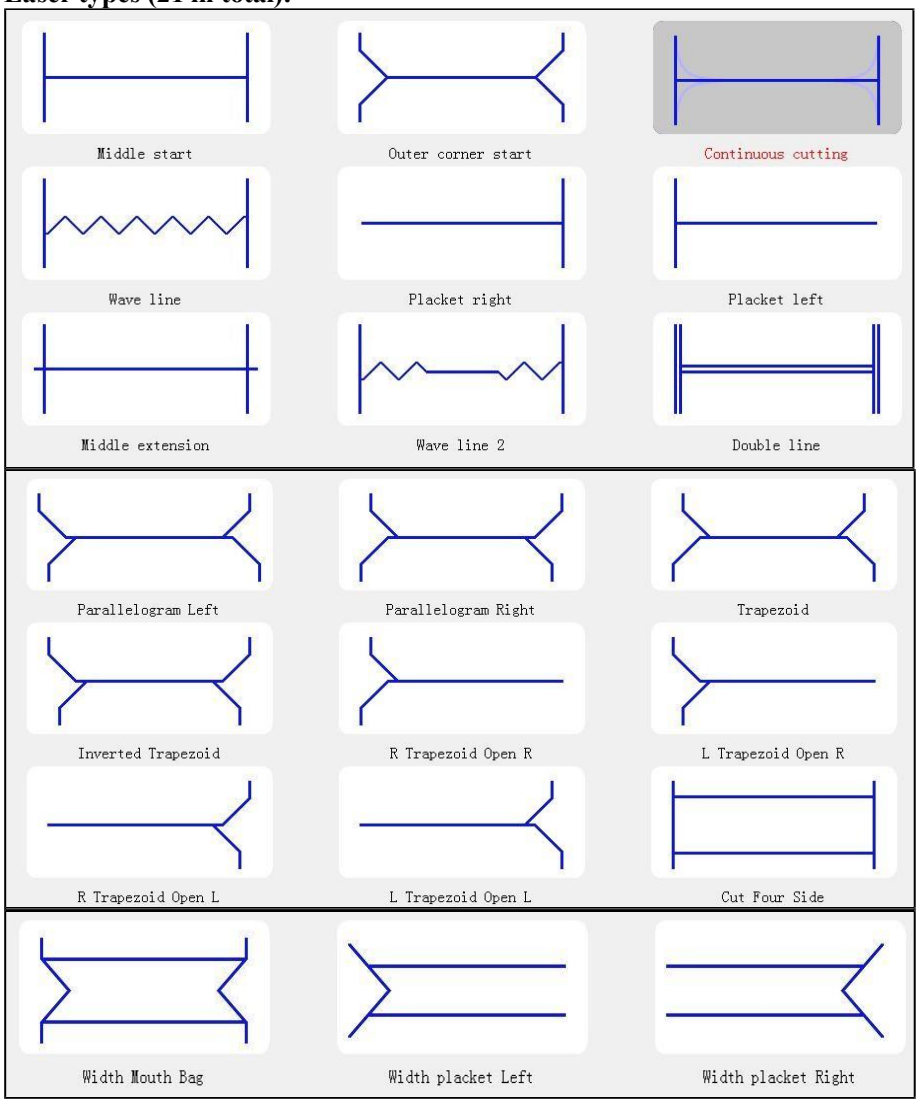
serial number	function	content
A	stitch type	There are a total of 21 types of wires
B	laser type	21 types of lasers in total
C	Switch function interface	Switch between homepage, sewing thread, laser thread, knotting, down jacket, and action interface.
D	Restore Default	Restore default parameters
E	Graphic Template	Display the current graphic template
F	Coordinate setting	Set laser center, pattern center offset, etc
G	preview	Preview of printed graphics
H	exit	Exit the settings interface
I	save	Save current parameter settings

Thread type (21 types in total):

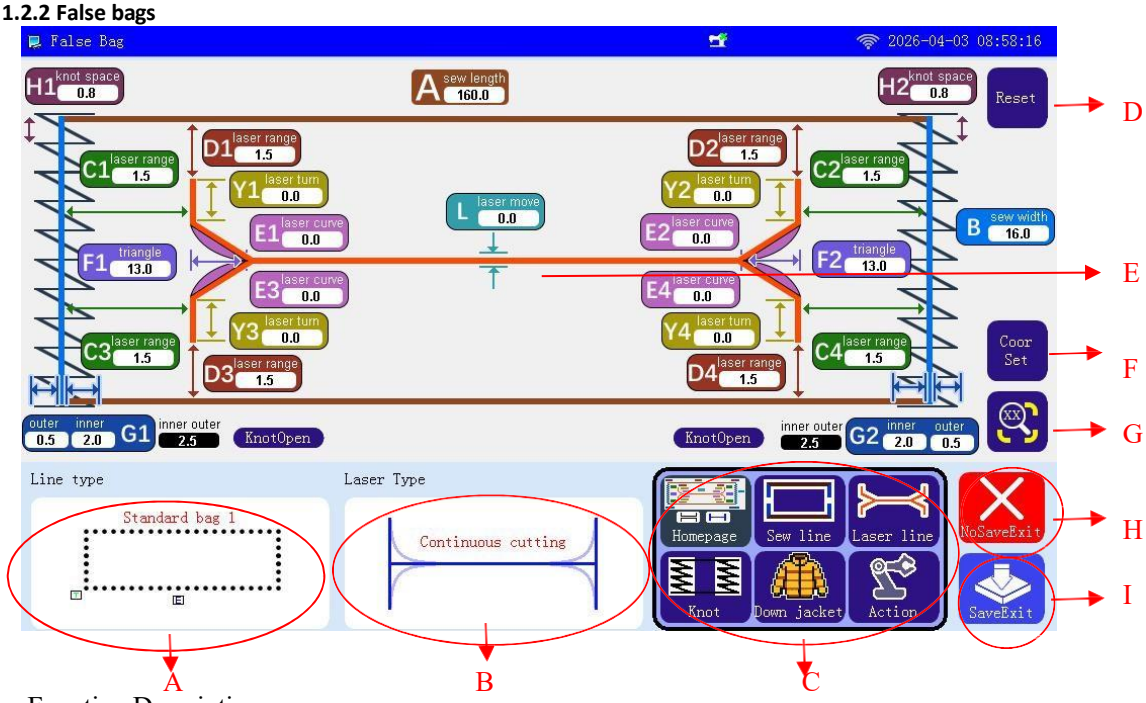




Laser types (21 in total):



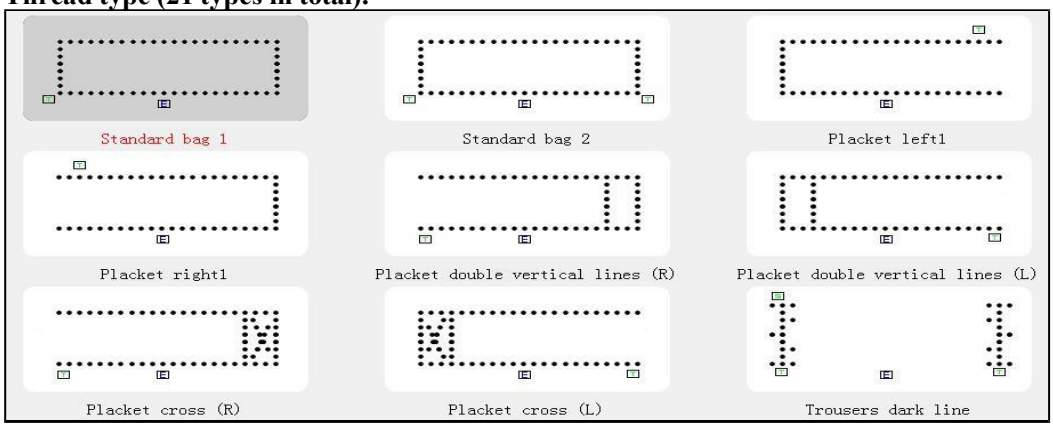
1.2.2 False bags

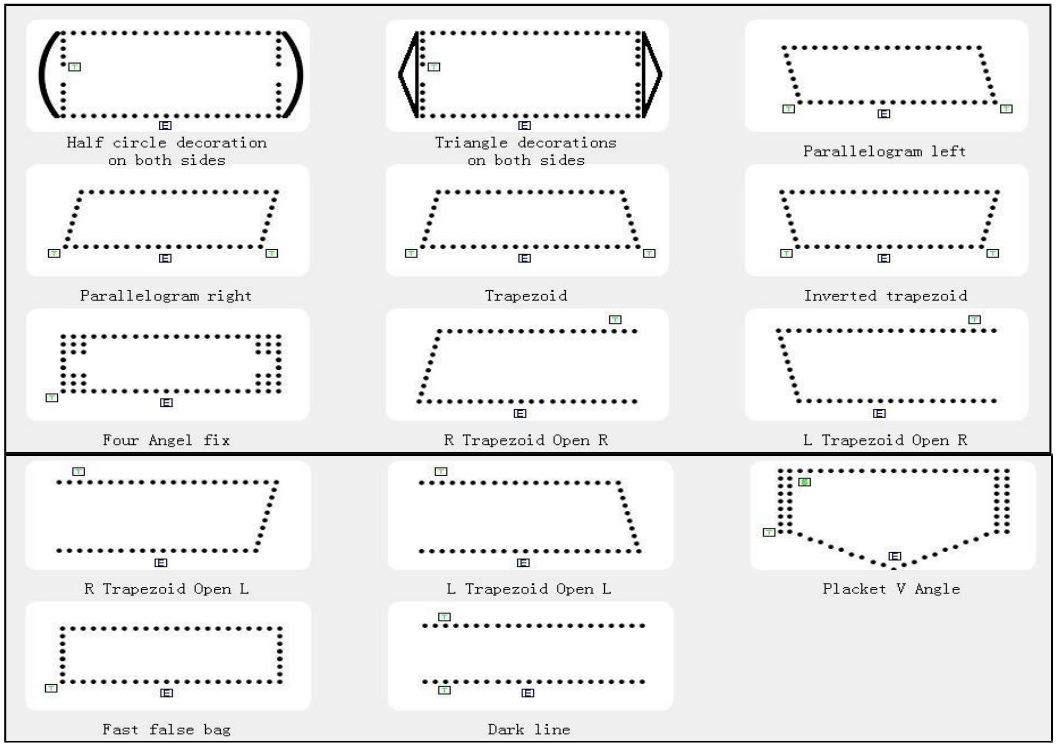


Function Description:

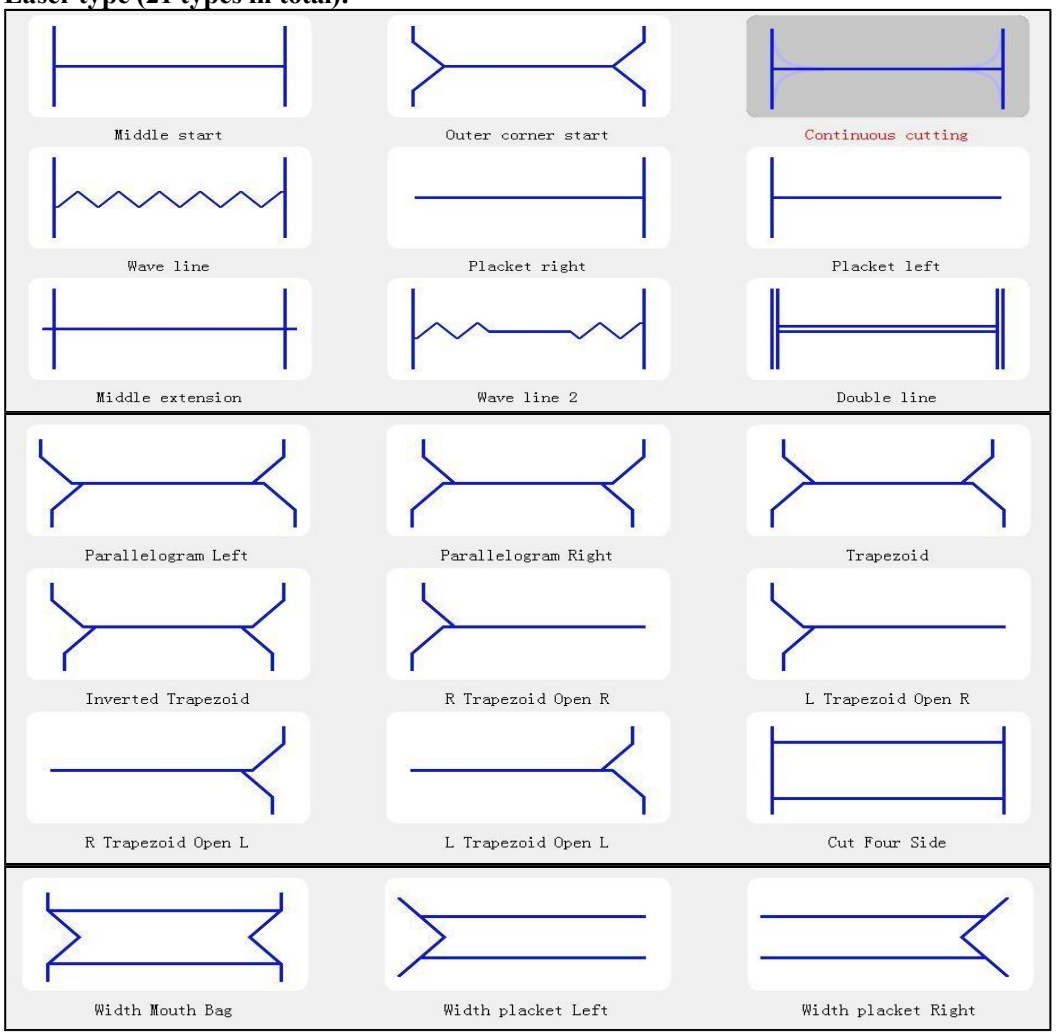
serial number	function	content
A	stitch type	There are a total of 9 types of wires
B	laser type	There are a total of 9 types of lasers
C	Switch function interface	Switch between homepage, sewing thread, laser thread, knotting, down jacket, and action interface.
D	Restore Default	Restore default parameters
E	Graphic Template	Display the current graphic template
F	Coordinate setting	Set laser center, pattern center offset, etc
G	preview	Preview of printed graphics
H	exit	Exit the settings interface
I	save	Save current parameter settings

Thread type (21 types in total):

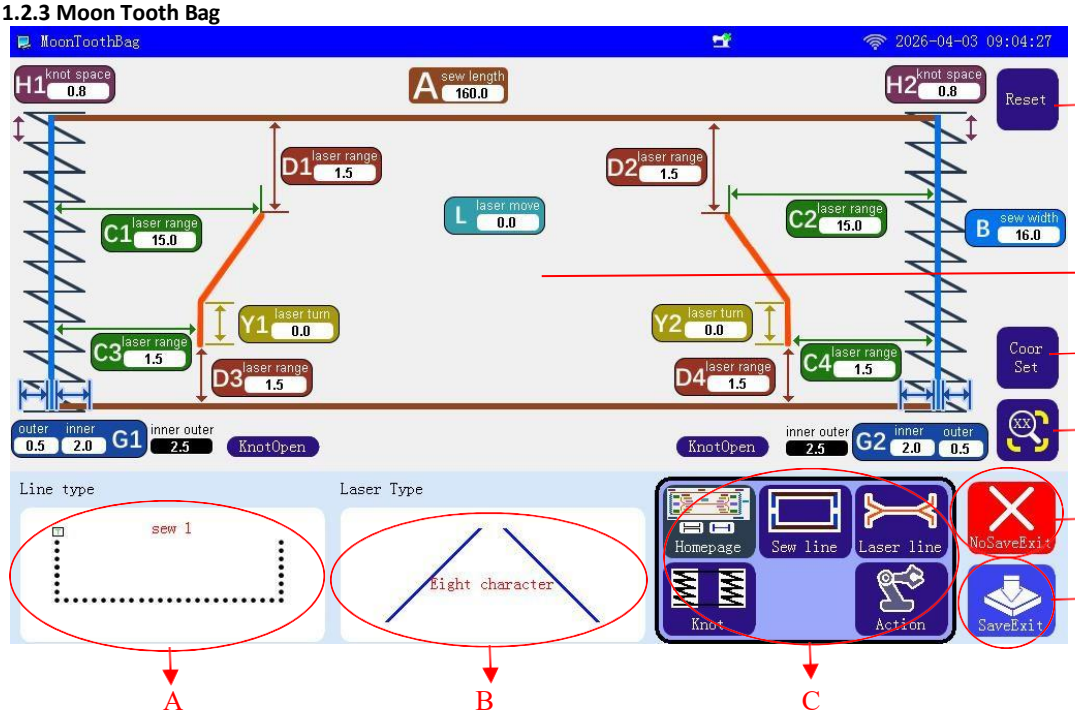




Laser type (21 types in total):



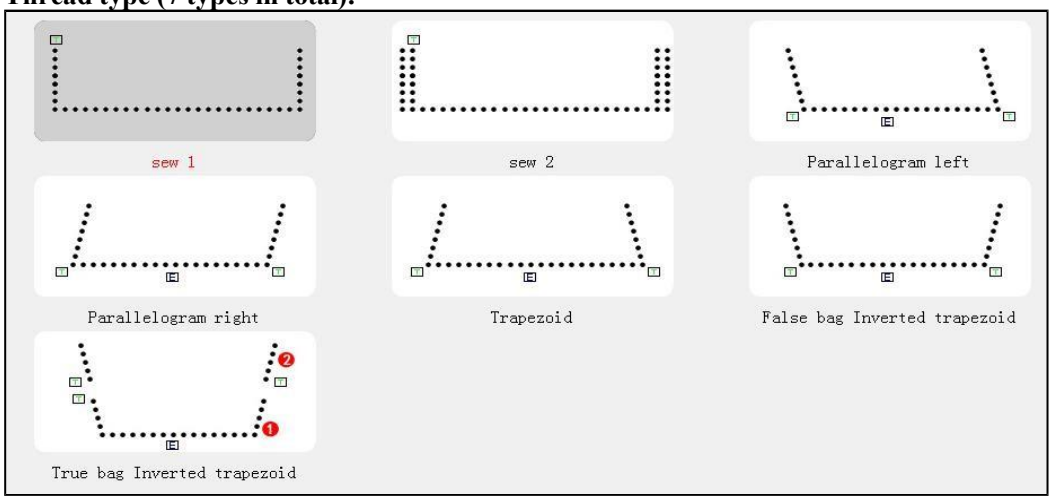
1.2.3 Moon Tooth Bag



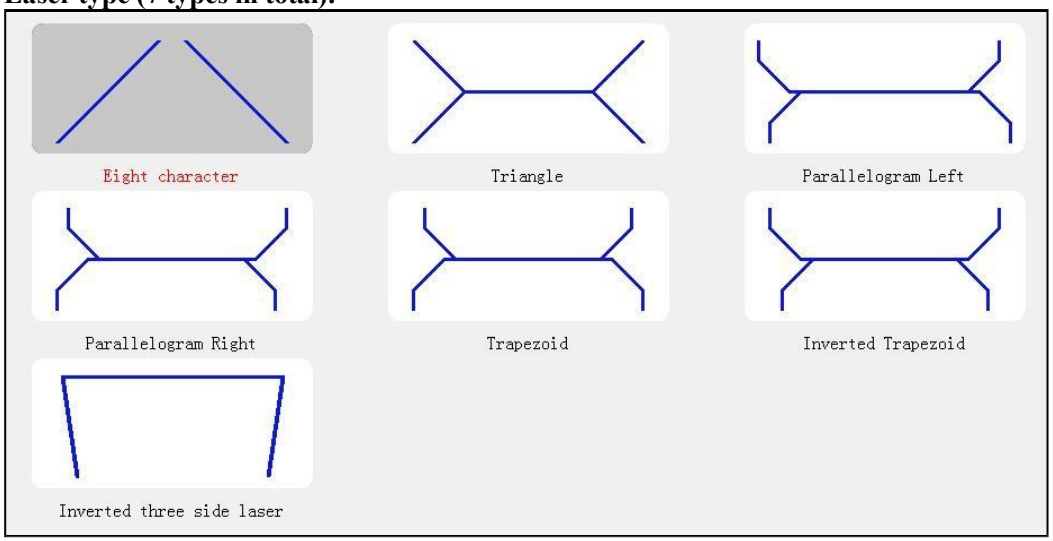
Function Description:

serial number	function	content
A	stitch type	There are a total of 7 types of wires
B	laser type	There are a total of 7 types of lasers
C	Switch function interface	Switch between homepage, sewing thread, laser thread, knotting, and action interface.
D	Restore Default	Restore default parameters
E	Graphic Template	Display the current graphic template
F	Coordinate setting	Set laser center, pattern center offset, etc
G	preview	Preview of printed graphics
H	exit	Exit the settings interface
I	save	Save current parameter settings

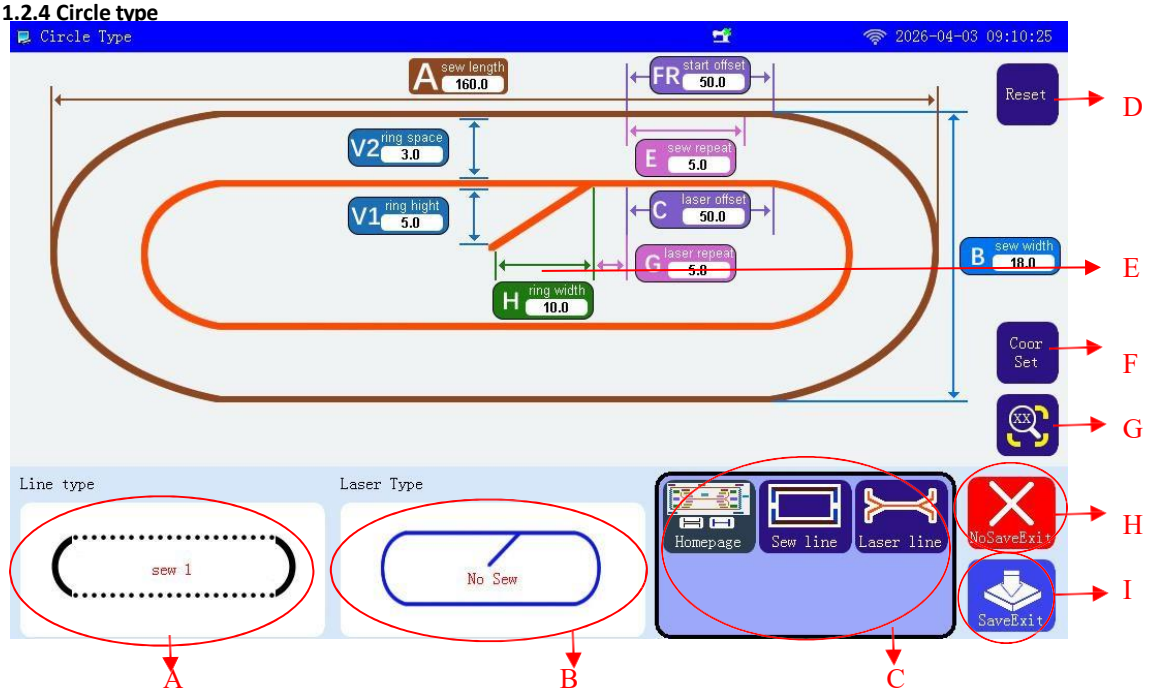
Thread type (7 types in total):



Laser type (7 types in total):



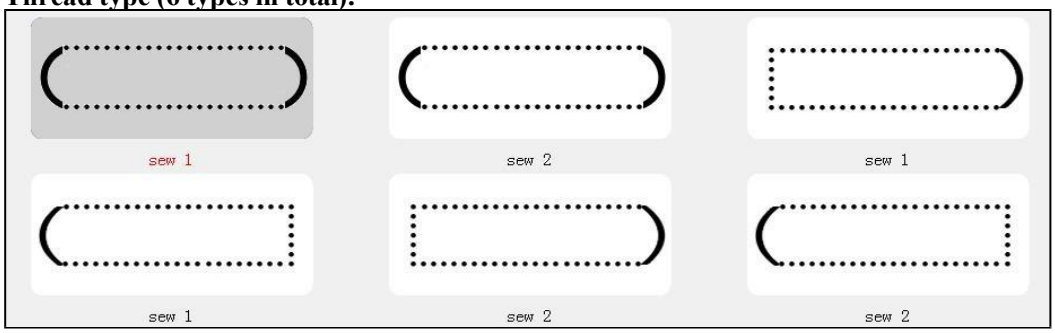
1.2.4 Circle type



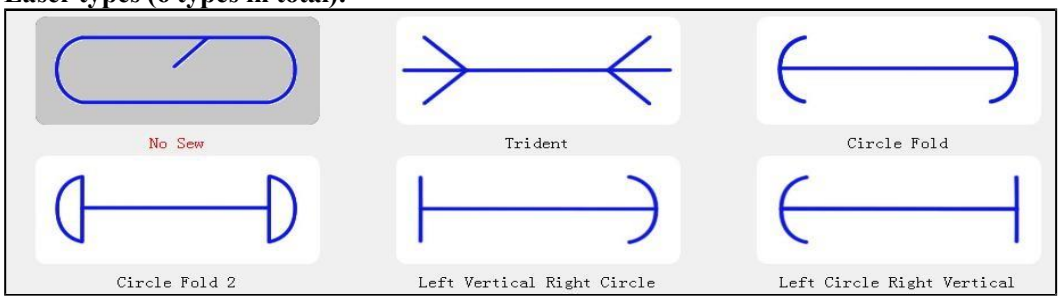
Function Description:

serial number	function	content
A	stitch type	1 type of thread in total
B	laser type	There are a total of 4 types of lasers
C	Switch function interface	Switch between homepage, sewing thread, and laser thread.
D	Restore Default	Restore default parameters
E	Graphic Template	Display the current graphic template
F	Coordinate setting	Set laser center, pattern center offset, etc
G	preview	Preview of printed graphics
H	exit	Exit the settings interface
I	save	Save current parameter settings

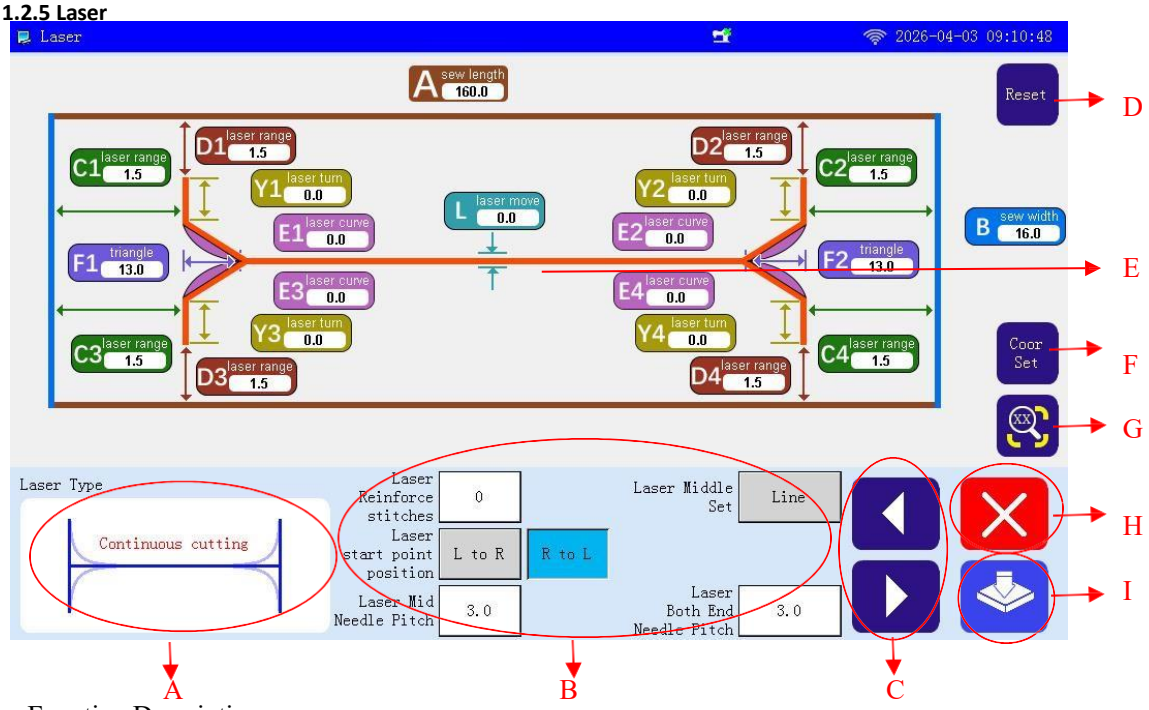
Thread type (6 types in total):



Laser types (6 types in total):



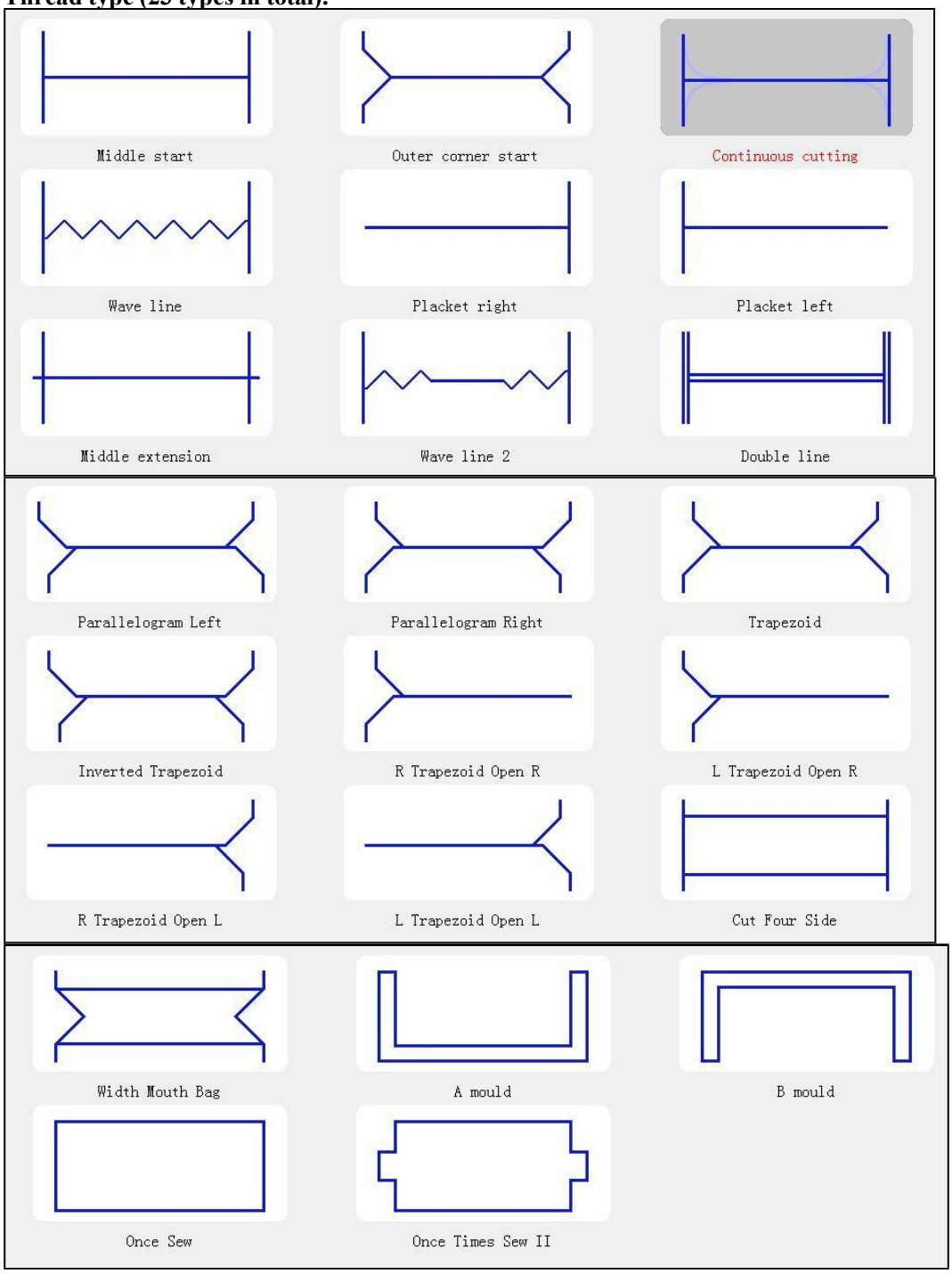
1.2.5 Laser



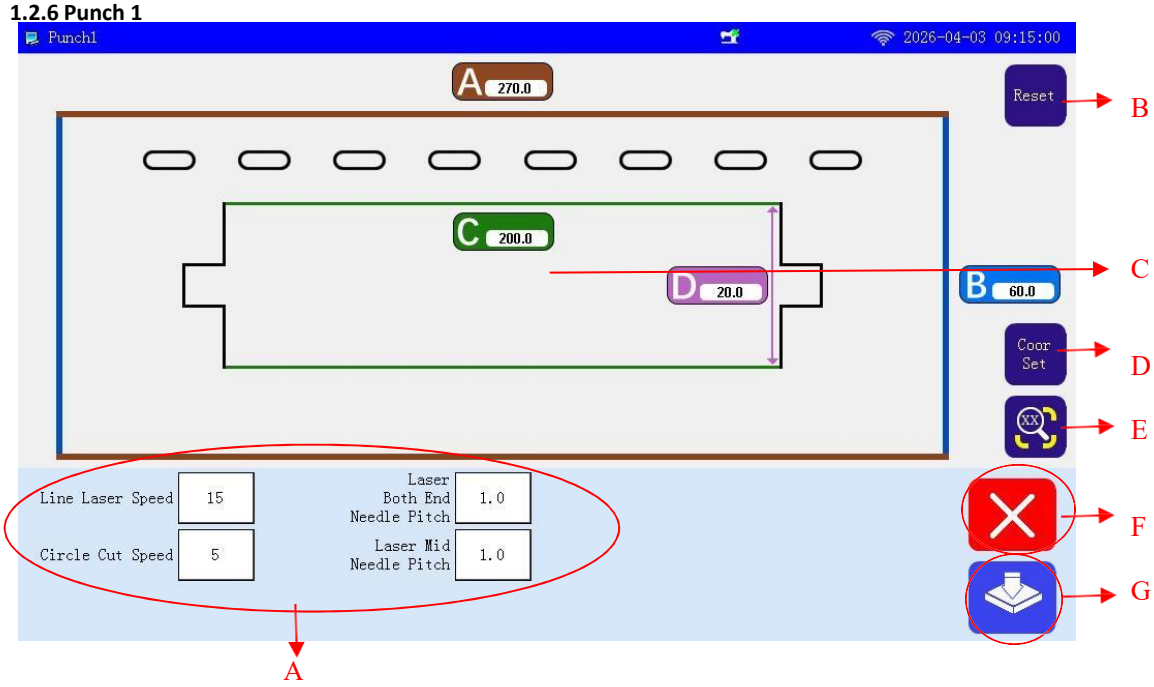
Function Description:

serial number	function	content
A	laser type	There are a total of 13 types of lasers
B	Parameters can be	Parameters can be set
C	Page turning button	Parameter page flipping, left page flipping, right page flipping
D	Restore Default	Restore default parameters
E	Graphic Template	Display the current graphic template
F	Coordinate setting	Set laser center, pattern center offset, etc
G	preview	Preview of printed graphics
H	exit	Exit the settings interface
I	save	Save current parameter settings

Thread type (23 types in total):



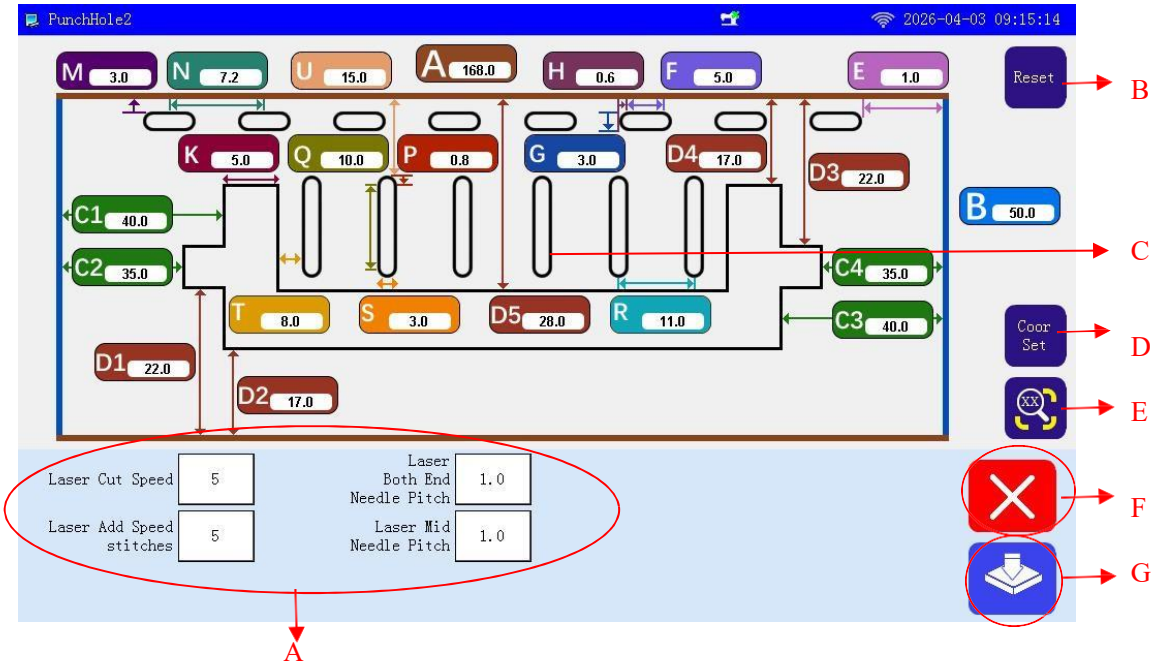
1.2.6 Punch 1



Function Description:

serial number	function	content
A	Parameter Settings	modify parameters
B	Restore Default	Restore default parameters
C	Graphic Template	Display the current graphic template
D	Coordinate setting	Set laser center, pattern center offset, etc
E	preview	Preview of printed graphics
F	exit	Exit the settings interface
G	save	Save current parameter settings

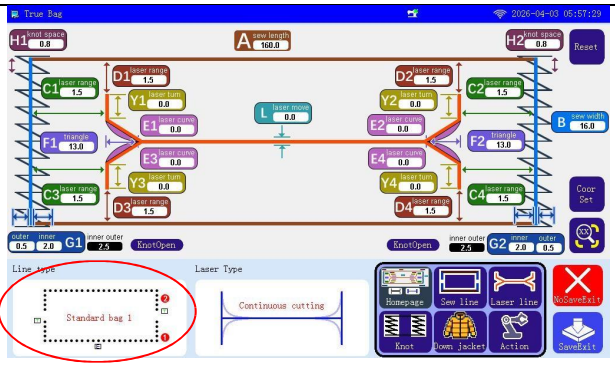
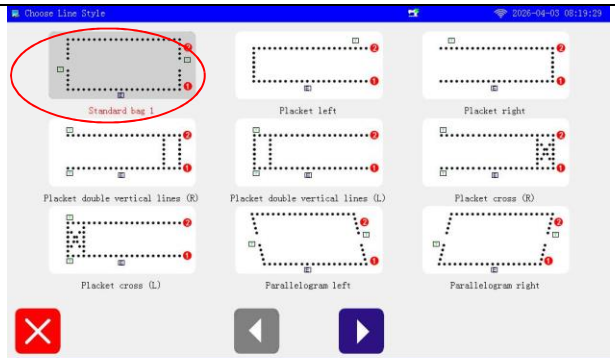
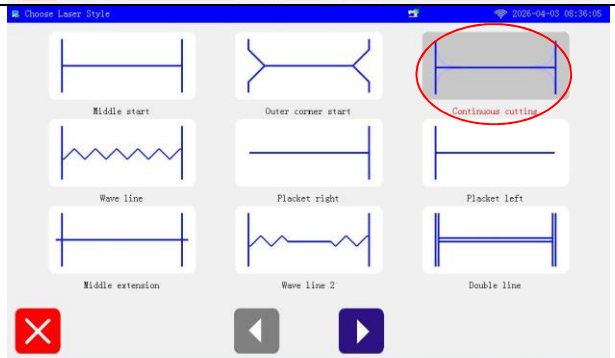
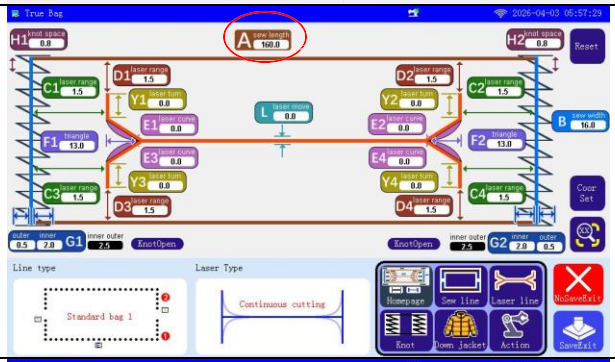
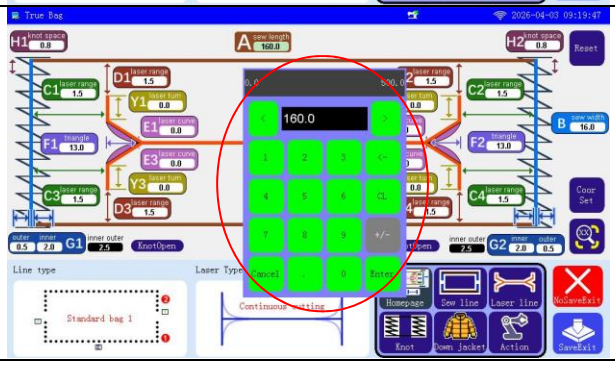
1.2.7 Punch Hole 2

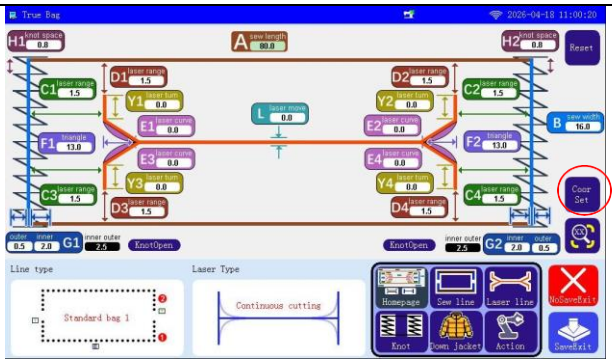
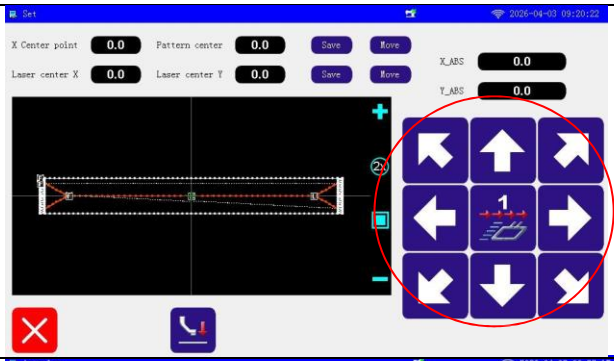
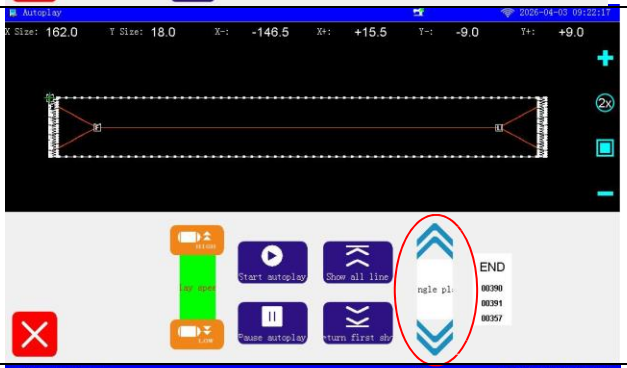
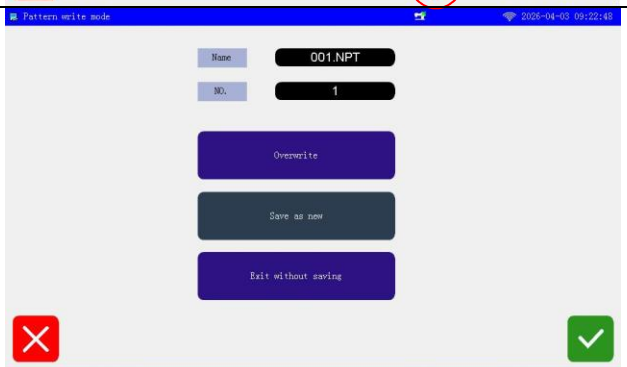
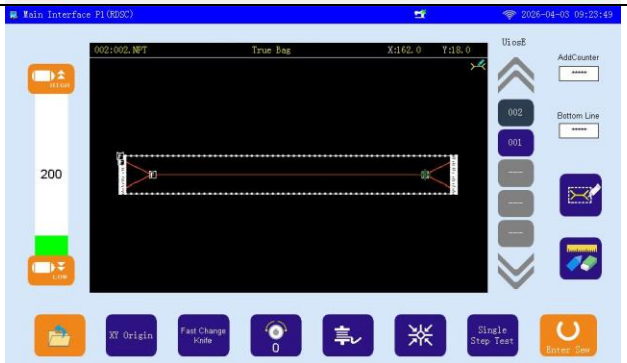


Function Description:

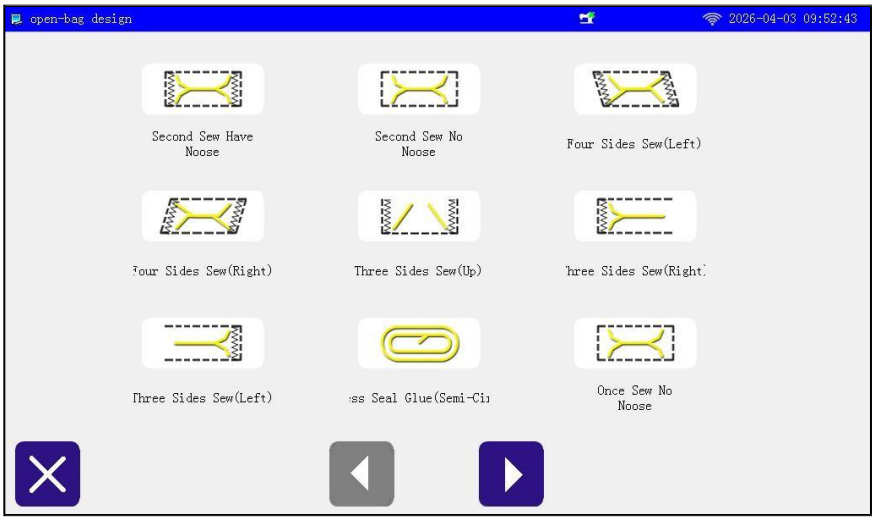
serial number	function	content
A	Parameter Settings	modify parameters
B	Restore Default	Restore default parameters
C	Graphic Template	Display the current graphic template
D	Coordinate setting	Set laser center, pattern center offset, etc
E	preview	Preview of printed graphics
F	exit	Exit the settings interface
G	save	Save current parameter settings

1.3 Operation demonstration

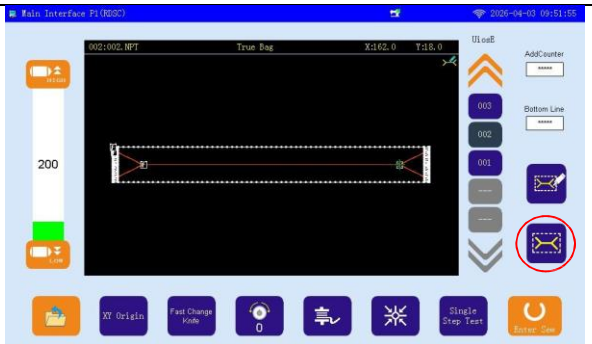
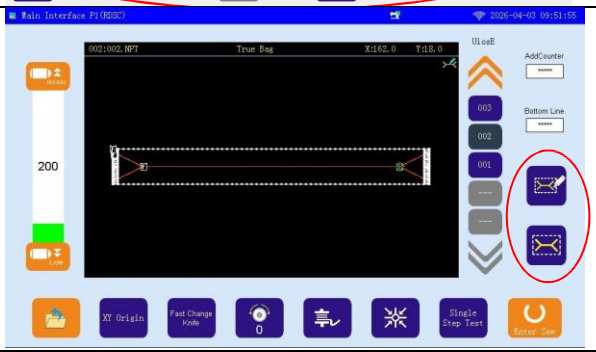
1. After selecting the bag type as genuine bag, click on the stitch type.	
2. Select the stitch type as "Standard Bag 1" and click ✕ Return to the previous interface and click on 'Laser Type'.	
3. Select the laser type as "continuous cutting" and click ✕ Return to the previous interface.	
Click on the numbers in the graphic template to modify the corresponding parameter values. Modify parameter A - sewing length here and change the value to 80.	
5. Open the numeric keypad, enter the value 60, and click OK to save.	

6. Click on coordinate settings to adjust the XY direction of the pattern center and the offset of the laser center XY direction.	
7. Modify the offset coordinates through the directional keyboard, and save the movement data through the save and move keys.	
8. Click Preview  to preview the printing effect.	
9. Click Save  to save the current printing data and generate a graphic file.	
10. The effect is shown in the image on the right.	

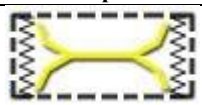
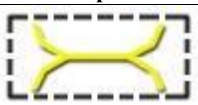
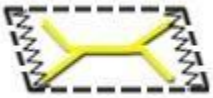
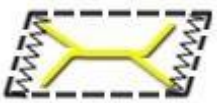
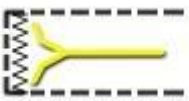
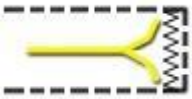
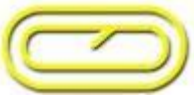
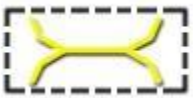
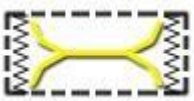
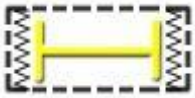
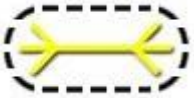
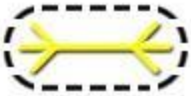
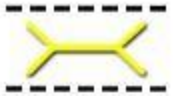
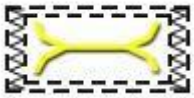
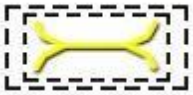
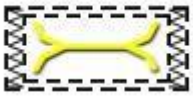
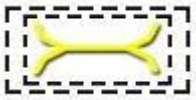
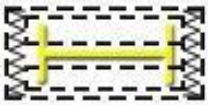
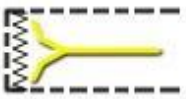
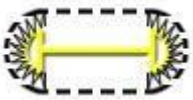
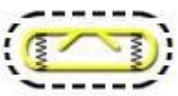
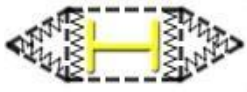
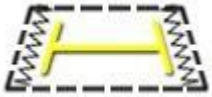
Chapter 2 Bag Opening Design

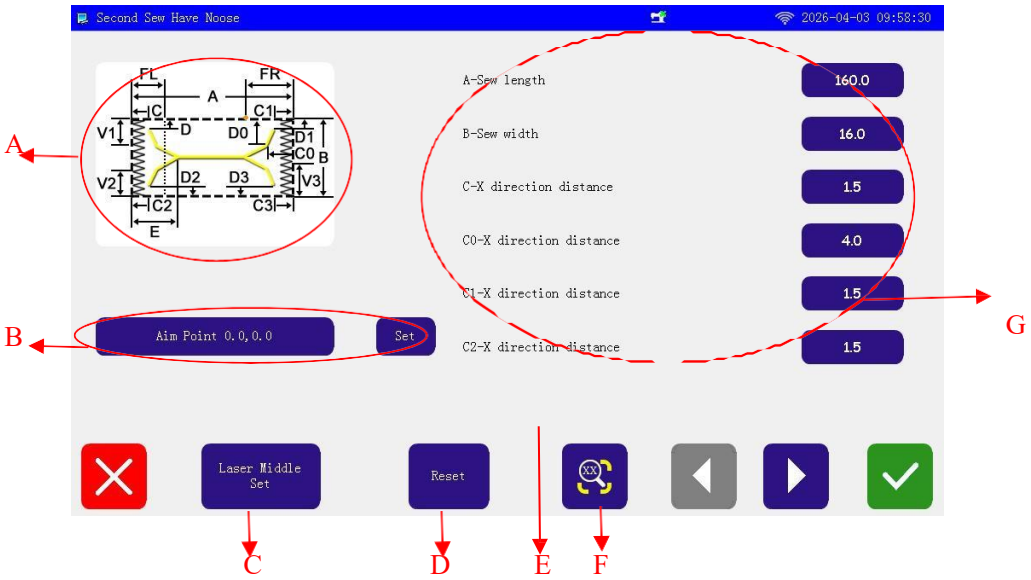


2.1 Entry Method

1. Click the shortcut key "Open Bag Design" on the main interface.	
2. Enter the laser bag opening selection template.	
Note: The two buttons at the top of "Enter Sewing" are shortcut buttons that can be replaced with other buttons. Replacement method: Menu - Function Settings - Function Shortcuts	

2.2 Template Introduction

Template	name	Template	name
	Second Sew Have Noose		Secondary sewing No binding
	Four Sides Sew (Left)		Four sided sewing (right)
	Three Sides Sew (up)		Three sided sewing (left)
	Three sides Sew (Left)		Seamless sealant (semi-circular)
	Once Sew No Noose		Sewing with a knot at once
	Straight Cut Once Sew Have Noose		One round sewing
	Circle Once Sew		Normal mode dark line
	Common Mode Dark-line		Cotton clothing secondary sewing without a knot
	Cotton Clothes Twice Sew Have knot		Cotton clothing sewn once without a knot
	Cotton Clothes Once Sew Haven't knot		Access control one/X
	二次缝圆角 折套结边 2		Glue fillet Zipper binding
	side pocket		There is a knot sewn on both sides of the triangle
	Trapezoidal sewing with a knot		

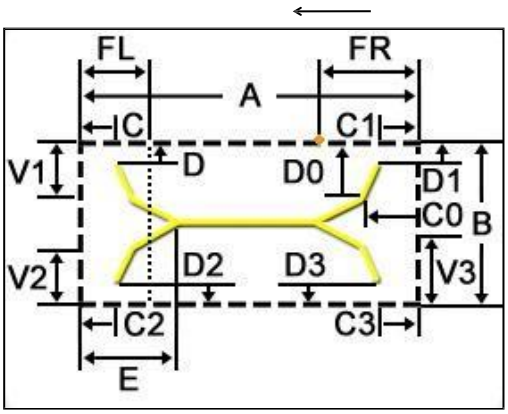


Main interface function description:

serial number	function	content
A	display diagram	Pattern data annotation, where the letters in the region correspond to the letter items in the G area
B	Pattern alignment point setting	Adjust the XY position value of the pattern alignment point
C	Laser intermediate setting	Set the laser middle sewing shape, laser middle up and down offset, etc
D	Restore Default	Restore default data values
E	Pre ordering materials, post	/
F	preview	Enter the preview interface of the printing graphics
G	Pattern parameter area	Numerical setting

2.3 Bag type parameter description

By modifying the parameters related to the bag type, the entire bag type can be adjusted as needed. The parameters of different bag types are different, as shown in the schematic diagram of the parameters for secondary sewing without knots.

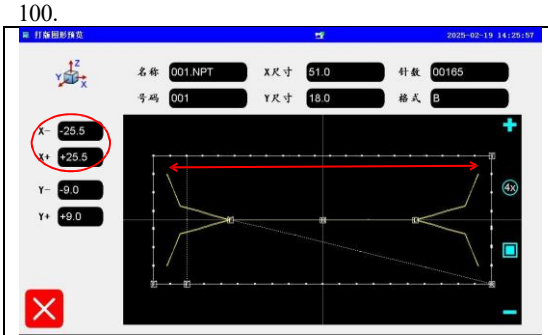


serial number	parameter name
A	Sewing length
B	Sewing width
C	Cut the distance in the X direction
C0	Cut the distance of the middle
C1	Cut the distance in the X direction
C2	Cut the distance in the X direction
C3	Cut the distance in the X direction
D	Cut the Y-direction distance in the
D0	Cut the distance from the middle
D1	Cut the Y-direction distance in the
D2	Cut the Y-direction distance in the
D3	Cut the Y-direction distance from
E	Cutting starting position
FL	Empty delivery distance (left)
FR	Distance from code to right (right)
V1	Y compensation distance (left)
V2	Y compensation distance (left)
V3	Y compensation distance (right)

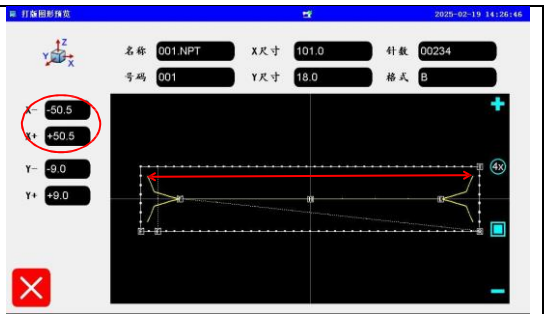
Below is a brief introduction to the definition and setting effects of bag type parameters.

2.3.1 A-Sewing Length

Definition: The horizontal distance of bag type sewing thread, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of secondary sewing without a knot when the sewing length is 50 and 100.



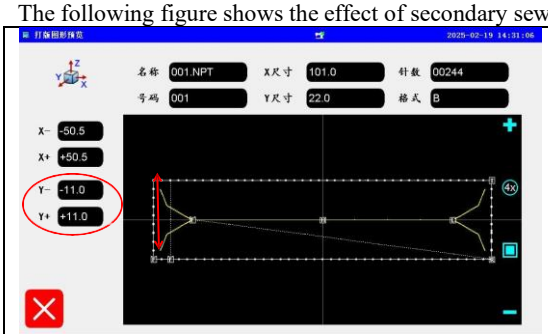
sewing length is 50



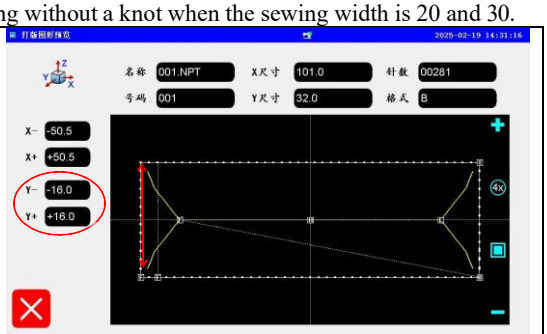
sewing length is 100

2.3.2 B-Sewing Width

Definition: The longitudinal distance between the upper and lower sewing threads of a bag type, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of secondary sewing without a knot when the sewing width is 20 and 30.



sewing width is 20

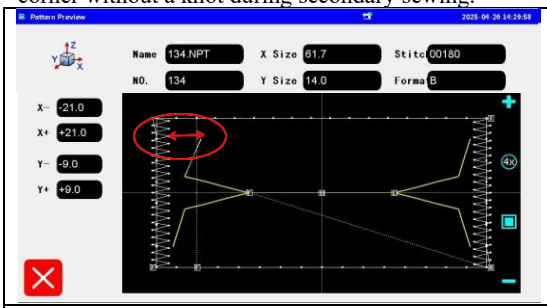
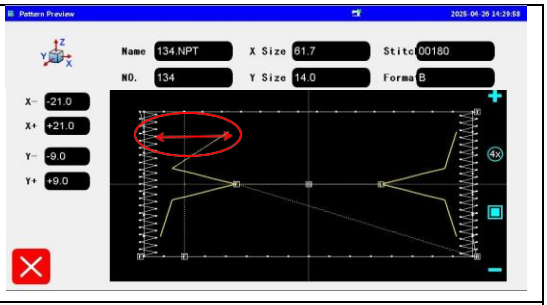


sewing width is 30

2.3.3 C-Upper left cutting distance in the X direction

Definition: The horizontal length from the upper left cutting point to the left sewing thread, with a numerical range of 0.0-999.9mm.

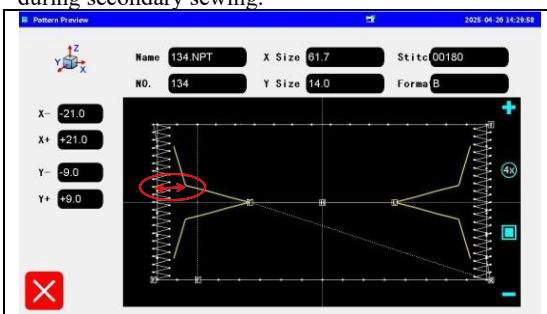
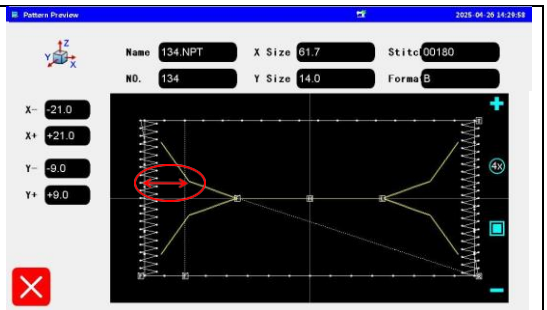
The following image shows the effect of cutting in the X direction at distances of 20 and 10 in the upper left corner without a knot during secondary sewing.

	
Upper left cutting distance in the X direction is 10	Upper left cutting distance in the X direction is 20

2.3.4 C0- Distance from cutting midpoint in the X direction

Definition: The horizontal length from the cutting midpoint to the left and right sewing threads, with a numerical range of 0.0-999.9mm.

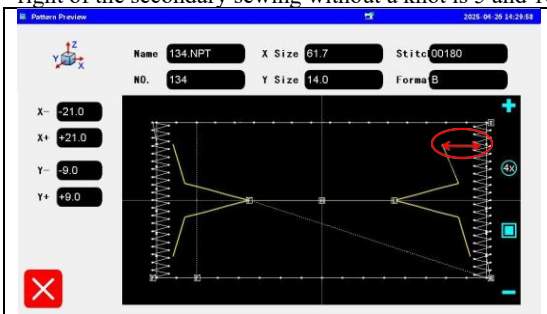
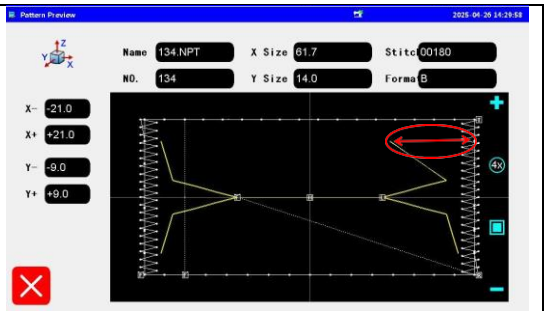
The picture shows the effect of cutting the middle point in the X direction at distances of 4 and 6 without a knot during secondary sewing.

	
Distance from cutting midpoint in the X direction is 4	Distance from cutting midpoint in the X direction is 6

2.3.5 C1- Upper right cutting distance in the X direction

Definition: The horizontal length from the upper right cutting point to the right sewing thread, with a numerical range of 0.0-999.9mm.

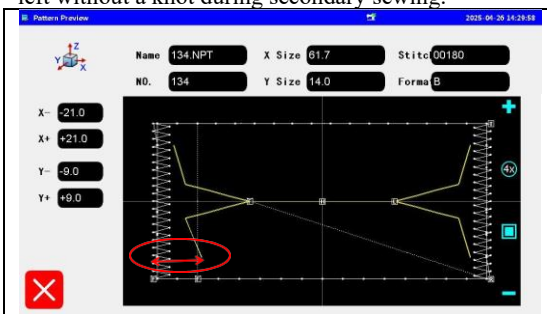
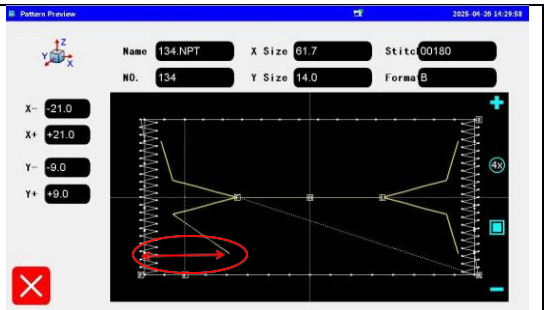
The following image shows the effect when the distance in the X direction of the cutting point on the upper right of the secondary sewing without a knot is 5 and 10.

	
Upper right cutting distance in the X direction is 5	Upper right cutting distance in the X direction is 10

2.3.6 C2- Lower left cutting distance in the X direction

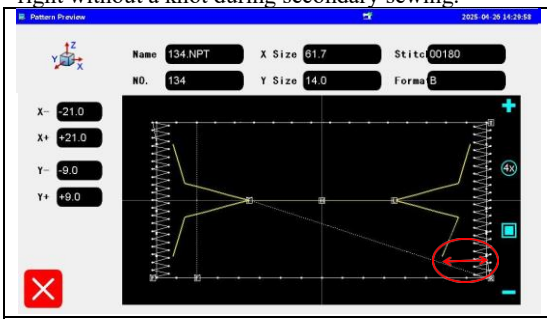
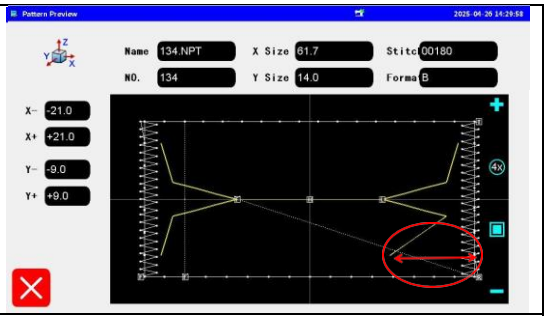
Definition: The horizontal length from the lower left cutting point to the left sewing thread, with a numerical range of 0.0-999.9mm.

The following image shows the effect when cutting in the X direction at distances of 5 and 10 from the bottom left without a knot during secondary sewing.

	
Lower left cutting distance in the X direction is 5	Lower left cutting distance in the X direction is 10

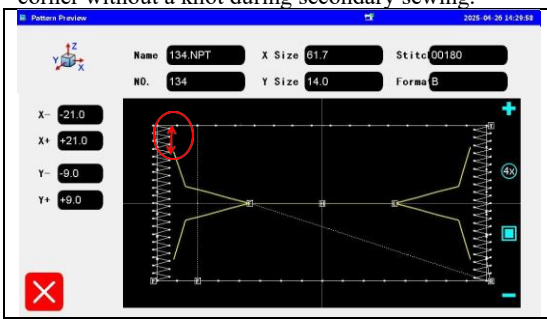
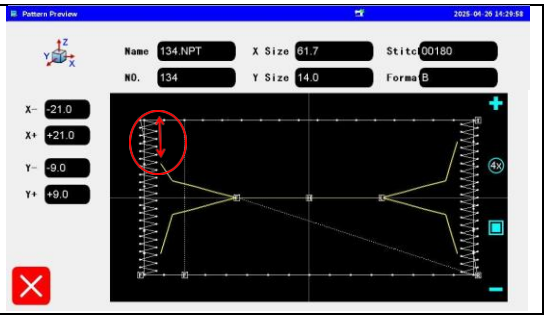
2.3.7 C3- X-directional distance for cutting in the lower right corner

Definition: The horizontal length from the lower right cutting point to the right sewing thread, with a numerical range of 0.0-999.9mm.
The following image shows the effect when cutting in the X direction at distances of 5 and 10 from the bottom right without a knot during secondary sewing.

	
X-directional distance for cutting in the lower right corner is 5	X-directional distance for cutting in the lower right corner is 10

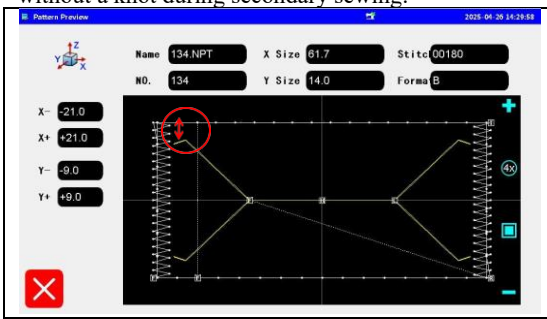
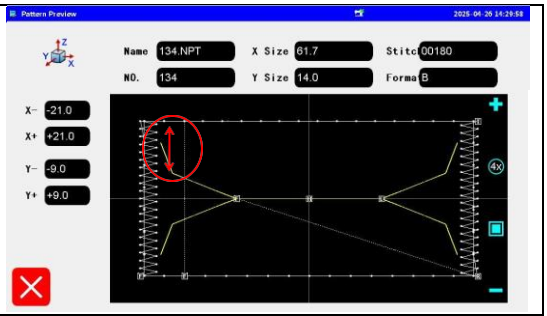
2.3.8 D-Upper left cutting Y-direction distance

Definition: The longitudinal length of the sewing thread from the upper left cutting point to the top, with a numerical range of -999.9-999.9mm.
The following image shows the effect when cutting in the Y direction at distances of 2 and 4 in the upper left corner without a knot during secondary sewing.

	
Upper left cutting Y-direction distance is 2	Upper left cutting Y-direction distance is 4

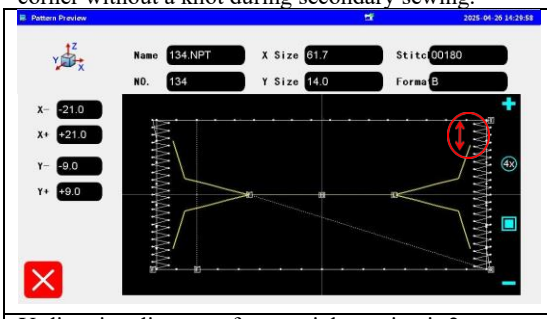
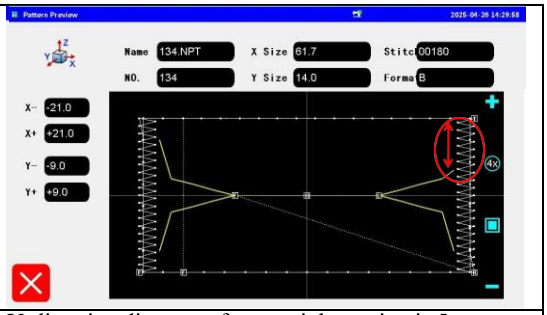
2.3.9 D0- Y-distance of cutting midpoint

Definition: The longitudinal length of the sewing thread from the cutting midpoint to the upper and lower edges, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of cutting the middle point in the Y direction at distances of 2 and 6 without a knot during secondary sewing.

	
Y-distance of cutting midpoint is 2	Y-distance of cutting midpoint is 6

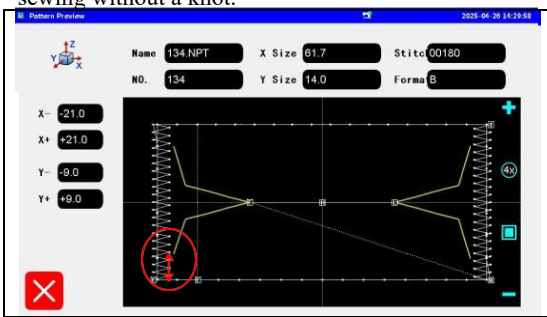
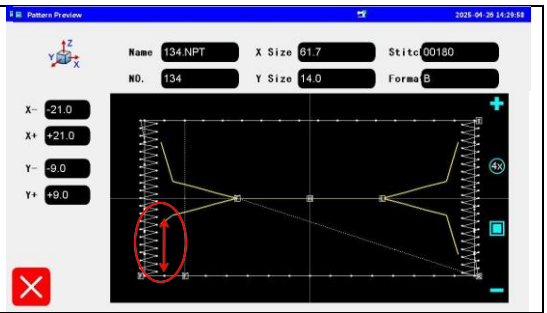
2.3.10 D1- Y-direction distance of upper right cutting

Definition: The longitudinal length of the sewing thread from the upper right cutting point to the top, with a numerical range of 0.0-999.9mm.
The following image shows the effect when cutting in the Y direction at distances of 2 and 5 in the upper right corner without a knot during secondary sewing.

	
Y-direction distance of upper right cutting is 2	Y-direction distance of upper right cutting is 5

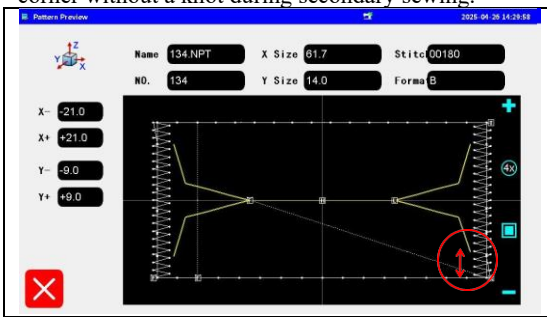
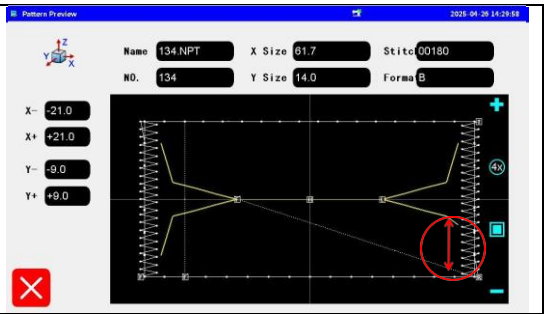
2.3.11 D2- Bottom left cutting Y-direction distance

Definition: The longitudinal length of the sewing thread from the lower left cutting point to the bottom, with a numerical range of 0.0-999.9mm.
The following image shows the effect when cutting in the Y direction at distances of 2 and 5 for the second sewing without a knot.

	
Bottom left cutting Y-direction distance is 2	Bottom left cutting Y-direction distance is 5

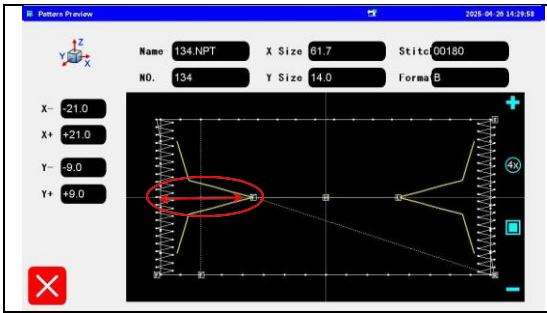
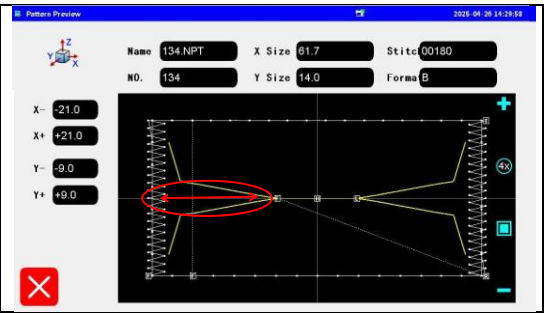
2.3.12 D3- Y-direction cutting distance at the bottom right

Definition: The longitudinal length of the sewing thread from the bottom right cutting point to the bottom, with a numerical range of 0.0-999.9mm.
The following image shows the effect when cutting the Y-direction at distances of 2 and 5 in the lower right corner without a knot during secondary sewing.

	
Y-direction cutting distance at the bottom right is 2	Y-direction cutting distance at the bottom right is 5

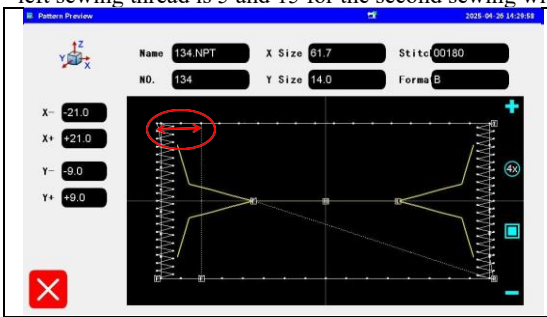
2.3.13 E-cutting Starting position

Definition: The horizontal distance from the starting point of the cutting line to the starting points of the upper and lower sewing lines, with a numerical range of 0.0-999.9mm.
The following image shows the effect when the cutting start position is 11 and 30 for the second sewing without a knot.

	
cutting Starting position is 11	cutting Starting position is 30

2.3.14 FL-air delivery distance (left)

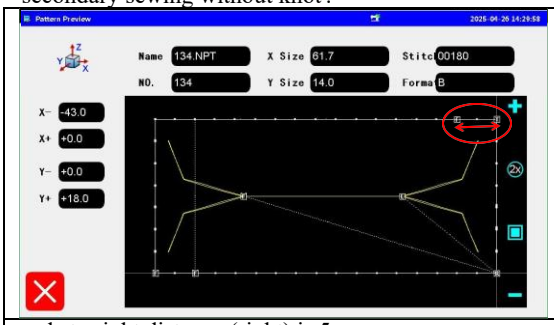
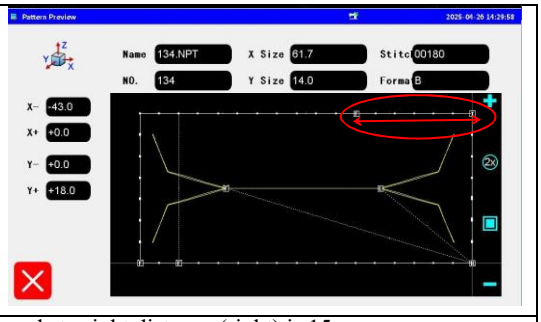
Definition: The horizontal distance between the empty feed distance and the left sewing thread, with a numerical range of 0.0-999.9mm.
The following figure shows the effect when the horizontal distance between the empty feed distance and the left sewing thread is 5 and 15 for the second sewing without a knot.

	
air delivery distance (left) is 5	air delivery distance (left) is 15

2.3.15 FR-code to right distance (right)

Definition: The lateral distance from the code (side slip 2 lift) to the right, with a numerical range of 0.0-999.9mm.

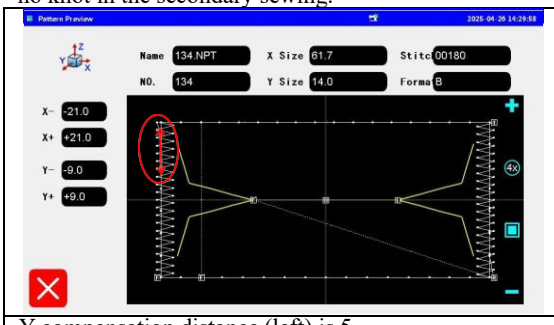
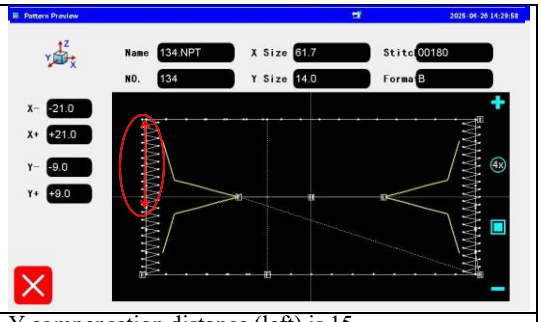
The following figure shows the effect when the horizontal distance from the code to the right is 5 and 15 for the 'secondary sewing without knot'.

	
code to right distance (right) is 5	code to right distance (right) is 15

2.3.16 V1-Y compensation distance (left)

Definition: When sewing to the upper left corner, continue sewing downwards for a distance and then return, with a numerical range of 0.0-999.9mm.

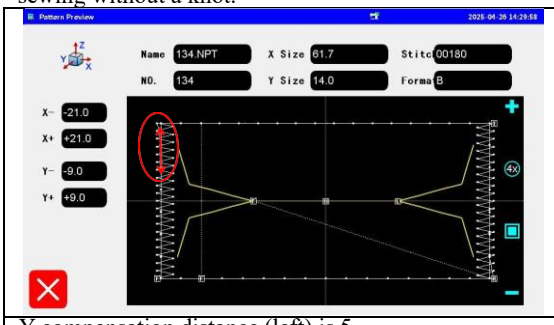
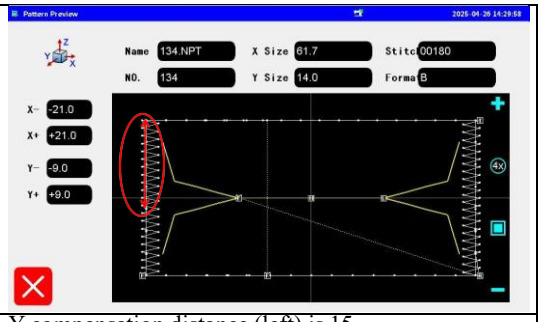
The following figure shows the effect of Y compensation distance (left) at distances of 5 and 15 when there is no knot in the secondary sewing.

	
Y compensation distance (left) is 5	Y compensation distance (left) is 15

2.3.17 V2-Y compensation distance (left)

Definition: When sewing to the bottom left corner, continue sewing upwards for a distance and then return, with a numerical range of 0.0-999.9mm.

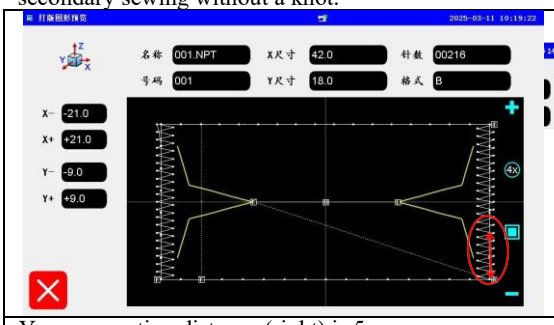
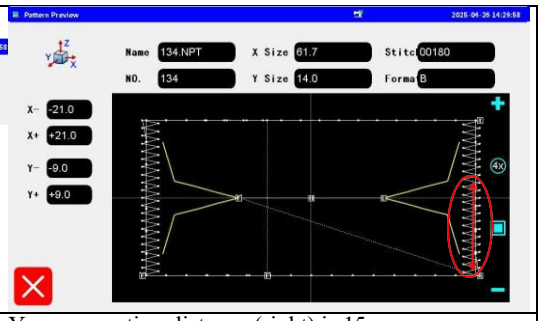
The following figure shows the effect when the Y compensation distance (left) is 5 and 15 for the second sewing without a knot.

	
Y compensation distance (left) is 5	Y compensation distance (left) is 15

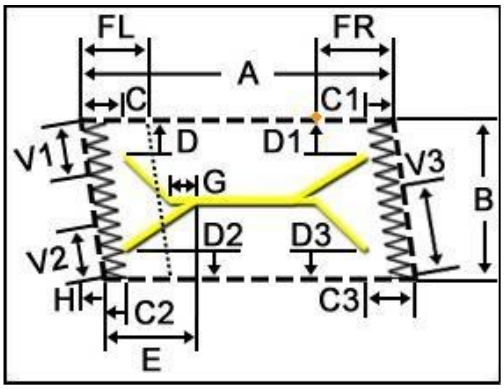
2.3.18 V3-Y compensation distance (right)

Definition: When sewing to the bottom right corner, continue sewing upwards for a distance and then return, with a numerical range of 0.0-999.9mm.

The following figure shows the effect when the Y compensation distance (on the right) is 5 and 15 for the secondary sewing without a knot.

	
Y compensation distance (right) is 5	Y compensation distance (right) is 15

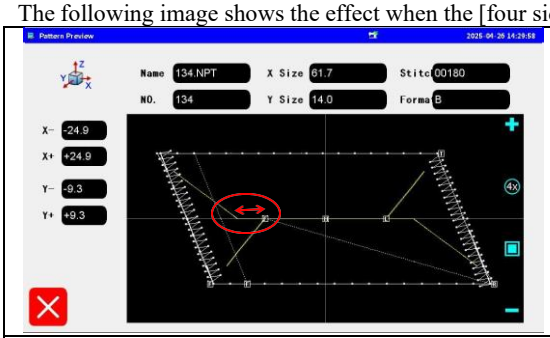
The following is a schematic diagram of the parameters for four sided sewing (left)



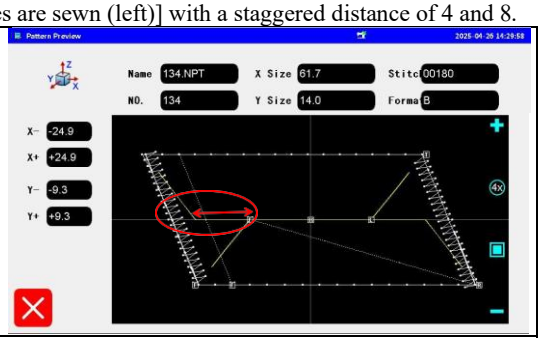
serial number	parameter name
A	Sewing length
B	Sewing width
C	Cut the distance in the X direction from the top left corner
G	**Staggered distance**
C1	Cut the distance in the X direction from the top right corner
C2	Cut the distance in the X direction at the bottom left
C3	Cut the distance in the X direction from the bottom right corner
D	Cut the Y-direction distance in the upper left corner
H	**Tilt distance**
D1	Cut the Y-direction distance in the upper right corner
D2	Cut the Y-direction distance in the lower left corner
D3	Cut the Y-direction distance from the bottom right corner
E	Cutting starting position
FL	Empty delivery distance (left)
FR	Distance from code to right (right)
V1	Y compensation distance (left)
V2	Y compensation distance (left)
V3	Y compensation distance (right)

2.3.19 G-offset distance

Definition: The horizontal distance between two cutting points, with a numerical range of 0.0-999.9mm.
The following image shows the effect when the [four sides are sewn (left)] with a staggered distance of 4 and 8.



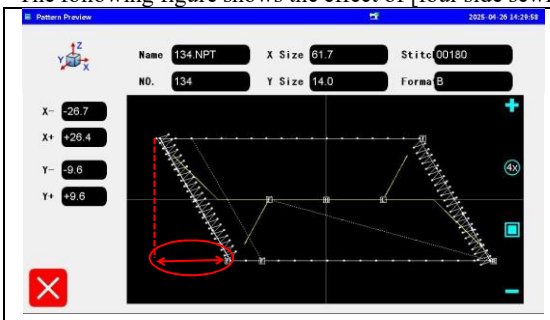
offset distance is 4



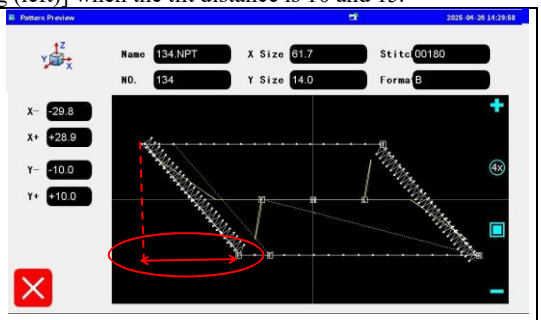
offset distance is 8

2.3.20 H-Tilt distance

Definition: The lateral distance offset between the upper and lower sewing threads, with a numerical range of 0.0-999.9mm.
The following figure shows the effect of [four side sewing (left)] when the tilt distance is 10 and 15.

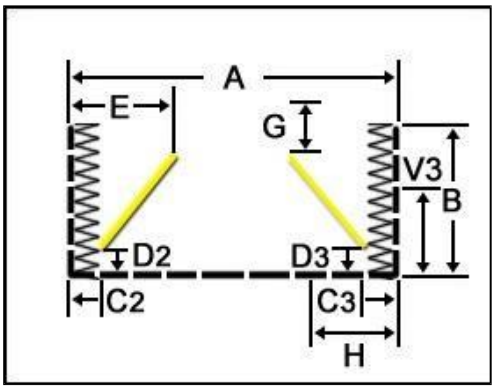


Tilt distance is 10



Tilt distance is 15

The following is a schematic diagram of the parameters for three sided sewing (top)

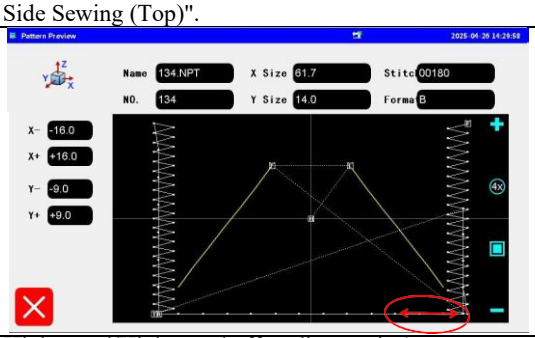
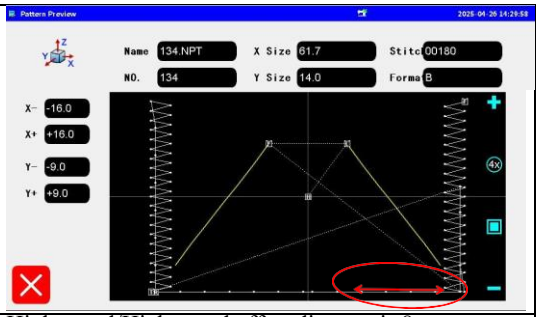


serial number	parameter name
A	Sewing length
B	Sewing width
C2	Cut the distance in the X direction at the bottom left
C3	Cut the distance in the X direction from the bottom right corner
D2	Cut the Y-direction distance in the lower left corner
D3	Cut the Y-direction distance from the bottom right corner
E	Cutting starting position
G	Staggered distance
H	**Medium to high speed/high**
V3	**Y compensation distance (right)**

2.3.21 H-High speed/High speed offset distance

Definition: The lateral distance of medium to high speed/high-speed offset, with a numerical range of 0-100mm.

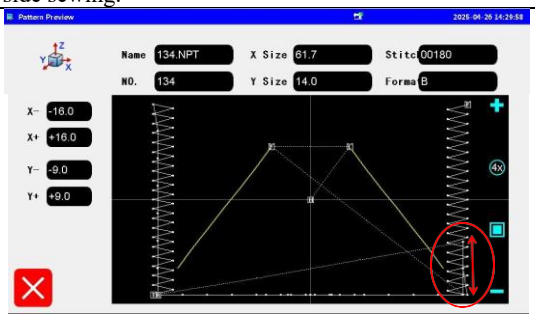
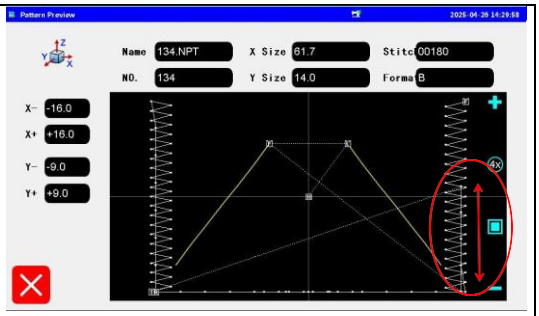
The following figure shows the effect when the high-speed/high-speed offset distance is 4 and 8 in the "Three Side Sewing (Top)".

	
High speed/High speed offset distance is 4	High speed/High speed offset distance is 8

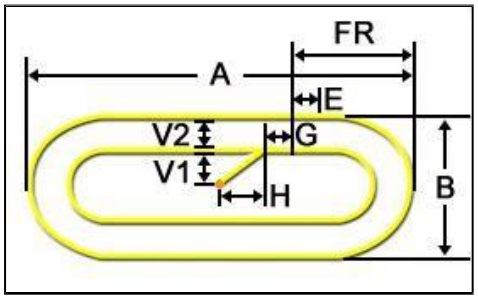
2.3.22 V3-Y compensation distance (right)

Definition: The longitudinal distance under Y compensation distance (right), with a numerical range of 0-100mm.

The following figure shows the effect when the compensation distance is 5 and 10 respectively for the top three side sewing.

	
Y compensation distance (right) is 5	Y compensation distance (right) is 10

The figure is a schematic diagram of the parameters of seamless sealant (semi-circular)

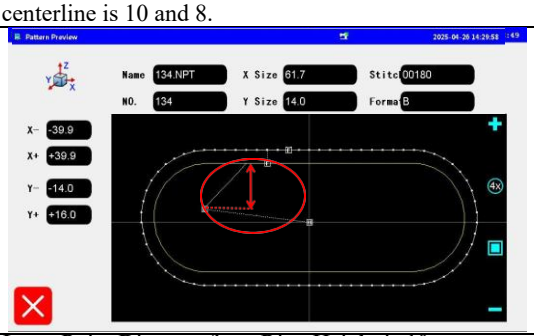
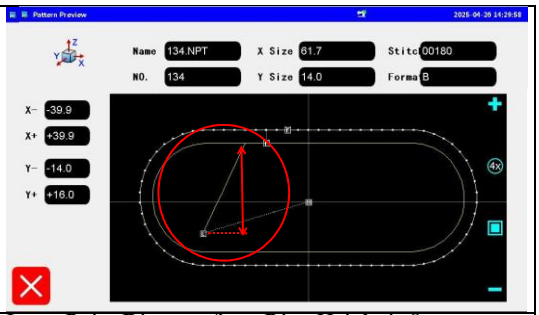


serial number	parameter name
A	Sewing length
B	Sewing width
G	Staggered distance
H	Medium to high speed/high speed offset distance
E	Cutting start distance
FR	Distance from code to right (right)
V1	**Laser point height from the ring**
V2	**Distance between two rings**

2.3.23 V1- Laser Point Distance from Ring Height

Definition: The height of the laser point from the ring, with a numerical range of 0.0-999.9mm.

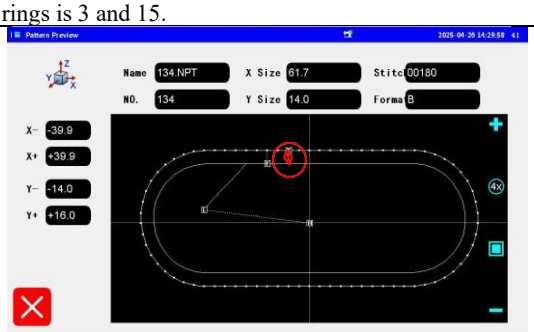
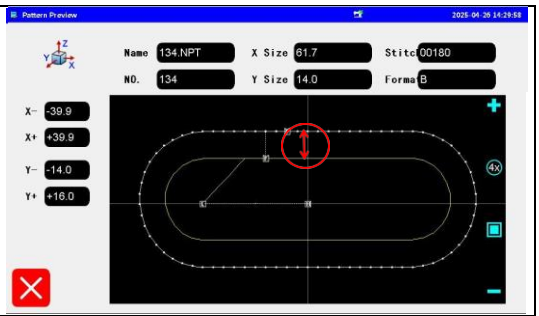
The following figure shows the effect of seamless sealing (semi-circular) when the starting point of the cutting centerline is 10 and 8.

	
Laser Point Distance from Ring Height is 10	Laser Point Distance from Ring Height is 8

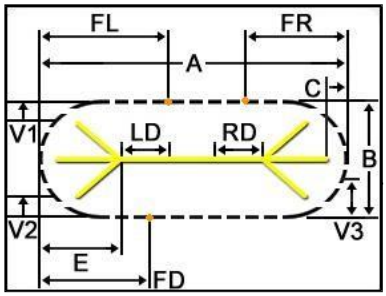
2.3.24 V2- Distance between two rings

Definition: The longitudinal distance between the laser ring and the sewing ring, with a numerical range of 0.0-999.9mm.

The following figure shows the effect of seamless sealing (semi-circular) when the distance between the two rings is 3 and 15.

	
Distance between two rings is 3	Distance between two rings is 15

The figure is a schematic diagram of the parameters for "secondary sewing of circles

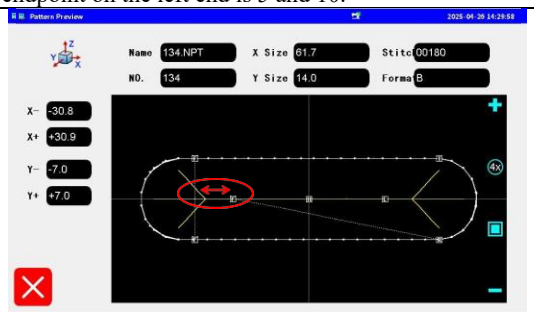


serial number	parameter name
A	Sewing length
B	Sewing width
C	Cut the distance in the X direction from the top left corner
FD	Distance from code to bottom left (bottom left)
LD	**Left end laser endpoint distance (left)**
RD	**Right end laser endpoint distance (right)**
E	Cutting starting position
FL	Empty delivery distance (left)
FR	Distance from code to right (right)
V1	Y compensation distance (left)
V2	Y compensation distance (left)
V3	Y compensation distance (right)

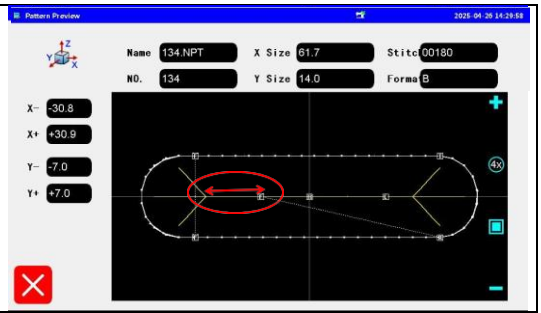
2.3.25 LD - Left End Laser End Point Distance (Left)

Definition: The lateral distance of the end point of the left laser, with a numerical range of 0-100mm.

The following figure shows the effect of secondary sewing of a circle when the distance between the laser endpoint on the left end is 5 and 10.



Left End Laser End Point Distance is 5

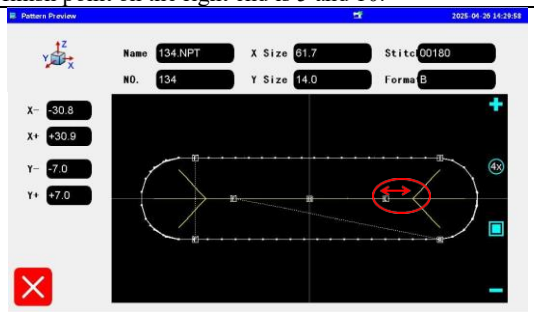


Left End Laser End Point Distance is 10

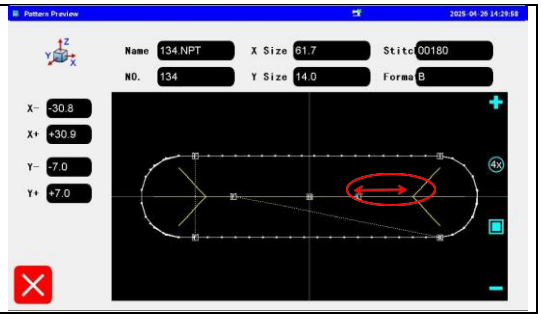
2.3.26 RD - Right End Laser End Point Distance (Right)

Definition: The lateral distance from the end point of the right laser, with a numerical range of 0-100mm.

The following figure shows the effect of secondary sewing of a circle when the distance between the laser finish point on the right end is 5 and 10.

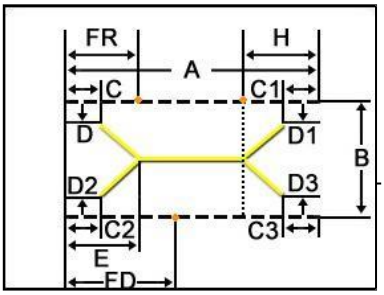


Right End Laser End Point Distance is 5



Right End Laser End Point Distance is 10

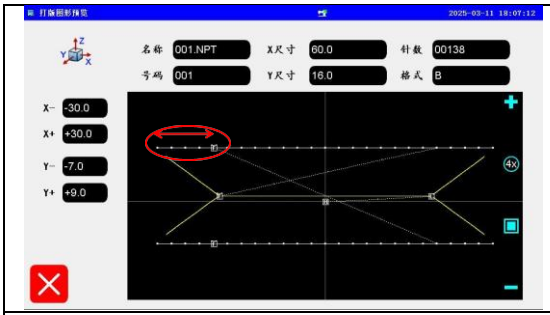
The figure is a schematic diagram of the "normal mode dark line" parameter



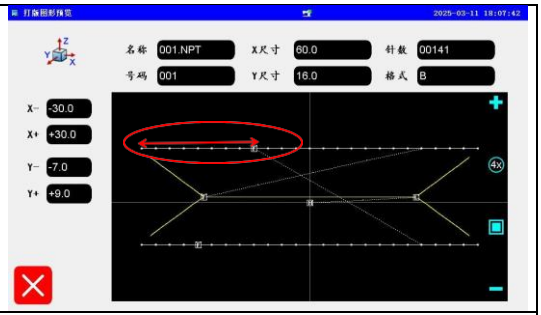
serial number	parameter name
A	Sewing length
B	Sewing width
C	Cut the distance in the X direction from the top left corner
C1	Cut the distance in the X direction from the top right corner
C2	Cut the distance in the X direction at the bottom left
C3	Cut the distance in the X direction from the bottom right corner
D	Cut the Y-direction distance in the upper left corner
D1	Cut the Y-direction distance in the upper right corner
D2	Cut the Y-direction distance in the lower left corner
D3	Cut the Y-direction distance from the bottom right corner
E	Cutting starting position
H	Tilt distance
FR	**Distance from code to left (left)**
FD	**Distance from code to bottom left**

2.3.27 FR-code to left distance (left)

Definition: The horizontal distance from the code to the left (left), with a numerical range of 0-100mm.
The following figure shows the effect of the 'Normal Mode Dark Line' code when the distance to the left (left) is 10 and 20.



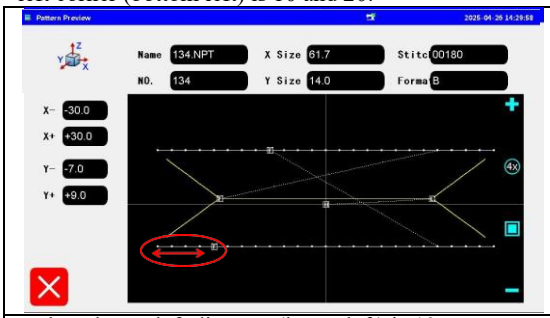
code to left distance (left) is 10



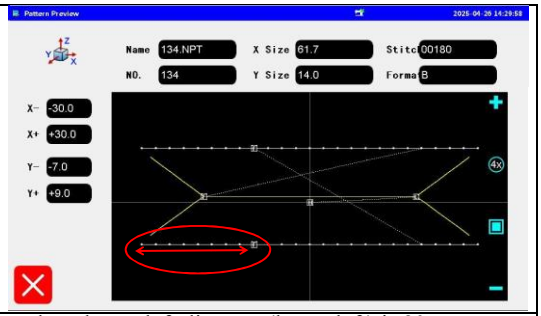
code to left distance (left) is 20

2.3.28 FD-code to lower left distance (lower left)

Definition: The horizontal distance from the code to the bottom left corner (bottom left), with a numerical range of 0-100mm.
The following figure shows the effect of the 'Normal Mode Dark Line' code when the distance from the bottom left corner (bottom left) is 10 and 20.

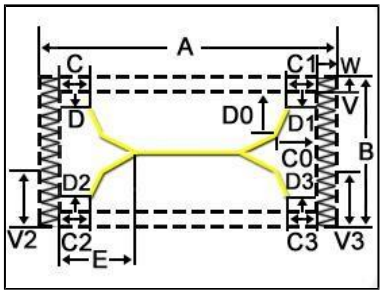


code to lower left distance (lower left) is 10



code to lower left distance (lower left) is 20

The figure is a schematic diagram of the parameters for "secondary sewing of cotton clothing with knots"

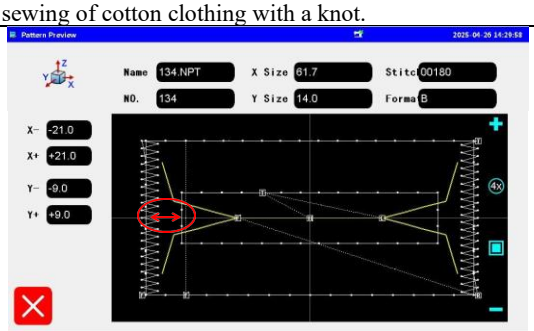


serial number	parameter name	serial number	parameter name
A	Sewing length	D3	Cut the Y-direction
B	Sewing width	C0	Cut the distance of the middle
C	Cut the distance in the X direction	D0	Cut the distance from the middle
C1	Cut the distance in the X direction	E	Cutting starting position
C2	Cut the distance in the X direction	V2	Y compensation distance (left)
C3	Cut the distance in the X direction	V3	Y compensation distance (right)
D	Cut the Y-direction distance in the	**W**	**Sewing width interval (top right)**
D1	Cut the Y-direction distance in the	**V**	**Sewing height interval (top right)**
D2	Cut the Y-direction distance in the lower left corner		

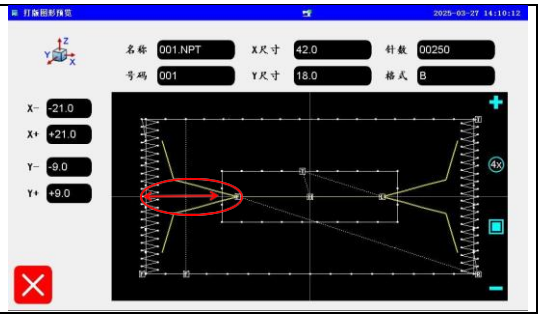
2.3.29 W-Sewing width interval (top right)

Definition: The horizontal distance of the sewing width interval (top right), with a numerical range of 0-100mm.

The following image shows the effect when the starting point of the cutting line is 5 and 10 for the secondary sewing of cotton clothing with a knot.



Sewing width interval (top right) is 5

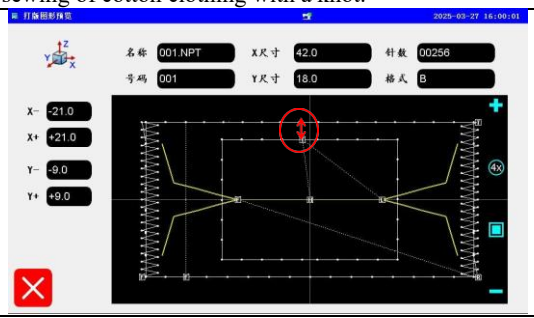


Sewing width interval (top right) is 10

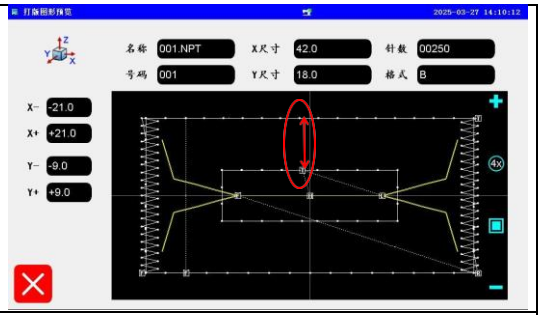
2.3.30 V-Sewing height interval (top right)

Definition: The longitudinal distance between sewing heights (top right), with a numerical range of 0-100mm.

The following image shows the effect when the starting point of the cutting line is 2 and 6 for the secondary sewing of cotton clothing with a knot.

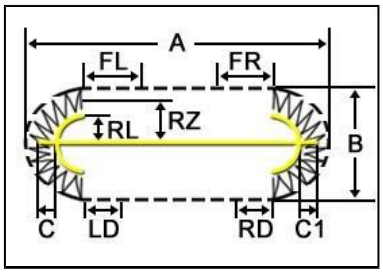


Sewing height interval (top right) is 2



Sewing height interval (top right) is 6

The figure is a schematic diagram of the parameters for "secondary seam rounded edge folding and nesting"

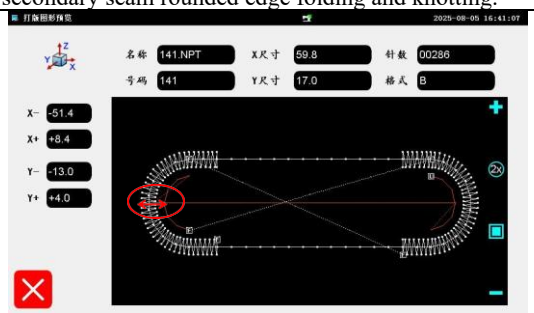
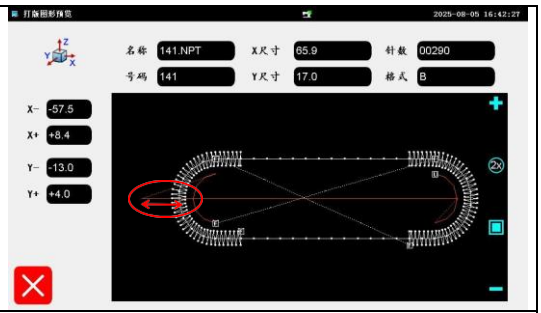


serial number	parameter name	serial number	parameter name
A	Sewing length	**FR**	**Compensation**
B	Sewing width	**LD**	**Compensation distance for**
C	**Cutting length in X direction (left)**	**RD**	**Compensation distance for**
C1	**Cutting length in X direction**	**RL**	**Laser arc radius**
FL	**Compensation distance for**	**RZ**	**Reinforcement line arc radius**

2.3.31 C-Cutting length in X direction (left)

Definition: The horizontal distance of the cutting length (left) in the X direction, with a numerical range of 0-99.9m.

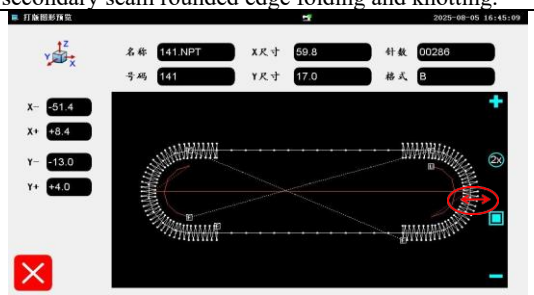
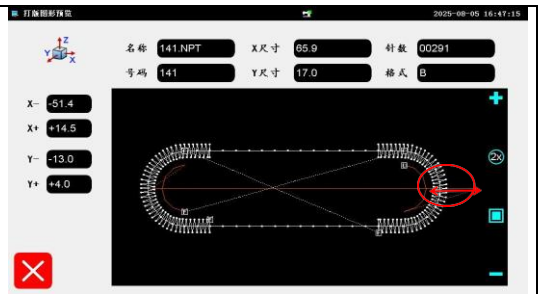
The following figure shows the effect when the cutting length (left) in the X direction is 2 and 10 for the secondary seam rounded edge folding and knotting.

	
Cutting length in X direction (left) is 2	Cutting length in X direction (left) is 10

2.3.32 C1-Cut length in the X direction (right)

Definition: The horizontal distance of the cutting length (right) in the X direction, with a numerical range of 0-99.9m.

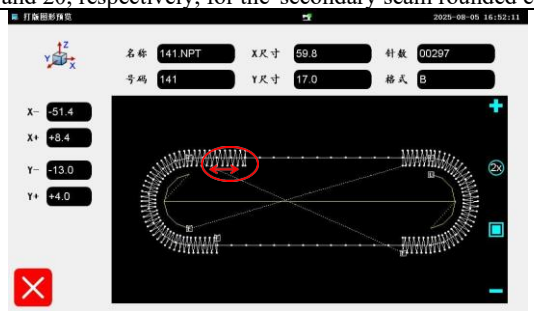
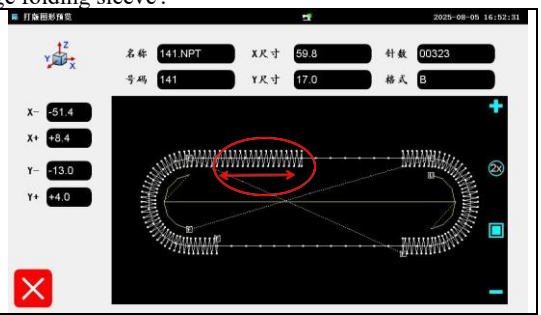
The following figure shows the effect when the cutting length (right) in the X direction is 2 and 10 for the secondary seam rounded edge folding and knotting.

	
Cut length in the X direction (right) is 2	Cut length in the X direction (right) is 10

2.3.33 FL-herringbone seam compensation distance (top left)

Definition: The horizontal distance of the compensating distance (top left) of the herringbone seam, with a numerical range of 0-999.9m.

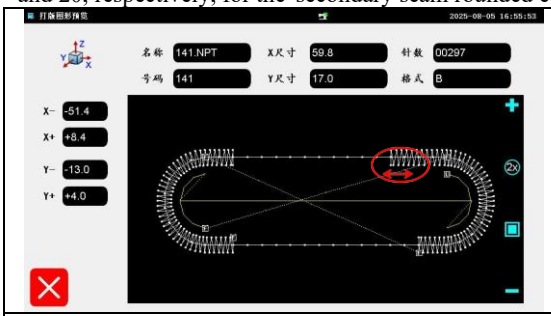
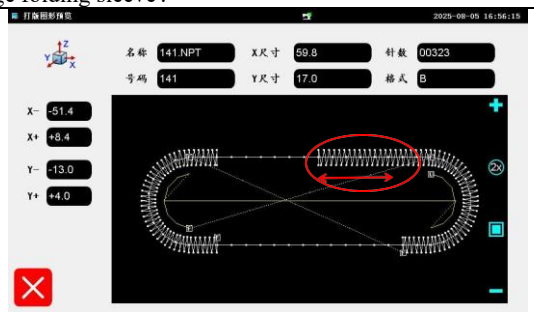
The following figure shows the effect when the compensating distance (top left) of the herringbone seam is 10 and 20, respectively, for the 'secondary seam rounded edge folding sleeve'.

	
herringbone seam compensation distance (top left) is 10	herringbone seam compensation distance (top left) is 20

2.3.34 FR-herringbone seam compensation distance (top right)

Definition: The horizontal distance of the compensating distance (top right) of the herringbone seam, with a numerical range of 0-999.9m.

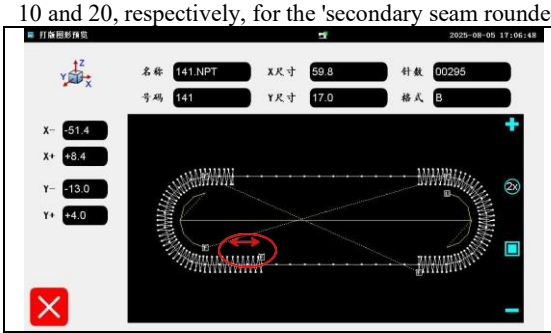
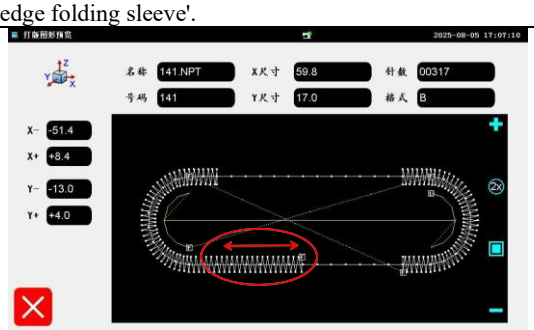
The following figure shows the effect when the compensating distance (top right) of the herringbone seam is 10 and 20, respectively, for the 'secondary seam rounded edge folding sleeve'.

	
herringbone seam compensation distance (top right) is 10	herringbone seam compensation distance (top right) is 20

2.3.35 LD-herringbone seam compensation distance (bottom left)

Definition: The horizontal distance of the compensating distance (bottom left) of the herringbone seam, with a numerical range of 0-999.9m.

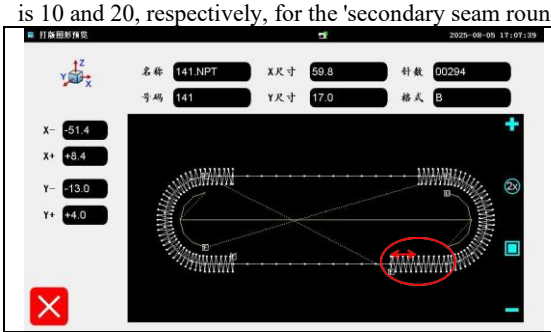
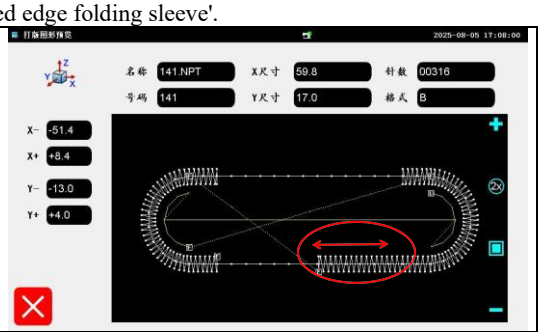
The following figure shows the effect when the compensating distance (bottom left) of the herringbone seam is 10 and 20, respectively, for the 'secondary seam rounded edge folding sleeve'.

	
herringbone seam compensation distance (bottom left) is 5	herringbone seam compensation distance (bottom left) is 10

2.3.36 RD-herringbone seam compensation distance (bottom right)

Definition: The horizontal distance of the compensating distance (bottom right) of the herringbone seam, with a numerical range of 0-999.9m.

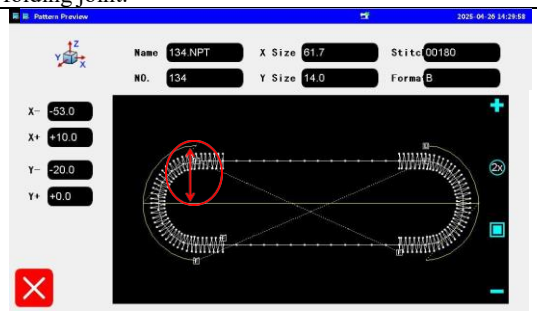
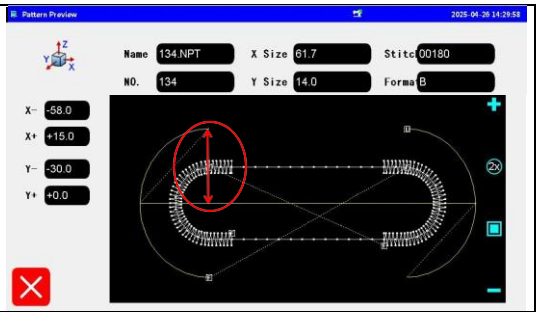
The following figure shows the effect when the compensating distance (bottom right) of the herringbone seam is 10 and 20, respectively, for the 'secondary seam rounded edge folding sleeve'.

	
herringbone seam compensation distance (bottom right) is 5	herringbone seam compensation distance (bottom right) is 10

2.3.37 RL-Laser Arc Radius

Definition: The length of the laser arc radius, with a numerical range of 0-100mm.

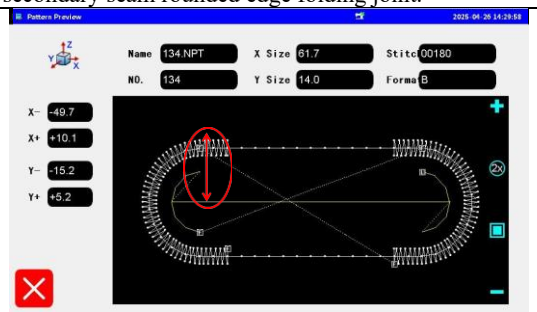
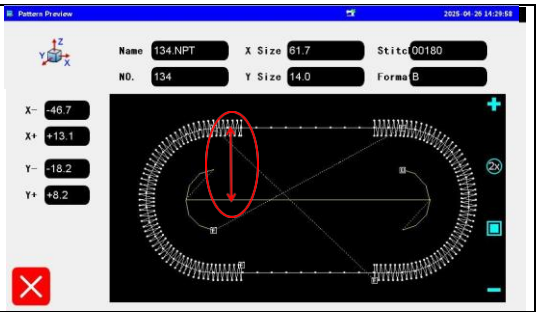
The following figure shows the effect of the laser arc radius of 10 and 15 for the secondary seam rounded edge folding joint.

	
Laser Arc Radius is 10	Laser Arc Radius is 15

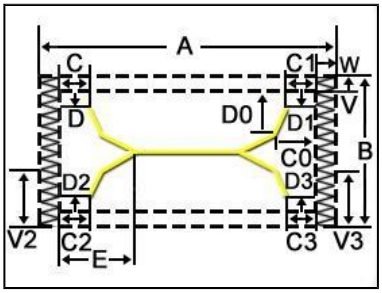
2.3.38 RZ - Reinforcement Line Arc Radius

Definition: The length of the radius of the reinforcing line arc, with a numerical range of 0-100mm.

The following figure shows the effect of the reinforcement line with a circular arc radius of 9 and 12 for the secondary seam rounded edge folding joint.

	
Reinforcement Line Arc Radius is 9	Reinforcement Line Arc Radius is 12

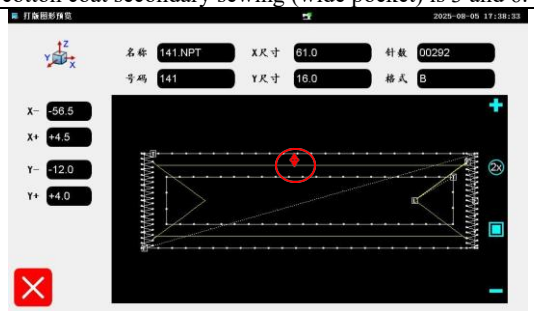
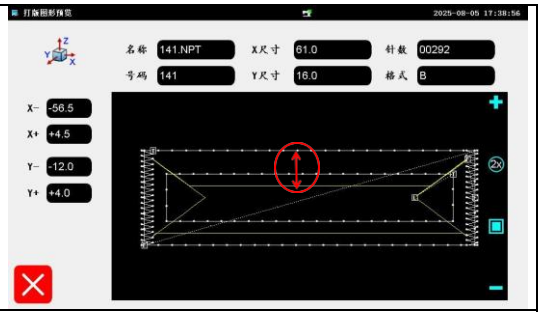
The figure is a schematic diagram of the parameters for "cotton clothing secondary sewing (wide pocket)"



serial number	parameter name
A	Sewing length
B	Sewing width
C	Cut the distance in the X direction from the top left
C1	Cut the distance in the X direction from the top right
C2	Cut the distance in the X direction at the bottom left
C3	Cut the distance in the X direction from the bottom
D	Cut the Y-direction distance in the upper left corner
D1	Cut the Y-direction distance in the upper right corner
D2	Cut the Y-direction distance in the lower left corner
D3	Cut the Y-direction distance from the bottom right
C0	Cut the distance of the middle point in the X direction
D0	Cut the distance from the middle point in the Y
E	Cutting starting position
V1	**Y compensation distance**
V2	Y compensation distance (left)
V3	Y compensation distance (right)
V4	**Under Y compensation distance**
W	Sewing width interval (top right)
V	Sewing height interval (top right)

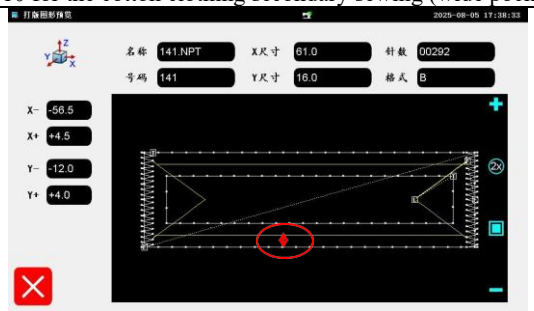
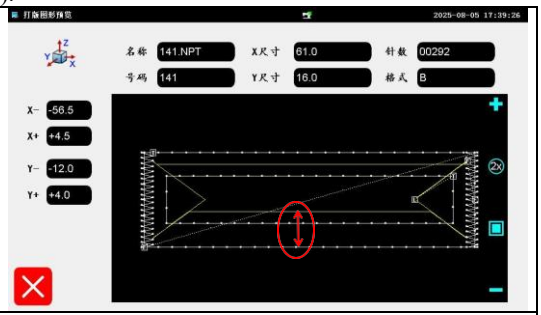
2.3.39 V1-Y compensation distance

Definition: The longitudinal distance on the Y compensation distance, with a numerical range of 0-100mm.
The following figure shows the effect when the longitudinal distance on the Y compensation distance of the cotton coat secondary sewing (wide pocket) is 3 and 6.

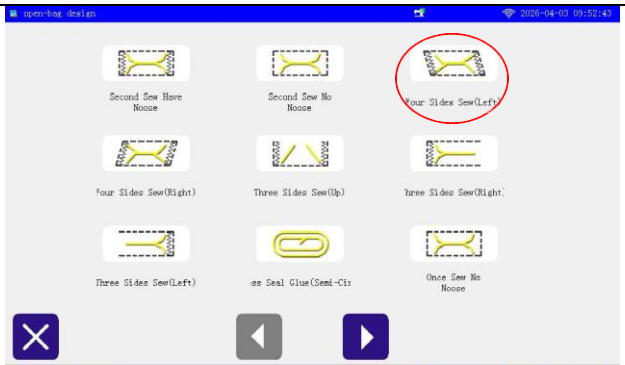
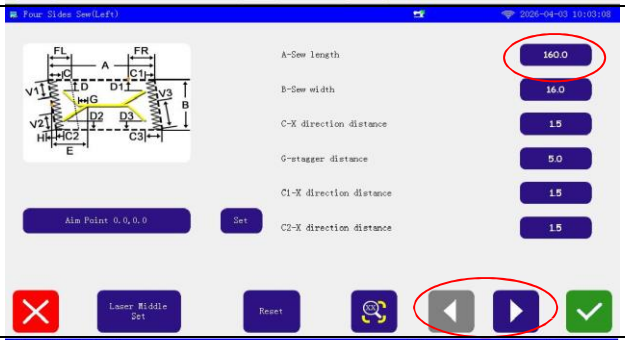
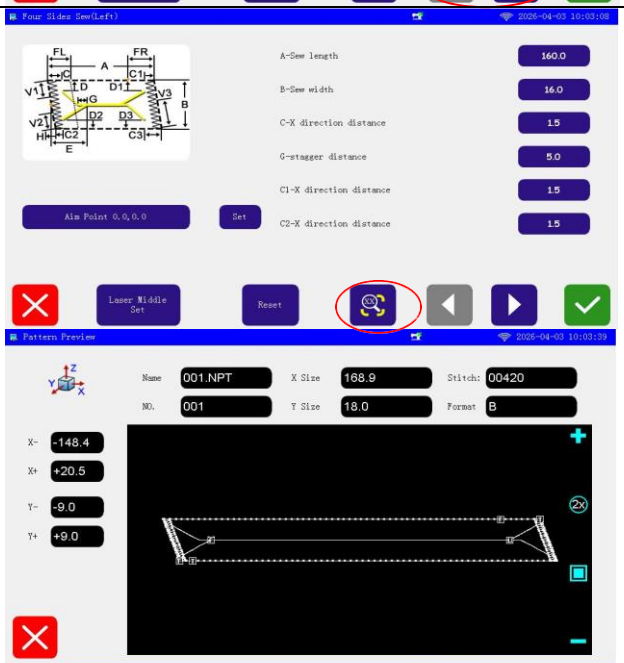
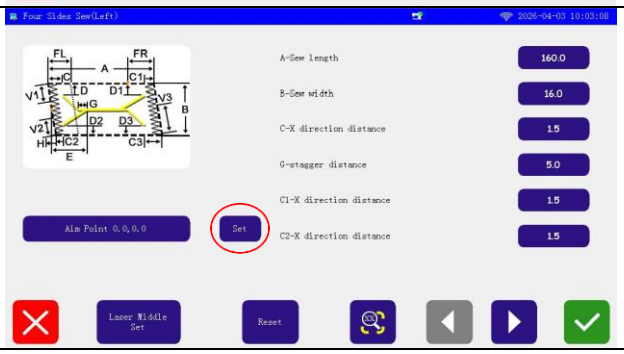
	
Y compensation distance is 3	Y compensation distance is 6

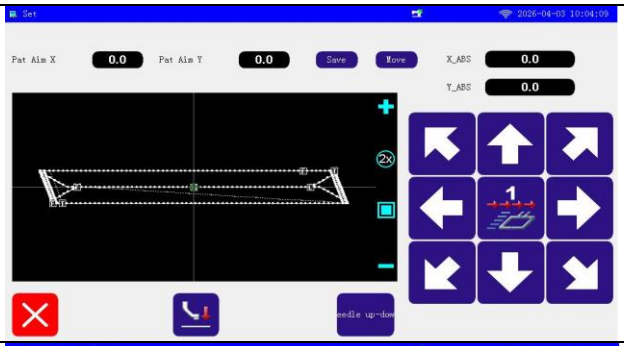
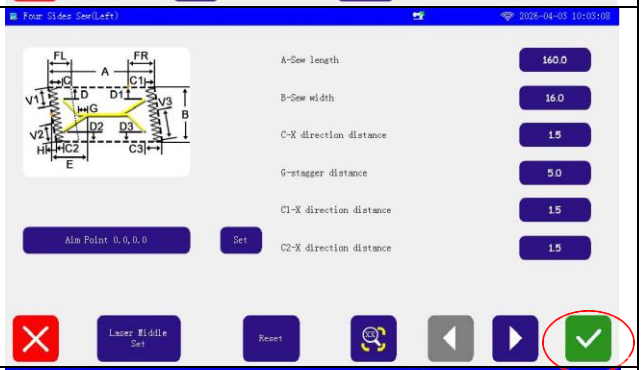
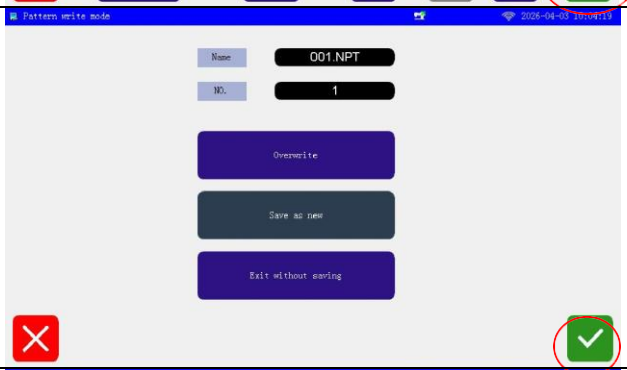
2.3.40 V4-Y compensation distance

Definition: The longitudinal distance under Y compensation distance, with a numerical range of 0-100mm.
The following figure shows the effect when the longitudinal distance under Y compensation distance is 5 and 10 for the cotton clothing secondary sewing (wide pocket).

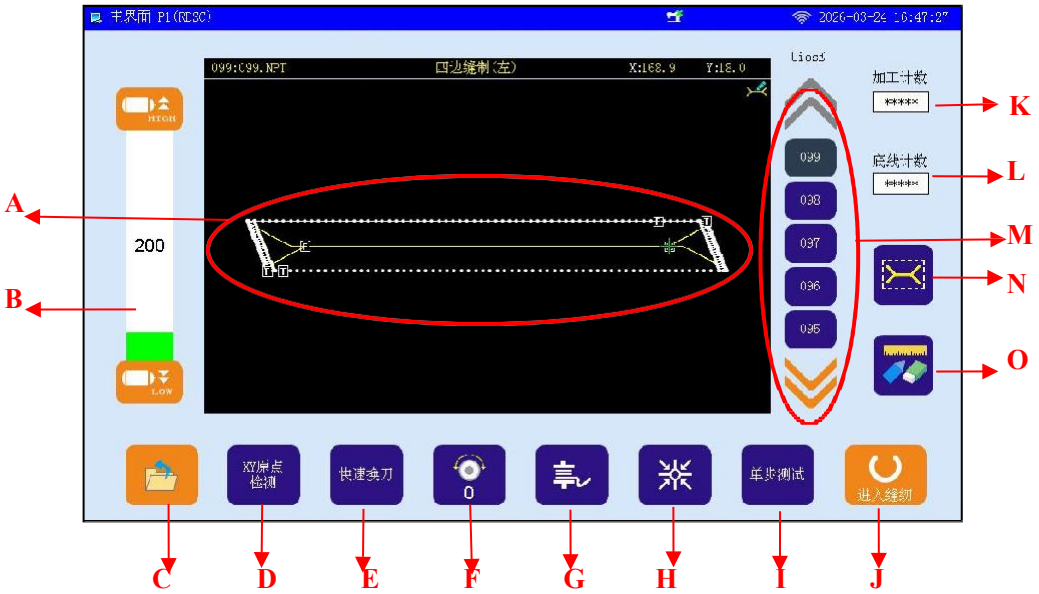
	
Y compensation distance is 3	Y compensation distance is 6

2.4 Operation demonstration

1. Select the corresponding bag opening template.	
2. Set corresponding values for needle spacing, length, width, etc. Use the page turning button to modify other data items.	
3. Click the preview button to enter the graphic preview interface. Click to exit.	
4. Click on Settings and adjust the XY position value of the pattern alignment point through the steering wheel.	

	
5. Click OK to save the pattern.	
6. Click OK.	
7. Set the name and number, click OK.	
8. The figure is shown on the right.	

Chapter 3: Setting Functions Related to Board Making Styles

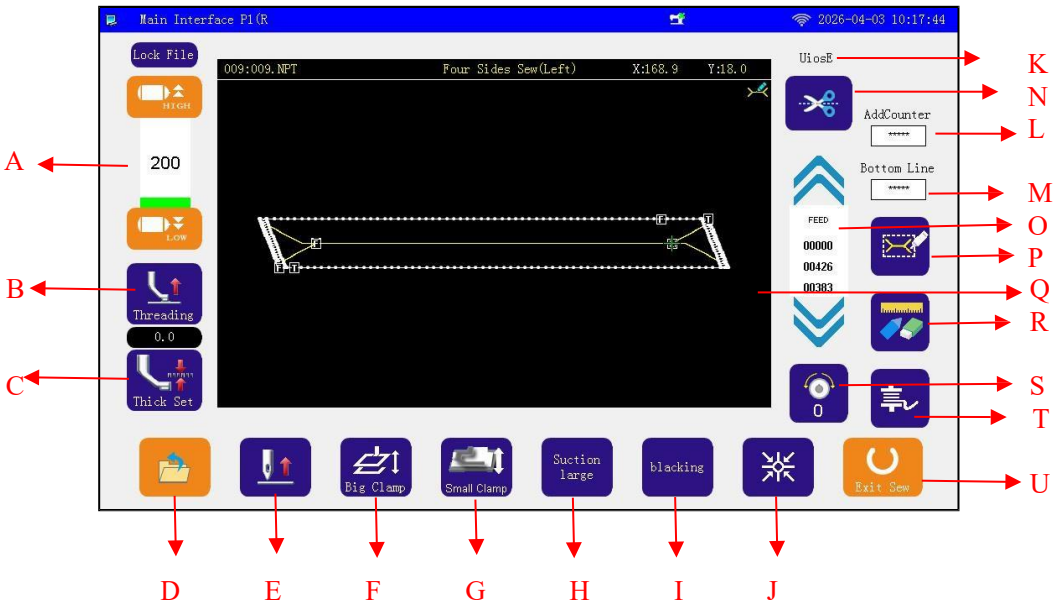


Main interface function description:

serial number	function	content
A	pattern	Display the current pattern
B	speed	Adjust sewing speed
C	menu	Enter menu mode
D	XY origin detection	Enter the XY origin detection interface
E	Quick knife change	Perform quick tool change action
F	Line tension	Set line tension
G	Winding mode	Enter the winding mode to set the winding core speed and time
H	return to original	Back to the origin
I	Single-step testing	Enter the single step testing interface
J	Enter sewing	Enter the sewing interface
K	processing count	Set the processing count value
L	Bottom line count	Set the baseline count value
M	Pattern number	Switching patterns
N	Shortcut Key - Bag Opening Design	Enter the quick printing interface for bag opening design, set parameters to quickly generate patterns
O	Shortcut Key - Pattern Modification	Enter pattern modification mode

3.1 Sewing interface

Click the 'Enter Sewing' button on the main interface to enter the sewing interface. As shown in the following figure.

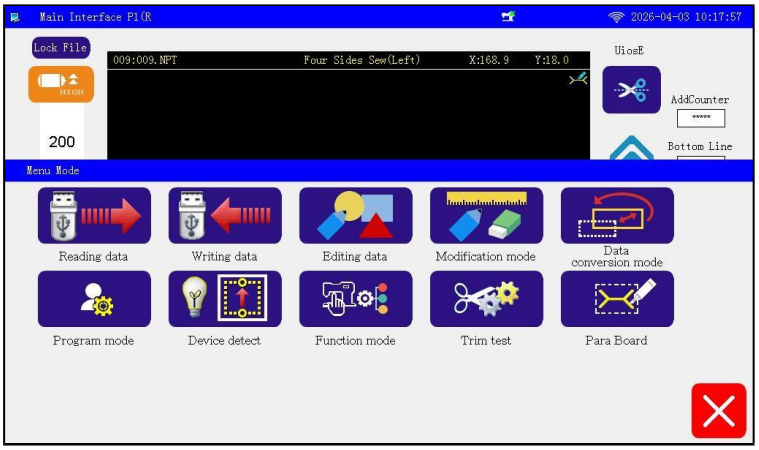


Function Description:

serial number	function	content
A	speed	Adjust sewing speed
B	threading	Lift the pressure foot/drop the pressure foot
C	material thickness	Set material thickness
D	menu	Enter menu mode
E	Needle takeoff and	Needle lifting/needle falling
F	Large pressure plate	Lift or drop the large pressure plate
G	Small pressure plate	Lift or drop the small pressure foot
H	Air intake volume	High suction air volume/medium suction air volume/low
I	blanking	Execute the cutting action
J	return to original	Back to the origin
K	Laser cleaning	Perform laser cleaning action
L	processing count	Set the processing count value
M	Bottom line count	Set the baseline count value
N	Cut the thread	Perform cutting action
O	transfer	Needle transfer in patterns
P	Shortcut Key - Bag Opening Design	Enter the quick printing interface for bag opening design, set parameters to quickly generate patterns
Q	Current pattern	Display the current pattern graphic
R	Shortcut Key - Pattern Modification	Enter pattern modification mode
S	Line tension	Set line tension
T	Winding mode	Enter the winding mode to set the winding core speed and time
U	Exit sewing	Exit sewing mode

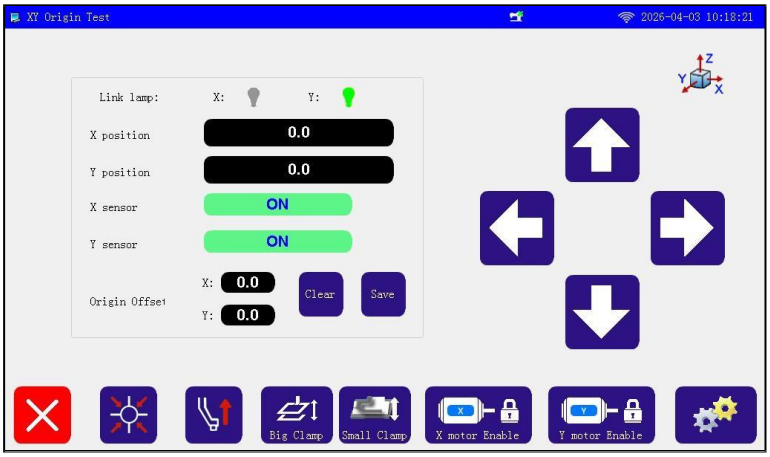
3.2 Menu Mode

Click the 'Menu' button on the main interface to enter menu mode.



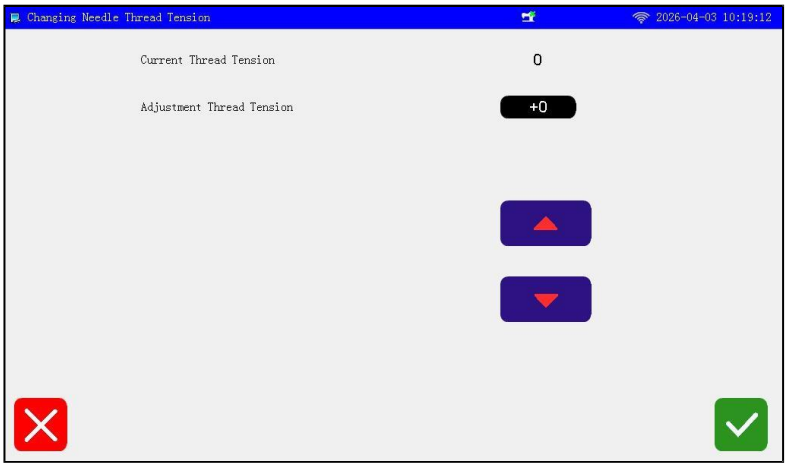
3.3 XY origin detection

Click the "XY Origin Detection" button on the main interface to enter the XY Origin Test interface.



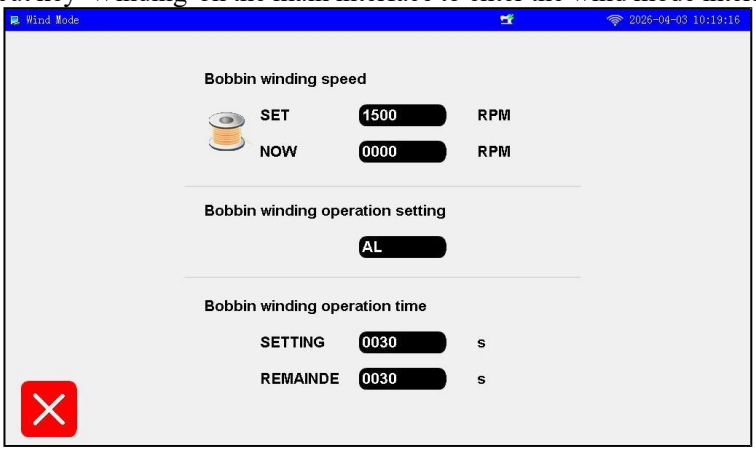
3.4 Line tension

Click the "Line Tension" button on the main interface to enter the setting Changing needle thread tesion interface.



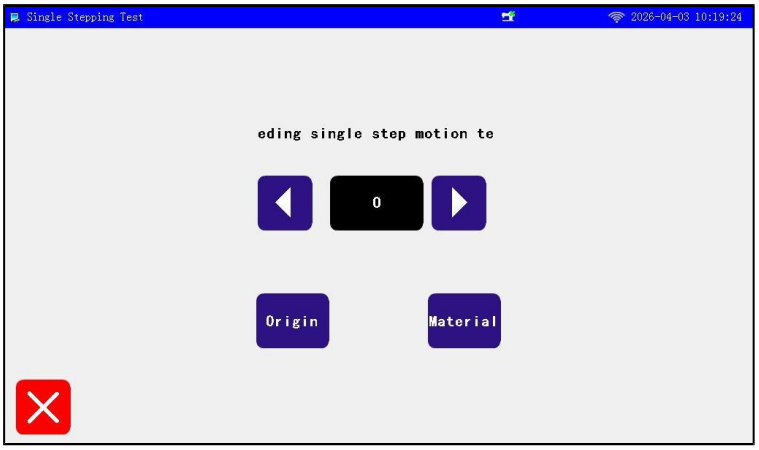
3.5 Winding

Click the shortcut key 'Winding' on the main interface to enter the wind mode interface.



3.6 Single step testing

Click the shortcut key 'Single Step Test' on the main interface to enter the single stepping test interface.

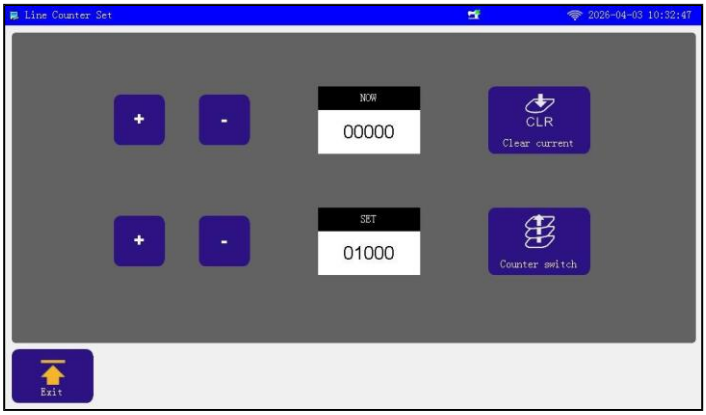


3.7 Modification Mode

Click the 'Modify Mode' button on the main interface to enter the modify mode interface.

3.8 Processing Counting

Click the 'Processing Count' button on the main interface to enter the counting setting interface.



include:

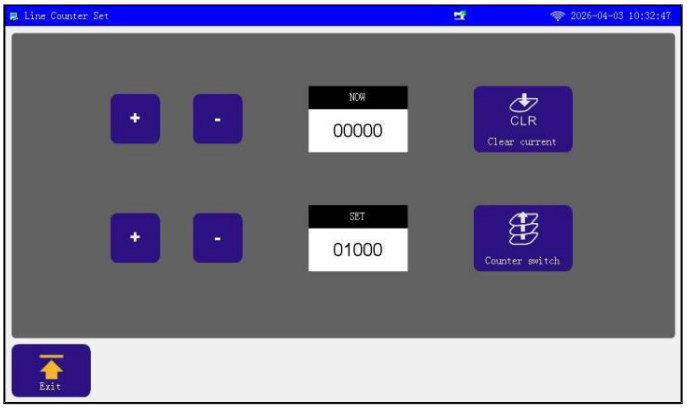
1. Set the production count value (total count).
2. Set the current value of production count.
3. Counter function on/off button.
4. Clear the current value button to reset the current count to zero.

Set target count: In the setting area, enter the desired target count value. Ensure that the input and target numbers meet the production requirements.

Click the confirm button, and the system will start counting the output data during the production process.

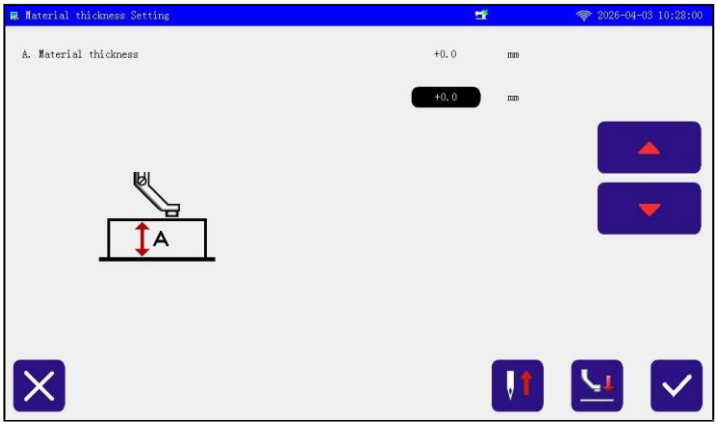
3.9 Bottom line counting

Click the 'Bottom Line Counting' button on the main interface to enter the line counter set interface.



3.10 Material thickness

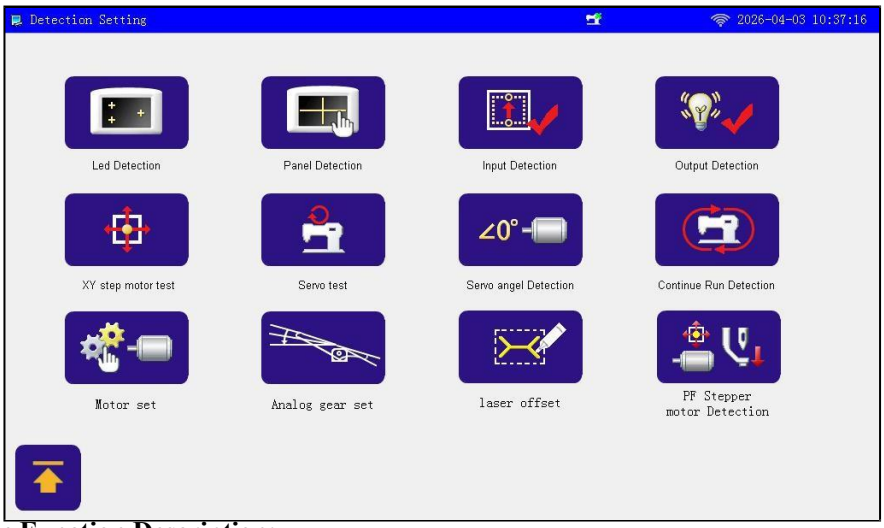
Click the 'Material Thickness' button on the sewing interface to set the material thickness setting interface.



3.11 Air intake volume

Click on the 'Suction Air Volume' button on the sewing interface to adjust the suction air volume.

Chapter 4 Equipment Testing



Interface Function Description:

1. Enter the device testing interface

Function description: Users can enter the device detection interface through the device detection button in the menu.

2. LCD detection

Function description: Enable or disable screen detection function, set detection time.

3. Touch screen detection

Function description: Users can enter the touch screen detection interface through the menu interface to calibrate the screen.

4. Input signal detection and output signal detection

Function description:

This function is used to detect the status of input and output signals and ensure that the system will receive the correct signals.

Usage steps:

1.1 Find the input/output signal detection button in the device detection interface.

1.2 Clicking this button will start inputting signals.

1.3 Observe the signal status displayed on the interface and confirm if the signal is normal.

5. XY stepper motor detection

Function description: It can debug the XY axis click position and switch.

6. Servo motor testing

Function description: This function is used for detecting the spindle angle to ensure that the spindle operates within the normal range.

7. Spindle angle detection

Function description: This function is used for detecting the spindle angle to ensure that the spindle operates within the normal range.

8. Continuous operation detection

Function description: Adjust the action interval time, the number of material receiving origin detections, the number of cycles, etc.

9. Motor settings

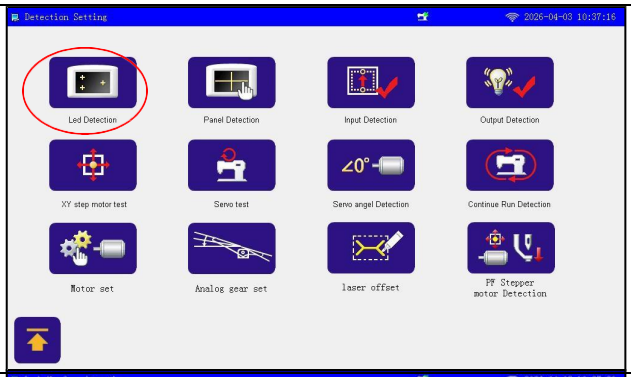
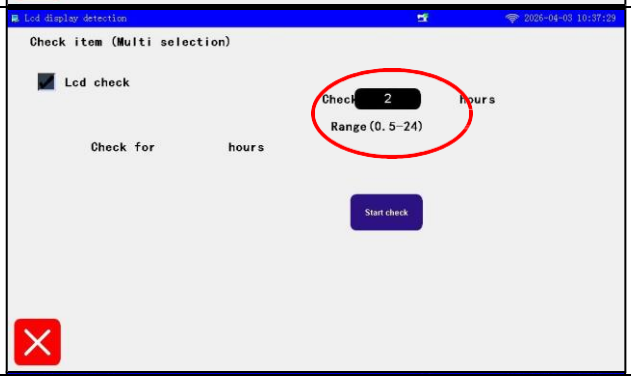
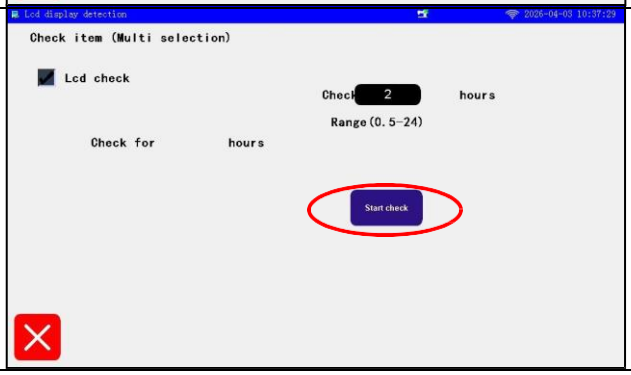
Function description: Motor setting and testing.

10. Laser offset

Function description: Adjust laser coordinates and needle coordinates, set offset.

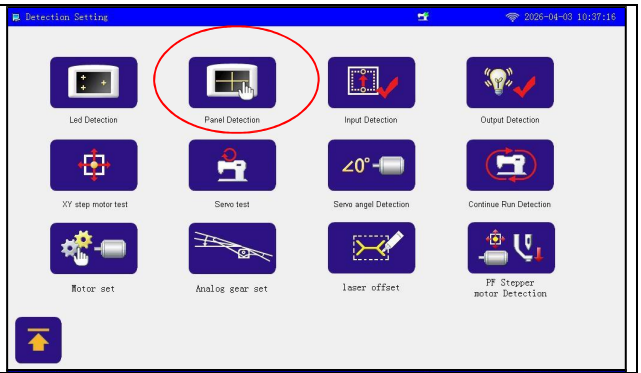
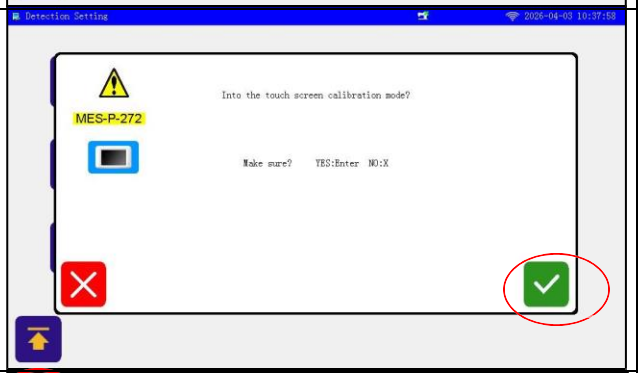
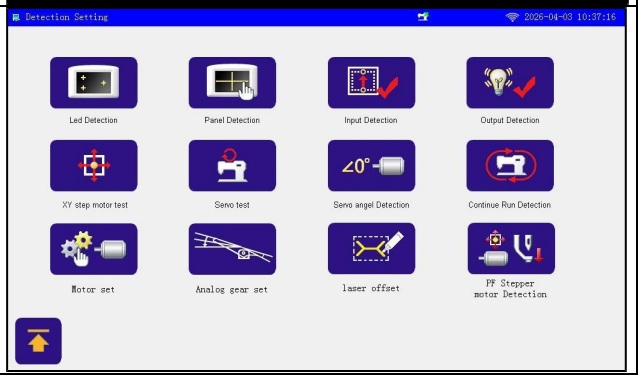
4.1 LCD detection

Click the 'Port Test' button in the menu to enter the detection mode interface and enter the LCD detection.

1. Click the "LCD detection" button.	
2. Enter the screen detection interface and select screen detection.	
3. Set the screen detection interval time.	
4. Click to start detection.	

4.2 Touch screen detection

Click the 'Port Test' button in the menu to enter the detection mode interface and enter the touch screen detection.

1. Click the "pannel setecction" button.	
2. Press Enter to confirm.	
3. Follow the cursor and click on the calibration one by one.	
4. Finally, return to the "Detection Mode" interface.	

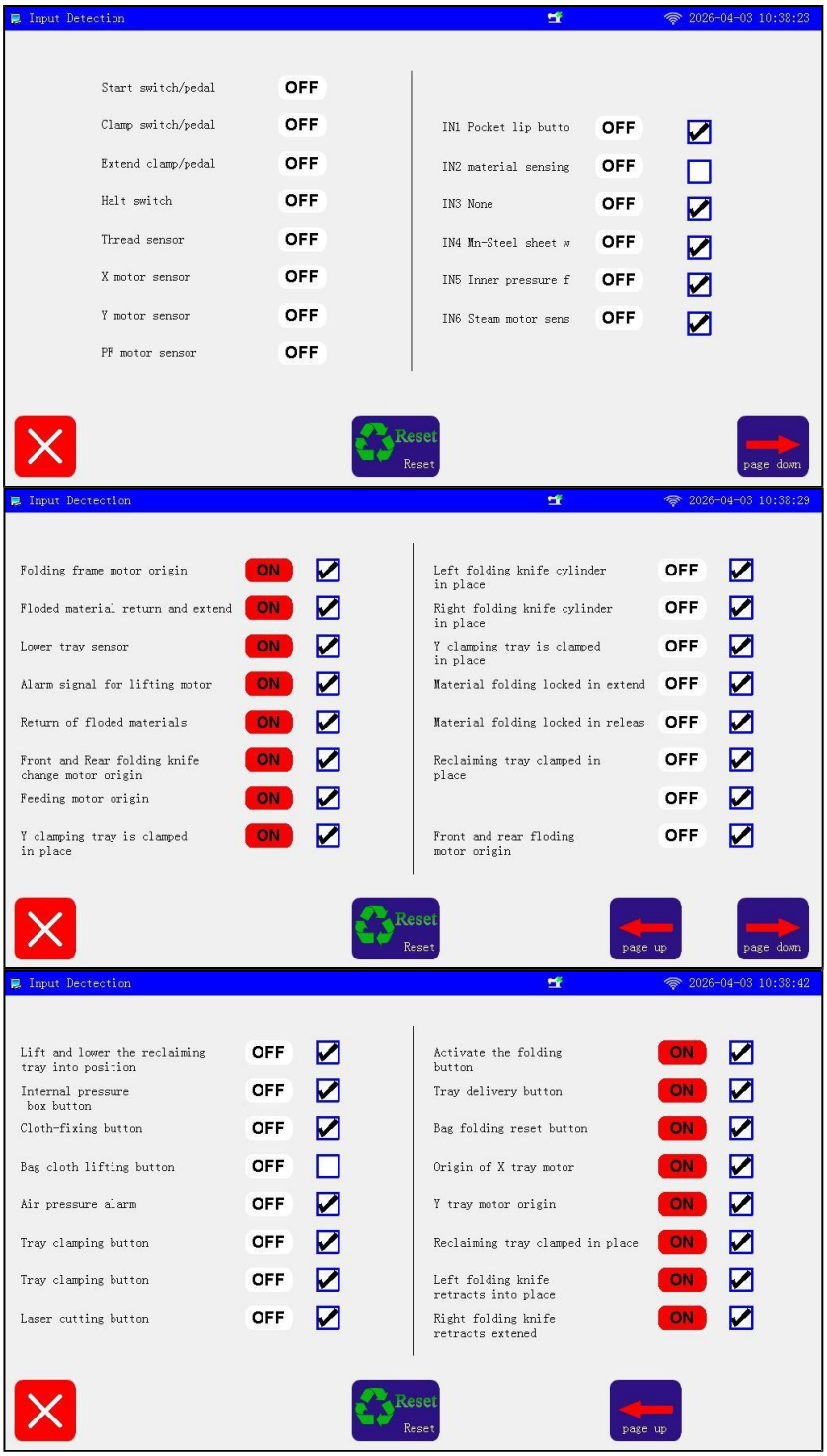
4.3 Input signal detection

Click the 'Input Signal Detection' button to enter the input signal detection interface. Implement query communication to control signal OFF/ON. The interface includes the following content displayed as shown in the following figure.

Precautions:

Before performing any operation, please ensure that the mechanical device is correctly installed and connected to avoid errors caused by improper linking.

During operation, pay attention to safety and avoid moving parts to prevent accidental injury.



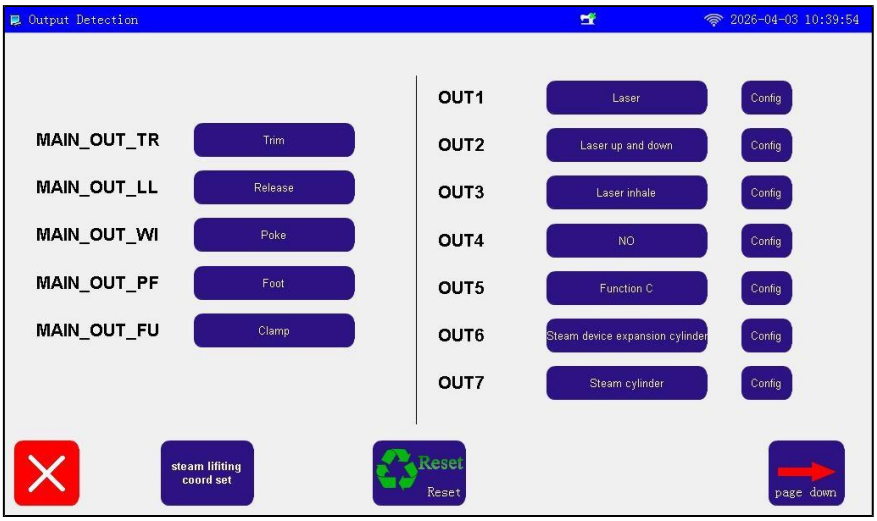
4.4 Output signal detection

Click the 'Input Signal Detection' button to enter the input signal detection interface. Implement query communication to control signal OFF/ON. The interface includes the following content displayed as shown in the following figure.

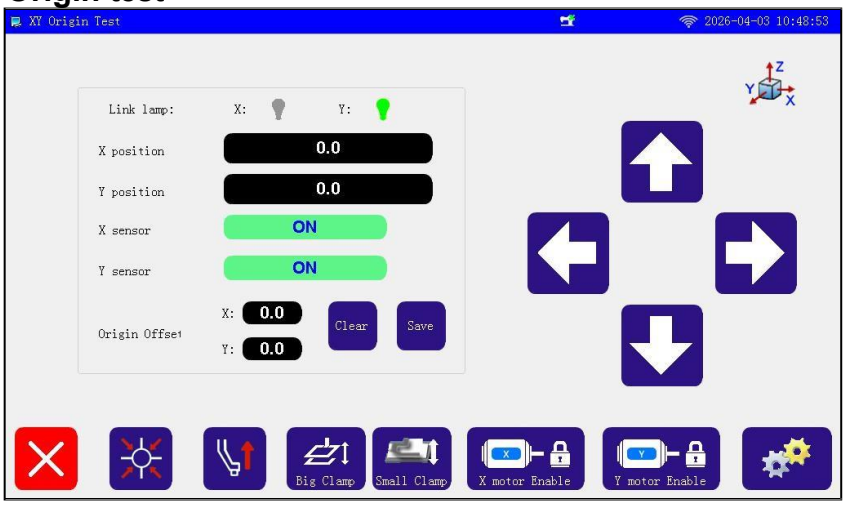
Precautions:

Before performing any operation, please ensure that the mechanical device is correctly installed and connected to avoid errors caused by improper linking.

During operation, pay attention to safety and avoid moving parts to prevent accidental injury.

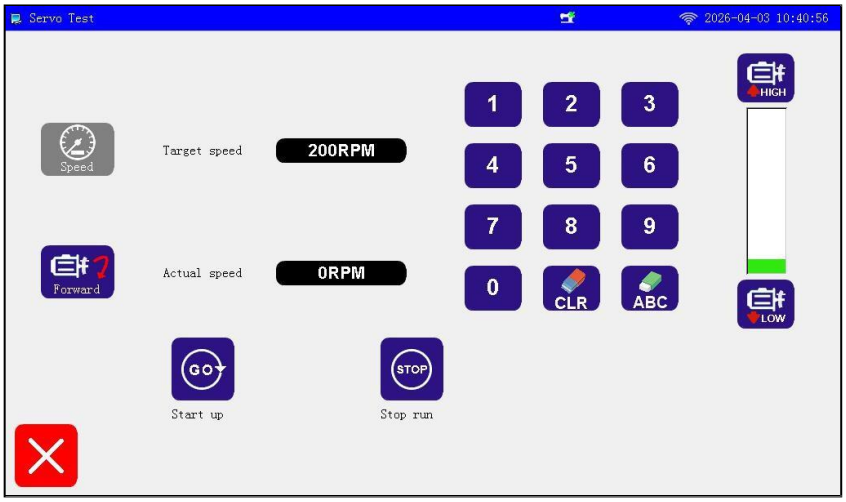


4.5 XY Origin test



Click the XY stepper motor detection button to enter the XY Origin test interface. On this interface, you can adjust the XY axis click position and switch.

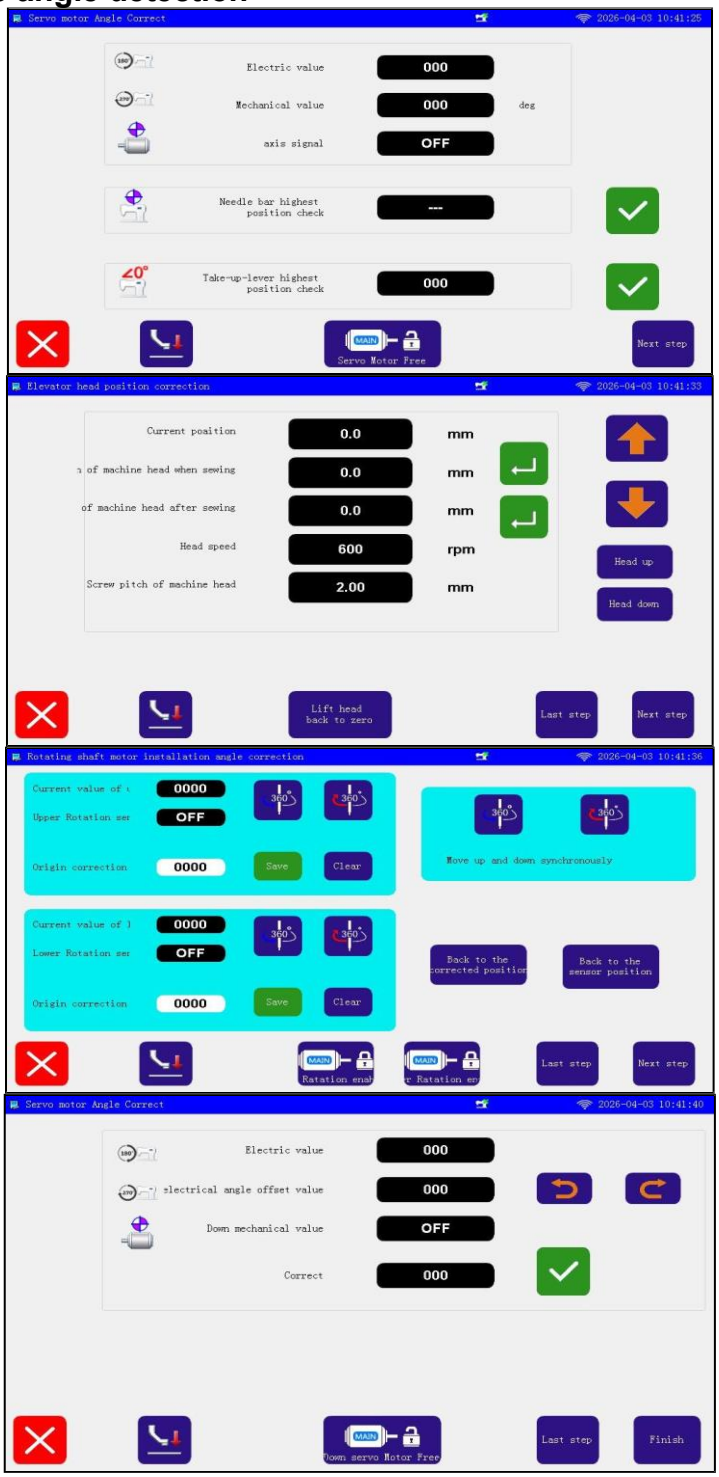
4.6 Servo Test



Click the 'Servo Motor Detection' button to enter the spindle speed detection interface. On this interface, you can adjust the spindle speed. As shown in the figure.

1. Display actual speed: Display the actual speed (RPM) of the current spindle.
2. Set speed: Allow the use of input or buttons to reach the target speed.
3. Control buttons: Basic operation buttons such as start, stop, reset, etc.
4. Alarm: If a safe range is set, an alarm message will be displayed.
5. Adjustment and optimization: If you need to adjust the spindle speed, you can reset the target setting value.

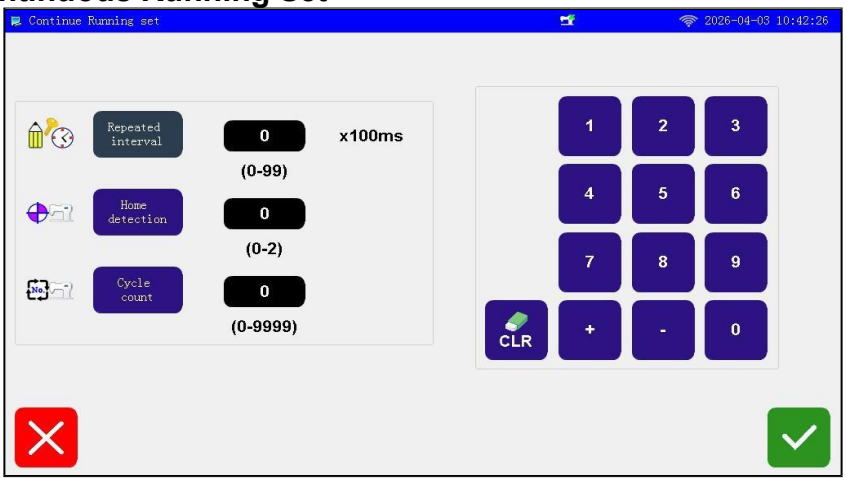
4.7 Spindle angle detection



Click the 'Spindle Angle Detection' button to enter the spindle motor installation angle correction interface. On this interface, you can debug the spindle motor. As shown in the following figure.

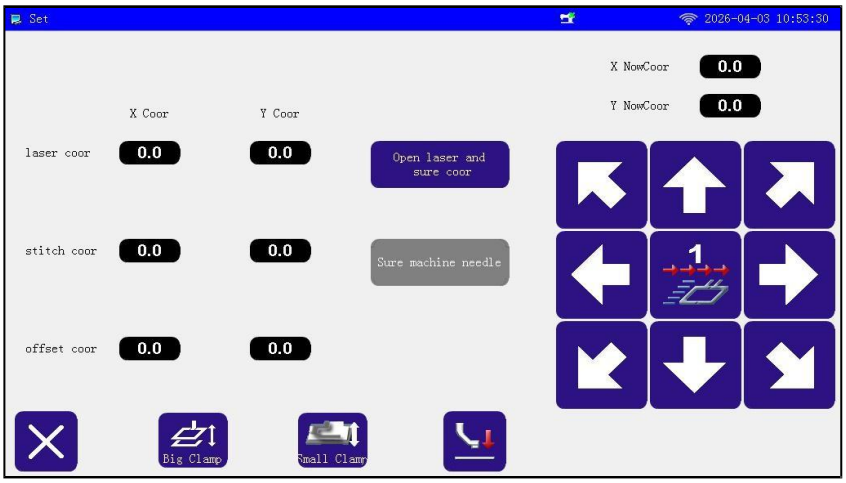
1. Determine necessary safety measures before making adjustments. Install the sensor correctly onto the spindle and reference point. Confirm that they are secure and in the correct position. Open the interface and complete the initialization settings.
2. Find the "Spindle Motor Release/Lock" button on the interface, click it to release or lock it, allowing it to move freely for easy adjustment.
3. Conduct measurements, rotate the spindle by a certain angle, read data from multiple positions, calculate the current offset, and display it on the interface.
4. After adjusting to the satisfactory position, find "Spindle Motor Lock" on the software interface to prevent displacement during operation.
5. Final validation, perform a complete measurement again to ensure that all parameters are within the allowable tolerance range.

4.8 Continuous Running Set



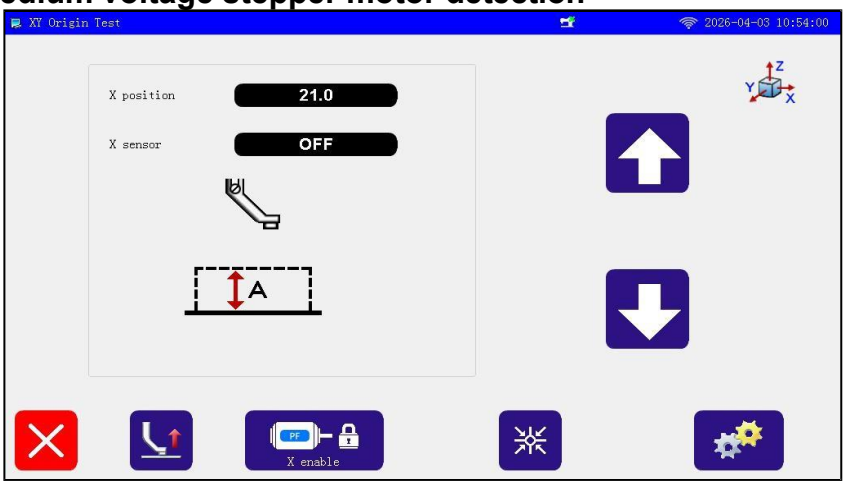
Click the 'Continuous Operation Detection' button to enter the continuous operation detection interface. Adjust the action interval time, the number of material receiving origin detections, the number of cycles, etc.

4.9 Laser offset



Click the 'Continuous Operation Detection' button to enter the continuous operation detection interface. Adjust the action interval time, the number of material receiving origin detections, the number of cycles, etc.

4.10 Medium voltage stepper motor detection



Click the 'Continuous Operation Detection' button to enter the continuous operation detection interface. Adjust the action interval time, the number of material receiving origin detections, the number of cycles, etc.

Chapter 5 System Upgrade and Function Settings

5.1 System Upgrade

Click on the [Function Mode] ->[Version Query and Upgrade] button on the menu interface to enter the firmware version mode interface. Used to view the version number of the control system. Example: Version information of the main control, panel, manufacturer logo, stepper, etc.

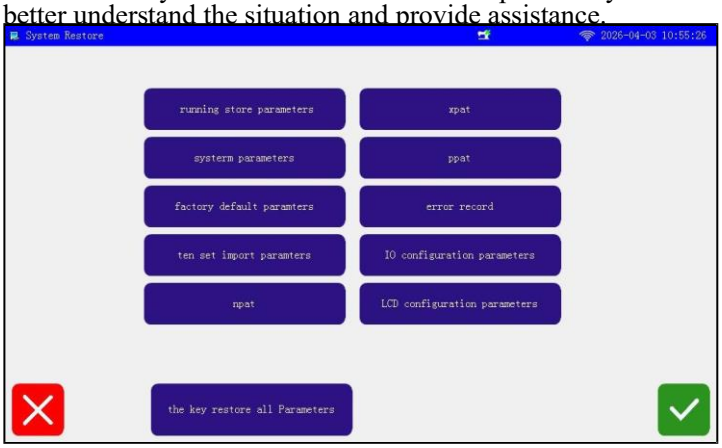
Click the 'Upgrade' button to enter the system upgrade mode interface. Version upgrade and system restore functions can be implemented on this interface. As shown in the following figure.

1. Version upgrade: Search for the upgrade file on the USB drive, and the system will prompt for installation. Click the 'One click Upgrade' button to proceed with the version upgrade process. Do not turn off the power during the upgrade process. After the upgrade is completed, a prompt box will pop up. Please turn off the power and restart it patiently. After restarting the system, you will enter the new version interface. Please check if the new version's functions are normal to ensure that everything runs smoothly.

2. In case of upgrade errors or backtracking to past versions, you can click on the upper left corner of the startup connection to enter the relevant settings interface and make changes to the system version. If you see the error message, try restarting the settings and upgrading again.

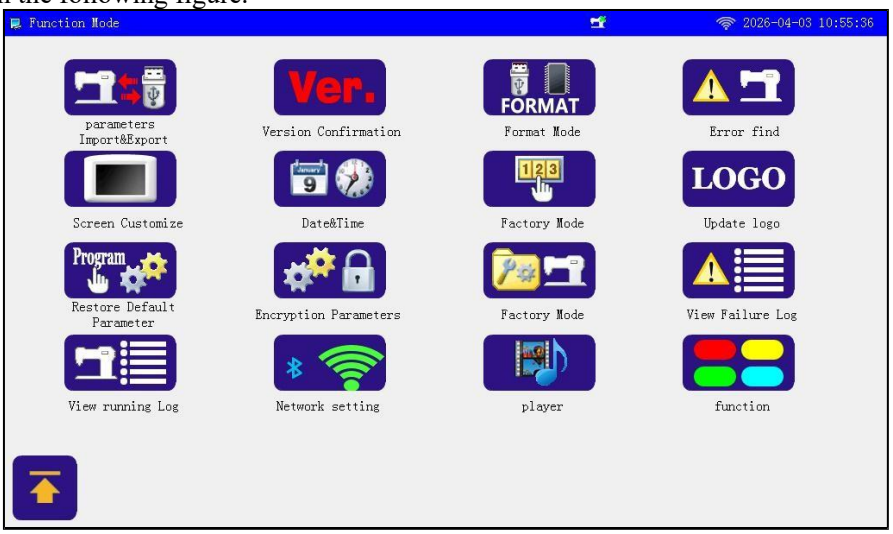
3. System restore: Click the [One click restore] button to enter the system restore interface. As shown in the following figure. You can restore all parameters with one click, or select the parameter items that need to be restored. After the operation, restore to the original default value. After the system restoration is completed, a prompt box will pop up, please restart the power.

4. Troubleshooting: If the upgrade issue persists. You can search for the technical support contact information provided by the company. Please make sure to provide a detailed description of the solutions you have tried to solve the problem you encountered, so that technicians can better understand the situation and provide assistance.



5.2 Function Settings

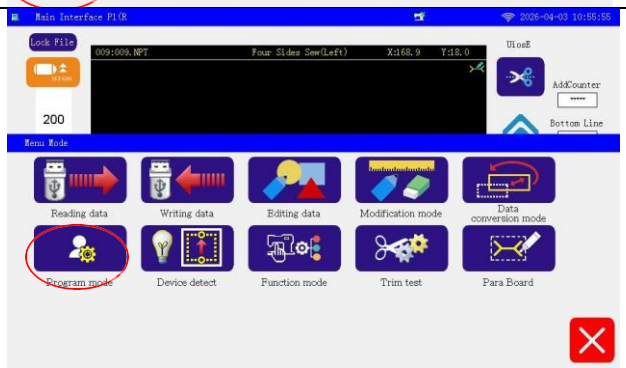
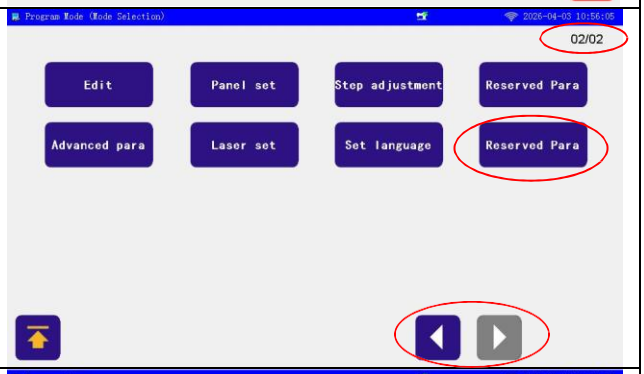
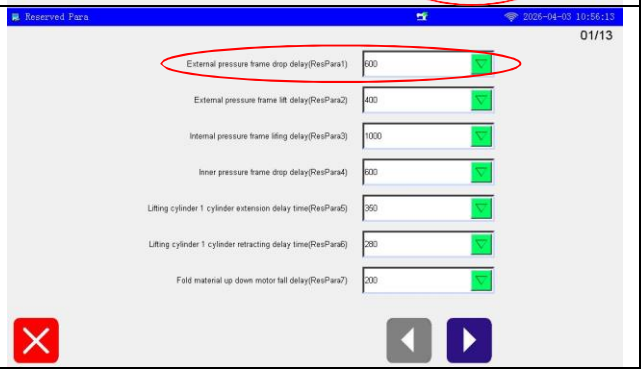
Click on the [System and Upgrade] ->[Function Settings] button on the motor debugging interface to enter the function mode interface. This interface is divided into sixteen modules. As shown in the following figure.



Chapter 6 Reserved Parameters

6.1 Reserved parameter operation

Operation steps:

1. Click on the menu.	
2. Enter parameter settings.	
3. Scroll to the last page and click on the reserved parameters.	
4. Modify parameters.	

6.2 Parameter Introduction

Reserved Parameters Page 1:

serial	parameter	value	Modify the interval
1	External pressure frame drop delay	600	Range: 0-30000
2	External pressure frame lift delay	400	Range: 0-30000
3	Internal pressure frame lifting delay	1000	Range: 0-30000
4	Inner pressure frame drop delay	600	Range: 0-30000
5	Lift cylinder 1 cylinder extension delay time	350	Range: 0-30000
6	Lift cylinder 1 cylinder retracting delay time	280	Range: 0-30000
7	Fold material up down motor fall delay	200	Range: 0-9999

Reserved Parameters Page 2:

serial	parameter	value	Modify the interval
1	Lifting action delay of bag cloth	200	Range: 0-9999
2	External pressure frame fixed material open delay	200	Range: 0-30000
3	External pressure frame fixed material closing delay	500	Range: 0-30000
4	Moving action delay of bag cloth	500	Range: 0-9999
5	Cloth clamp fixed action delay	200	Range: 0-9999
6	Feeding tray rise and fall open delay	250	Range: 0-30000
7	Feeding tray rise and fall close delay	0	Range: 0-30000

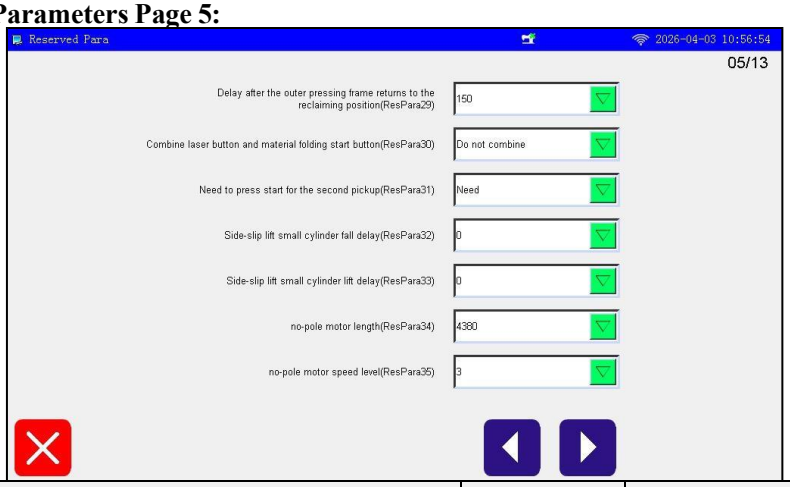
Reserved Parameters Page 3:

serial	parameter	value	Modify the interval
1	Delay after front and back fold knife is insert	0	Range: 0-30000
2	Delay after front and back fold knife is retracted	0	Range: 0-30000
3	Delay after front and back fold knives are lowered	0	Range: 0-30000
4	Delay after front and back fold knives rise	0	Range: 0-30000
5	Feeding tray clamp delay	250	Range: 0-30000
6	Feeding tray return delay	200	Range: 0-30000
7	Left and right folded material 1 sandwiched in delay	0	Range: 0-30000

Reserved Parameters Page 4:

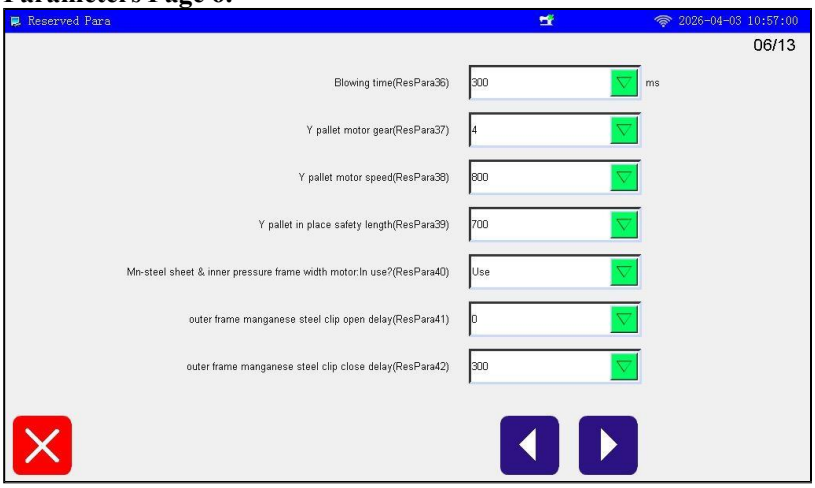
serial	parameter	value	Modify the interval
1	Left and right folding 1 return delay	0	Range: 0-30000
2	Left and right folding material 2 falling delay	0	Range: 0-30000
3	Left and right folding 2 rise delay	0	Range: 0-30000
4	The first material collection and suction air delay shutdown time	150	Range: 0-9999
5	Is the top bag air cylinder used	do not use	use; do not use
6	The second material collection and suction air delay shutdown time	50	Range: 0-9999
7	Bag top fabric cylinder delay	0	Range: 0-9999

Reserved Parameters Page 5:



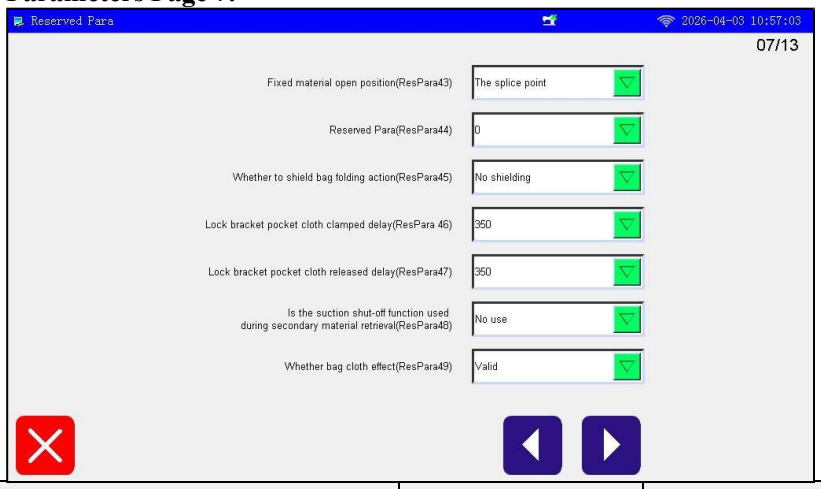
serial	parameter	value	Modify the interval
1	Delay after the outer pressing frame returns to the reclaiming position	150	Range: 0-30000
2	Combine laser button and material start button	Do not merge	Not merging; merge
3	Need to press start for the second pickup	need	need; No need
4	Side-slip lift small cylinder fall delay	0	Range: 0-30000
5	Side-slip lift small cylinder lift delay	0	Range: 0-30000
6	no-pole motor length	4380	Range: 0-25000
7	no-pole motor speed level	3	Range: 0-9

Reserved Parameters Page 6:



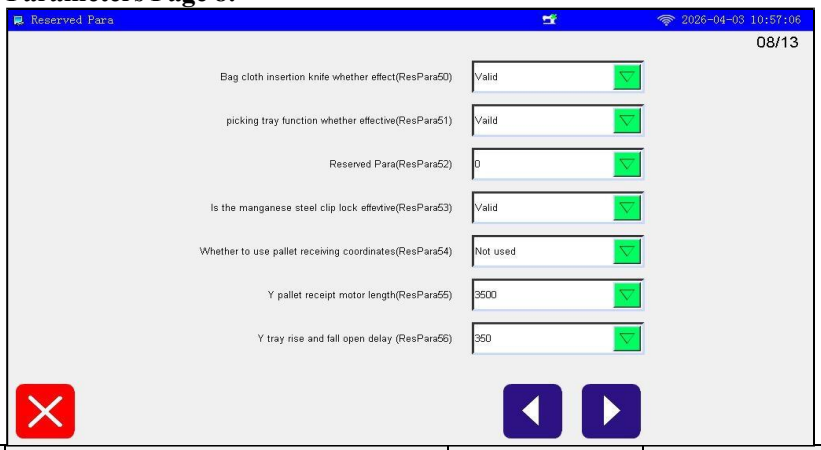
serial	parameter	value	Modify the interval
1	Blowing time	300	Range: 0-9999
2	Y pallet motor gear	4	Range: 0-9
3	Y pallet motor speed	800	Range: 0-800
4	Y pallet in place safety length	700	Range: 0-25000
5	Mn-steel sheet & inner pressure frame width motor:In use?	use	Not used; use
6	outer frame manganese steel clip open delay	0	Range: 0-30000
7	outer frame manganese steel clip close delay	300	Range: 0-30000

Reserved Parameters Page 7:



serial	parameter	value	Modify the interval
1	Fixed material open position	Material receiving point	Material receiving point - Open material receiving point Starting point - Starting point open Open halfway - Return to the starting point and open halfway
2	Reserved para	0	Range: 0-30000
3	Whether to shield bag folding action	do not block	Do not block - Do not block Shielding - Shielding Folding Bag Action Shielding - Shielding folding bag action and fixed sheet action
4	Lock bracket pocket cloth clamped delay	350	Range: 0-30000
5	Lock bracket pocket cloth released delay	350	Range: 0-30000
6	Is the suction shut-off function used during secondary material retrieval	do not use	Not used - Not used Use 1-use, turn off the suction air during secondary material retrieval Use 2- High air volume during secondary material retrieval Use 3- during secondary material retrieval, the air volume is moderate Use 4- Low air volume during secondary material retrieval
7	Whether bag cloth effect	effective	Invalid, valid

Reserved Parameters Page 8:

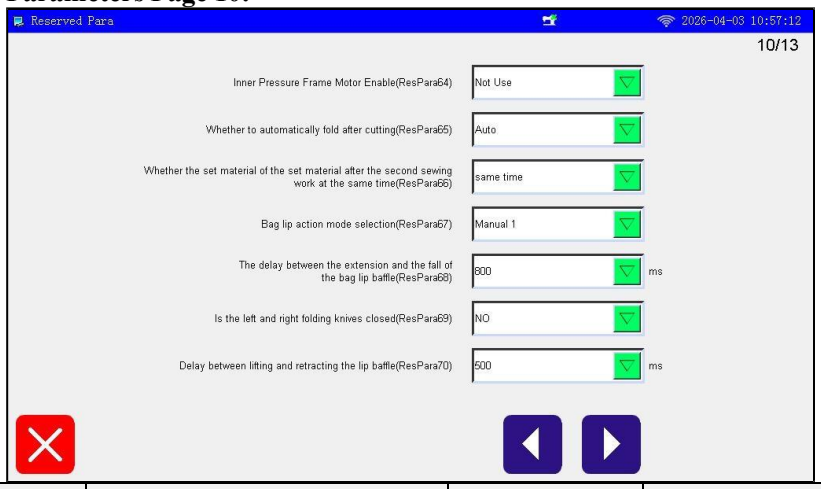


serial	parameter	value	Modify the interval
1	Bag cloth insertion knife whether effect	effective	Invalid, valid
2	picking tray function whether effective	effective	Invalid, valid
3	Reserved Para	0	Range: 0-30000
4	Is the manganese steel clip lock effective	effective	Invalid, valid
5	Whether to use pallet receiving coordinates	do not use	Not used - share one set of Y coordinates; Use - Separate two sets of Y coordinates
6	Y pallet receipt motor length	3500	Range: 0-25000
7	Y tray rise and fall open delay	350	Range: 0-30000

Reserved Parameters Page 9:

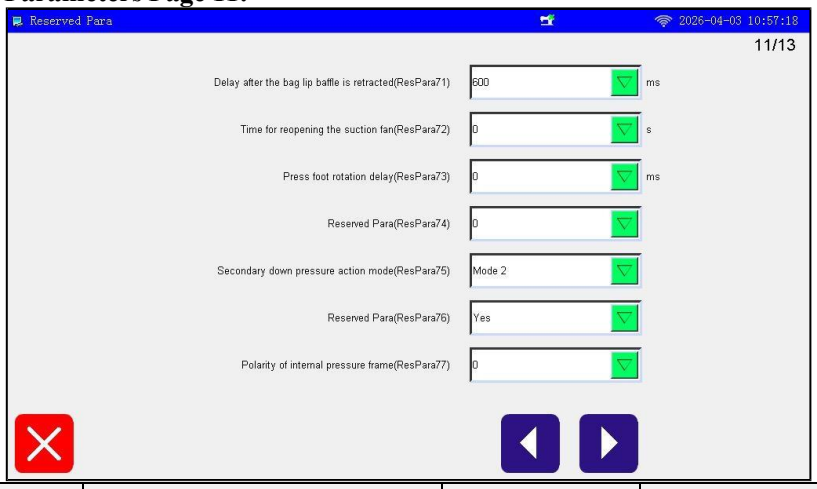
serial	parameter	value	Modify the interval
1	Y tray rise and close delay	200	Range: 0-30000
2	Y clamp tray open delay	200	Range: 0-30000
3	Y clamp tray close delay	100	Range: 0-30000
4	Tray fixed open delay	200	Range: 0-30000
5	Tray fixed close delay	200	Range: 0-30000
6	Y pallet reclaimer motor length	3851	Range: 0-25000
7	Lifting delay of external pressure frame	400	Range: 0-30000

Reserved Parameters Page 10:



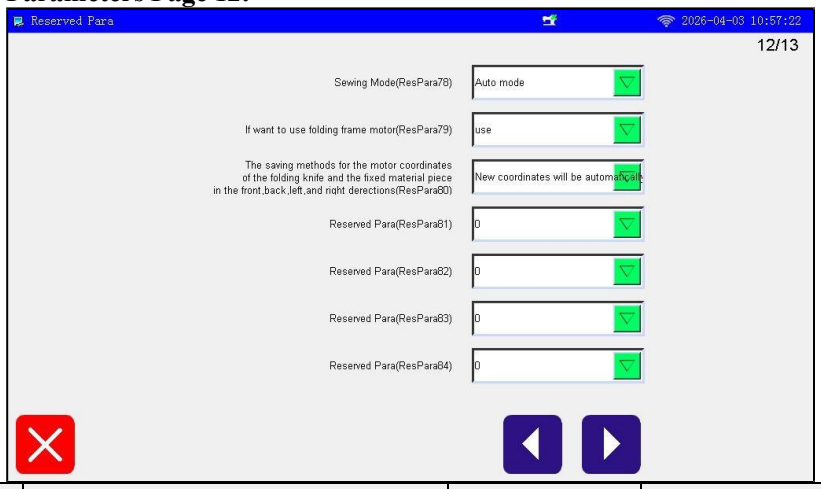
serial	parameter	value	Modify the interval
1	Inner Pressure Frame Motor Enable	do not use	Not used; use
2	Whether to automatically fold after cutting	automatic	Not automatic; automatic
3	Whether the set material of the set material after the second sewing work at the same time	simultaneously	At different times; simultaneously
4	Bag lip action mode selection	Manual 1	Invalid - Invalid Manual 1- Bag Cloth - Zipper - Bag Lip Automatic 1- Bag Cloth - Zipper - Bag Lip Manual 2-zipper Automatic 2-Zipper Manual 3-bag lip Automatic 3-bag lip Manual 4-Bag Cloth Automatic 4-Bag Cloth Zipper Manual 5-bag cloth bag lip Automatic 5-bag fabric bag lip Manual 6-zipper bag lip Automatic 6-zipper bag lip
5	The delay between the extension and the fall of the bag lip baffle	800	Range: 0-3000
6	Is the left and right folding knives closed	No	No - Left and right folding knives do not close Yes, the left and right folding knives are closed
7	Delay between lifting and retracting the lip baffle	500	Range: 0-3000

Reserved Parameters Page 11:



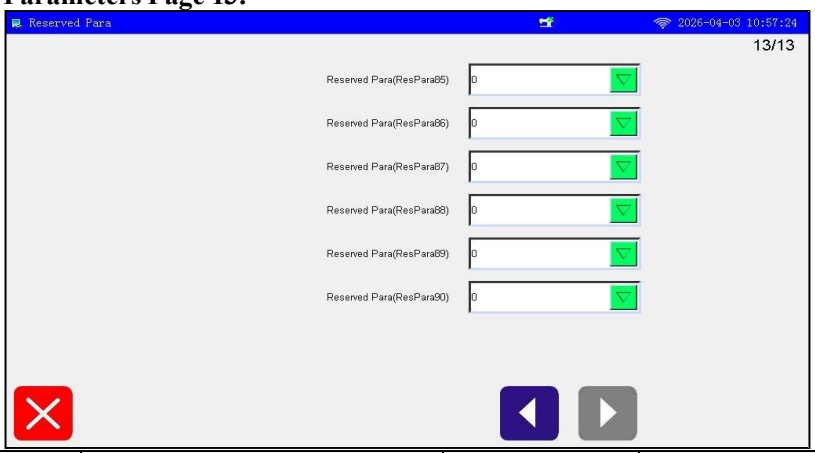
serial	parameter	value	Modify the interval
1	Delay after the bag lip baffle is retracted	600	Scope: 1-3000
2	Time for reopening the suction fan	0	Range: 0-10
3	Press foot rotation delay	0	Scope: 1-3000
4	Reserved para	0	Scope: 1-9999
5	Secondary down pressure action mode	Mode 2	Mode 1- After pulling out the fixed piece, apply secondary downward pressure, and during the secondary material retrieval, there is secondary pressure on the return and return Mode 2- After pulling out the fixed piece, press it down again, and there is no secondary pressure when picking up the material again Mode 3- Press down twice before pulling out the fixed piece, and apply secondary pressure to the back and forth during the second material retrieval Mode 4- Press down twice before pulling out the fixed piece, and there is no secondary pressure during the second material retrieval process
6	Reserved para	is	Yes; No
7	Polarity of internal pressure frame	0	0-Default lifting after machine power failure After the machine is powered off, it defaults to falling

Reserved Parameters Page 12:



serial	parameter	value	Modify the interval
1	Sewing mode	Fully Automatic Mode	Fully Automatic Mode Normal Mode Front placket mode
2	If want to use folding frame motor	use	use; do not use
3	The saving methods for the motor coordinates of the folding knife and the fixed material piece in the front.back.left.and riqht derections	automatic	Automatic - Automatically generate new coordinates Current pattern - use current pattern coordinates
4	Reserved para	0	Scope: 1-30000
5	Reserved para	0	Scope: 1-30000
6	Reserved para	0	Scope: 1-30000
7	Reserved para	0	Scope: 1-30000

Reserved Parameters Page 13:



serial	parameter	value	Modify the interval
1	reserved parameter	0	Scope: 1-30000
2	reserved parameter	0	Scope: 1-30000
3	reserved parameter	0	Scope: 1-30000
4	reserved parameter	0	Scope: 1-30000
5	reserved parameter	0	Scope: 1-30000
6	reserved parameter	0	Scope: 1-30000