

# Operating instructions

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# Operating instructions

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# Operating instructions

## Chapter 1 Introduction to Basic Images

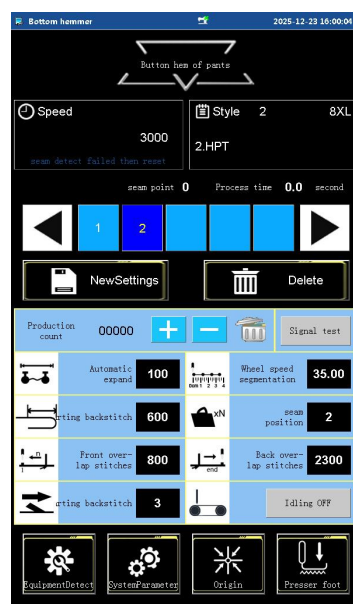
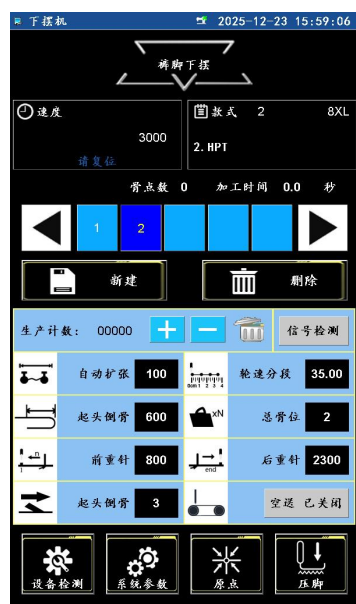
### 1.1 Basic Screen

#### 1.1.1 Turn on the power switch

1. After power on, the language selection interface will be displayed.

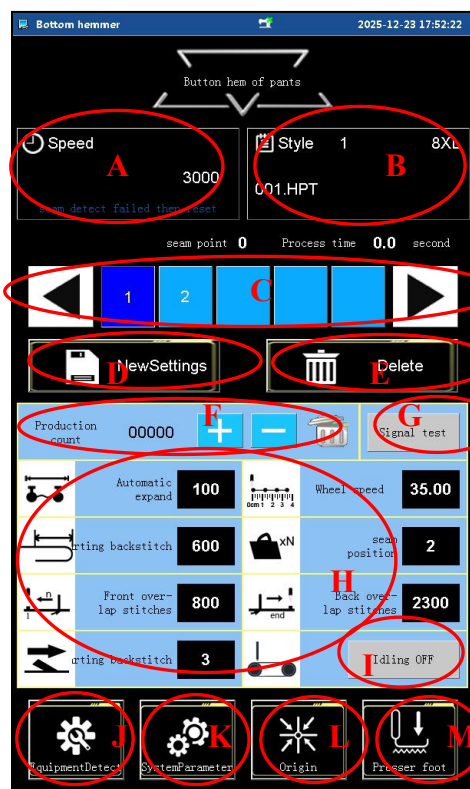
2. Click the left button to enter the English interface.

3. Click the button on the right to enter the Chinese interface.



Language interface entrances on both sides, language settings can be set through the parameter directory

#### 1.1.2 Introduction to the Main Interface



Serial	Name	Content
A	Speed regulation	Sewing speed regulator
B	Style	Display the size of the current sewing pattern
C	Style	Style selection
D	Newly build	New Style
E	Delete	Delete style
F	Production quantity counting	Production quantity counting setting
G	Signal detection	Enter the input signal detection interface
H	Parameter settings	Set sewing parameters
I	Empty delivery	Close/Open
J	Device detection	Enter the motor debugging interface
K	System parameter	Enter parameter directory
L	Origin	Perform a return to original action
M	Pressing feet	Press the foot to lift or lower it

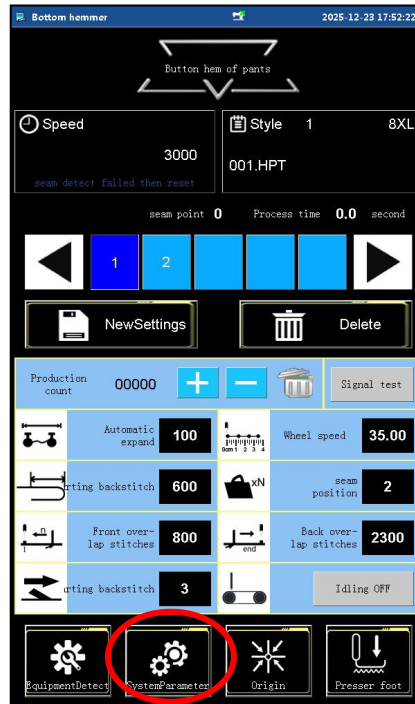
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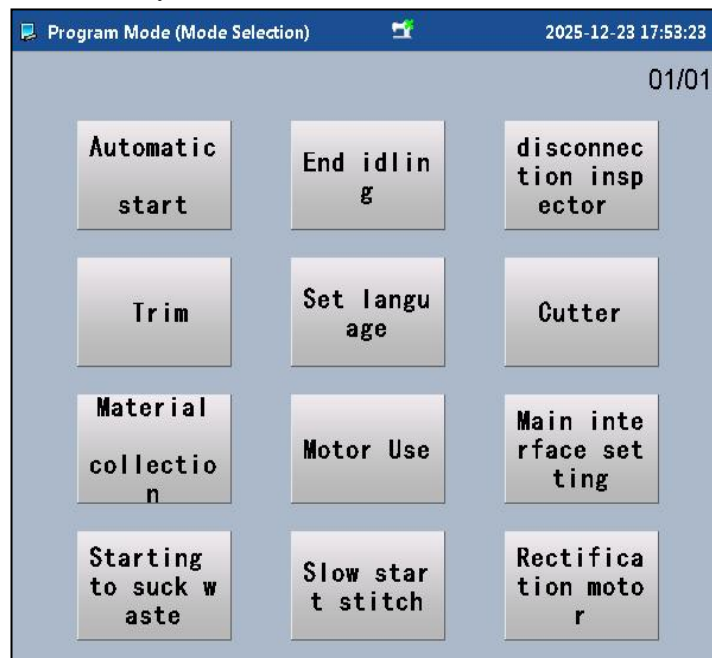
## Chapter 2 Parameter Catalog

### 2.1 Menu Catalog

Click on system parameters

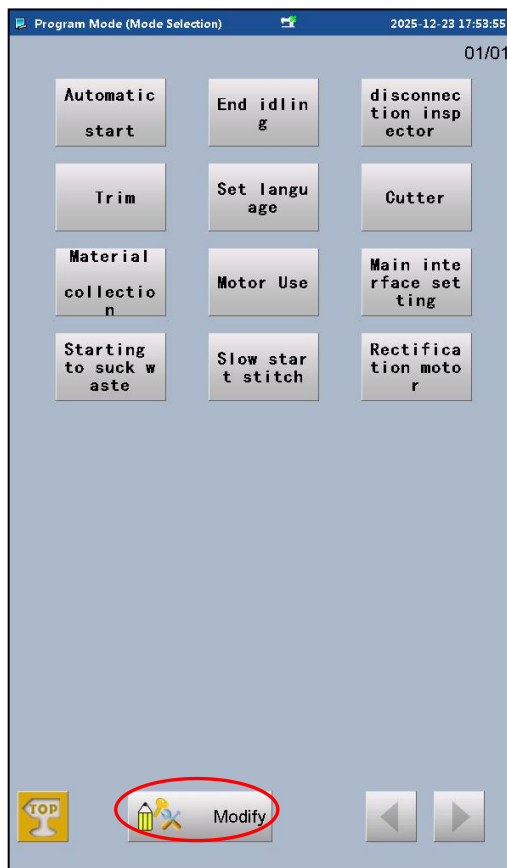


#### 2.1.1 Enter parameter directory

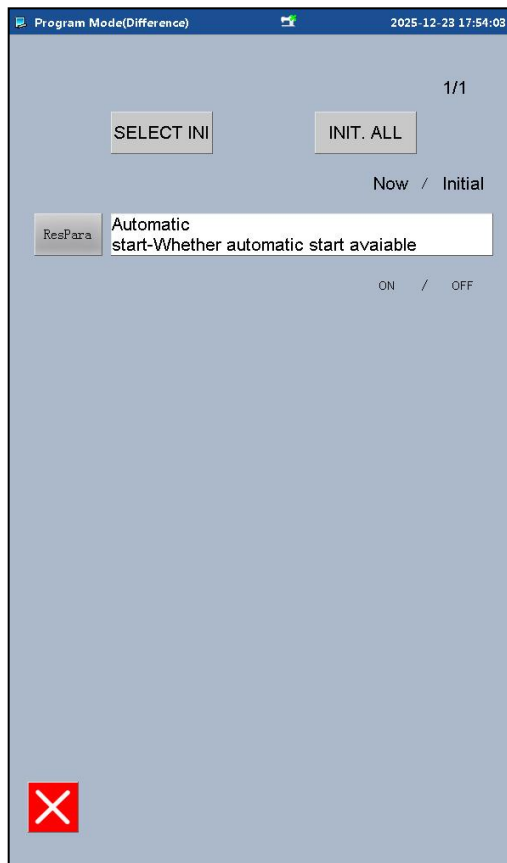


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## 2.1.2 Enter parameter comparison and restoration mode



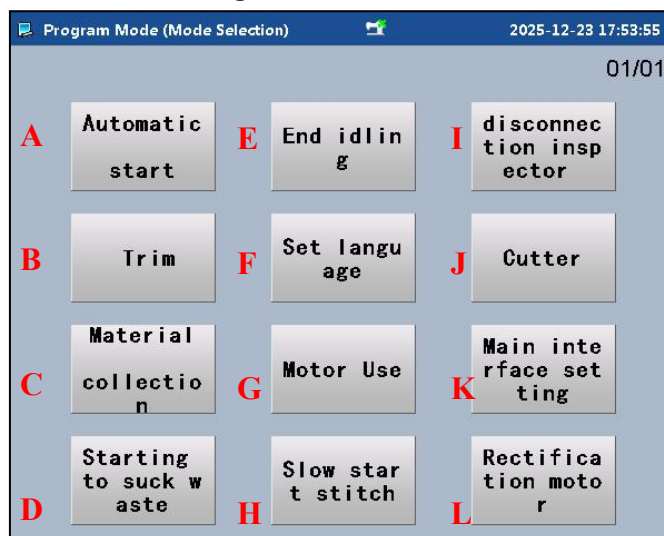
Click on 'Modify' to enter Program Mode(Difference).



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## 2.2 Parameter Settings

### 2.2.1 Introduction to Parameter Catalog



Serial	Name	Content
A	Automatic start	Whether automatic start available;How long does it take to start after sensing; Switch sensor timing;Timing of front edge curling retraction; Switch the detection correction method;Safety switch detection alarm; Number of stitches that cannot be sewn by the left and right wheels;
B	Trim	Whether thread trimming cylinder is valid;Delay from trimming open to close; Delay from trimming close to hook open;Whether hook is ok; The delay from hook on to off;the delay from hook close action; Trim test stitches;
C	Material collection	Whether material receipt is open;Material receiving interval frequency; Material receiving clamp cylinder delay;Material receiving left-right cylinder delay Material receiving front-rear cylinder delay;
D	Starting to suck waste	Initial waste suction duration;check the ineffective distance of the bone postion
E	End idling	End idling distance;Ending speed of idle;Needle stop angle for backstitch in seam; Speed of left and right wheel idling and retraction after bone turnover; Delay in rolling back when there is no bone; Slow down the sewing tail speed;speed ratio of left and right wheels;
F	Set language	Language
G	Motor Use	Reserved para;Reserved para;Reserved para;
H	Slow start stitch	Start slow needle;Slow stitch first stitch speed;Slow stitch second stitch speed; Slow stitch third stitch speed;Slow stitch four stitch speed;Slow stitch five stitch speed;Slow stitch six stitch speed;
I	Disconnection inspector	Whether disconnection 1 is valid;Whether disconnection 2 is valid;Whether Disconnection 3 is valid;Whether disconnection 4 is valid;Whether disconnection 5 is valid;Number of broken thread detection needles;
J	Cutter	Whether the cutter is used;empty cutting speed;Advance cutter position;Number of stitches to stop the cutter in advance at the end;air cutting and pressing material switch
K	Main interface setting	Display language of icon on the left of main interface;Display language of icon on the right of main interface; Show multi stock interface
L	Rectification motor	Deviation correction motor default direction

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## 2.2.2 Parameter Setting Preview

### 1) Automatic start

Automatic start

2025-12-23 17:59:14

01/01

Whether automatic start available(ResPara) ON

How long does it take to start after sensing(ResPara) 350 ms

Switch sensor timing(ResPara) 3800

Timing of front edge curling retraction(ResPara) 100

Switch the deviation correction method(ResPara) Sensor switchina

Safety switch detection alarm(ResPara) open

Number of stitches that cannot be seen by the left and right wheels(ResPara) 20 X0.1Sitch

### 2) Trim

Trim

2025-12-23 17:59:22

01/01

Whether thread trimming cylinder is valid(TR.M) on

Delay from trimming open to close(LTM) 350 ms

Delay from trimming close to hook open(TRS) 50 ms

Whether hook is ok(ResPara) off

The delay from hook on to off(ResPara) 120

The delay from hook close action(ResPara) 120

Trim test stitches(ResPara) 40

### 3) Material collection

Material Mode (N)

2025-12-23 17:59:30

01/01

Whether material receipt is open(ResPara) OFF

Material receiving interval frequency(ResPara) once

Material receiving clamp cylinder delay(ResPara) 500 ms

Material receiving left-right cylinder delay(ResPara) 500 ms

Material receiving front-rear cylinder delay(ResPara) 500 ms

### 4) Starting to suck waste

Starting to suck waste

2025-12-23 17:59:38

01/01

Initial waste suction duration(ResPara) 200 ms

Check the ineffective distance of the bone position(ResPara) 500 x0.1mm

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## 5) End idling

End idling 2025-12-23 17:59:50 01/02

End idling distance(ResPara) 1000

Ending speed of idle(ResPara) 20

Needle stop angle for backstitch in seam(ResPara) 279  °

Speed of left and right wheel idling and retraction after bone turnover(ResPara) 50

Delay in rolling back when there is no bone(ResPara) 1000

Slow down the sewing tail speed(ResPara) 0

Speed ratio of left and right wheels (ResPara) 2000

End idling 2025-12-23 17:59:57 02/02

Slow down the speed after passing the first position(ResPara) 0

The position where deceleration begins after passing the first bone(ResPara) 1500

First bone position deceleration(ResPara) 10  Needles

End idle left and right speed(ResPara) 20

Machine continuous test switch(ResPara) OFF

End expansion(ResPara) 0

## 6) Set language

Set language 2025-12-23 18:00:14 01/01

Language(LAN) English

## 7) Motor use

Motor Use 2025-12-23 18:04:58 01/01

Reserved Para(ResPara) ON

Reserved Para(ResPara) Forward

Reserved Para(ResPara) 50

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## 8) Slow start stitch

Slow start stitch 2025-12-23 18:01:37 01/01

Start slow needle(ResPara)

Slow stitch first stitch speed(ResPara)

Slow stitch second stitch speed(ResPara)

Slow stitch third stitch speed(ResPara)

Slow stitch four stitch speed(ResPara)

Slow stitch five stitch speed(ResPara)

Slow stitch six stitch speed(ResPara)

## 9) Disconnection inspector

disconnection inspector 2025-12-23 18:04:38 01/01

Whether disconnection 1 is valid(ResPara)

Whether disconnection 2 is valid(ResPara)

Whether disconnection 3 is valid(ResPara)

Whether disconnection 4 is valid(ResPara)

Whether disconnection 5 is valid(ResPara)

Number of broken thread detection needles(ResPara)

## 10) Cutter

Cutter 2025-12-23 18:04:29 01/01

Whether the cutter is used(ResPara)

Empty cutting speed(ResPara)

Advance cutter position(ResPara)

Number of stitches to stop the cutter in advance at the end(ResPara)

Air cutting and pressing material switch(ResPara)

## 11) Main interface setting

Main interface setting 2025-12-23 18:04:21 01/01

Display language of icon on the left of main interface(Para1)

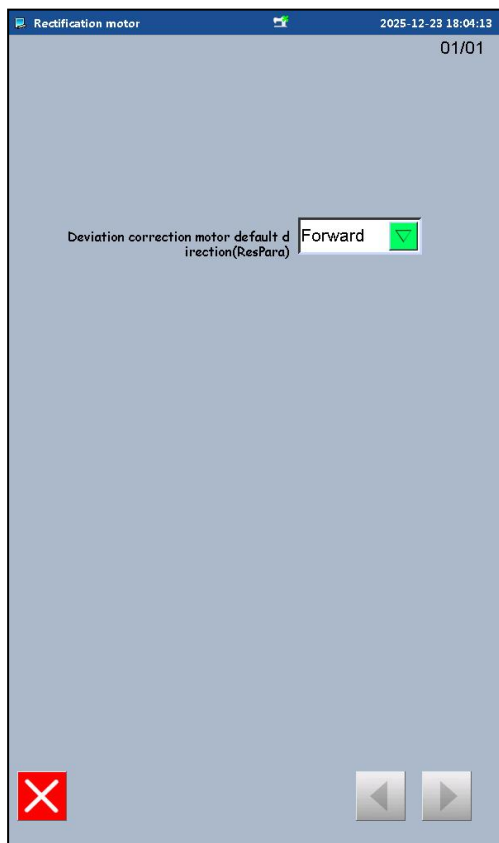
Display language of icon on the right of main interface(Para2)

Show multi stock interface(ResPara)

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## 12) Rectification motor



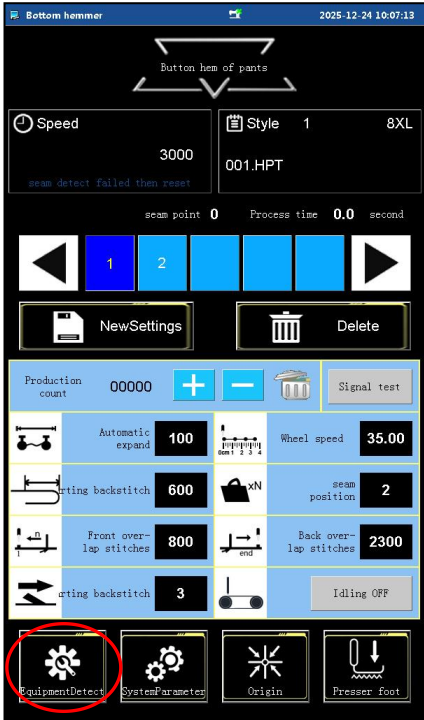
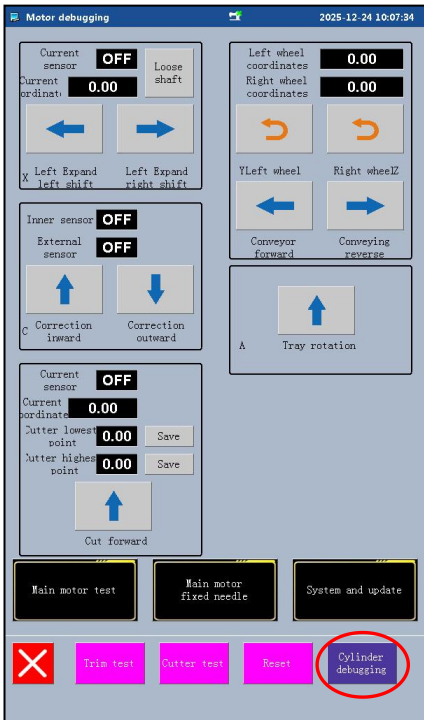
# Operating instructions

## Chapter 3 Function Introduction

### 3.1 Equipment testing

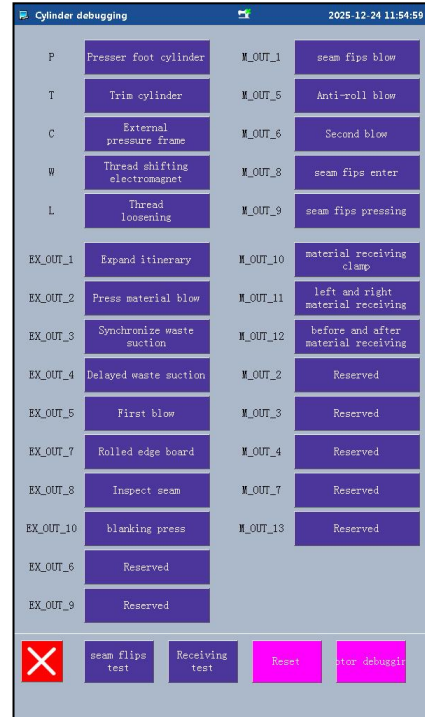
#### 3.1.1 Motor Debugging&Cylinder Debugging

Operating instructions:

Step	Interface
1、 Click the "Equipment Detect" button on the main interface.	 <p>The screenshot shows the 'Bottom hemmer' main interface. At the top, it displays 'Bottom hemmer' and the date/time '2025-12-24 10:07:13'. Below this is a diagram of a 'Button hem of pants'. The interface includes several control panels: 'Speed' (3000), 'Style' (1, 8XL), '001.HPT', 'seam point 0', and 'Process time 0.0 second'. There are navigation buttons (left and right arrows) and a 'NewSettings' button. A 'Production count' section shows '00000' with '+' and '-' buttons and a 'Signal test' button. Below this are various stitch and speed settings: 'Automatic expand 100', 'Wheel speed 35.00', 'Starting backstitch 600', 'seam position 2', 'Front over-lap stitches 800', 'Back over-lap stitches 2300', and 'Starting backstitch 3'. At the bottom, there are four buttons: 'Equipment Detect' (circled in red), 'SystemParameter', 'Origin', and 'Presser foot'.</p>
2、 Enter the motor debugging interface, Click on “Cylinder debugging” to enter the cylinder debugging interface.	 <p>The screenshot shows the 'Motor debugging' interface. At the top, it displays 'Motor debugging' and the date/time '2025-12-24 10:07:34'. The interface is divided into several sections: 'Current sensor OFF', 'Loose shaft', 'Current coordinat 0.00', 'Left Expand left shift', 'Left Expand right shift', 'Inner sensor OFF', 'External sensor OFF', 'Correction inward', 'Correction outward', 'Conveyor forward', 'Conveying reverse', 'Conveyer forward', 'Conveyer reverse', 'Tray rotation', 'Current sensor OFF', 'Current coordinat 0.00', 'Jutter lowest point 0.00', 'Jutter highest point 0.00', 'Save', 'Save', 'Cut forward', 'Main motor test', 'Main motor fixed needle', 'System and update', 'Trial test', 'Cutter test', 'Reset', and 'Cylinder debugging' (circled in red).</p>

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3、 Enter the cylinder debugging interface.



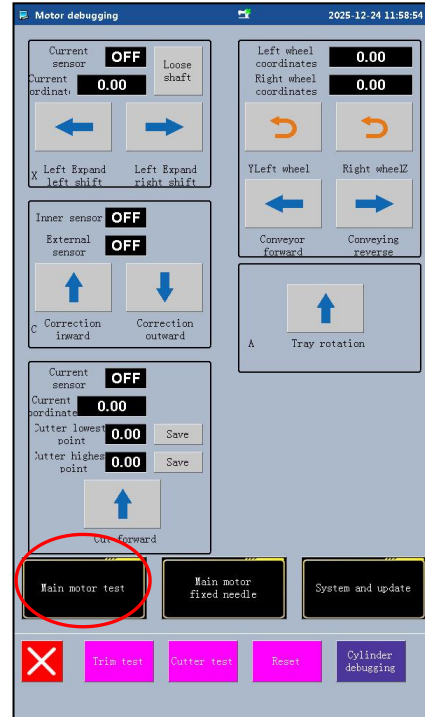
## 3.1.2 Main motor test

Operating instructions:

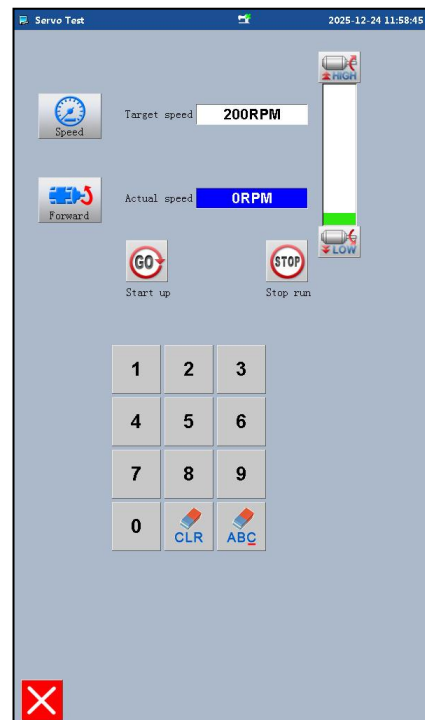
Step	Interface
<p>1、 Click on the "Equipment Detect" button on the main interface</p>	

# Operating instructions

2、 Enter the motor debugging interface and click on "Main Motor Test".



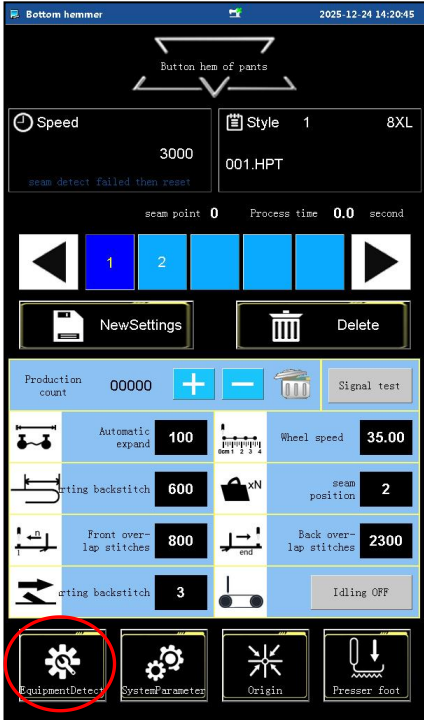
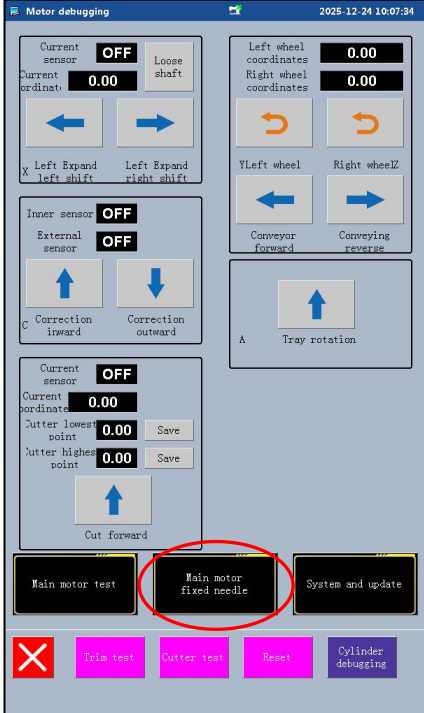
3、 Enter the "Servo Test" interface.



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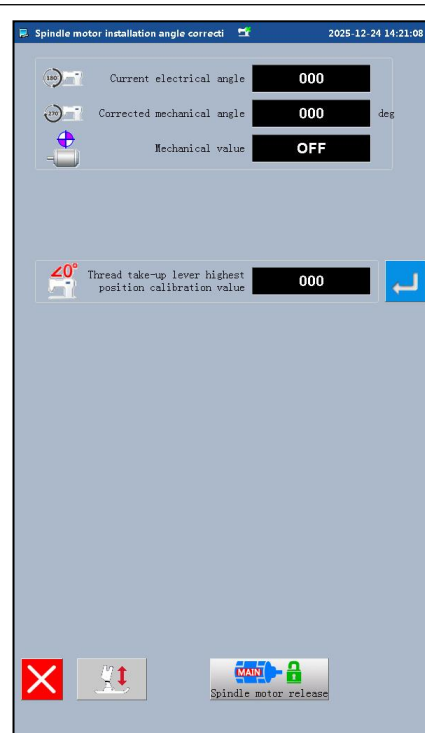
## 3.1.3 Main motor needle setting

Operating instructions:

Step	Interface
<p>1. Click the "Equipment Detect" button on the main interface.</p>	 <p>The screenshot shows the 'Bottom hemmer' main interface. At the top, it displays 'Bottom hemmer' and the date '2025-12-24 14:20:45'. Below this is a diagram of a button hem on pants. The interface includes several control panels: 'Speed' set to 3000, 'Style' set to 1 (8XL) with '001.HPT' below it, 'seam point' set to 0, and 'Process time' set to 0.0 second. There are navigation buttons (back, 1, 2, forward) and 'NewSettings' and 'Delete' buttons. A 'Production count' of 00000 is shown with '+' and '-' buttons and a 'Signal test' button. Below are various stitch type settings: 'Automatic expand' (100), 'Wheel speed' (35.00), 'Starting backstitch' (600), 'seam position' (2), 'Front over-lap stitches' (800), 'Back over-lap stitches' (2300), and 'Starting backstitch' (3). At the bottom, there are four buttons: 'Equipment Detect' (circled in red), 'SystemParameters', 'Origin', and 'Presser foot'.</p>
<p>2. Enter the motor debugging interface and click on "Main Motor Fixed needle".</p>	 <p>The screenshot shows the 'Motor debugging' interface with the date '2025-12-24 10:07:34'. It contains several control panels: 'Current sensor' (OFF), 'Loose shaft' (0.00), 'Left wheel coordinates' (0.00), 'Right wheel coordinates' (0.00), 'Left Expand' (Left shift, right shift), 'Inner sensor' (OFF), 'External sensor' (OFF), 'Conveyor forward', 'Conveying reverse', 'Tray rotation' (A), 'Current sensor' (OFF), 'Current coordinate' (0.00), 'Dutter lowest point' (0.00), 'Dutter highest point' (0.00), 'Cut forward', 'Main motor test', 'Main motor Fixed needle' (circled in red), 'System and update', 'Trim test', 'Cutter test', 'Reset', and 'Cylinder debugging'.</p>

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3. Enter the "Servo motor Angle Correct" interface.

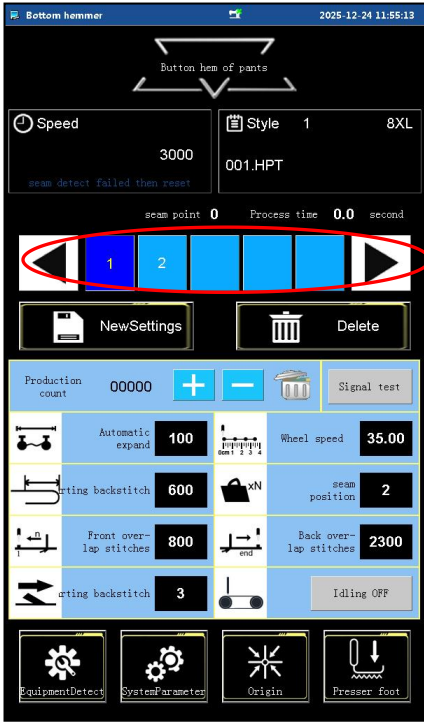
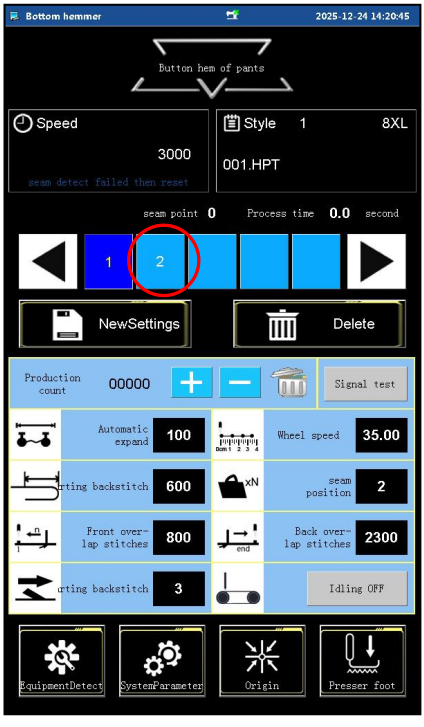


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## 3.2 Style selection

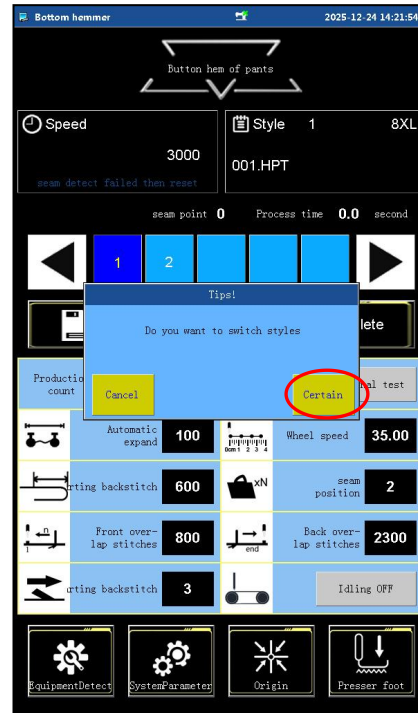
### 3.2.1 Style selection and material feeding and unloading settings

Operating instructions:

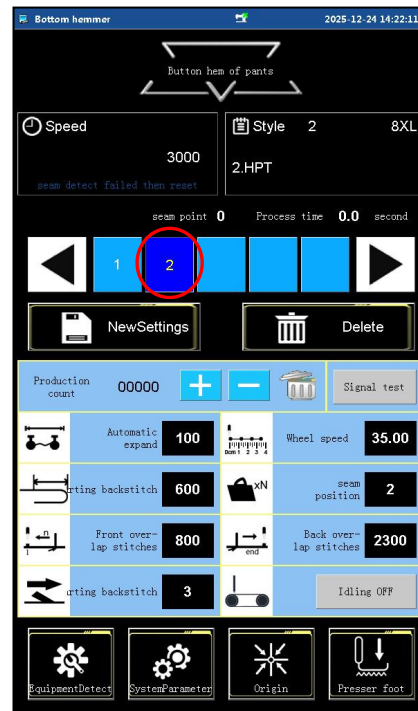
Step	Interface
1. Click on "Style number" on the main interface.	 <p>The screenshot shows the 'Bottom hemmer' control interface. At the top, it displays 'Bottom hemmer' and the date/time '2025-12-24 11:55:13'. Below this is a diagram of a button hem. The 'Speed' is set to 3000, and 'Style' is set to '1' (8XL) with '001.HPT' below it. A note says 'seam detect failed then reset'. 'seam point' is 0 and 'Process time' is 0.0 second. A row of style selection buttons is highlighted with a red oval; the first button is '1' and the second is '2'. Below are 'NewSettings' and 'Delete' buttons. The 'Production count' is 00000. Settings include 'Automatic expand' (100), 'Wheel speed' (35.00), 'Starting backstitch' (600), 'seam position' (2), 'Front over-lap stitches' (800), 'Back over-lap stitches' (2300), and 'Starting backstitch' (3). 'Idling' is OFF. Bottom icons are 'EquipmentDetect', 'SystemParameter', 'Origin', and 'Presser foot'.</p>
2. Click on the style2.	 <p>This screenshot is identical to the one above, but the red oval is replaced by a red circle around the '2' style selection button. The 'Style' field still shows '1' and '001.HPT'.</p>

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3. Do you want to switch styles , click certain.



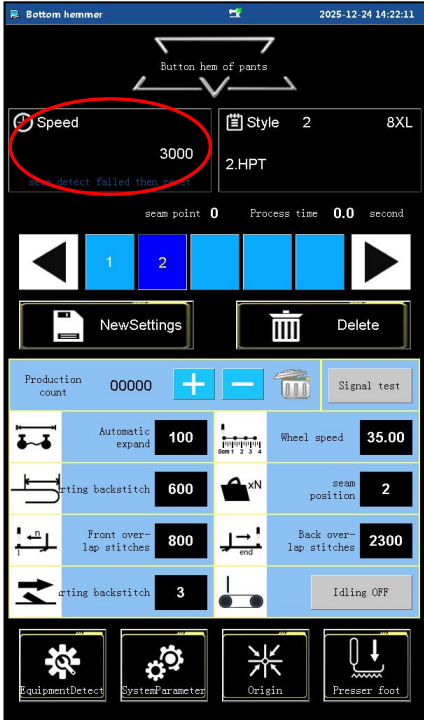
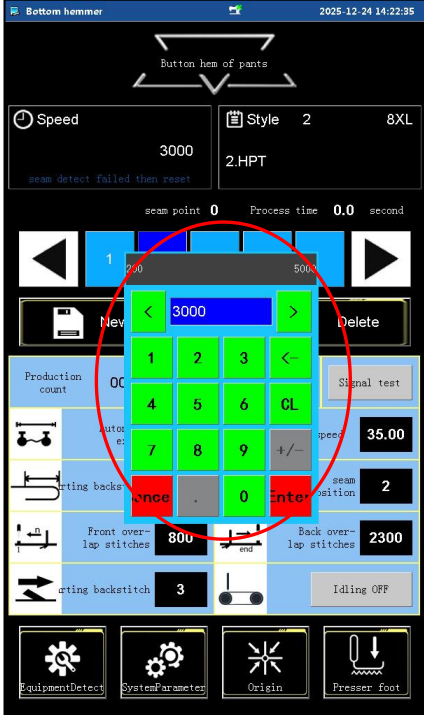
4. It has been switched to style2.



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## 3.2.2 Sewing speed setting

Operating instructions:

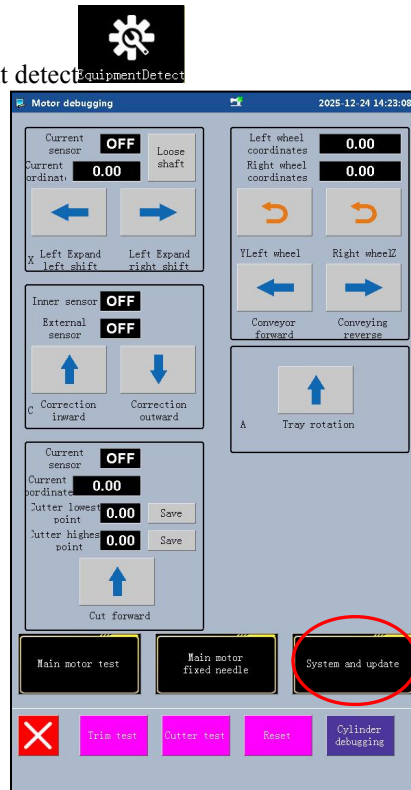
Step	Interface
1. Click on 'Speed' on the main interface.	 <p>The screenshot shows the main interface of a sewing machine. At the top, it displays 'Bottom hemmer' and the date '2025-12-24 14:22:11'. Below this, there is a diagram of a button hem on pants. The 'Speed' parameter is highlighted with a red circle and shows a value of 3000. Other parameters include 'Style 2', '8XL', and '2.HPT'. The interface also shows 'seam point 0' and 'Process time 0.0 second'. There are navigation buttons (left and right arrows) and a 'NewSettings' button. Below these are controls for 'Production count' (00000), 'Automatic expand' (100), 'Wheel speed' (35.00), 'Sewing backstitch' (600), 'Front over-lap stitches' (800), 'Back over-lap stitches' (2300), and 'Sewing backstitch' (3). At the bottom, there are icons for 'EquipmentDetect', 'SystemParameters', 'Origin', and 'Presser foot'.</p>
2. Set sewing speed.	 <p>The screenshot shows the same interface as the previous one, but with a numeric keypad overlay. The keypad is used to set the sewing speed. The value '3000' is entered and highlighted in blue. The keypad has buttons for digits 0-9, a decimal point, and an 'Enter' key. The 'Speed' parameter in the background is now set to 3000. The interface also shows 'seam detect failed then reset' and 'seam point 0'.</p>

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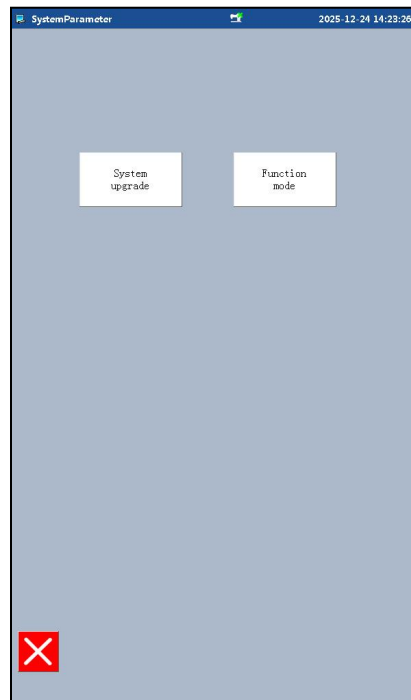
## Chapter 4 Functional `Mode

### 4.1 Introduction to Function Modes

Main interface, open Equipment detect



Click the "System and Upgrade" button to enter the system parameter page

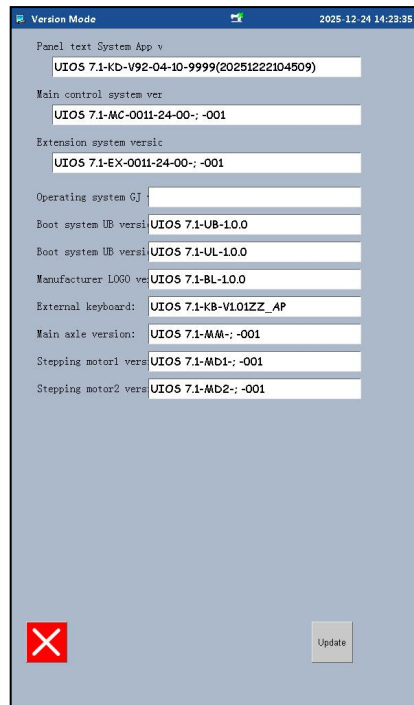


Introduction: You can see that the system parameters are divided into two parts: "System Upgrade" and "Function Mode"

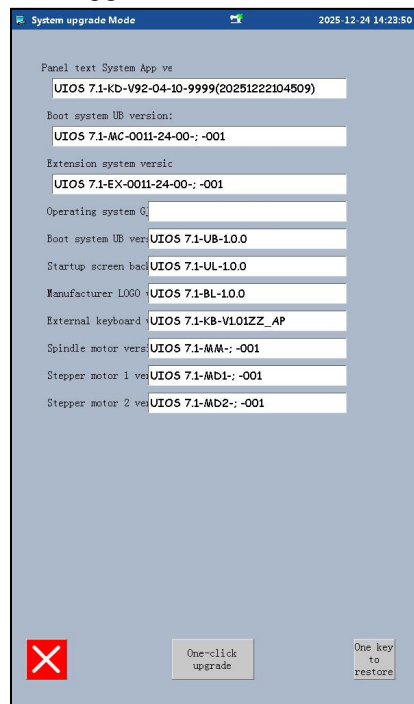
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## 4.2 Parameter Import and Export

Click on "System Upgrade" on the system parameter interface



Insert the USB flash drive and click upgrade



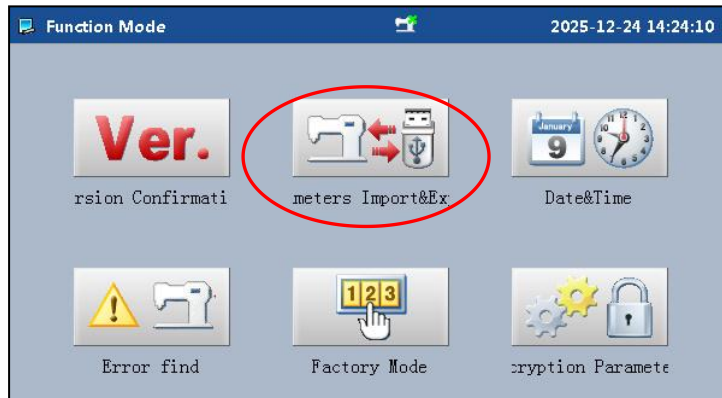
Attention: USB upgrade file upgrade method

- 1) Download the file to the USB drive first;
- 2) Create a new folder on the USB drive and rename it as SY;
- 3) Drag and drop the file to the SY folder;
- 4) Click the "Upgrade" button again in the firmware version mode shown in the picture;

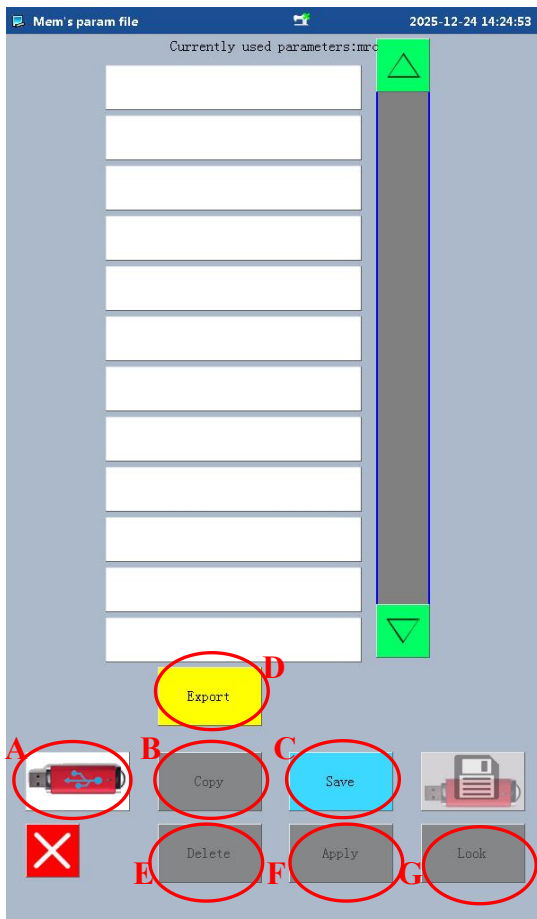
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## 4.3 Parameter Import and Export

Click on "Function Mode" in the system parameter interface, and then click on "meters Import/Export".



Enter the "Mem's Parameter File" interface



Serial	Name	Content
A	USB file	Open the USB file interface
B	Copy	Copy file
C	Save	Save the file
D	Export	Export file
E	Delete	Delete file
F	Application	Application Files
G	View	File preview