

Operating instructions

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Operating instructions

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Operating instructions

Chapter 1 Introduction to Basic Images

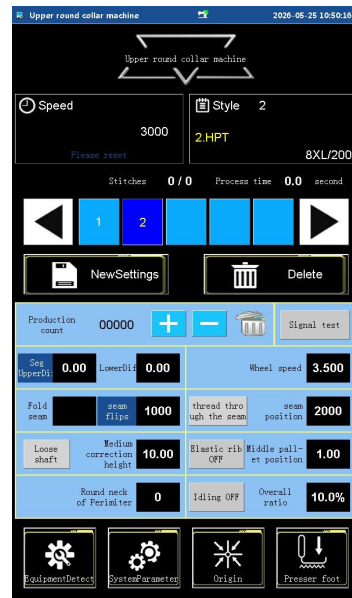
1.1 Basic Screen

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.

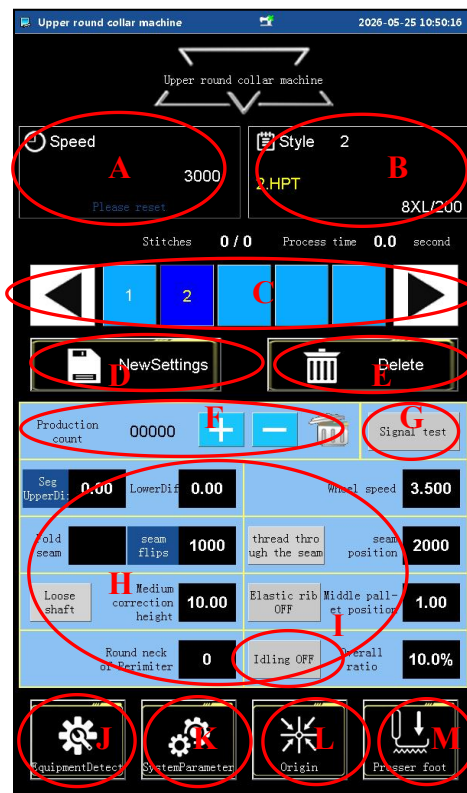


3. Click the button on the right to enter the Chinese interface.



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

1.1.2 Introduction to the Main Interface



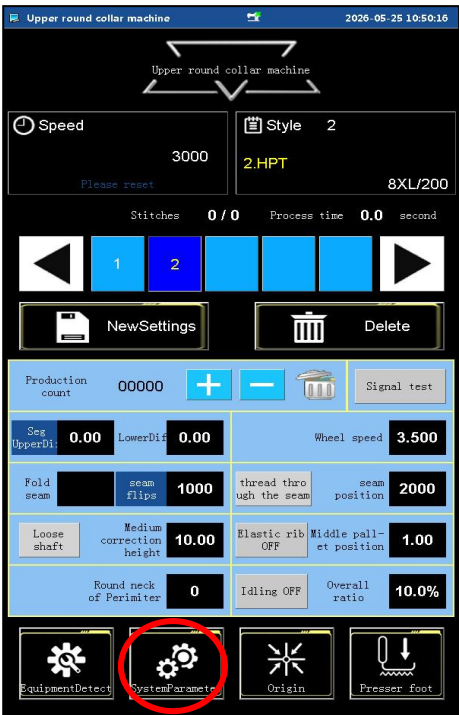
Serial	Name	Content
A	Speed regulation	Sewing speed regulator
B	Style and size	Display the formula and size of the current sewing pattern
C	Style	Style selection
D	Newly build	New Style
E	Delete	Delete style
F	Production quantity counting	Production quantity counting setting
G	Signal detection	Enter 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

Operating instructions

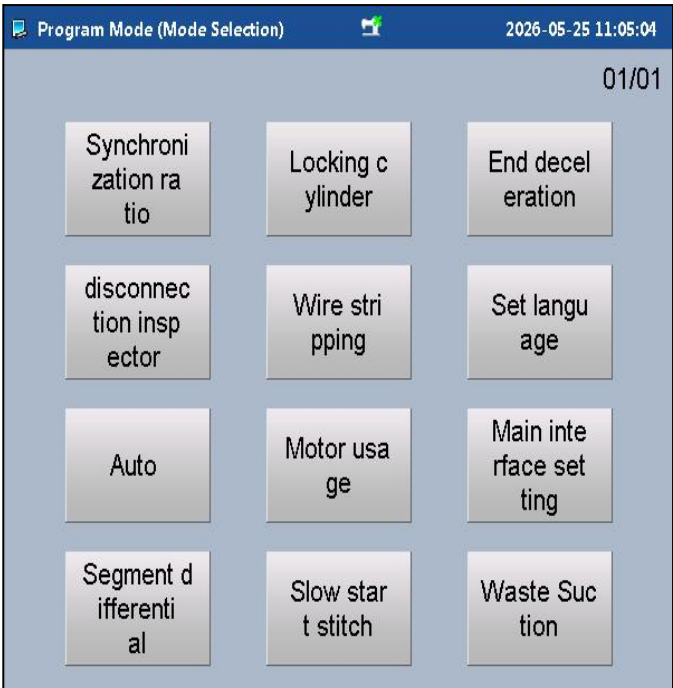
Chapter 2 Parameter Catalog

2.1 Menu Catalog

Click on system parameters

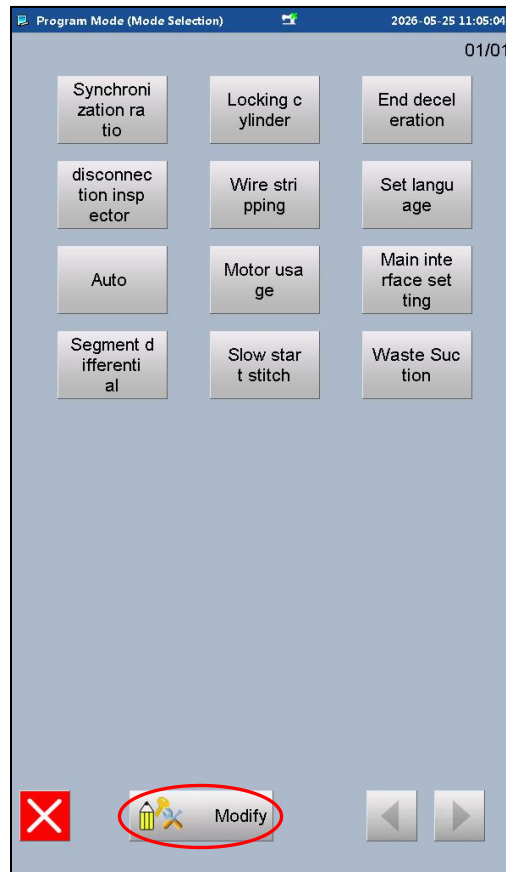


2.1.1 Enter parameter directory



Operating instructions

2.1.2 Enter parameter comparison and restoration mode



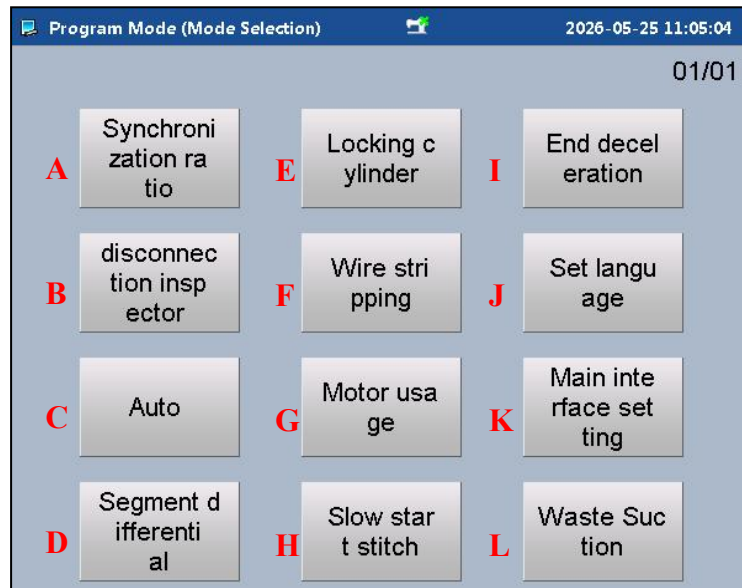
Click on 'Modify' to enter Program Mode(Difference).



Operating instructions

2.2 Parameter Settings

2.2.1 Introduction to Parameter Catalog



Seria	Name	Content
A	Synchronization ratio	Left wheel synchronization ratio Left wheel front and rear cylinder switch Switch sensor timing Front and rear sylinder switch of brush Invert bone stitching test switch Middle wheel synchronization ratio
B	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;
C	Auto	Whether the cutter is used Delay of left and right rotating cylinder Feeding right-forward cylinder delay Install the rght-expansion telescopic cylinder Reserved Para
D	Segment differential	Upper differential segmented deceleration speed Number of segmented deceleration needles for upper differential Lower differential segmented deceleration speed Number of differential segmented deceleration soeed
E	Locking cylinder	Right correction switching timing Middle pallet retracted position Middle correction lifting timing Isolation board retreat position Guide lifting timing Heavy line extending timing Segment stretching retract timing Stitch segment deceleration speed Stitch segment deceleration stitches

Operating instructions

Seria	Name	Content
F	Wire stripping	Pull function switch The duration of the wire pulling cylinder from opening to closing Duration from the the thread shifting cylinder closing to subsequent action Seam bone postion lifting and lowing duration Duration of seam bone plectrum Bone blowing time Seam bone sewing stop switch
G	Motor usage	Right wheel size type Moving speed of middle support motor
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 Reserved Para
I	End deceleration	End spindle deceleration speed Delay the number of pins when cutting the line by pressing the foot Delay the number of stitches when cutting the line Number of pins retated by the wheel during tangent cutting Wheel rotation speed during tangent cutting End tangent spindle speed
J	Set language	Language
K	Main interface setting	Display language of icon on the left of main interface The icon on the right side of the startup interface displays the language Feed ratio on/off Reserved Para
L	Waste suction	Start stitch thread trimming&waste suction stitch count Pallet lifting cylinder switch Upper feed dog lift display switch V-neck start switch Stitches for V-neck start

Operating instructions

2.2.2 Parameter Setting Preview

1) Synchronization ratio

Synchronization ratio 2026-05-27 15:55:32 01/01

Left wheel synchronnization ratio(ResPara) 1000 ✓

Left wheel front and rear cylinder switch(ResPara) ON ✓

Switch sensor timing(ResPara) OFF ✓

Front and rear sylinder switch of brush(ResPara) ON ✓

Invert bone stitching test switch(ResPara) OFF ✓

Middle wheel synchronization ratio(ResPara) 1000 ✓

✗ ⏪ ⏩

2) Disconnection inspector

disconnection inspector 2026-05-27 15:55:39 01/02

	Detect switch	Detect stitch count	
Thread break 1 d	OFF ✓	20 ✓	stitch
Thread break 2 d	OFF ✓	20 ✓	stitch
Thread break 3 d	OFF ✓	20 ✓	stitch
Thread break 4 d	OFF ✓	20 ✓	stitch
Thread break 5 d	OFF ✓	20 ✓	stitch

✗ ⏪ ⏩

3) Auto

Auto 2026-05-27 15:55:43 01/01

Whether the cutter is used(ResPara) Not used ✓

Delay of left and right rotating cylinder(ResPara) 400 ✓ ms

Feeding right-forward cylinder delay(ResPara) 300 ✓ ms

Install the right-expansion telescopic cylinder(ResPara) Not install ✓

Reserved Para(ResPara) 0 ✓

✗ ⏪ ⏩

4) Segment differential

Segment differential 2026-05-27 15:55:47 01/01

Upper differential segmented deceleration speed(ResPara) 200 ✓

Number of segmented deceleration needles for upper differential(ResPara) 0 ✓

Lower differential segmented deceleration speed(ResPara) 0 ✓

Number of differential segmented deceleration speed(ResPara) 0 ✓

✗ ⏪ ⏩

Operating instructions

5) Locking cylinder

Locking cylinder 2026-05-27 15:55:51 01/02

Right correction switching timing(ResPara)	4500	✓
Middle pallet retracted position(ResPara)	800	✓
Middle correction lifting timing(ResPara)	700	✓
Isolation board retreat position(ResPara)	520	✓
Guide lifting timing(ResPara)	300	✓
Heavy line extending timing(ResPara)	200	✓
Segment stretching retract timing(ResPara)	1800	✓
Stitch segment deceleration speed(ResPara)	0	✓

✗ ⏪ ⏩

6) Wire stripping

Wire stripping 2026-05-27 15:55:55 01/01

Pull function switch(ResPara)	OFF	✓
The duration of the wire pulling cylinder from opening to closing(ResPara)	500	✓ ms
Duration from the thread shifting cylinder closing to subsequent action(ResPara)	500	✓ ms
Seam bone position lifting and lowering duration(ResPara)	500	✓ ms
Duration of seam bone plectrum(ResPara)	300	✓ ms
Bone blowing time(ResPara)	800	✓ ms
Seam bone sewing stop switch(ResPara)	OFF	✓

✗ ⏪ ⏩

7) Motor usage

Motor usage 2026-05-27 15:55:59 01/01

Right wheel size type(ResPara)	Small Wheel	✓
Moving speed of middle support motor(ResPara)	9	✓

✗ ⏪ ⏩

8) Slow start stitch

Slow start stitch 2026-05-27 15:56:02 01/01

Start slow needle(ResPara)	OFF	✓
Slow stitch first stitch speed(ResPara)	200	✓
Slow stitch second stitch speed(ResPara)	400	✓
Slow stitch third stitch speed(ResPara)	600	✓
Slow stitch four stitch speed(ResPara)	800	✓
Slow stitch five stitch speed(ResPara)	1000	✓
Slow stitch six stitch speed(ResPara)	1200	✓
Reserved Para(ResPara)	0	✓

✗ ⏪ ⏩

Operating instructions

9) End deceleration

End deceleration 2026-05-27 15:56:08 01/01

End spindle deceleration speed(ResPara) 0

Delay the number of pins when cutting the line by pressing the foot(ResPara) 150 pin

Delay the number of stitches when cutting the line(ResPara) 50 pin

Number of pins rotated by the wheel during tangent cutting(ResPara) 20 pin

Wheel rotation speed during tangent cutting(ResPara) 4000

End tangent spindle speed(ResPara) 6000

✖ ⏪ ⏩

10) Set language

Set language 2026-05-27 15:56:12 01/01

Language(LAN) English

✖ ⏪ ⏩

11) Main interface setting

Main interface setting 2026-05-27 15:56:15 01/01

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

The icon on the right side of the startup interface displays the language(Para2) Chinese

Feed ratio on/off(Para3) OFF

Reserved Para(ResPara) OFF

✖ ⏪ ⏩

12) Waste suction

Waste Suction 2026-05-27 15:56:20 01/01

Start stitch, thread trimming & waste suction stitch count(ResPara) 30 stitch

Pallet lifting cylinder switch(ResPara) OFF

Upper feed dog lift display switch(ResPara) OFF

V-neck start switch(ResPara) OFF

Stitches for V-neck start(ResPara) 30 stitch

✖ ⏪ ⏩

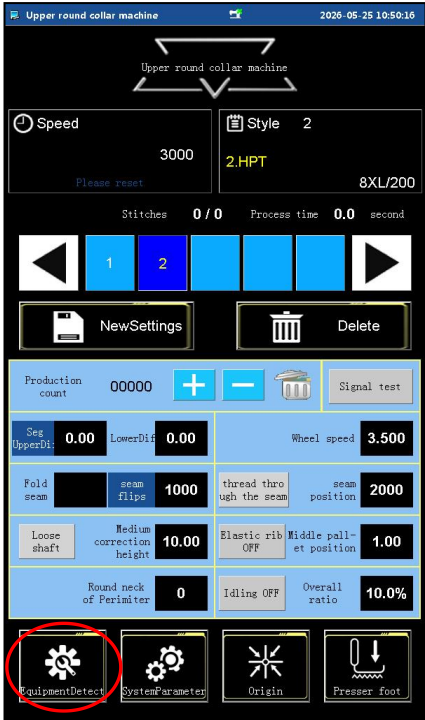
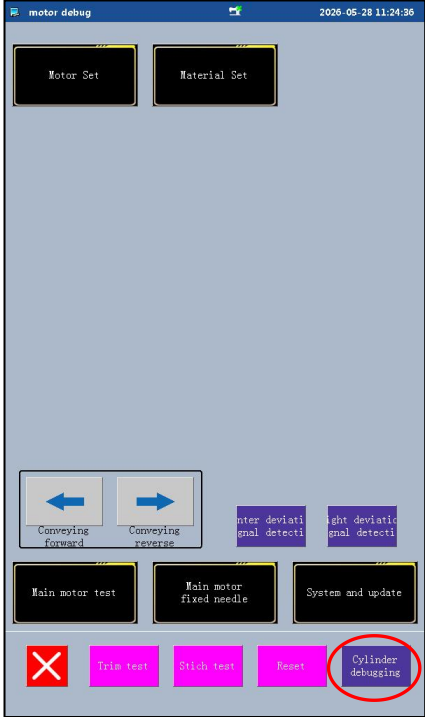
Operating instructions

Chapter 3 Function Introduction

3.1 Equipment testing

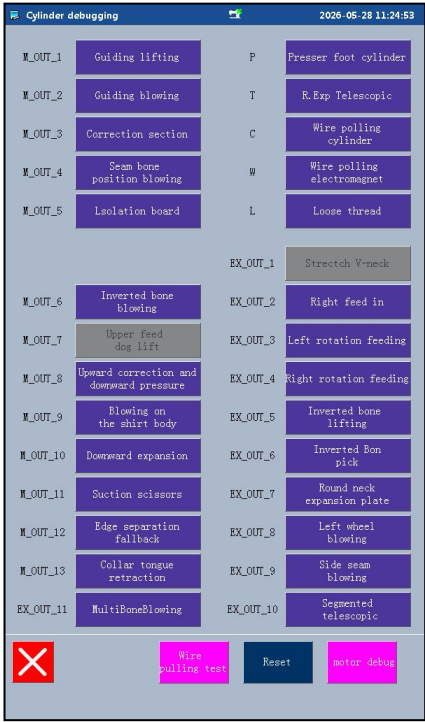
3.1.1 Motor Debugging&Cylinder Debugging

Operating instructions:

Step	Interface
1、Click the "Equipment Detect" button on the main interface.	
2、Enter the motor debugging interface, Click on “Cylinder debugging” to enter the cylinder debugging interface.	

Operating instructions

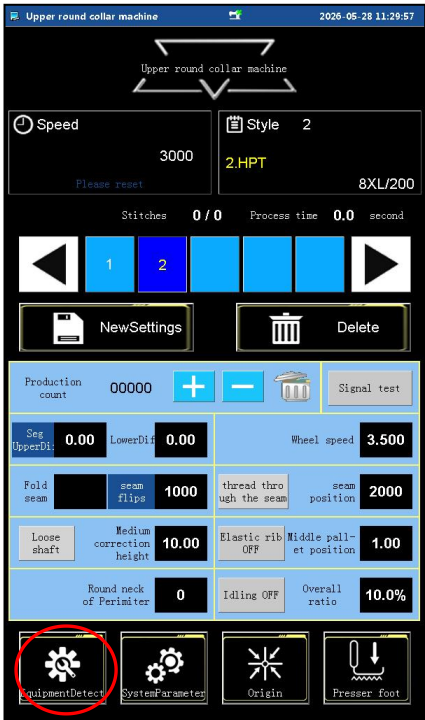
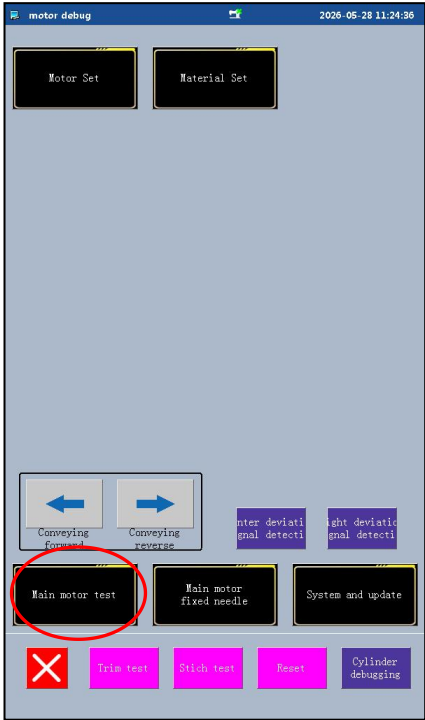
3、Enter the cylinder debugging interface.



Operating instructions

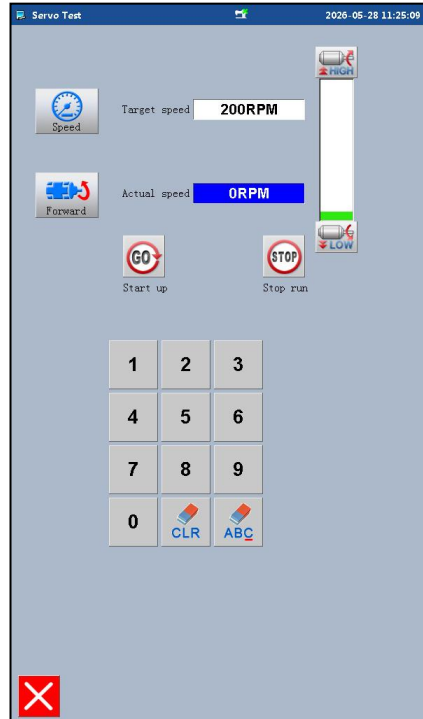
3.1.2 Main motor test

Operating instructions:

Step	Interface
1、Click on the "Equipment Detect" button on the main interface	
2、Enter the motor debugging interface and click on "Main Motor Test".	

Operating instructions

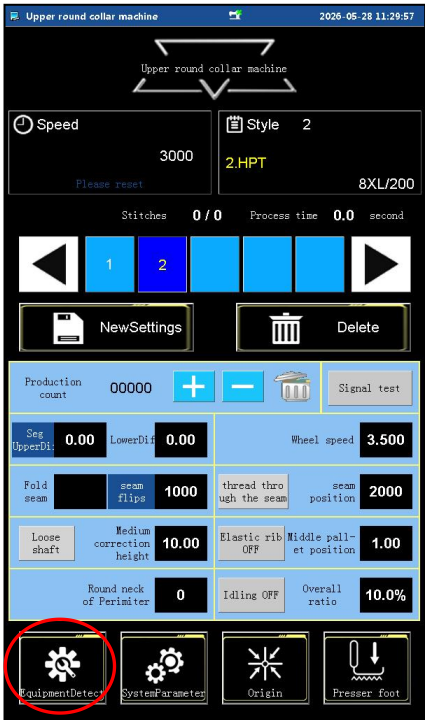
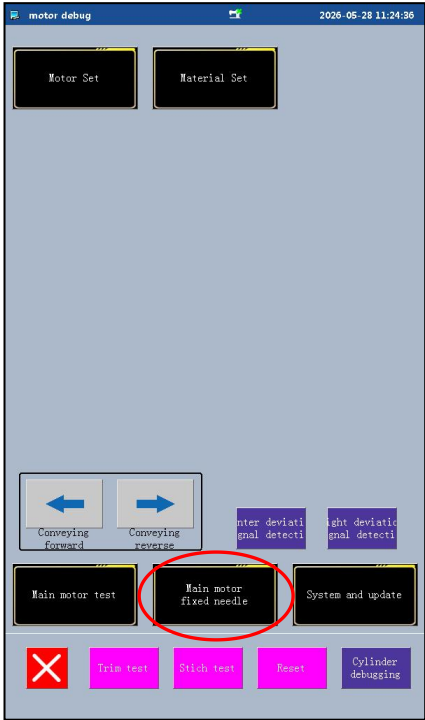
3、Enter the "Servo Test" interface.



Operating instructions

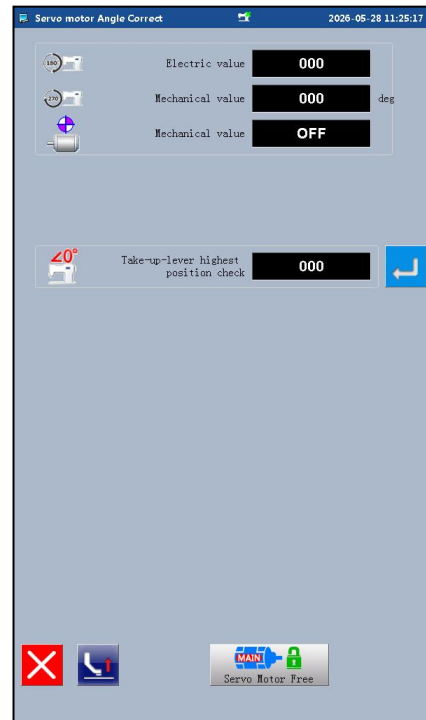
3.1.3 Main motor needle setting

Operating instructions:

Step	Interface
1. Click the "Equipment Detect"button on the main interface.	
2. Enter the motor debugging interface and click on "Main Motor Fixed needle".	

Operating instructions

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



Operating instructions

3.2 Code selection

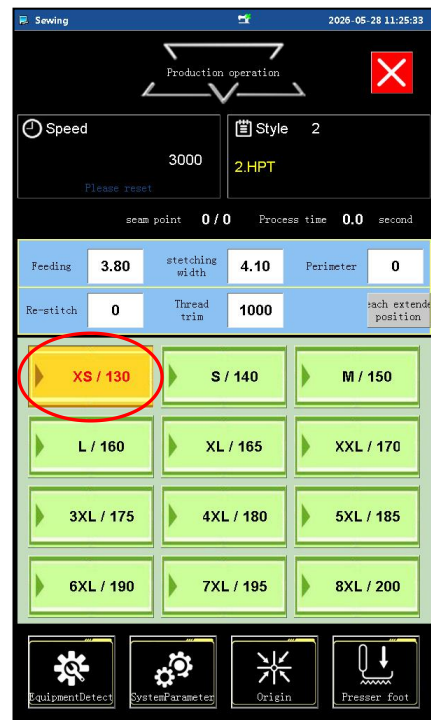
3.2.1 Code selection and material feeding and unloading settings

Operating instructions:

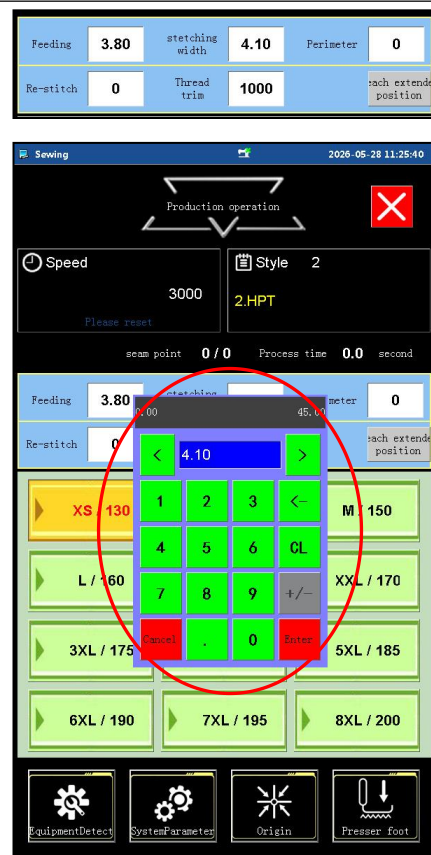
Step	Interface
1. Click on "Style" on the main interface.	
2. Enter the sewing interface.	

Operating instructions

3. Select the number of codes.



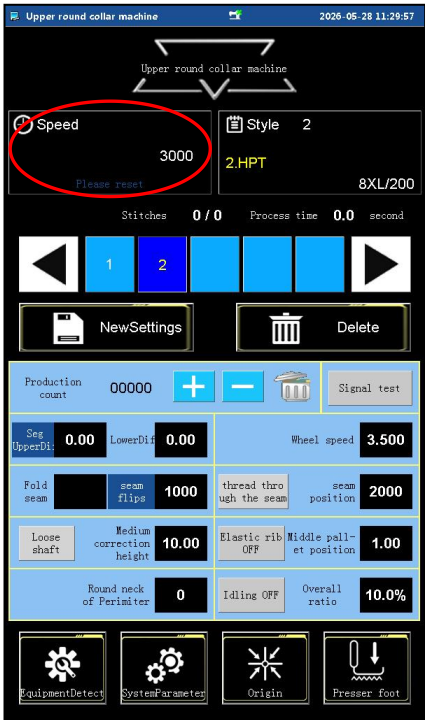
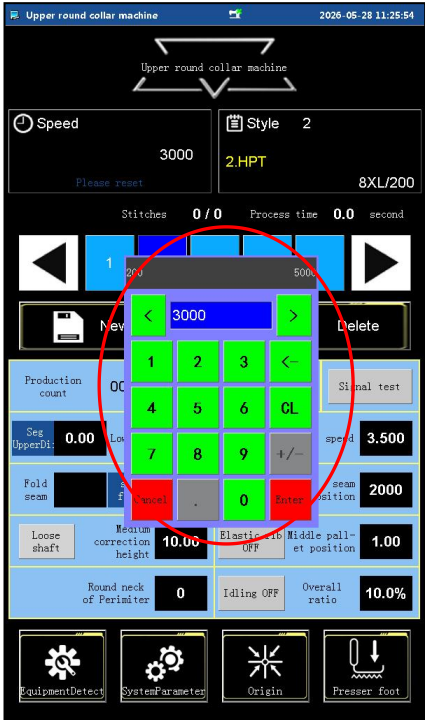
4. Press "Feeding" , "stretching width", "automatic perim" or "tangent needle" to set the value.



Operating instructions

3.2.2 Sewing speed setting

Operating instructions:

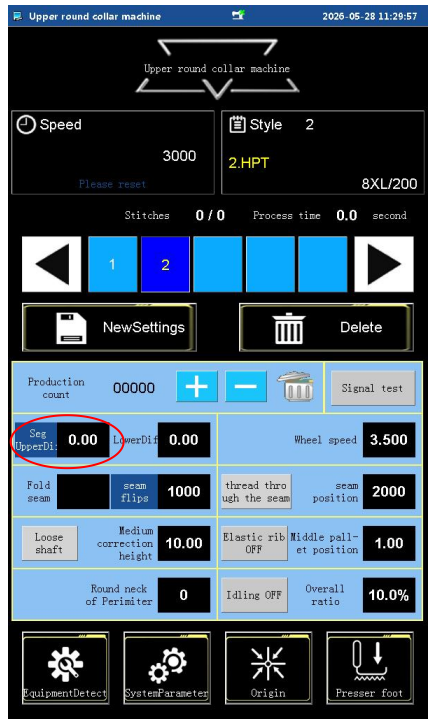
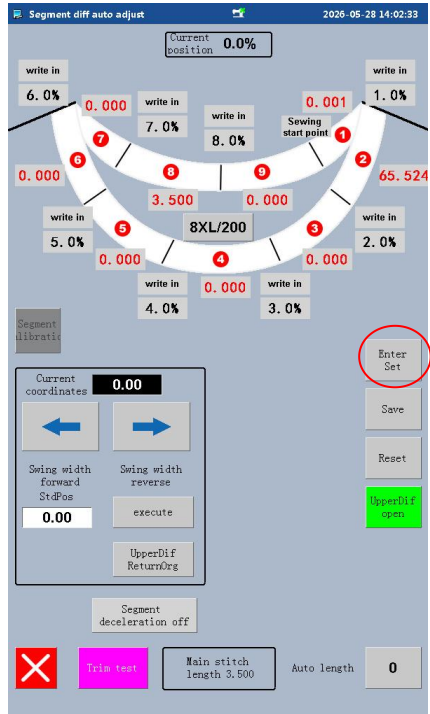
Step	Interface
1. Click on 'Speed' on the main interface.	
2. Set sewing speed.	

Operating instructions

3.3 Main interface parameter settings

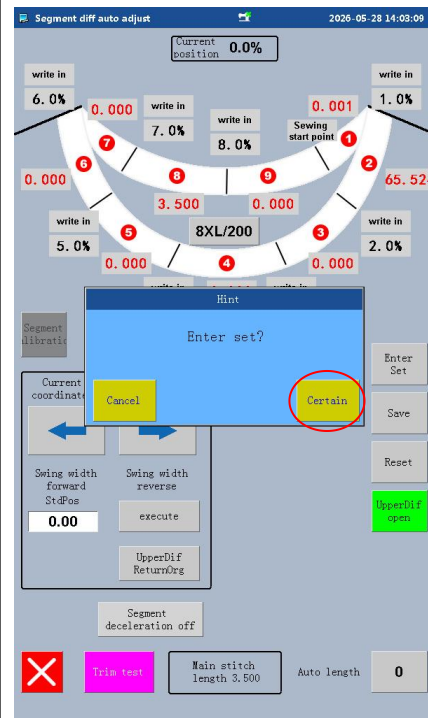
3.3.1 Upper differential settings

Operating instructions:

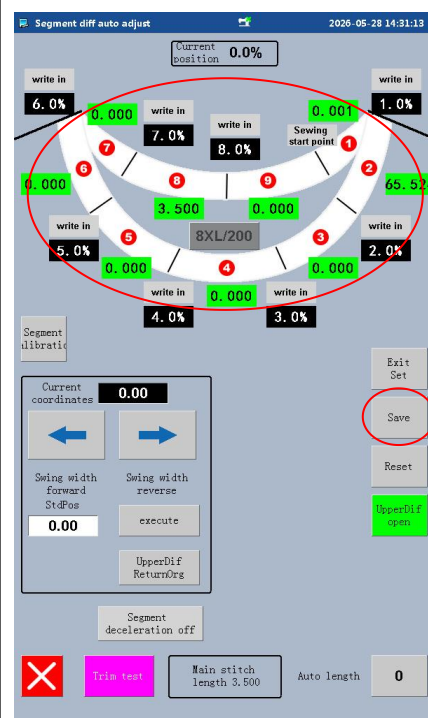
Step	Interface
1. Click on 'Segment Upper differential' on the main interface.	 The screenshot shows the main interface of the 'Upper round collar machine'. At the top, it displays 'Speed 3000' and 'Style 2'. Below this, there are buttons for 'NewSettings' and 'Delete'. The 'Production count' is shown as '00000'. The 'Set UpperDif' button is circled in red. Other parameters include 'LowerDif 0.00', 'Wheel speed 3.500', 'Fold seam', 'seam flips 1000', 'thread through the seam', 'seam position 2000', 'Loose shaft', 'Medium correction height 10.00', 'Elastic rib OFF', 'Middle pallet position 1.00', 'Round neck of Perimeter 0', 'Idling OFF', and 'Overall ratio 10.0%'. At the bottom, there are icons for 'EquipmentDetect', 'SystemParameter', 'Origin', and 'Presser foot'.
2. Enter the segment differential auto adjust, click 'Enter set'.	 The screenshot shows the 'Segment diff auto adjust' interface. It features a circular diagram with various percentage values (6.0%, 7.0%, 8.0%, 5.0%, 4.0%, 3.0%, 2.0%, 1.0%) and 'write in' buttons. The 'Current position' is '0.00%'. The 'Sewing start point' is '0.001'. The 'Main stitch length' is '3.500'. The 'Auto length' is '0'. The 'Enter Set' button is circled in red. Other buttons include 'Save', 'Reset', 'UpperDif ReturnOrg', and 'Segment deceleration off'.

Operating instructions

3. Click 'Certain', enter set mode.

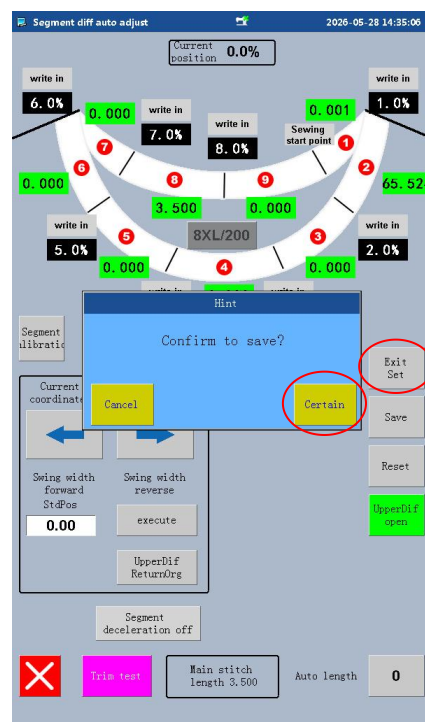


4. Set the upper differential parameters and click 'Save'.

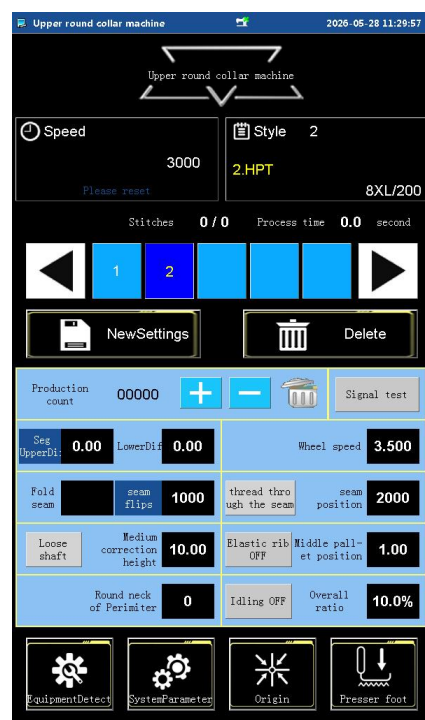


Operating instructions

5. Click 'Confirm', save the upper differential parameter settings.



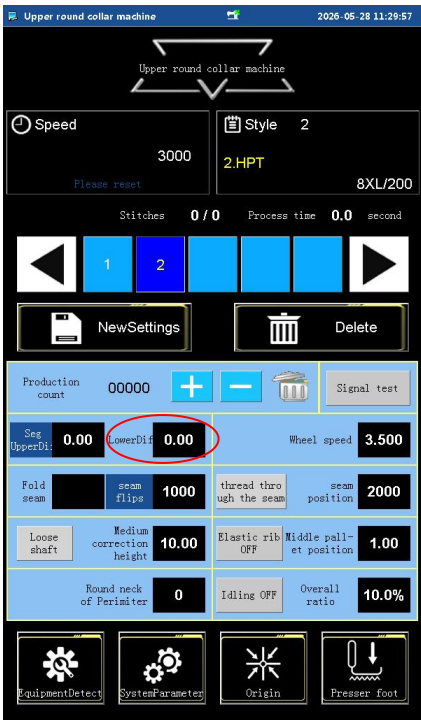
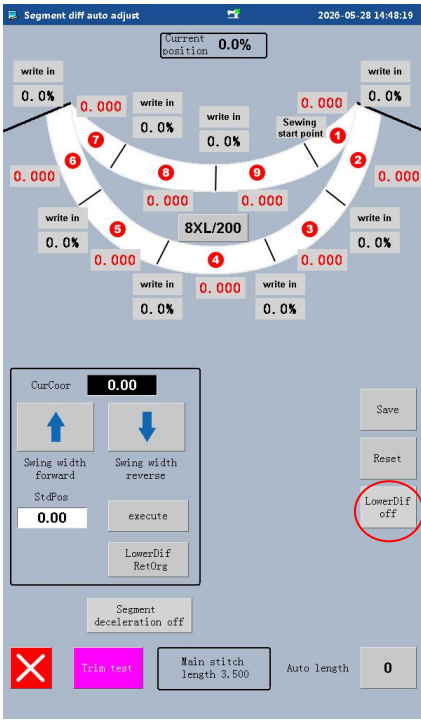
6. Exit parameter setting operation and return to the main interface.



Operating instructions

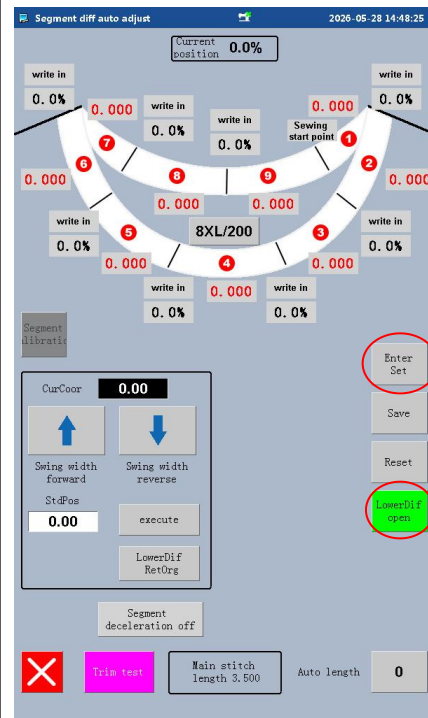
3.3.2 Lower differential settings

Operating instructions:

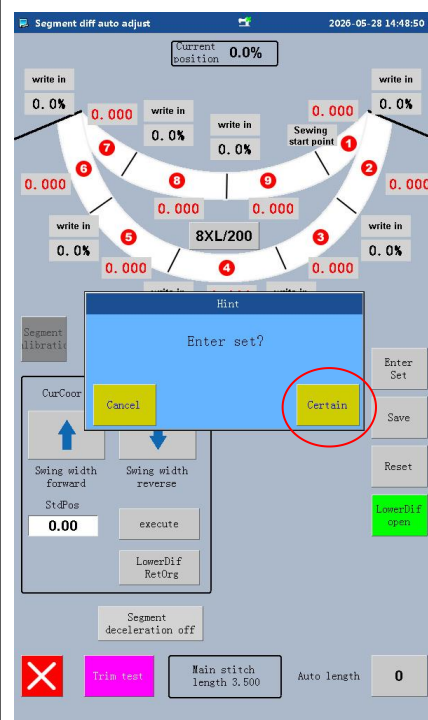
Step	Interface
1.On the main interface,click‘Lower Differential’.	
2.Enter the lower differential segmented interface,click the‘Lower Differential Segmented On/Off’switch to open the segmented correction settings.	

Operating instructions

3. Click 'Enter Settings'.

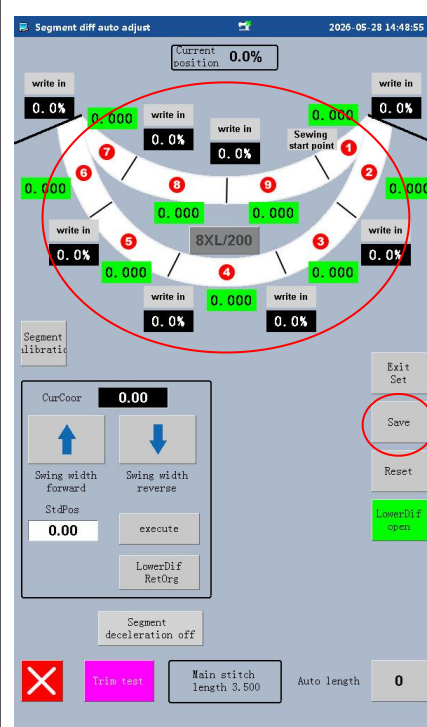


4. Click 'Confirm' to enter the setting mode.

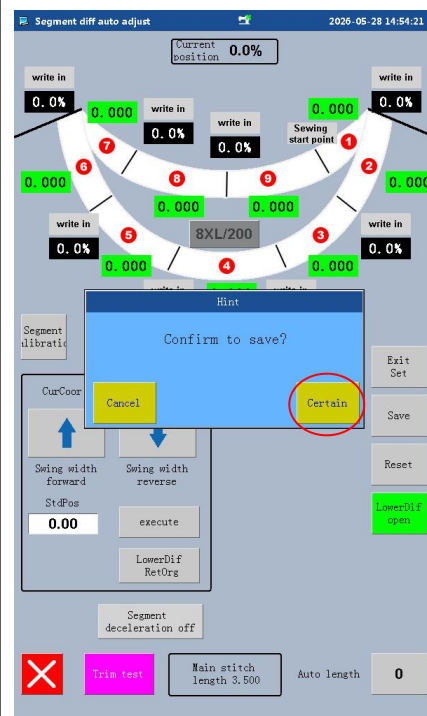


Operating instructions

5. Set the lower differential parameters, click 'Save'.

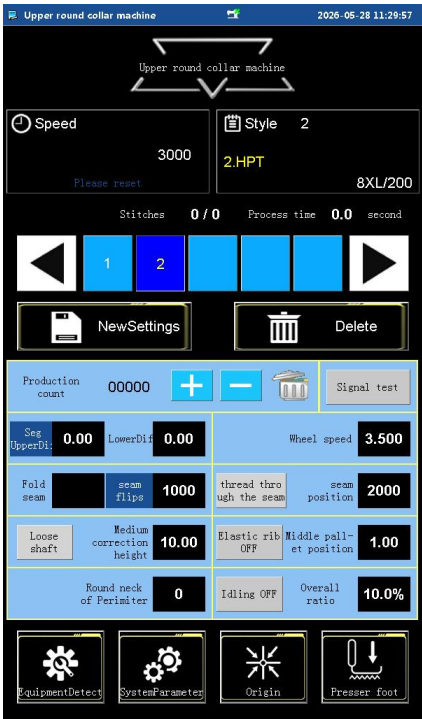


6. Click 'OK' to save the lower differential parameter settings.



Operating instructions

7.Exit parameter settings and return to the main interface.



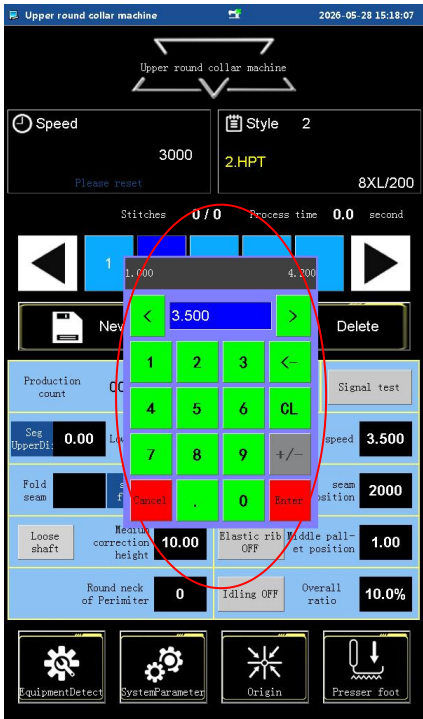
3.3.3 Wheel speed

Operating instructions:

Step	Interface
1.On the main interface,click‘Wheel speed’.	

Operating instructions

2.Set the wheel speed.



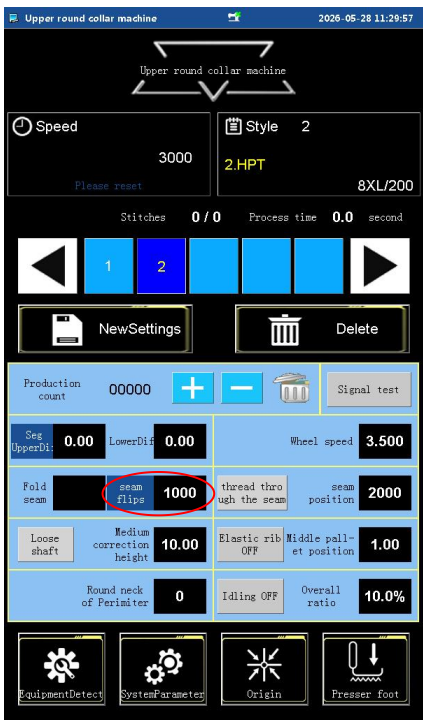
3.3.4 Seam flips

Operating instructions:

Step

1.Click‘Seam Flips’on the main interface.

Interface



Operating instructions

2.Set the reverse bone distance at the start of sewing,click‘Next Page’to enter the jump bone parameter setting interface.

seam flips

2020-05-28 15:20:29

seam position 1

ON

Invert bone method

SeamBone P/B

Current distance

0

Start distance of the inverted of bone

1000

Write In

Multi-bone Air Blowing Function

Multi-bone air blowing time

100ms

Multi-bone air blowing deceleration speed

ti-boning reverse #

Seam bone detection

Seam Bone Offset

100

Fail test

InvertBone test

Repeat

NEXT

3.Set jump bone position parameters.

seam flips

2020-05-28 15:20:35

JumpingBone Technique

Current position

0.0%

JumpingBone Pos.

10.0%

Write In

JumpingBone Pos.

10.0%

Write In

JumpingBone Pos.

10.0%

Write In

JumpingBone Pos.

10.0%

Write In

Jumping bone po or bone examina

100

Jumping Bone Distance.

--

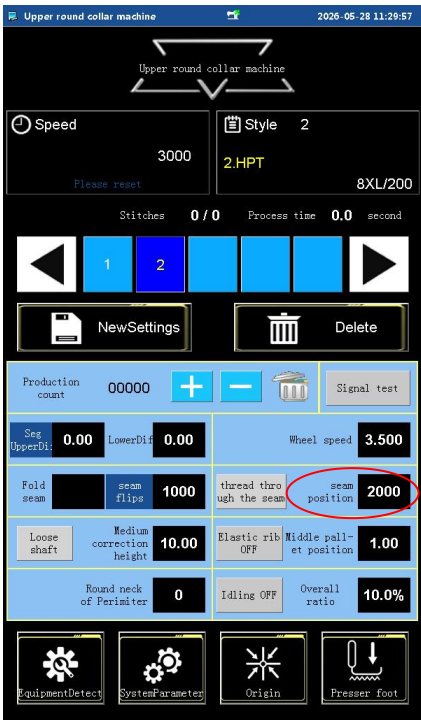
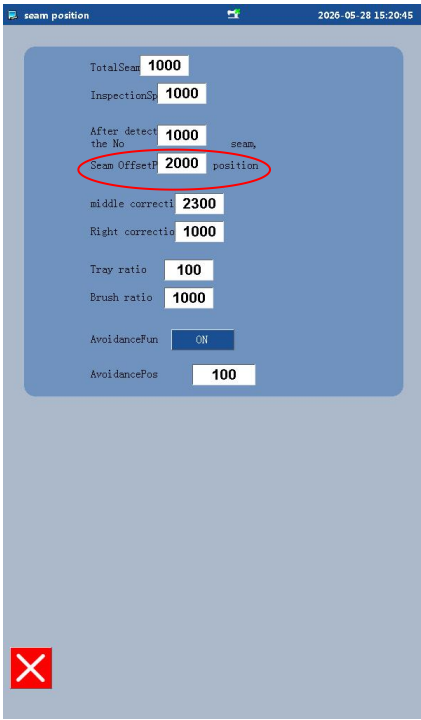
Fail test

LAST

Operating instructions

3.3.5 Seam position offset

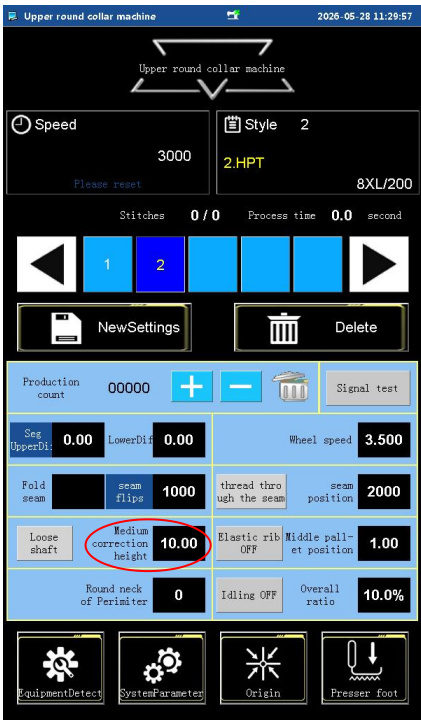
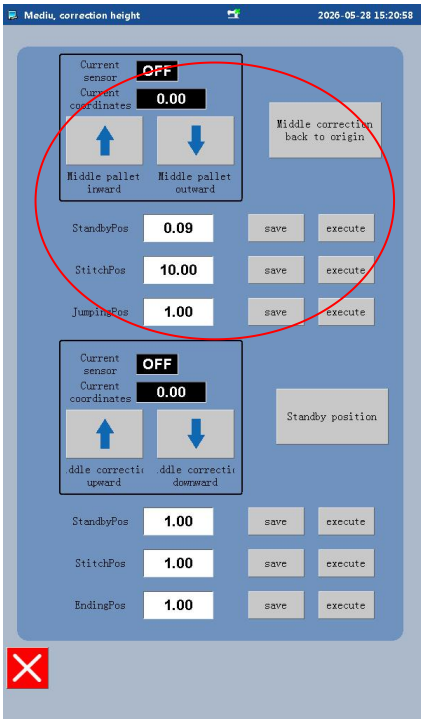
Operating instructions:

Step	Interface
1.Click‘Bone Position Offset’on the main interface.	
2.Enter the bone position setting interface,set the bone position offset parameters.	

Operating instructions

3.3.6 Mediu correction height

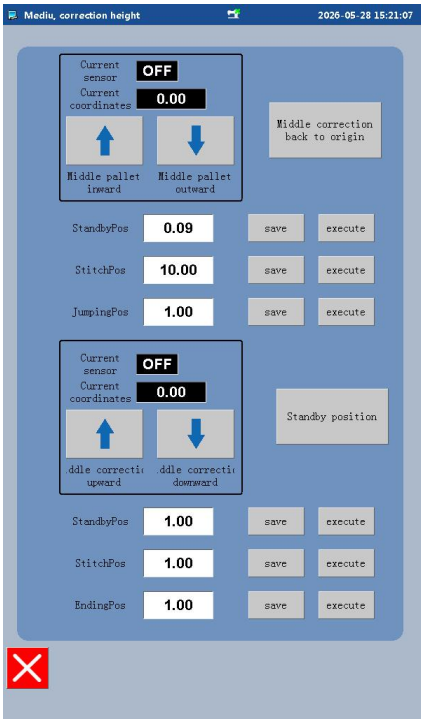
Operating instructions:

Step	Interface
1.Click‘Middle Pleat Height’on the main interface.	
2.Enter the Middle Pleat Height setting interface. Set the sewing position parameters.	

Operating instructions

3.3.7 Middle pallet position

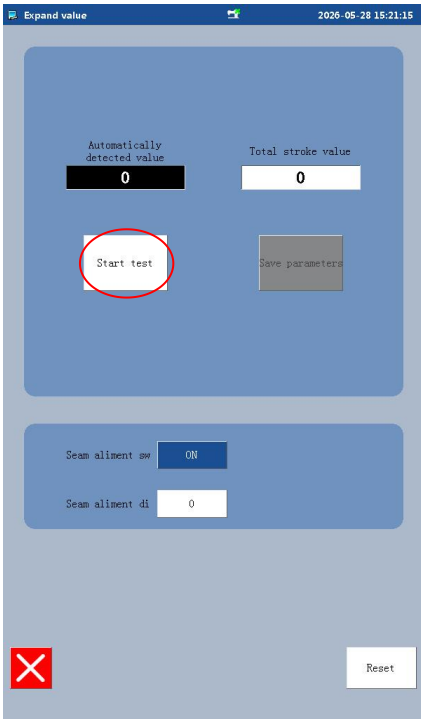
Operating instructions:

Step	Interface
1.Click‘Middle Support Position’on the main interface.	
2.Enter the middle correction height setting interface.	

Operating instructions

3.3.8 Round neck of perimeter

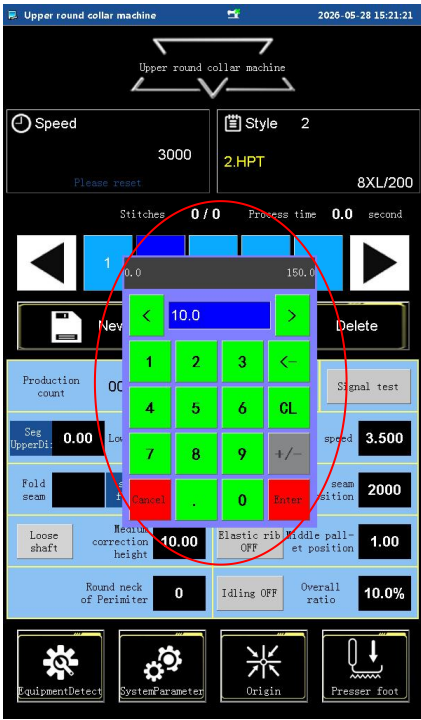
Operating instructions:

Step	Interface
1.Click‘Round Neck Of Perimeter’on the main interface.	
2.Enter the automatic circumference calculation interface,click‘Start Detection’,and set the stroke value parameters.Set the bone alignment distance.	

Operating instructions

3.3.9 Overall ratio

Operating instructions:

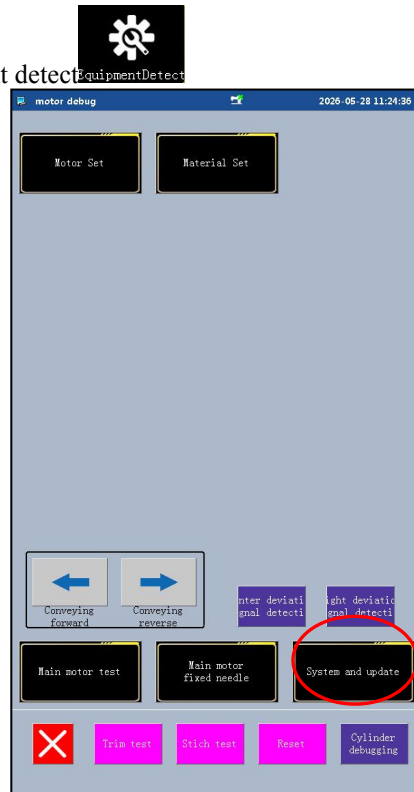
Step	Interface
1.On the main interface,click‘overall Ratio’.	
2.Set the ratio value.	

Operating instructions

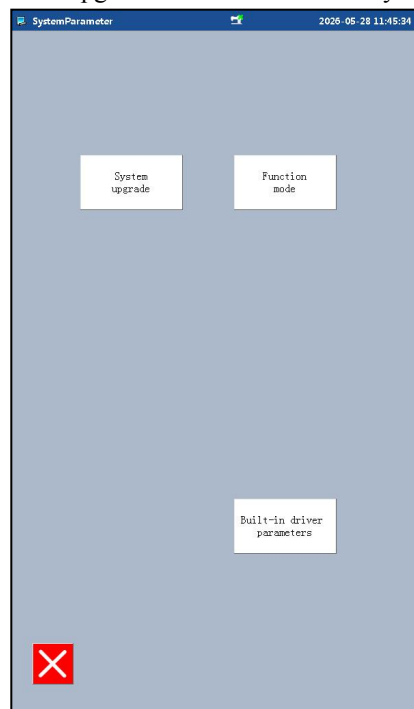
Chapter 4 Functional Mode

4.1 Introduction to Function Modes

Main interface, open Equipment detect



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

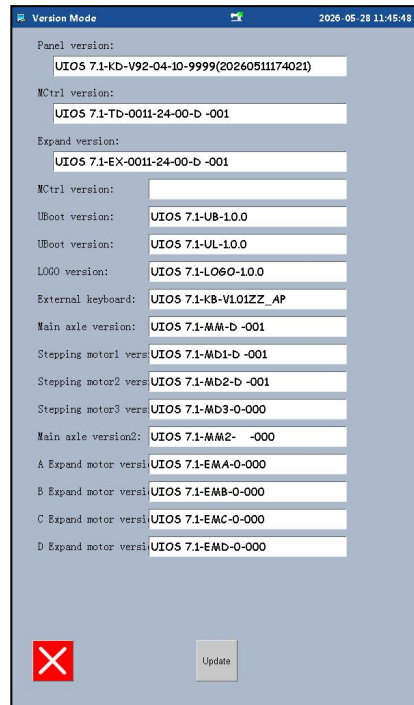


Introduction: You can see that the system parameters are divided into two parts: "System Upgrade" and "Function Mode"

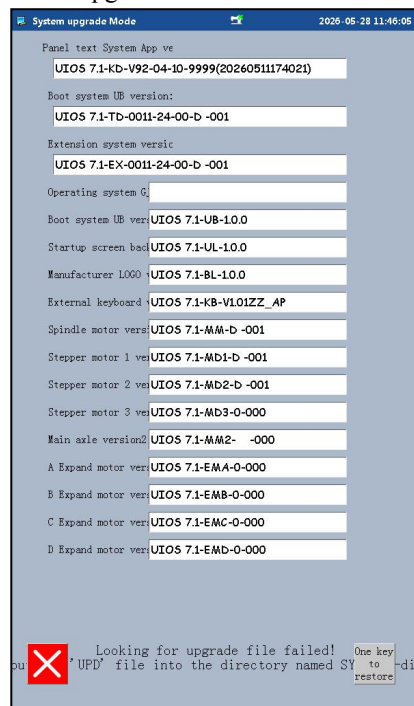
Operating instructions

4.2 Parameter Import and Export

Click on "System Upgrade" on the system parameter interface



Insert the USB flash drive and click upgrade



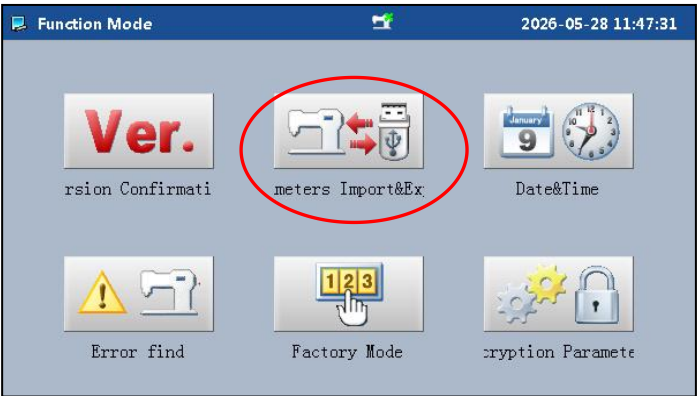
Attention: USB upgrade file upgrade method

- 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;

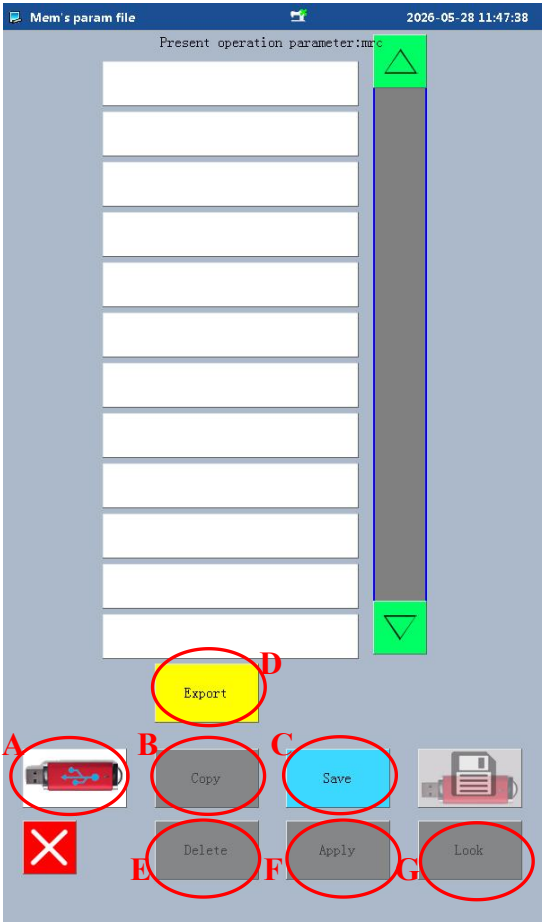
Operating instructions

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	Apply	Application Files
G	Lock	File preview