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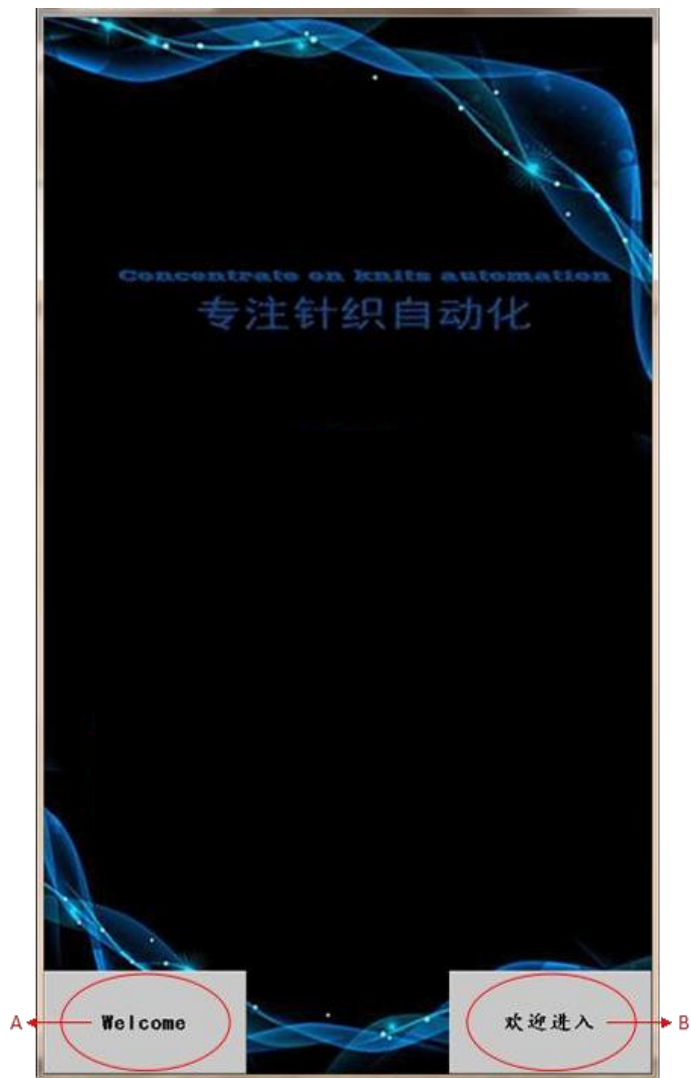
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Chapter 1: Boot interface

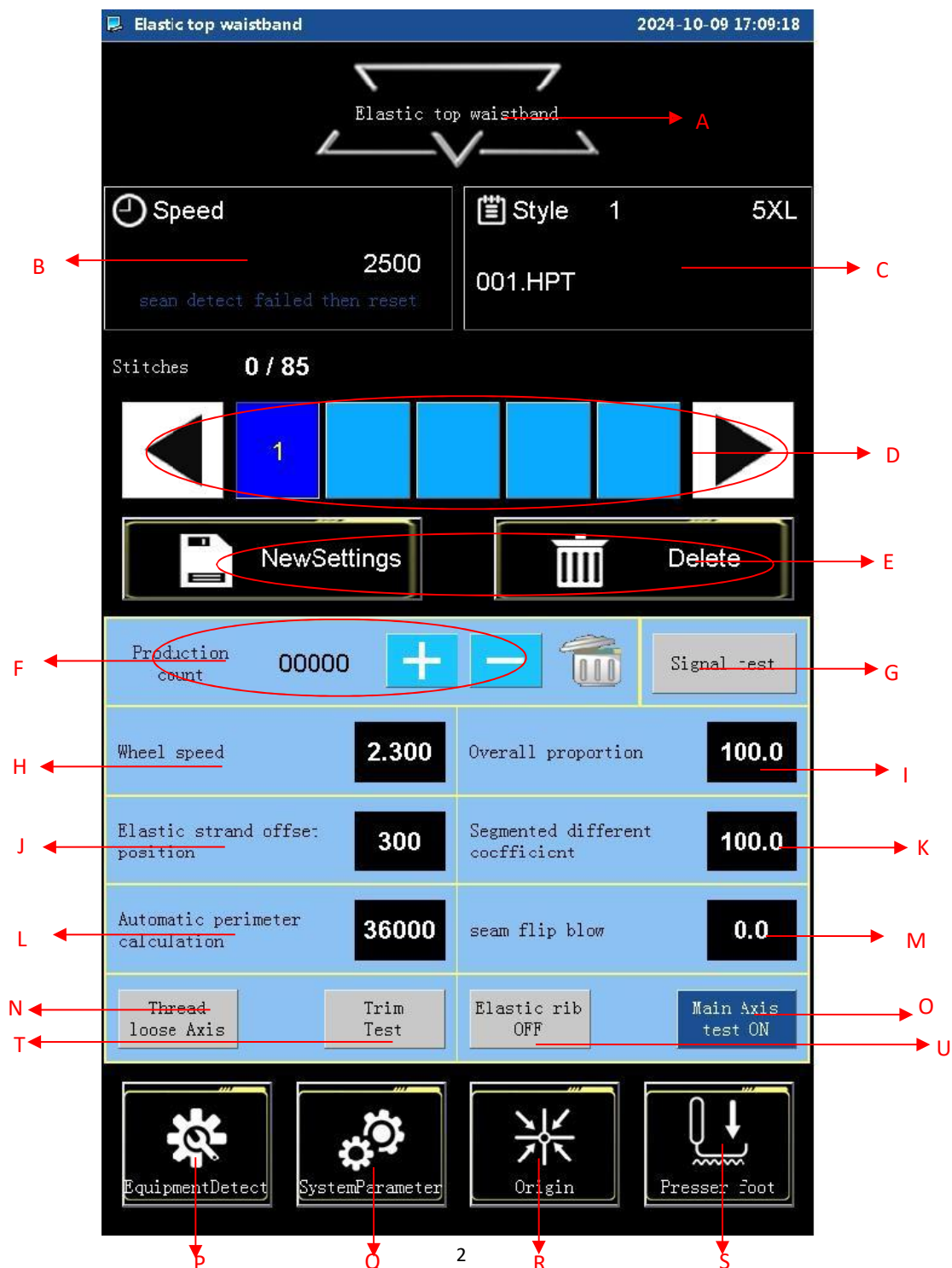
This machine supports multiple languages can switch system languages accord to the user After turning on the power, click on the foreign or Chinese button according to user needs to enter the option interface.



Function :

order	function	content
A	Foreign language	This display can be displayed in the system parameters->Main interface set->Parameter 1 settings
B	Chinese	Display Chinese

Chapter 2: Settings and functions related to large version style

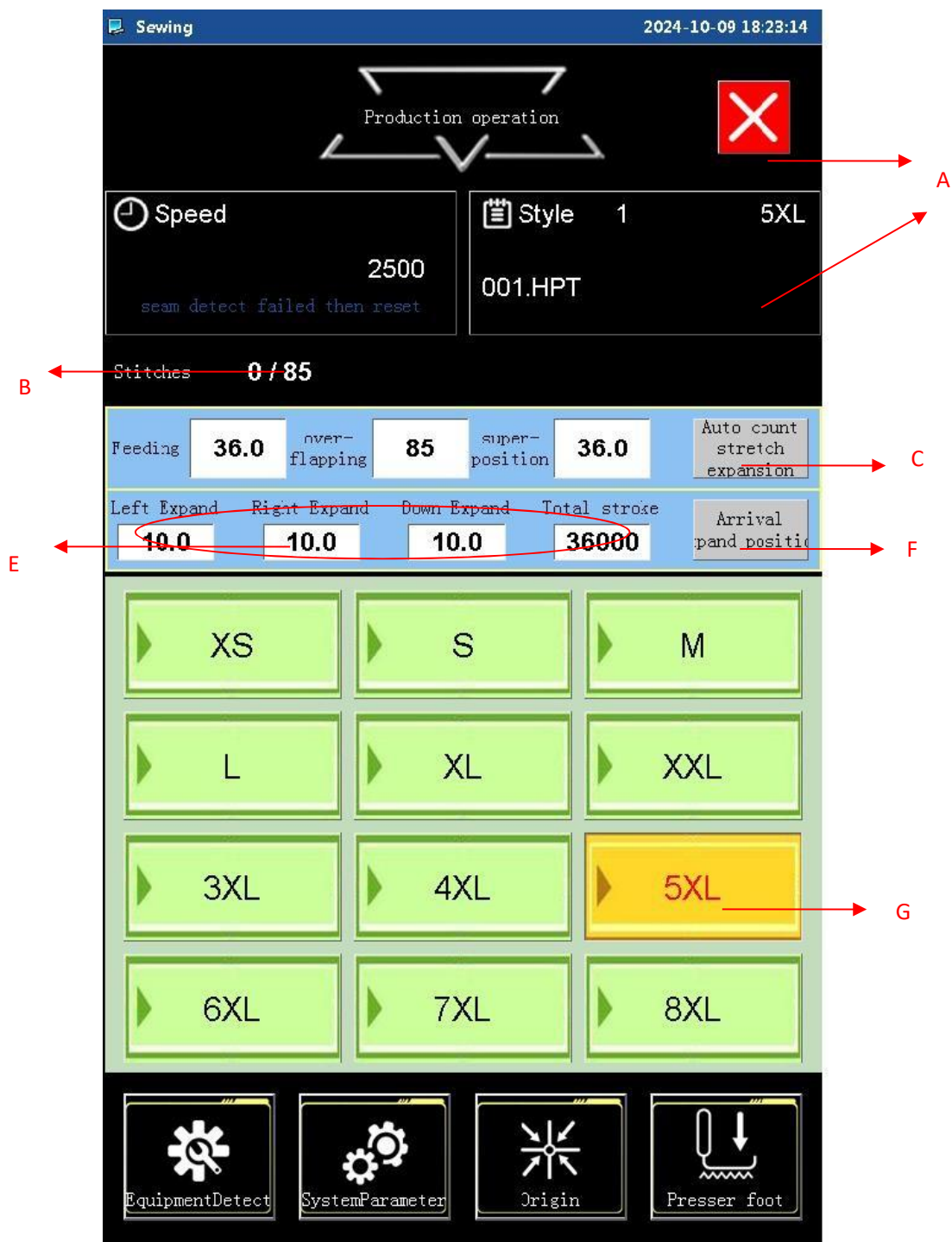


Mian interface function description:

order	function	content
A	Elastic top waistband	Click here to enter the startup interface
B	Speed and its prompt text	Set running speed prompt text displays
C	Style information and sewing interface	Click on the style number and size to enter the sewing interface
D	Style List	Style List choose a larger style
E	New and delete	Create and delete style
F	Production count	Count addition/subtraction, clear to zero, click to enter the count setting interface
G	Signal test	Input and output signal detection interface
H	Wheel speed	Set wheel speed
I	Automatic perimeter calculation	Set to obtain automatically calculated perimeter values
J	Overall proportion	E overall scale value
K	Segmented different coefficient	Different proportions of display break
L	Automatic perimeter calculation	In the Expand value inftere
M	Seam flip blow	Set Reverse Stich Blowing Function
N	Thread loose Axis	Click on the threading and axe loosening function
O	Elastic rib OFF\ON	Elastic rib OFF\ON
P	Main Axis test OFF\ON	Main Axis test OFF\ON
Q	Device detect	Click to enter the device detection
R	System Parameter	Click to enter the system para
S	Presser foot	Lift /Raise Presser Foot
T	Trim test	Click on the thread cutting test function
U	Elastic rib OFF\ON	Elastic rib OFF\ON

2.1 Sewing interface

Click on the style buttons shown in the figures.



Function description :

order	function	content
A	Exit	Click to exit and enter the main interface
B	Stitches	Display stitch count
C	Over flapping	Set the repeat needle value, different values vary
D	Super position	Set overlay values, different sizes have different values
E	Auto count stretch expansion	Click to automatically count and expand the self-setting value
F	Feeding	The feed function controls the movement of materials within a system key feature include.
G	Size Selection	There are twelve defeat sizes available

2.2 New style

Click the button “New Settings” on the main interface to enter the interface and set the style and number. Click Cancel to go to Style interface. As shown in the figures.



2024-10-09 08:44:03

Name

NO.

<< >>

1 2 3 4 5

6 7 8 9 0

a b c d e

f g h i j

k l m n o

p q r s t

u v w x y

z _ Caps EN Delete

Space Backspace

Cancel OK

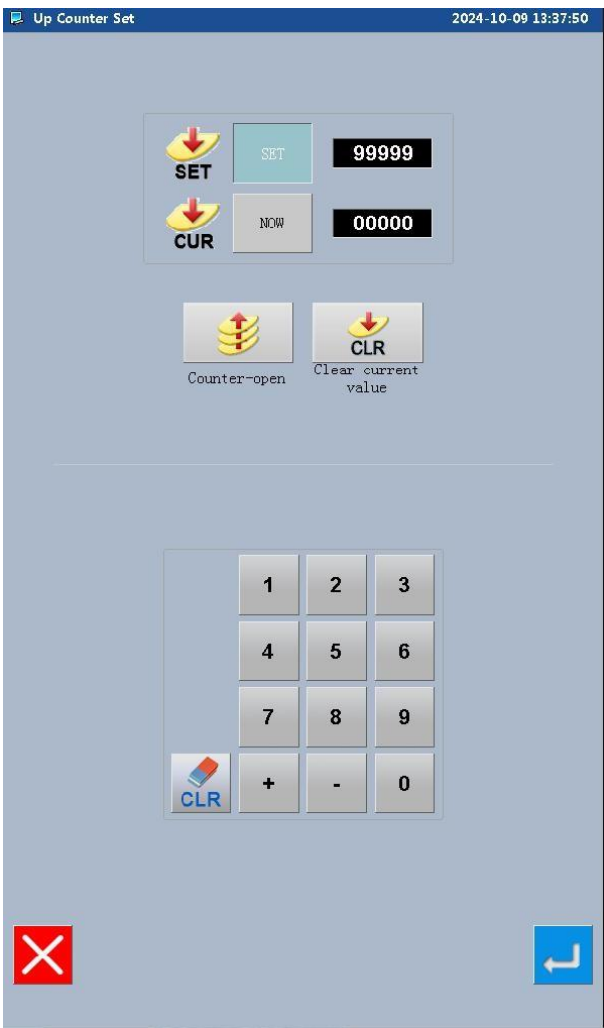
2.3 Delete Style

Click the delete button on the main interface and a prompt box will pop up. Click to confirm the successful deletion the style, click Cancel to exit the detection of the style。



2.4 Production count

Click the button on the main interface called Production count value enter the count up setting interface。As shown in the figures。

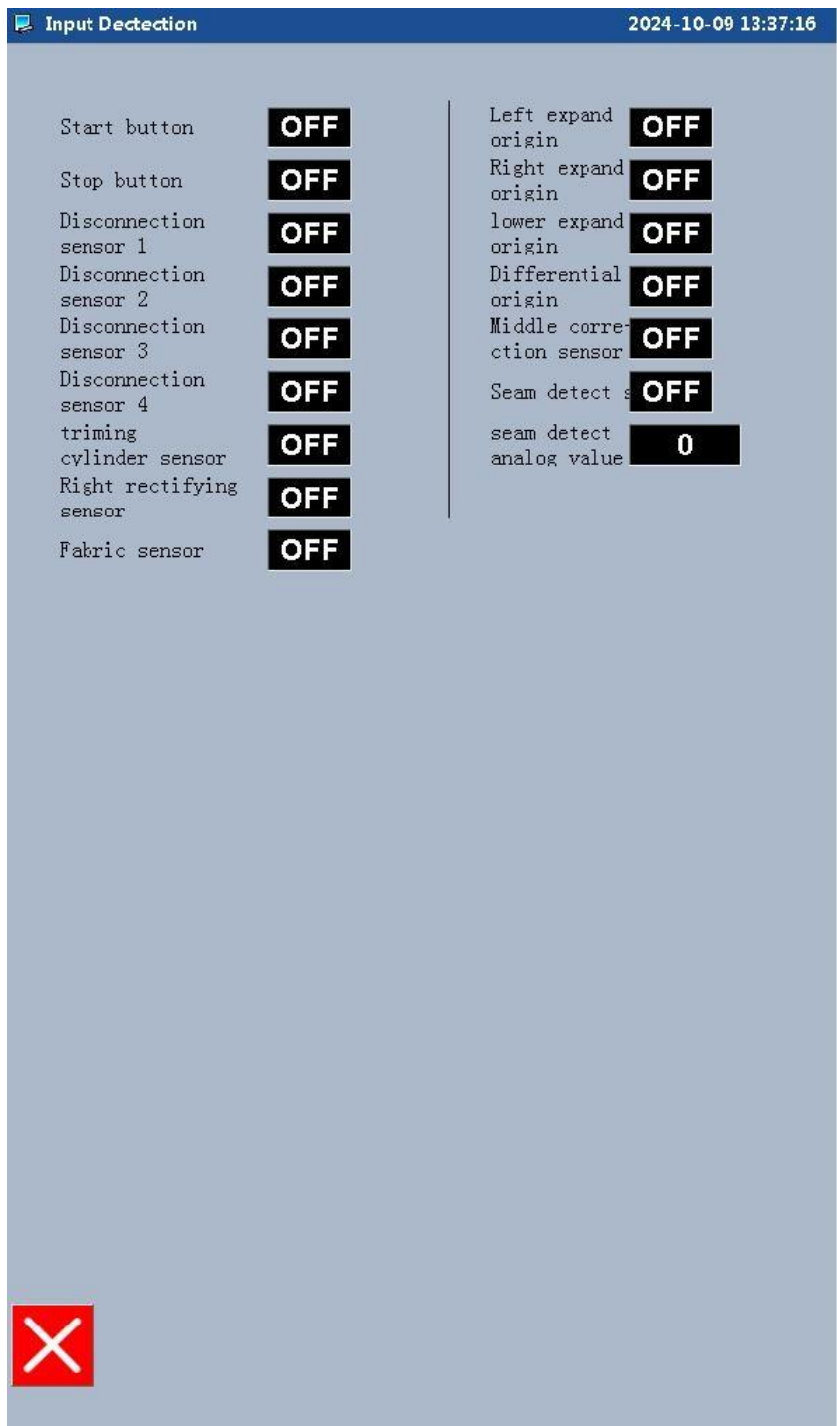


1. Production count setting value (total count setting).
 2. Production Count Current Value Setting.
 3. Counter function switch button。
 4. Clear current value button。
- Set target count: In the setting area, enter the desired production target count, after inputting the number target count. After inputting the number, click the confirmation button to initiate the counting produces during production. It is essential to ensure that the target number you enter aligns accurately with the required production volume, thus maintain the efficiency and accuracy of the manufacturing process.

2.5 Input Diction

Click the input diction button on the main interface the to enter the signal detection interface. Ask for communication to control signal off/on.

As shown in the figures.



2.6 seam high position

Click on the text box name start point on the main interface to enter the automatic expansion。

As shown in the figures。

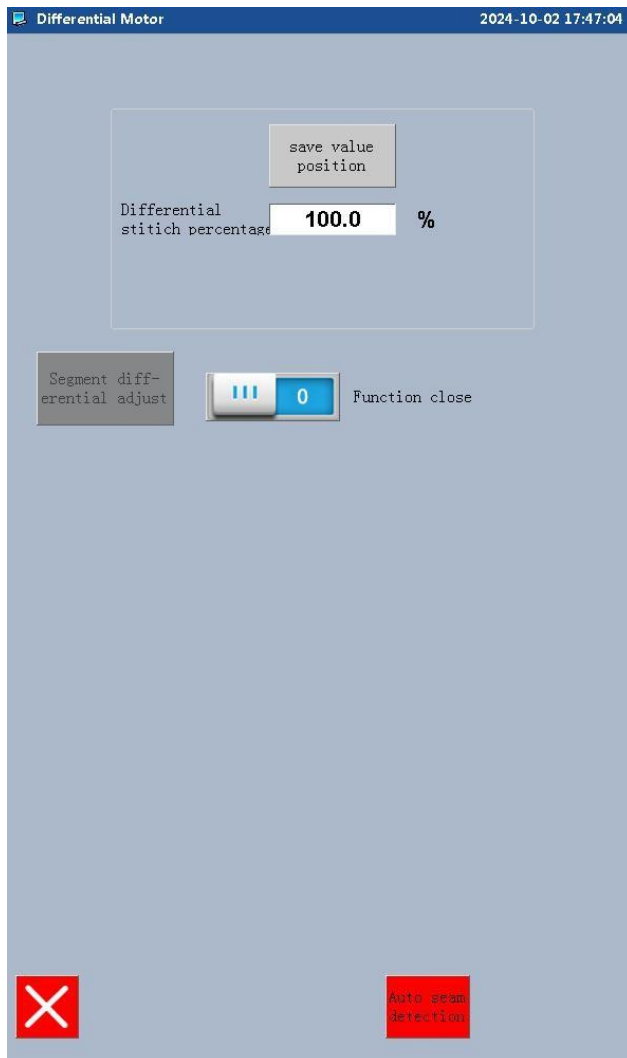
The screenshot shows a software interface titled "seam high position" with a timestamp of "2024-10-03 15:19:48". The interface has a light blue background. It contains two input fields: "seam deviation value" with the number "300" and "Number of shares" with the number "1". At the bottom left is a red square button with a white "X". At the bottom right is a red rectangular button labeled "Auto seam detection".

contain:

1. seam deviation value。
Set seam deviation value。
2. Number of shares, Setting Number of shares。
3. Auto seam detection Click to automatically check the stock function.

2.7 Differential motor

Click on the Edit Text box “Different Moto Portions” o the main interfaced Ent the stock conversion. As shown in the figures.



1. Set target position:

2. unction: input the specific percentage value of the position you want to set.

Description: For example. If you want the motor to operate at 50% differential needle distance you need to input 50. This will adjust the motor to the specified target position to achieve the desired operational effect.

2. Automatic stock Detection:

3. Function: Click the “Automatic stock detection” button to active the automatic stock detection feature.

4. Description: This function allows the system automatically detect the current stock position, ensuring that the device is in the correct location. Once activated, the system will perform necessary measurements and adjustments.

5. Toggle switch button:1

6. Function: Clicking this button will display “1”, enabling the button segment differential adjustment feature.

Description: After pressing this button, the system will show “1”, indict.

Segment differential adjust

2024-10-09 18:10:36

The first position:

0.0%

Differential pitch

60.000

The eighth position:

100.0%

Restore de-fault scale

Reduce

Add

Enter Set



Current position

0.0%

Main needle space

2.300

Interface features:

1. Click to enter settings. A prompt will appear asking if you want to proceed to settings where you can configure various options.
2. Differential spacing setting: Set the differential spacing to a specific size. Click on the differential spacing input field to enter the appropriate numerical value.
3. Position ratio setting: Based on the current position displayed by the main controller, set the position ratio for each point.
4. Restore default ratio button: Click to restore the default position ratios.

2.8 Seam Flip Air Blow

Click on the edit text “seam flip air blow” on the main interface to enter the seam flip air blow interface 。
As shown in the figures。

seam flip air blow

2024-10-03 14:20:44

seam flip position 1		Save	Clear
seam flip position 2		Save	Clear
seam flip position 3		Save	Clear
seam flip position 4		Save	Clear
seam flip position 5		Save	Clear

0.0%

Enter Set

seam flips blow time

0

seam flip blow switch

OFF

seam flip air blow

Reset

- contain:**
- 1. Set the percentage ratio 1to 5 for the inverter position, and click to save the current value, or clear value。
 - 2. Reset, click to reset the inverted position.

2.9 Expand value

Click the “automatic perimeter calculation value” button on the main interface to enter the corresponding value expand interface

1. Automatic detected value: This feature allows users to input and display the total travel value that needs to be adjusted. It provides real-time feedback on the current settings. Enabling precise control over the system's operation.

2. Start Detection:

This button imitates the motor's detection process. Once pressed, the system will begin to measure the specified values, allowing for accurate adjustments based on the detected parameters.

3. Save parameters:

This function allows users to save the parameters that have been deemed suitable after adjustments. By saving these settings, users can ensure that the system retains the optimal configurations for future operations.

4. Reset button:

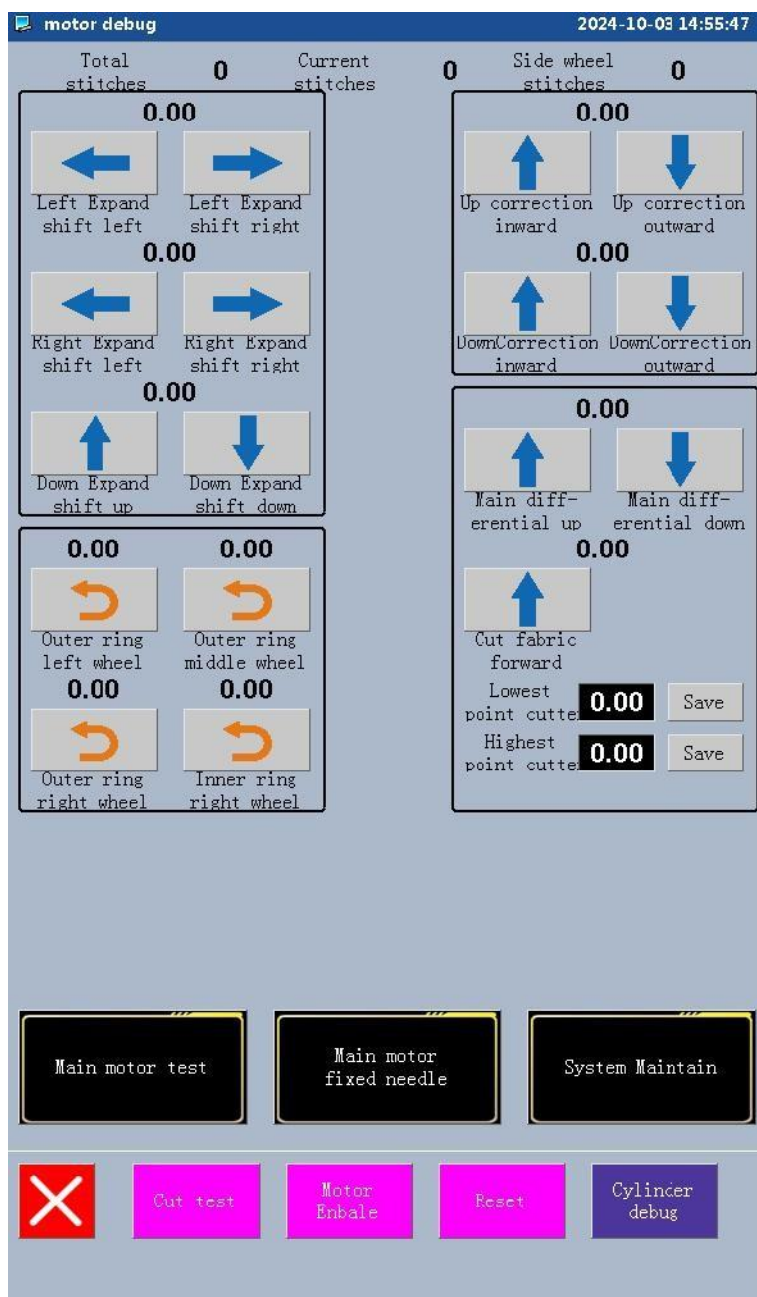
This reset button restores the system to its default settings. This is useful for reverting any changes made during the adjustment process, allowing users to start fresh if needed.

The screenshot displays the 'Expand value' interface with a blue header bar containing the title 'Expand value' and a timestamp '2024-10-08 15:32:01'. The main area has a light blue background. It features two input fields at the top: 'Automatically detected value' with a black background and white text '0', and 'Total stroke value' with a white background and black text '65000'. Below these are two buttons: 'Start test' (white with black text) and 'Save parameters' (grey with black text). At the bottom left is a red square button with a white 'X', and at the bottom right is a white button with black text 'Reset'.

Chapter 3: Device detection

3.1 Motor debug

Click the button named Device Detection on the main interface to enter motor configuration interface. In this interface, functions such as motor debug, thread cutting cutter testing and reset can be achieved. As Shon in the figures.



3.2 Cylinder debug

Click the “Cylinder debug” button on the motor debug trace to enter the debug interface。

In this interface, the cylinder button status, cylinder debugging, strand inversion material receiving test, reset, and other functions can be achieved。

As shown in the figure。



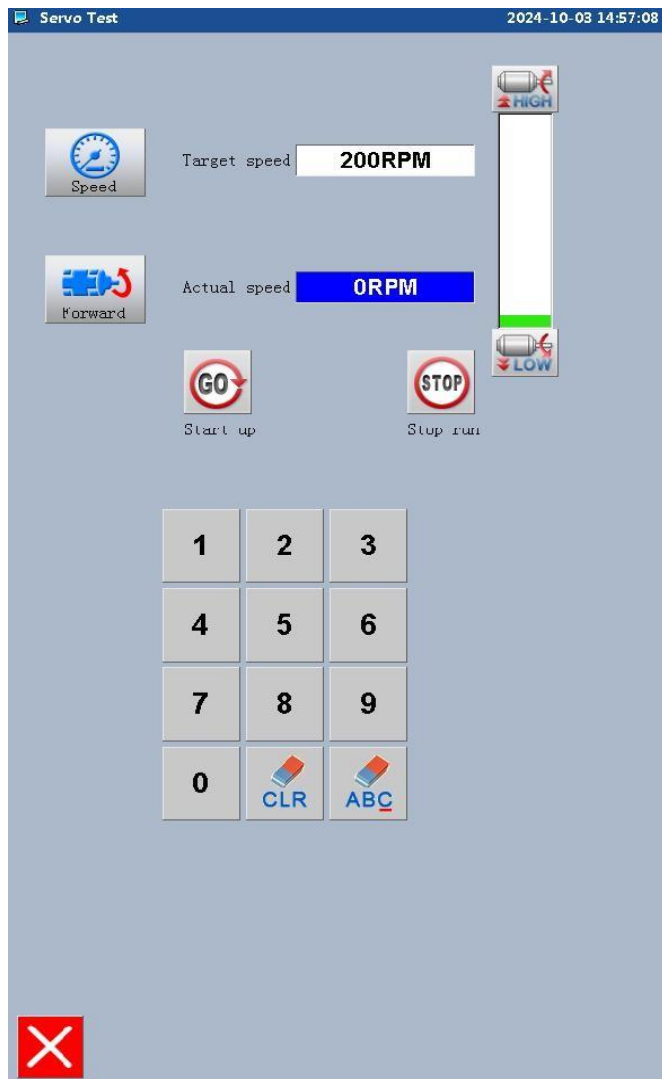
3.3 Servo Speed Detection

Click the “Servo Speed Detection” button on the motor debugging interface to enter the spindle testing interfaces.

On this interface, you can debug the spindle speed.

As shown in the figure.

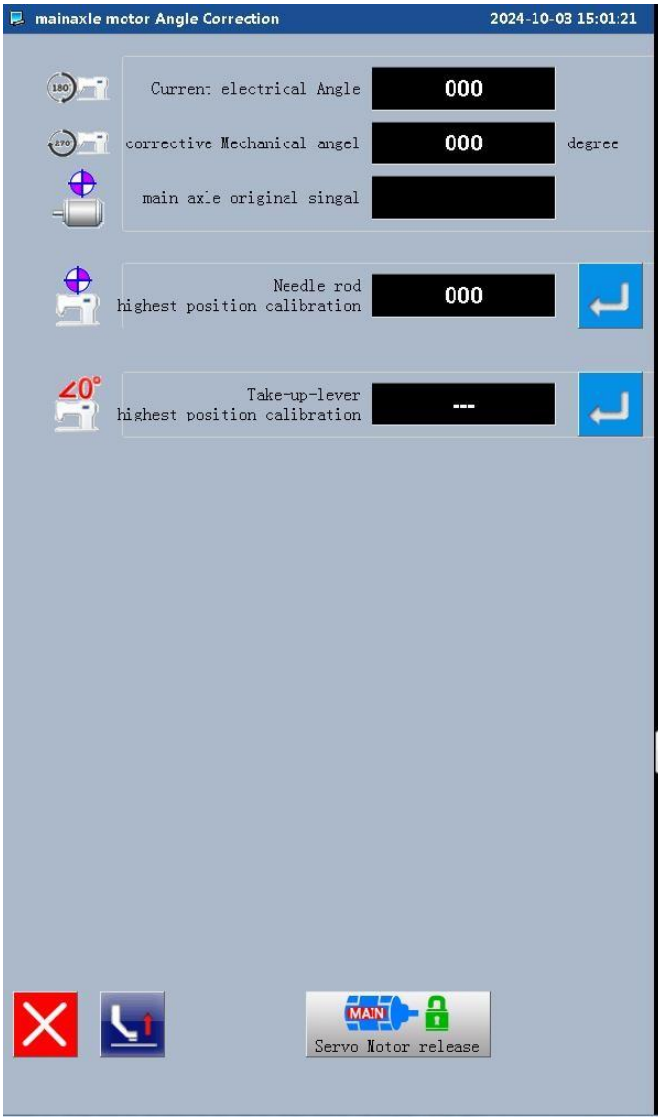
1. Display the actual speed and show the current spindle’s actual speed (RPM).
2. Set speed: Allow the use of input or buttons to reach the target speed.
3. Control buttons: Basic operation buttons such as start, stop, reset, etc.
4. Alarm: If a safe range is set, an alarm message will be displayed.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



3.4 Main axle motor Angle Correction

Click the button named “Servo angel Detection” on the device detection and debug interface to enter Mianaxle motor angle correction . This interface allows for main ale motor Angle Correction. As shown in the 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. Exactly Open the interface and complete the initiation settings;
2. Find the “Spindle Motor Release/Lock” button on the interface. Clicking this button can release or lock th state, allowing it to move freaky and conveniently.
3. Conduct measurements, rotate the spindle by a certain angle, read data from multiple position
4. After adjusting to the satisfactory position, find “Spindle Motor Lock” on the soft armor interface to prevent it from shifting during operation.
5. Final validation, perform a complete measurement again to ensure that all parameters are within the allowable tolerance range.



Chapter 4: System upgrade and functions

4.1 System upgrade Mode

Click on the testing interface 【System update】 -> 【Update】 , enter the Version Mode interface。

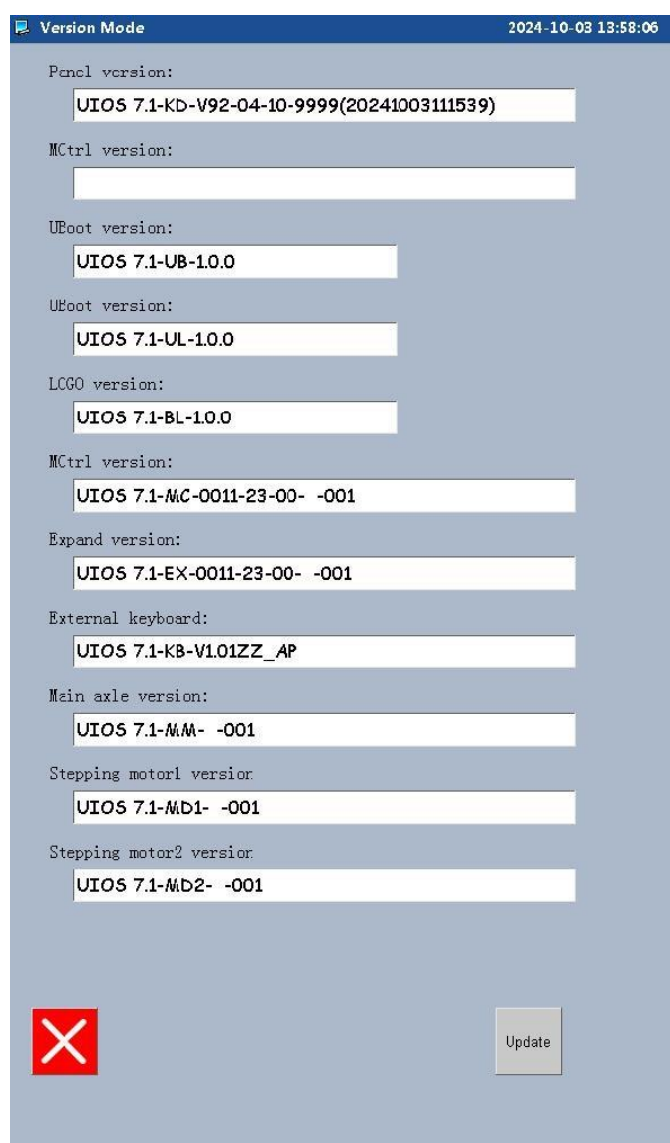
Used to view the version number of the control system。

For example: MCtrl version、Panel information LOGO version、 Stepping motor1 version, etc. information.

Click the upgrade button to enter the system upgrade interface。

This interface allows for version upgrader and system restore function。

As shown in the figure。

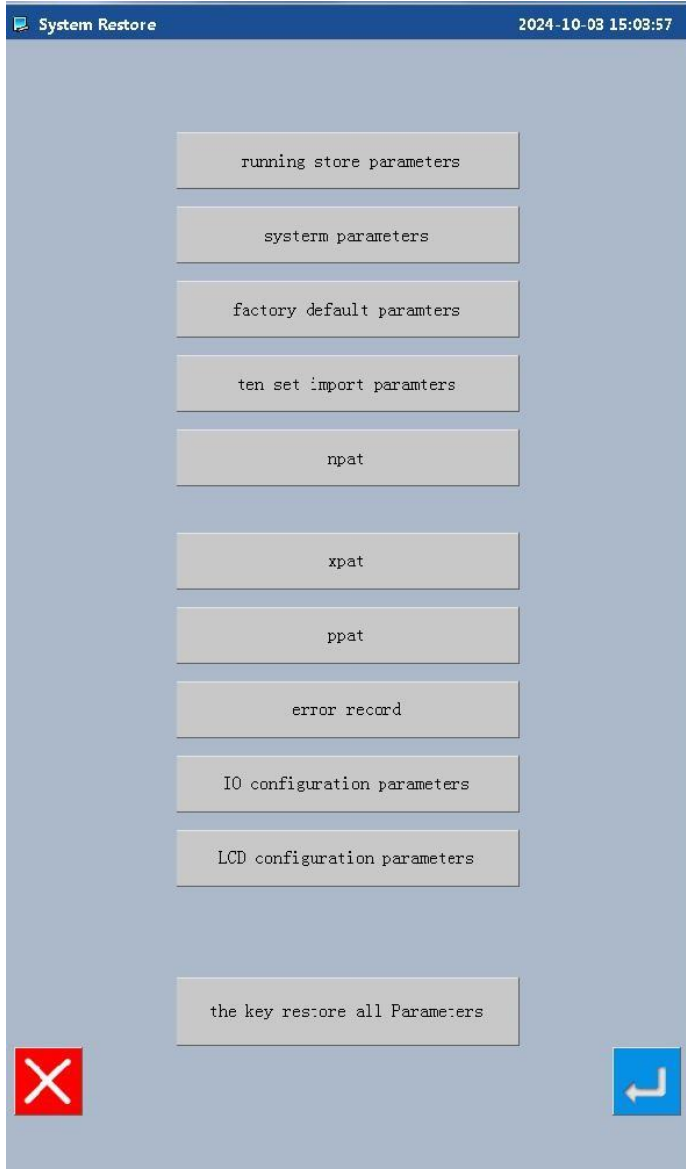


1. Upgrade: Search for USB drive upgrade files and select the upgraded system. Click on the one upgrade button to proceed with the upgrade process. Don't turn off the power during the upgrade process. After upgrading, a prompt box will pop up, please restart the power supply。

2. Restore: Click the one click recovery button to enter the system restore. As shown in the figure. You can restore all parameters with one click or select the parameter items that need to be restored. Restore the operation to the original default values. After the system is restored, a prompt box will pop up, please restart the power supplies。

3. System restores: Click the [Click restore] button to enter the system restore interface; As shown in the following figure 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, prompt box will pop up, please restart the power supply。

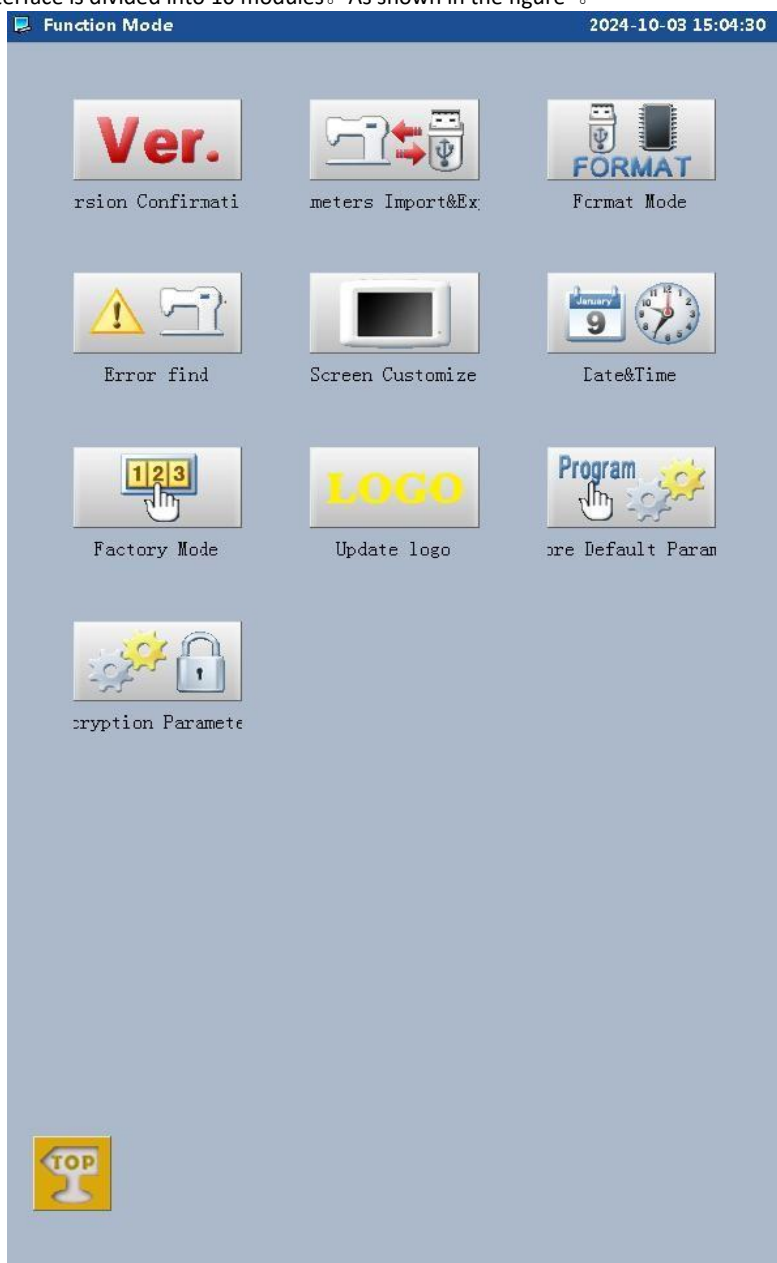
4. Troubleshooting: if the upgrade issue persists. You can search for the technical support contact information provided by the company. Please make sure it provides a detailed description of the problem you encountered and the solutions you have tried, so that technicians can better understand the situation.



4.2 Function mode

Click on the motor debug 【system Maintain】 -> 【Function mode】 button, enter the function mode interface.

This interface is divided into 10 modules. As shown in the figure .



Chapter 5: System parameters

Parameter List:

Parameter Name	Default value	Range
Syncscale (1 Set)		
Side wheel sync scale	350	500-2000
Left wheel sync scale	1500	500-2000
Middle wheel sync scale	1600	500-1600
Differential secondary origin position	0	-1000-1000
Middle wheel cylinder switch	ON	ON\OFF
Left Wheel cylinder switch	ON	ON \ OFF
Put on elastic action (2 Set)		
How long to extend after retracting close and open	350	1-30000
Sewing action (3 Set)		
Right wheel correction in the later stage of sewing	Stop correction	Stop correction\ External correction
Sewing position 1	6000	1000-10000
Sewing position 2	6500	1000-10000
Sewing position 3	7000	1000-10000
Sewing position 4	1000	1000-10000
Outer cycle right wheel outward correction speed	0	0-9999
Speed of center correction position 4	2000	0-9999
Direction of action for position 4 of center correction	Outward correction	Outward correction\ Inward correction
Extension of differential pulse interval time before sewing	0	0-1000
Extension of differential pulse interval time between sewing	0	0-500

Parameter Name	Default value	Range
Correcting method	Ather the presses	Ather the presses 、 Conventional methos
Trim sensor(4Set)		
Whether the disconnection 1 is effective	Invalid	Invalid valid
Whether the disconnection 2 is effective	Invalid	Invalid valid
Whether the disconnection 3 is effective	Invalid	Invalid valid
Whether the disconnection 4 is effective	Invalid	Invalid valid
Broken wire detection needles	1	1-20
Trim (5Set)		
Whether the thread trimming cylinder Is valid	valid	Invalid valid
Delay from thread trimming opening to closing	350ms	10-3000
Delay from thread trimming closing to hool thread opening	50ms	10-3000
Whether the hook line is effective	Invalid	Invalid valid
The delay from hooking on to hooking off	120	10-3000
The delay from hooking close to subsequent action	120	10-3000
Advanced (6Set)		
Servo enable signal delay	100ms	100-999
Time delay after servo ban	100ms	100-999

HALT switch type	ON	ON、NC
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Parameter Name	Default value	Range
Trim switch type	NC	ON、NC
Pneumatic check switch type	NC	ON、NC
Set language (7Set)		
Language	English	Chinese 、 English 、 Vietnam 、 Korean 、 Turkish
Cutter (8 Set)		
Whether the cutter is valid	Effective	Effective - Invalid
Start position	1	0-9999
Number of stitches that the cutter stops in advance	0	0-50
Roller adjustment (9 Set)		
Speed of idling when start	600	50-600
Main interface (10 Set)		
Display language of icon on the left if main interface	English	Chinese 、 English 、 Vietnam 、 Korean 、 Turkish
Automatic Start (11 Set)		
Whether to start sewing automatically	No automatic	No automatic - Automatic start
Delay time for automatic start	200	100 -30000
Security switch detection a Larm	ON	ON 、 OFF
Expand Setting (12 Set)		
Whether the left expansion origin sensor is useful	Valid	Valid 、 Invalid
Down Expansion Device Options	General	General 、 Ration
Sean flip blow (13 Set)		
Seam flip blow switch	OFF	ON 、 OFF
Seam flips blow time	0	0-5000ms
First strand position switch	OFF	ON、 OFF

Continus testing	Stop	Stop 、 Continuous
Delayed Inhalation (14 Set)		

Parameter Name	Parameter Name	Parameter Name
Delayed inhalation time at the begin	200	1-1000
Delayed inhalation time at the end	1000ms	1-5000
Locking cylidner (15 Set)		
Whether locking cylinder is ok	Invalid	Invalid\Pegasus
Dense needle (16 Set)		
Dense needle switch	OFF	OFF, Convective - DAHE
Dense needle stiches number	3	Dense needle stitches