

Bottom Hemming Machine Touch LCD Screen

User Manual v1.0

Safely Instruction

Please read this manual carefully, also with related manual for the machine head before use. For perfect operation safety, installing and operating this product by trained personnel is required. When install and operate this product, precaution must be taken as following.

1. To avoid the false by electromagnetic interference. Please keep the product away from arc welding equipment or electro pulse generator.
2. Please don't operate in room temperature is above 45°C or under 0°C.
3. Please don't operate in room humidity is below 30% or above 95% or dew and mist of places.
4. Install the control box and other components, turn off the power and unplug the power cord.
5. To prevent interference or leakage accidents, please do the ground work, the power cord ground wire must be securely connected to an effective way to earth.
6. All parts for the repair provided by the Company or approved before use.
7. Maintenance and Repairs must be done by specially trained personnel. Performing any maintenance action, you must turn off the power and unplug the power cord. There are dangerous high voltage control box, you must turn the power off and wait five minutes before opening the control box.
8. The marked  in this manual are safety precautions, which must be paid attention to and strictly observed to avoid unnecessary damage.

1 Operation Panel Instructions

1.1 Operation Panel function keys :

Turning ON the powers witch, the machine automatically enters the main interface display screen, as shown in Figure 1-1 below :

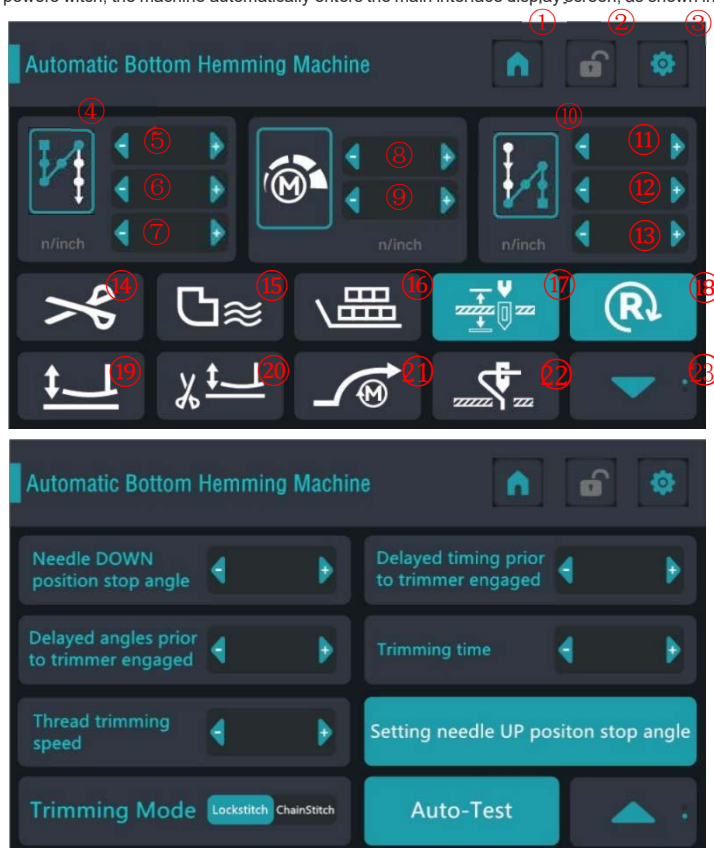


Figure 1-1 Main interface of operation panel

1.2 Functions to each display area are as follows:

NO.	Icon	Name	Function Description
1		Setting key	This switch is used for enter the settings interface screen.
2		Lock Screen key	This switch is used for displaying lock status of the screen on it.
3		Home key	Press this key to returns to the home screen.
4		Start back-tacking	Press this key to turn on or off the start back-tacking.
5		Start back-tacking speed	Press “+” to adjust the start back-tacking speed.
6		Start back-tacking stitch	Press “+” to adjust the start back-tacking stitch.
7		Start back-tacking stitch length	Press “+” to adjust the start back-tacking stitch length.
8		Sewing speed	Press this key to adjust the sewing speed.
9		Sewing stitch	Press this key to adjust the sewing stitch length.
10		End back-tacking	Press this key to turn on or off the end back-tacking.
11		End back-tacking speed	Press “+” to adjust the end back-tacking speed.
12		End back-tacking stitch	Press “+” to adjust the end back-tacking stitch.
13		End back-tacking stitch length	Press “+” to adjust the end back-tacking stitch length.
14		Trimming setting key	Press this key to turn on or off the trimming function.
15		Blowing setting key	Press this key to turn on or off the blowing function.
16		Pulling setting key	Press this key to turn on or off the pulling function.
17		Needle position setting key	Needle stop setting: Stop at down position or at up position.
18		Restore and save key	Restore the user parameter or save the user parameter.
19		Auto foot-lifting during intermediate stop	Presser foot action when motor stop.
20		Auto foot-lifting after trimming	Presser foot action after trimming.
21		Slow start sewing key	Press this key to turn on or off the slow start sewing function.
22		Poke setting key	Press this key to turn on or off the poke function.
23		Next page key	Press this key to enter the next page.

1.3 Basic operation

1.3.1 \ up position calibration

In standby mode, run the motor once to ensure that it can operate normally and the system has no faults. Then, rotate the handwheel of the machine head to reach the desired upper needle position, and click the icon  to save the current position as the upper needle position.

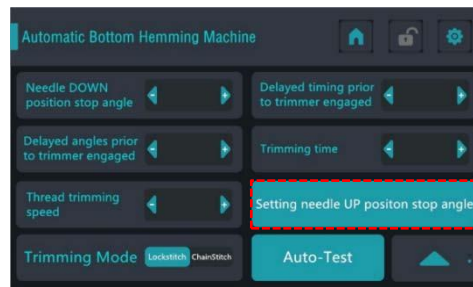


Figure 1-2 Up position calibration

1.3.2 \ Auto-test

In standby mode, simply click on the icon  to enter automatic testing mode.

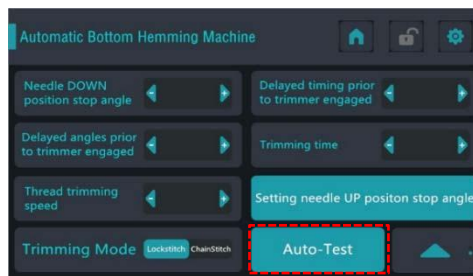


Figure 1-3 Auto-test function

1.3.3 \ Restore and Save setting

Restore user parameters: In standby mode, press the restore button to enter the user parameter recovery and save operation interface. Click the restore button and the machine will automatically restore user parameters. After completion, it will display "Parameter recovery completed, please restart", indicating that the recovery is complete. Shut down and restart again.

Save user parameters: In standby mode, press the restore button to enter the user parameter recovery and save operation interface. Click the save button, and the machine will automatically save the user parameters. After completion, Display 'Parameter save completed, please restart' to indicate that the save is complete. Shut down and restart. As shown in Figure 1-4 below.



Figure 1-4 Restore and Save setting

2 System and Parameter setting instruction

2.1 system setting: System Setting menu includes language Settings, screen brightness Setting, key tone Setting. Click  and then click "System setting" to enter the system setting menu. At this time, you can set the language, brightness and key tone.

2.2 Motor angle calibration : Motor angle calibration includes up position calibration and motor initial calibration.

2.2.1 up position calibration : In idle mode, click  to enter setting interface. Click "motor angle calibration" to enter the menu of Angle calibration, and click "up position calibration" to enter the interface of up position calibration. At this time, press the front pedal and release it to display the current angle value. Rotate the hand wheel according to the normal running direction of the machine to the up position. Click the key  until 0 is showed, and the machine will save the up position automatically. Click  to go back to the upper menu and click home key to go back to the main menu.

2.2.2 Motor initial calibration: In idle mode, click  to enter setting interface. Click "motor angle calibration" to enter the menu of Angle calibration, and click "initial angle calibration" to enter the interface of initial angle calibration. At this time, press the pedal and release it. The machine will automatically calibrate the initial angle. The current value is the test value. Click  to copy the current value to the set value, and then press the key OK to save. Click  to go back to the upper menu and click home key  to go back to the main menu.

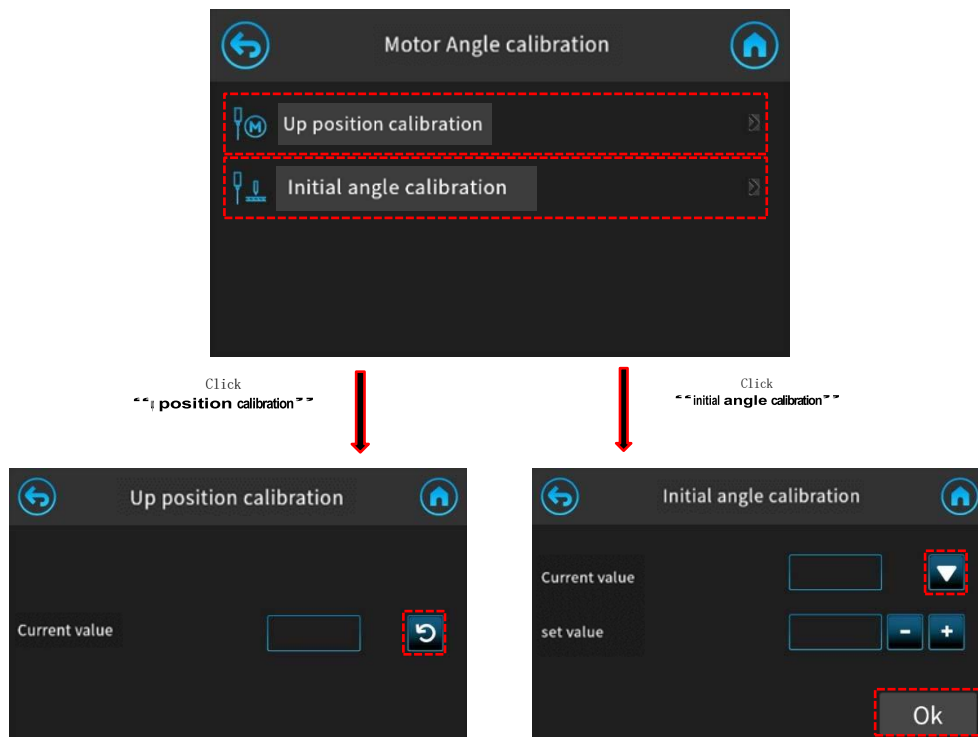


Figure 2-1 motor angle calibration

2.3 System service : System service includes "monitor parameter", "input test", "output test" and "auto-test". Since the input test and output test are not used by the end user, they are not introduced in this manual.