

Installation Instructions
for ALS Series Washing Label
Feeding Device

一、 General Installation Overview

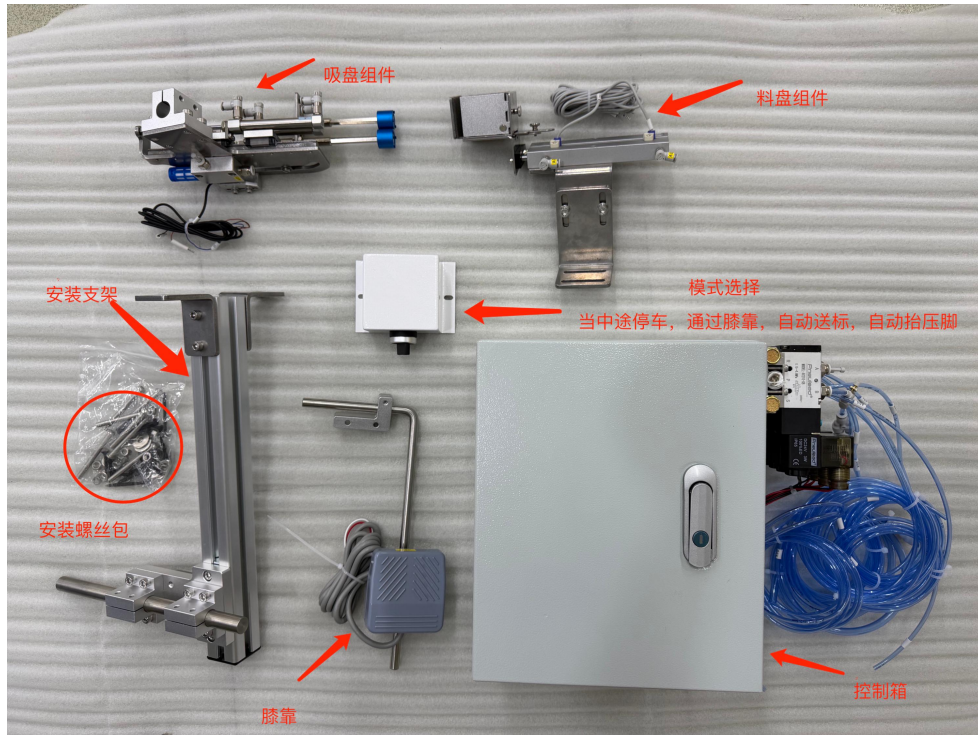
This manual is applicable to the on-site installation, fixing, wiring and commissioning of the special label (care label) feeding device for sewing equipment. It standardizes the installation process to ensure firm installation, accurate positioning and stable operation of the device, meeting the automatic label feeding requirements for various fabrics. The device is matched with sewing machine heads, with functions of automatic label feeding, knee control start-stop, mode switching and linkage presser foot lifting. All installation operations shall comply with equipment safety operation specifications and original factory technical standards.

二、 Pre-installation Preparation

2.1 Tools and Accessories Preparation

Prepare installation tools and original supporting accessories in advance. Tools include cross screwdriver, electric drill, drill bit, level ruler, tape measure, wrench, insulating tape, cable tie, etc.

Supporting accessories include the equipment mounting bracket, tray assembly, suction cup assembly, control box, knee-dependent switch, mode knob switch, signal connecting cable (lifting foot control cable), and installation screw kit. Upon unboxing, inspect each component to ensure no missing or damaged parts and that specifications match. Check all accessories after unpacking to ensure no loss, no damage and consistent specifications.

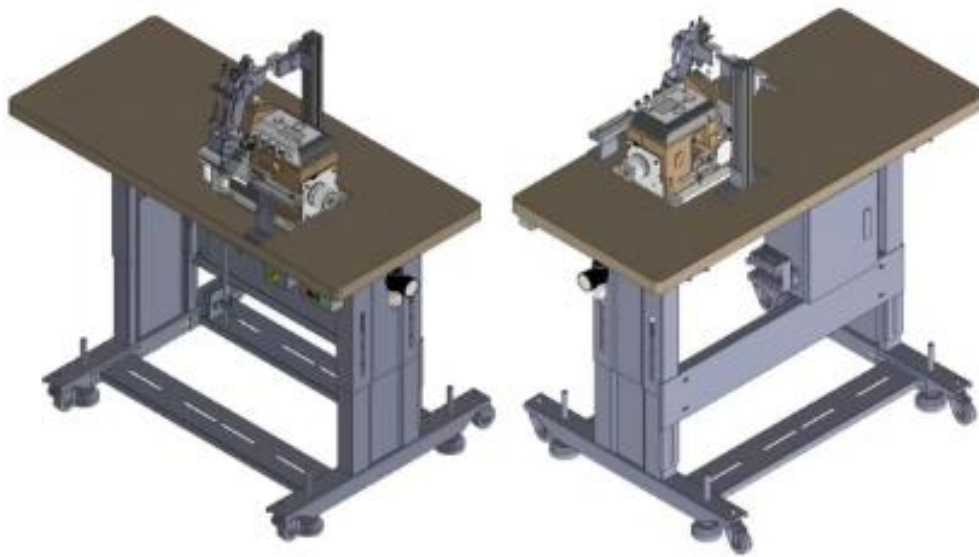


2.2 On-site Environment Inspection

Clean the operating area of the sewing equipment, ensure that the installation position behind the machine head and under the table board is free of sundries and has a flat and firm base. Avoid high-frequency vibration areas of the equipment, reserve sufficient space for installation, commissioning and later maintenance, and ensure no interference between the installation position and equipment operating parts.

三、 Detailed Installation Steps

Preliminary Structure Diagram



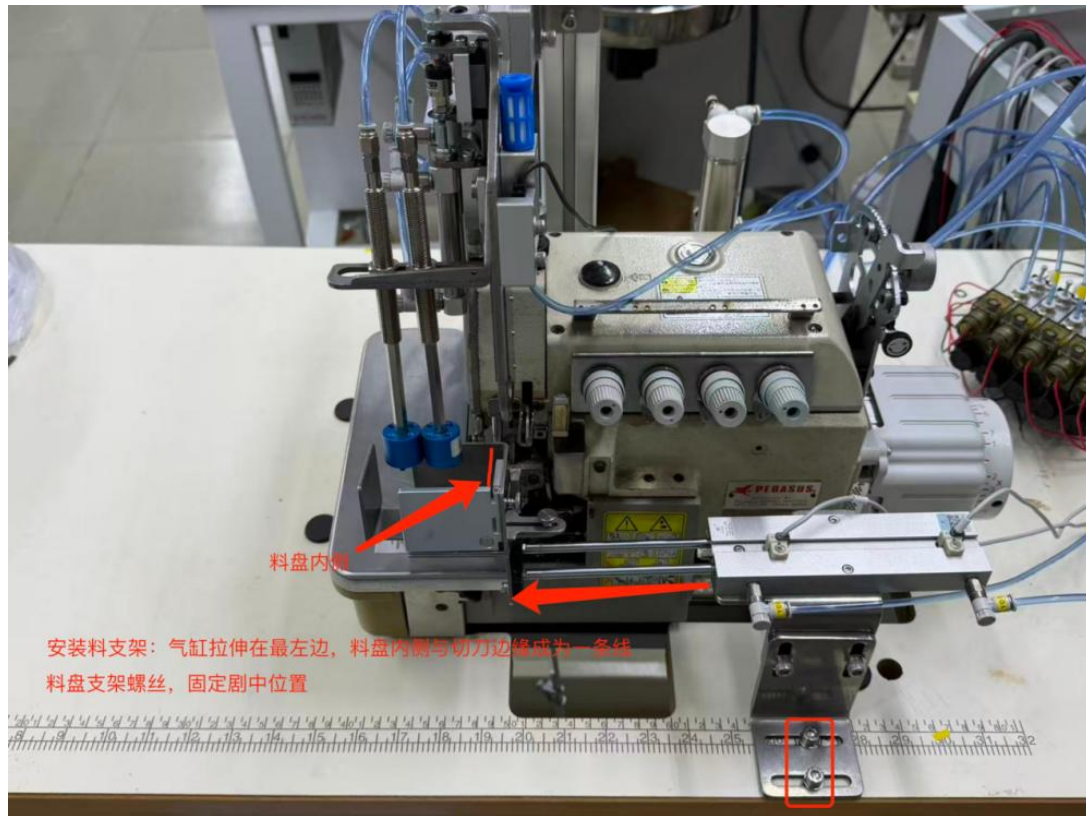
3.1 Control Box Installation

Take out 4 wood screws from the accessory box. The standard mounting position is behind the sewing machine head and under the table board. Fit the control box closely to the mounting surface, adjust the level, and fasten it evenly with the supplied wood screws to ensure firm installation without shaking or displacement.



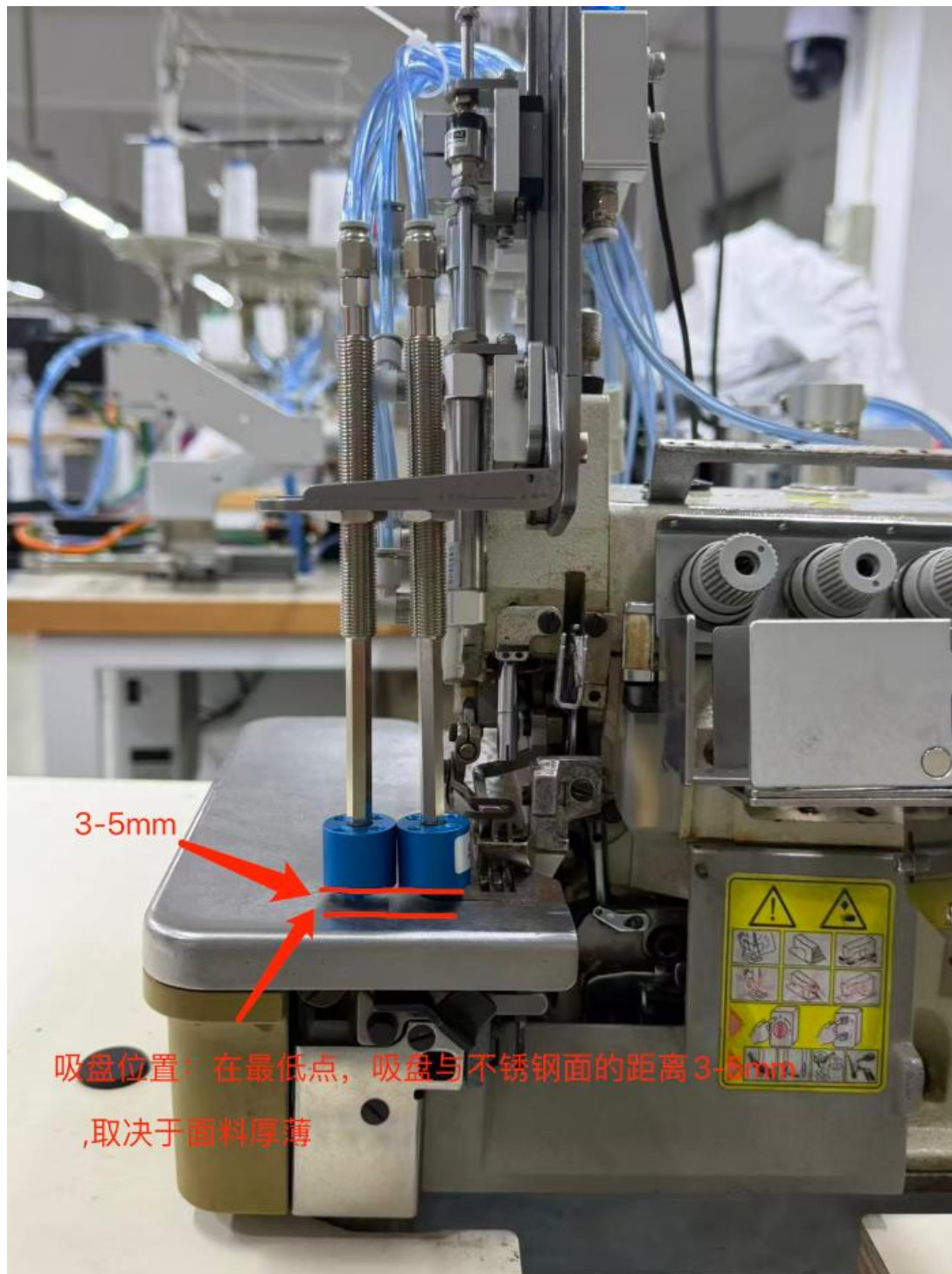
3.2 Material Tray Bracket Installation

Extend the cylinder fully to the left limit position. Adjust the material tray so that its inner edge is aligned straight with the cutter edge. Fasten the tray bracket screws at the center reference position. After installation, confirm the tray rotates smoothly without offset or jamming.



3.3 Suction Cup Height Adjustment

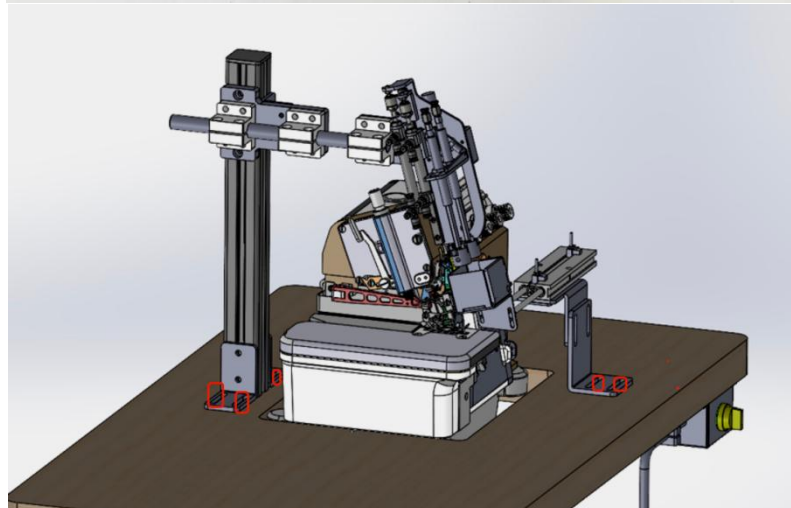
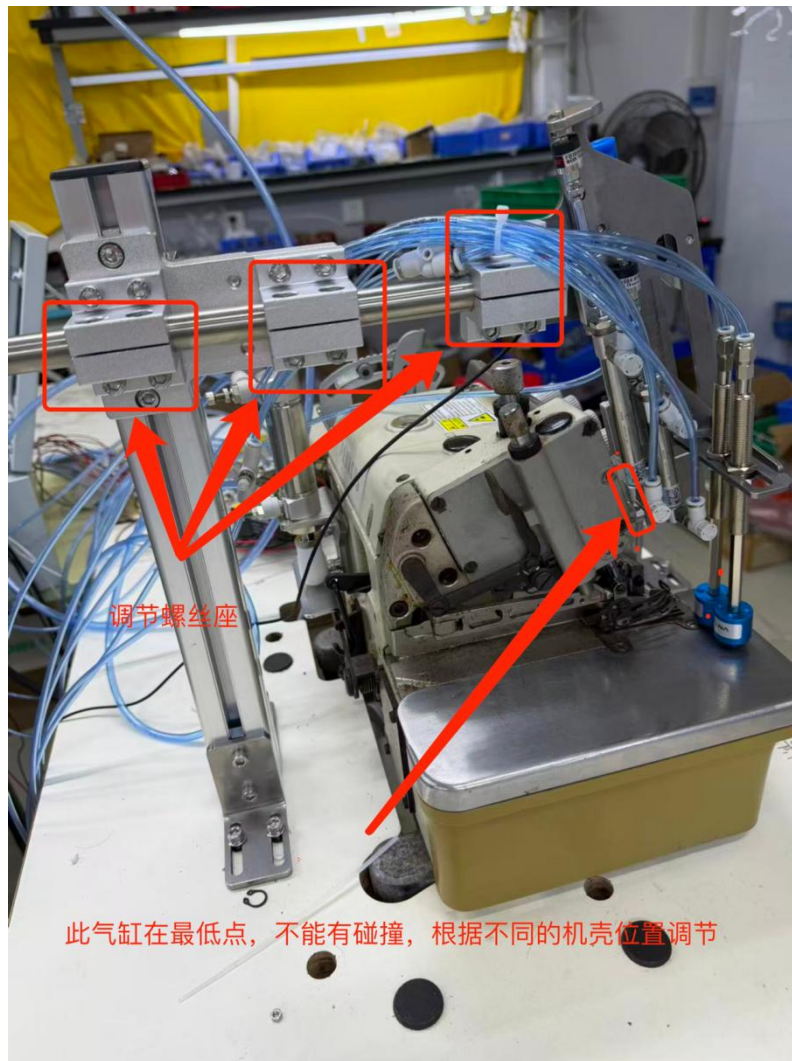
Move the suction cup to its lowest stroke position. Adjust the gap between the suction cup and the stainless steel tabletop to **3–5 mm**. This height can be fine-tuned according to fabric thickness: smaller gap for thin fabrics and slightly larger gap for thick fabrics to ensure stable label adsorption and feeding.



3.4 Cylinder Angle & Frame Collision Avoidance

According to different head housing structures, check the cylinder at the lowest stroke to ensure no collision or interference with the machine housing. Adjust the overall mounting angle via the movable screw seat for perfect clearance. Drill 6 mounting holes at the marked red positions and fasten with

the supplied screws.

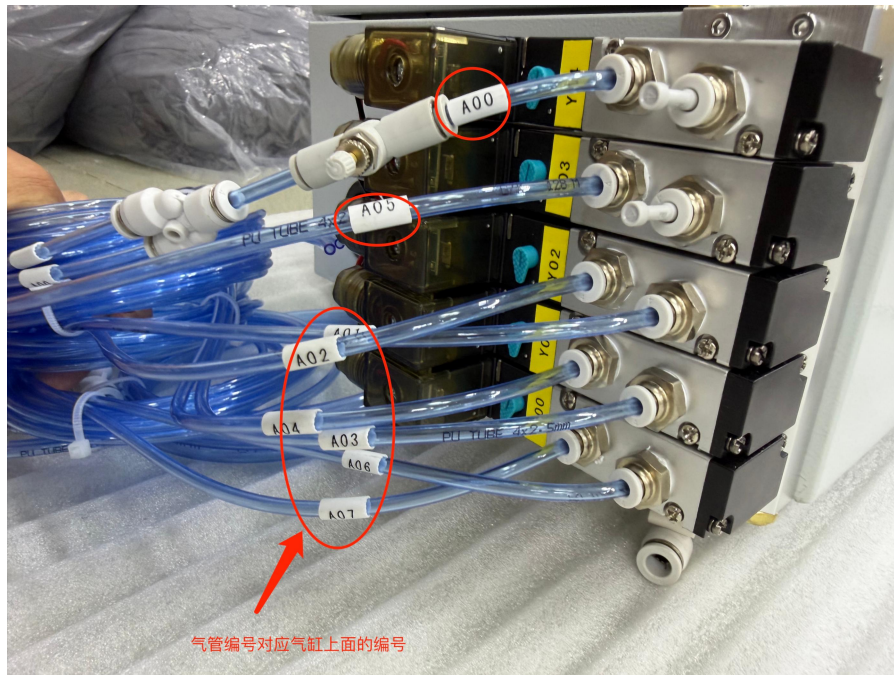


3.5 Wiring for Presser Foot Lifting

Graphic Cable Marking Explanation

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First picture (solenoid valve bank): Transparent PU air tubes are marked with white serial labels (A00, A01, A02, A03, A04, A05, A06, A07). Each tube connects to an independent output port of the solenoid valve.



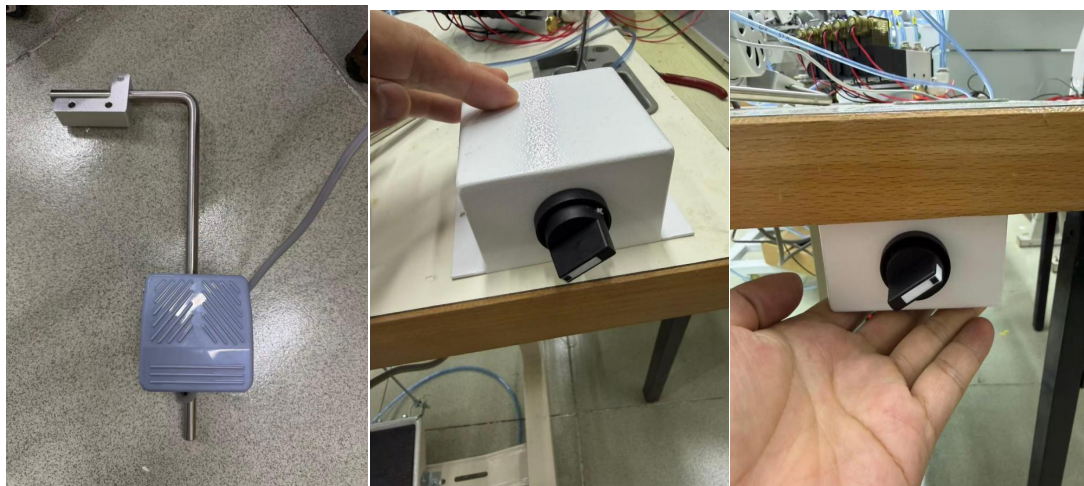
Second picture (cylinder actuator assembly): Yellow serial labels are attached to the air inlet fittings of cylinders, and the codes fully match the labels on air tubes from the valve bank.



Matching Rule: The serial number on each air tube must align with the identical number on the cylinder fitting. Crossed or mismatched connection will cause abnormal label feeding and suction cup adsorption.

3.7 Knee Switch & Mode Knob Installation

The knee switch is used for auxiliary label feeding during sewing, enabling knee-triggered label output. It can be installed above or below the table board according to operating habits. The side knob is a mode switch for two working logics: **label feeding with presser foot lifting** or **label feeding without presser foot lifting**, which can be selected according to actual production requirements.



四、 Post-installation Commissioning & Acceptance

4.1 Structural Inspection

All brackets, trays, suction cups and cylinders are firmly fixed without looseness or offset. The cylinder runs smoothly without collision or interference. All screws are fully tightened, and wiring is tidy and well-insulated.

4.2 Functional Test

Power on and test all functions: smooth tray feeding, normal suction cup adsorption, sensitive cylinder movement; valid knee switch trigger and stable mode switching; accurate presser foot linkage response without jamming or misoperation.

4.3 No-load Trial Operation

Perform 10–15 minutes of continuous no-load operation. The installation is qualified if label feeding is stable without deviation or jamming, mechanical movements are coordinated, and no abnormal noise or vibration occurs.

五、 Installation & Operation Precautions

1. Always power off the equipment before installation, drilling and wiring to avoid electric shock and circuit burnout.
2. Apply even and moderate force during drilling and screwing to prevent damage to machine housing, sheet metal and plastic parts.
3. Wire strictly according to terminal definitions; wrong or reverse connection is forbidden to prevent signal errors and equipment damage.
4. Ensure zero mechanical interference at the cylinder lowest stroke to avoid operational collision faults.
5. Switch modes only when the machine is stopped; mode switching during operation is prohibited.
6. Unauthorized structural modification or wiring alteration is forbidden and not covered by warranty.
7. Always follow sewing equipment safety specifications during on-site operation.

六、 Daily Maintenance

Regularly clean thread scraps, dust and sundries on suction cups and trays

to ensure smooth adsorption and feeding. Check all fastening screws weekly. Maintain aging or loose wires and inspect terminal insulation regularly. Perform a full-function linkage test monthly to eliminate hidden troubles such as jamming and slow response, ensuring long-term stable operation.