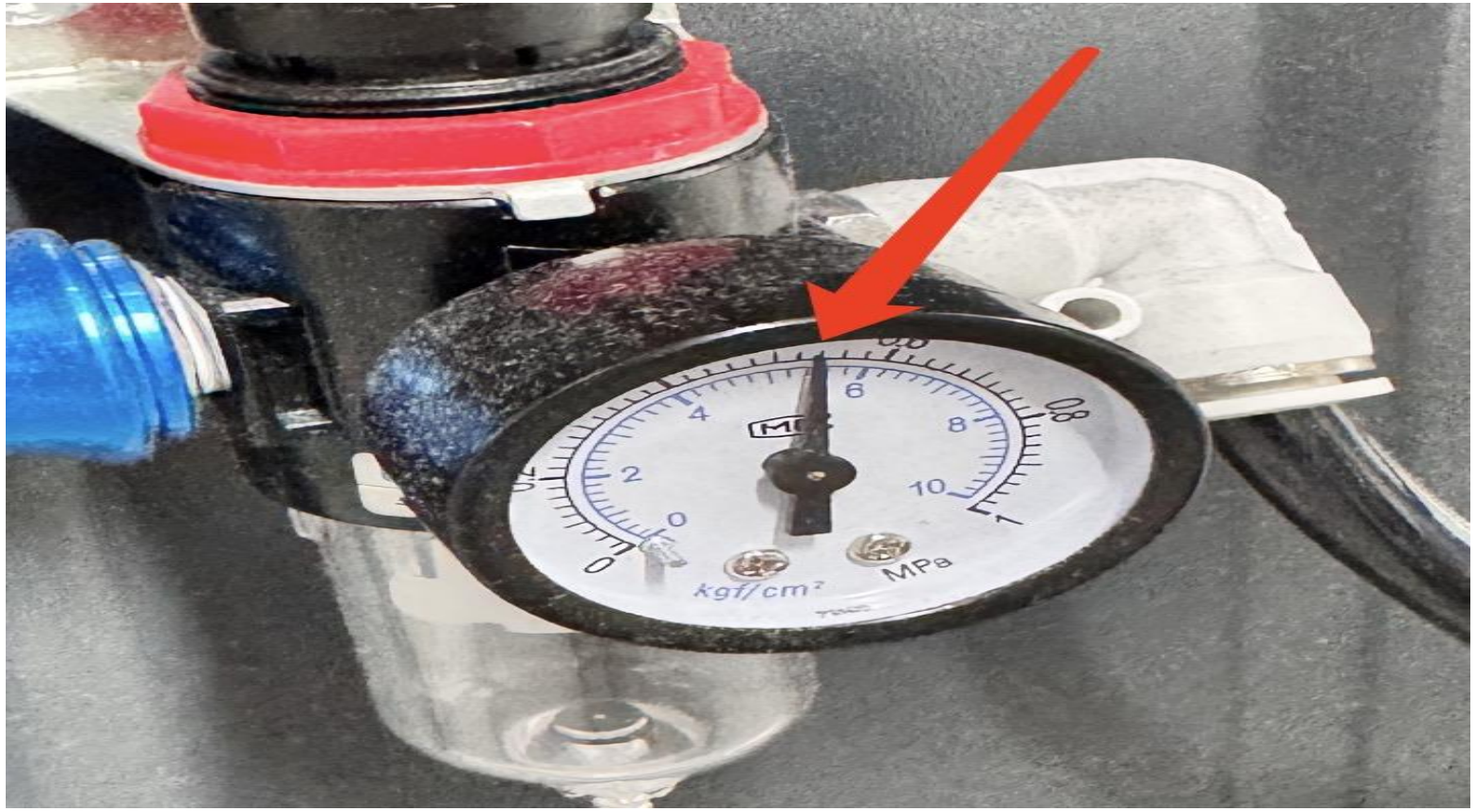
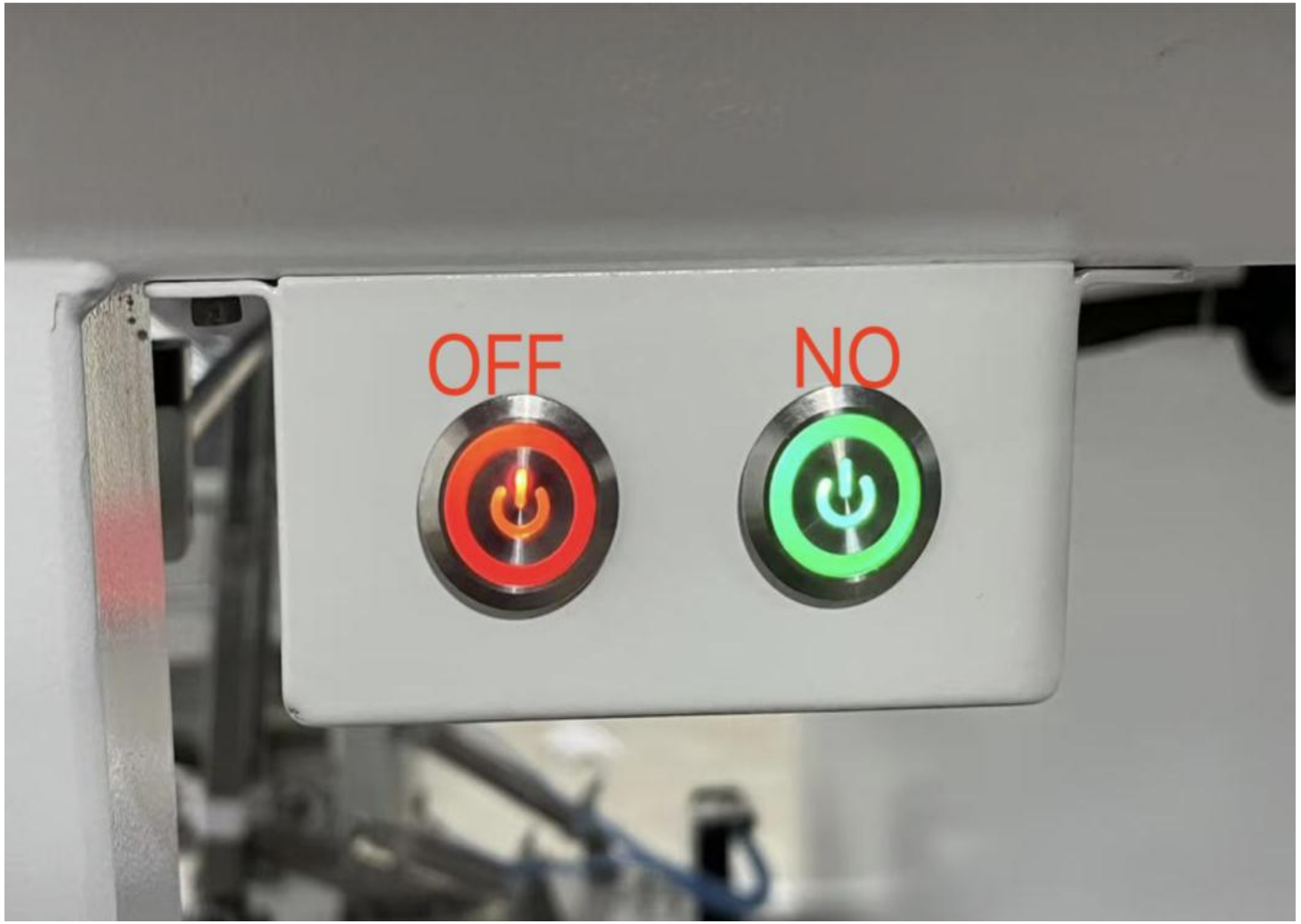
# Document

一、Before starting up, check the air pressure first. It is recommended to be above 0.5 pa.



# 三、Turn on the power switch and enter the main interface.



# 三、Click the reset button at the center of the screen.



# 四、Click  to enter the sewing button



# 五、 Based on the sample clothes, please confirm the following steps first

- 1.Manually set the reference value for the expansion of the tension fabric weight
  When changing to different fabrics, it is necessary to check first to avoid the situation where the clothes do not expand properly (become loose) or expand too much causing the clothes to stretch and deform (become larger in size).。
  On the main control interface, click on 

to enter the fabric tension setting interface. Select the tension button 1 and input the value 2 for modification. Then, press  to save the settings.



- 2.Set the hemming width according to the sample garment, and set it in the screen buttons.



- 3.According to the stitch spacing requirements of the sample garment,

First, set the parameter value of the machine handwheel to 2.5. Then, input the needle spacing of the screen on the screen. The larger the screen needle spacing number, the longer the needle spacing; the smaller the number, the shorter the needle spacing. When changing the screen needle spacing parameter, it is generally necessary to match it with the handwheel parameter. The specific value depends on the fabric.



- 4.On the main interface, press  to enter, set the program number and model number, and then press  to save key. The new pattern is successfully created.






## 5.Setting of material placement size







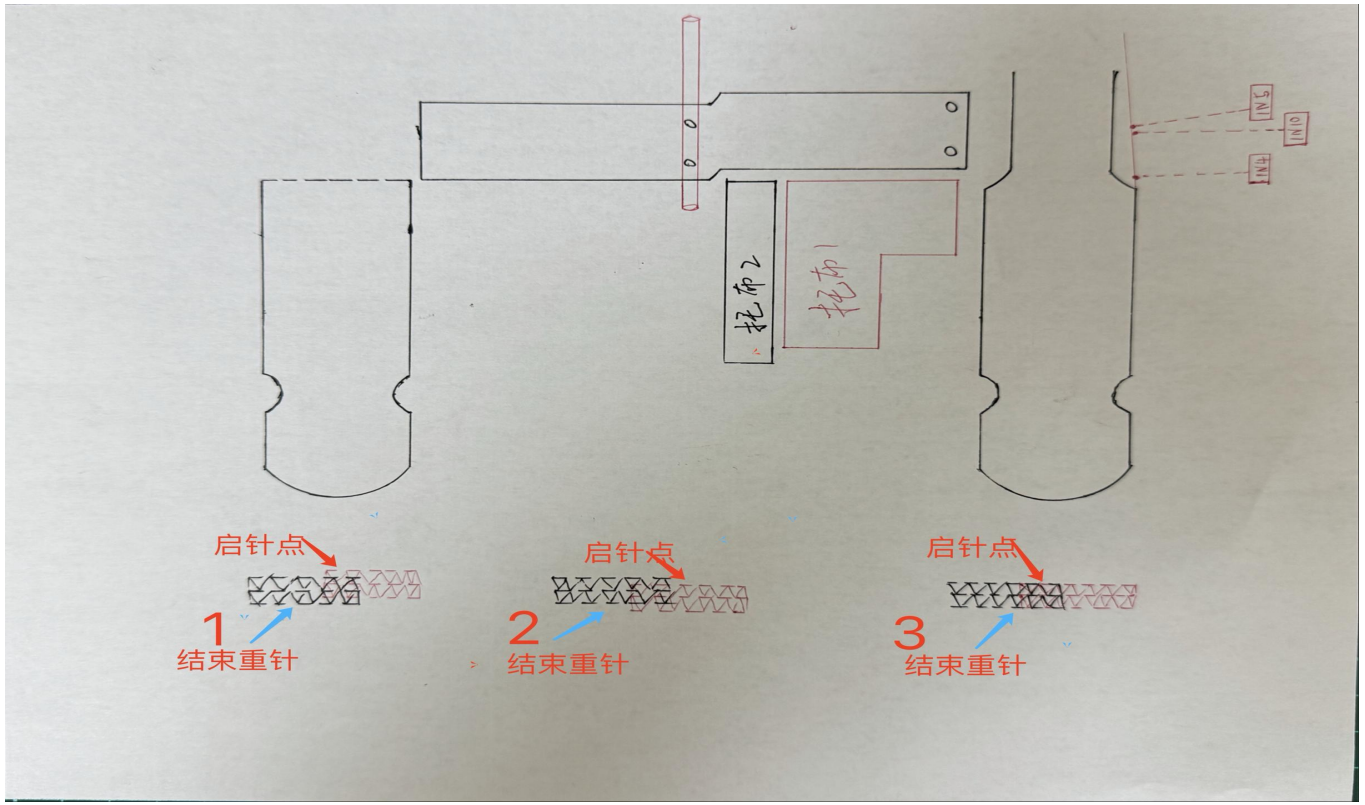
On the main control interface, click "Width Mode" to enter the fabric tension mode setting interface. Then press  to access the setting and editing for each size.

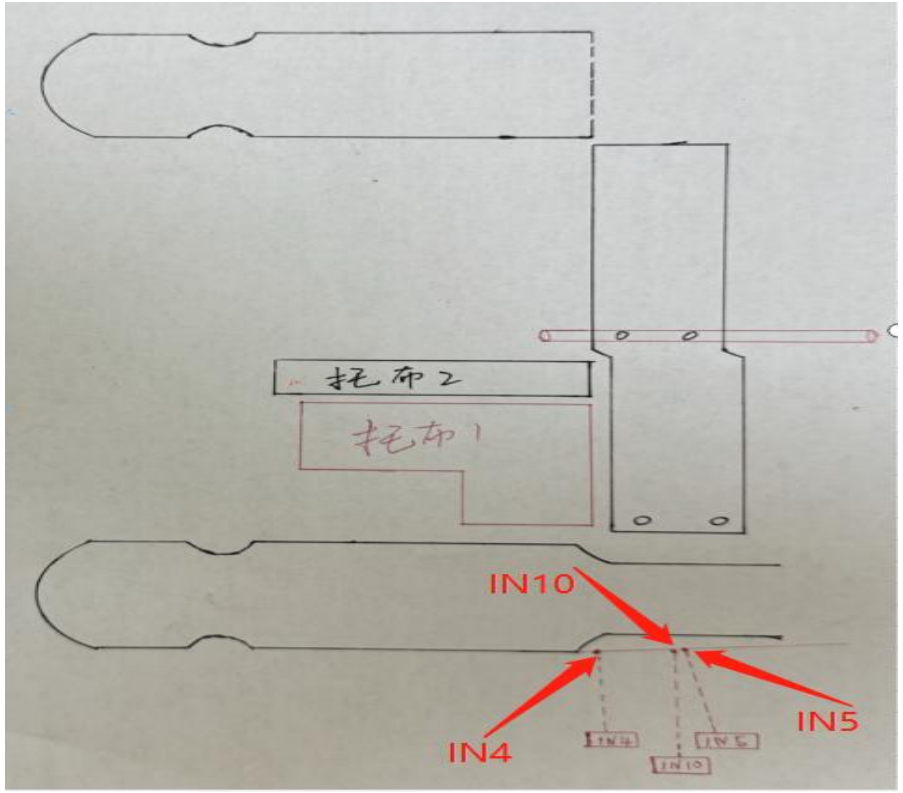





# 六、Regarding several different patterns for ending the use of heavy needles

- 1.The following is the fault analysis shown in Figure 1: The synchronization speed of the nose of the machine is faster than that of the left and right wheels.

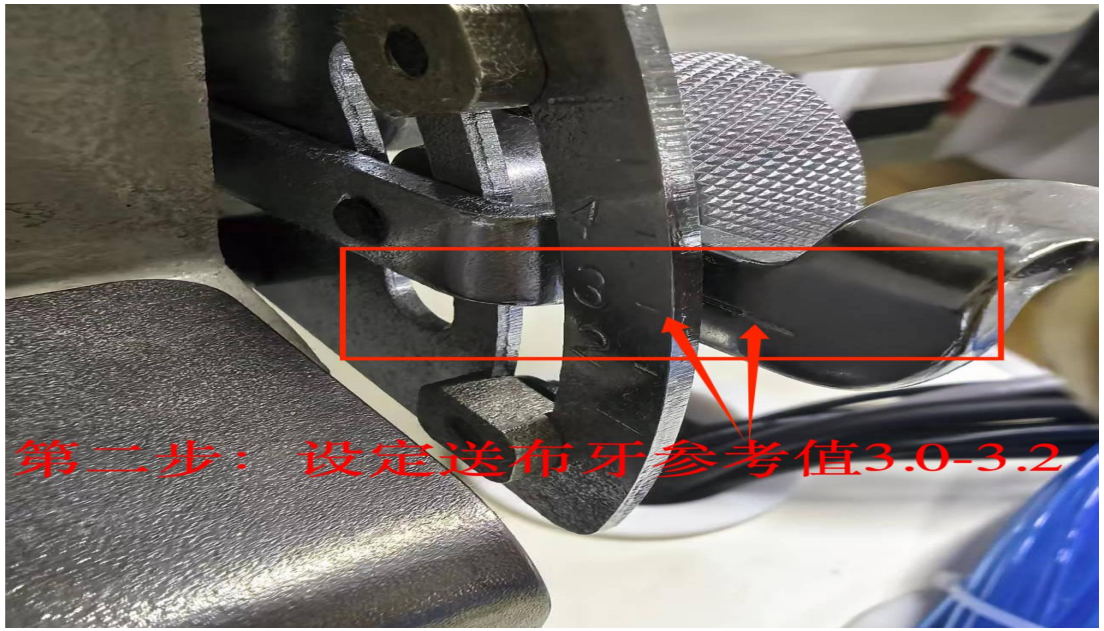


Step 1: Adjust the mechanical pitch of the handwheel to the reference value of 3.0.




Step 2: Set the reference value for the toothbrushing pressure as 3.0 - 3.2.



Step 3: Select the head synchronization pitch and the left and right wheel synchronization pitch mode and proceed to the screen as shown in the figure on the right.

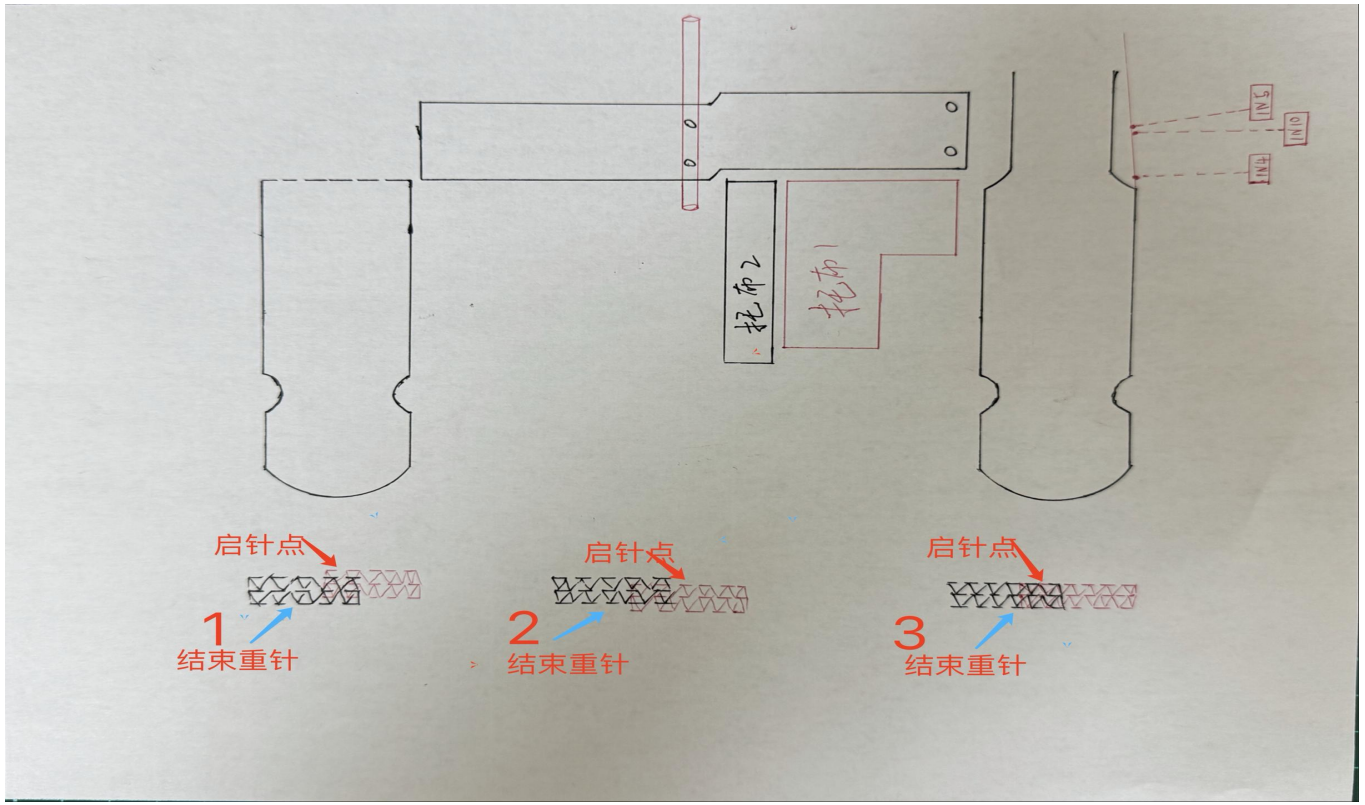


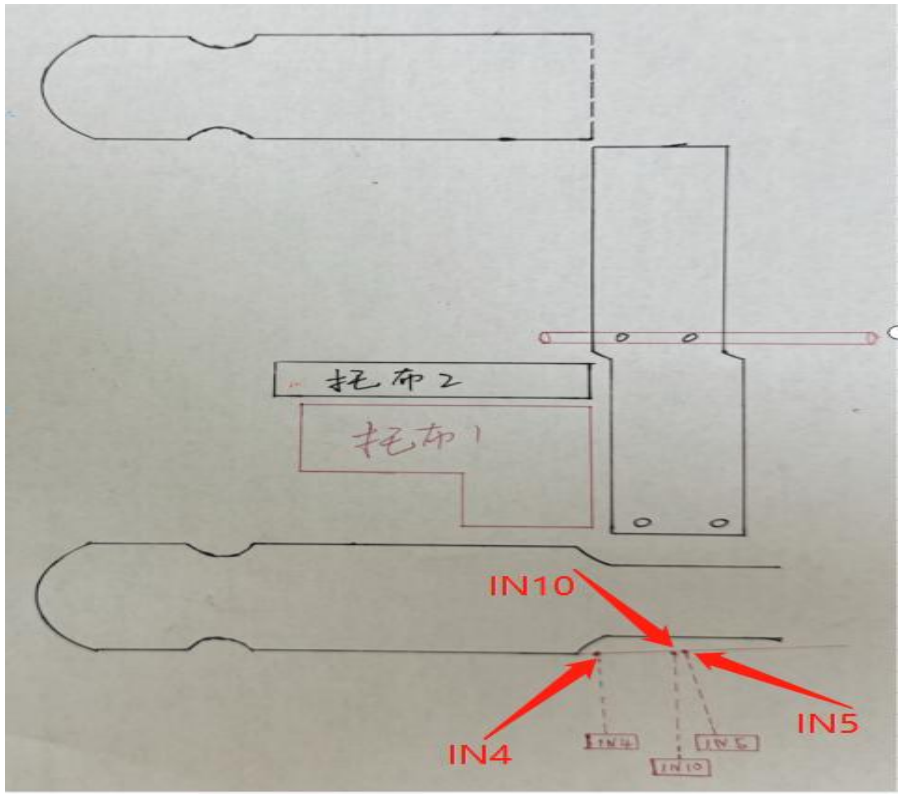

Step 4: Reduce the original needle spacing and speed values of the machine head. The smaller the values, the slower the speed of the machine head compared to the speeds of the left and right synchronous wheels.



# 六、Regarding several different patterns for ending the use of heavy needles

- 2. The following is the fault analysis as shown in Figure 2: The synchronization speed of the nose of the machine is (slower) than that of the left and right wheels.

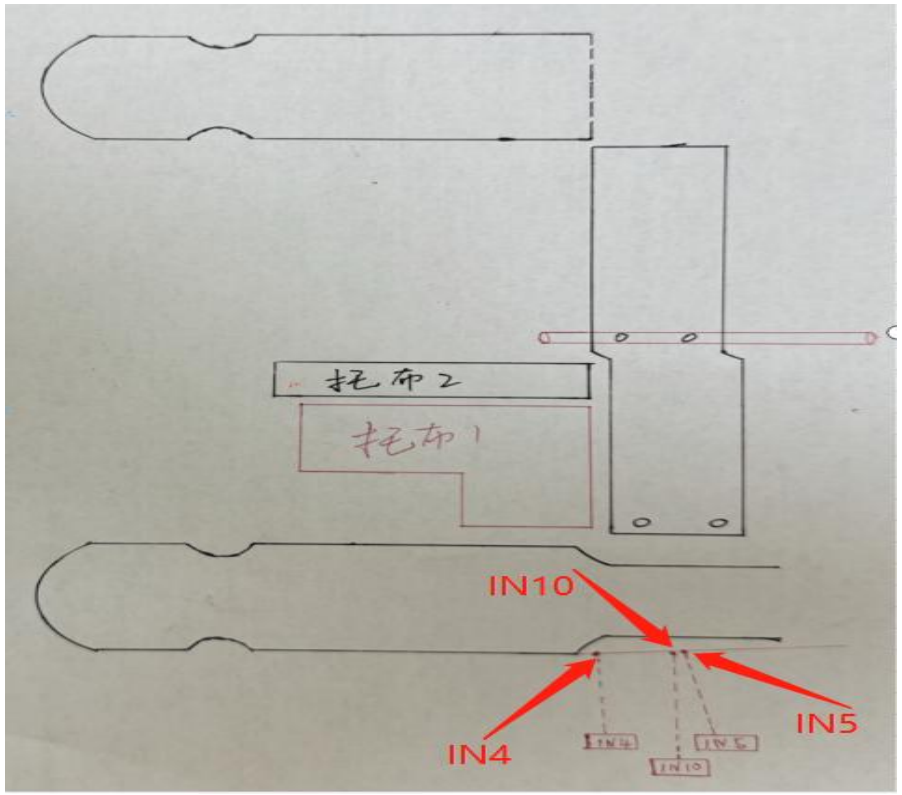


# Regarding several different patterns for ending the use of heavy needles

- 3. The needle spacing at the machine head is synchronized with that of the computer (correct)

| | |
|---|---|
| **IN4:单双层切换点（结束双层感应器）** | 参考功能 |
| IN5:单层布边感应器（取决于切刀废料） | |
| IN10:单双层转换 | |



# VII. Regarding Starting Needling and Repeated Needling

