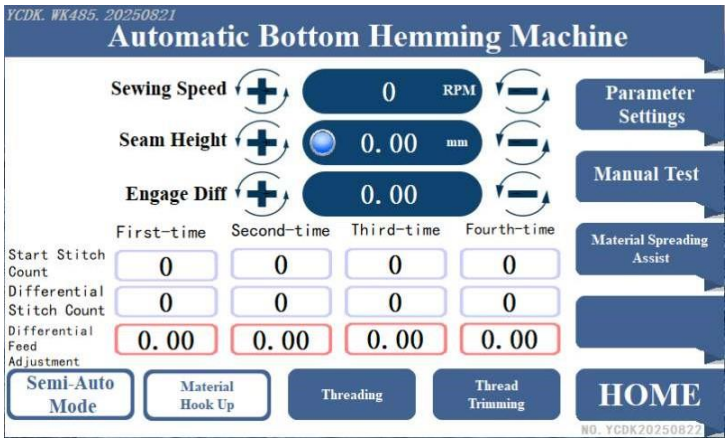
Main Screen Operation

English screen



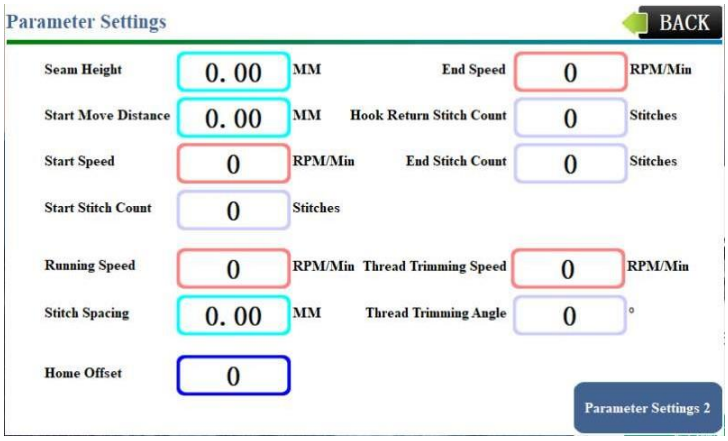
Sewing settings	
Sewing Speed	Sewing machine speed in revolutions per minute (RPM).
Seam Height	First find the reference point on the seam sensor. Then fine-tune its sensing height (mm) on screen for the material thickness.
Engage Diff	Range 1.00–9.99. The lower puller roller always runs 1:1 with the main shaft motor. At 1.00 both rollers run together. At 1.30 the upper roller runs 30% faster. It can match or exceed the motor speed.

Seam crossings and stitch counts	
Number of bone assessments	Tap the seam-count button on the right to select one to four crossings. Fill in all three settings below for each selected column, starting from the left.
Start Stitch Count	The stitch at which this column's feed ratio takes effect. For example, 10 means start on stitch 10.
Differential Stitch Count	How many consecutive stitches use the ratio. A setting of 10 applies it for 10 stitches, including the starting stitch.
Differential Feed Adjustment	Range 0.01–2.00. Compared with the main shaft motor, the upper roller runs 20% slower at 0.80, at the same speed at 1.00, and 20% faster at 1.20.

Controls and navigation	
Semi-Auto Mode	Tap Semi-Auto Mode to switch to full auto. Press the pedal twice to start sewing in semi-auto, or once in full auto.
Material Hook Up	Once the hem is in place, the reverse-pull folder retracts. With this button selected, its cylinder also lifts. With it off, the folder only retracts.
Threading	Tap after a thread break or when rethreading. The presser foot lowers for threading.
Thread Trimming	Tap once to run one complete thread-trimming cycle.
Material Spreading Assist	When selected, both spreading rods are active. When off, only one rod is active.
Page Entry Point	Tap Parameter Settings, Manual Test or HOME to open the corresponding screen.

Parameter Settings 1

English screen

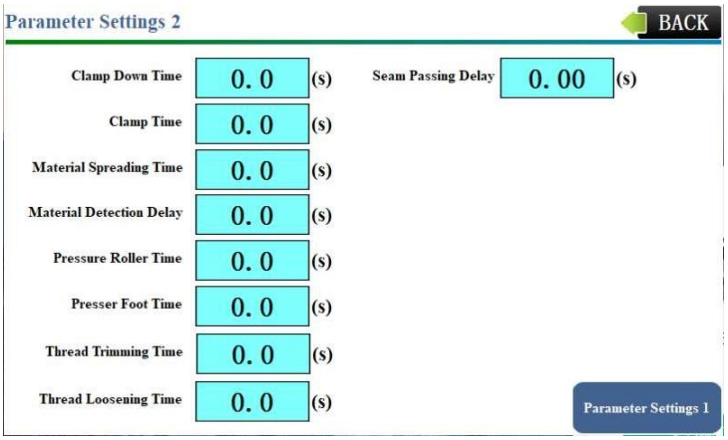


Seam detection and start position	
Seam Height	Linked to Seam Height on the main screen. Find the reference point on the seam sensor, then fine-tune the height (mm) for the hem thickness. Changing either screen updates both.
Start Move Distance	After loading the hem, this is the distance it travels from seam detection to the first stitch. For example, at 5 mm, sewing starts after a further 5 mm of travel.

Starting and sewing	
Start Speed	Sets the speed (RPM) for the first stitches. Use with Start Stitch Count.
Start Stitch Count	Sets how many stitches use the start speed. With 5 stitches and a start speed of 600 RPM, the first 5 stitches are sewn at 600 RPM.
Running Speed	The sewing speed in RPM. This is the same setting as Sewing Speed on the main screen. Changing it on either screen updates both.
Stitch Spacing	Stitch length in millimeters, measured between two consecutive needle penetration points.
Unhooking and Finishing Up	
Hook Return Stitch count	After the sensor detects the last seam, the machine sews this many more stitches before retracting the hook.
End Speed	Sets the sewing speed (RPM) for the final stitches. Use with End Stitch Count.
End Stitch Count	Sets how many final stitches use the end speed. At 5, the last 5 stitches are sewn at that speed.
Home Offset	Adjusts the needle bar's stop position when sewing ends.
Thread trimming adjustments	
Thread Trimming Speed	If the thread is not cut, check the trimming speed and angle. Trimming speed sets how fast the main shaft turns during trimming (RPM).
Thread Trimming Angle	One full turn of the main shaft is 360°. This setting selects the shaft angle at which the trimming cylinder starts to move.

Parameter Settings 2

English screen

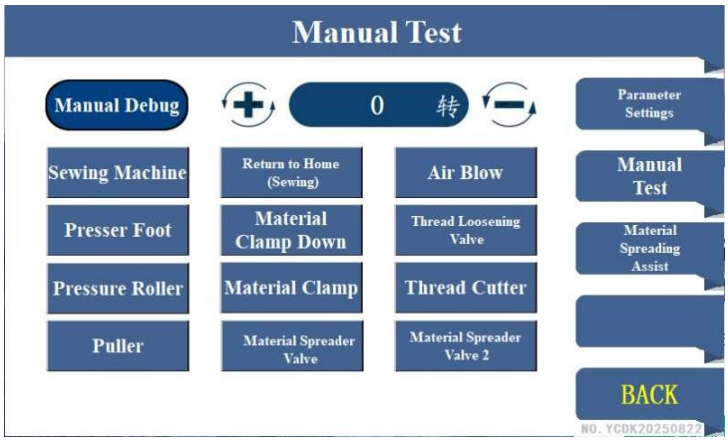


Clamping and spreading	
Clamp Down Time	How long the clamp-down cylinder stays in its lowered position.
Clamp Time	How long the clamp cylinder holds the material after clamping it, before the next step begins.
Material Spreading time	In full-auto mode, once the spreading step begins, the machine holds the material spread for the set time before moving to the next step.
Detection and seam passing	
Clamp Down Time	How long the clamp-down cylinder stays in its lowered position.
Clamp Time	How long the clamp cylinder holds the material after clamping it, before the next step begins.
Pressure roller and presser foot	
Pressure Roller Time	In full-auto mode, how long the pressure roller stays pressed down before the next step begins.
Presser Foot Time	How long the presser foot stays down. This setting is currently unused.
Thread trimming and release	
Thread Trimming Time	How long the controller energizes the trimming solenoid valve. Generally, use at least 0.2 s. A shorter signal may end before the valve responds. A slightly longer signal can improve reliability.
Thread Loosening Time	How long the thread-release cylinder keeps the thread tension released.

*****All times on this screen are in seconds (s).

Manual Test

English screen



Enable manual testing	
Manual Debug	Turn on Manual Debug at the upper left. Then tap one test button at a time and observe the corresponding cylinder, motor or mechanism.
Test buttons and checks	
Sewing Machine	Check that the main shaft motor turns.
Return to Home (Sewing)	Tap once. Check that the sewing machine completes one full homing cycle.
Air Blow	Check that the air-blow cylinder operates and air flows from the outlet.
Presser Foot	Check that the presser-foot cylinder operates and the presser foot moves as expected.
Material Clamp Down	Check that the clamp-down cylinder lowers the material clamp.
Thread Loosening Valve	Check that the thread-release cylinder operates and releases thread tension.
Pressure Roller	Check that the pressure-roller cylinder operates and the roller lowers.
Material Clamp	Check that the clamp cylinder actuates the material clamp.
Thread Cutter	Check that the trimming cylinder operates and the cutter makes a cutting stroke.
Puller	Check that the puller roller runs as expected.
Material Spreader Valve	Check that the spreading mechanism connected to valve 1 operates.
Material Spreader Valve 2	Check that the spreading mechanism connected to valve 2 operates.
Assess the result	
Method of determination	The test passes if the selected mechanism responds as expected. No response, incorrect movement or movement by a different mechanism indicates a fault.