

A5E 电脑高速平缝机系列

JACK 杰克

快速服务 100%

产品使用说明书

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杰克缝纫机

JACK SEWING MACHINE

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杰克缝纫机股份有限公司

JACK SEWING MACHINE CO.,LTD.

• 公司地址 (Address of Company) :

中国浙江省台州市椒江区三甲东海大道东段 1008 号

NO.1008 , DONGHAI AVENUE EAST, JIAOJIANG DISTRICT,TAIZHOU CITY, ZHEJIANG

邮编: 318000

• 国内销售部 (Domestic Trade Department) :

电话 (TEL) : 0086-0576-881177788 88177789

传真 (FAX) : 0086-0576-881177758

• 国贸销售部 (International Trade Department) :

电话 (TEL) : 0086-0576-881177782 88177774

传真 (FAX) : 0086-0576-881177787

• 免费售后服务电话: 400-8876858

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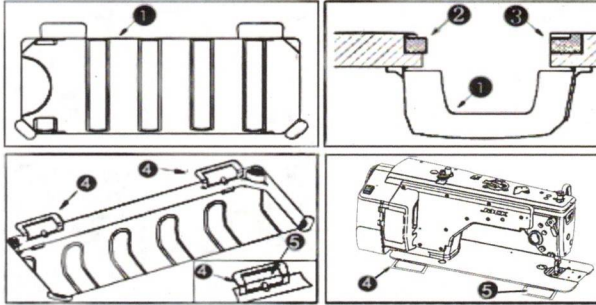
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1.规格/SPECIFICATIONS

用途	一般布料、薄料、中厚料	中厚料、厚料
缝纫速度	最高 5,000rpm	最高 3,500rpm
最大针脚长度	5mm	
机针	DBx1 #9~#18 (14#)	DPx5 #20
压脚高度 (自动抬压脚)	9mm (标准) 12mm (最大)	9mm (标准)
使用机油	New Defrix Oil NO.10 机油	

Application	General fabrica,light-weight and medium-weight materials	Medium-weight Heavy-weight
Sewing speed	Max. 5,000rpm	Max. 3,500rpm
Max.Stitch length	5mm	
Needle	DBx1 #9~#18 (14#)	DPx5 #20
Presser foot lift	9mm (standard) ;12mm (Max.)	9mm (standard)
Lubricating oil	New Defrix Oil NO.10	

2.缝纫机的安装/INSTALLATION



(1) 油盘托盘安装

- 1) 将油盘托盘 ① 安装在台板背面。
- 2) 将机头支架 ②、机头座垫 ③ 分别安装在台板上。如图所示, 安装时确保两架 ② 朝向操作者一边, 两个将机头座垫 ③ 是在有机头连接钩 ⑤ 的那一侧。
- 3) 先将机头连接钩座 ④ 安装在台板上, 再将机头连接钩 ⑤ 放入底板孔内, 最后将机头连接钩 ⑤ 要与台板上的机头连接钩座 ④ 相嵌合。

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使用说明书
Operation Manual

开车前的注意事项:

BEFORE OPERATION :

- 1.油盘内未加油绝不能开车。
- 2.机器运转时, 从手轮外侧看转向应为逆时针方向。注意, 不能倒转。
- 3.确认电控标识上的电压及相位是否正确。
- 1.Never operate the machine unless its oil reservoir has been filled with oil.
- 2.After setting up the machine,check the direction of motor rotation.To check it,turn the hand wheel by,hand to bring the needle down,and turn the power switch ON while observing the hand wheel.(The hand-wheel should turn counterclockwise as observed from the hand wheel side)
- 3.Confirm that the voltage and phase(single or 3-phase)are correct by checking them against the ratings shown on the electronic identification.

使用注意事项:

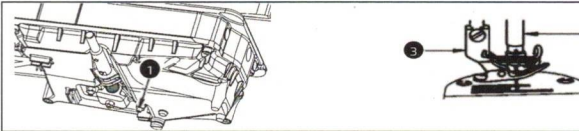
OPERATION PRECAUTIONS:

- 1.接通电源开关或机器运转时, 请误将手放到针的下部。
- 2.机器运转时, 请勿将手指伸入挑线杆护罩内。
- 3.机头翻倒时, 一定要切断电机开关。
- 4.操作者离开机器时, 必须切断电源。
- 5.机器运转期间, 注意不允许任何人的头或手以及任何东西靠近绕线轮和手轮。
- 6.装拆防护罩, 或者其他保护装置时, 请勿开动机器。
- 7.不要用香蕉水等油漆稀释剂擦洗机头表面。
1. Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
2. Do not put your finger into the thread take-up cover while the machine is operating.
3. Be sure to turn the power switch OFF before tilting the machine head.
4. When an operator leaves from the machine ,make sure to turn off the power.
5. During operation,be careful not to allow your or any other person's head or hands to come close to the bobbin winder or hand wheel.Also,do not piece anything close to them.Doing so may be dangerous.
- 6.If your machine is provided with a finger guard or any other protectors,do not operate your machine with any of them removed.
- 7.Don't clean the face of machine head with thinner

(1)The installation of plastic reservoir

- 1)Install the plastic reservoir ① under the stand & table.
- 2)Put the machine holder ① and the machine cushion ② on the stand & table, making sure that the machine holders ① are pointing towards the operator during the installation and the two machine cushion ② are which is with machine head connecting hook ⑤.
- 3)Install the machine head connecting hook base ④ on the stand & table, making sure machine head connecting hook ⑤ is nestled in the baseplate hole,at last,put the machine head connecting hook base ④ which is on the stand & table.

3.膝动提升高度的调整/ADJUSTING THE HEIGHT OF THE KNEE LIFTER



- 1) 膝动提升的标准高度为 10mm。
- 2) 调节膝动提升调节螺丝 ① 可以把压脚高度最大调整到 13mm。
- 3) 压脚提升到 10mm 以上时, 请注意针杆 ② 的前端下降到底部, 不能碰到压脚。
- 1) The standard height of the presser foot lifted using the knee lifter is 10mm.
- 2) You can adjust the presser foot lifted up to 13mm using knee lifter adjust screw ①.
- 3) When you have adjusted the presser foot lift to over 10mm,be sure that the needle bar ② in its lowest position does not hit presser foot ③.

4.加油与油量调节/LUBRICATION&FUEL CONTROL

运转缝纫机之前, 请注入 375mL New Defrix

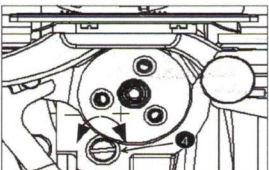
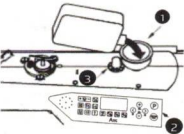
1) 请保持缝纫机为开机状态, 取下机臂上部加油斗 ① 进行加油。

2) 加油量请从机器操作面板 ② 上进行观察。当油盒内机油不够正常运行时, 操作面板 ② 上会有加油提示灯亮起, 并有半小时一次的警示音提醒加油。此情况持续运行一段时间, 之后机器进入锁定保护状态, 到最少油量以上后, 加油图标熄灭, 此时允许继续运行, 请适当加油, 注意最低位 ⑤ (红线) 最高位 ⑥ (绿线) 有可能出现漏油现象, 请加以注意。

3) 加油后运转, 如果润滑正常, 可通过视窗 ⑦ 观察。

4) 油量调节螺钉 ④ 左旋, 旋梭油量减少; 右旋, 旋梭油量增加。

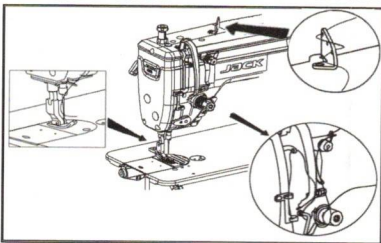
5) 新机使用 1 个月后再请更换机油, 后续每 6 个月更换一次。机油流动量的多少, 与油量的多少无关。



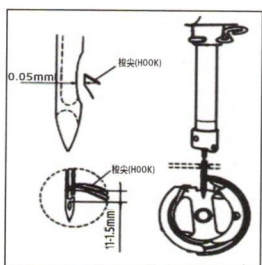
Before the machine operation, please inject 330mL New Defrix No.10 oil

- 1) Please keep the sewing machine open, take off the rubber plug on the upper arm, and use a funnel ① to add oil.
- 2) Please observe the oil amount on the operation panel ②.
when the machine oil cannot ensure the normal operation of the machine, the icon on the operation panel ② would twinkle to warn us to add oil. In this situation, the machine would operate for a period of time. After that, the machine would be locked and can not operate. Only when the oil is higher than the minimum quantity line, the warning icon will be off. And we can continue to oiling machine to the maximum oil line. And then the other icon on the operation panel ② would light up and send out warning tone to warn us that the oil is full and stop oiling.
- 3) Running the machine after adding oil, if it's normal of lubrication, we can see the oil flow through the window ③.
- 4) The oil quantity of rotating shuttle decreases when the oil quantity adjusting screw ④ is left-handed. The oil quantity of rotating shuttle increases when the oil quantity adjusting screw is turned right.
- 5) Replace the oil after 1 month of use the new machine and change oil every 6 months.
How much the flow oil is no relevant to how much oil.

5. 上线的穿线方法/THREADING THE MACHINE HEAD



6. 机针与旋梭的关系/NEEDLE-TO-HOOK RELATIONSHIP



(1) 针与旋梭的配合关系应如下:

- 1) 转动手轮, 使针杆位于最低点, 在旋梭针杆连接柱定位螺钉。
* 针杆高度的确定。
- 2) 拉动针杆, 水平透过内梭内边缘可看到针孔有 1/2 下露 (机针必须安装到位)。机针埋线槽朝左, 然后旋紧针杆连接柱螺钉。
* 旋梭位置的确定
- 3) 先将旋梭梭尖朝上, 转动手轮, 针杆从最低点回升时, 观察旋梭与机针配合关系。当旋梭梭尖位于机针孔边上端 1-1.5mm 时且梭尖平面距机针短槽平面 0.05mm 时 (保证梭尖位于机针的中心线部位), 旋紧旋梭螺钉。

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(1) Adjust the timing between the needle and the hook as follow:

- 1) Turn the hand wheel to bring the needle bar down to the lowest point of its stroke, and loosen setscrew.
- * Adjusting the needle bar height
- 2) Pull the needle bar, you can see the pinhole basset 1/2 level through edge of inside hook (needle must be position). Turn needle cover wire slot left, then tighten setscrew.
- * Adjusting position a of the hook
- 3) First move the point of hook in direction, when running strap pulley needle bar risen from the lowest, observe cooperate relation of the hook and needle. When hook point above Pinhole about top of 1mm to 1.5mm and when plane of the hook point form plane of needle short bar 0.05mm (keep the align hook blade point with the center of needle), tighten the hook setscrews.



注意

若间隙太小, 会磨损梭尖, 若间隙太大, 则会引起跳针; 旋梭原来用的什么型号, 调换后, 也请使用原来的型号; 更换机针后注意机针必须安装到位且类型相同, 如不同类型机针须检查配合关系。

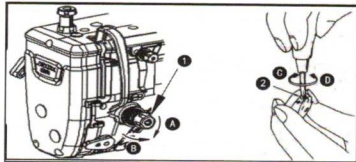


*Precaution

If the clearance is too small, the tip of the hook will be abraded. If it is too big, it will lead to skip over.

*Note that the type of hook to be substituted for, when replacing the hook. Shall be in conformity with the very type of the hook installed in the sewing machine of original assemblage. After replacing the needle, the needle must be same type and install right position. If the needle is different type, need check match with relation.

7. 缝线张力/THREAD TENSION



(1) Adjusting the needle thread tension

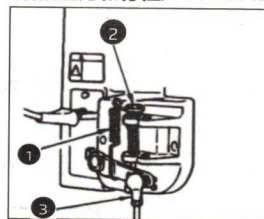
- 1) Adjust the needle thread tension using tension adjust nut ① according to the sewing specifications.
- 2) As you turn nut ① clockwise (in direction A), the needle thread tension will increase.
- 3) As you turn nut ① counterclockwise (in direction B), the tension will decrease.

(2) Adjusting the bobbin thread tension

- 1) As you turn tension adjust screw ② clockwise (in direction C), the bobbin thread tension will increase.
- 2) As you turn screw ② counterclockwise (in direction D), the bobbin thread tension will decrease.

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8. 踏板压力和行程/PEDAL PRESSURE AND PEDAL STROKE



(1) 踏板踩踏压力的调整

- 1) 更换脚踏弹簧 ① 的位置, 可调节压力。
- 2) 把弹簧挂到左侧之后, 压力变大。
- 3) 挂到右侧之后变重。

(2) 踏板回踩力的调整

- 1) 用踏板回踩压力调节弹簧 ②。
- 2) 拧进调节螺丝则压力变大。
- 3) 拧松调节螺丝则压力变小。

(3) 踏板踩踏行程的调整

- 1) 把连接器 ③ 插到右侧的孔里。

(1) Adjusting the pressure required to depress the front part of pedal

- 1) This pressure can be changed by changing the mounting position of pedal spring ①.
- 2) The pressure decreases when you hook the spring on the left side.
- 3) The pressure increases when you hook the spring on the right side.

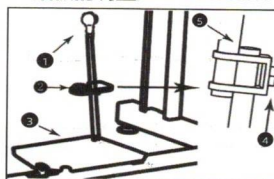
(2) Adjusting the pressure required to depress the back part of the pedal

- 1) This pressure can be adjusted using regulator screw ②.
- 2) The pressure increases as you turn the regulator screw in.
- 3) The pressure decreases as you turn the screw out.

(3) Adjusting the pedal stroke

- 1) The pedal stroke increases when you insert connecting rod ③ into the right hole.

9. 踏板的调整/ADJUSTMENT OF THE PEDAL



(1) 连接杆的安装

- 1) 向箭头方向移动踏板调节板 ②, 让连接杆球形头插入孔中。

(2) 踏板的角度

- 1) 调节连杆的长度就可以自由的改变踏板的倾斜。
- 2) 拧松调节螺丝 ④, 拉出插入连接杆 ⑤ 进行调整。

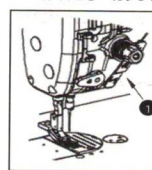
(1) Installing the connecting rod

- 1) Move pedal to the right or left as illustrated, so that spherical head and connecting rod are inserted into the hole.

(2) Adjusting the pedal angle

- 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
- 2) Loosen adjust screw, and adjust the length of the connecting rod.

10. 触键手动倒缝(盒式)/ONE-TOUCH TYPE REVERSE FEED SWITCH



(1) 使用方法

- 1) 按下开关按钮 ① 缝机立即倒缝。
- 2) 在按下的时间内进行倒缝。
- 3) 手一松开立即变为正向缝纫。

(1) How to operate

- 1) The moment switch button ① is pressed, the machine performs reverse feed stitching.
- 2) The machine performs reverse feed stitching as long as the switch lever is pressed.
- 3) The machine resumes normal feed stitching the moment the switch lever is released.

11. 挑线簧/THREAD TAKE UP SPRING

(1) 改变挑线簧 ① 的摆动量:

- 1) 旋松定位螺钉 ②。
- 2) 把夹线螺钉 ③ 朝 ② 顺时针方向 (即 A 方向) 转动时, 挑线簧的摆动量将增大。
- 3) 把夹线螺钉朝逆时针方向 (即 B 方向) 转动时, 挑线簧的摆动量将减小。

(2) 改变挑线簧 ① 的张力:

- 1) 旋松定位螺钉 ②, 取出夹线器 (组件) ⑤。
- 2) 旋松定位螺钉 ④ 并转动夹线螺钉 ③。
- 3) 把夹线螺钉 ③ 朝顺时针方向 (即 A 方向) 转动时, 挑线簧张力将增大。
- 4) 把夹线螺钉 ③ 朝逆时针方向 (即 B 方向) 转动时, 挑线簧张力将减小。

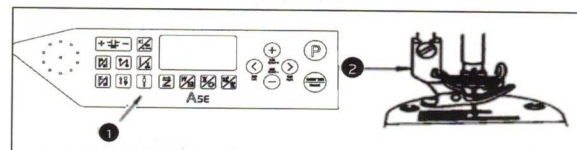
(1) Changing the stroke of thread take-up spring ①

- 1) Loosen setscrew ②.
- 2) As you turn tension post ③ clockwise (in direction A), the stroke of thread take-up spring will be increased.
- 3) As you turn the knob counterclockwise (in direction B), the stroke will be decreased.

(2) Changing the pressure of thread take-up spring ①

- 1) Loosen setscrew ②, and take out tension assembly ⑤.
- 2) Loosen setscrew ④, and remove tension post ③.
- 3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
- 4) As you turn the post counterclockwise (in direction B), the pressure will be decreased.

12. 少鸟巢功能/ Less bird's nest (-N 机型专用)



(1) 机器开启后, 点击 ① 实现少鸟巢功能的开启和关闭;

- (2) 在开始缝纫后, 夹住的线头在缝纫过程中多次无法割断后需要更换相匹配的压脚。

(1) After open the machine, press to ① achieve the function for the bird's nest and closing.

- (2) After the start sewing, the thrum of the clamp cannot be cut off many times sewing, then you need to change the matched presser foot ②.

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工业缝纫机安全使用注意事项：

- 1.必须遵守基本措施；
- 2.必须经过专业培训，对缝纫机设备性能。
- 3.使用前应检查所有安全装置；
- 4.在安装机针、更换机针、压脚、针板、送布牙、弯针、旋梭或修理时，应立即关闭电源；
- 5.离开缝纫机或工作场所时应关闭电源；
- 6.使用离合马达时，要等待马达完全停止后再进行；
- 7.缝纫机及附属装置使用的机油，润滑油等液体流入眼睛或沾到皮肤上应立即清洗；
- 8.禁止用手触摸缝纫机通电时的零件或装置；
- 9.有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行；
- 10.一般的维修保养由专人进行；
- 11.在电气方面的修理应在电气技术员的监督和指导下进行；
- 12.缝纫机使用期间应定期清扫；
- 13.为了正常安全运转，应安装地线，同时应在不受高频焊接机等强噪声源影响的环境下使用；
- 14.电源插头应由专人安装；
- 15.工业用平缝机、包缝机在指定用途以外不能使用。

环保要求：

- 1、使用过程中产生的废油及其他废弃物请根据当地环保的要求进行合理的处置。
- 2、请在使用完后及时关闭电源，减少电能的消耗。
- 3、请在说明书要求的电压及环境下使用，已延长产品的使用寿命，减少废弃物的产生。
- 4、机器报废后请勿将本机器及其附件作为普通的生活垃圾处理。请遵守本设备及其附件处理的规定，并支持回收行动。

Notes for safe use of industrial sewing machines:

- 1.Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle, and changing needle, presser foot, plate, feed dog , bent needle or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.

6. When using the clutch motor, please wait until the motor stops completely.
7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
8. Do not touch the parts or devices when the machine is powered by hand.
9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
12. The machine should be cleaned regularly during operation.
13. In order to operate normally and safely, ground lines should be installed, and they should be installed in an environment free from strong noise sources such as high frequency welding machine.
14. Power plug should be installed by specially-assigned person.
15. Industrial lockstitch sewing machine and overlock sewing machine can not be used for other designated use.

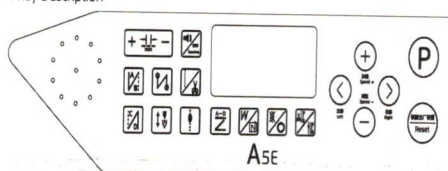
Environmental requirements:

- 1、 Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
- 2、 Please turn off the power after use to reduce power consumption.
- 3、 Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
- 4、 Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories to support recycling operations.

operation.
should be installed and pre-operated by well-trained persons. All power
be turned off during the installation work, remember not to operate with
marked with sign Δ must be observed or executed; otherwise,
might occur.
eration and safety, it is prohibited that using extension cable with
r power connection.
ing the power cord, you must make sure that the operating voltage is
250V and that it meets the rated voltage value specified in the product
power specification of the electric control box is AC220V, please do not
AC380V power socket, otherwise abnormality will occur and the motor
le. At this time, immediately turn off the power switch and recheck the
Continuous supply of 380V for more than five minutes may burn the
the electric control box and endanger personal safety.
in direct sun light. outdoors area and where the room temperature is
low 0°C.
operating near the heater at dew area or at the humidity below 10% or
in area with heavy dust, corrosive substance or volatile gas.
rd being applied by heavy objects or excessive force, or over bend.
of power cord must be connected to the system ground of the
t by proper size of conductions and terminals. This connection should be
tly.
portions must be prevented to be exposed by the parts provided.
achine in the first time, operate the sewing machine at low speed and
ct rotation direction.
ver before the following operation:
disconnecting any connectors on the control box or motor.
edle.
achine head.
doing any mechanical adjustment.
ng.
level maintenance work should only be carried out by electronic
appropriate training.
ts for repair must be provided or approved by the manufacturer.
jects or force to hit or ram the product.
of this product is 1 year dated from purchasing, or within 2 years from
nd within warranty period under normal operation, it will be repaired
However, maintenance cost will be charged in the following cases even
ty period:
use, including: wrong connecting high voltage, wrong application,
pair, modification by incompetent personnel, or operation without the
eration out of its specification range, or inserting other objects or
product.
e, Earth quake, lightning, wind, flood, salt corrosive, moisture, abnormal
nd any other damage cause by the natural disaster or by the
vironments.

ing or damage in transportation by customer himself or by
customer's shipping agency.
* We make our best effort to test and manufacture the product for assuring the quality.
However, it is possible that this product can be damaged due to external magnetic
interference and electronic static or noise or unstable power source more than expected;
therefore the grounding system of operate area must guarantee the good earth and it's
also recommended to install a failsafe device (Such as residual current breaker).

1 Key Description



Name	Key	Indicate
Stitch length setting		If click \square - Stitch length increases by 0.1mm each time If click \square - Stitch length decreases by 0.1mm each time.
Start back-tacking sewing		If click, switch starting back seam (A, B segment) 1 time, starting back seam (A, B segment) 2 times or turn off.
Clamping function without any thread		If click, set used or cancelled clamping function without any thread.
End back-tacking sewing		If click, switch ending back seam (C, D segment) 1 time, ending back seam (C, D segment) 2 times or turn off.
Needle stop position selection		If click, shift to the needle stop position (up position / down position).
Clamping function / Auto function		If click, set used or cancelled clamping function. If long-press, set used or cancelled auto function (Effective in multi-segment mode).
Press foot lifting after trimming / Press foot lifting after pause		If click, set used or cancelled press foot lifting after trimming function. If long-press, set used or cancelled press foot lifting after pause function.
Free sewing / Thread trimming		If click, shift to free sewing If long-press, set used or cancelled thread trimming function.
W sewing / Multi-segment sewing		If click, shift to W sewing. If long-press, shift to multi-segment sewing.
Lock needle key		If click, set to use front lock needle, back lock needle, front and back lock needle or cancel front and back lock needle function. (The needle lock function is tight seam)

Boot speech / Voice function key		Without error: 1. If click, the boot speech switch is cyclically selected. 2. If long-press, the voice switch is cyclically selected. In the case of error: If click, broadcast error codes and solutions directly.
Pattern sewing mode		If click, switch the pattern sewing mode and pattern.
Function parameter edit		Press this key can enter or exit the parameter setting. Save and exit the selected parameter: Press this key the parameter value to exit and save the parameter.
Parameter increase		The main interface, if clicked, increase the speed time. Parameter interface, if click, increase the parameter time.
Parameter decrease		The main interface, if clicked, reduces the speed time. Parameter interface, if click, decrease the parameter time.
Left selection		Left selection parameter content
Right selection		Right selection parameter content
Restore Factory		Long-press can restore factory setting.

2 Auxiliary Function

2.1 Parameter adjustment

2.1.1 User parameter adjustment

Boot, long press P key enter to user parameter mode. Press \leftarrow or \rightarrow to change parameter item, remove cursor, the corresponding digit value is flashing, then press $+$ or $-$ to modify this digit value, when the cursor is blinking at a numerical position, press P key, parameter value is flashing, save the parameter. Press P key again to exit.

2.1.2 Technician parameter adjustment

In the off state, hold on P key to turn on the machine (show P92) enter to technician mode. Press \leftarrow or \rightarrow change parameter item, remove cursor, the corresponding digit value is flashing, then press $+$ or $-$ to modify this digit value, when the cursor is blinking at

position, press P key, the whole parameter value is flashing, save parameter. Press P key again to exit.

2.2 Soft start

P14 adjustment in user parameters, the parameter is ON means open, the parameter is OFF means close (The default value).

2.3 Needle stop position function setting

In the off state, press and hold P key to enter the technician parameter mode (the P92 parameter interface is displayed). Adjust the parameter to P72, manually rotate the handwheel to up position, the value displayed will change with the change of the wheel position. Press P key to save the current position (value) as the up needle stop position and calculate down needle stop position automatically.

2.4 Stepper motor zero correction setting

In the shutdown state, press and hold P key to boot into the technician parameter mode (display the P92 parameter interface). Adjust the parameter to item P129, use ordinary A4 paper to measure, the speed is 4000, adjust the parameter to make the needle stick more than 10 stitches in place, and press the P key to save; (if the stitch length is along the seam, the number increases upwards, if the stitch length is reverse stitching, the number decreases downward, the value is between -50 and -80)

2.5 Stitch length setting

In the shutdown state, press and hold P key to boot into the technician parameter mode (display the P92 parameter interface). Adjust the parameter to P197 (tacking stitch length compensation), adjust the stitch length to 5, use ordinary A4 paper, speed 200 to measure, adjust the parameter so that the stitch

length is 4.9-5.1mm, press P to save. (The larger the stitch pitch, the greater the stitch length, The stitch length of 1 value changed to about 0.05), then enter the P198 (back-tacking stitch length compensation) parameter, use ordinary A4 paper, speed 200 to measure, press and hold the back-tacking switch, speed

200, adjust parameters to make the sewing overlap more than 11 stitches, press P key to save; (the greater the value, the greater the back-tacking stitch length)

2.6 Quick adjustment of presser foot lift

In the main interface, press and hold P and P , you can quickly turn on or off the presser foot lifting function.

3 Parameter Definition

3.1 User Parameter (Turn on the machine and long-press P key to enter)

No.	Items	Range	Default	Description
P01	Maximum sewing speed (rpm)	100-5000	4000	

P02	Set accelerated curve (%)	10-100	80	The speed controller dim The large of slope value speed. The small of slope value speed.
P03	Needle up/ down	UP/DN	DN	UP: Needle stops at up po DN: Needle stops at down
P04	Start back-tacking speed (rpm)	200-3200	1800	
P05	End back-tacking speed (rpm)	200-3200	1800	
P06	W sewing speed (rpm)	200-3200	1800	
P07	Soft start speed (rpm)	200-1500	400	
P08	Stitch numbers for soft start (needle)	1-15	2	
P09	Automatic multi-segment sewing speed (rpm)	200-4000	3700	Speed adjustment for auto constant-stitch sewing
P10	Automatic end back-tacking sewing after multi-segment sewing (without mending stitch function)	ON/OFF	ON	ON: After executing the la sewing, the back-tacking s executed automatically. Note: In other words, in an mending stitch function ca OFF: After executing the la sewing, the back-tacking s not be automatically execu step or full back step must again.
P12	Start back-tacking running mode Selection	0-1	1	0: Controlled by foot pedal and started at will. 1: Touch the foot pedal to execute start back-tacking
P13	Operation mode selection of the end point of start back-tacking sewing	CON/STP	CON	CON: Start Back-Tacking is automatically continued fo STP: After the number of st stop automatically.
P14	Slow start function selection	ON/OFF	OFF	0: OFF 1: Half stitch 2: One stitch 3: Continuous half stitch 4: Continuous one stitch 5: Back-tacking when mach 6: Tight seam function
P15	Mending stitch mode	0-6	5	
P16	Speed limit of manual back-tacking	0-3200	0	When the parameter is 0, th function is OFF.

P17	Automatic count mode selection	0-9	1	0: P41 parameter disable auto-count. 1-9: P41 item counter automatically counts one piece every 1-9 times of tangent.
P18	Start back-tacking compensation 1	0-200	162	0-200 action gradually delay.
P19	Start back-tacking compensation 2	0-200	162	0-200 action gradually delay.
P20	End back-tacking running mode selection	0-1	1	0: Artificial, controlled by foot pedal, can be stopped and started at will. 1: Automatic, touch the foot pedal to automatically execute back-tacking action.
P21	The position of the pedal for running	30-1000	520	
P22	The position of the pedal for stopping	30-1000	420	
P23	The position of the pedal for presser foot lifting	30-1000	270	
P24	The position of the pedal for thread trimming	30-500	130	
P25	End back-tacking compensation 3	0-200	162	0-200 action gradually delay.
P26	End back-tacking compensation 4	0-200	162	0-200 action gradually delay.
P28	W sewing running mode selection	0-1	1	0: Controlled by foot pedal, can be stopped and started at will. 1: Touch the foot pedal to automatically execute back-tacking action.
P29	The strength of thread trimming stop	1-45	20	
P32	W sewing compensation 5	0-200	162	
P33	W sewing compensation 6	0-200	162	
P34	Multi-segment sewing running mode selection	A/M	A	A: Touch the foot pedal to automatically execute constant-stitch sewing action. M: Controlled by foot pedal, can be stopped and started at will.
P35	Thread slacking function setting when presser foot lifting	0-2	0	0: OFF 1: Thread slacking function ON when presser foot lifting, Thread slacking function off when pause 2: Full function
P36	Thread slacking function selection	0-1	1	0: OFF 1: ON
P37	Thread wiping function / Thread damping function selection	0-11	8	0: OFF 1: Thread wiping function 2-11: Thread damping function, the higher the value, the stronger the action.
P38	Automatic thread trimming function selection	ON/OFF	ON	ON: With thread trimming OFF: Without thread trimming

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P39	Automatic presser foot lifting when pause function selection	UP/DN	DN	UP: When the sewing stops, will lift automatically DN: When the sewing stops, will not lift automatically (Control pedal)
P40	Automatic presser foot lifting after trimming function selection	UP/DN	DN	UP: When the sewing stops, will lift automatically DN: When the sewing stops, will not lift automatically (Control pedal)
P41	Counter display	0-9999		The number of sewing completed, long press parameter to clear the count.
P42	Information display		N01	N01 The control system version N02 The panel version number N03 Speed N04 The pedal AD N05 The mechanical angle (encoder) N06 The mechanical angle (encoder) N07 Busbar voltage AD N12 Kneeling device position N13 Presser foot height sensor N14 The control system version N15 Stepping version number
P43	Direction of motor rotation	CCW/CW	CCW	CW: Clockwise CCW: Counter Clockwise

3.2 Technician Parameter (Hold P key to boot)

No.	Items	Range	Default	Description
P44	Brake strength during stopover	1-45	16	Adjustment of efforts while
P46	Motor stop with a reverse angle after trimming function	ON/OFF	OFF	ON: Function on OFF: Function off
P47	Adjust the reverse angle when motor stop after trimming	40-200	160	After trimming, count from the position and adjust the angle by reverse rotation.
P48	Minimum speed (Positioning speed) (rpm)	100-500	200	Minimum speed limit adjustment
P49	Thread trimming speed (rpm)	100-500	250	Adjust the motor speed during cycle
P50	Foot lifter operation time to full output (ms)	10-990	200	
P51	Presser foot lifter operation duty cycle (%)	10-50	30	Presser foot lifter operate in electricity and protect the electric over-heat.

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Motor to	10-990	120	Delay the start time, with automatic presser foot down.
ing presser	0-2	1	0: OFF 1: Back pedaling and half back pedaling with lifting presser foot. 2: half back pedaling without lifting presser foot, back pedaling with lifting presser foot.
on time	10-990	200	Completion of the thread trimming action required time
time (ms)	10-990	10	Completion of the thread wiping action required time
oning	0-1	1	0: always not to find the up needle position 1: always to find the up needle position
t protection	1-60	5	Forced shutdown after hold time to prevent the electromagnet from being hot for a long time
adjustment	0-359	180	Up position adjustment, the needle will advance stop when the value decreased, the needle will delay stop when the value increased.
n	0-359	350	Down position adjustment, the needle will advance stop when the value decreased, the needle will delay stop when the value increased.
0)	100-4000	3500	Setting testing speed
	ON/OFF	OFF	After setting A, continuous running at the speed of 【P60.TV】
	ON/OFF	OFF	Option of Testing B, after setting press 【P60.TV】 to set the speed execute the cycle of Start - Sewing - Stop - Trimming
	ON/OFF	OFF	Option of Testing C, after setting press 【P60.TV】 to set the speed execute the cycle of Start - Sewing - Stop without positioning function
ing B and C	1-250	30	Setting running time of testing B and C
and C	1-250	10	Setting stop time of testing B and C
switch	0-2	1	0: Disable 1: Testing zero signal 2: Testing positive signal
freedom	100-5000	4000	
distance of	100-3000	2000	
	0-50	30	

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P72	Up needle position adjustment	0-359		
P73	Down needle position adjustment	0-359		
P76	Brake strength of back-tacking step motor	0-5	0	
P78	The start angle of thread damping	10-150	130	Positioning angle when start clipping
P79	The stop angle of thread damping	160-359	320	Positioning angle when finish clipping
P80	The start angle of thread trimming	0-359	5	Shear line infed id angle setting(under defined as 0°)
P81	Presser foot release buffer time	1-800	200	
P82	The stop angle of thread trimming	0-359	175	Feeder back angle of thread trimming setting Down position as 0°.
P83	Stopping strength after trimming	10-100	20	
P86	The distance of up and down position	15-345	170	
P87	Wiping thread return delay time	10-990	50	Make sure the wiper return to its original position
P88	Stopover distance	10-100	30	
P89	Alternating current (AC) over-voltage value setting	500-1023	880	
P92	Correct the electrical angle of motor	0-1200	430	Press the needle position key to read the initial angle of encoder, the factory default was set, please do not change the values (parameter value cannot be changed manually, random change it will result the control box and motor abnormal or damaged).
P93	The delay time of the half back pedaling function (ms)	10-900	100	
P99	Starting tight seam stitch length	0-50	8	If the value is 10, the stitch length is 1.0
P100	Direction of starting tight seam	0-1	0	
P101	The start angle of thread slacking	1-359	30	Thread slacking start angle (defined as 0°under calculation)
P102	The stop angle of thread slacking	1-359	180	Thread slacking end angle (defined as 0°under calculation, must be greater than P101 parameter value)
P103	Thread slacking strength	1-5	3	
P105	Pattern freedom sewing mode selection	NO-N9	NO	N0: OFF N1-N9: Pattern freedom sewing mode
P107	Starting tight seam speed	100-2500	1000	
P108	Starting tight seam stitch number	0-12	2	When the parameter value is 0, ending tight seam function is closed

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P109	The delay time before thread wiping	5-990	5	Interval time before enter action after finding the up
P110	Trimming back time (ms)	60-990	65	Make sure the thread trim to its original position
P111	Clamp function without any thrum switch	0-1	0	
P112	The delay time before hook thread with clamp function without any thrum	0-990	100	
P113	The hook thread action time with clamp function without any thrum	0-990	30	
P114	The return back time of hook thread with clamp function without any thrum	0-990	30	
P115	Duty cycle for hook thread with clamp function without any thrum	0-100	80	0: Function off
P116	The suction time for clamp function without any thrum	0-5000	1000	
P117	Duty cycle for pull thread with clamp function without any thrum	0-100	80	
P119	Electromagnet over-current protection selection	0-1	0	0: OFF 1: ON
P120	Oil level alarm switch	0-1	1	0: OFF 1: ON
P123	Maximum stitch length limit	0-70	50	
P129	Back-tacking step motor zero-point correction	-500~-500	-65	
P131	Normal stitch length	0-50	35	Stitch length in normal sewing
P132	Manual close stitches distance	0-50	20	
P133	Layer seam stitch length	0-50	40	
P138	Foot lifting release buffer duty cycle (%)	0-100	10	
P139	Foot lifting release buffer delay time (ms)	0-200	5	
P143	Tight seam mode selection	0-3	2	Tight seam mode selection 0: OFF 1: Starting tight seam 2: Ending tight seam 3: Full function
P144	High-speed tacking stitch length compensation	-50~-50	0	The larger the value, the s high-speed stitch length.

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P145	High-speed back-tacking stitch length compensation	-50~50	0	The larger the value, the smaller the high-speed stitch length.
P153	Ending tight seam stitch length	0-50	5	If the value is 10, the stitch length is 1.0
P154	Ending tight seam speed	100-2500	1800	
P159	Direction of ending tight seam	0-1	0	0: Forward 1: Backward
P160	Ending tight seam stitches	0-12	2	When the parameter value is 0, the function off.
P167	Key tone and voice navigation selection	0-3	1	0: OFF 1: With voice navigation and key tone 2: With key tone but without voice navigation 3: With voice navigation but without key tone
P168	Voice settings	0-2	1	0: OFF 1: Chinese 2: English
P169	Boot speech switch	0-1	1	0: OFF 1: ON
P197	Tacking stitch length compensation	-50~50	0	It is adjusted when main shaft at low speed, the larger the value is, the larger the stitch length is, it is used when the stitch length is inconsistent due to mechanical error.
P198	Back-tacking stitch length compensation	-50~50	0	It is adjusted when main shaft at low speed, the larger the value is, the larger the stitch length is, it is used when the stitch length is inconsistent due to mechanical error.
P201	Start sewing presser foot lifting switch	0-1	0	0: OFF 1: ON
P202	The start angle of start sewing presser foot lifting	0-359	1	
P203	The stop angle of start sewing presser foot lifting	0-359	200	
P204	Start sewing presser foot lifting strength	0-100	60	
P205	Start sewing first stitch speed limit	0-1500	600	The default 0 is off
P206	Start sewing second stitch speed limit	0-2000	1200	The default 0 is off
P207	Start sewing third stitch speed limit	0-2500	0	The default 0 is off
P208	Panel stitch length lock function	0-1	0	0: OFF 1: ON+ key and - key on the main interface are invalid

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P216	The start angle of damping when start back-tacking sewing and W sewing function on	10-159	80	
P217	The stop angle of damping when start back-tacking sewing and W sewing function on	160-359	180	
P218	The start angle of damping when starting tight seam function on	10-159	80	
P219	The stop angle of damping when starting tight seam function on	160-359	180	

Note: The initial value of parameters is for reference only, and the actual value of parameters to the real object.

4 Error Code List

Error Code	Problem description	Measure
E01	Over-voltage	Turn off the machine, check the power supply voltage, or exceeds the rated voltage used. If there are still errors, please replace the control box and call for customer service.
E02	Low-voltage	Turn off the machine, check the power supply voltage, or lower than the rated voltage used. If there are still errors, the control box and call for customer service.
E03	CPU communication error	Turn off the power and check whether the connector is connected to the operation panel and the cable condition, restart the system. If there are still errors, please replace the control box and call for customer service.
E05	Speed control unit connection is abnormal	Please turn off the power and check whether the connector is connected to the speed controller and the cable condition, restart the system. If there are still errors, please replace the control box and call for customer service.
E07	Main shaft motor rotating abnormally	Please rotate handwheel to check if the spindle motor is locked. Check the encoder cable of the motor and the power cable of the motor. If the power supply voltage is too high, and whether the sewing speed is too high. If it still does not work after the removal, please replace the control box and call for customer service.
E10	Solenoid over-current protection	Turn off the system power supply, please check the solenoid not.
E09	Positioning signal error	Turn off the system power supply, please check motor encoder cable is loose or fall off, restore it to normal then restart system. If there are still errors, please replace the motor and call for customer service.
E14	Encoder signal error	Turn off the system power supply, please check motor encoder cable is loose or fall off, restore it to normal then restart system. If there are still errors, please replace the motor and call for customer service.
E15	Power module abnormal over-current protection	Turn off the power, and then turn it on again. If there are still errors, please replace the control box and call for customer service.

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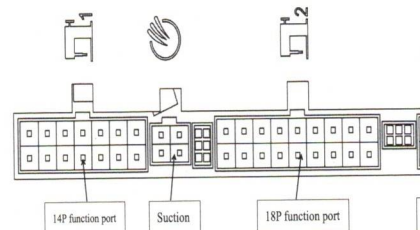
E17	Safety switch alarm	Turn off the system power, check whether the machine head is opened, and whether the ball switch in the control box is displaced or damaged.
E20	Motor start failed	Turn off the system power supply, please check motor encoder connector and motor power socket if loose or fall off, restore it to normal then restart system. If there are still errors, please replace the motor and call for customer service.
E30	Shutdown failure when password is locked	The machine has reached the set time. If you need to continue using it, please contact your local service provider.
E40	Crystal oscillator of panel abnormal	Turn off the power and replace the panel PCB. If there are still errors, please call for customer service.
E80	Abnormal communication between the main CPU and the step driver CPU	Turn off the system power and restart. If you still get an error, please call for customer service.
E82	Back-tacking step motor overcurrent	Turn off the power and check the step motor connector, then turn it on again. If you still get an error, please call for customer service.
E84	Back-tacking step motor encoder Z signal abnormal	Turn off the power and check the step motor connector, then turn it on again. If you still get an error, please call for customer service.
E85	Back-tacking step motor encoder AB signal abnormal	Turn off the power and check the step motor connector, then turn it on again. If you still get an error, please call for customer service.
E86	Back-tacking step motor failed to start	Turn off the power and check whether the connector connecting the step motor coding cable and the power cable is loose or fall off, restore it to normal and restart the system. If it still does not work properly, please replace back-tacking step motor and call for customer service.
E87	Back-tacking step motor locked-rotor	Turn off the power and check whether back-tacking step motor is locked, restore it to normal and restart the system. If it still does not work properly, please replace back-tacking step motor and call for customer service.
Oil	Low oil warning	Turn off the power, check whether the oil amount of the sewing machine is too low, and restart the system after filling the oil amount.

Note: 1. Stepping motor encoder wire alarm troubleshooting: when alarm E84 please kindly check whether the encoder wire black (ground wire), blue (zero position signal) and pink (power wire) fall off or not; when alarm E85 please kindly check whether the encoder connector falls off or not; if not, please kindly check whether the encoder wire black (ground wire), brown (A signal) and orange (B signal) fall off or not; when the machine after start or normal operation alarm E87 please kindly check the encoder connector falls off or not.

2. Stepping motor power wire alarm troubleshooting: when alarm E82 please kindly check whether the power wire red (A power wire), blue (B power wire), green (C power wire) falls off or not; when starting up then alarm E82 please kindly check whether the connector of power wire falls off or not; if not, please kindly check whether the blue (B power wire), green (C power wire) falls off or not; when the machine after start or normal operation alarm E87 please kindly check the power wire connector falls off or not.

If the above problem is that the wire or connector falls off, please disconnect the power supply and reconnect again. If not, please refer above to solve.

3. The motor disc problem caused alarm troubleshooting: when alarm E85 and the above wire and connectors all not falls off, then please kindly check whether the outer ring motor disc is covered by oil or not. If the outer ring motor disc is covered by oil, please contact after-sales service to replace the motor disc.

5 Port Diagram
51 Port Description

5.2 18P function port description

18	17	16	15	14	13	12	11	10
9	8	7	6	5	4	3	2	1

- Oil level sensor: 2, 11
- Half-needle button: 4, 14(GND)
- Back-tacking key switch: 5, 14(GND)
- Fill needle key switch: 6, 14(GND)

5.3 14P function port description

14	13	12	11	10	9	8
7	6	5	4	3	2	1

- Trimming electromagnet: 2, 9
- Clamping electromagnet: 5, 12
- Thread releasing electromagnet: 6, 13
- Presser foot electromagnet: 7, 14

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