



Machine Brief



One: Fashion integrated design

Fashion integration, back-type electric control, simple and elegant

Two: Voice Guidance

Each key function has a voice reminder, easy to understand

Three: Pattern Sewing

9 kinds of patterns, and user-friendly customized function

Four: Electronic stitch length

The stitch length can be accurate to 0.1MM, and the stitch length can be locked according to the demand, which provides a guarantee for the cloth quality

Five: Step motor drive reverse sewing

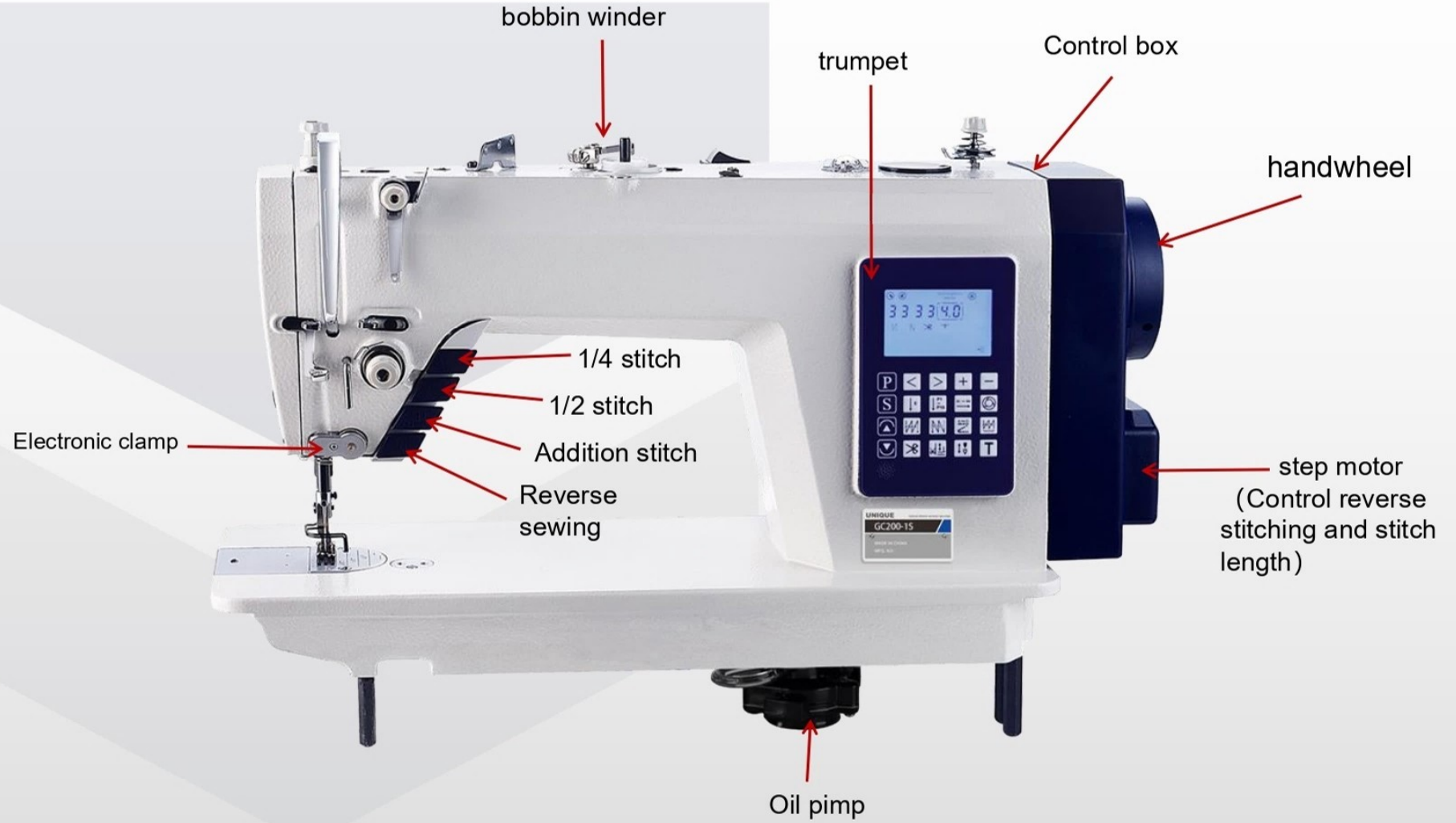
quiet sewing, good coincidence degree, beautiful stitch.

Six: Front and end condense sewing

Lock the thread easily, the thread residue will not loosen or fall off after washing, it will be shorter after the trimmer

Seven: Coaxial System

The upper shaft adopts Coaxial System, the whole machine has light torque and starts faster.



No.	Item
1	Parameter adjustment
2	Voice function
3	Stitch length and Sewing pattern choose
4	Speed setting
5	Starting/Ending reverse sewing
6	Trimmer/Press foot lifter
7	Factory reset
8	Nipper function/Needle position
9	Small stitch sewing
10	Sewing pattern modification
11	Starting/Ending pattern sewing
12	Fixed stitch sewing
13	Multi-section stitch sewing
14	Multi-section stitch sewing test mode

No.	Item
15	Bar-tacking (W sewing) mode
16	Multi- section stitch/pattern sewing
17	Soft start/ Machine button function
18	After trimming needle position
19	Monitoring /Piece counting mode
20	Main motor running angle test
21	Stepping motor original position adjust
22	Pedal original position adjustment
23	pedal working position adjustment
24	LCD screen Brightness adjustment
25	Parameter
26	Error list



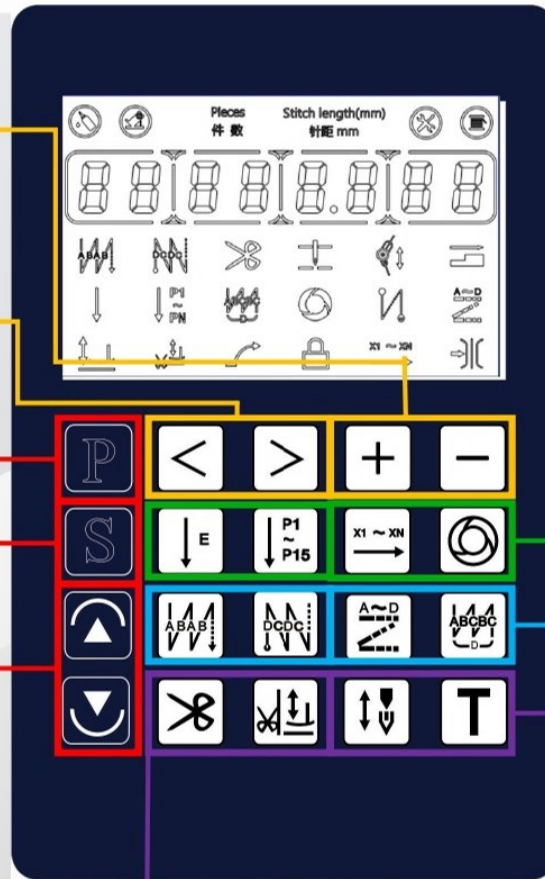
Speed adjustment

Stitch length and Sewing pattern choose

Parameter setting

Confirm & save

Speed adjustment



Fixed stitch

Multi-section stitch

Multi-section stitch or pattern

Combined function key

Starting reverse sewing

Ending reverse sewing

Sewing pattern adjust / starting ending pattern sewing

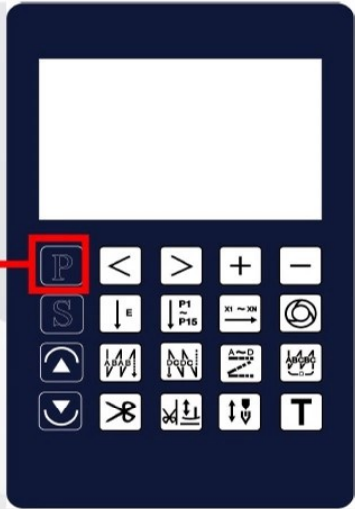
Bar-tacking (W sewing) mode

Up and down needle position

Test mode

Trimmer ON/OFF

trimmer and presser foot lifter mode



Parameter adjustment

Enter different parameter levels

(parameters are divided into 2 levels)

1. Normal parameter

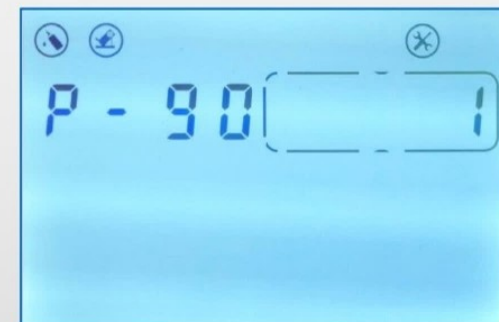
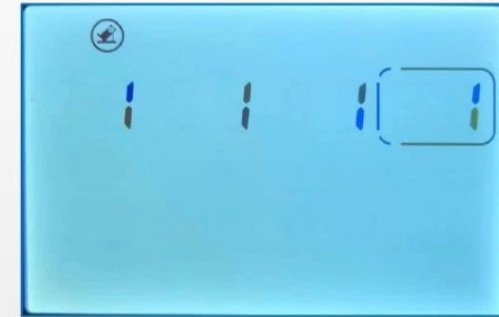
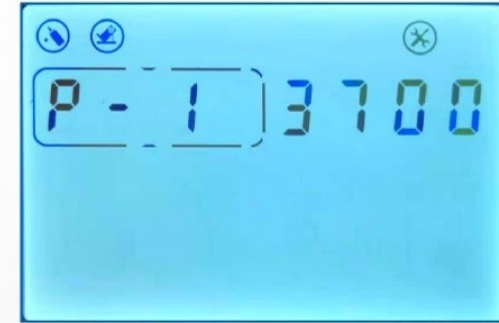
long press the **P**
+ or - select parameter,
press **S** confirm parameter

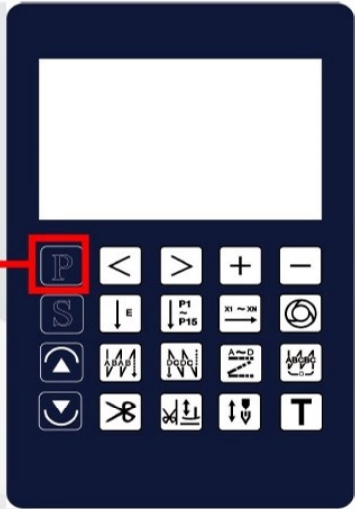
+ or - adjust the parameter value
press **S** save
press **P** exit

2. High level parameter

long press the **P** for 5 seconds
input password **1111**, press **S**
+ or - select parameter,
press **S** confirm parameter

+ or - adjust the parameter value
press **S** save
press **P** exit





Voice function

Select voice function on / off,
provide Chinese / English selection

1. Language

long press the **P** for 5 seconds
input password **1111**, press **S**
choose **P-90**, press **S** confirm

+ or - adjust the parameter value

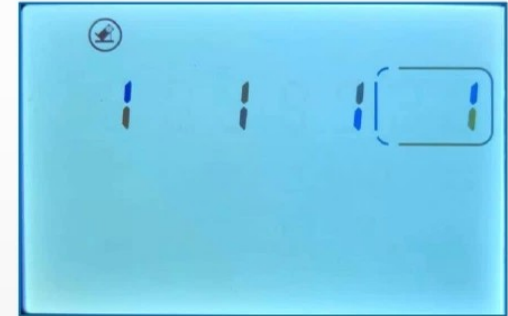
0 Off Voice

1 Chinese

2 English

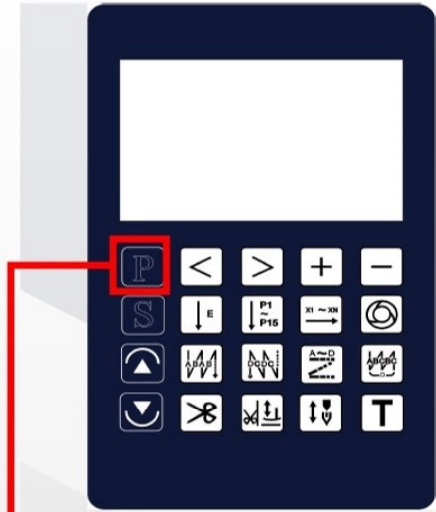
press **S** save

press **P** exit





3、 Stitch length and Sewing pattern choose

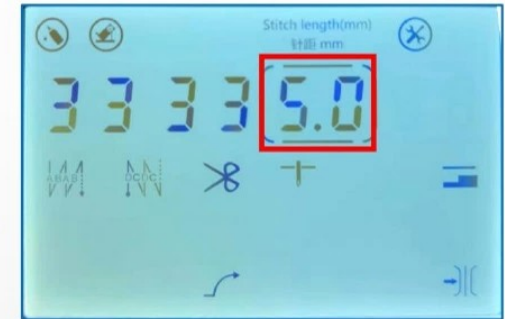


+ **-** **Stitch length / Sewing pattern**

Normal Mode :press **+** or **-**
choose 0-5m/g stitch
choosed1-d9 pattern

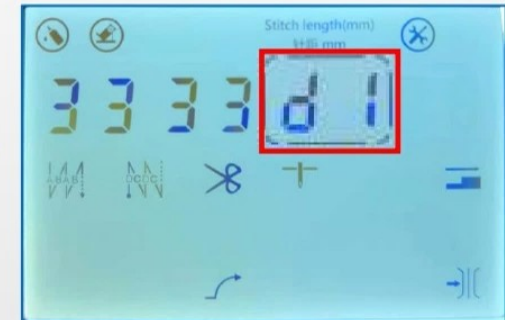
1. Adjust stitch length

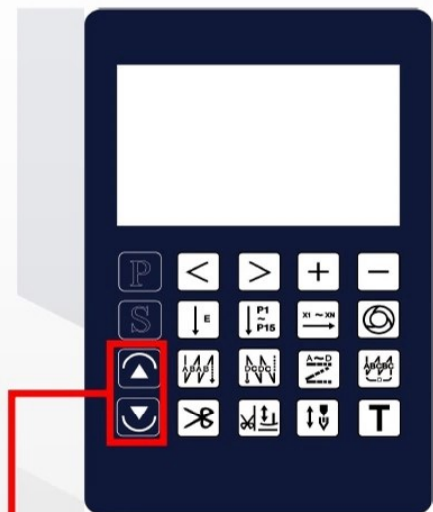
+ or **-** adjust **stitch length**
0-5mm can be choose
press **S** save



2. Adjust Pattern

After increased to 5.0,
press **+**
choose **d1-d9 pattern**
press **S** save





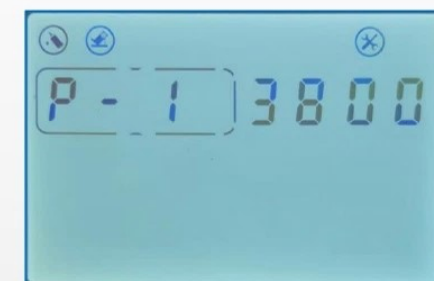
1. Normal mode

< or > adjust speed



2. maximum speed setting

long press the **P** , choose **P-1** ,
press **S** , **setting the speed**
press **S** save, press **P** exit



3. Maximum speed lock

long press the **P** for 5 seconds
input password **1111** , press **S**
+ or - select **P-80** ,
press **S** , **setting the speed lock**
press **S** save, press **P** exit



Noted: P-80 finished, then adjust the P-1, then
< or > adjust normal speed, speed lock can be work



Speed setting

1. Normal mode : < or > adjust speed

2. P-1 parameter: maximum speed setting

3. P-80 parameter: maximum speed lock

5、 Starting/Ending reverse sewing



S/E reverse

1. In normal interface ,press the starting and ending reverse sewing button setting the reverse mode and reverse stitch or off the reverse

1. Starting/Ending reverse sewing

starting and ending reverse sewing, have 3 mode

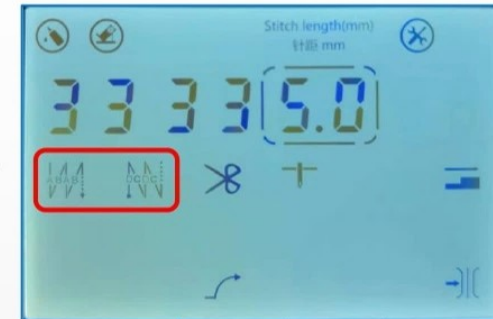
single reverse

double reverse

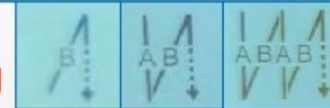
four time reverse

press the button

Circular selection the function



starting



ending



2. Reverse stitch quantity setting

pres **S**, stitch setting mode

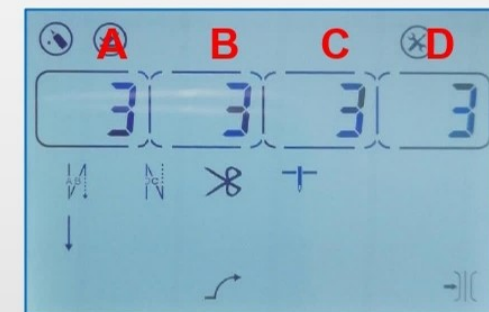
press **< or >**

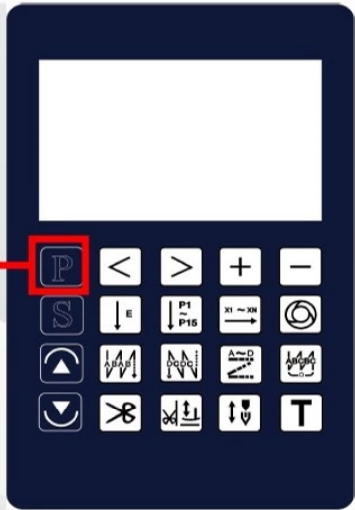
choose A B C D position

press **+** or **-**

change A B C D stitch

pres **S**, exit the sewing mode



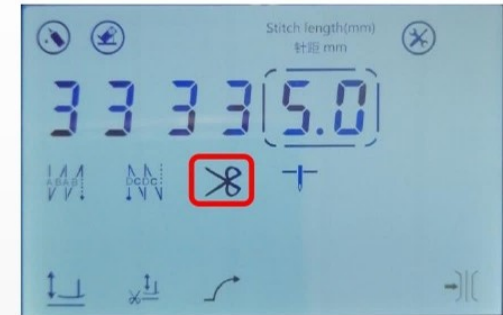


Tr/PFL function

1. Press foot lifter Circular selection function:
Sewing pause work / Trimmer finished work
/ Both states work
2. **P-25 parameter** Press foot lifter **on/off**
3. **P-24 parameter** Press foot lifter
soft lowering **on/off**

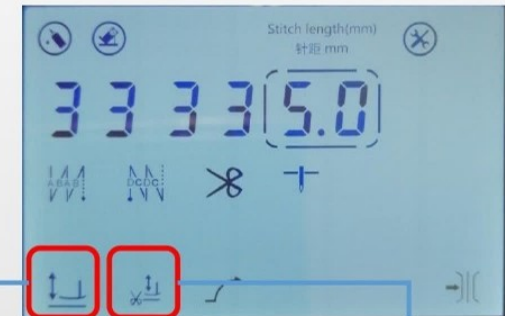
1. Trimmer

long press the trimmer button
trimmer on/off

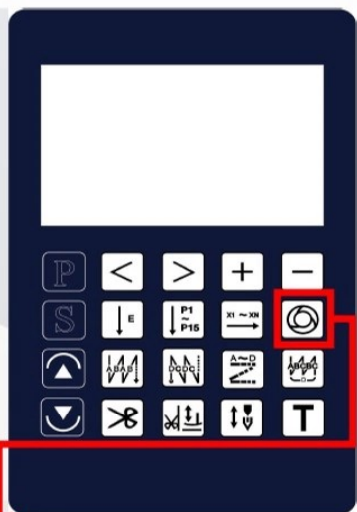


2. Press foot lifter

long press the **P** ,
choose **P-25** , press **S**
0 off / 1 on
press **S** save
press **P** exit



Sewing pause Press foot lifter work
Trimmer finished Press foot lifter work



Factory reset

1.Button Reset: panel setting and **I level** parameter reset

2. Parameter Reset: panel setting and **I level** and **II level** parameter reset

1. Button Reset

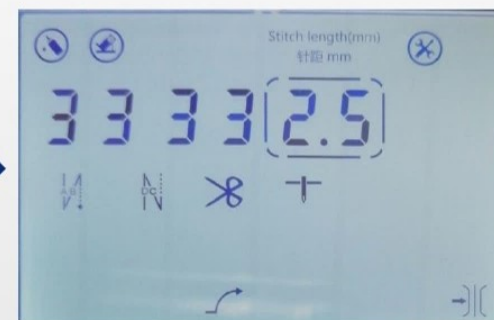
long press **Reset** button
press **S**

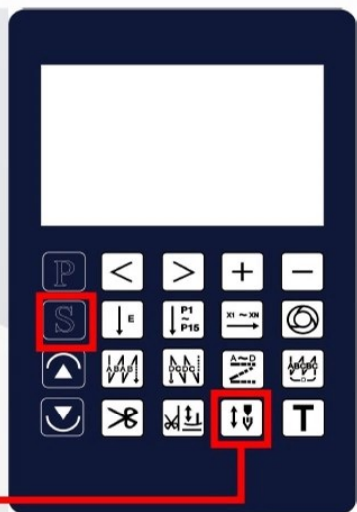


2. Parameter Reset

long press the **P** for 5 seconds
input password **1111**, press **S**
press **P** exit

long press **Reset** button
press **S**



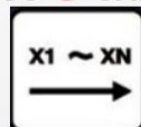


Nipper function/ Needle position

1. Long press : Nipper **on/off**
2. Short press : Needle position **up/down**
3. Long press S button:
Nipper working pressure

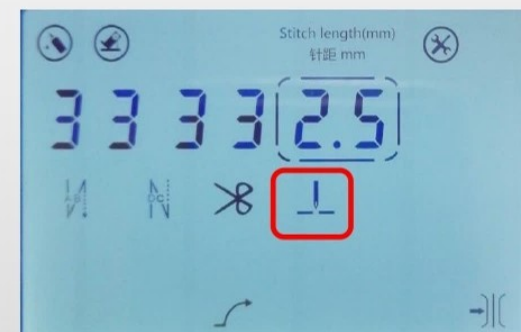
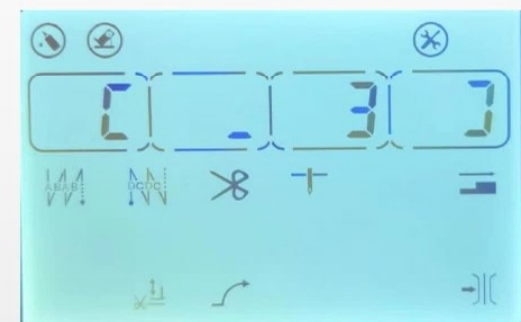
1. Nipper function

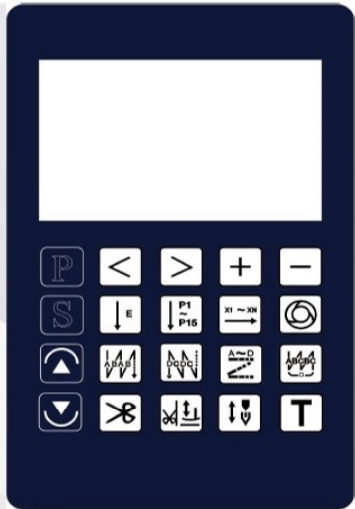
Long press **S** button
show the nipper magnet
workig pressure
1 for smaller -9 for biggest
0 for OFF Nipper function
press **S** exit



2. Needle position

Short press needle position
button
up needle position
down needle position





1. Small stitch sewing

Long press button

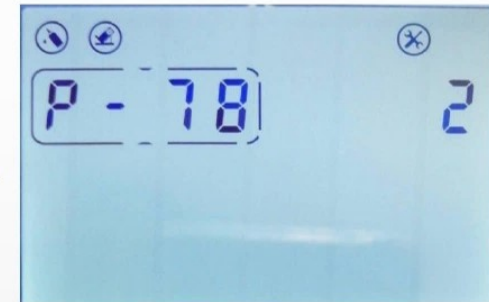
small stitch sewing on/off

Parameter setting

P-78 mode setting

P-117 stitch length setting

P-118 stitch quantity setting



- 1 start small stitch sewing
- 2 end small stitch sewing
- 3 start and end both

Small stitch sewing

start small stitch sewing: beautiful stitch can instead of the starting reverse sewing

end small stitch sewing: short trimmer thread , when garment factory Washing process, the thread no loose

Small stitch sewing

Pattern introduction

Compared with the normal sewing mode, after the ending reverse sewing is finished

Realize the Small stitch sewing
(1-1.5mm stitch length can be adjust)

trimmer thread < 3mm

International boutique clothing

QC standard

International standard for clothing inspection

AQL 2.5 standard



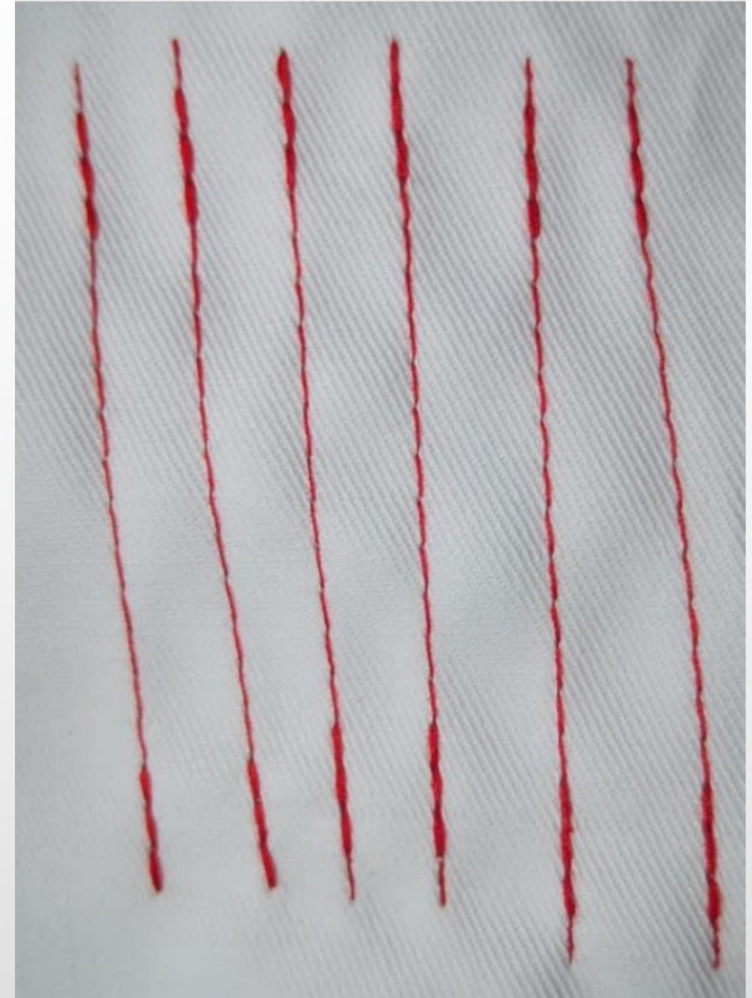
Small stitch sewing

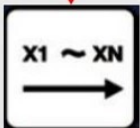
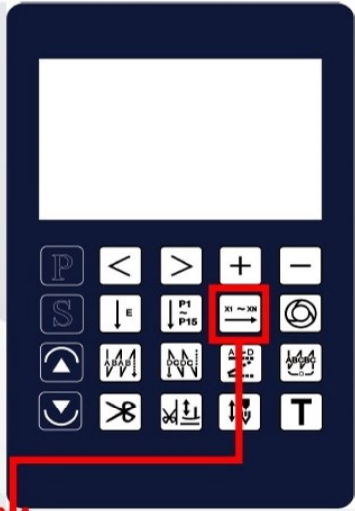
Pattern introduction

1-2 Segment: start 4 stitch, length 1.1mm

3-4 Segment: start 4 stitch, length 1.1mm

4-6 Segment: start and end both 4 stitch, length 1.1mm





Sewing pattern modification


1. Modify the preset pattern d1-d9

Simple description:

- ① Consider each action first, normal stitch or reverse stitch, how many stitches for each action
- ② First normal stitch, then reverse stitch, then again normal stitch
(like a 1 ,b a(2 3), b a(4 5), b a(6 7),.....)
(If the pattern stitch look like no full, again b a, b a)
- ③ Normal stitch and reverse stitch, stitch length and quantity should be same



1. choose pattern

long press 
+ or - Choose the pattern which is you need to modify

2. Pattern modify

Set from left to right

Action
 Stitch length
 Stitch quantity

noted: stitch length
 minus - for reverse



- 1** means First action
- 4.0** normal stitch 4mm
- 4.0** reverse stitch 4mm
- 01** means action have one stitch

Sewing pattern modification

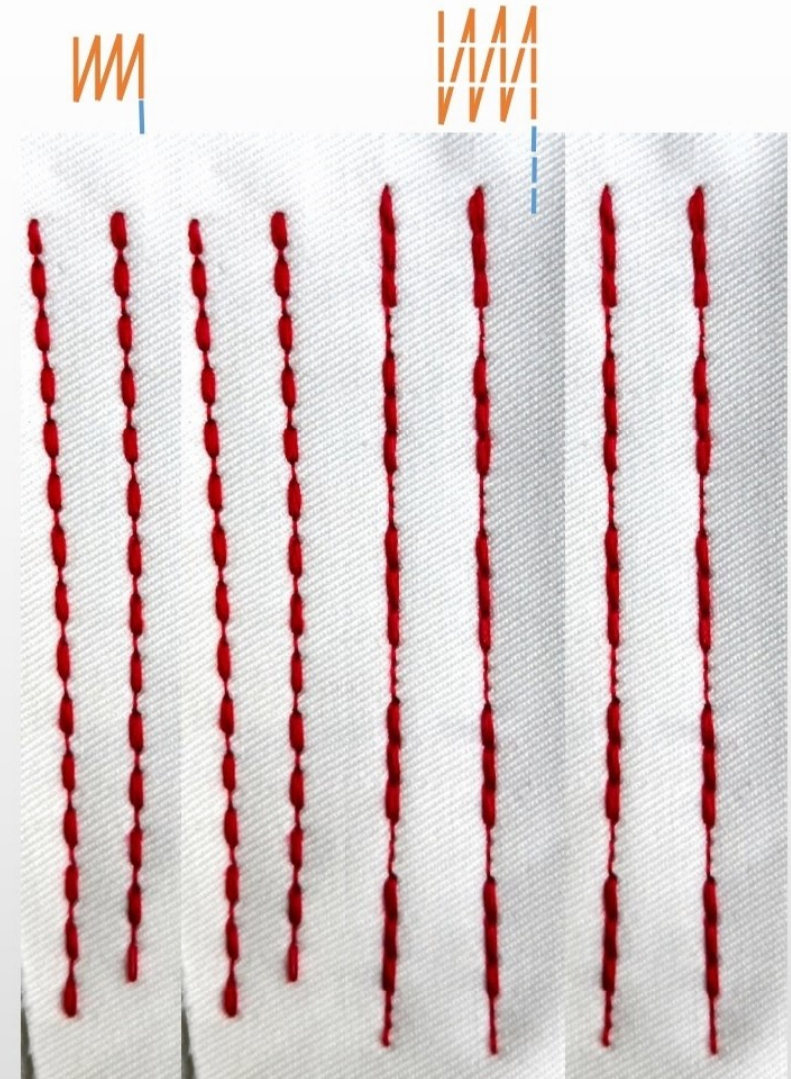
Pattern introduction

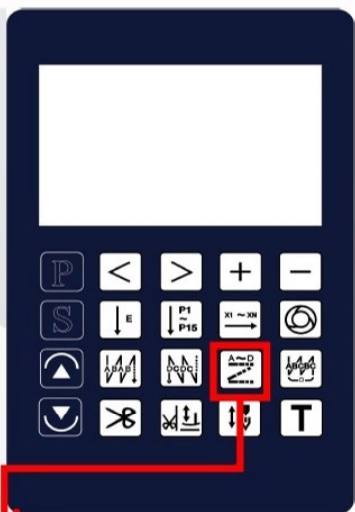
factory d1 pattern (**left**)

Action	stitch length	stitch quantity
1	4mm	1
2	-4mm	1
3	4mm	1
4	-4mm	1
5	4mm	1
6	-4mm	1
7	4mm	1
8	2mm	1

modify d1 pattern (**right**)

Action	stitch length	stitch quantity
1	4.2mm	3
2	-4.2mm	3
3	4.2mm	3
4	-4.2mm	3
5	4.2mm	3
6	-4.2mm	3
7	4.2mm	3
8	2mm	3






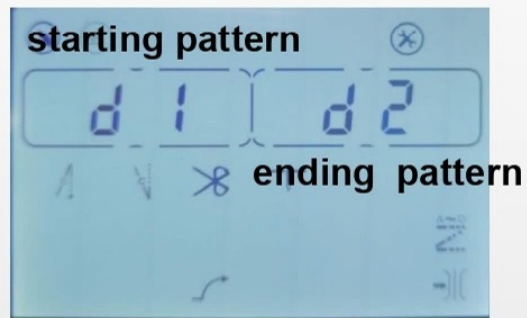
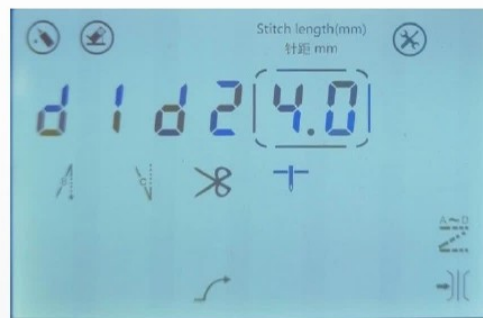
S / E pattern sewing

1. The starting and ending reverse sewing can use the pattern instead of it
 you can use the factory pattern d1-d9 also you can use the new pattern which is you modified

1.Starting/Ending pattern sewing

press  pattern button
+ or - choose the stitch length
 press **S** save

press **S**,
< or > choose the starting and ending sewing
+ or - choose sewing pattern
 press **S** save
 press **P** exit



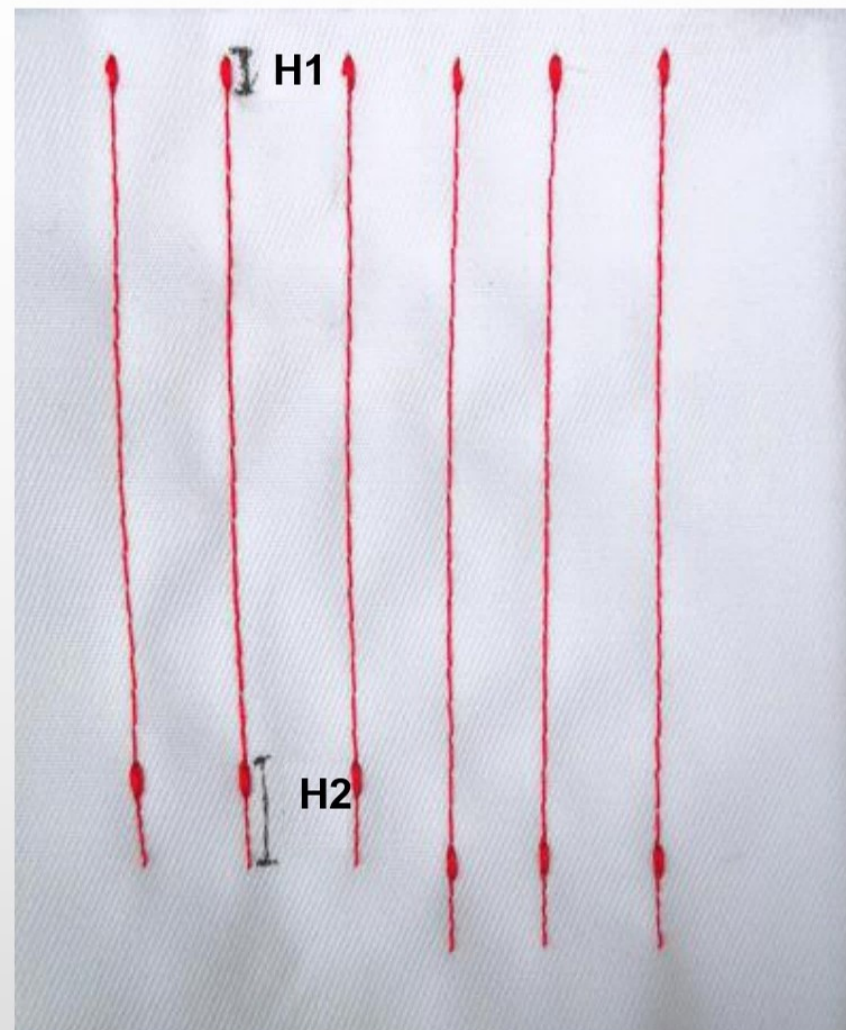
2.S/E Pattern modify

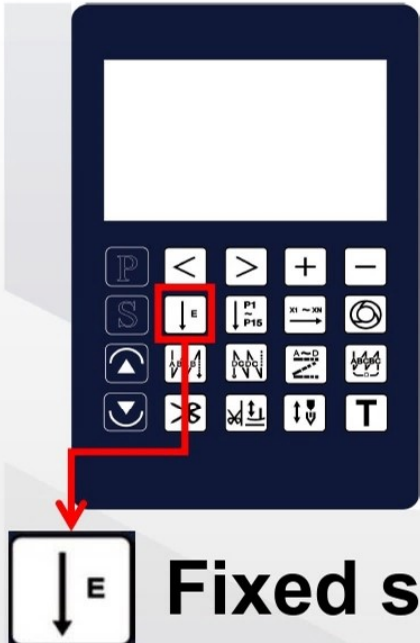
long press 
+ or - Choose the pattern which is you need to modify
 edit in the same way as the D pattern

Starting/Ending pattern sewing

Pattern introduction

- 1、 The H1 pattern is used for starting reverse sewing
- 2、 The H2 pattern is used for ending reverse sewing





Fixed stitch sewing

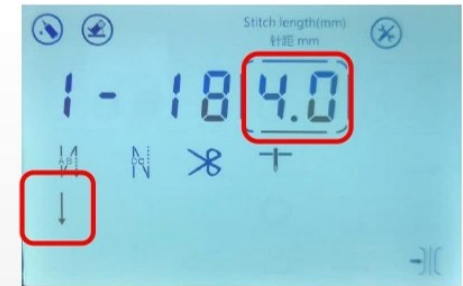
Fixed stitch (one-section stitch)

0 ~ 99 stitches can be setting

press  button, can be sewing automatically

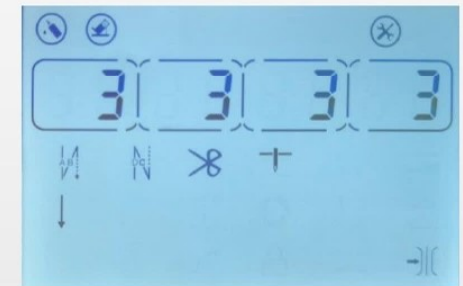
1. Stitch length

press **+** or **-**
adjust **stitch length**
press **S** save



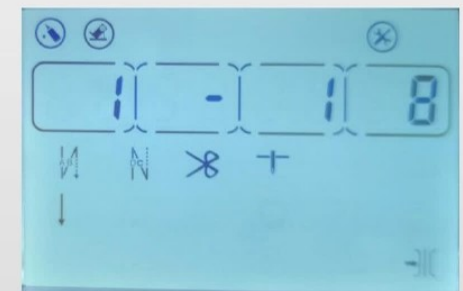
2. Starting and Ending reverse stitch

press **S** , setting the S/E
reverse stitch quantity
and reverse mode
press **S** save



3. Stitch quantity

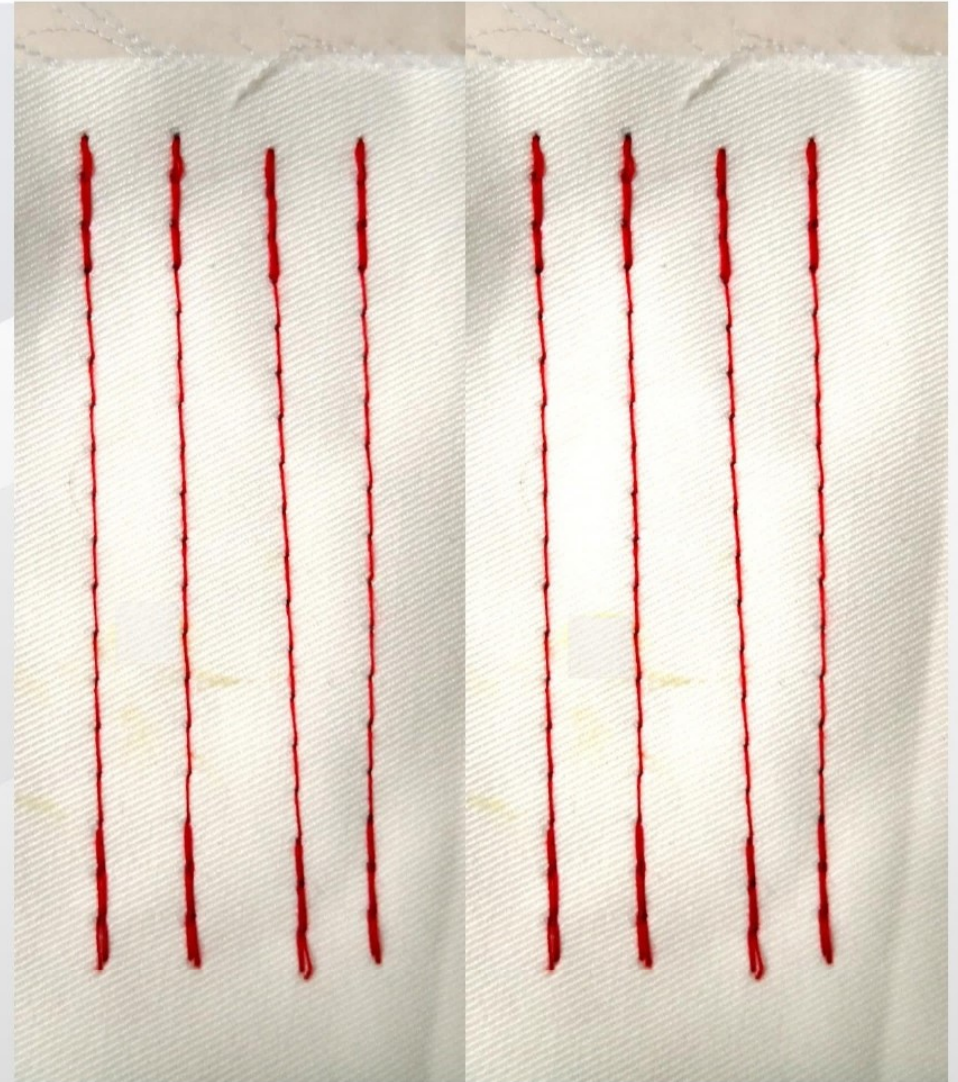
press **S** , setting the
One-section stitch quantity
press **S** save

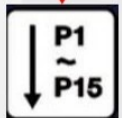
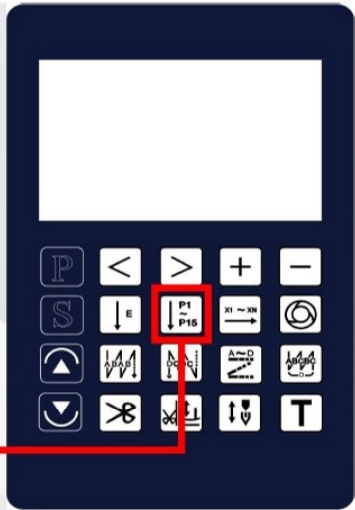


Fixed stitch sewing (One-section stitch)

Pattern introduction

- 1、 starting and ending reverse
3 stitch
- 2、 One-section 18stitch






Multi-section stitch

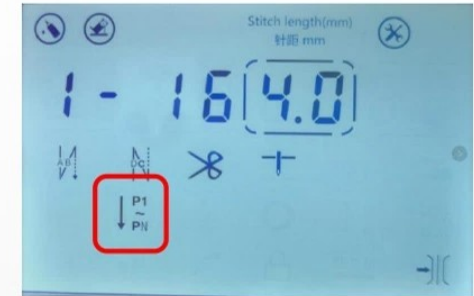
Multi-section mode

15 section, 0 ~ 99 stitches can be setting

press  button, can be sewing automatically

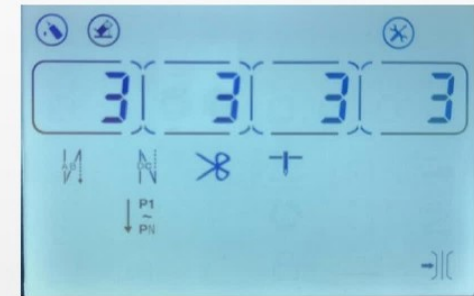
1. Stitch length

press **+** or **-**
adjust **stitch length**
press **S** save



2. Starting and Ending reverse stitch

press **S** , setting the S/E
reverse stitch quantity
and reverse mode
press **S** save



3. Stitch quantity

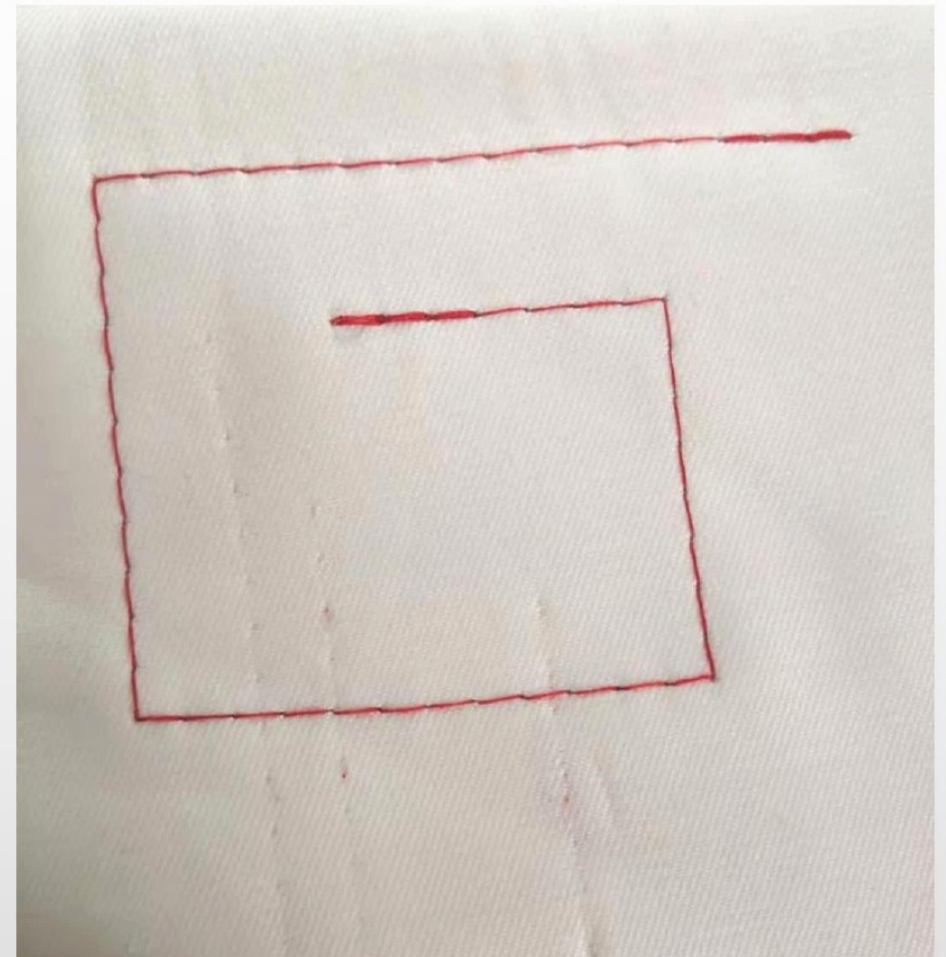
press **S** , setting the
Multi-section stitch quantity
+ or **-** choose the section
press **S** save



Multi-section stitch

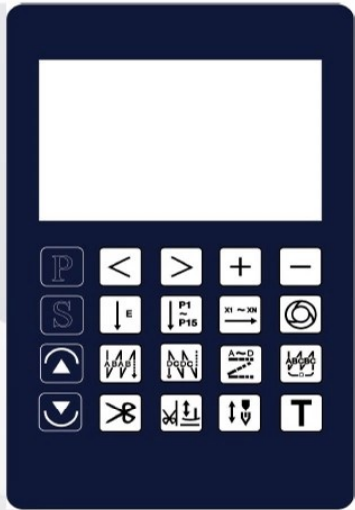
Pattern introduction

- 1section: starting reverse 3 stitch,
16 stitch, length 4mm
- 2section: 11 stitch, length 4mm
- 3section: 12 stitch, length 4mm
- 4section: 8 stitch, length 4mm
- 5section: ending reverse 3 stitch,
7stitch, length 4mm





14、 Multi-section stitch sewing test mode



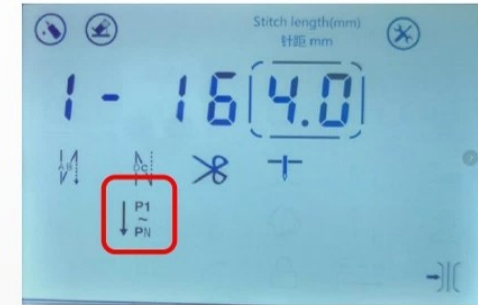
T Multi-section test mode

Testing mode: Sewing stitches , and stitch quantity in each section will save in the control box system.

Traditional methods: sewing stitches , and counting one by on for each section then input into the control box now, become especially convenient.

1. Testing mode

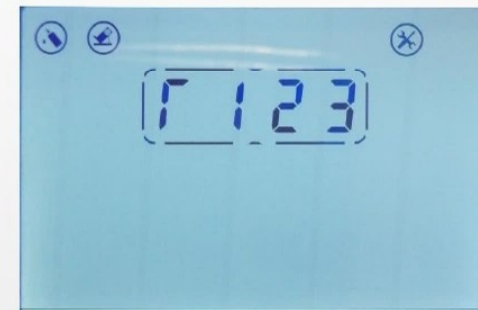
In Multi-section mode , long press **T** button



2. Stitch quantity setting

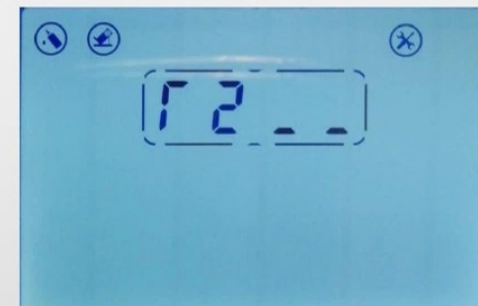
Stitching to required length

As shown, the first section **T1, 23 stitches**
+ or - adjust the quantity



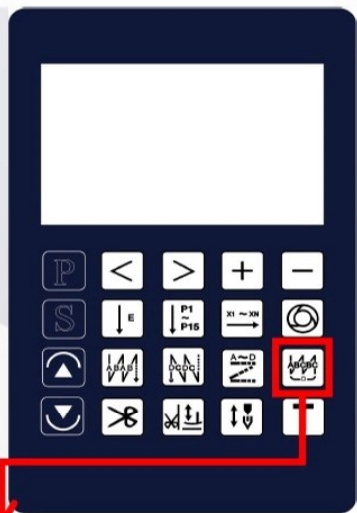
3. Multi-section setting

press **>** button, stitching the second section **T2** setting.
In this way , stitching for each section



Set the quantity of section according to the demand

Press the pedal to trimmer and end the testing mode



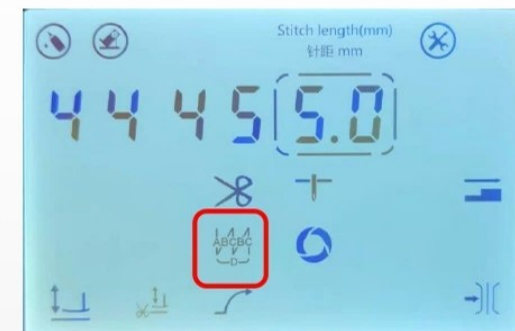
Bar-tacking mode

Bar-tacking(W Sewing)

Bar-tacking mode, for sewing lable or reinforce use

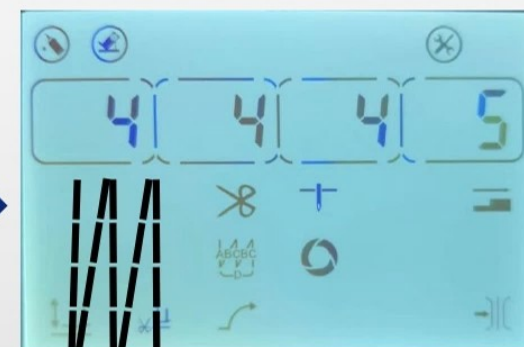
1. Stitch length

press **+** or **-**
adjust **stitch length**
press **S** save



2. Reverse times

press **S** , setting the reverse stitch quantity and reverse times
press **>** , press **+** / **-** adjust
press **S** save
As shown, 4 stitches, 5 times

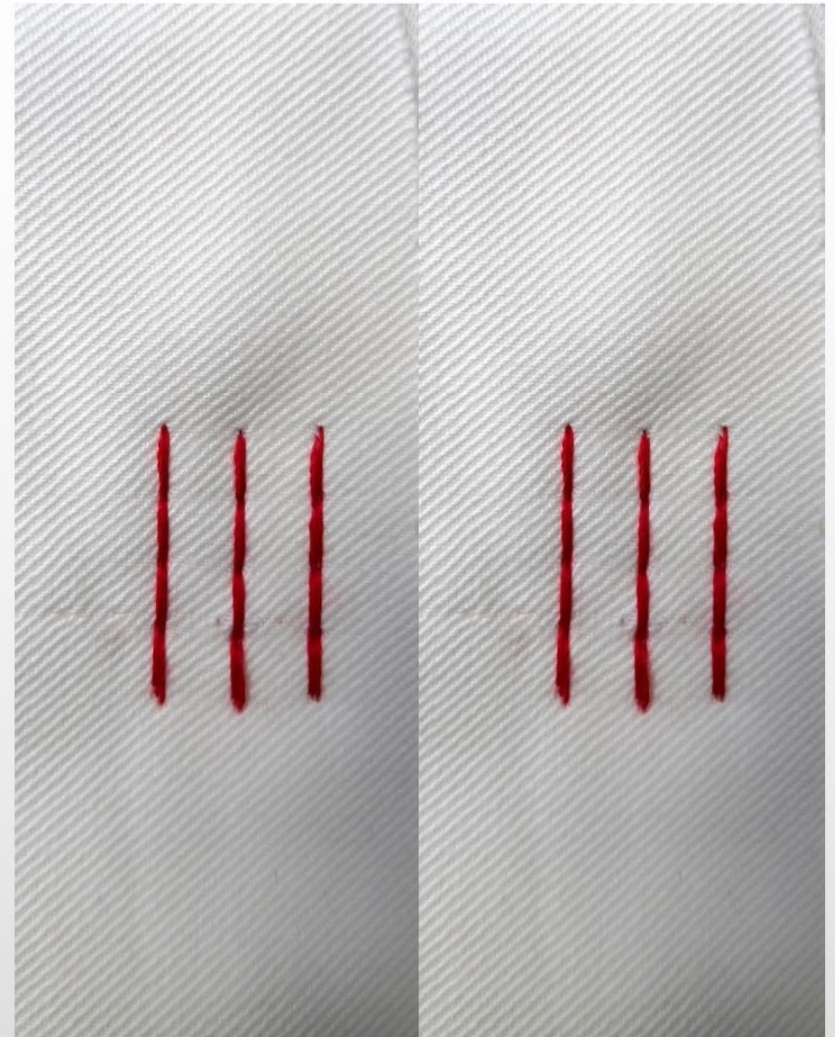


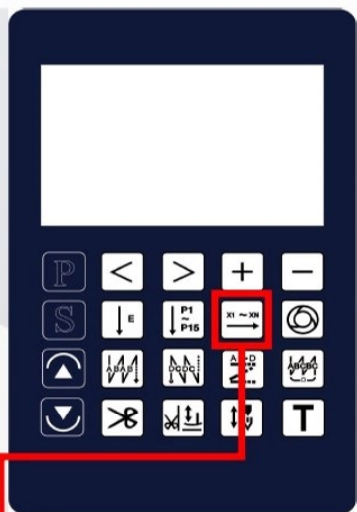
Bar-tacking mode

Pattern introduction

1、 4 stitches

2、 5 times






Multi-section stitch/pattern sewing

Multi-section stitch/pattern sewing

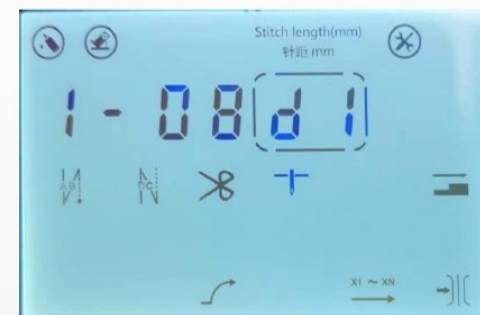
15 section, stitch and pattern setting freedom

press  button, can be sewing automatically

1. pattern/stitch

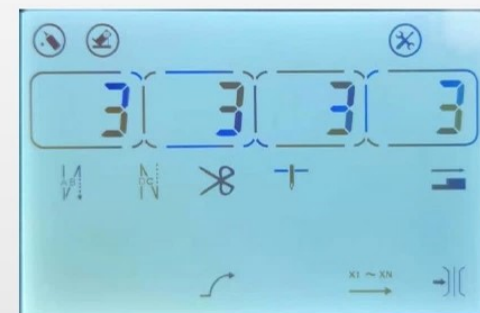
press **+** or **-**
choose **stitch length / pattern** 
press **S** save

press **<** button
+ or **-** change the **stitch quantity**
press **<** button
+ or **-** change the **section**



2. Starting and Ending reverse stitch

press **S**, setting the S/E reverse stitch quantity and reverse mode
press **S** save
press **S** exit



Multi-section stitch/pattern sewing

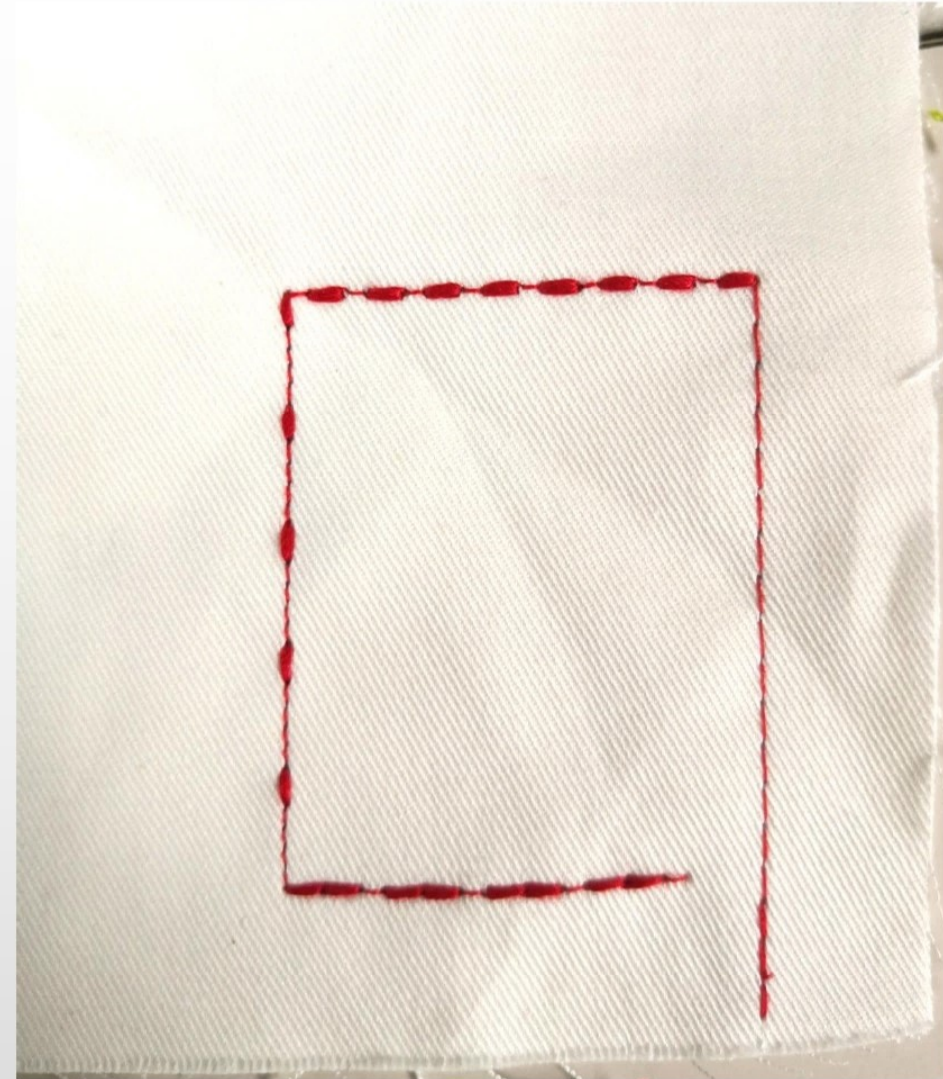
Pattern introduction

1section: starting reverse 3 stitch,
18 stitch, length 4mm

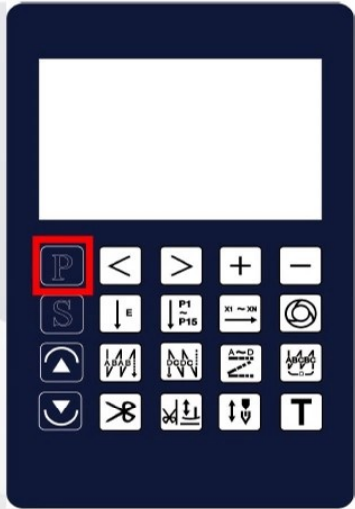
2section: 8 stitch, pattern d1

3section: 5 stitch, pattern d2

4section: 4 stitch, pattern d3



17、 Soft start/ Machine button function

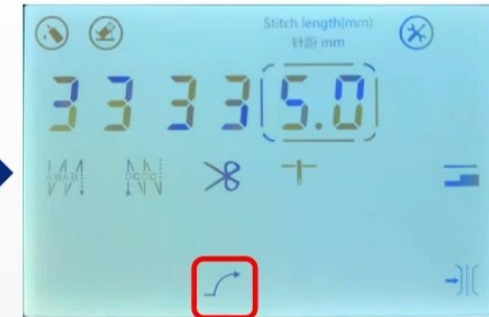


Soft start/ Machine button function

1. Soft start: Reduce the inertia impact of the machine
2. Machine button: Set the button function freely according to the usage habit.

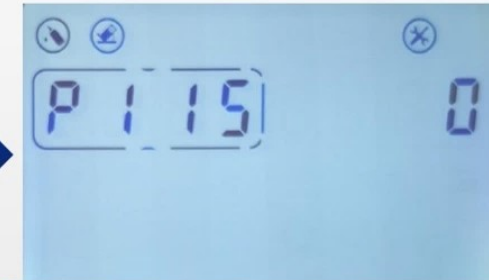
1. Soft start

Parameter P-2
 Setting the soft start
 1-9 stitches
0 for soft start off
 P21-23 soft start stitch 1-3
 sewing speed



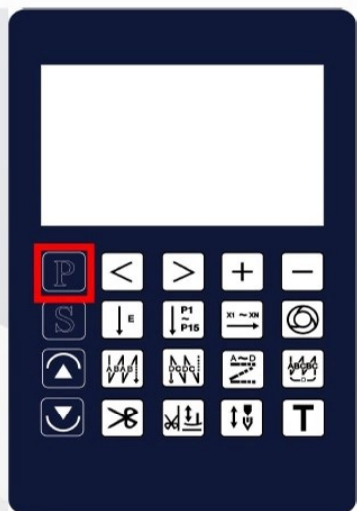
2. Machine button function

Setting the function according the usage habit



Parameter P-115
Reverse function button
 Parameter P-116
Half/one stitch sewing function
 Parameter P-117
Sewing pause ,Small stitch sewing

- 0: reverse
- 1: small stitch sewing
- 2: Half/one stitch sewing
- 3: reverse + Half/one stitch sewing



1. After trimming needle position

long press **P** , choose parameter **P-75** , press **S**

After turning the handwheel for two circle, Stop to the correct after trimming needle position



After trimming needle position

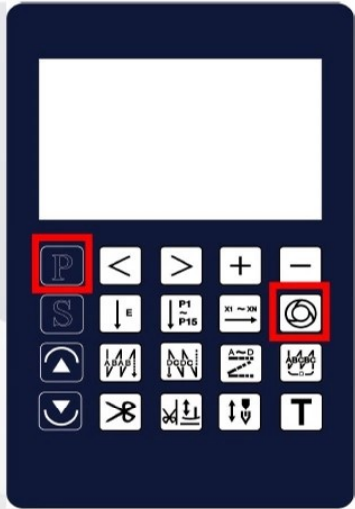
Adjust the after trimmer needle position according the parameter

Noted: only trimmer finished can adjust the position (or switch off, then switch on, then adjust the position)

press **S** save
press **S** exit

suggestion:

after trimmer, thread take up lever from the highest position ,then rises to 1 mm
DBx1, the needle tip is 10mm away from the needle plate
DPx5, the needle tip is 12mm away from the needle plate



Monitoring /Piece counting mode

Monitoring mode: Monitor the current use status of the machine. when control box face problem the manufacturers need that information to provide technical support

Counting mode: Through the statistics of the number of trimmer, statistics of the number of products produced

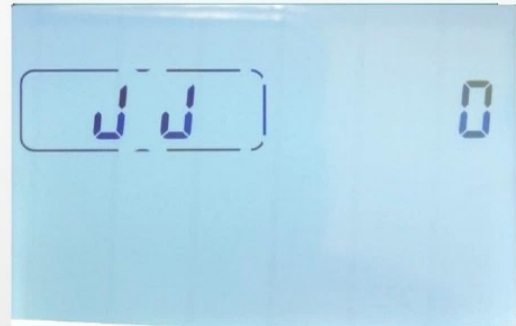
1. Monitoring mode

press **P** +  together
Monitor the current use status of the machine

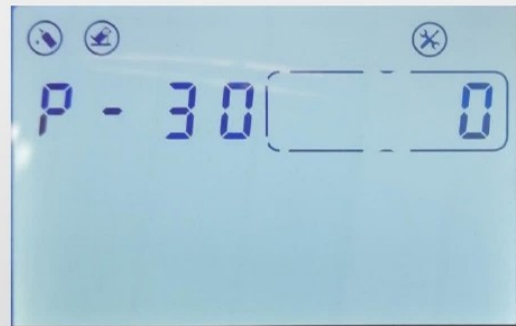


2. Counting mode

Count the number of Production quantity according to trimmer times
JJ counting increment
JP counting decline



parameter P-35
0 counting function off
1 trimmer 1time counting 1
2 trimmer 2time counting 1
3 trimmer 3time counting 1
.....




1. Normal Monitoring


Monitor the current use status of the machine

For manufacturers to provide technical support

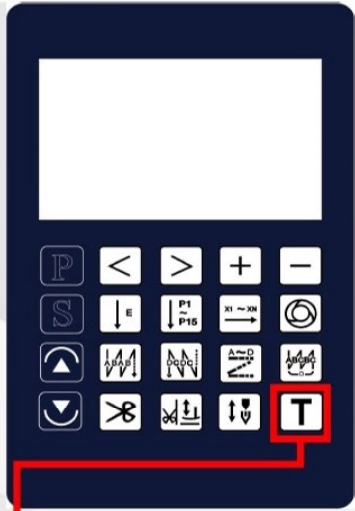
2. Counting mode(JJ / JP)

1. reset the counting quantity ,in JJ mode,press S, and long press  for 3 second
2. P-35 Multiple ratio (according to trimmer times)
3. P-38 JJ counting increment / JP counting decline
4. Counting error: PBOB

3. Hook thread length(DX)

1. reset the hook thread length ,in DX mode,press S, and long press  for 3 second
2. P-30 Hook thread length function **on/off**
3. P-31 Initial value setting
4. Hook thread used up : LBOB

Parameter	content	unit
U1	Motor speed	rpm
U2	Motor current	0.01A
U3	DC voltage	V
U4	Pedal voltage	0.01V
U5	Handwheel mechanical angle	°(degree)
U6	Motor initial angle	°(degree)
U7	Machine model	JIA
U8	DSP version	V100
U9	DSP model	F73
U10	step motor version	V1xx
U11	Step motor current	0.01A
VER	HMI main chip version	v1xx
TYPE	HMI model	C104
AD1	Knee sensor voltage	1mV
AD2	Presser foot sensor voltage	1mV
H1	HMI chip version	V1xx
H2	machine mode	1969
JJ	counting increment	件
Jp	counting decline	件
DX	hook thread length	cm



Motor running angle test

1. Replacement the main motor ,motor encoder and motor disk. need running the angle
2. The wrong angle of the motor will affect the performance, Occasionally,there will be speeding , error,motor heats up,which affects the use.

1. Running the motor angle

long press **T**
choose **1-DJ** , press **S**

step the pedal and run the motor angle Motor angle should be **$268 \pm 10^\circ$**
After running in, press **P** exit



2. Adjustment motor disk

if the angle is wrong , remove the motor cover , adjust the disk adjust once, , run once, until you reach **$268 \pm 10^\circ$** .



Motor running angle test



1.5 Allen key adjust

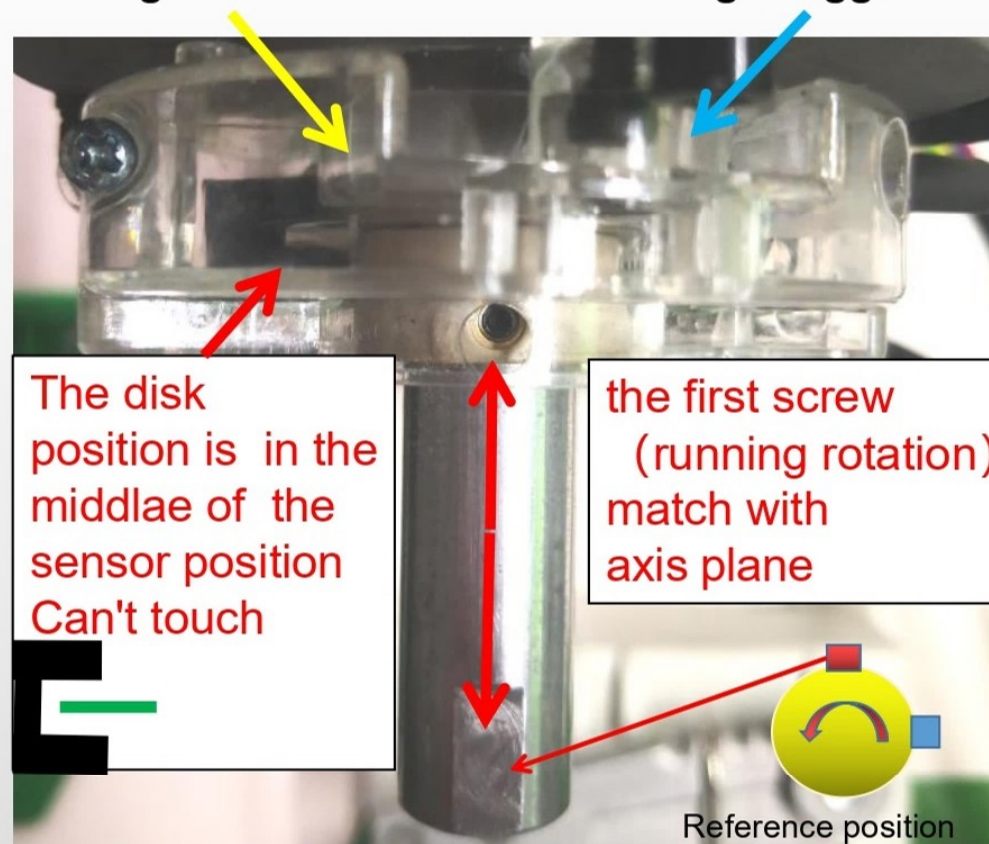
As shown :
adjust once and step
the pedal run once,
until you reach
Within $268 \pm 10^\circ$.

disk Turn left

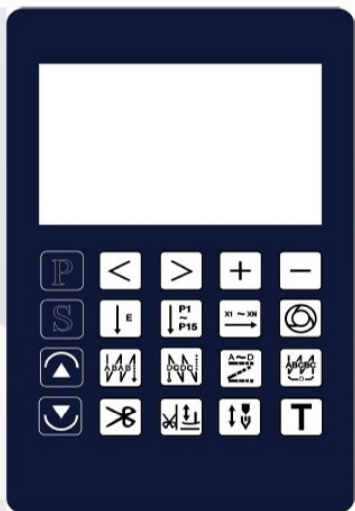
Angel smaller

disk Turn right

Angle bigger



21、Stepping motor original position adjust



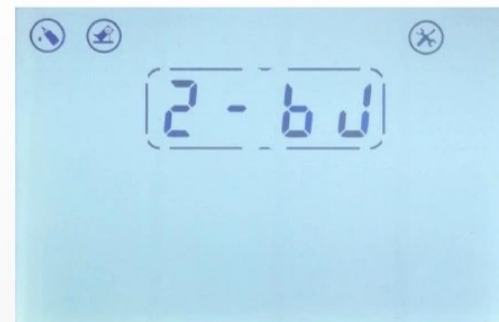
Stepping motor original position adjust

1. Wrong position, stitch length wrong, reverse sewing stitch not overlap
2. In garment factory, due to the fabric, operating habits, mechanical adjustments, etc., the stitches are not beautiful, and the parameters can be fine-tuned

1. original position adjust

long press **T**
choose **2-bj**, press **S**

- P-6: original position
- P-7: stitch length adjustment
- P-8: reverse stitch length adjustment



2. fine-tuned stitch length

P-170: Compensate system enablement by speed

(P171-176) Respectively fix the front reinforcement, Back reinforcement, forward and reverse sew speed compensation



P-180: Compensate system enablement by stitch length

(P181-194) Respectively 1mm-7mm Compensate the stitch length of forward and reverse stitches



21、Stepping motor original position adjust

Stepping motor original position description

Mechanical adjust description

Key points: Stepping motor original position and mechanical stitch original position matching

Stepper motor control the needle base to control the needle stitch

Stepping motor original position: control box stitch show **0.0 mm**, it is control system original position

Mechanical original position: feed dog work with two rods, one rod control the up and down, one rod control the stitch length, so when the **stitch length rod no feeding** and only up/down work work, it is mechanical original position

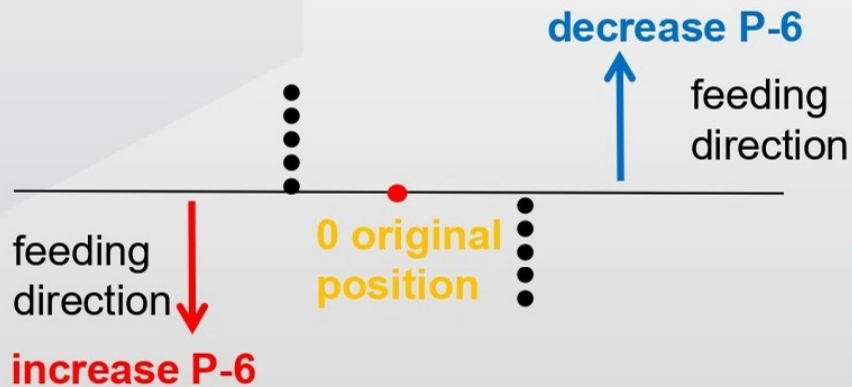
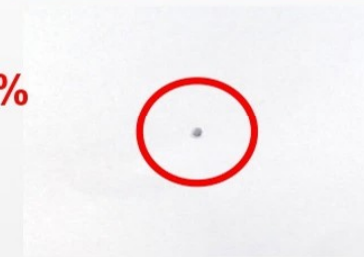
1. Parameter setting:

- ① long press **T**, choose **2-bj**, press **S**
- ② choose **P-6, 0.0** means now stepper motor was in the original position
- ③ take a A4 paper, press foot it, gently step the pedal 20 stitches

needle holes should be overlap

- ④ No overlap → press **S**, adjust **P-6 percentage %**
- ⑤ The best percentage is between **90-110**, after adjustment, press **S** to save as shown

paper **Back**, “↑” **increase** P-6 percentage, press **S**
 paper **Forward**, “↓” **decrease** P-6 percentage, press **S**



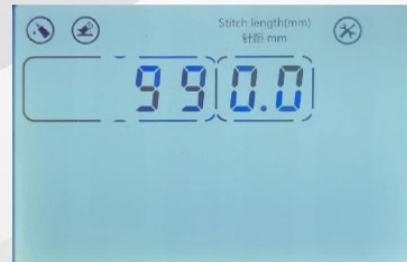
Noted: Beyond the range of 90-110, please adjust the mechanical

2. Mechanical adjustment

⑤ Before adjusting the mechanical, **make the percentage to 100** then start the adjustment (try to make the mechanical and control system 100% match)



⑥ **Parameter fine tuning**: If the mechanical adjust really can not reach the ideal state, **You can fine-tune the percentage of parameters.**



perfect adjustment
all of the stitches are all stuck in one hole.

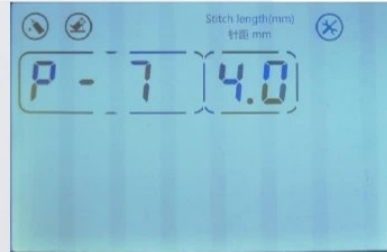


adjustment method

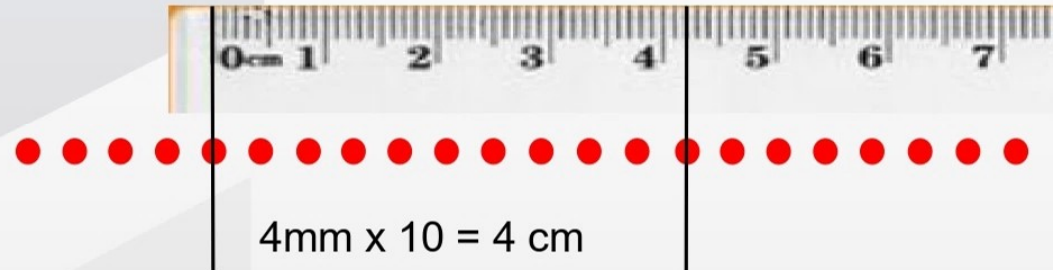
- ① loosen the hexagon screws of the feeding crank, move the crank up and down, and observe the feeding situation at the same time
- ② When the feed rod is not feeding, also, the needle is stuck in the same hole, tighten the screw slightly
- ③ Repeat the test until the zero position is accurate, tighten the screws

3. P-7 stitch length adjustment

- ① long press **T**
choose **2-bj**, press **S**
- ② choose **P-7**, 4.0 means testing stitch 4mm,
< or > can adjust the testing stitch
(4mm is normal use, suggest use for testing)/
- ③ Take a A4 paper, press foot it, gently
step the pedal 20 stitches
- ④ Take the middle 10 stitch and measure with a ruler,
at this time 4mm x 10stitch = 4 cm
- ⑤ press **S**, adjust **P-7 percentage %**

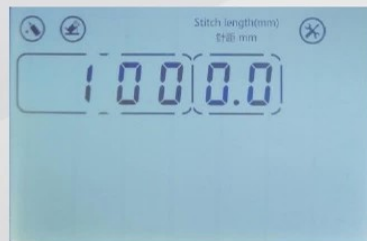


normal stitch



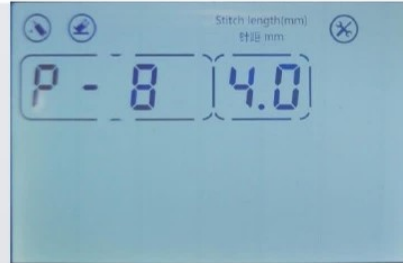
The actual test is **larger than 4 cm**
reduce the percentage of P-7 appropriately

The actual test is **smaller than 4 cm**
increase the percentage of P-7 appropriately

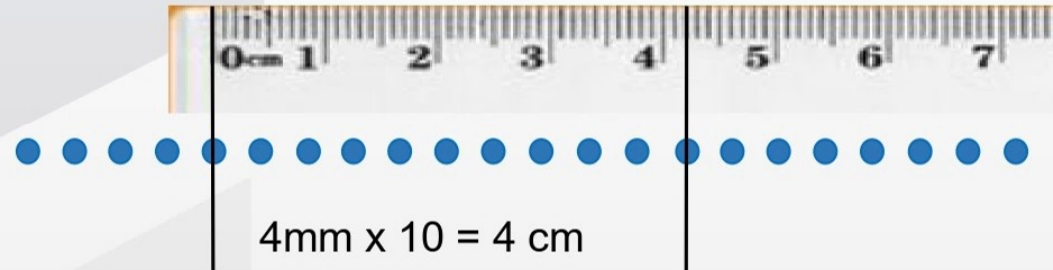


4. P-8 reverse stitch length adjustment

- ① long press **T**
choose **2-bj**, press **S**
- ② choose **P-8**, 4.0 means testing stitch 4mm,
< or > can adjust the testing stitch
(4mm is normal use, suggest use for testing)/
- ③ Take a A4 paper, press foot it, gently
press machine reverse button, step the pedal 20 stitches
- ④ Take the middle 10 stitch and measure with a ruler,
at this time 4mm x 10stitch = 4 cm
- ⑤ press **S**, adjust **P-8 percentage %**



reverse stitch



The actual test is **larger than 4 cm**
reduce the percentage of P-8 appropriately

The actual test is **smaller than 4 cm**
increase the percentage of P-8 appropriately





21、Stepping motor original position adjust

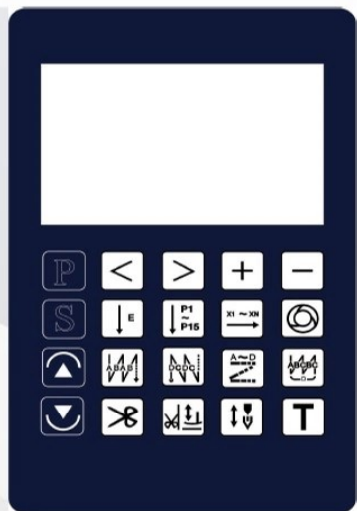
5. Fine adjustment of stitch pitch

No	item	content	range	step	default	level
P-170	Compensate system enablement by speed	=0, P171~P176 Invalid parameter=1, P171~P176 Invalid parameter	0 ~ 1	1	1	II
P-171	Speed clockwise sewing compensation	Speed clockwise sewing compensate system	50 ~ 150	1	100	II
P-172	Speed anti-clockwise sewing compensation	Speed anti-clockwise sewing compensate system	50 ~ 150	1	100	II
P-173	Starting reinforcing-sewing speed Clockwise sewing compensation	Speed Clockwise sewing compensation coefficient	50 ~ 150	1	100	II
P-174	Starting reinforcing-sewing speed Anti-clockwise sewing compensation	Speed Anti-clockwise sewing compensation coefficient	50 ~ 150	1	100	II
P-175	ending reinforcing-sewing speed Clockwise sewing compensation	Speed Clockwise sewing compensation coefficient	50 ~ 150	1	100	II
P-176	ending reinforcing-sewing speed Anti-clockwise sewing compensation	Speed Anti-clockwise sewing compensation coefficient	50 ~ 150	1	100	II

Note: When the garment factory produces, fabrics with different materials, due to the different fabrics have different stretchability, and the lockstitch sewing machine cannot adjust the differential. The stitch length of the positive stitch may become smaller, and the reverse stitch may not overlap well.

Suggested method:

1. Properly adjust the percentages of P-171 and P-172 parameters (open P-170 parameters first, adjust the normal stitch first, and then adjust the reverse stitch)
2. Presser foot pressure adjusting nut pressure (increase the pressure and reduce the pressure have a try)



+ pedal original position

1. pedal original position adjustment

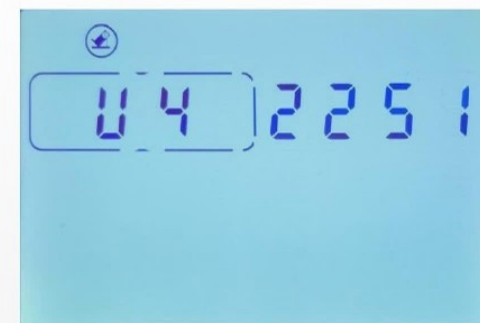
When the machine is not working, the pedal position is original position.

1. pedal original position adjustment

long press **P** + , together

choose U4, as shown, Pedal voltage.

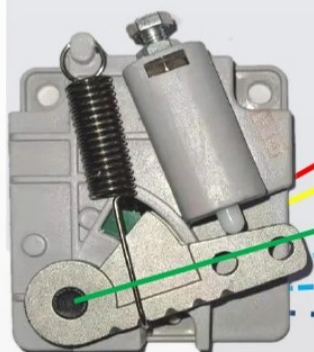
2300±30° is normal
If abnormal, please adjust the pedal magnet.



2. original position Save

long press **T**, choose 3-pd
press **S**, as shown **PDL**
then show **PASS**
press **P** exit





Trimmer position 2 -60°

Presser foot raised -30°

original position 0°

start running 25°

Start acceleration 50°

MAX speed 110°

1. position adjustment

long press **P**

+ or **-** choose the parameter

press **S**

+ or **-** adjust the parameter value

press **S** save

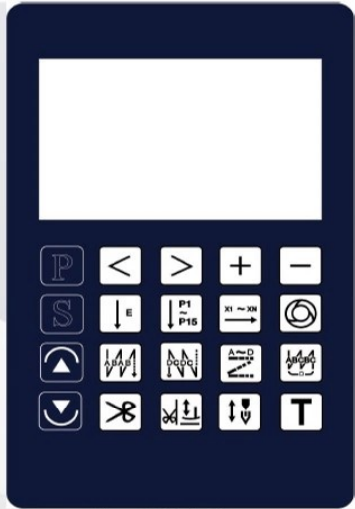
press **P** exit

According to the difference of the operator, set the foot feeling which is suitable for the operator according the parameter.

P pedal working position adjustment

1. original position - pedal stop position
2. start running - where the machine starts to walk slowly
3. Start acceleration- where the machine starts accelerating
4. Presser foot raised-the position where the presser foot starts to work
5. Thread trimming stroke 1-The position of thread trimming without presser foot lifting
6. Thread trimming stroke 2-With the presser foot lifted, the thread trimming position

No.	Items	Range	default
P-62	start running	10 ~ 50 (°)	25
P-63	Start acceleration	10 ~ 100 (°)	50
P-64	MAX speed	10 ~ 150 (°)	110
P-65	Presser foot raised	-100 ~ -10 (°)	-30
P-67	Trimmer position 1	-100 ~ -10 (°)	-30
P-68	Trimmer position 2	-100 ~ -10 (°)	-60



1. Brightness adjustment

long press **P**
choose the parameter **P-129**
press **S**
+ or - adjust the parameter value
press **S** save
press **P** exit



LCD screen Brightness adjustment

1. LCD brightness adjustment, 1-10 level



25、Parameter

No	item	content	range	step	default	level
P-41	Low speed	The lowest speed of pedal	100~500(rpm)	10	200	I
P-42	Pedal curve selection	Pedal speed adjustment 0: normal 1: Slow acceleration 2: Quick acceleration	0/1/2	1	2	I
P-44	thread-cutting speed	thread-cutting speed	100~500(rpm)	10	300	I
P-45	Back-tracking speed limit function	Back-tracking speed processing can prevent reverse sewing needle breakage 0:1: infinite speed limit 2: the speed limit	0/1/2	1	0	I
P-46	presser foot lifting delays sewing	delay with presser foot lowered	0~800(ms)	10	100	II
P-49	Press foot holding time	Lift the pressure foot after holding time to force off	1~60(s)	1	25	II
P-50	output time of total pressure of presser foot lifting	output time of total pressure of presser foot lifting	0~800(ms)	10	150	II
P-51	output duty cycle of presser foot lifting hold time of presser foot lifting	output duty cycle of presser foot lifting hold time of presser foot lifting	0~100	1	40	II
P-53	starting reinforcing-sewing speed	starting reinforcing-sewing speed	100~3000(rpm) 100~2000(rpm)	50	2200 1800	I
P-54	Compensation coefficient of front tacking sewing	Compensation coefficient of front tacking sewing	80~120	1	100	I
P-55	Compensation coefficient of front back tacking sewing	Compensation coefficient of front back tacking sewing	80~120	1	100	I
P-56	ending reinforcing-sewing speed	ending reinforcing-sewing speed	100~3000(rpm)	50	2200	I
P-57	starting reinforcing-sewing of front tacking sewing	starting reinforcing-sewing of front tacking sewing	80~120	1	100	I
P-58	starting reinforcing-sewing of front back tacking sewing	starting reinforcing-sewing of front back tacking sewing	80~120	1	100	I
P-59	Continuous reinforcing-sewing speed	Continuous reinforcing-sewing speed	100~3000(rpm) 100~2000(rpm)	50	2200 1800	I



25、Parameter

No	item	content	range	step	default	level
P-60	Bartack stitch cancel speed limit	0: The software has speed limited 1: No speedlimited	0/1	1	0	I
P-61	A switch to cancel the angle limit when change stitch length	0: Change the stitch length within the limiting angle 1: Vhange stitch length at any angle (The stitch length may not coincide,or the needle may break)	0/1	1	0	I
P-62	Pedal travel upon start	Pedal position upon start (Travel relative to medium pedal)	10~50(0.1°)	1	25	II
P-63	Pedal travel upon acceleration	Pedal position upon start acceleration (Travel relative to medium pedal)	10~100(0.1°)	1	50	II
P-64	Pedal travel at highest rotation speed	Pedal position at highest rotating speed (Travel relative to medium pedal)	10~150(0.1°)	1	110	II
P-65	Pedal travel upon presser foot lift	Pedal position upon pedal lift (Travel relative to medium pedal)	-100~-10(0.1°)	1	-30	II
P-67	Pedal travel 1 upon thread trimming	Pedal position upon start trimming without presser foot functionTravel relative to medium pedal	-100~-10(0.1°)	1	-30	II
P-68	Pedal travel 2 upon thread trimming	Pedal position upon start thread trimming with presserfoot function (Travel relative to medium pedal)	-100~-10(0.1°)	1	-60	II
P-69	Down needle positioning position	To adjust down needle position	0~240	1	175	I
P-70	Reverse needle lift function	Reversal of needle lift function after threadtrimming 0: unavailable 1: available	0/1	1	0	I
P-71	Reversal of needle lift angle	Reversal of needle lift angle	0~45°	1	20	I
P-72	Thread clamp strength adjustment	Adjust the thread clamp strength size0: Cli p line function is invalid1~9: Three Intensity Adjustment	0~9	1	7	I
P-73	Thread pressing actuation angle	Thread pressing actuation angle	10~150°	5	100	I
P-74	Thread pressing release angle	Thread pressing release angle	160~300°	5	270	I
P-75	Needle position adjustment	Needle position adjustment	0~240	1	33	I



25、Parameter

No	item	content	range	step	default	level
P-77	Setting of beauty sewing	0: unavailable 1: available	0/1	1	0	I
P-78	Beauty sewing (close sewing) mode setting	1: Close stitch on start sewing 2: Close stitch on end-sewing 3: Close stitch on both start nad end sewing	1/2/3	1	2	II
P-79	return to factory-set parameter	Special functional parameters 5/8: Restore factory parameters	0~15	1	0	I
P-80	highest speed of sewing	highest speed of sewing	300~5000(rpm)	100	4000	II
			300~3500(rpm)		3000	
P-81	Pedal speed percentage	Pedal speed percentage	50~100	1	100	II
P-82	Trial time	function 0: off 10~1000: power on/ hours	0~1000(hours)	10	0	II
P-83	Strength function	Try if the needle can't penetrate the cloth. 0: invalid; 1~15: intensity adjustment	0~15	1	0	II
p-84	Function of cutting line and adding force	Effective when the cutting wire is an electromagnet; 0: invalid; 1~15: intensity adjustment	0~15	1	0	II
P-85	trimming pull in angle	trimming pull in angle setting	150~200	2	174	II
P-86	trimming strength angle	trimming strength angle setting	200~300	2	260	II
P-87	trimming release angle	trimming release angle setting	300~360	2	340	II
P-88	Loose line suction Angle	Loose line suction Angle	0~360	2	180	II
P-89	Loose line release Angle	Loose line release Angle	0~360	2	350	II
P-90	Language selection setting	Setting of language: 0: turn off 1: Chinese 2: English	0~2	1	1	II
P-91	Change pitch selection	Change pitch selection 0:Changes Allowed 1:Allowed to change	0~1	1	0	II
P-92	Pedal presser foot lift confirm time	Pedal presser foot lift confirm time	10~300(ms)	10	80	II



25、Parameter

No	item	content	range	step	default	level
P-123	Start trimming angle of Paragraph 2	Start trimming angle of Paragraph 2	250~360	2	330	II
P-124	Paragraph 2 stroke of trimming	Paragraph 2 stroke of trimming	0~100	1	65	II
P-125	Stop and trimming during fixed-length sewing	0: invaild 1: vaild	0/1	1	0	II
P-126	loose thread enable when start sewing	0: invaild 1: vaild	0/1	1	1	II
P-127	Delay before start-sewing loose thread	Delay before start-sewing loose thread	0~1000	10	100	II
P-128	Action time of loose thread when start-sewing	Action time of loose thread when start-sewin	0~1000	10	200	II
P-129	Display backlight brightness Setting	Display backlight brightness Setting	0~10	1	5	I
P-130	Voice selection (hide)	Voice selection : invaild 1: vaild	0~1	1	1	1
P-131	Factory parameter saving selection	Factory parameter saving selection : 0.invaild 1. Save all current parameters as factory -level parameters	0~1	1	0	II
P135	Midway reverse function selection	0: unavailable 1: available	0~1	1	0	I
P136	The number of midway stitch set	Pin setting	1~50	1	4	I
P137	Seam midway down the number of times back and forth set	Set times	1~10	1	1	I
P-138	Lock screen function setting	Lock screen function setting: 0: invalid 1: valid	0~1	1	1	I
P-139	Lock screen time setting	Lock screen time setting: 0~240 (s)	0~240	1	2	I
P-140	Delay time before thread hooking of Anti-nest	The delay time between the end of trimming and the hook	0~500ms	5	50	II
P-141	Thread hooking time of Anti-nest	The action time of the hooked electromagnet	0~500ms	5	50	II
P-142	Delay after Anti-nest hook	The delay time of the hook electromagnet turning off	0~500ms	5	50	II
P-143	Thread hooking duty ratio of Anti-nest	Adjust the action force of the hooked electromagnet	0~100	1	100	II



25、Parameter

No	item	content	range	step	default	level
P-144	Anti-nest suction work time	The work time of the suction valve	0~2000ms	10	250	II
P-145	Thread-straight work time of Anti-nest	The work time of a thread-straight solenoid	0~500ms	5	50	II
P150	Maximum setting	Maximum needle distance setting 5mm model parameter scale (1.0mm~5.0mm) 7mm model parameter scale (1.0mm~7.0mm)	10~50 (70) mm	1	50	II
P-151	First off-line prevented stitch length	0.invaild 1.vaild	0~1	1	0	II
P-152	First off-line prevented stitch length setting	Stitch length setting Parameter range (1.0mm~5.0mm)	10~50	1	40	II
P-153	Head button inching mode setting	0: Invalid 1: valid (Press once valid ,press again cancel, such as close sewing, over thickness, presser foot)	0~1	1	0	II
P-155	Needle bar lamp brightness setting	0: Needle bar light off 1~5: Adjust the brightness of needle bar lamp of 5 gears (HMI control 0/1/2/3/4/5/0switch)	0~5	1	5	II
P-170	Compensate system enablement by speed	=0, P171~P176 Invalid parameter=1, P171~P176 Invalid parameter	0~1	1	1	II
P-171	Speed clockwise sewing compensation	Speed clockwise sewing compensate system	50~150	1	100	II
P-172	Speed anti-clockwise sewing compensation	Speed anti-clockwise sewing compensate system	50~150	1	100	II
P-173	Starting reinforcing-sewing speed Clockwise sewing compensation	Speed Clockwise sewing compensation coefficient	50~150	1	100	II
P-174	Starting reinforcing-sewing speed Anti-clockwise sewing compensation	Speed Anti-clockwise sewing compensation coefficient	50~150	1	100	II
P-175	ending reinforcing-sewing speed Clockwise sewing compensation	Speed Clockwise sewing compensation coefficient	50~150	1	100	II
P-176	ending reinforcing-sewing speed Anti-clockwise sewing compensation	Speed Anti-clockwise sewing compensation coefficient	50~150	1	100	II

Error Code	Contents	Possible reasons	Checking and treatment
E011E012	Motor signal error	Motor position sensor signal failure	If electric engine plug is well contacted;if electric engine signal detecting device has been broken;if sewing machine handwheel correctly installed.
E021E023	Motor overload	motor stall motor overload	If electric engine plug is well contacted;if machine head or thread-cutting mechanism has been blocked completely;f materials are too thick;Electrical signal detection signal whether the normal.
E101	Hardware drivers fault	Current detection abnormal Driving hardware error	Current detection loop system is working properly;Whether the damage to the device driver.
E111E112	Voltage too high	High input voltage Brake circuit fault Voltage detection error	System into line voltage is too high;Braking resistance are working properly;System voltage detection circuit are working properly.
E121E122	Voltage too low	Actual low voltage Voltage detection is wrong	If the voltage on the inlet wire is too low Whether the system voltage detection circuit the normal work.
E131	Current circuit fault	Current detection abnormal	Current detection loop system is working properly.
E133	Oz circuit fault	Oz circuit fault	Oz circuit system is working properly.
E134	DBFLT malfunction	Automatic resistance circuit failure	Brake resistor plug is in good contact Brake resistance is damaged
E201	over current	Current detection error	Current detection loop system is working properly Electrical signal is normal.
E211E212	Abnormal motor operation	Current or voltage detection error	If electric engine plug is well contacted If electric engine signal
E301	Communication error	Sci circuit error	if operation box plug is well contacted;if operation box components are damaged.
E302	Operation inner failure	Sci circuit error	check whether the operating box is damaged.
E303	SPI Communication breakdown	Sci circuit error	check whether the main control board is damaged.
E304	HMI From the main chip communication failure	Sci circuit error	check whether the operating box is damaged.
E402	Pedal ID fault	Pedal verification fault	Pedal connection is loosen.

Error Code	Contents	Possible reasons	Checking and treatment
E403	Pedal zero position fault	The pedal zero position over range	The pedal is damaged or it is not under stop state when correction
E501	Safety switch fault	Safety switch effective	Put down the head or check turned up switch.
E502	Fuel fault alarm	Fuel fault alarm	Add oil Tips
E601	Hardware drivers fault	Feed motor STEP2 hardware overcurrent	Current detection loop system is working properly;Whether the damage to the device driver.
E602	Hardware drivers fault	Feed motor STEP2 software overcurrent	Current detection loop system is working properly;Whether the damage to the device driver
E603	Hardware drivers fault	Feed motor STEP2 Current detection circuit	Current detection loop system is working properly;Whether the damage to the device driver.
E604	Motor signal error	Feed motor STEP2 The initial mechanical angle	Feed motor connector is a good contact
E605	Motor signal error	Feed motor STEP2 at the start, Encoder or rotor stuck	Feed motor connector is a good contact Machinery is stuck
E606	Hardware drivers fault	Feed motor STEP2 Motor winding circuit	Current detection loop system is working properly;Whether the damage to the device driver.
E607	Hardware drivers fault	Presser foot trimming motor STEP1 hardware overcurrent	Current detection loop system is working properly;Whether the damage to the device driver.
P.oFF	Power off Display	Power off	Wait for power supply to resume.
EvAL	Trial expired	Trial expired	Contact the dealer processing
L.bob	The bottom line tips	The bottom line count value is negative	After replacing the bottom line, press P to cancel the Alert Status
P.bob	Remind of counting by piece	The number of counting is 0	Press S key to enter the interface, and long press "front seam" button for more than 2 seconds to cancel the prompt state