本墨作指导为简易版墨作说明,旨在进行基本的操作指导,如有不明之处,诸参考完基版用户手册。

工业缝纫机数控交流伺服系统简易操作说明

1. 产品说明

1.1 产品介绍

工业缝纫机数控交流伺服系统,采用全新结构设计,体积小巧,结构紧凑,外形美观,安装灵活方便。 电路设计采用驱动与主控分离的设计技术,有效阻断电源驱动电路给主控电路带来的干扰,使得伺服系统具 有比同类产品更为优秀的稳定性及更长的使用寿命。优化常规开关电源的设计方式,提高了伺服系统的工作 旁室的同时, 降低了整体功耗, 因此更为省电, 发热量更小。且有电路保护功能, 防止电源短路烧得电路 深度优化了系统的控制算法,使其具有比传统控制方法更高的精度控制,更快的响应速度等工作特点。本系 统具有极为方便的上针位调整方法,大大减少了上针位的调整时间,使得调试、装机流程变得极其简单。

1.2 产品组成 同服系统组成包括:

主件部分:伺服主控箱,操作面板,脚路控制器,永磁伺服电机。

 2. 附件部分,操作面板安装支架,使用说明书,由源线,球节连杆,固定螺纹。 青杏园产品组成清单,并且仔细检杏包装箱内的产品部件,如有遗漏,请尽快与供应商联系。

1.3 技术规制	*	产品组	成清单		
项目名称	指标	编号	名称	单位	数量
額定输入电压	220V±10%	1	主控箱	台	1
額定输入頻率	50/60HZ	2	操作面板	个	1
額定输出功率	750W	3	脚踏板控制器	台	1
电机最大转速	5000rpm	4	交流永磁伺服电机	台	1
输出最大扭矩	3.5Nm	5	操作面板安装支架	个	1
		6	使用说明书	本	1
		7	电源线	根	1
0 18.44-26 m		8	球节连杆	套	1
2.1来TF1况明		9	固定螺丝	袋	1
	● ● ● ● ● ● ● ● ● ● ● ● ● ● ● ● ● ● ●			A EG 日 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一 一	в В.В мии ял

功能	按键	说明	显示屏图标
功能参数编辑键	Ρ	进入或退出功能参数的编辑;在缝纫模式状态时按键2~3秒进入 参数编辑状态,在参数编辑状态按下键2~3秒退出参数编辑状态 返回缝纫模式状态	
参数查看保存键	S	对所选参数号内容进行查看和保存:选择好参数号后按此键可以 进行查看和修改操作,修改参数值后按此键则退出并保存参数	
净压遗储		加速键:提高运行速度	
从二/支,目初4,885	►	减速键: 降低运行速度	
参数增减键	Ð	增大参数键	
2 20.012	\bigcirc	減小参数键	
针数设定选择键	\bigcirc	参数设置切换键	
触发自动功能键	9	触发自动功能选择,当触发功能键激活时,显示屏显示图标(只 在定长缝中有效)	0
停针位置选择键		选择上下停针位,默认状态为上停针位,当显示屏显示图标时表 示选择上停针位	<u>11</u>
慢速启动设定键	$\boldsymbol{\checkmark}$	慢速启动设定,当显示屏显示图标时,启动慢速启动功能	<u>_</u>
中途停车自动抬 压脚设定键	F	设置中途停车时是否自动抬压脚,当显示屏显示图标时,激活中 途停车自动抬压脚功能	Ľ
剪线自动抬压脚 设定键	F.X	剪线后自动抬压脚,当显示屏显示图标时,激活剪线后自动抬压 脚功能	тı _x
连续回缝设定键	W	连续回缝功能设定,当显示屏显示图标时,激活连续回缝(W缝) 功能	W
自由缝设定键		自由缝功能设定,当显示屏显示图标时,激活自由缝功能	
扫绘网络巩实体	N	起始单回缝,B段缝功能设定,设置AB段回缝,显示屏显示相应 图标	ΝN
起始回继反正键	¥	起始双回缝功能设定,当显示屏显示图标时,激活起始双回缝功 能	W
终止回绕设定键	\sum	终止单回缝,C段缝功能设定,设置CD段回缝显示屏显示相应图标	NN
或正因睡夜花睡	X	终止双回缝功能设定,当显示屏显示图标时,激活终止双回缝功能	М
	ŀ	执行E段定长缝,当显示屏显示图标时,激活E段定长缝功能	ŀ
正式確议正確	***	多段缝功能键,交替设置四段缝,七段缝,自定义多段缝模式,显示屏显示相应图标	
剪线开关	\gg	设定是否剪线功能,当显示屏显示图标时,激活剪线功能	\gg
提针与补针	11	执行补针,提针功能,详见功能说明	
速度显示	-	显示当前电机速度档位	

2.2.2 用户参数设置模式

在用户参数设置模式时,可以根据缝制需要调整各类缝纫功能的技术参数,参数设定步骤如下: 1. 在缝纫模式下按P键2~3秒进入用户参数设置模式。

- 2. 进入用户参数模式后默认参数号选择界面,同时可以通过+-键来选择参数号
- 选择好参数号后按下S键进入参数修改界面进行参数值查看,可以通过+ -键来设置参数值。

4. 设置参数值后按S键保存参数值并退出至参数号选择界面5. 按P键2~3秒 退出系经参数设置模式,返回一般缝纫模式 用户参数麦

参数号	名称	出厂值	范围	说明
Fn – 01	最高转速(r/min)	3600	100~5000	最高转速设定
Fn – 02	加速曲线调整(%)	80	10~100	控制器的加速爬升斜率设定
Fn – 03	起始回缝速度(r/min)	1800	$150 \sim 2800$	起始回缝的速度设定
Fn – 04	终止回缝速度(r/min)	1800	$150 \sim 2800$	终止回缝的速度设定
Fn – 05	连续回缝速度(r/min)	1800	$150 \sim 2800$	连续回缝的速度设定
Fn – 06	慢速启动速度(r/min)	300	$150{\sim}2800$	慢速启动的速度设定
Fn – 07	慢速启动针数(针)	2	0~99	慢速启动的针数设定
Fn – 08	定长缝自动运行速度(r/min)	3200	$300 {\sim} 4500$	触发自动功能键按下时的速度设定
Fn – 09	定长缝后自动执行终止回缝功 能	1	0~1	1. 在执行完最后一段定长继后,将自动执行终止回 缝。即在任何缝动模式下,终止回缝前不能作补针, 0: 在执行完最后一段定长继后,将无法自动执行终 上回缝边枪,必须重新再作前或全后踏动作始可。
Fn – 10	点动倒缝时功能模式选择	1	0~1	手按车头回缝开关动作时机: 1:JUKI方式(即在车缝中和停止时均执行倒缝动作) 0:BROTHER方式(即在车缝中执行倒缝动作,在停 止时执行补针动作)
Fn – 11	起始回缝运行模式	1	$0 \sim 1$	 轻敏踏板,自动执行回缝动作 受踏板控制,可任意停止与起动
Fn – 12	起始回缝结束模式	1	$0 \sim 1$	 起始回缝完成后,自动连续下一段功能; 2. 起始回缝段针数完成后自动停止
Fn – 13	起始回缝补偿-1	60	$1 \sim 150$	起始回继A段针迹补偿
Fn – 14	起始回缝补偿-2	60	$1 \sim 150$	起始回维B段针迹补偿
Fn – 15	终止回缝运行模式	1	$0 \sim 1$	 轻触踏板,自动执行回缝动作 受踏板控制,可任意停止与起动
Fn – 16	终止回缝补偿-1	60	$1 \sim \! 150$	终止回继C段针迹补偿
Fn – 17	终止回缝补偿-2	60	$1 \sim \! 150$	终止回继D段针迹补偿
Fn – 18	连续回缝运行模式	1	0~1	 轻触踏板,自动执行回缝动作 受踏板控制,可任意停止与起动
Fn – 19	连续回缝补偿-1	60	$1 \sim \! 150$	连续回缝A,C段针迹补偿
Fn – 20	连续回缝补偿-2	60	$1 \sim \! 150$	连续回维B, D段针迹补偿
Fn – 21	停针位置选择	1	0~1	当无外接操作面板时的功能设定: 1(上停针)/0(下停针)
Fn – 22	慢速起缝功能设定	0	$0 \sim 1$	当无外接操作面板时的功能设定: 1(启动)/0(关闭)
Fn – 23	剪线自动抬压脚设定	0	0~1	当无外接操作面板时的功能设定: 1(启动)/0(关闭)
Fn – 24	中途停车自动拾压脚设定	0	0~1	当无外接操作面板时的功能设定: 1(启动)/0(关闭)
Fn – 25	触发自动功能设定	0	0~1	当无外接操作面板时的功能设定: 1(启动)/0(关闭)

Fn – 26	自动扫线/夹线功能设定	1	0~2	0 (关闭) / 1(启动扫线功能) / 2(启动夹线功能)
Fn – 27	夹线器动作机械角度	180	$1 \sim 300$	夹线器动作角度
Fn – 28	夹线器释放角度	300	30~330	夹线器释放角度(线头长度控制)
Fn – 36	剪刀停车反转提针控制模式	0	0~2	关闭[0]/开启[1]/剪刀联动关开[2]
Fn – 37	剪刀停车反转提针角度	40	$20 \sim 90$	剪刀停车反转提针角度
Fn – 38	脚踏板行程宽度比(%)	100	$30{\sim}100$	脚踏板行程宽度比(%)
Fn – 39	车缝完成件数显示	-	$0 \sim 99999$	车继完成件数显示

2.2.3 系统参数设置模式

3.1.2 磁钢模式

在系统参数设置模式时,可以根据缝制需要调整各类电磁铁参数以及系统设置,参数设定步骤如下: 1. 在关机状态,按住P键,同时开启电源为系统上电,系统启动后即进入系统参数设置模式,在此模式下,可以对系约 参数讲行修改,同时也可以对用户参数讲行修改。

通过+ -键来选择参数号,按下S键进入参数修改界面进行参数值查看和修改。

3. 设置参数值后按S键保存参数值并退出至参数号选择界面 4. 按P键2~3秒退出系统参数设置模式, 返回一般缝纫模式 系统参数表

ALL DATE				
参数号	名称	出厂值	范围	说明
Fn – 40	马达转动方向设定			保留
Fn – 41	电机停止时,刹车锁住功能	0	$0 \sim 1$	 电机停止时,刹车锁住车头 无作用
Fn – 42	自动运行测试功能	0	0~1	1: 启动 0: 关闭 该参数设置为1时,自动运转测试开始,按操作面板设 置的缝制模式运行
Fn – 43	电机自动运转测试的总限时间 (hr.)	8	$1\!\sim\!800$	当 Fn = 42=1 时有效 电机自动运转测试的总限时间
Fn – 44	测试时电机运转时间(s)	3	$1{\sim}30$	当 Fn = 42=1 时有效 电机自动运行测试周期内的工作时间
Fn – 45	测试时电机停止时间(s)	3	$1{\sim}60$	当 Fn - 42=1 时有效 自动运行测试时,每次的间隔时间
Fn – 46	最低速度设置(r/min)	200	$100\!\sim\!500$	电机最低速度限制调整
Fn – 47	切线、停车的速度设定(r/min)	300	$100\!\sim\!500$	切线停车的速度调整,速度过低可能导致无法正常切 线,速度过高可能导致定位控制不平稳
Fn – 48	抬压脚、回缝电磁铁全额初始 出力的动作时间(ms)	300	0~990	抬压脚、回缝电磁铁开始动作时,全额出力动作时间
Fn – 49	回缝电磁铁动作的周期信号 (%)	30	10~90	回缝电磁铁动作时,以周期性省电输出,避免抬压脚 电磁铁发烫
Fn – 50	延迟马达启动,保护抬压脚下 放时间(ms)	50	0~990	踩下时延迟启动时间,以配合自动抬压脚放下的确认
Fn – 51	半后踏释放剪刀抬压脚	1	$0 \sim 1$	 半后踏时,有抬压脚释放功能 半后踏时,无抬压脚释放功能
Fn – 52	安全开关信号形式	0	$0 \sim 1$	 1:安全开关入力信号,必须保持常开状态 0:安全开关入力信号,必须保持常闭状态
Fn – 53	切线动作前延迟机械角度(度)	189	$120{\sim}250$	找到上定位后进至切线时序前所需的间距机械角
Fn – 54	切线动作完成前延迟机械角度 (度)	360	$250\!\sim\!360$	切线时序所需的动作角度
Fn – 55	扫线动作前延时时间(ms)	10	$0 \sim 980$	找到上定位后进至拨/扫线时序的问距时间
Fn – 56	扫线动作时间(ms)	70	0~9990	裁/扫时序的动作时间

1时,上针位定位模式为磁钢式,设置方法如下: (注意,磁铜模式时,上针位设置好后,只要手轮、电机未被拆卸、移动过,都无需重新设 COD 置上針位。) 0 1. 上电后,观察针位位置,通过调节手轮上的磁钢调节螺丝,调整上针位。 2.踩下脚踏板,观察上针位停针位置。 3. 边调整边观察上针位置直至达到用户要求为止。 3.2 参数复制粘贴功能 1. 在关机状态,按住S键,同时开启电源为系统上电,系统启动后即进入特殊功能设置模式,进入特殊功能设置模式模 式后,显示屏显示功能代码选择界面,同时可以通过←键来选择代码号。 2 功能代码设置为·0011 即为执行参数款贴复制功能的代码。 3. 按下 触发自动功能键 🙆 将执行粘贴功能,即将操作面板参数内存中的参数粘贴到主控板的参数内存中。 按下 剪刀键,将执行复制功能 🔀,即从主控板的参数内存中将参数复制到操作面板的参数内存中。 3.3 出厂参数初始化 1.首先进入系统参数模式,系统参数模式的进入方法参见 "2.2.3 系统 恢复参数方式的执行代码 参数设置模式"章节。 输入(1111),从默认参数区恢复参数 2. 讲入系统参数模式后, 将参数号调整到 Fn-79, 按S键讲入参数后显示 届会显示代码输入界面。 3. 在代码输入界面上输入不同的代码将执行不同的恢复方式,如右表所示: 输入(5555):操作面板恢复默认参数 4 加丁件教统计 . 长按S键,显示屏将显示如左图所示的加工件数统计。每一次缝纫周期结束,记为完成一件加工件 在一般缝纫模式下, 5 电机实时速度监视 在用户参数设置模式或者系统参数设置模式界面下长按加速调节键 🔺,将做为电机转速监视功能。 故障处理与维护 E r r. 0 时与我们技术人员联系。报警显示如左图(Err-01): 故障代码对应含义及解决方法如下表。

故障代码	代码含义	解决方法
Err-0	输入信号自检错误 (上电脚踏板故障测试)	 检查脚踏板的信号是否连接正常 松开脚踏板,回复中立位置
Err-2	EEPROM读/写数据错误	更换EEPROM
Err-3	EEPROM内设置参数错误	上电重启
Err-4	过流、过压、超温、欠压	 1. 关机30秒后重新上电检查是否正常。 2. 电机功率模块可能发生故障。 3. 检查是否发生瞬间干扰。
Err-5	直流母线电压超压	 1. 关机30秒后重新上电检查是否正常。 2. 检测电源电压是否正常。
Err-6	电磁铁供电电源过流	 1. 关机30秒后重新上电检查是否正常。 2. 关闭系统,检查电磁铁回路是否连接正常。
Err-7	堵转	关闭系统,检查缝纫机机械结构是否正常。
Err-8	电机编码器输出信号错误	检查电机输出信号线是否断线或者连接不良。
Err-9	同步器自检错误	 关闭系统,重新连接同步器。 更换同步器。
Err-E	缝纫机(机头)保养提示	缝纫机运行时间达到所设置的保养周期,请对机头进行保养操作后,进入FN-67参数设0清除累计运行时间。
Err-F	安全开关警告	 机头被翻开。 检查安全开关回路是否连接正常。

Fn - 58 年雄健止自行(政治)(新興上介格 持日間(1)) 30 1-120 年雄樹止自行(政治)(新興上介格(陸)) (次) 15 100 第4世世(1) (次) 15 101 第4世世(1) (次) 100	Fn – 57	拾压脚动作前的延迟时间(ms)	50	$0\!\sim\!990$	拨/扫动作完局	言进至抢压脚时序前的问距时间
Fn -59 上份年代會小計的設定置(中心電力) (2) 15 1-0 10 <	Fn – 58	车缝停止时自动抬压脚上升维 持时间(s)	30	1~120	车缝停止日	时自动抬压脚上升维持时间
Fn - 60 序件社会件出的位置调整 (0) 180 120 - 220 用用目上平序件性容少与的的现在常、面电高少好 发展符件、整理和助合发起得行 Fn - 61 上也后自动找上定位	Fn – 59	上停针位停止时的位置调整 (度)	15	1~30	微调修正上停针位停止时的角度位置(中心数 15): 数值减少时会提前停针,数值增加时会 针	
Fn-61 上地信印換比定使 一一 一一 受問 Fn-62 正常停车速率(%) 305 30-199 「現建正等停车速率(%) Fn-63 切战停车速率(%) 925 30-199 「現建正等停车速率(%) Fn-64 明確能学時间(s) 30 1-120 「評価電報告诉問願係 Fn-65 「認識水油面定(%) 25 10-05 「認識報告诉問願係 Fn-66 「認識水油面定(%) 25 10-05 「認識報告诉問願所 Fn-66 「認識水面容(%) 10 0-5 「認識報告诉問問問問 Fn-66 「認識和書意情的期間 30 10-99 「言語本自己、注意保護 Fn-68 「認識取得支援手術」 0 0-999 「言語本自己、注意保護 10 Fn-69 算能上住信務局面 0 0-999 「言語本自己、注意保護 10 10 Fn-70 万族成為信息作((%) 0 0 9999 三式成点点点面 10 Fn-71 現成編得意識比違、 二 0-159 三式成点点点面 10 10 10 Fn-73 山磁強強性 一 0 9.999 30 10 10 10 10 <th>Fn – 60</th> <th>下停针位停止时的位置调整 (度)</th> <th>180</th> <th>$120\!\sim\!220$</th> <th>微调修正下停针位 提前停针</th> <th>停止时的角度位置:数值减少时; ,数值增加时会延迟停针</th>	Fn – 60	下停针位停止时的位置调整 (度)	180	$120\!\sim\!220$	微调修正下停针位 提前停针	停止时的角度位置:数值减少时; ,数值增加时会延迟停针
Fn -62 正常今末連年(%) 325 30 - 1999 現態日素学未準本 Fn -63 切技停车連年(%) 925 30 - 1999 現態日数や指導本 Fn -64 阿酸化学目標(%) 30 1~120 F840-0186 / 0198/8. Fn -65 低速目な掛け目(%) 25 10 - 80 F840-0186 / 0198/8. Fn -66 低空目の時間(%) 25 10 - 80 F862/8. 60.088/8. Fn -66 低空目の時間(%) 1 0 - 5 562/8. 60.088/8. Fn -67 松広卿也観歌介作的周期信句 0 0 - 9999 完成世界の時間(%) 20.0 Fn -68 埴敷肌(低く)の茶月期時间 (br.,) 0 0 - 9999 完成世界の(%) な 周期時) 10.0 Fn -69 直楽上日を編集後命信 - 0 - 1599 見定年の(%) - Fn -71 机式協等器線や載虫 - 0 - 1599 見楽市長振会(%) - Fn -73 电磁戦能電信 - 0 - 1599 見楽で目的長振会(%) - Fn -74 脚踏能変化(%) 公務事例 - - - - Fn -75 付服素性(%) 公務事例 - - - -<	Fn – 61	上电后自动找上定位				保留
Fn -63 切线停车速率(%) 925 20-1999 現態以換停車準 Fn -64 阿爾曼科学時间(x) 30 1-120 阿爾曼科学時间(x) 30 10-120 阿爾曼科学校局(x) 64% </th <th>Fn – 62</th> <th>正常停车速率(‰)</th> <th>325</th> <th>$30\!\sim\!1999$</th> <th>i</th> <th>周整正常停车速率</th>	Fn – 62	正常停车速率(‰)	325	$30\!\sim\!1999$	i	周整正常停车速率
Fn - 64 回題程が时间(3) 30 1~120 評価連載(24,24) (#12,44)(24,24) Fn - 65 低速度分類時間送産 25 10~80 低速度分類時間送産 Fn - 66 低速度分類時間送産 1 0~5 低速度分類時間送産 Fn - 66 低速度分類時間送産 1 0~5 パスペロン Fn - 67 指応期中に載成为性的周期信 0 0 7.9999 fn - 68 確認知(43,3 位界周期时) 0 0~9999 225 位式の引用した 2.900 Fn - 68 産素成素的な信息化(9) - 0 0.900 225 (#12,63) 2.91(#) 2.91(#) Fn - 69 直接公共信息度度(20,24) - 0 9000 2.91(#) 2.91(Fn – 63	切线停车速率(‰)	925	$30\!\sim\!1999$	i	周整切线停车速率
Fn-65 低速度分離時期度(3) 25 10-80 低速度改加時期度(3) Fn-66 低速度分離時期度(3) 1 0-5 17828年、558128 Fn-67 指応期电磁吸消費的期后(3) 10-90 約5.588128 10.8928 Fn-67 指応期电磁吸消費的期后(3) 0 10-90 約5.588128 20.055318 Fn-68 虚砂肌(10,3) 保奈用期时(1) 0 0.9999 202649(4,3) 保急用期時(1) 20.055318 Fn-69 直接出件检索器化度(1,2) - 0 20.000 202649(4,3) 保急局消费(1) 10.000 Fn-703 直接放弹信息低印 - 0 - - - - Fn-71 机头碱可加加加加 0 0.000 - - - - Fn-72 工作机械自信加(1) - 0 - - - - - Fn-73 电磁铁能由电流(1) - 0 -	Fn – 64	回缝保护时间(s)	30	$1 \sim 120$	回維 保护	电磁铁吸合时间限制, 电磁铁以及电路安全
Fn - 66 低温度分钟问题并 (1) 任 6 万 公 1 0-5 1 約5 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	Fn – 65	低速最大输出扭矩(%)	25	$10 \sim 80$	f	低速最大输出扭矩
Fn - 67 指馬興也總钱动作的周期后句 (S) 30 10 - 90 部馬興也總找动作的 目期管倉電輸品. 老条約 動車能效效 Fn - 68 總胡貝(項.5) 客 序周興的何 (br.) 0 0 - 999 見渡田県(有.5) 常月四興的 (br.) 0 0.999 見渡田県(有.5) 常月四興的 (br.) 0 0.999 見渡田県(有.5) 常月四興的 (br.) 0 1.0 - 90 夏渡田県(有.5) 常月四興的 (br.) 0 1.0 - 90 夏渡田県(有.5) 常月四興的 (br.) 0 1.0 - 90 夏渡田県(有.5) 常月四興的 (br.) 1.0 - 90	Fn – 66	低速启动时间选择 (上针位有效)	1	$0\sim 5$	档位 0为关注	越高, 启动加速越快 引低速启动时间调整功能
Fn -68 地球町(町5.96 茶月期町村 (hc.) 0 0-999 2世世報年期(中方、日本用町村 (hc.) 2世世報年期(中方、日本用町村 (hc.) Fn -69 直配上社包編集商 (加工) - 0 - 0 1 <	Fn – 67	抬压脚电磁铁动作的周期信号 (%)	30	10~90	抬压脚电磁铁动作	时,以周期性省电输出,避免抬) 脚电磁铁发烫
Fn - 69 並私上社会編格度(度(x)) 一 0 0 1 <th1< th=""> 1</th1<>	Fn – 68	缝纫机(机头)保养周期时间 (hr.)	0	$0 \sim 9999$	设置缝: 当输入【	四机(机头)保养周期时间 0】时,关闭保养提示功能
Fn -70 系成故病信息代码 Fn -71 机式编码器能冲载获取 0~1599 現我成局器能冲载流 Fn -72 工作机械信息(位) 0~399 現我工作机械信息 Fn -73 电磁装输出电流() 0~399 現我工作机械信息 Fn -73 电磁装输出电流() 0~399 具取电磁装输出电流() Fn -73 电磁装输出电流() 0~399 具取电磁转输出电流() Fn -74 脚膀胱接度电平 (Y) 0~399 引取电磁转输出电流() Fn -75 伺服系化(机会) 程序期内的器计 0~9999 10~401 Fn -76 健振器(北京会市時市) 0~9999 10~401 40.01 Fn -76 身長前的信 0~1 9.02 10.01 <td< th=""><th>Fn – 69</th><th>直驱上针位偏移角度(度x10)</th><th>-</th><th>0~3600</th><th>白</th><th>驱上针位偏移角度 (相对于[Z]信号)</th></td<>	Fn – 69	直驱上针位偏移角度(度x10)	-	0~3600	白	驱上针位偏移角度 (相对于[Z]信号)
Fn -71 机头编码器能冲载获取 一 0~1599 成取机头编网器能冲载 Fn -72 工作机械角信息(定) 一 0~359 风取工作机械角信息 Fn -73 电磁铁输出电流(u) 一 0~000 Q取电电铁输出电流 Fn -73 电磁铁输出电流(u) 一 0~000 Q取电电铁输出电流 Fn -73 电磁铁输出电流(u) 一 0~000 QR和编标准成电平 Fn -74 脚路被迫攻电平 (r) 一 0~300 QR和编标准成电平 Fn -75 伺服系位(印输入器规 一 一 Referent (and phy difficient) (and philicient) (an	Fn – 70	系统故障信息代码				
Fn -72 工作就械角信息(定) 一 0~039 风坂工作就械角信息(定) Fn -73 电磁铁输出电流(A) 一 0~000 9.999 Q	Fn – 71	机头编码器脉冲数获取	-	$0\!\sim\!1599$	获取机头编码器脉冲数	
Fn - 73 电磁铁输出电流(A) - 0.000 9.999 我求他磁铁输出电流 Fn - 74 脚鹬板道皮电平 (Y) - 0.000 3.000 我求博爾板道皮电平 Fn - 75 伺服系统(IO)输入监视 - - 死动动肉和 Fn - 75 伺服系统(IO)输入监视 - - 死动动肉和 Fn - 78 撞动机(机3)风能学期内的案计 - 0~9999 当输入(IO).4, 电动器中部时间到达,输入系 运行时间(IDL).4 - 2.07 3.3 dD 学数动物化 Fn - 79 执行出「少人教力」 - 0~9999 当输入(IO).4, 电动器中部中部 - 2.07 3.3 dD 学数动物化 Fn - 79 执行出「少人教育社会社学和的合义、和下关制的会会点代表中的奇义、和下关制的会社会工具 - 2.01 JI 伊朗斯氏泪露的与输入 Y - 74的会会点代表中的奇义、和学术和的会会会优表中的专用的事件在的考试和 - - 2.01 JI 伊朗斯氏泪露的与输入 G(11) G(05) G(02) - - 2.01 JI 伊朗斯氏泪露的小型 G(11) G(06) G(02) - - - - - G(12) D(09) D(06) D(03) - - - - - - - - - - - - - -	Fn – 72	工作机械角信息(度)	-	0~359	获取工作机械角信息	
Fn - 74 脚路板速度电平 (Y) - 0.000 ~ .3.300 現現開新転進度电平 Fn - 75 伺服系统(10 输入器戏 - - 見は鮮の Fn - 78 總明紙(根久)(保奈期前的路社 运行时间(bc.)) - 0~9999 当他人【11 并,可以時級計运行时间 当他人【11 并,可以時級計运行时间 Fn - 78 總明紙(根久)(保奈期前的路社 运行时间(bc.)) - 0~9999 当他人【11 并,可以時級計运行时间、他人 软化的子数数约的化 - - 見有可 3.3 伯/多数约約化 Fn - 79 执行出厂多 免数数始化 - - - 見有可 3.3 伯/多数约約化 G相低 4.00 Å取取送系中での自然の意識の意識の意識の意識 - - - 見有 3.3 伯/多数约約化 G111 G105 森田 2.5 報告表報告報告報告報告報 1011 1021 1018秒前面に面白 90A.1021 G111 G108 G105 G1021 10111 10111 10111 <t< th=""><th>Fn – 73</th><th>电磁铁输出电流(A)</th><th></th><th>0.000 ~ 9.999</th><th colspan="2">获取电磁铁输出电流</th></t<>	Fn – 73	电磁铁输出电流(A)		0.000 ~ 9.999	获取电磁铁输出电流	
Fn -75 伺服系统(10 输入器税 - - 見出物の Fn -78 違切根(税,均,投非期内的影社 运行控制(加) - 0~9999 物価入口1,可以調整調理行時,、油入非 素加工作用 Fn -79 执行出「影教助统 - 0~9999 物価入口1,可以調整調理行時,、油入非 素加工作用 Fn -79 执行出「影教助统 - 見定 2 fm 長位(10 h人混取以是示律)年間向金融裁判管的化化 - 2 fm 長位(10 h人混取以是示律)年間向金融裁判管的化总统 - 2 fm 系统(10 h人混取以是示律)年間向金融裁判管的化总统 - 2 fm 系统(10 h人混取以是示律)年間の金融裁判管的化总统 - 2 1 期価額面面的場へ fm 系统(10 h人混取以上系指示 - 101 期価額額面的場へ 1 <th>Fn – 74</th> <th>脚踏板速度电平 (V)</th> <th></th> <th>0.000 ~ 3.300</th> <th colspan="2">获取脚踏板速度电平</th>	Fn – 74	脚踏板速度电平 (V)		0.000 ~ 3.300	获取脚踏板速度电平	
Fn - 78 總規則(視头)保养期內的影计 运行控何(加) - 0~9999 当他入口,并,或国路常出活行时,当他入口,非,或国路常出活行时,当他入口,非,或国路常出活行时,当他入口,非,或国路常出活行时,当他入口,非,或国路常出活行时,当他入口,非,或国路常出活行时,当他入口,非,或国路常出活行时,当他入口,非,或国路常出活行时,当他入口,其,或国路常出活行时,当他入口,其,或国路常出活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常活行时,当他入口,其,或国路常引,如此入口,其,或国路引,如他入口,其,或国路常行,或国路引,或国路引,如此口,其,或国路,如此口,其,或国路,如山口,其,或国路,和山口,其,或国路,和山口,其,或国路,和山口,其,或国路,和山口,其,或国路,和山口,其,或国路,和山口,其,和山口, 和山口,其,和山口,和山口,和山口,和山口,和山口,和山口,和山口,和山	Fn – 75	伺服系统(I0)输入监视				见注解①
Fn - 79 执行出「参载初始化 一 一 足常章 1.3 出「参载初始化 注解(2) 关于 Fn - 75 号参数 监视内容的显示说明 问题系统(10) 输入器或以是示师中运用改造器或的音响放包显示。 [22] 则需数或面白·输入 可用数位面白·输入 不时的变色点代名不时的含义、 PC 和助含义 PC 和助含义 PC 和助含义 人们10 A[07] A[04] A[01] [22] PE 和助含义 G[11] G[08] G[05] G[02] [23] [24] PL 和助金 G[11] G[08] G[05] G[02] [26] [26] [26] D[12] D[09] D[06] D[03] [26] 0.024 0.024 [21] D[19] D[06] D[03] [21] 0.024 0.024	Fn – 78	缝纫机(机头)保养期内的累计 运行时间(hr.)	-	0~9999	显示缝纫机保养期内的累计运行时间 当输入【0】时,可以消除累计运行时间,,输入 数值无作用	
注解 ① 关于 Fn - 75 号参数 监视内容的显示说明 [01] 明朗新前面哲与输入 同题系统 103 输入器或以系向中写用的总裁或软骨的检检显示。 不均的皮包点形式不均的含义、如下发展所示。 4[10] 4[07] 4[04] 4[01] [03] [04] 安全的差开式输入 G[11] G[08] G[05] G[02] [05] [05] [05] [05] [05] [05] [05] [05	Fn – 79	执行出厂参数初始化	1	-	见章寸	5 3.3 出厂参数初始化
[10] 与CREICALINIA 与 [12] 编码器 (2)信号	注解 ① 信服系统(II 不同的段位	关于 Fn - 75 号参数 监視 P の) 输入监視以显示所中后用危速指 直然代表不同的含义。如下表相所 <u>A[07]</u> <u>G[08]</u> <u>D[09]</u> <u>D[06]</u> <u>D[06]</u>	容的显示 数码管的的 示: 	<说明 _{我位显示} , 1] 2] 3]	[01] [02] [03] [04] [05] [06] [07] [08] [09] [09]	> 與點板市路信号输入 與路板后路信号输入 回接控制开关输入 公全控制开关输入 (SYNUP)上针位同步输入 (SYNUP)上针位同步输入 (Hall)电机霍尔(U)信号 (Hall)电机霍尔(U)信号 (Hall)电机霍尔(U)信号 Healu 记者在后。
	- 11 - 19 - 19		645	-82	[12]	编码器 (2) 信号

2.3.1 回编功能 以起始单回缝为例,步骤如下

2.3 功能操作

8.8. 14 14

按键显示功能对照表:

- 1. 按下此键,设置起始单回缝功能,再次按下此键,则可切换至B段回缝功能。
- 2. 显示展显示当前所选择起始单同缝举到。同时可以通过+-键分别调整A. B段针数。针数设定范围1~15针。 3. 设置好前周缝后,踩下脚踏板将开始执行所设置的起始单回缝功能。
- 如果同时设置了定长缝等功能,可以使用针位设定选择键 💭 将显示数值切换到定长缝等功能的针数设置界面,进行 针数设定。终止回缝,以及起始双回缝,终止双回缝的操作设置步骤与以上步骤类似,请参照以上设置进行操作。

正常对系统上电后、默认进入缝纫模式。在缝纫模式时、用户可以在已设定好技术参数的情况下选择使用各种缝纫功能 此模式时,用户可以依据需要切换各种缝纫功能进行缝制工作,但是无法对系统各类技术参数进行修改和设置。

2.3.2 自由編功能

- 1. 按下自由缝功能键 , 启动自由缝功能.
- 2. 屏幕自由缝图标点亮,表示已设置好自由缝功能。
- 3. 设置好自由缝功能后,踩下脚踏板将执行自由缝。缝纫的起停完全由脚踏板自由控制。

2.3.3 定长编功能 一段编模式。

- 1.按一段缝功能键 📘,启动一段缝功能。
- 2. 屏幕一段缝图标点亮,表示已设置好一段缝功能,同时可以通过+-键分别调整E段针数,针数设定范围0~999针。 设置好一段缝功能后,踩下脚踏板将执行一段缝,系统将自动完成所设定的E针数。

四段錯權式。

- 1. 按四段缝功能键 🔝 , 启动四段缝功能。
- 2. 屏幕四段缝图标点亮,表示已设置好四段缝功能,同时可以通过+-键分别调整E,F段针数,针数设定范围0~99针. 3. 按键针位选择键 门 , 切换6, H段的针数设置界面。
- 4. 切换好G.H段后,显示屏显示G.H段针数设置界面,同时可以通过+-键分别调整G.H段针数,针数设定范围0~99针
- 5. 设置好四段缝功能后,踩下脚踏板将执行四段缝,系统将自动完成所设定的EFGH段针数。 七段编模式。
- . 连续按下四段缝功能键 🔝 ,切换出七段缝模式显示屏同时显示出当前切换的模式图标。
- 2. 当屏幕七段缝图标点亮,表示已设置好七段缝功能,同时可以通过+键分别调整E,F段针数,针数设定范围0~99年 3. 按键针位洗择键 〇 , 切换G. H段的针数设置界面
- 4. 切换好G, H段后,显示屏显示G, H段针数设置界面,同时可以通过+-键分别调整G, H段针数,针数设定范围0~99针 5. 设置好七段缝功能后,踩下脚踏板将执行七段缝,系统将自动完成所设定的EFGH段针数
- 自定义多段编模式:
- 1. 连续按下四段缝功能键 🔝 , 切换出自定义多段缝模式显示屏同时显示出当前切换的模式图标。 2 屏幕自定义条段储图标点亭、同时显示屏显示PX-XXX、PX表示段位(16进制表示)、XXX 表示针数(十进制)。 3. 首先通过+ -锑调整段位,设置好需要调整的段位号后,即可设定当前洗择的段位针数。默认P1~P4的针数为15,未
- 使用的段位需要将针数设为0,段位可编范围P1~PF(16进制)共计15段。每个段位针数的取值范围0~999。 4. 设置好自定义多段缝功能后,踩下脚踏板将执行自定义多段缝,系统将自动完成所设定的各段位针数。
- 段位位号采用16进制表示,取值范围P1~PF,共计15段。段位针数采用10进制表示,取值范围0~999针。

2.3.4 剪线功能

- → 开启剪线功能或者关闭剪线功能。 2. 当开启剪线功能时,显示屏点亮剪刀图标,当关闭剪线功能时,显示屏消隐剪刀图标
- 2.3.5 剪线自动抬压脚功能
- 山 开启剪线自动抬压脚功能或者关闭剪线自动抬压脚功能。
- 2. 当开启荀线自动抬压脚功能时,显示屏点亮自动抬压脚图标,当关闭时,显示屏消隐自动抬压脚图标。 2.3.6 中途停车自动抬压脚功能
- 🛄 开启中途停车自动抬压脚功能或者关闭中途停车自动抬压脚功能。
- 2. 当开启中途停车自动抬压脚功能时,显示屏点亮自动抬压脚图标,当关闭时,显示屏消隐中途停车自动抬压脚图标。

- 山 选择停止位置在上针位或者下针位。
- 2. 当选择上停针位时,显示屏点亮停针位置选择图标,当选择下停针位时,显示屏消隐停针位置选择图标 2.3.8 提针与补针功能
- 1 当在自由缝模式下执行提针与补针功能时,系统执行提针或者半针补针动作,
- 2. 当在定长缝模式下执行提针与补针功能时。

2.3.9 连续回缝功能

2.3.7 停针位置选择功能

- 1. 按下连续回缝键 🝿 开启连续回缝功能,显示屏连续回缝图标点亮 2.显示屏显示E段重复次数设置界面,同时可以通过+-键调整E段数值,数值设定范围1~99次。
- 3. 按键针位选择键 ○, 切换出ABCD段针数设置界面,通过++键调整各段所需的针数,各段的取值范围: 0~15针。 设置好连续回缝功能后踩下脚踏板将自动完成连续回缝动作,重复次数由所设定的E段决定。

2.3.10 慢速启动功能

1. 开启慢启动功能或者关闭慢启动功能,显示屏慢启动图标点亮 📝 2. 开启慢速启动功能后,前踏脚踏板时,系统将以慢速执行起缝针数,之后开始正常缝制

2.3.11 针迹补偿调整方法

当在使用固缝和连续回缝时,如果正缝和倒缝的针迹出现差异,可以通过调整倒缝电磁铁延时参数进行补偿。以下将 以起始双回缝为例进行说明,其中,A=4,B=4:

出现现象	调整方法
	A段针数超出设定数值,或A段最后一针变长、B段第一针 变短,造成执行完B段针数后无法回到起始点时: 适当调大Fn-13号参数。
TA)	A段针数少于设定数值,或A段最后一针变短、B段第一针 变长,造成执行完B段针数后超出起始点时: 适当调小Fn-13号参数。
7.4.1	B段针数超出设定数值,或B段最后一针变长、后续缝纫 的第一针变短,造成执行完B段针数后超出起始点时: 适当调大Fn-14号参数。
TRO	B段针数少于设定数值,或B段最后一针变短、后续缝纫 的第一针变长,造成执行完B段针数后无法回到起始点 时:适当调小Fn-14号参数。
终止回缝,以及连续回缝	可参照上述方法调整 Fo-16、Fo-17、连续回路补偿调整杂款、Fo-19、Fo-20

3.1.1 数5 当Fn-83=0时,上针位定位模式为数字式,设置方法如下:

(注意,数字模式时,第一次上机以及更换电控后都需要重新设置上针位!)

- 1. 在关机状态,按住S键,同时开启电源为系统上电,系统启动后即进入特殊功能设置模式,进入特殊功能设置模式模
- 式后,显示屏显示功能代码洗择界面,同时可以通过←键来洗择代码号。 2. 将功能代码设置为: 8080 即为执行自动上针位设置的代码。
- 3 手动转动转轮将针位调整到所需上针位的位置。

4. 调整好后,按S键即可执行该功能,听到四声短促音表示完成上针位的设定。步骤(3) 所调针位将被设置为上针位

	The second second second second second		a (acc)
Industrial Sewing Machine AC Servo Control System Operation Instruction	Key function definition:	2. 2. 2 USOF parameter setting mode. In user parameter setting mode, users can adjust various kinds of sewing function parameter. It can be eat or	Fn-26 Wipe Thread Function / Clamp 1 0~2 1 (Wipe Thread Function 0N)
	Function parameter Function parameter edit node after pressing the key for 2°3S	the following steps:	Clamp Thread Function 0N) Fn - 27 Clamp start angle 180 1~300 Clamp start angle
1. Introduction	edit P in the operation mode; Quit function parameter edit mode after press the key for 2°3 S in the edit mode.	1. Press key P for 2°3S in the sewing mode to Enter into user parameter setting mode.	Fn-28 Clamp release angle 300 30~330 Clamp release angle (Thread length control)
1 1 Abstract	Setting parameter After setting the function code, press this key to check the preset	 Press +/- to select the required function ID. Press kew S to show and modify the voluted parameter. Press +/- to set the required parameter. 	Fn-36 Reverse needle lifting control 0 0~2 0FF[0]/0N[1]/Linked switch [2]
Industrial sewing machine servo control system adopts new mechanical design with small volume,	check and save or parameter and usen can doit the parameter according;y; when the parameter is fixed, press this key to save the setting and quit.	 A. After fixing the parameter, press key S to save the setting and quit the interface. 	Fn-37 Reverse needle lifting angle 40 20~90 Reverse needle lifting angle
compact structure, beautiful shape and installation flexibility. Its circuit design isolates	Speed Increase the sewing speed -	5. Press key P for $2{\sim}3S$ to quit the user parameter setting mode and recovery to sewing mode.	Fn-38 Pedal stroke ratio (%) 100 30~100 Pedal stroke ratio (%)
the driver and main control, and so prevents the control circuit from interference of driver. Finally, it has the excellence stability and reliability. With ontimized SMPS designation it	increase/decrease Slow down the sewing speed.	User parameter table:	Fn - 39 Finished Sewing Piece Counter 0~9999 Display the quantity of finished sewing piece
archives the good efficiency and lower consumption with lower heat. The system has the perfect	Parameter Increase the parameter	Fn - 01 Maximum sewing speed (r/min) 3600 100~5000 Maximum speed adjustments	2.2.3 System parameter setting mode
protective circuits which prevent it from burned circuit because of short circuit of power supply.	Decrease the parameter	Fn - 02 Set accelerated curve (%) 80 10~100 Set the acceleration slope	an system parameter setting move, it's available to adjust kinds of the parameter of the electromagnet and system setting. Details parameter can be set according the following steps.
It is designed with feasible method to adjust the needle stop position which cuts down the time.	Stitch setting O Press this key to change the line section	Fn - U3 Start Back-Tacking Speed (r/min) 1800 150~2800 Set Start Back-Tacking Speed Fn - O4 End Back-Tacking Speed (r/min) 1800 150~2800 Set Fnd Back-Tacking speed	 Long press key P, in the same time turn on the power. Switch from off to enter into system parameter settin mode. In this mode, both system parameter and uson parameter can be modified.
to fix the needle position and facilitates the debugging and installation of the machine.	Auto function 🙆 Automatic function for constant stitch sewing.	Fn - 05 Bar-Tacking Speed (r/min) 1800 150-2800 Set Ear-Tacking Speed	 In one. In one model of a system parameter and user parameter can be modified. Press +/- to select the required function ID, press key S to enter parameter modification interface to check the select the required function interface to check the select the required function interface to check the select t
1.2 Composition	Needle stop position III Select needle up/down stop position. The default is up position when	Fn-06 Slow Start Speed (r/min) 300 150~2800 Set slow start speed	and modify the parameter. 3 After fix the parameter, press key S to save the setting and ouit
Servo control system consists of the following parts	Selection is institute function. The related icon is display on the selection is displ	Fn = 07 Number Of Stitches For Slow Start 2 0~99 Number of stitches setting for slow start	 Long press key P for 2⁵3S to quit the system parameter setting mode and recovery to normal sewing mode
1. Main parts: Servo control cabinet, operation panel, pedal controller, permanent magnet AC servo	Auto lift measure for much lift of the lift of the lift of the lift of the lift measure for the lift of the lift o	FII - UO Seering Speed (r/min) 3200 300~4500 seering	System parameter table
motor.	Auto 1111 préssér foot after pause LLL Set presser foot auto-lifting after pause function. When the related icon is display on the panel, the function is activated.	1: After last seam of Constant Stitch sewing, it will automatic execute the End Back-Tacking sewing	No. Items Default Range Contents
2. Accessories: stand of operation panel, user manual, power supply cable, pedal connecting rod,	Auto lift presser	Fn-09 Automatic End Back-Tacking 1 0~1 function. When turned on, the Stitch-Correction is invalid.	Fn = 40 Direction of Motor Rotation Reserved Fn = 41 Motor Rotation 0 0~1 1. When motor stormed Kappits 1-bod (0. No. 200-4)
Screws. Please check the packed parts according the packing list at the first time opening the carton. if	Consecutive reverse WW Set consecutive reverse sewing function. When the related icon is	0: Automatic End Back-Tacking will not execute after last seam, but can be done by pedal manually	second state transition o 0 -1 1: High Bold Stopped, arep 1: 100KEd / 0: NO Effect l: enable
any lack, contact the distributor asap.	sewing display on the panel, the function is activated.	 JUKI mode (Back-tacking sewing is executed whenever machine is stonmed or remaine) 	Fn-42 Auto running for test function 0 0~1 When the parameter set as 1, the machine will start
	Sewing as you please on the panel, the function is activated.	Fn - 10 Back-Tacking Mode selection 1 0~1 0. EROTHER mode (Back-tacking senior) secured	auto running as sewing function set on the operation papel
	Set start single back-tracking sewing function, and its section AMB or B parameters. When the an icon is display on the panel, the	when machine is running, needle rilling is executed when stop).	Fn-43 Motor auto-running full 8 1~800 Only valid when Fn = 42=1, set the full time for
1.3 Technology Specification Item Name Unit Qty.	back-tracking sewing Set start dual back-tracking sewing function When the related icon	Fn-11 Start Back-Tacking Running Mode 1 0~1 1: Automatically perform actions 0: Could be arbitrarily stop and start.	Fn-44 Motor auto-running on cycle 3 130 Only valid when Fn = 42=1, set the motor on time for
Parameter Specification 1 Servo control cabinet pcs 1	is display on the panel, the function is activated.	1:Start Back-Tacking is completed automatically	each running cycle. En AE Notor auto-running off cycle 2 001y valid when Fn = 42=1, set the motor off time
Rated input voltage 220V±10% 2 Operation panel pcs 1	End back-tracking Find back-tracking sewing function, and its section C&D or C parameters. When an icon is display on the panel, the related NVV	$ \begin{array}{c c} Fn-12 & \mbox{Ending Mode Of Star Back-Tacking} & 1 & 0 1 & \mbox{continued for next actions.} \\ 0: \ \mbox{After the number of stitches is completed, the} \end{array} $	$\frac{1}{100} \frac{1}{100} \frac{1}$
Rated input frequency 50/60HZ 3 Pedal controller pcs 1	sewing Set end dual back-tracking sewing function like the related icon	action stop automatically.	rn=+u ine minimum speed(r/min) 200 100~500 Adjust the minimum speed of the motor Speed is too low may lead to unusual thread, the
Rated output power 750W 4 permanent magnet AC pcs 1	is display on the panel, the function is activated.	Fn = 13 compensation -1 60 1~150 Compensation for A part of Start Back-Tacking	Fn-47 Thread trimming speed(r/min) 300 100~500 speed is too high may lead to unstable positioning control
speed 5000rpm 5 Stand of operation panels pcs 1	Execute section E constant stitch sewing	Fn-14 Start Back-Tacking 60 1~150 Compensation for B Part of Start Back-Tacking	Foot lifter and back-tracking and a sector back-tracking electromagnet
Maximum output torque 3. 5Nm 6 User manual book 1	Constant stitch Set multi-section sewing function, press the function key to switchover between four section sewing, seven section sewing and	Fn-15 End Back-Tacking Running Mode 1 0~1 1: Automatically perform actions selection 0. Could be arbitrarily stop and start.	rn-40 electromagnet operation time 300 0~990 operation time to full output
7 Power supply cable pcs 1	sewing user-defined multi-section.	Fn - 16 End Back-Tacking compensation -1 60 1~150 Compensation for C part of end Back-Tacking	Fn - 49 Back-tracking electromagnet sector and the sector and the
2 Operation description 8 Pedal connecting rod set 1	such an iou is usplay on the panel, the related function is activated.	Fn = 17 End Back-Tacking compensation -2 60 1~150 Compensation for D part of end Back-Tacking Bar-Tacking Running Mode L. Automatically parform action	operation duty cycle (%) electromagnet from over-heat.
2 1 Panel description	Line trimming When this function is selected, and this icon will be displayed on the panel LCD, and so line trimming function is activated.	Fn = 18 selection 1 0~1 1: Automatically performance of the selection of t	Fn - 50 Motor starting delay time (ms) 50 0~990 Delay the start time, with matomatic presser foot down
GL-BO	Lift and fill needle	Fn = 19 Bar-Tacking compensation -1 60 1~150 Compensation for A,C part of Bar-Tacking	Hn = 51 Half step release Foot Lift 1 0~1 1: 0X / 0: 0FF Fn = 52 Safety switch signal selection 0 0~1 1. Keen 0X / 0. Keen 0FF
	Speed display — Display the sewing speed grade	Fn = 21 Needle ston Position Selection 1 n_{-2} to 12 Compensation for b, U part of par-Tacking Valid only when the operation panel is disconnected,	Trimming operation delay The degrees between UP position and thread
		Francisco and a second and a se	rn-53 before the mechanical angle 189 120~250 trimming action
	2. 2 Operation mode selection	FII = 22 Slow Start Function Selection 0 0^{-1} $1(08)/0(0FF)$	Fn-54 Completion of the mechanical angle of the thread trimming 360 250~360 Completion of the mechanical angle of the thread
	2. 2. 1 Sewing mode	Fn - 23 Automatic root Lift after 0 0~1 Valid only when the operation panel is disconnected, 1(0N) / 0 (OFF)	action required (degrees) trimming action required
Panel keypad Panel LCD	The machine enters into sewing mode as default setting after powering on. In the sewing mode, the user can select various kinds of sewing function after setting technology parameter. In sewing mode, the users can switchover	Fn - 24 Automatic Foot Lift When Pause 0 0~1 Valid only when the operation panel is disconnected, 1(0N)/ 0 (OFF)	Fn-55 Thread take action before the delay time n (ms) 10 0~980 The time between UP position and Thread take action
	between various kinds of sewing function according to their need, but can't modify and set all the system	Fn - 25 Automatic Function Selection 0 0~1 Valid only when the operation panel is disconnected,	En EC m toth with () zo Completion of the thread take-up action required
	collingingy parameters.	1(0x)/ 0 (0rr)	PII O
$\label{eq:rescaled} \begin{array}{ c c c c c } \hline Fn-57 & \mbox{The time before Foot lifter} & 50 & $0{\sim}990$ & \mbox{The time between Brend take action and Foot lifter} \\ \hline Fn-58 & \mbox{Foot lifter action to} & 30 & $1{\sim}120$ & \mbox{Foot lifter action to minimize the time} \\ \hline \end{array}$	2.3 Functions operation 2.3.1 Back-tracking sewing function Oneck start-back-tracking sewing stops as following:	2.3.8 Lifting and filling the needle function I. Buen the function is set under sering as you please mode, the machine will execute meedle lifting or half-stitch filling. 2. When the function is set under constant stitch sering, and the machine will execute needle lifting while press	3.1.2 Magnet steel mode Man Fn-93-1, needle positioning mode setting method is magnet steel mode, a follow; in sugnetic mode, on the seedle position is set up, as long as the hand wheel, motor is not discassibled, moved, the mache motific on mask to be the set of the se
$\label{eq:rescaled} \begin{array}{ c c c c c } \hline Fn-57 & The time before Foot lifter & 50 & 0-900 & The time between Thread take action and Foot lifter action & foot time acti$	 Functions operation S.1 Back-tracking sewing function (Beck start-back-tracking serving steps as following: Press the related key to set starts back-tracking Serving. Them press the key consecutively, and it Will set as (1) start back-tracking serving. (2)Security and its set as (2) set of the security of the of th	2. 3. 8 Lifting and filling the needle function I. When the function is set under sering as you please node, the makine will execute needle lifting or half-stitch filling. The function at the measure of the machine is pussed. If the function is the sum of the finished read matter is pussed.	3.1.2 Magnet steel mode When PP-83-1, needle positioning mode setting method is magnet steel mode, force, in magnetic mode, on the needle position is set up, as long as the hand wheel, motor is not disassembled, moved, the needle position no need to be reset.)
$\begin{tabular}{ c c c c c c c c c c c c c c c c c c c$	 S Functions operation S 1 Back-tracking seving function Check start-thack-tracking seving steps as following: Press the related key to set starts hack-tracking Seving. Them press the key consecutively, and it Will set as (1) start hack-tracking seving. 2156-e116 Beving. (2) closed alternatively. Mjust the stitches for section A and B by pressing +/-, and the number of stitches can be set between 0 and 15. End back-tracking seving. starts thack-tracking alternatively. 	 2. 3.8 Lifting and filling the needle function I. Then the function is set under sering as you please ade, the makine will execute needle lifting or half-strick filling. Then the function is set under constant stich sering, and the machine will execute needle lifting while press the function at the machine is panetine in panetine. The machine will execute needle filling function. 2. The machine will execut or function to the machine is a sering. 2. The machine will execut needle filling function. 2. 3.9 Conservation have track-tracking machine function. 	3.1.2 Magnet steel mode When PR-83-1, needle positioning mode setting method is magnet steel mode, is follow: model, motor is not disassembled, moved, the needle position no need to be reset.) Porer on, dherre the medle position, by adjusting the magnetic steel adjusting arree on the hand Steel position the medle position.
$\label{eq:response} \begin{array}{ c c c c c } \hline Fn-57 & The time before Foot lifter & 50 & 0990 & The time between Thread take action and Foot lifter action & foot lifter action & foot lifter action to minimize the time (b) & 20 & 120 & Foot lifter action to minimize the time (b) & Fn-59 & The result of the time (b) & 10 & 120 & The time foot lifter action of the time (b) & The tim$	 S Functions operation A: 1 Back-tracking serving function Check start-thed-tracking serving straps as following: There is the related here up or starts the tracking Serving. Then press the key consecutively, and it Will set as (1) start back tracking serving (355-the B serving (1)-checking alternatively. Adjust the stitches for section A and B by pressing +/, and the maher of stitches can be set hetween 0 and 15. End back-tracking serving strate tack-tracking dail serving, end back-track dual serving can be operated according the above steps. S S Serving as you please 	 2.3.8 Lifting and filling the needle function i. Then the function is set under sering as you please node, the makine will execute needle lifting or half-strick filling. Then the function is set under constant stricts sering, and the machine will execute needle lifting thile press for back-tracking sewing function F. The machine will reacted seried infing function. I. Press the related key Min to gene the function the lighted. 	3.1.2 Magnet steel mode When Pr-81-1, needle positioning mode setting method is magnet steel mode, a follows: [notes, in magnetic mode, on the needle position is set up, se long as the hand preset.] 1. Parer a, dwarre the meedle position to need to be reset.] 1. Parer a, dwarre the meedle position to read to be position. 1. Parer a, dwarre the meedle position to read to be interest.] 3. Adjuster of readel model, dwarre the seedle a seedle stop position. 3. Majneter of readel model, dwarre the content is requirement of users.
$\label{eq:response} \begin{array}{ c c c c c c } \hline Fn-57 & The time before Foot lifter from (m) & 50 & 0-990 & The time between Thread take action and Foot lifter action & Foot Tifter action to minimize the time (i) & 30 & 1-120 & Foot Tifter action to minimize the time (i) & 10 & 1-120 & Foot Tifter action to minimize the time (i) & 10 & 1-120 & Foot Tifter action to minimize the time (i) & 10 & 1-120 & Foot Tifter action to minimize the time (i) & 10 & 1-120 & Foot Tifter action to minimize the foot Tifter action to minimize the time (i) & 10 & 1-120 & Continue time (i) & 120 & 220 & Continue time (i) &$	 2.3 Functions operation 2.3.1 Back-tracking sewing function Backs start-back-tracking sewing steps as following: Press the related key to set starts back-tracking Sewing. Then press the key consecutively, and it Will set as (1) start back-tracking sering. (2) Coloring alternatively. Might the stitches for setting. Obtaining with a weak of the number of stitches can be set between 0 and 15. I also back-tracking as you please function be sering, and back-track dual sering, and back-tracking as possible setting. 2.3.2 Sewing as you please function key to activate the function. The related ion is displayed on the panel to bits setting as you please function. 	 2.3.8 Lifting and filling the needle function 1. When the function is set under sering as you please node, the makine will execute needle lifting or half-witch filling. 2. When the function is set under constant stitch sering, and the machine will execute needle lifting while press the function at the scenar of the machine is passed. If the function is researed while finished each section sering. 2. 3.9 Consecutive back-tracking seving function 2. 3.9 Consecutive back-tracking seving function 2. In the same is the trapest turn E setting interface is displayed on the pasel, then press +/- to adjust the maker, which ranges form 1 = 000 	 3.1.2 Magnet steel mode When Pre-83-1, needle positioning mode setting method is magnet steel mode, as follows: (note, is magnetic mode, on the medle position is set up, as long as the hand setting method is not discassed). Parer on, observe the medle position, by adjusting the magnetic steel adjusting serve on the hand steel, adjusting the medle position. Step on the foot peakl, observe the medle a needle stop position. Adjustent of medle position. Adjustent of medle position. Adjustent of medle position. The parameter copy and paste function. Long trave for 5. In the same tips throng of the mere rate medial function particular discussion.
$\label{eq:results} \begin{array}{ c c c c c c } \hline Fn-57 & The time before Foot lifter & 50 & 0-900 & The time between Thread take action and Foot lifter action & arises & action & maintain the time (m) & 30 & 1-120 & Foot lifter action to anishing the time (m) & 30 & 1-120 & Foot lifter action to anishing the time (m) & foot lifter action to anishing the time (m) & foot lifter action to anishing the time (m) & foot lifter action to anishing the time (m) & 10 & 10-120 & Foot lifter action to anishing the time (m) & foot lifter action to anishing the time (m) & foot lifter action to anishing the time (m) & foot lifter action to anishing the time (m) & foot lifter action to anishing (m) & 120-200 & Dom meelle position adjustment (for even) & 180 & 120-220 & Dom meelle position adjustment (for even) & foot foot action to action to an foot lifter action and foot lifter action action to anishing (m) & 120-220 & Dom meelle position adjustment (for even) & foot foot action to action the time (m) & 120-220 & Dom meelle position adjustment (for even) & foot foot action to action $	 S Functions operation S.1 Back-tracking sewing function (heck start-back-tracking serving steps as following: Press the related key to set starts hack-tracking (serving. Them press the key consecutively, and it Will set as (1) start back-tracking serving. (2) Security (a) start back-tracking serving. The set of stitches can be set between 0 and 13, Algorithm of the stitches for section A and B top pressing v/s, and the maker of stitches can be set between 0 and 13, A security as your please. A security as your please the section of the section of the section of the second section of the section o	 2. 3. 8 Lifting and filling the needle function I. Then the function is set under sering as you please node, the makine will execute needle lifting or half-stitch filling. The function at the measure of the machine is parsed. The function at the measure of the machine is parsed. The function at the measure of the machine is parsed. The function at the measure of the machine is parsed. The function at the measure of the machine is parsed. The function at the measure of the machine is parsed. The function at the measure of the machine is parsed. The function at the measure of the machine is parsed. The function at the measure is a function. The set the related larging the setting interface is displayed on the parsel, then press +/- to adjust the mather. which ranges for 1 to 90. The set the setting interface is displayed on the parsel, then press +/- to adjust the mather. which ranges for 1 to 90. The set the setting interface. 	 3.1.2 Magnet steel mode When PP-8-1, needle positioning mode setting method is magnet steel mode, force, in magnetic mode, on the needle position is set up, as long as the hand wheel, motor is not disassembled, moved, the needle position no need to be react. Step on the foor load, abserve the medle position. Adjustment of medle position. Mightenet of medle position
$\label{eq:response} \begin{array}{ c c c c c c } \hline Fn-57 & The time before Foot lifter & 50 & 0-990 & The time between Thread take action and Foot lifter action & 1-200 & Foot lifter action to minimize the (i) & 30 & 1-200 & Foot lifter action to minimize the time & Th -59 & The meedle point in adjustment & 1-30 & The meedle point in adjustment & (15 is the central location) & Fn -60 & adjustment (agrees) & 180 & 120-220 & Down meedle position adjustment & Fn -61 & Power on and point of the meedle of access location & - & - & - & - & - & - & Fn -62 & The rate of mend step (%) & 225 & 20-1999 & Sort the rate of mend step & - & - & - & - & - & - & - & - & - & $	 S Functions operation S.1 Back-tracking sewing function (Beck start-back-tracking serving steps as following: Press the related key to set starts back-tracking serving. Them press the key consecutively, and it Will set as (1) start back-tracking serving steps in Baving, Olicoing alternatively. Adjust the stitches for section A and B by pressing v/-, and the number of stitches can be set between 0 and 15. S for back-tracking serving starts back-tracking alternatively. Adjust the stitches for section A and B by pressing v/-, and the number of stitches can be set between 0 and 15. S for back-tracking serving starts include-tracking alternatively. S and back-tracking serving starts metric back that serving a strong press the persted seconding the above steps. Press serving as you please that its stituing on the paper to that setting on serving as you please function. More serving a, month beyond to exercise the rewing as you please. S a Constant stitch sewing Consection mode: 	 2.3.8 Lifting and filling the needle function 1. Then the function is set under sering as you please node, the makine will execute needle lifting or half-stirkh filling. 2. Then the function is set under constant stirls sering, and the makine will execute needle lifting thile press. 3. Then the function is not under constant stirls sering. 3. Then the function is not under constant stirls inder deal store needle. 3. Then the function is not under constant stirls inder deal store needle. 4. The function is not under constant stirls inder deal store needle. 3. The satisfies of the function. 3. The satisfies the register that the function. The icon will be lighted. 3. In the same in the result time is esting interface is displayed on the panel, then press +/- to adjust the number, which ranges from 1 to 90. 3. Press titls adjuster that be deal-tracking series function. put the forst part of the pedial to complete the consecutive back-interview section A.B.C.D stirkh setting interface. 4. After setting the consecutive back-tracking series function, put the front part of the pedial to complete the consecutive back-interview in a find by parameter E. 	 3.1.2 Magnet steel mode When PR-83-1, needle positioning mode setting method is magnet steel mode, needle position is set up, as long as the hand position is needle position no need to be react.) 1. she, advanting the mode, needle position is set up, as long as the hand position is needle position and the needle position is needle position. 2. Stop m the for position, br adjasting the magnetic steel adjasting scree on the hand position. 3. Stop m the for position will it reaches the requirement of mers. 3.2 Parameter copy and paste function 1. and press kry S, in the same time turn on the power with from off to enter into special function setting mode, press + to sale the required function ID. 2. Store the fourier long and the store target function in the power stick from off to enter into special function setting mode, press + to sale the required function ID. 3. Store the fourier long and 0011 to enter into copy and paste function. 3. From such control and paste function. 3. From such control and paste function. 4. Stop methods and the power strick from off to enter into special function setting mode, press + to sale the required function ID. 5. Stop the fourier long.
$\label{eq:response} \begin{array}{ c c c c c } \hline Fn-57 & The time before Foot lifter & 50 & 0920 & The time between Thread take action and Foot lifter action & action & action & foot lifter & foot & foot lifter & action & foot lifter & action & foot lifter & foot & foot & foot lifter & foot & $	 2.3 Functions operation 2.3.1 Back-tracking sewing function Check start-back-tracking sewing steps as following: Press the related ker to set starts hack-tracking alternative?. 2.4 Mjust the stitches for section A and B by pressing +/, and the number of stitches can be set between 0 and 15. 2.5 Back-tracking sewing steps as steps set of the structure of the set between 0 and 15. 2.6 Back-tracking set of the starts hack-tracking alternative?. 2.8 Journal of the stitches of the stitches of the structure of th	 2.3.8 Lifting and filling the needle function I. Wen the function is set under sering as you please ade, the makine will execute needle lifting or half-strick filling. 2. Wen the function is set under constant sticht sering, and the machine will execute needle lifting the press with function is needed to be achieved the sering of the machine is a series. 3. We notice the second of the machine is passed. 4. The machine will execute needle filling function 3. The machine will execute needle filling function are sering. 4. The state the related by the sector function. The icon will be lighted. 3. In the same time the setting interface is displayed on the pasel, then press i/- to adjust the number, which ranges from a trick the lighted machine will need to make the string interface. 4. The rest tit the denome time is function, what the front part of the pedia to complete the consecutive back-tracking sering function, what the front part of the pedia to complete the consecutive backing in first of part of the machine will not stop will completing all the steps of consecutive backing the machine will not stop will complete the state series in the series of the machine will not stop will completing all the steps of consecutive backing backing and the machine will not stop will completing all the steps of consecutive backing backing and the machine machine is displayed to the series in the set of the series in the set of the set of	 3.1.2 Magnet steel mode When PR-83-1, needle positioning mode setting method is magnet steel mode, scilized and scilized position is set up, selong as the hand position is set up, selong as the hand position is need to be reset.) I over a, dherre the medle position, by adjusting the magnetic steel adjusting arree as the hand of the position with the medle position are set up, selong as the hand position is not all assessments of the set of th
$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2. 3 Functions operation 2. 3. 1 Back-tracking seving function (Back start-back-tracking serving steps as following: 1. Press the related key to set starts back-tracking alternatively. 1. Press the related key to set starts back-tracking alternatively. 2. 3. 2. Seving as you please 2. 3. 2. Seving as you please 1. The related ion is diaplaced on the panel to hist setting of seving as you please. 2. 3. 3. Seving as you please 1. The related ion is diaplaced on the panel to hist setting as you please. 2. 3. 4. Seving as you please 1. The related ion is diaplaced with setting function key to activate one section setting. 2. Bernel and the seving setting the back to be a setting as you please. 2. The related ion is diaplaced by the setting the setting as you please. 3. 4. The setting one panel have back to activate one section setting. 3. Previous this setting compared to the panel to hist setting do are setting setting. 3. Previous this setting compared to the panel to hist setting do are setting setting. 3. Previous this setting compared to the panel to hist setting do are setting setting. 4. The related ion is diaplaced by the plane is the setting as panel back. 5. The related ion is diaplaced by the setting set the plane is the section back. 6. The related ion is the plane is the setting factor on setting se	 2.3.8 Lifting and filling the needle function 1. Then the function is set under series as you please node, the makine will execute needle lifting or half-strick filling. 2. Then the function is set under constant sticts series, and the machine will execute needle lifting while press functions for the machine is passed. The machine will execute needle lifting the mathematic press of the press of the presson of the press of the presson of the pres	 3.1.2 Magnet steel mode When PR-83-1, needle positioning mode setting method is magnet steel mode, a follow: Income set of the seedle position is set up, set long as the hand indeel, abstor is into disasceabled, moved, the needle position no need to be reset. Income set one of other set is up and participation of method is magnet steel mode, abstor is into disasceabled, moved, the needle position no need to be reset. Income set of media position will it render be requirement of metric. 3.7 Parameter copy and paste function Income sets ky. In the asset inset uran on the post atic from off to enter into special function setting mode, part function Press moder index is in the next the source of any and paste function. Press moder index is in the next researce of any magnet function. The to main controller is more the source or any magnet function. A researce function is in the interm metric the sum is no controller memory to paral parameter memory. 3.3 Factory parameter initialization
$\label{eq:results} \begin{array}{ c c c c c c } \hline Fn-57 & The time before Foot lifter & 50 & 0-90 & The time between Thread take action and Foot lifter action to maintain the time (a) and (b) & 0 & 1-120 & Foot lifter action to maintain the time (a) & 0 & 1-120 & Foot lifter action to maintain the time (a) & Fn-58 & The media point adjustment (apprece) & 15 & 1-30 & UP needle point adjustment (apprece) & 15 & 1-30 & UP needle point (b) & 120-220 & Dom needle point (b)$	 2. 3 Functions operation 2. 3.1 Back-tracking sewing function (Beck start-back-tracking sewing steps as following: 1. Press the related key to set starts back-tracking fairmatively. 2. Adjust the stitches for section A and By pressing v/v, and the maker of stitches can be set between 0 and 15. 2. Adjust the stitches for section A and By pressing v/v, and the maker of stitches can be set between 0 and 15. 3. Adjust the stitches for section A and By pressing v/v, and the maker of stitches can be set between 0 and 15. 3. Adjust the stitches for section A and By pressing v/v, and the maker of stitches can be set between 0 and 15. 3. A form a section gas your please. 3. A form a section is stipplased on the panel to bits setting as you please function. 3. After setting ab, push the pedal to execute the sering as you please. 3. Cassand stitch serving One section mode: 1. Prevalue stitche resting start in the string function key to activate one section sering. 2. The related icon is fighted on the panel to bint setting do see section sering. 3. The related icon is fighted on the panel to hint setting do see section sering. 3. The related icon is fighted on the panel to hint setting do see section sering. 3. The related icon is fighted on the panel to hint setting do see section sering. 4. The related icon is fighted on the panel to hint setting do see section sering. 4. The related icon is fighted on the panel to hint setting do see section sering. 5. The related icon is fighted on the panel to hint setting do see section series relate the series function and the machine will find the section for seving made the section for seving made the seving for the sectio	 2.3.8 Lifting and filling the needle function 1. Then the function is set under sering as you please made, the makine will execute needle lifting or half-stitch filling. 1. Then the function is set under contant stitch averaging, and the makine will execute needle lifting the press 1. The function is the machine is parameted. 1. The function is the machine is parameted. 1. The machine will execute needle filling function. 2. 3.9 Consecutive back-tracking asymptotic is displayed on the panel, then press +/- to adjust the maker, which ranges for 1 to 9%. 2. Press that the decision by One other function. The filling function. 3. Press that the decision by One other is averaging function. 3. Press that the decision by One other is averaging function. 4. After setting the consecutive back-tracking asymptotic panels. 4. After setting the consecutive back-tracking asymptotic panels and the set consecutive back-tracking asymptotic panels. 5. Press that the decision by One other panels of the panels of the panels to complete the consecutive back-tracking asymptotic panels. 6. After setting the consecutive back-tracking asymptotic panels at the set consecutive back-tracking set will be the function is attrivated, the machine will not stop will completing all the steps of consecutive back-tracking will be received by the panels of panels of the panels of the panels to complete the consecutive back-tracking will be received. 6. A for set of the panels of the range of the panels of the panels is panel will be tracked by the set consecutive back-tracking will be received by the panels of t	 3.1.2 Magnet steel mode When Pr-8-1, needle positioning mode setting method is magnet ateel mode, force, in magnet to mode, on the needle position is set up, as long as the hand force in motor is not disassembled, moved, the needle position need to be ater. ater.<!--</td-->
$\begin{tabular}{ c c c c c c c c c c c c c c c c c c c$	 2. 3 Functions operation 2. 3.1 Back-tracking seving function (Beck start-back-tracking seving steps as following: 1. Press the related key to set starts back-tracking fewing. Hen press the key consecutively, and it Will set as (1) start back-tracking seving starts back-tracking seven press the key consecutively, and it Will set as (1) start back-tracking seving starts back-tracking alternatively. 2. Majout the stitches for section A and B by pressing st-A and the number of stitches can be set between 0 and 15. 3. Ear back-tracking seving starts back-tracking alternatively. 2. A structure of the stitches for section A and B by pressing st-A and the number of stitches can be set between 0 and 15. 3. Ear back-tracking seving starts back-tracking alternatively. 3. For starts are you please. 4. After setting ak, public backet be sering as you please. 4. After setting ak, public backet be sering as you please. 7. A starts settion stitch seving Consection mode: a relation at stitch seving fraction key to activate one section series. b relation at stitch reging as the first part of the pedal to accente one section series function and the machine will finish the section E sering as set to 15 peda the machine will finish the setting for a settion Favoring as settion for seving machine and the machine will finish the setting for a settion for seving machine. Four section seving function key to activate four section series. Four section seving function key to activate four section series. Four section seving function key to activate four section series. Four section seving function key to activate four section series. Four section four period to a section series. Four section four period to a section series. 	 2.3.8 Lifting and filling the needle function 1. Wen the function is set under sering as you please ade, the auchine will execute needle lifting or half-strick filling. 2. Wen the function is act under constant sitch avering. and the auchine will execute needle lifting thile press filling function are and the strict of the second second	 3.1.2 Magnet steel mode When PP-18-1, needle positioning mode setting method is magnet steel mode, processing and processin
$ \begin{array}{ c c c c c c c c c c c c c c c c c c c$	 2.3 Functions operation 2.3.1 Back-tracking sewing function (Beck start-back-tracking sewing steps as following: Press the related key to set starts back-tracking slematively. Adjust the stitches for section & and B by pressing +/, and the maker of stitches can be set between 0 and 15. In an back-tracking sering (25% the back-tracking all sering, etholschertsch and seving can be operated according the above steps. 2.3.2 Sewing as you please units in the string as the string as you please the function. Press seving as you please the string as you please the string as you please. 2.3.3 Constant stitch sewing Consection mode: Press seving the string function key to activate the function. The related ion is lighted on the panel to hint setting do serving as you please. 2.1 Back-tracking seving starts the string function key to activate one section seving. 2.2 The related ion is lighted on the panel to hint setting do serving as section seving. 2.3.3 Constant stitch seving function key to activate functions. 3.4.4.5.5.5.5.5.5.5.5.5.5.5.5.5.5.5.5.5.	 2.3.8 Lifting and filling the needle function 1. Wen the function is set under sering as you please ade, the makine will execute needle lifting or half-strick filling. 2. Wen the function is set under constant stick sering, and the makine will execute needle lifting the plane plane ade, the makine will execute needle lifting the plane strick framework in a sering. The makine will execute meedle filling function wing. 2. Wen the function is set under constant stick sering, and the makine will execute needle lifting the plane strice will be function at the maximum of the makine is a sering. The makine will execute meedle filling function are sering. 2. 3.9 Consecutive Dack-tracking seveng function 1. Fress the related key will be other that strice is displayed on the panel, the press +/- to adjust the number, which ranges is tracking tracking are string the resource whech tracking are string the string interface. 3. A for string the consecutive back-tracking are string function, push the front part of the pedal to complete the consecutive back-tracking will be matched will not at op until completing all the steps of consecutive back-tracking will be matched will not a stop will complete the string and the set consecutive back-tracking will be madeled will not a stop will complete the string and the set consecutive back-tracking will be matched will not a stop will complete the string and the set consecutive back-tracking will be matched will not a stop will complete the string and the set consecutive back-tracking will be matched will not a stop will be stop of consecutive back-tracking will be matched will not a stop will be stop of consecutive back-tracking will be associated and	 3.1.2 Magnet steel mode When PR-83-1, needle positioning mode setting method is magnet steel mode, scillar and science of the scale position is set up, as long as the hand breact, notor is not disassembled, moved, the needle position no need to be seened. Porer on, during the medle position, bradjasting the magnetic steel adjusting scare on the model according to the scale position. Streen the fore local, above the model a medle position. Streen the fore local, above the model according to the position. Maintent of medle position will it reaches the remirment of users. 3.2 Parameter coys and paste function I near sets the same time turn on the power with from off to enter into special function setting mode, press 1, to acket the required function B. Sets the function by Bounders and the coy and paste function. Press and function by Bounders area. A set the function by Bounders area. A set offer to clame 2.2 to enter synta parameters in main controller awary to parameters aware. A set different code to excetch factory parameter situation and into for Portmeter. Code how the mathemater at the scane and into function bounders. A set different code to excetch factory parameter situation in the function. A set different code to excetch factory parameter initialization in different set. A set different code to excetch factory parameter initialization in different to the parameter for the right to be.
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$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2. 3 Functions operation 2. 3.1 Back-tracking seving function Check start-back-tracking seving items as following: 1. Press the related key to set starts back-tracking seving. Them press the key consecutively, and it Will set as (1) start back-tracking seving items as following: 2. A Serving as your please serving steps as following: 2. A Serving as your please serving steps as the serving steps and the serving steps as the serving st	 2.3.9 Lifting and filling the needle function 1. Then the function is set under sering as yop place made, the muthine will exect meedle lifting that prior the function is not under sering as yop places made, the muthine will execute meedle lifting that prior that the function is not under sering as you places made, the muthine will execute meedle lifting that prior that the function is not under sering as you places made, the muthine will execute meedle lifting that prior that the function of the machine is a pared. 1. If the function is not under sering as you places made, the muthine will execute meedle lifting that prior the function of the muthine will execute meedle filling function sering. 2. A meaning will execute meedle filling function. The icen will be lighted. 3. Press the related key is the series of the muthine. The icen will be lighted. 3. Press that the descentive back-tracking serving function, put the forth part of the podd is complete the consecutive back-tracking serving. 4. A for setting the consecutive back-tracking serving function, put the filling that is the serving of the podd is complete the consecutive back-tracking serving. 4. The set the function is activated, the makine will not stop will complete during writing and the set consecutive back-tracking will be appended during as you as a start factor is separed, the makine will start slory to seeing the start stickes while the front part of the podd is panded. And then operate normally. 3. A for start fraction is separed. 4. The start function is separed. 5. The start function is separed. 5. The start function is separed. 6. The start functis is separed. The start slory to seeing the s	A.1.2 Magnet steel mode When FP ₂ -B-1, needle positioning mode setting method is magnet ateel mode, FP ₂ -B-1, needle position is set up, selong as the hand position is need to be accelerate intervent the medle position. • need, algoring the mode, on the medle position is set up, selong as the hand position is need to be accelerate intervent the medle position. • need, algoring the mode, on the medle position is set up, selong as the hand position. • need, algoring the model on the model stop position. • need, algoring the model position. • needle stop position. • needle stop. • needle s
$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2. 3 Functions operation 2. 3.1 Back-tracking seving function Check start-back-tracking seving items as following: 1. Press the related key to set starts back-tracking seving. Then press the key consecutively, and it Will set as (1) start back-tracking seving items as following: 2. Major the strictles for section A and B by pressing +/-, and the number of strictles can be set between 0 and 15. 3. To back-tracking seving items as well seven to be set in the device streps. 2. Adjust the strictles for section A and B by pressing +/-, and the number of strictles can be set between 0 and 15. 3. To back-tracking seving items function key to setimate the function. 2. Adjust the strictles pering strate the setimate the function. 3. A fiver setting set you blease function key to setimate the function. 3. A fiver setting set you blease function key to setimate the function. 4. After setting set, push the pedal to resource the sering as you please. 2. 4. 3. 3. Constant stift. Serving Constant stift. Serving function key to activate one section servine. 4. There related ion is lighted on the panel to hint setting do new section servine. 1. The related ion is lighted on the panel to hint form section sering. 2. There starts sering function key to activate fur section sering. 3. There starts use to sering function key to activate fur section sering. 4. There starts use to a sering function key to activate fur section sering and or section 6 and 18 attricks which maper for 0 to 9. 4. Mere starts use to section 6 and 18 attrick interface, press +/- to set the number of section 6 and 18 attricks which maper for 0 to 9. 5. After setting sering function, key to antinuously util seven te form section sering and complete section E, F, G, II sering when push the front pering setting moment on section sering and complete section E, F, G, II sering	 2.3.9 Lifting and filling the needle function 1. Wen the function is set under sering as you please ade, the auchine will execute needle lifting or half-strict hilling. 2. Wen the function is act under constant sitch average, and the machine will execute needle lifting the plant will be filled to be action average. 2. Wenther the function is act under constant sitch average. 2. Wenther is present will filled filled each action average. 2. A second the ray persent will be filled will be added to be action average. 3. A second the ray is present will be filled filled each action average. 3. Press the related two genes the function. The icon will be lighted. 3. Press the related two genes the function. The icon will be lighted. 4. A for activity added the auchine will not stop will complete the consecutive back-tracking sering function, push the front part of the pold is complete the consecutive back-tracking sering function, push the front part of the pold is complete the consecutive back-tracking sering. 3. A constant function is activated, the makine will not stop will completely and the set consecutive back-tracking will be encoded up to be pared. 3. A constant function is one one close the function. The related icon is lighted when egen, disageared when close. 3. A constant function is posen or close the function. The related icon is lighted when egen, disageared when close. 3. A constant function is posen or close the function. The related is not singlet the set will not stop will be average. 3. A constant function is posen or close the function. The related is not singlet when egen, disageared when close. 3. A constant function is posen or close the function. The related is not singlet when egen, disageared when close. 3. A constant function is posen or close the function of the beyond fibes of noise of noise of noise. 4. The average the constant f	A.1.2 Magnet steel mode When Ph-13-1, needle positioning mode setting method is magnet steel mode, increased position is sat up, as long as the hand position. Subject is motified by the position is sat up, as long as the hand position. 1. she, a bloor is not disassembled, moved, the needle position consect to be accelled position. 2. Sup on the one of position. 3. Sup on the one of position. 4. Sup on the one of position. 5. Sup on the one of position. 5. Sup on the one of position. 5. Sup on the one of position. 6. Sup one of position. 7. Sup one of position. 8. Sup one 2.3.1 one one vystee parameter set in an in controller one or the answer on an one of the answer of position. 8. Sup one of the one of position. 9. Sup one one one of position. </td
$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2. 3 Functions operation 2. 3.1 Back-tracking seving function Check start-back-tracking seving steps as following: 1. Press the related key to set starts back-tracking seving alternatively. 2. The starts back-tracking seving steps as following: 2. Press the related key to set starts back-tracking alternatively. 3.1 Back-tracking seving the set starts back-tracking seving. Then press the key consecutively, and it Will set as (1) start back-tracking sering. (2) Setting alternatively. 3.2 Ead back-tracking seven place function key to activate the function. 3.4 The setting as you place function key to activate the function. 3.4 The setting on the pediel to reserve the sering as you please function. 4.4 After setting on the pediel to seven the sering as you please function. 3.4 After setting on the pediel to hist setting does are close on setting sering. 4.7 Press reving as you please function key to activate four section mode. 5.8 Constant Stitch Serving 7 One section mode: 1.7 Press reving section setting function key to activate four section mode. In the same time, press s/- to set the number of section for the section beach in the section setting function and the analytic function function function key to activate four section meeting functions and the starking the reset of the section section for the section setting function function hey to activate four section section for a set to act the number of section 6 and II stitches. 5.8 Conserving model 6. After setting four section setting function, the makine will execute one section for all stitches. 6.4 After setting four section setting function, the makine will execute four section for all stitches. 7.8 The setting function key to cativate four section serving and complete section 6 and II stitches. 8.4 After setting four section serving function, the makine will execute four	 2.3.9 Constant fulling the needle function I here the function is set under sering as yos please ande, the makine will execute needle lifting or half-strict hilling. The function is set under sering as yos please ande, the makine will execute needle lifting or half-strict hilling. The function is set under sering as yos please ande, the makine will execute needle lifting or half-strict hilling. The function is a strict of meakine is a paradet. I the function is a transfer due to function sering. 2.3.9 Consecutive back-tracking serving function 3.1 Prease the related by the serving the tracking interface. 3. Prease thick settle service that the function is a function of the paradet. 3. Prease thick settle service that the tracking serving function are into a settle set	<text></text>
$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2. 3 Functions operation 2. 3.1 Back-tracking seving function Check start-back-tracking seving tops as following: 1. Preas the related key to set starts back-tracking adventurely. 1. Preas the related key to set starts back-tracking adventurely. 1. Preas the related key to set starts back-tracking adventurely. 2. A four the related key to set starts back-tracking adventurely. 3. A four the related key to set starts back-tracking adventurely. 3. A four the related key to set starts back-tracking adventurely. 3. A four the related key to set starts back-tracking adventurely. 3. A four the related key to set starts back-tracking adventure of a stitute of the start of adventure of the start of the start of adventure of the start of the start of the start of adventure of the start of the start of the start of adventure of the start of	 2.3.9 Control of the second control	 A.1. A Magnet steel mode. When FP-13-1, needle positioning mode setting method is magnet atteel mode, FP-13-1, needle position is set up, as long as the hand, for the same location is set up, as long as the hand is magnet atteel mode. A. Setting the model position. A. Setting
$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2.3 Functions operation 2.3.1 Back-tracking seving function Check start-back-tracking seving items as following: 1. Press the related lay to set starts back-tracking seving items as following: 2. A pressive related lay to set starts back-tracking seven and the maker of stickes can be set between 0 and 13. 3.4 A pressive related lay to set starts back-tracking seven and the maker of stickes can be set between 0 and 13. 3.4 A structure of the stickes for section A and B to pressing v/-, and the maker of stickes can be set between 0 and 13. 3.4 A structure of the stickes for section A and B to pressing v/-, and the maker of stickes can be set between 0 and 13. 3.4 A structure of the stickes for section A and B to pressing v/-, and the maker of stickes can be set between 0 and 13. 3.4 A structure of the stickes of the section and the structure of the section and the solution of the structure of the section of the section be and the structure of the section and the solution of the section and the machine will finish the section E avering as set. Pour section seving mode: Pour section seving mode: Pour stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectively with maker for 0 to 99. Pores stickes respectivel	 1. One the function is set under sering as you places made, the multihe will exect to eaself lifting or half-strict fitting. The function is not under sering as you places made, the multihe will exect to eaself lifting or half-strict fitting. The function is not the multiple of the series of o	 A.1. Magnet steel mode Mark Phy-B-1, needle positioning mode setting method is magnet ateel mode, Ry-B-1, needle position is set up, se long as the hand position is set up, se long as the hand position is setting method is magnet ateel mode, needle not disassembled, moved, the medile position cases to be added position. a. she method for polad, derive the model a needle stop position. b. stop method position, brightsing the medies at media to position. c. stop method position. c. stop meth
Fn - 57The time before Foot lifter mattin (a)500900The time between thread take action and Foot lifter actionFn - 58Foot lifter action to minimize the time (b)301120Foot lifter action to minimize the time (b)Fn - 59UP seedle position adjuttant (degrees)15130UP needle position adjuttant (US is the central licetion)Fn - 60adjuttant (degrees)180120220Down meedle position adjuttant (US is the central licetion)Fn - 61Power on and positioning adjuttant	 2. 3 Functions operation 2. 3.1 Back-tracking seving function Check start-back-tracking seving steps as following: Preas the related key to set starts back-tracking advantation. 3.1 Back-tracking seving the starts starts back-tracking advantation. 3.2 Back-tracking seving the starts back-tracking advantation. 3.4 Back-tracking seving steps and starts back-tracking advantation. 3.5 Back-tracking seving steps that back-tracking advantation. 3.6 Back-tracking seving steps that back-tracking advantation. 3.7 Press seving as you please function key to activate the function. 3.8 The setting on the pediel to receive the sering as you please. 2.3.2 Southant Stitch Serving. 2.3.3 Constant Stitch Serving function key to activate one section sering. 3.8 The related ion is diplayed on the panel to hint setting do are settion sering. 3.9 The related ion is fighted on the panel to hint setting do are settion sering. 4.1 Press section constant stitch serving function key to activate four sections setting muttime and the machine will finish the section for avering as you please. 4.2 The related ion is fighted on the panel to hint form section sering add, then press v/- to set the imber of section for a setting setting setting setting interface, press v/- to set the number of section 6 and 11 stitches. 4.1 After setting four section sering function, the machine will section four section activate four section sering and complete section 5, 0, 0, 0, 0, 0, 0, 0, 0, 0, 0, 0, 0, 0,	 2.3.9 Lifting and filling the needle function 1. Wen the function is set under sering as you please ade, the auchine will execute needle lifting or half-strict filling. 2. Wen the function is act under constant sittle needle. and the auchine will execute needle lifting or half-strict filling. 2. Wen the function is act under constant sittle needle. and the auchine will execute needle lifting the lift spin of the auchine will execute needle lifting the lift spin of the auchine will exceed needle lifting the lift filling devices of the auchine will execute needle filling function execute needle filling function execute needle lifting the lifting of each act in a setue. 3. Press the related two filling function. The icon will be lighted? 3. Press that the the regret true in a first day parameter b. 4. After astitus the consecutive back-tracking serving function, put the front part of the pold to complete the consecutive back-tracking serving function. The lifting will and the serving of the regret in the regret true is first day parameter b. 4. Bo also extend function is activated, the auchine will not stop will completely al the steps of consecutive back-tracking will be exceeded. 3. O Slow start function is going one calce the function. The related icon is lighted then agen, disagneared twen clear. 4. The sath the related two fills on going on clear the function. The related icon is lighted with gene disagneared when clears. 5. A D Slow start function is going does not clear the function. The related icon is lighted with agene and the sector part of the pold is panded during series and the sector part of the pold is panded and then agene, disagneared when clears. 5. The start factor is to goong on clear the function. The related icon is lighted with agene and the pole sector part for the pole is panded. 6. The start factor is to goong on clear the function is the start start clear with the create	 A.1.4 Magnet steel mode We here 1-21-1, needle positioning mode setting method is magnet atteel mode, Research 1, nored, takes setting method is magnet atteel mode, and the setting method is magnet atteel mode. A. Setting the model position. A. Setting the model position will it rankes the reprirement of users. A. Market of model position will it rankes the reprirement of users. A. Setting the model position will be possed with the posses attend from the model and possed model posses. A. Setting the model position will be possed with the posses attend from the neutral model of model possition. A. Setting the model will be possed with the posses attend from the neutral model of model possition. A. Setting the model will be possed with the posses attend from the neutral model of model possition. A. Setting the model will be possed with the posses attend from the neutral model of model possition. A. Setting the model will be possible of the model will be possible of the neutral model of model possition. A. Setting the model will be possible of the model will be possible of the model of the m
Fn - 57The time before Fost lifter matting (a)500900The time between thread take action and Foot lifter actionFn - 58Ten titter action (a)301-120Fost lifter action to minimize the time (b)Fost lifter action to minimize the time (b)Fn - 59(P medile position adjustment (b) graves151-20Fost lifter action to minimize the (b) is the central location)Fn - 60Down medle position adjustment (degrees)180120-220Down medle position adjustmentFn - 61Power on and positioning states of thread triming states (degrees)20120-120Eventral too the rate of somal stepFn - 62the rate of somal step (b)32530-1999Set the rate of somal stepFn - 63The rate of somal step (b)201~120Forced dust-down dire hold time.Fn - 64hold time of flack-Tasking (a)201~120Forced dust-down dire hold time.Fn - 66Low-speed start-up time states (b)10-5The higher the gar, and start to accelerate the factation (b) routine eable)Fn - 68Sering moline minimeance operation duty rele (b)100-50Fost lifter electromagnet queries in daty cycle to state height release in the start stangel queriesFn - 68Sering moline minimeance operation duty rele (b)0-9999Set the sering moline malter mathemater cycle (cing the start indication and/eFn - 71Incode pails make degrees (in)-0-9999Set the start stangel queriesFn - 72Reduction addition	 2. 3 Functions operation 2. 3.1 Back-tracking seving function Check start-back-tracking seving steps as following: 1. Preas the related key to set starts back-tracking deving atternatively. a the back-tracking seving steps as following: a the back-tracking seving steps as following: b the back-tracking seving steps as following: c the setting seving as you please. c the setting seving as you please function key to activate the function. c there setting seving and the peakel to insert the thering as you please. c the setting seving as you please function key to activate one section seving. c the related icon is injusted on the peak to thirt setting does a setting seving. c the related icon is injusted on the peak to the part of the peak to activate one section seving. c the related icon is injusted on the peak to hirt setting doe activate one section seving metrics and the analytic of seving model. c the related icon is injusted on the peak to low the peak to a to the peak to activate four seving metrics. c the related icon is injusted on the peak to low the seving seven seving as you please. d the related icon is injusted on the peak to low the seving seven seving seven seve	<text><text><text></text></text></text>	A.1.4 Magnet steel mode When Pr-14-1, needle positioning mode setting method is magnet atteel mode, Pr-14-1, needle position is set up, as long as the hand, adjusting the model position is set up, as long as the hand. Output: The set of issue based position is set up, as long as the hand. Output: The set of position will it rankes the regiment of users. Output: The set of position will be readied to position. Output: The set of position will it reades the regiment of users. Output: The set of model position. Output: The set of position will it reades the regiment of users. Output: The set of model position.
$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2.3 Functions operation 2.3.1 Back-tracking seving function Check start-back-tracking seving tops as following: 1. Preas the related key to set starts back-tracking faithermittely. 2.4 Adjust the stitcher for section A and By pressing +/-, and the maker of stitches can be set between 0 and 15. 2.8 Adjust the stitcher for section A and By pressing +/-, and the maker of stitches can be set between 0 and 15. 2.8 Adjust the stitcher for section A and By pressing +/-, and the maker of stitches can be set between 0 and 15. 2.8 Adjust the stitcher for section A and By pressing +/-, and the maker of stitches can be set between 0 and 15. 2.8 Adjust the stitcher for section A and By pressing +/-, and the maker of stitches can be set between 0 and 15. 3.8 Adjust the stitcher for section A and By pressing +/-, and the maker of stitches can be set between 0 and 15. 3.8 Adjust the stitcher by the sacinate the forction. 3.9 The statistic section stipplace function by the sacinate the forction. 4. The related ion is fighted on the panel to hint stitug do section section series. 4. The related ion is fighted on the panel to hint stitug do section sets. 7. Fore satistic section E sering as set. 7. Fore satistic section E sering as set. 7. Fore satistic section E sering as set. 8. The related ion fail fighted in the panel to hint fore section sering and extitus do, then press +/- to as the maker of section E which maker for a to 10.9. 9. Press stitch aclection function key to change to interface where to as the maker of section G and B interding interface, press +/- to as the maker of section G and B interding interface, press +/- to set the maker of section G and B interding interface, press +/- to set the maker of section G and B interding interface, press +/- to set the maker of section G and B interding interface, press +/- to set the maker of section G and	 1.9.4.9 Lifting and Illing the needle function 1.9. The the function is set under sering as yop place ands, the makine will exect easeful fifting or half-minic avering and the step or or one sector half-minic mark the half-minic fifting or half-m	 A.1. Magnet steel mode. When FP-23-1, needle positioning mode setting method is magnet atteel mode, FP-23-1, needle position is set up, as long as the hand is needle sposition is set up, as long as the hand is needle sposition. a. step on the order logarithe, brightnik the magnetic steel adjusting the res on the hand is needle sposition. b. step on the order logarithe. The step of the set up, as long as the hand is needle sposition. b. step on the order logarithe. The step of the set up as long as the hand is needle sposition. b. step on the order logarithe. The step of the set of the se
Fn - 57The time before Foot lifter action (a)50090The time between Thread take action and Foot lifter actionFn - 58Foot lifter action to minimate the time1010-120Foot lifter action to minimate the timeFn - 59UP seedle position adjustment (dagrees)15130UP needle position adjustment (US is the central hostical)Fn - 60Dawn needle position adjustment (dagrees)18010220Down needle position (dagrees)Fn - 61Paer on and positioning adjustment (dagrees) ReservedReservedFn - 62The rate of thread trimming top (b)20530-1999Set the rate of acronal stopFn - 63The rate of thread trimming top (b)301-120Forced alut-down after hold time.Fn - 64hold time of the-k-tacking (c)301-120Forced alut-down after hold time.Fn - 65Lee speed maxima output torque (b)2510-80Lee speed maxima output torqueFn - 67Poot lifter electromagnet operation day cycle (b)3010-90Does 116 the set compact grave to the fast or (0.977)Fn - 68Seving minitine maintenance eperation day cycle (b)3010-920Direct drive UP position (direct close)Fn - 70System fluit information code ercle day	 2.3 Functions operation 2.3.1 Back-tracking seving function Check start-back-tracking seving items as following: 1. Press the related key to set starts back-tracking seving. When press the key consensively, and it Will set as (1) start back-tracking seving items are indicated by pressing -/, and the maker of stitches can be set between 0 and 13. 3.2 Seving as you please 1. Press the related key to set starts back-tracking seving. When the stitches can be set between 0 and 13. 3.3 Seving as you please 1. The stitches of a stitches of the part of the stitches of the sevent de according the above steps. 2.3 Seving as you please 1. The stitches of a stitches of the part of the string design as you please function. 3. After setting edu path the pedal to receive the sering as you please. 2.3.3 Constant Stitch serving 1. Press form section contant stitch serving function key to activate one section sering. 1. Press form section contant stitch serving function key to activate one section serving. 2. Press form section serving model 3. Press form section serving function key to activate four section serving. 3. Press form section serving function key to activate four section serving and the maker of section is highted on the parel to bin four section serving. 3. Press four section serving function key to charge to interface, press -/- to set the number of section and H stitches which ranges from 0 to 90. 4. Press stitch selection function key to charge to interface, press -/- to set the number of section 6 and H stitches which ranges from 0 to 90. 5. Press stitch selection function key to charge to large setting selection 6 and H stitches which ranges from 0 to 90. 6. Press stitch selection function key to charge to large setting selection 6 and H stitches shift serving seven section serving and complete section 6 and H stitches sele	 1. One the function is net under sering as you please made, the muthins will exect the medile lifting or half-mitting information of the machine will execute medile lifting or half-mitting information in the machine will execute medile lifting or half-mitting information in the machine will execute medile lifting or half-mitting information in the machine will execute medile lifting or half-mitting information in the machine will execute medile lifting or half-mitting information in the machine will execute medile lifting or half-mitting information in the machine will execute medile lifting or half-mitting information in the machine will execute medile lifting or half-mitting information in the information is a disclared on the medil. The machine will be halfed. A rest the related two in the study information is findely plane medile in the model of the podel to complete the consecutive back-tracking sering function. The time will not a store of the podel to complete the consecutive back-tracking sering. A rest the related two in a findel by parameter i. B the function is activated, the machine will not atop will completely all the steps of consecutive back-tracking restrict the life on the machine will not a store machine will not a store machine will not a store machine. A rest the related two in the rest rest or of the podel in podel during wering and the set consecutive back-tracking restrict. A rest the related two in the rest rest or the store will that store will complete the store consecutive back-tracking neuronal type is parable. A rest the function is network with the store store of the podel in complete the store store with the rest function is a parameter. A store store function is a pose of close the function. The related length of store store store with the rest function is a store store machine. A store store function is a store store store store store. A store store function is a store store store store s	 A.1. Magnet steel mode. When P₂-13-1, needle positioning mode setting method is magnet ateel mode, incost, incost is not disassembled, moved, the needle position need to need t
Fn - 57 The time before Foot lifter arise (a) 50 090 The time before Foot lifter arise Fn - 58 for each point instance to time (a) 30 1-130 Foot lifter arise to time to taking the time (b) Fn - 59 UP needle point in adjustment (b) 10 120-20 Down meelle point in adjustment (b) Fn - 60 Down meelle point in adjustment (b) 120-200 Down meelle point in adjustment (b) 120-200 Fn - 61 Poer on and position adjustment (b) 235 30-1999 Set the rate of normal stop Fn - 63 The rate of insmal stop (b) 325 30-1999 Set the rate of normal stop Fn - 64 Inditize of the charter to time stop (c) 25 10-40 Lor-speed maxime output torgue Fn - 66 Lor-speed maxime output 25 10-40 Lor-speed maxime output torgue Fn - 66 Sering mohine maintennee 0 0-5 The higher better mager to accelerate the fraction (f) provide (c) Fn - 68 Sering mohine maintennee 0 0-9999 Foot lifter electromager fraction and fraction angle (d) Fn - 76 Foot lifter electromager fraction angle deviation angle (d) 0 0-9999 Foot lifter electromager fraction a	 2. 3 Functions operation 2. 3.1 Back-tracking seving function Check start-back-tracking seving steps as following: 1. Preas the related key to set starts back-tracking seving attempt step. 2. The starts back-tracking seving steps as following: 2. Preas the related key to set starts back-tracking seving. Wen, press the key consecutively, and it Will set as (1) start back-tracking seving steps at set of back-track dual seving on the operated according the dove steps. 2. 2. 2. Seving as you please function key to activate the function. 3. The related ion is diplayed on the panel to hint setting data seving, and please function. 3. After setting ob, pan the pedal to execut the sering as you please. 2. 3. 3. Constant stitch serving: 3. One section mode: 3. Press section constant stitch serving function key to activate one section serving. 4. Press section constant stitch serving function key to activate four section mode. 5. Press section seving mode: 6. Press section seving function key to activate four section serving. 7. Press section seving function key to activate four section serving and section serving function and the makhing the section 1 serving as one. 7. Press stitch serving function key to activate four section serving and complete section 5 and 1 stitches respectively with frames from 0 to 99. 8. Press stitch are lighted on the panel to hint form section serving and section 6 and 1 stitches. 8. After setting four section serving function, the makhing vill secure four section serving and complete section 5 are 1 stitches. 8. After setting four section serving function, the makhing vill secure four section deving and 1 stitches. 9. After setting four section serving function key continuously still secure four section for add 1 stitches. 9. After setting four section serving function key continuously still sec	 1. All fulling and filling the needle function 1. Then the function is as the under sering as yos please ande, the makine will execute needle lifting that parts of the filling function of the start of the machine is paraded. 1. The function is a start of the machine is paraded. 1. The matter of the machine is displayed on the matter. 1. The matter of the machine is displayed on the matter. 1. The matter of the matter of the machine is displayed on the matter. 1. The matter of the	<text></text>
Fn - 57The time before Foot lifter matting (a)50090The time between thread take action and Foot lifter actionFn - 58mains as the tim (a)301-120Foot lifter action to minimize the time (b)Fn - 59UP needle position adjuntant (dagrees)115120UP needle position to minimize the (b) is the central hostical)Fn - 60Den medle position adjuntant (dagrees)100120220Don medle position adjuntant (b) is the central hostical)Fn - 61Poer on and position adjuntantEnservedFn - 62The rate of moral stop (b)32530-199Set the rate of moral stopFn - 63The rate of moral stop (b)32530-199Set the rate of and stopFn - 64hold time of factor (terms 0)2310-30Low speed address output tampFn - 65Low speed attri-up time (terms 0)10 -5The higher the garr, and start to accelerate the factor (to factor of position making 1Fn - 66Low speed attri-up time (terms 0)10 -00Foot lifter electromagnet (soft tamp)Fn - 68Sering machine maintenance (core) (so)00Fn - 68Sering machine maintenance (core) (so)00Fn - 68Sering machine maintenance (core) (so)00Fn - 70System fail informationFn - 71Encoder poilse maker00-399Fn - 72Refinition adaptionFn - 73Opput current for el	 2.3 Functions operation 2.3.1 Back-tracking seving function Check start-back-tracking seving steps as following: 1. Preas the related key to set starts back-tracking deving atternatively. a the back-tracking seving the set of starts back-tracking deving atternatively. a the back-tracking seving atternatively is a start back-tracking seving. The press the back tracking seving atternatively. a the back-tracking seving atternatively is a start back-tracking atternatively. a the back-tracking seving atternative back-tracking start back-track dual seving on be operated according the show steps. a the back-tracking seving atternative back-track dual seving as you please function. a there setting sk, put the pedal to excert the sering as you please. a there setting sk, put the pedal to excert the sering as you please. a there setting sk, put the pedal to excert the sering as you please. b The related icon is in justice function by to activate one section mode. In the same time, press s/- to act stitches of section activation activation and the auxinit setting the one setting setting setting setting setting setting at the setting function activate function setting metric and the pedal to excert one section makes functions and the auxinit setting the setting se	 1. As the function is set under sering as yos places ands, the makine will execute medie lifting that part of the fitting. The function is the theorem and the fitting chain of the set of th	 A.1. Magnet steel mode. Wein Fry-3-1, needle positioning mode setting method is magnet atteel mode, Fry-3-1, needle position is set up, as long as the hand, income the medle position. It is an experimental intermediate the setting method is magnet atteel mode. A. Setting the model position. <
$ \begin{array}{c c c c c c c c c c c c c c c c c c c $	 2.3 Functions operation 2.3.1 Back-tracking seving function Check start-back-tracking seving items as following: 1. Preas the related key to set starts back-tracking seving. Then press the key consecutively, and it Will set as (1) start back-tracking seving. The set items is a set in the pressing of the set items of an II. 3.4 Algore the stitches for section A and B by pressing +/-, and the maker of stitches can be set between 0 and II. 3.4 Algore the stitches for section A and B by pressing +/-, and the maker of stitches can be set between 0 and II. 3.4 Algore the stitches for section A and B by pressing +/-, and the maker of stitches can be set between 0 and II. 3.4 The section pression and the section is diplayed on the panel to iterate the function. 3.4 The section is diplayed function between the sering as you please. 3.5 Algore and a pression of the panel to hint setting do section section. The section mode. 3.4 The related icon is fliphed on the panel to hint setting do section section sering. 4.7 There a funct section straing back function by to activate one section section. It has an existing function and the anchine will fliphed on the panel to hint form section sering and existing a section of and it has a section and the anchine will fliphed on the panel to hint form section sering and existing a section of and it stitches section and the anchine will the section a section and and it has a section a section and the anchine will be section a section and and it section section and a section and and a section and a section and a section and a section and and a section and and an antickes shift the section and and its section and a section and and antickes shift the section and and its section and and antickes shift the section and and its section and and antickes shift the section and and its section and and antickes shift the section and anot and the section and anot and the anchine will sectio	 1.9. Can be direction is net under sering as pay plazes made, the mathine will execute medile lifting or half-miting interfaces of the mathine is a part of the part	 A.1. Magnet steel mode When Fy-2-3-1, needle position is not a setting method is magnet atteel mode, Fy-2-3-1, needle position is set up, as long as the hand, setting method is magnet atteel mode, is not disassembled, moved, the medile position needs to be added to
Fn - 57The time before Post lifter matting (a)500900The time between thread take action and Post lifter actionFn - 58For lifter action to minimate the time (a)301120Font lifter action to minimate the time (a)Fn - 59UP seedle position adjustment (degrees)15130UP needle position adjustment (15 is the central location)Fn - 60Deam seedle position adjustment (degrees)180100220Deam seedle position adjustment (15 is the central location)Fn - 61Poser on and positioning	 2.3 Functions operation 2.3.1 Back-tracking seving function Check start-back-tracking seving steps as following: Preas the related key to set starts back-tracking astematics? 3.4 In the track tracking seving steps as following: 3.5 Preas the related key to set starts back-tracking advantation? 3.6 In the back-tracking seving steps as following: 3.7 Preas seving as your please function key to activate the function. 3.8 The back-tracking seveng the set that the tracking the seving as you please function. 3.8 After setting ob, push the pedia to recearch the sering as you please function. 3.8 After setting ob, push the pedia to recearch the sering as you please. 3.8 Constant stitch serving 3.9 One section mode: 1. Press section constant stitch serving function key to activate one section serving. 3.9 The related loss is all plated on the paule to hist setting does settion work. 3.1 Break-tracking serving as your please. 3.2 Constant stitch serving: 3.1 Press section serving model. 3.2 The related loss is all plated on the paule to hist for setting setting add, then press s/- to set the induce of the section factor and the section factor and the setting function key to activate four section serving and complete sections for all setting interface, press s/- to set the number of section G and II attiches which mange from G to 90. 4.1 After setting four section serving function, the machine with lacence four section and II attiches which mange from G to 90. 4. After setting four section serving function, the machine will secure four section G and II attiches. 4. There should be from part of the padl. 5. After setting four section serving function, the machine will secure four section serving and complete section E, F, G, II serving then padl. 5. After setting four section serving function, the machine will	 1.9. Can be determined in the service as you please made, the mathine will exect the medile lifting or half-mathin filling. The the function is net under service as one please made, the mathine will execute medile lifting or half-mathin filling. 2. The the function is net under constant with the mathine will execute medile lifting or half-mathin filling. 2. The the function is net under constant with the mathine will execute medile lifting or half-mathin filling. 3. The mathine will execute medile filling function service. 3. Presenture based-tracking services mathine will be lighted. 4. The mathine will execute medile filling function. The item will be lighted. 4. Presenture based-tracking services in displayed on the part of the podul to complete the consecutive bask-tracking service. 4. Presenture based-tracking services in the filling the mathine will execute as one of the podul to complete the consecutive bask-tracking service. 4. Presenture function is networks: 4. Presenture function is groupe on the state will not state will complete the consecutive bask-tracking reservice. 4. Presenture function is groupe on the state will not state subjet to service the state state of the podul is poduled during average and the serve consecutive bask-tracking reservice. The podule of the podule life poduled during will go at the state state of the podul is parked, and then operate normally. 5. Present function is groupe on the state state state state to back-tracking neering reservice. 6. And then operate normally. 6. The state states is decreased in the state state state state. 7. Present function is groupe on the state state state state. 7. Present function is	<text></text>

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