

### ⚠ Safety Instruction

- Users are required to read the operation manual completely and carefully before installation or operation.
- All the instruction marked with sign ⚠ must be observed or executed; otherwise, bodily injuries might occur.
- The product should be installed and pre-operated by well trained persons.
- For perfect operation and safety, it is prohibited that using extension cable with multi-outlet for power connection.
- When connecting power supply cords to power sources, it is necessary to make sure that the power voltage is lower than 250 VAC and matches the rated voltage indicated on the motor's name plate.
- ⚠ ※Attention: If the Control Box is AC 220V system, please don't connect the Control Box to AC 380V power outlet. Otherwise, the error will occur and motor will not work. If that happens, please turn off the power immediately and check the power voltage.
- Don't operate in direct sun light, outdoors area and where the room temperature is over 45°C or below 5°C.
- Please avoid operating near the heater at dew area or at the humidity below 30% or above 95%.
- Don't operate in area with heavy dust, corrosive substance or volatile gas.
- Avoid power cord being applied by heavy objects or excessive force, or over bend.
- The earth wire of power cord must be connected to the system ground of the production plant by proper size of conductions and terminals. This connection should be fixed permanently.
- All the moving portions must be prevented to be exposed by the parts provided.
- Turning on the machine in the first time, operate the sewing machine at low speed and check the correct rotation direction.
- Turn off the power before the following operation:
  - Connecting or disconnecting any connectors on the control box or motor.
  - Threading needle.
  - Raising the machine head.
  - Repairing or doing any mechanical adjustment.
  - Machines idling.
- Repairs and high level maintenance work should only be carried out by electronic technicians with appropriate training.
- All the spare parts for repair must be provided or approved by the manufacturer.
- Don't use any objects or force to hit or ram the product.

### Guarantee Time

Warranty period of this product is 1 year dated from purchasing, or within 2 years from ex-factory date.

### Warranty Detail:

Any trouble found within warranty period under normal operation, it will be repaired free of charge. However, maintenance cost will be charged in the following cases even if within warranty period:

- Inappropriate use, including: wrong connecting high voltage, wrong application, disassemble, repair, modification by incompetent personnel, or operation without the precaution, or operation out of its specification range, or inserting other objects or liquids into the product.
- Damage by fire, Earth quake, lightning, wind, flood, salt corrosive, moisture, abnormal power voltage and any other damage cause by the natural disaster or by the inappropriate environments.
- Dropping after purchasing or damage in transportation by customer himself or by customer's shipping agency

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

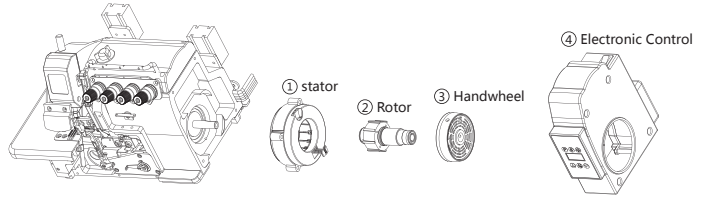
## 1 Installation

### 1.1 Power Connection

⚠ For countries or regions with unstable power supply, it is proposed to install a power stabilizer.

### 1.2 Motor Installation:

#### Installation of Internal Motor



## 2: Keysfunction

Entering the parameter mode		1. Press key P to enter into user parameter setting mode. 2. Long press key P in the same time turn on the power switch from off to enter into system parameter setting mode.
Setting Parameter Check And Save		After setting the function code, press this key to check the preset parameter and then can edit the parameter accordingly. When the parameter is fixed, press key to save the setting and quit.
On the adjustment key		1. Choose the region parameter items incrementing key 2. Parameter setting value incrementing key
Under the adjustment key		1. Choose the region parameter items of diminishing key 2. Is decremented key parameter settings
LED brightness adjustment shortcut key		Press this key to adjust LED brightness (same as the P16)
Slow play seam selection shortcuts/ Select the shortcut needle position		1. Slow play seam selection shortcuts 2. Select the shortcut needle position

## 3 Operating instructions

### 3.1: Reset the system

1. Under the shutdown state, hold on the "up" key and "down" key to boot, then double-click the S key to confirm it, shutdown restart.

### 3.2 Enter the user argument and save changes

1. Under normal mode, press key P enter to **【User parameter area】**  
2. Press S key enter to parameter content value; Changed the value through "up"/"down" key, and then press S key to save the value.

### 3.3 Enter technician mode and save changes

1. In the shutdown state, hold on key P to turn on machine and enter **【Technical parameter area】**  
2. Press S key enter to parameter content value, changed the value through "up"/"down" key, and then press S key to save the value.

## 4: User Parameter & Technician Parameter

### 4.1 User Parameter

Parameters	Parameter Function	Range	Default	Description
P01	Maximum speed	200-600	5000	set the max sewing speed (show the actual number *10= speed)
P02	needle stop position selection	000-002	000	set the needle stop position(0: needle up 1: needle down)
P03	soft start switch	000-001	000	soft start switch setting(0:OFF 1: ON)
P04	soft start sewing speed	200-1500	400	soft start sewing speed setting(show the actual number *10= speed)
P05	stitches number of soft start	001-015	001	set the stitches number of soft start, each unit is half stitch
P06	Minimum speed	200-500	200	set the minimum speed (show the actual number *10= speed)

### 4.2 Technician Parameter

Parameters	Parameter Function	Range	Default	Description
P07	Up Position Adjustment	000-024	000	
P08	Down Position Adjustment	000-024	012	
P09	Needles Goes Up Automatically as Power turned on	000-001	001	0: No Function. 1: Power turned on, needle goes up position automatically
P11	Speed Curve Adjustment (%)	001-100	032	The Larger the value, the faster to increase speed
P15	Stitch Correction Mode	000-003	000	0: Half stitch 1: One stitch 2: Continuous correct half stitch Continuous correct stitch and quickly stop machine.
P16	Machine head lamp brightness	000-004	4	0: OFF; 1-4 the brightness grade, the more value the more brightness.
P21	motor rotate direction	000-001	000	motor rotate direction setting (0:clockwise 1:counter-clockwise)
P22	auto running speed	200-6000	3500	auto running speed setting(show the actual number *10= speed)
P23	auto running time	001-250	020	set the auto running time in testing
P24	auto running stop time	001-250	020	set the auto running stop time in testing
P25	Item A test	000-001	000	Item A test setting(continue running with constant speed)
P26	Item B test	000-001	000	Item B test setting( carry out the set loop running)
P29	Inhale feature selection	000-002	001	0: OFF; 1: Inhale feature; 2: Foot Lifting when Half-Heeling the Pedal
P36	Type	001-010	010	

## 5 Error Code Table:

Error	Problem	Measurement
E01	1) When power on, detected main voltage too high. 2) When the supply voltage is too high	Turn off the system power supply, and detect whether the supply voltage is correct. (Or exceed the rated voltage.) If correct, please replace the control box and inform the factory
E07	a)Bad connection at the motor connector. b)Machine locked or object stuck in the motor pulley c)Sewing material is too thick. d)Module output is abnormal.	If normal running, please check the encoder connector and motor power cord connector if loose. If loose please tight connection. If connection well, please check supply voltage whether abnormal or setting speed too high. If have please modify. If normal, please replace the control box and notify the manufacturer.
E09 E11	Synchronizer signal error.	Turn off the system power supply, please check motor encoder connector if loose or fall off, renew to normal then restart system. If still not work, please replace the motor and notify the manufacture.
E14	Encoder signal error.	Turn off the system power supply, please check motor encoder connector if loose or fall off, renew to normal then restart system. If still not work, please replace the motor and notify the manufacture.
E15	Power module abnormal over current protection	Module driver output and head output will close all. Waiting for the power to open / reset. ( please carefully check power supply board each function )
E17	The sewing table safety switch is not in the correct position	Please check sewing table is open or not, the sewing table safety switch is damage or not, the socket is abnormal or not.

## 6: Schematic diagram of port

### 6.1.1: Each port name:

#### ① Clothing lights Interface

Clothing lights Interface  
Clothing lights : 1 ( GND ) , 2 ( +5V )

#### ② Pedals Interface

