

# Industrial Highspeed Overlock Sewing Machine Auto-trimming System

## User Manual

In order to operate this product safely, please make sure to read this manual carefully before use.



Welcome to use the products of our company and it's the right investment choices of clothing industry!

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This is the product reference manual of the company's newly developed "suction line cut". Please carefully read this manual to better use the company's products!



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- 2.
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5 , 45  
30%~90%  
220V 220V 110V  
110V



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1. Do not put your feet on the pedal when the power is connected;
2. This product requires professional installation and commissioning;
3. Do not open the control box when power is on;
4. Turn off the power when changing the needle, threading or replacing the bottom thread;
5. Turn off the power when installing, removing and repairing;
6. Turn off the power when turning or lifting the sewing machine;
7. Away from high-frequency electromagnetic waves and radio waves, etc, in order to avoid the servo drive being interference by the electromagnetic waves and leading to the wrong action.



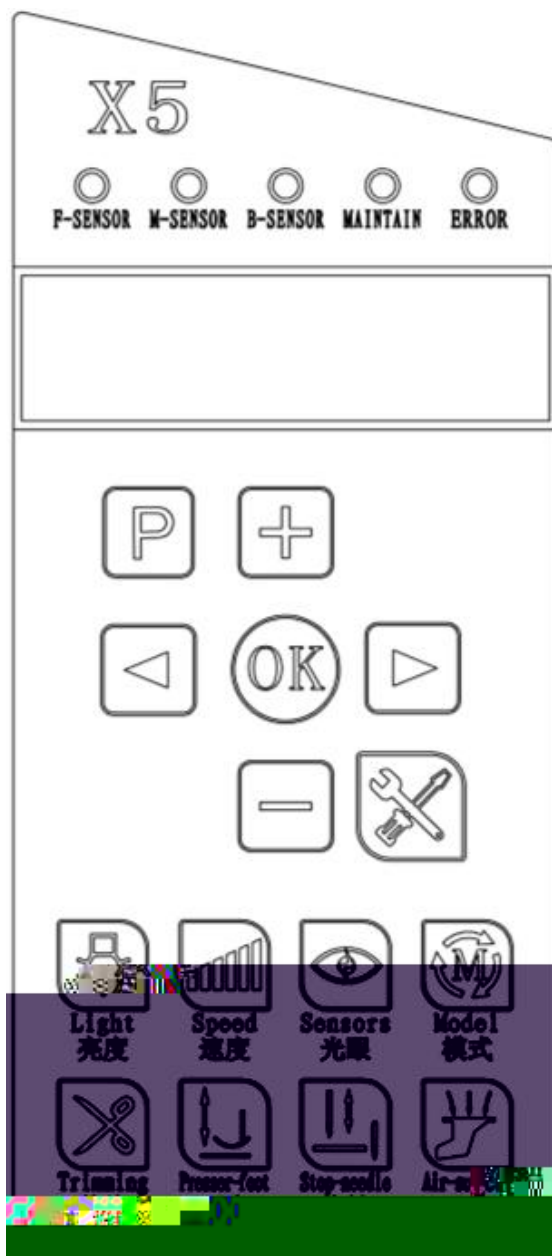
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





















1. Any quality problems other than man-made damage during the warranty period may be free of charge;
2. Without the consent of the company to disassemble, modification damage will not give the warranty;
3. If you can't solve a problem, you can contact the company;
4. The company has the final interpretation of this manual.



3.1

3.2






1		<p>Mode switch key: to switch the current sewing mode, will be in cycle between the free seam, semi-automatic, fully automatic, and normal sewing.</p>
2		<p style="text-align: center;">2</p> <div style="text-align: center;">     </div> <p>Infrared light function key: open and close the infrared light, long press 2 seconds into the light eye sensitivity adjustment.</p> <p>In the light eye sensitivity adjustment interface,</p> <div style="text-align: center;">  </div> <p>click, to automatically adjust the light eye intensity corresponding to thin material, medium material, thick material. After the</p> <div style="text-align: center;">  </div> <p>adjustment is completed, press the button to save.</p>
3		<p>Presser-foot function key: Select the ways of the presser-foot when sewing mode, you can continuously press to successively select before presser-foot, after the presser-foot, before and after the presser-foot, or closed.</p>
4		<p>Trimming function key: select the ways of trimming when sewing mode, continuously press in turn can choose the front cut line, after the cut line, before and after the cut line, or close.</p>

5		Air-suction function key (need to install the suction device): select the method of suction when sewing, continuously press can be selected before the suction, after the suction, before and after the suction, or closed.
6		Stop-needle adjustment key: used to change over the needle bar stop position at the time of stopping sewing between up and down.
7		<div style="text-align: right; margin-bottom: 10px;"> </div> <p>Speed adjustment key: View the current sewing speed, through </p> <p> to adjust the required speed, speed automatically saved.</p>
8		<div style="text-align: center; margin-bottom: 5px;">1      2</div> <p>Head light adjustment key: brightness 1, brightness 2, or brightness off.</p>
9		<div style="text-align: center; margin-bottom: 5px;">2</div> <p>Menu key: enter the user parameters, long press 2 seconds to enter the system parameters (need a password).</p>
10		Confirm key: parameter confirmation key.
11		Numeric adjustment key: used to modify the data.
12		Numeric adjustment key: used to modify the data.
13		Left key: When the parameter is modified, the cursor moves left.

14		Right key: When the parameter is modified, the cursor moves right.	
15		Maintenance key: When the machine need to be adjusted when an exception occurs, press this button or turn off the power for maintenance.	
16	F-SENSOR	The front infrared sensor indicator light	F-SENSOR When the front infrared sensor is blocked by a cloth, F-SENSOR light on, else light off.
17	M-SENSOR	The middle infrared sensor indicator light	M-SENSOR When the middle infrared sensor is blocked by a cloth, M-SENSOR light on, else light off.
18	B-SENSOR	The Behind infrared sensor indicator light	B-SENSOR When the behind infrared sensor is blocked by a cloth, B-SENSOR light on, else light off.
19	ERROR	Safety switch indicator light	Flashing when disconnecting, light off under normal circumstances
20	MAINTAIN	Maintenance indicator light	When the maintenance key is pressed, the lamp flashes and the lamp is turned off after exiting the service mode.






The analysis to enter System parameters: long press () button for 2 seconds into the "system parameters" list (need the password to enter adjustment).  ,  Keys be used to select to modify the parameter value or menu value, the selected place will be flashing.



Keys will increase or decrease the value of the flashing area. After editing the

parameters, press the  key to save the parameters and exit the system parameters.

### 3.1







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			%	% %
			%	



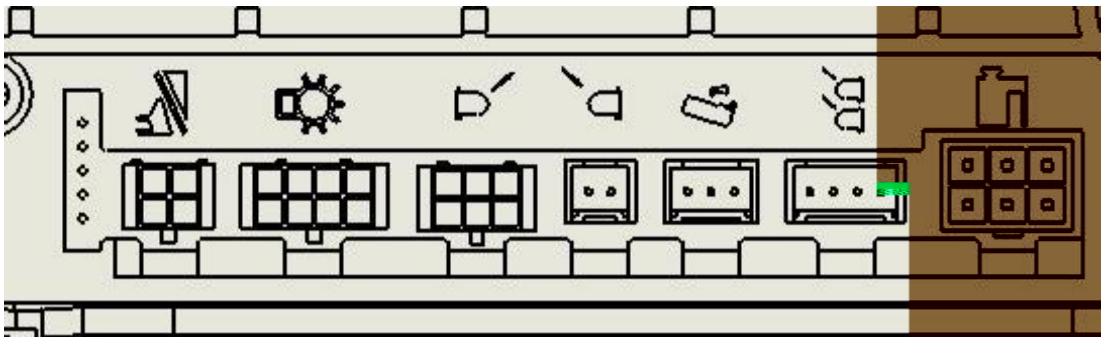

3.2

3.2 Workers system parameter list ( press  to enter )







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1	Speed controller port
2	Head lamp port
3	Presser foot safety switch and behind infrared light launch tube port
4	Behind infrared light receiver tube port
5	Connecting Sewing table safety switch
6	Front middle infrared light receiver tube port
7	Electromagnet: trimming electromagnet, suck wind magnet or magnetic value, pressure foot lifer electromagnet

ER-01		1 2	1 2 3
ER-02		1 2 3 4	1 2 3
ER-03		1 2 3	1 2 3 1MM
ER-04		1 2 3      4	1 2 3 4P

ER-05		1 2	1 2 3
ER-07		1 2	1 2 3 4
ER-11	1	1 2 3	1 2 3
ER-12	2	1 2	1 2 3

ER-01	The signal of the needle is wrong	1 the contact between the needle and Moore thread is bad 2 the permanent magnet on the hand wheel is at wrong position or is demagnetized.	1 check the needle and Moore thread 2 check whether the permanent magnet is at the wrong position 3 change the hand wheel
ER-02	The signal of the speed controller is wrong	1 didn't plug the speed controller in when the machine is on. 2 the speed controller is plugged in at the wrong position.	1 check the signal line of the speed controller 2 change the speed controller 3 change the controller

		<p>3 the speed controller is disconnected.</p> <p>4 the speed controller is broken</p>	
ER-03	The signal of the motor is wrong	<p>1 the contact between plugs is bad</p> <p>2 Moore and rotator have some big deviations when install the motor</p> <p>3 the motor and Moore is broken</p>	<p>1 open the rubber cap and check whether the motor rotator and stator is at the same level, make sure the deviation is less than 1MM</p> <p>2 change the motor</p> <p>3 change the controller</p>
ER-04	The motor stops rolling	<p>1 the sewing machine is too heavy or is stuck</p> <p>2 the motor is overloaded</p> <p>3 the motor's 4 drive lines didn't connect or were plugged at the wrong position</p>	<p>1 check the motor's 4P thread</p> <p>2 check whether the sewing machine is too heavy.</p> <p>3 change the controller</p>
ER-05	Hardware overcurrent	<p>1: The sewing machine is too heavy or blocked</p> <p>2: Motor overload</p>	<p>1: Check if the sewing machine is too heavy</p> <p>2: Replace the controller</p> <p>3: Restart the machine</p>
ER-07	Communication timeout	<p>1 display connection board line connection is bad</p> <p>2 the main board chip is broken</p>	<p>1 check the connection line between the screen and the controller</p> <p>2 check whether the controller can still function. if not, then it's the controller that's broken</p> <p>3 check whether there are some high frequency machines interfering</p> <p>4 change the screen</p>

ER-11	Safety switch 1 is disconnected	<ol style="list-style-type: none"> <li>1 press foot safety switch didn't go back to the right position</li> <li>2 the contact of the connection lines of press foot is bad</li> <li>3 the Moore component of the press foot is broken.</li> </ol>	<ol style="list-style-type: none"> <li>1 check whether the connection line of the press foot safety switch is abnormal</li> <li>2 check whether the magnet of the press foot safety switch has gone back to the right position.</li> <li>3 change the Moore component</li> </ol>
ER-12	Safety switch 2 is disconnected	<ol style="list-style-type: none"> <li>1 sewing platform's safety switch isn't installed right or is broken</li> <li>2 line fault</li> </ol>	<ol style="list-style-type: none"> <li>1 check whether the sewing platform's safety switch is broken</li> <li>2 check whether the sewing machine is lifted</li> <li>3 check whether the plug base is abnormal</li> </ol>