



**LEADING IN
GLOBAL SALES**
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JK-SHIRLEYIIE Operation and Daily Service Manual



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Edited by Customer Service Center
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KNEE FREE



JK-SHIRLEY IIE
computerized machine

PK



Ordinary computerized
machine

**LEADING IN
GLOBAL SALES**

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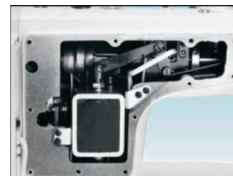
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JK-SHIRLEYIIE



With powermax control box

Presser foot PK



VS

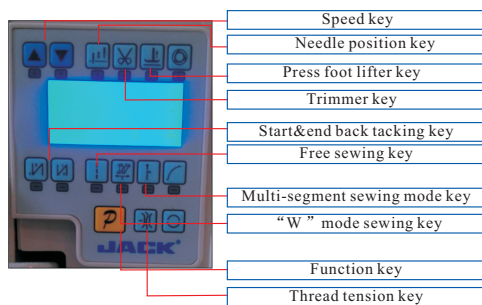


Simple	Beautiful
Efficient	Saving energy
Stable	Low noise

Technical parameter

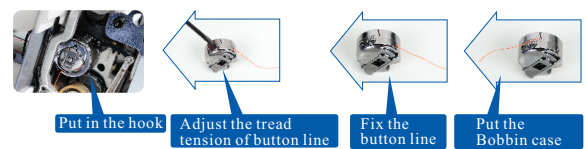
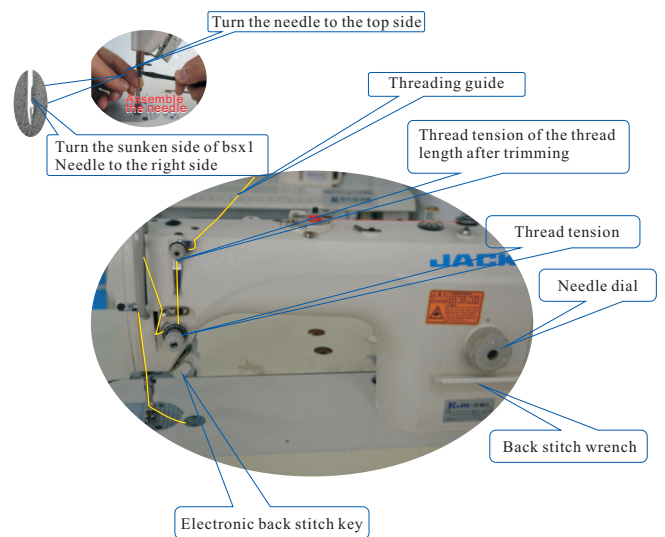
JK-SHIRLEYIIE	
Model	Integrated computerized lockstitch
Fabric	Thin ,medium
Needle size	DBX1, 14#
Maximum needle gauge	5mm
Auto-bar tacking	Standard
Auto-press foot lifter	Standard
Auto-trimmer	Standard
MAX height of Press foot lifter	5/9/12MM
Factory setting of Press foot lifter	9MM
Distance of press foot lifter by hand	5MM
Max speed	5000RPM
Thread tension	Standard

Operator Panel instructions



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Preparation before sewing (Threading)



— 3 —

Mechanical adjustments



The first tension device adjustment

Control the length on the needle after automatic trimming and the thread length around 4-4.5 cm is the best. Adjusting the knob in clockwise way, thread will be short; otherwise, it will be long.



The main tension device adjustment

Control the tension of thread during sewing. Adjusting the knob in clockwise way, the tension will be bigger; otherwise, it will be smaller. If the under-thread loose, the tension should be adjusted stronger, but too stronger would cause upper-thread be cut easily.



Needle gauge adjustment

The left hand holds the backstitch wrench, with the middle finger back from the lock to the needle, with the thumb and index finger rotating needle gauge plate. The gage will be smaller when turning in clockwise way and will be bigger when turning in anti-clockwise way.



Reverse-sewing button Operation

During sewing, keep pressing the reverse-sewing button, the machine will be in reverse-sewing state; otherwise, the machine will be in sewing state.

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Instruction of Pedal Control



Original state

Turn on the power, machine will be up needle position, the pedal will be as original state.





Step forward to run:

When powered on, the speed will change as the pedal stepped deeper, the deeper the pedal stepped, the higher the speed will be.



Step backward to trim and stop:

After sewing, step the rear of pedal, machine will trim and stop. If there is presser foot lifter accessories, presser foot will lift when stepping backward further.

Press  and  together to enter technician mode, the pedal control mode can be changed by adjusting the following parameter:

P30: Pedal Curve mode setup (0: Auto Calculated liner Curve; 1: Two segment liner Curve; 2: Arithmetic Curve; 3: S curve)

P34: Pedal trimming position set (the value is not higher than the parameter [35]); when adjust P34, need to adjust the value of P35 closer to the value of P36, that's the sensitivity of trimming

P35: Press foot lifting (the value is between [34] and [36].)

P36: Pedal back mid position (the value is between [35] and [37].)

P37: Pedal step upon running position (the value is between [36] and [38]), if want the machine to response faster, need to turn down the value of P37, but the value should be higher than P36

P38: Pedal low speed running position (the value is between [37] and [39])

P39: Pedal simulation the largest of value (the value is not lower than the parameter [38])

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Selection of Sewing Mode



Press this key, the machine enters into "free sewing mode", the sewing length can be controlled by the operator, that is why we called this function as "free sewing model". It's often used for lap seam and bar-tacking sewing.



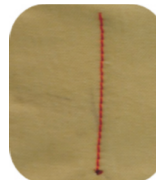
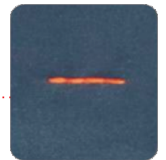
Press this key, the machine enters into "fixed-stitch sewing mode", the sewing length and segment is confirmed by the operator through control panel, and sewing will be finished automatically. The operator only needs to pedal the speed controller, then will work automatically till finishing the trimming. It's often used for sewing the fixed-length thread segment and the trademark.



Press this key, the machine enters into "W pattern bar-tacking sewing mode", the bar-tacking stitches and times are set up by the operator through control panel, and sewing will be finished automatically. The operator only needs to pedal the speed controller, then machine will work automatically till finishing the trimming. It's often used for straight bar-tacking sewing.

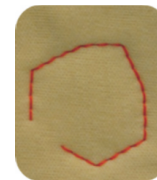
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**Intelligent sewing
simple operation**



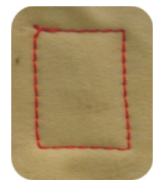
**Fixed-stitch length
sewing model 1:**

You can set the stitch length according to customer's requirement ,after sewing ,it will auto trimmer and auto stop .



**Fixed-stitch length
sewing model 2:**

You can set edges number and stitch numbers of each edge according to customer's requirement ,after sewing ,it will auto trimmer and auto stop .







**Common Fixed-stitch
length sewing model:**

It is used to sewing rectangular lables.

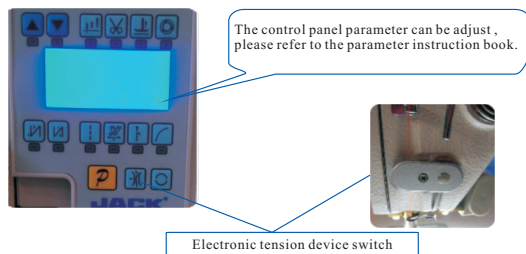
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Speed

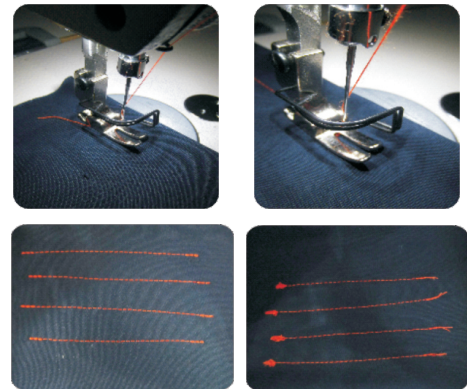
Keeping press  then press  , will be displayed “Pd-0000”, press 
enter “P62-2101”, press  to confirm.

Parameter code	Default	Parameter definition	Adjusting instruction
P00	200	Beginning sewing speed	Limit the maximum beginning speed
P01	3500	Sewing speed	Limit the maximum sewing speed
P02	3000	Fixed-length sewing speed	Limit the maximum fixed-length sewing speed
P03	3000	Manual reinforced sewing speed	Limit the maximum manual reinforced sewing speed
P05	250	Trimming thread speed	The speed of mainshaft when trimming
P10	1800	The beginning reinforced sewing speed	The speed of mainshaft when the beginning reinforced sewing
P11	1800	The finishing reinforced sewing speed	The speed of mainshaft when the finishing reinforced sewing
P12	1800	“W” sewing speed	The speed of mainshaft when “W” reinforced sewing

Trial sewing





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no thread on upper side

realize clean sewing
in the bottom side

Needle Position

Press and hold button  ,press button  at the same time ,
enter into “system programmer parameter mode”

P42: needle position up adjustment

With this parameter can realize machine to stop at any angle position

When adjust the parameter, make sure to rotate the hand wheel by hand ,after adjust to a suitable position and then,press button “ P” to save

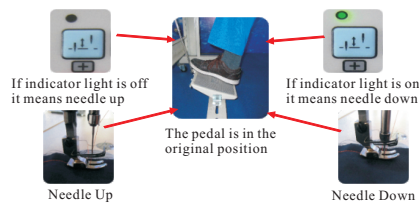
P43: needle-down position down adjustment

With this parameter can realize machine to stop at any angle position

(adjustment method is the same as P42)

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Application of needle position



Needle positioning mode

When we switch on the power, if the indicator light is off, it means the needle is up, if the indicator light is on, it means the needle is down.



Note:

During stitching, if you want to change the needle positioning according to your requirements, please stop the machine, make sure the pedal is in the original position, then press the needle positioning button to change as you want.

Presser foot lifter



1. Press this button continuously; this function of the auto-presser foot lifter can be cycling switch between "function on in middle way/function off" and "function on after thread trimming and stop/function off". Suitable for many different operation customs, and different procedures of sewing demands.

2. Press and hold button , press button  at the same time, enter into "system programmer parameter mode".

P44: Delay time of presser foot lifter down

This parameter is defined as the interval time between the presser foot lifter down and the begin of sewing. The bigger the numerical value, the speed of starting sewing is slower; the smaller the numerical value, the speed of starting sewing is faster.

3. "system programmer parameter" P35: setting of presser foot lifter position

4. P78-53 revise as P78-200 (solenoid full output strength time)

P79-05 revise as P79-04 (full output strength connect time)

P7A-05 revise as P7A-06 (full output strength disconnect time)

Thread tension device

Press  and it can open or close the small thread tension device easily.

1. After the user presses the , and it presses the  at the same time, it will enter into system parameter modification mode.

2. P19: choose clamp thread function (0: off, 1: on)

P1A: Angle for clamping thread start

P1C: Angle for clamping thread finish

Bar tacking



Front reinforce stitching switch



Behind reinforce stitching switch

Technology source parameter modification mode

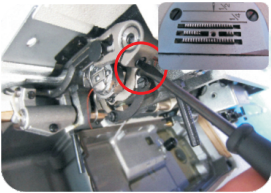
P13: the needle tracing compensation A for front reinforce stitching

P14: the needle tracing compensation B for front reinforce stitching

P15: the needle tracing compensation A for behind reinforce stitching

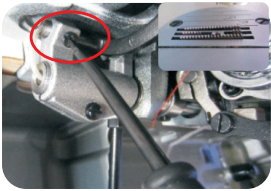
P16: the needle tracing compensation B for behind reinforce stitching

Adjustment of feed dog



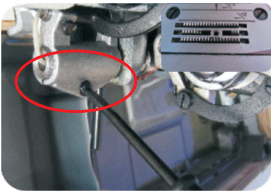
Height adjustment for feed dog

Unscrew the braces screw
For light fabric, appropriately
adjust feed dog lower
For heavy fabric, appropriately
adjust feed dog higher .After
finishing ,tighten the screws.



Adjustment for feed dog gradient

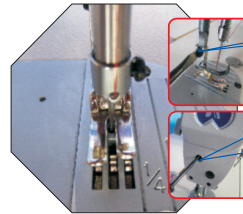
Unscrew the screw,turn the brace
and adjust the eccentric shaft, it can
adjust teeth front or back,high or
low.This step depend on different
fabric.



Front or back for feed dog

Adjust the needle spacing to
maximum, unscrew the braces screw,
and it can adjust feed dog front and
back, when the machine is running,
please pay attention to the teeth
front and back and can not touch the
throat plate ,and feed dog left and
right also can not have the
friction with needle plate.

Adjustment of the presser foot lifter

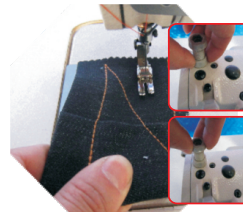


Change the presser footer:

loose the footer screw then can change
the presser footer.

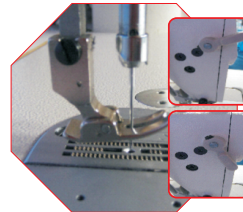
Adjust the footer and needle:

When the needle is not in the middle of the
presser footer ,or the feed dog is in low
position. Unscrew and adjust the presser to
the right position . Then tighten it.



Adjusting the pressure of the presser footer:

Lifting the footer, put the fabric below the footer,
put down the footer, pull the fabric by hand, if
the fabric can be easily pull out, so need increase
the pressure of the footer. Loose the press rod
nut, rotate it in the clockwise direction, if you
want to reduce the pressure, please rotate it in the
anticlockwise direction.





Footer protect:

When the machine work without
fabric, must move up the presser
footer protection wrench, lift the
footer, can reduce the ware rate of
the teeth and presser footer.



Thread trimming



Press the button can turn on or turn off the thread trimming function.

Press  +  at the same time, can enter the technician parameter mode.

P05: Set the trimming speed

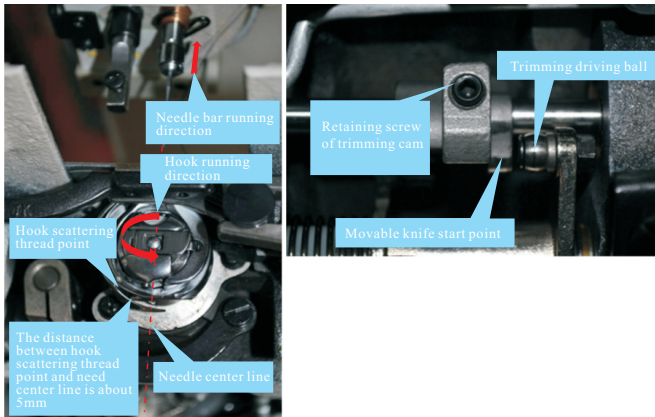
Press  and press  at the same time, can enter system parameter mode.

P03: Start angle shear line

P04: End angle shear line

P0A: Shear line strength angle

Standard method of adjustment trimming



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Adjust method:

Before adjusting the trimming time, we must adjust the height of needle bar, the time of hook drawing thread and needle position.




When the hook scattering thread point is about 5mm away from the needle center line as the picture shows, adjust the trimming cam to the position where the trimming movable knife just starts.

Adjust Description




When the movable knife scattering thread, do not let the hook loose thread. Make sure the hook take in enough thread so that the thread tail will be longer.

Introduction of system operation

Setting to technician parameter

Keep pressing the  +  at the same time. Then loosen both button and press  again to access to technician parameter

Setting to system officer parameter

Keep pressing  button and  button at the same time, loosen, then press  button again to access to system officer parameter.

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Factory Reset



Press **P** button first, then press **+**.
When the displayer shows Pd-0000,
press **P** button to enter P62-2101,
again press **P** button to save.

Common fault treatment(1)

(Err-01)

REASON: Hardware overcurrent

The way to check:

1. Check whether the power supply voltage is 220V +/-20V with a multimeter;
2. Replace the control box with "Replace exclusion method" to see whether the control box is damage or not.
3. Replace the main shaft motor with "Replace exclusion method" to see whether the motor is damage.

Solution:

1. If the power supply voltage is not in the normal range, please check the power cable design is normal or not.
2. If the control box is damage, please replace it or send it back to supplier for repairing.
3. If the motor is damaged, please replace it or send it back to supplier for repairing.

Common fault treatment(2)

(Err-06)

REASON: Solenoid circuit fault

The way to check:

1. check the DC resistance of each solenoid is normal or not with a multimeter (you can compare with the normal machine)
2. Replace the control box with "Replace exclusion method" to see whether the control box is damage or not.

Solution:

1. If any of the solenoid is damage, please replace that solenoid.
2. If the control box is damage, please replace it or send it back to supplier for repairing.

Common fault treatment(3)

(Err-07)

REASON: Current sensor fault

The way to check:

1. check if power line connection between motor and control box is broken or not.
2. Interchange the control box to check it it is the control box problem.

Solution:

1. If connection problem, just need to improve connection.
2. If control box problem, change another one or send the defective control box back to company to repair.

Common fault treatment(4)

(Err-08)

REASON: Motor blocked

The way to check:

- 1.Check if there is any other mechanical fault from machine in running condition.
- 2.Recheck motor angle.
- 3.Interchange the control box to check control box have problem or not.

Solution:

- 1.Make sure there is no any mechanical fault from machine.
- 2.Use P43 , change the last digital parameter from 0 to 2 , step on the pedal, recheck the motor angle , then change the last digital parameter from 2 to 0 and save.
- 3.If control box problem, change another one or send the defective control box back to company to repair.

Common fault treatment(5)

(Err-10)

REASON: Panel no display or panel no power

The way to check:

- 1.check if connection between panel and control box is broken or not.
- 2.Interchange the panel to check if it is the panel problem.
- 3.Interchange the control box to check if it is the control box problem.

Solution:

- 1.If connection problem, just need to improve connection.
- 2.If panel problem, just change the panel.
- 3.If control box problem, change another one or send the defective control box back to company to repair.

Common fault treatment(6)

(Err-12/13/15)

REASON: Motor initial rotor position fault

The way to check:

- 1.Check if connection between motor encoder and control box is in good condition or not.
- 2.Interchange the encoder to check if it is the encoder problem.
- 3.Interchange the control box to check if it is the control box problem.

Solution:

- 1.If connection problem, just need to improve connection.
- 2.If encode problem, just change the encode.
- 3.If control box problem, change another one or send the defective control box back to company to repair.

Common fault treatment(7)

(Err-09)

REASON: Discharge circuit fault.

The way to check:

- 1.Testing discharge cement resistor is burn out or not;

Solution:

1. Replace the cement resistor with same model.
2. Replace the control box or send it back to supplier for repairing.

Daily Maintenance



Keep the machine surface clean



Keep the oil in the oil reservoir not lower than the scale



Make sure that there's oil spraying up in the oil sight window during running



Keep the small oil reservoir clean, no thread dust gathering



Keep the big oil reservoir with clean oil, not getting dirty to black



Clean all around the hook regularly



Disassembly the plate, clean the feed dog and knife bracket regularly

Attachment 1

Machine maintenance knowledge

Daily maintenance:

After work-off, turn off the power first. Clean the dust on the machine and machine head, table, thread holder, and make sure the oil are clear of oil tank.

Weekly maintenance:




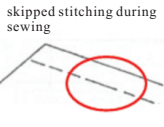

Clean the machine surface and feed dog by disconnecting the needle plate. Take over machine clean the fragment of thread and fabric. Make up the oil if the oil line is lower than the lowest line.


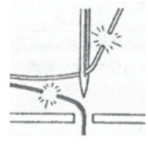

Half year maintenance:

Change all of machine oil. Disconnect the oil screw under the oil tank than unload the oil (PS: PUT A CONTAINER UNER THE TANK TO CATCH THE OIL), clean the tank then install the oil screw and reload the clean oil. Check the whole machine body adjust or replace what parts are noisy.

Attachment 2

Common sewing fault

1	upper thread is not tight enough 	<ul style="list-style-type: none"> The tension of upper thread is weak, or the tension of bottom thread is too strong. <p>To adjust the tension of upper thread or bottom thread.</p>
2	bottom thread is not tight enough 	<ul style="list-style-type: none"> The tension of bottom thread is weak, or the tension of upper thread is too strong. <p>To adjust the tension of upper thread or bottom thread.</p>
3	the thread loose under the fabric 	<ul style="list-style-type: none"> Whether the thread line is smooth or not <p>To polish the thread line</p>
4	skipped stitching during sewing 	<ul style="list-style-type: none"> Whether the needle is bended To change the needle Whether the needle installed well To install the needle correctly Whether threaded correctly To thread in right way Whether the presser foot pressure is too weak To adjust the pressure of presser foot Whether the needle is suitable for the fabric To change a better needle which is suitable for the fabric
5	skipped stitching when starting sewing 	<ul style="list-style-type: none"> Whether the upper thread is too short after trimming To adjust the thread tension or trimming time, make the upper thread longer Whether the speed of starting sewing is too fast To adjust the speed of starting sewing Whether the bottom thread is too short or moveble knife and fixed knife has burr after trimming To deburred the moveble knife and fixed knife, and adjust the stopper spring.

6	the fabric not flat enough 	<ul style="list-style-type: none"> Whether the presser foot pressure is too weak To adjust the pressure of presser foot High-low about the feed dog, whether not flatness To adjust the feed dog height and parallelism Whether the bottom thread is suitable To adjust the bottom thread tight
7	bottom thread is break 	<ul style="list-style-type: none"> Whether the needle is bended To change the needle Whether the needle installed well To install the needle correctly Whether threading correctly To threading in right way Bottom thread is too tight To adjust the tension of bottom thread. Whether the hook and needle have well matched To adjust the hook and needle match well
8	needle break 	<ul style="list-style-type: none"> Whether the needle installed well To install the needle correctly Whether the hook and needle have well matched To adjust the hook and needle match well Whether the knife position and moveing time is right To adjust the trimmer position in right way Whether the needle size is appropriate To choose the right needle

Attachment 3

The common problems and solutions of JK-SHIRLEY IIE (Powermax)

1.Q: How to lift presser foot when we are sewing?

Answer: The control system of this type of sewing machine has the function that operators just need to press the button "Presser Foot Lift" continuously to achieve circulatory Switch between four patterns "no lift presser foot- midway parking presser foot lift—trimming parking presser foot lift—Midway parking and trimming parking presser foot lift" flexibly. When users set "presser foot lift" during sewing and after cutting, icon of this function will be lighted in the panel, so the machine can achieve this function; besides, when the presser foot presses the cloth in sewing, half reverse tread trample also can realize the presser foot function.

2.Q: How to lift presser foot automatically after cutting?

Answer: The control system of this type of sewing machine has the function that only operators press button "Presser Foot Lift" continuously, which the sewing machine can achieve circulatory Switch between four patterns "no lift presser foot- midway parking presser foot lift—trimming parking presser foot lift—Midway parking and trimming parking presser foot lift" flexibly. When users set "trimming parking presser foot lift", icon of this function will be lighted in the panel, so this function can be achieved. And presser foot will be putted down after finishing cutting after the time of presser foot lifting set by the system and if you want to lift the presser foot again just to half counter trample to realize the presser foot function.

3.Q: Why workers feel heavy when trimming?

Answer: Too low rotating speed results in the heavy feeling when cutting, or Pedal counter trample too much when cutting.
A、 For low rotating speed, workers could solve this problem to adjust the technician parameters 05. First, to press button "P" meanwhile to press the button "presser foot lift" when "Pd-0000" appeared, pressing "P" again to enter the technician parameter "05-XXXX", then adjust "05" to "05-0270" (The actual setting value is 270), then press "P" to save and exit. Watching out the speed of trimming can't be set too large in case of resulting in a lot of noisy, and cutting will be unsteady. Please follow the rules of operation as the standard strictly. Generally speaking, adjustment values is 230-270.
B、 For reverse tread resulting in cutting route too big, to adjust rear number of "Technician parameter" and "the number behind 34" bigger and always set parameter from 50 to 180. if Value is too small, trimming will be felt heavy; too big, when presser foot life during sewing will be easy to mistakenly trigger cut line. According to the worker's habit to make adjust, operators usually set between 80 and 100 appropriately.

4.Q: Presser foot can't be controlled well when half reverse tread, and trim mistakenly.

This phenomenon is caused by unreasonable parameter settings of trimming position and Presser Foot Lift position. (the method of getting into The technician parameters as above) Increase the value of P35 appropriately. Increase the numerical difference of "35" and "34", bigger this difference is, more obvious time of "trimming" and "presser foot lift" action gap will be, on the contrary, the smaller the value is, the easier to mistakenly trimming when presser foot lift. This difference is generally not less than 50, the closer "35" number and parameter value "36" number parameter is, the easier to fulfill "half reverse tread presser foot lift" is, but the difference of the "36" should be no less than 100, otherwise the presser foot will automatically lift when stopped in the middle. This parameter can be adjusted depending on the habits of the operator.

5.Q: Why it can't trimming after adjusting reverse tread parameters?

This phenomenon is caused by the small setting of the pedal cut line position which the parameters (Technician parameters 34) is set too small. This parameter can be adjusted appropriately larger than before. Generally it often set between 80-100. When setting this parameter, the value can not be bigger than "technicians parameter" and "35" setting value.

6.Q: The function "presser foot lift during sewing" wasn't open, why the presser foot lift when stop sewing?

Answer: This phenomenon is caused by unreasonable parameter settings, and you will turn down technician parameters (press P + button presser foot lift to enter) value of P35 appropriately, always increase it between 200 and 300, at the same time, operators would better to make the value of P36 to about 500. If the difference between parameter "36" and "35" is less than 100, the presser foot will lift automatically when half-way stop.

7.Q: why the machine starts sewing before putting down presser foot?

Answer: this phenomenon exist because of the delay of presser foot putting down set too shortly. Please press and hold down the "P" after power source being opened, meanwhile then press the "circle" on the panel, entering "system member parameter model". Please turn the parameter values of "P44" up appropriately which usually between 200 and 300. Bigger the values is, longer the time of starting sewing delay is, which means that the interval between two action "Putting down presser foot" and "Starting sewing" is longer, vice versa. It can be adjusted appropriately according to operator's habits and different sewing art.

8.Q: how to adjust the problem of presser foot putted down too slowly?

Answer: this phenomenon caused by the delay of presser foot putting down set too shortly. Please press and hold down the "P" key after power source being opened, meanwhile then press the "circle" button on the panel, entering "system member parameter model". Please turn the parameter values of "P44" down appropriately which usually between 200 and 300.

9.Q: how to make presser foot raise half when machine is bone (sewing the material from thin to thick)?

Answer: this problem involve in operation habits, and in this condition it is

unnecessary to raise presser foot. when machine is bone only operator only need to pull with hand before sewing, and it is absolutely unnecessary to raise presser foot. on the contrary, stitch length is uneven and stitch trace is caused not beautiful if the presser foot is raised. on this point we have to pay attention to adjust operator to change this bad operation habits .

10.Q: How to raise presser foot a little instead of too much in order to make sew thin material in a high speed.

Answer: this problem is in our consideration, and the machine has been set three different presser foot height, respectively 5mm、 9mm and 12mm,and the The factory standard height is 9 mm. User can change the most height only if open machine rear cover plate, and change the fixed screw position on the presser rod.

11.Q:How to adjust the presser foot higher , but not too high?

Answer: what you need can't be meet due to the Electromagnet presser foot used in this machine. The pattern control you want can be realized, but the control cost will be expensive. our corporate mission is“Provide sewing machinery with the best cost-performance ratio to all”. As to the function of presser foot, the way of controlling Electromagnet can meet user's need basically, meanwhile our product possessed highly cost effective. Other special individual demand just need to adapt and there is no difference substantially.

12.Q:Why your machine's out-factory parameter does not set before, and they have to be adjusted after the machine sold to us?

Answer:Actually, Our standard parameters are the results of surveying large amounts of users. It customized to 80% users who can well-adapted this set of parameter. There may be a little difference between different regions, different users and the inefficiencies and habits. All these parameter is easy to adjust. With those adjustments, the sewing machines can well-adapted all kinds of individual practice habits.

13.Q:Compared with a large presser foot lifting electromagnet used in sewing machine before, how does the small one stand the force?

Answer: do not worry about this. Such design is out of scientific rule. We are just optimizing the structure. It takes about 12.6Kg when the large presser foot lifter works, but after optimizing the structure, it takes only 9.2Kg or much less in the same condition. You can use it with ease.

14.Q:how can workers get used to handle the auto presser foot lifter for they used knee to control it before?

Answer: It is just a matter of workers' habits. Workers may not well adjust the change at the beginning, but if they take an hour to adjust the change, which they will be accustomed to this structure. On the other hand, this change has another advantage of this machine. It not only equips excellent sewing functions as well as general sewing machines, but also releases worker's knees. Female can wear dress all the summer with this special design. They will not get illness related knees out of over-working. Workers can be attracted by this advantage.

15.Q: Will the electromagnet be short circuit or electricity leakage with inner-equipped presser foot lifter, where is so oily?

Answer: we adopt custom- made electromagnet, which is completely enclosed. It will not lead to oil leakage failure for the wire circuit is made by a pouring meddle. Customers can use it freely.

16.Q:How to set the function of multi-segment sewing ?

Answer: first step, press full line in the panel,(the last but one button in the second line). Second step, when the panel flashes yeg-4, we adjust the number to set the sewing-segment you need, and then press the circle button on the lower right corner. Finally, users want to set free sewing mode, they only need to press the dotted line.

17.How to set the function of automatic length-fixed sewing ?

Answer: the function of length-fixed sewing function and phase multi-segment sewing are combined. When users need to set length-fixed sewing, they can handle it like these steps. First step, press full line in the panel(the last but one button in the second line). Second step, when the panel flashes yeg-4, change 4 to 1. Third step, press the circle button on the lower right corner. We can set needle number. Fourth step, after setting needle number, press P to make sure. If users want to set free sewing mode, they only need to press the dotted line.

18.Q:How to close the small electronic tension device?

Answer: there is an electronic tension device sign on the panel, users can press the button to open or close the electronic tension device.

19.Q:How to restore to factory settings?

Answer: When the machine is on, please press the button “P”, and then press the button “presser foot lifter”,and Pd-0000 will be showed on the panel. After that, press the button “P” again into “62-2101”,and press the button “P”constantly for 4 seconds until one movable dotted line is displayed on the middle of the panel, which shows that factory settings is restored. Don't modify the parameter values behind “62” optionally, otherwise it will fail to restore to factory settings or restore to error program.

20.Q:How to increase the max speed of the machine?

Answer: When the power is on, please press the button “P”,and then press the button “presser foot lifter”. Pd-0000 will be displayed on the panel. After that, press the button “P” into the parameter “P01”,and turn up the value corresponded with the parameter “P01”. If your machine's service time is less than three months, don't turn up the max speed more than 3500r/min; if more than three months, please don't turn up the max speed more than 4200r/min.For the over-fast speed will short the machine wearing life, and increase the rate of wire breakage.

21.Q:How to adjust the position of power-off of the machine without the positioning magnetic steel as installed on the hand wheel?

Answer: The machine employs built-in positioner, and the position of power-off is electric controlled. Press the button “P” constantly and the button “circle” at the same time, and then

into the “parameter mode of system operator”P42. You can modify the upper stop position through adjusting the parameter value of P42, and modify the under stop position through adjusting the value “P43”. After finishing adjustment, press “P” to store it.

22.Q:How to adjust the speed?

Answer: Press the two triangle keys on the top left corner of the panel to adjust the stitching speed within the max rotating speed as the system presets.

23.Q:Why does the electromagnet always make a noisy sound when the machine lifts presser foot? Is there any problem?

Answer: The noise ,which is made by the micro vibration of the coil generated by the“the eddy current”when the electric current flow through the coil is normal. And the higher the power is, the louder the noise is. So please don't worry about it.

Overseas Market Planing Center

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This image shows a full page of primary-ruled paper. It features ten sets of horizontal lines, each consisting of a solid top line, a dashed middle line, and a solid bottom line, providing a guide for letter height and placement. The paper is otherwise blank, with no margins or additional markings.