

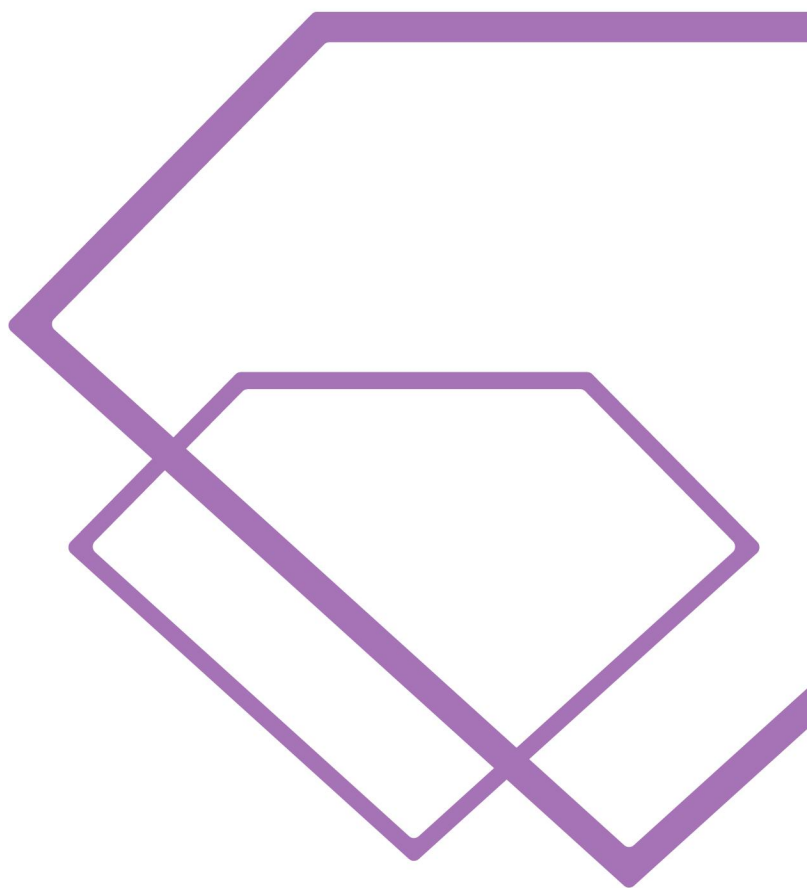
新一代智能缝纫机

THE NEW GENERATION OF INTELLIGENT SEWING MACHINE

HIKARI® 富山

使用说明书

INSTRUCTION MANUAL



HSAT-K9 系列
Series

自动上圆领机

AUTO NECK JOINING MACHINE

V1.00

Please read the safety instructions carefully first

HSAT-K9D

INSTRUCTION MANUAL BOOK



----- Safety attention -----

1. When using the machine, please strictly observe the safety measures as the following items
2. Please turn off the power or unplug the power plug when the following cases happen.
 - 2 - 1 When threading the stitch, double stitch, segregator and replacing bobbin.
 - 2 - 2 When changing replacing the stitch, the presser foot, the throat plate, bend stitch, the feed dog, the stitch guard, the folder and the cloth guider.
 - 2 - 3 Repairing work
 - 2 - 4 nobody in the working place or leaving the working place
3. Prohibit to touch the power on/off accessory and devices of the machine with oil hand .
4. The repair, alteration, adjustment about the machine should be carried out by professional staff.
5. General repair and maintenance of the machine should be carried out by trained staff.
6. The sewing machines should be regular cleaned while using.
7. The machine should be connected to ground wire for safe operation. It should be used against strong noise such an high-frequency welding machine.
8. Alteration and modification of the machine should be accorded to safety requirements and effective safety measures should be taken. In addition, we assume no responsibility for alteration and modification.

Please read the safety instructions carefully first

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Please read the safety instructions carefully first

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1. Introduction

- This instruction manual describes how to use our products safely.
- Read this instruction manual and learn very carefully how to operate, adjust and service this sewing machine before beginning any of the procedures.

2. Indications of dangers, warnings and cautions

To prevent accidents and ensure safety, warning indications which show the degree of danger are used on our products and in this manual.

Follow all warnings and instructions. Indication labels should be found easily. Attach new labels when they are stained or removed. Contact our sales department when new labels are needed.

Symbols, signs and/or signal words which attract users' attention

 DANGER	Indicates an immediate hazard to life or limb.
 WARNING	Indicates a potential hazard to life or limb.
 CAUTION	Indicates a possible mistake that could result in injury or damage.

Symbols and messages

	Be sure to follow the instructions when operate the machine.
	It's dangerous to get an electrical shock.
	It's dangerous to injure your hands or fingers.
	Indicates a danger of burn injury due to high temperature.
	Never do this.

Please read the safety instructions carefully first

	Shut off the power when checking ,adjusting and repairing the machine or when lightning may strike.
	Be sure to ground the machine and labor saving device securely.
	Denotes the normal rotating direction of the machine pulley.

3. Safety precautions

➤ Circumstances

The environment in which our industrial sewing machines are used may seriously affect their lives, functions, performance and/or safety.



For safety, do not use the machine under the circumstances below.

1. Do not use the machine near objects which make noise such as a high frequency welder, etc.
2. Do not use or store the machine in the air which has vapor from chemicals, or do not expose the device to chemicals.
3. Do not leave the machine outside, in high temperatures or the direct sun.
4. Do not use the machine in the places of high ambient temperature and humidity that seriously affects sewing machines.
5. Do not use the machine on the condition that the voltage fluctuation range is more than $\pm 10\%$ of the rated voltage.
6. Do not use the machine in the place where the supply voltage specified for the control motor cannot be properly obtained.

➤ Safety measures



(1) Safety precautions when you perform maintenance on the machine.

- Always turn off the power unplug the machine and then make sure that the machine does not run by pressing the treadle before performing any maintenance, such as checking, repairing, cleaning, etc. However, if you need to perform these procedures with the power on, to prevent accidents due to the unexpected start of the machine and users' misoperation, establish your own procedures for safety and follow them.
- Always turn off the power and unplug the machine before performing the procedures shown below.
 - Lubrication Threading
 - Cleaning
 - Replacing the needle
 - Checking/replacing the oil element
 - Replacing the oil
- Always turn off the power and unplug the machine before performing the procedures shown below.
 - Adjusting the stitch length
 - Adjusting the differential feed ratio
- Only well-trained people should perform routine daily maintenance and/or repair the machine.
- Do not modify the machine yourself.

※ Consult your local Hikari sales office or representative for modification.

4. Location of warning labels and safety devices

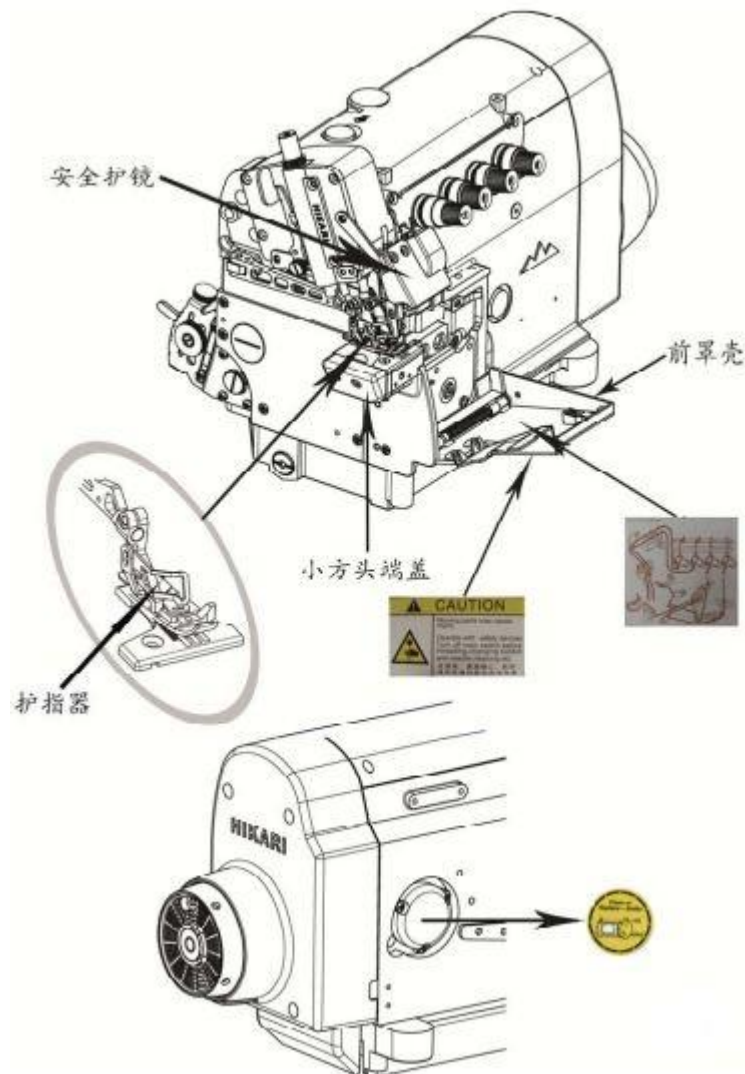


Fig.1

5. Protectors for safely



CAUTION

➤ Eye guard



Never leave the eye guard open

For the safety of eyes, do not operate the machine with the eye guard open. The eye guard will prevent any pieces of the broken needle from getting into your eyes if the needle should break during sewing.

➤ Finger guard



Never insert any of your fingers.

Please read the safety instructions carefully fist

To prevent the needle that moves up and down from contacting any of your body, the finger guard is installed close to the needle. However, there is clearance above the finger guard for easy threading. Be careful that the needle may penetrate any of your fingers if you insert it into this clearance.

➤ Presser foot

 Never insert any of your fingers.

There is a clearance of more than 5mm between the top surface of the needle plate and the presser foot. Be careful that none of your fingers are caught in this clearance. Never insert any of your fingers under the presser foot when raising the presser foot with the knee switch or automatically raising it with the treadle.

➤ Front cover

 Never insert any of your fingers.

The looper travels left to right while drawing an arc as seen from the front of the machine. To prevent the looper from contacting any part of your body, be sure to operate the machine with the front cover closed securely.

6. General issue of operation

➤ Lubrication



CAUTION

When lubrication the machine and/or replacing the oil, use our company recommended oil. Using other oils may damage machine.

1. Oil

Use the oil "HIGH SPEED SEWING MACHINE OIL" specified by our company (ISO Viscosity Grade 22).

2. To fill the machine with oil (Fig.2)

Remove cap 1, add the oil until the oil level (see oil gauge 2) reaches (H). After filling the tank with oil replace cap 1.

3. Required amount of oil (Fig.2)

(H) on oil gauge 2: Upper limit (L) on oil gauge 2: Lower limit The oil level should always lie between (H) and (L).

4. Manual lubrication (Fig.4)



CAUTION

Always turn off the power and unplug the machine when you apply oil by hand.

Apply 2 or 3 drops of oil to needle bar 3 and upper looper holder 4 by hand when the machine is used for the first time or has been left unused for some time.

5. Checking oil circulation (Fig.5)

Please read the safety instructions carefully first

Once the machine has been properly filled with oil, press the machine treadle to run the machine and check oil gauge window 5 to see if the oil is flowing.

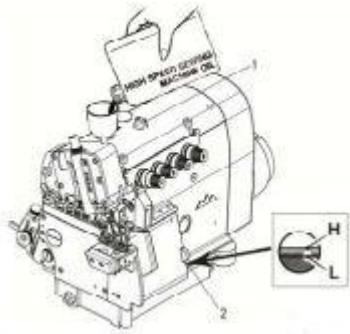


Fig.2

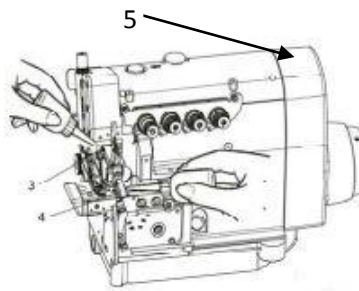


Fig.3

➤ Oil replacement



CAUTION

Well-qualified technicians should replace the oil. Replace the oil one month after the first use and thereafter every six months. If you keep using the old oil, it may cause the damage to the machine.

➤ To drain the oil

1. Drain the oil by removing screw 3 on the left side of the oil pan.
2. Tighten screw 3 after draining (Fig.6)

➤ Checking and replacing the filter

Always turn off the power, unplug the machine and then well-qualified technicians should check and replace the filter. If filter 7 is clogged up with dust and dirt, the machine will not be properly lubricated. Check filter 7 every six months, and clean or replace it if necessary.

To remove the filter (Fig.7)

Remove parts 4 to 7, and check the filter by referring to the illustration. If filter 7 is completely damaged, replace it with a new one.

➤ Cleaning the machine

Always turn off the power and unplug the machine when you clean the machine.

Clean the grooves of the needle plate and the area around the feed dogs (Fig.8)

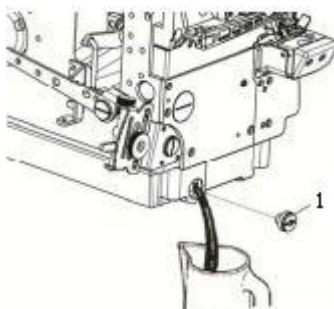


Fig.6



Fig.7

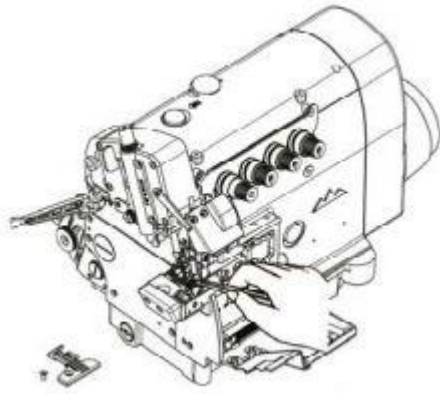


Fig.8

➤ Threading

Always turn off the power and unplug the machine when you thread the machine.

1. Open cloth plate 1, eye guard 2, front cover 3, and presser bar 4. Put each part back after threading the machine (Fig.9)

2. In case the machine is threaded previously (Fig.10)

A: Knot the preset thread and the thread being used together to thread the machine.

B: Needle thread Pull the knot toward the needle, trim the knot off and then thread the needle.

C: Looper thread Trim the knots off neatly after passing through the eye of the looper.

3. If the machine is not threaded Thread the machine properly by referring to the label attached to the machine.

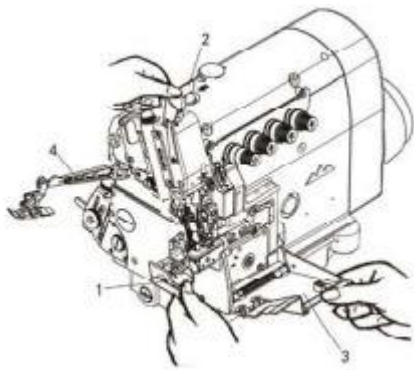


Fig.9

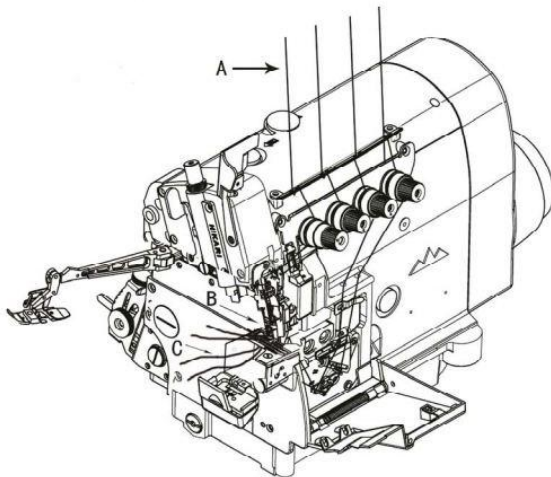


Fig.10

➤ **Adjusting presser foot pressure**

The presser foot pressure should be as light as possible, yet sufficient to feed the fabric correctly and provide the uniform stitch formation.。

Adjust presser foot pressure by turning adjustment screw 3. (图 16)

➤ **Adjusting the differential feed ratio**

1. Loosen nut, to increase the differential feed ratio, bring lever down. The finished fabric is shrunk. To decrease the differential feed ratio, bring lever up. The finished fabric is stretched.。

2. After this adjustment is made, tighten nut. (图 17)

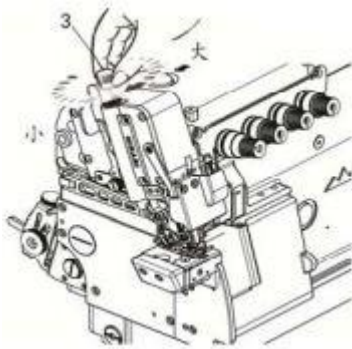


Fig.16

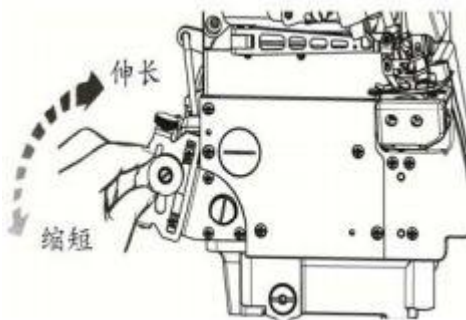


Fig.17

➤ **Adjusting stitch length**

Always turn off the power and unplug the machine when adjusting the stitch length.

1. With push button 1 depressed, turn handwheel 2 so that the push button 1 goes further into the depth (图 19)

2. With the push button in the place stated in 1. Turning handwheel 2 counterclockwise produces coarse stitches. Turning handwheel 2 clockwise produces fine stitches

NOTE:

Stitch length adjustment must only be made after the differential feed ratio has



CAUTION

Always turn off the power, disconnect the power cord and then only well-qualified technicians should replace and adjust the knife.

Pay attention to the knife edges not to injure your hands and fingers.

Please read the safety instructions carefully first

➤ Replacing the upper knife

1. Loosen screw 1. Bring lower knife holder 2 to its farthest position to the left. Tighten screw 1 temporarily.
2. Remove screw 3 and upper knife 4. Replace the upper knife with a new one. Tighten screw 3 temporarily. Turn the handwheel until the upper knife holder is at its lowest position. There should be 0.5-1.0mm overlap of the upper and lower knives. Adjustment is made by moving the upper knife up or down. Tighten screw 3.
3. Cross upper knife 4 and lower knife 6 with each other at the center (A) of their cutting edges (Fig.21). Loosen screw 1. Then check to make sure that the upper knife tightly touches the lower knife. Tighten screw 1.
4. To check proper cutting, place a thread between the upper and lower knives and turn the handwheel.

➤ Replacing the lower knife

1. Loosen screw 1. Bring lower knife holder 2 to its farthest position to the left. Tighten screw 1 temporarily.
2. Loosen screw, remove lower knife, replace it with a new knife. Adjust the lower knife so that the cutting edge is 0-0.3mm below the top surface of the needle plate. Tighten screw 5.
3. Follow procedures 3 and 4 in "Replacing the upper knife".

➤ Adjusting overedge width

1. Loosen screw 1. Bring lower knife holder 2 to the farthest position to the left. Tighten screw 1 temporarily.
2. Loosen screw 6, Adjusting overedge width by moving upper knife clamp 8 to the left or right.
3. Follow procedures 3 and 4 in "Replacing the upper knife".

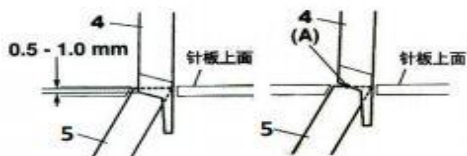


Fig.18

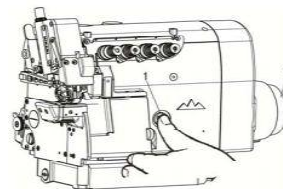


Fig.19

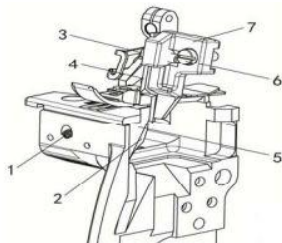


Fig.20



Fig.21

➤ Sharpening the knives

The upper knife is need to resharpen is for some time. Resharpen the lower knife for the proper cutting action.

1. Resharpen the lower knife ((Fig 21))

Please read the safety instructions carefully fist

If you sharpen the lower knife improperly, insufficient cutting will be obtain or the lower knife will become immediately dull. Be careful.

2. Upper knife

A special knife grinder is needed to sharpen the upper knife. It is recommended when sharpening the upper knife that you ask Hikari direct distributors or our agents. To increase efficiency, always prepare a spare upper knife.

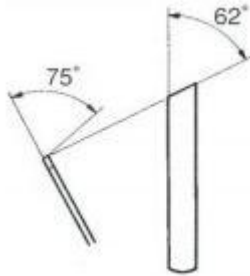


Fig.21

➤ Changing the fulcrum on the presser arm



CAUTION

Always turn off the power, unplug the machine and then well-qualified technicians should change the fulcrum on the presser arm.

1. Set the presser foot, and then bring down the feed dog to the bottom of its travel.
2. Move collar to the right while pressing presser foot shaft in the direction of A, tighten screw. (There should be a clearance of 1mm between presser foot lift lever and upper limit screw.)
3. Check to see if the slot(s) of the needle(s) on the presser foot is (are) aligned with that (those) on the needle plate. If not, loosen fixed presser foot bushings screw, and adjust presser arm by moving it left or right. After this adjustment, tighten screw. (Fig 22、 Fig 23)

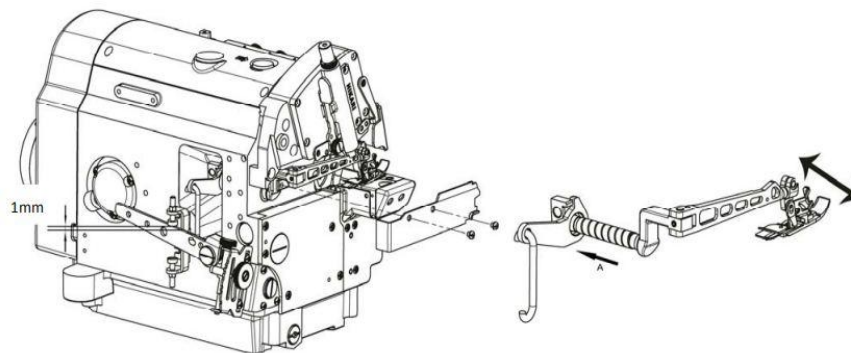


Fig22

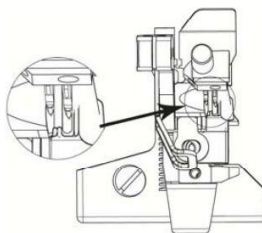


Fig 23

Please read the safety instructions carefully first

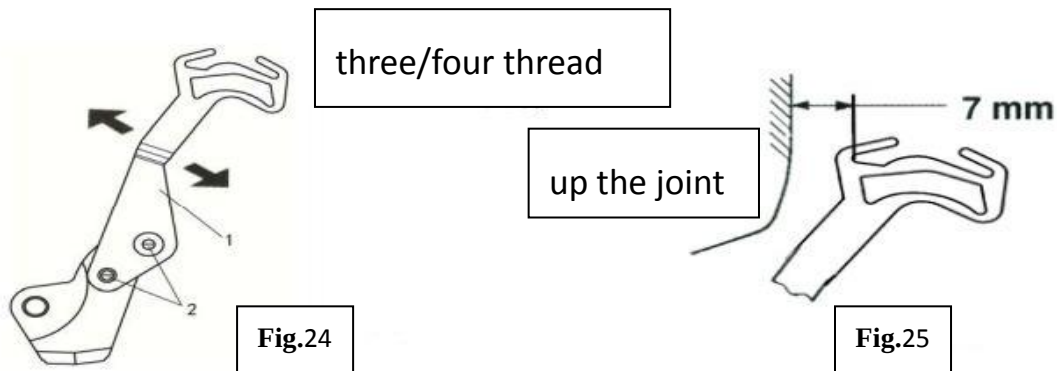
➤ Positioning and adjusting the needle thread take - up



CAUTION

Always turn off the power, unplug the machine and then well-qualified technicians should adjust the needle thread take-up.

When needle thread take-up 1 is at the bottom of its travel, adjust the distance from the front of the arm head to the needle thread take-up. To make this adjustment, loosen screws 2.

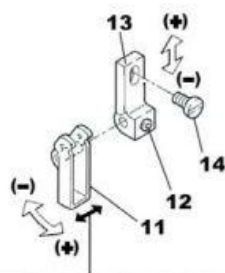


➤ Positioning the thread guides/Adjusting the amount thread to be supplied from the needle thread take - up

The location of each needle thread guide varies with types of machine. When the needle thread take-up is at the bottom and the top of its travel, position each needle thread guide according to the machine being used.

3, 4 thread series Adjusting the needle thread guides (Fig. 26)

Loosen screws 12 and 14. Adjust thread guides 11 and needle thread bracket 13 by moving them in the direction of the arrows. To increase the amount of thread to be supplied, move each thread guide, and needle thread bracket in the direction of (+). To decrease the amount of thread to be supplied, moving each thread guide, and needle thread bracket in the direction of (-). After this adjustment, tighten screws 12 to 14.



Adjust the left-right position of through thread piece No.11, made the line up piece of needle in the centre of two-ply

Fig. 26

Please read the safety instructions carefully first

7.Step-by-step instructions for using the unit

➤ Ventilation

1. Insert an 8 mm diameter air tube into the device shown below
2. Switch on the external air supply
3. After ventilating, check whether the air pressure pointer in the figure below reaches the factory-set minimum air pressure (0.5MPa)

Total air valve air pressure 0.5MPa



Schematic diagram of the total air valve of the round neck machine

➤ be connected to an electricity grid

1. This equipment uses 220VAC 50HZ AC power supply, and ensure that the socket is reliably grounded
2. When the power switch is switched on, the display and the head operating panel light up, and the motor locks

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8. Operating panel instructions

➤ Page description

There are five K9D user pages, the selected page will be rendered in purple, unselected is rendered in grey, the five pages are as follows

1) Main page



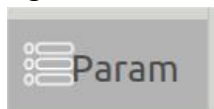
2) Control page



3) Parameter monitoring page



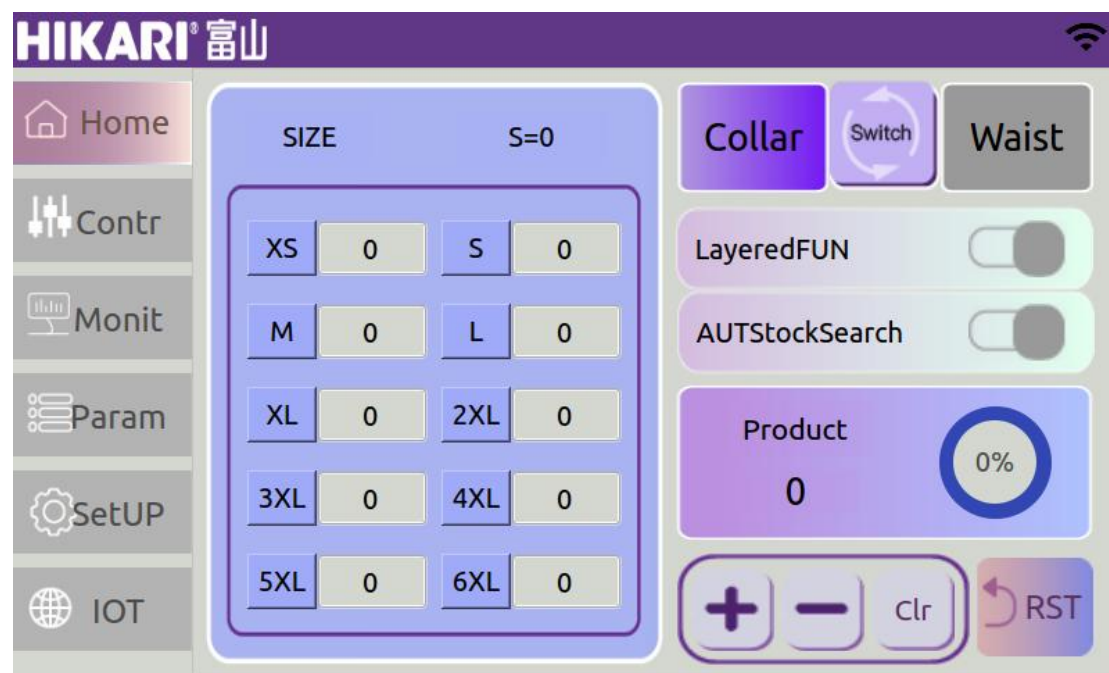
4) Parameter setting page



(5) System settings page



6) IOT Setting Page



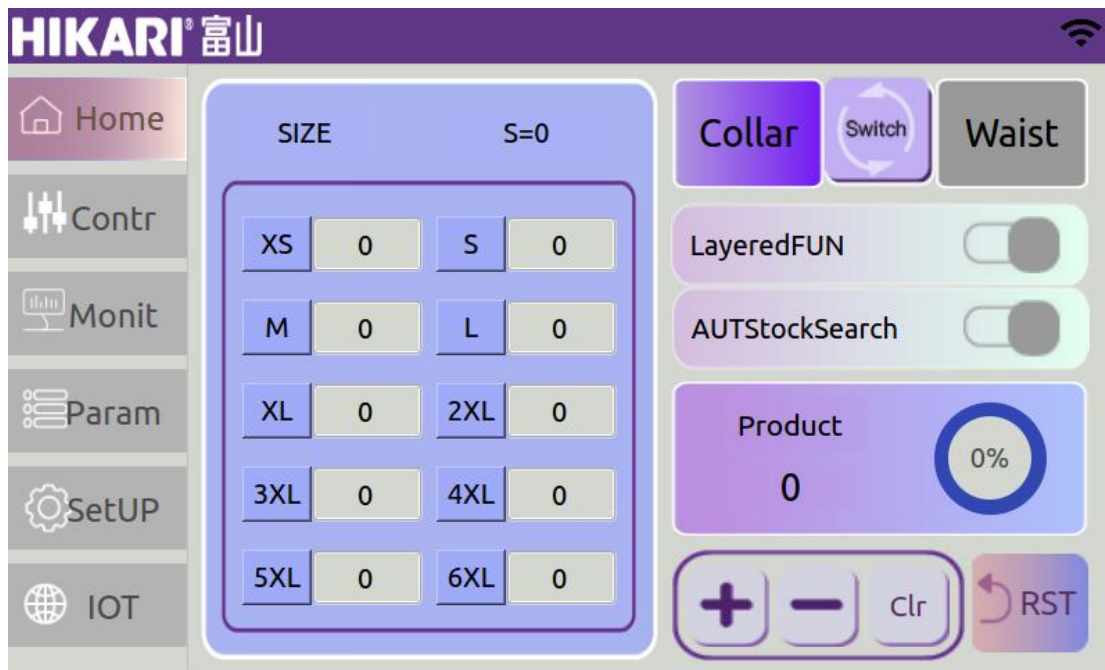
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➤ Description of the interface

1、 Main page :

In the lower part of the page is the page switch button, click it to go to the corresponding page.

In the main page there is a choice of modes for the machine, the K9D is equipped with two modes: upper round neck and upper trouser waist, in addition to the current size value, the number of pieces produced, the correction button for the number of pieces produced, the clearing of the zero, the layering function, the automatic stock search function, and the system reset function.



Model Description:



Crew neck pattern:

二. After the two-stage back-stepping equipment is activated, after the layering function and automatic stock-seeking function are turned on, it has the functions of automatic stock-seeking position, automatic material allocation and automatic layering.

Pantywaist mode.

You can control the motor to stretch by knee control, or you can activate the device by controlling the foot pedal two back pedal to make the pull wheel pull back.

2) The number of pieces produced is displayed:

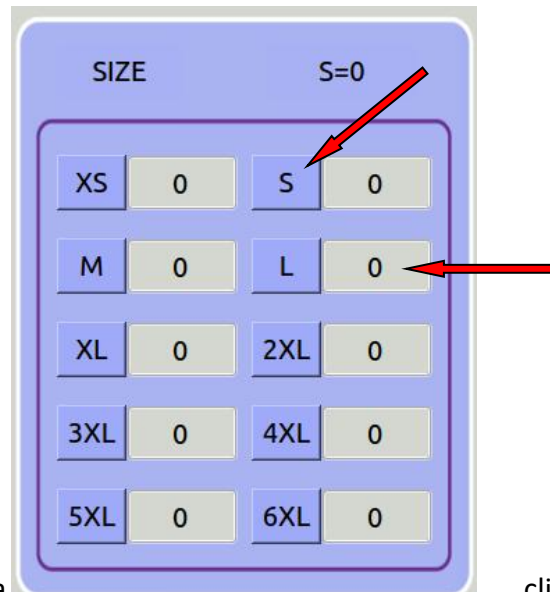
In the  area, click on  to zero out the number of

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pieces produced, click on  to set the total number of pieces expected to be

produced, and you can also make corrections with the  plus and minus buttons.

3) Size selection page:



Size selection via , click on the Size section to select a size, and click on the Parameters after Size section to modify the size parameter values.

Example: 700 means the pull back distance is 7cm.

The current size value and the specific size of the size value are also displayed at the top of the main page.

Function switch:



K9D Round Neck Mode Function Description:

(1) "Layering Function Switch": Controls whether the layering function is turned on or not. The layering mechanism will pop up after the stock position is found automatically, and the layering mechanism will not act after this function is turned off.

"Blue" is to enable layering, "Grey" is to disable layering.

The default is "On".

(2) "Automatic stock-seeking function switch": control whether to turn on the automatic stock-seeking function, enable this function, through the foot pedal two sections back pedal can be automatic stock-seeking position, the pull wheel motor will be stretched backward, the feeding motor is opened to feed the material, the

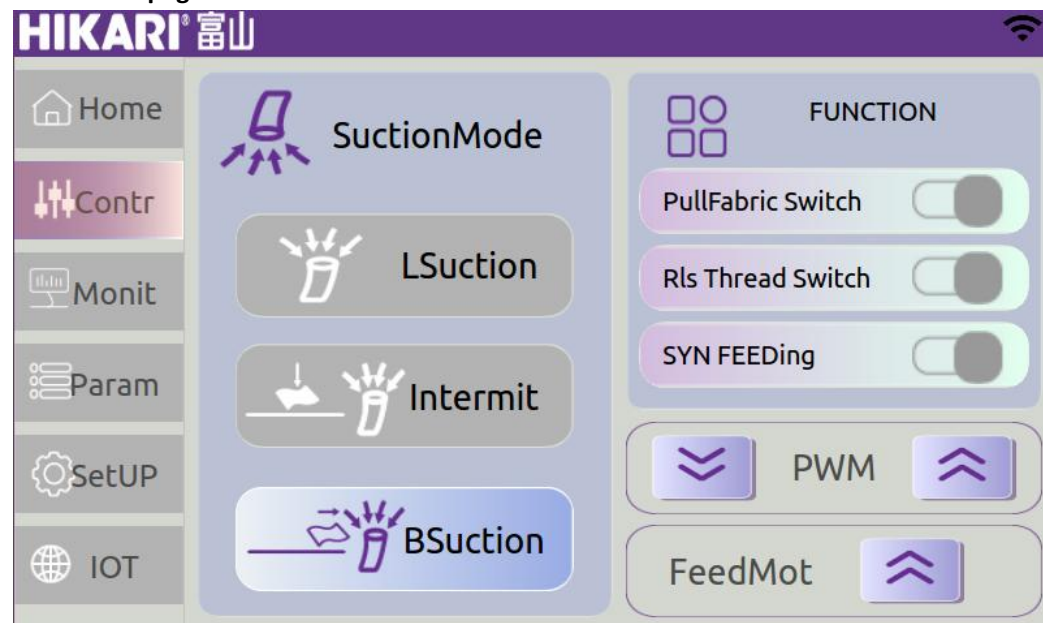
Please read the safety instructions carefully first

detection of the stock position, to find the stock position, and then continue to move forward for a certain distance (the parameters of the stock stopping position is decided), and then According to the state of the first two function switches, selective action and lower the presser foot.

"Blue" is to enable the auto stock search function, "grey" is to disable the auto stock search function.

The default is "On".

2、Control page



(1) Suction mode: there are three modes in total, such as long suction, intermittent and rear suction.

Long air suction: When checked, control the machine to keep the air suction all the time while sewing;

Intermittent: When checked, controls the machine to have intermittent suction while sewing;

Rear suction: When checked, the machine switches on suction mode after the sewing is completed.

(2) Function switches: a total of toggle function switch, end feed switch, synchronous feed switch

(3) Pull-wheel motors: The direction of motion of the motor can be set via and .

(4) Feed Motor: Set the motor via .

(1) "Toggle switch": Controls whether the toggle function is turned on or off. The toggle mechanism will be ejected when the strand is found automatically, and the toggle mechanism will not be activated when this function is turned off.

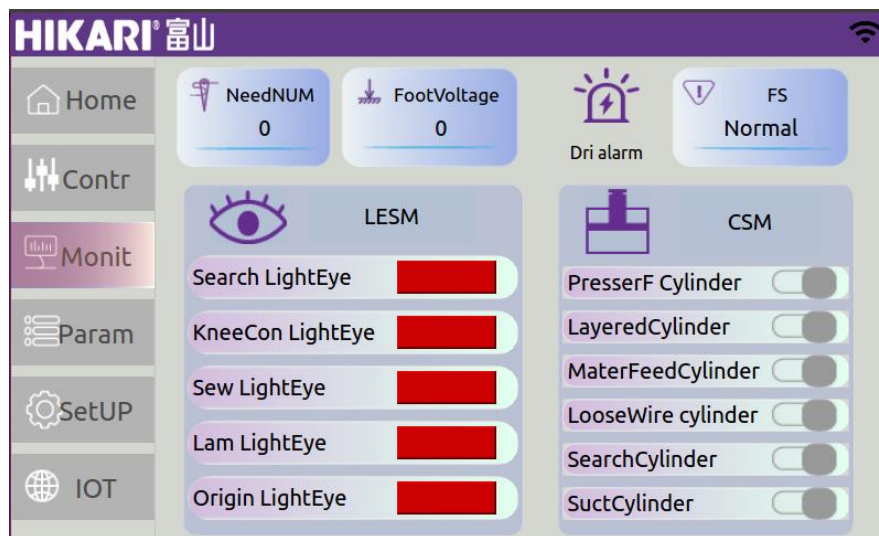
"On" enables the toggle function, "Off" disables the toggle function.

The default is "Off".

The parameters in the above figure are the default parameters, the actual parameters can be adjusted according to the changes in the field process.

Please read the safety instructions carefully first

3、Monitoring page



I Input status monitoring:

X1 Seek stock photo eye state:

Used to detect the strand level, the light on the sensor is always red and goes out when the strand level is detected.

X2 Knee-controlled photo eye state:

Press to turn red, release to turn green.

X3 Sewing photoeye state:

It is used to detect whether the fabric is on the machine, green when there is no obstruction, red when there is obstruction, and it can also be seen whether it is sewing or not according to the status of the leftmost LED on the Speedmaster electronic control.

X4 stratified photoeye state:

It is used to detect if it comes to the sewn part, when the collar bar is sewn one round, the sewn on part will trigger the sensor to avoid hooking the collar bar.

X5 original point photoeye state:

Used to detect if the rear pull wheel motor is at the home position.

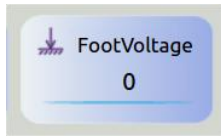
The red  status on the panel is related to the detection status of the sensor, the illustration shows a normal state, which will turn red or green when triggered.

Number of stitches:

Turning the handwheel by hand will increase the number of stitches in a round by 1 stitch.

Please read the safety instructions carefully fist

Foot pressure value:



The default value of the pedal voltage without pedalling is around 744, fluctuations within ± 5 are normal;

One section of back pedalling: the voltage value shows about 400.

Two-stage back pedal: the minimum value is 0, due to the difference of the speed controller, the minimum value of the back pedal is within 10 is normal, "parameter setting page" in the "starting voltage value" can be determined according to this value, the starting voltage value.

Forward stepping: max to 3846.

II Output test monitoring:

The K9D has a total of six solenoid valves.

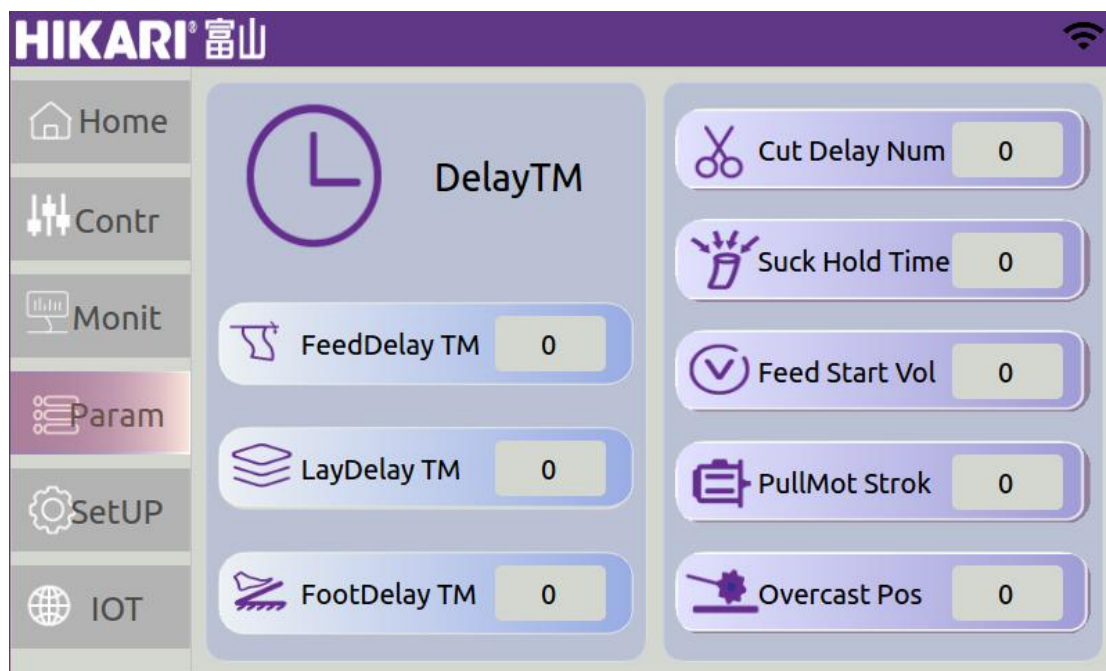
Separate controls:

1. Presser foot cylinder status (Y1)
2. Layered cylinder status (Y2)
3. Pulling cylinder status (Y3)
4. Loose wire cylinder status (Y4)
5. Stock-seeking cylinder status (Y5)
6. Suction cylinder status (Y6)

"Blue" for action

"Grey" is the restored normal position, i.e. the initial position after ventilation and power-up.

4、 Parameter page



Please read the safety instructions carefully first

Parameter Description:

(1) "Pulling delay time": when "pulling function switch ON", if the layering function is turned on, this time controls the delay time from the end of layering to pulling, and if the layering function is turned off, this time is the time from the detection of the stock position to the start of pulling action.

(2) "Layering delay time": The delay time between detecting a stock position and layering when the "Layering function switch is ON".

(3) "Presser foot delay time": the time between the end of dialling and the automatic lowering of the presser foot, at which point the presser foot will remain raised if the foot is not lowered.

(4) "Delayed Stitch": After sewing the "Delayed Stitch" stitch, the fabric leaves the sewing eye and the "Delayed Stitch" triggers the thread trimming function.

(5) Holding time of suction air": After triggering the "Cutting action", the holding time of the "Loosening cylinder" and the "Suction air cylinder" will be held for the "Loosening action" and "Suction air cylinder". Holding Time": After the trigger of "Cutting Action", the "Release Cylinder" and "Suction Cylinder" will hold the holding time of "Release Action" and "Suction Action".

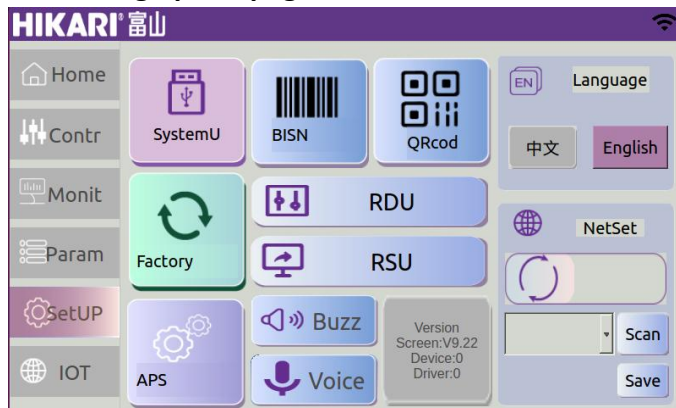
(6) "Loading start voltage": the voltage value of the two-stage back pedal to start the automatic function, such as the round neck mode to start the automatic stock search and other functions, and the trouser waist mode to start the back pulling wheel motor, the voltage value can be determined by the foot pedal voltage value in the test page.

(7) "Pull-wheel motor travel": in round neck mode, this parameter is used to control the distance that the rear pull-wheel backs up when automatically finding the stock position; in trouser waist mode, this parameter controls the distance that the rear pull-wheel moves. The maximum value of the size value and the size value of the back pulling wheel combined is 1250mm.

(8) "Stock Stop Position": The distance the fabric continues to travel after the stock level is detected by the stock level detection device. By adjusting the size of this value, the stock stop position can be controlled.

Please read the safety instructions carefully first

5、Setting up the page



The system settings screen contains the following information:

- 1、 "System Upgrade": you can upgrade the programme of the machine by this button;
- 2、 "Burn in serial number": the serial number of the burn-in model will be displayed in the IOT interface;
- 3、 "QR Code": Operator scanning the screen QR code can display the operator's information in the IOT interface;
- 4、 "Language switch": you can set the system language by entering this page, and you can switch between Chinese and English interfaces;
5. "Buzzer": you can choose to switch on the buzzer;
- 6、 "Voice": You can choose to open the voice;
- 7、 "Restore Factory Settings": Click this button to restore factory settings;
- 8、 "Remote electric control upgrade": the main control can be upgraded by remote way;
- 9、 "Remote Screen Upgrade": the screen can be upgraded in a remote way;
10. "Network Settings"; set the network mode of the connection;
- 11、 "Advanced Parameters": you can set the parameters of current, time and speed by entering this page.
- 12、 "System Version": It can display the version number of screen, software, category and driver.

6. Advanced parameters page

The Advanced Parameter Setting allows you to access the following sub-pages, which have three pages, namely, Current, Time, Speed, and Current.

Current: Parameters that can be set are run and count, stitch length, drawwheel motor type, feed locker current, drawwheel collar locker current, drawwheel reset locker current, feed running current, drawwheel collar running current, drawwheel trouser waist running current

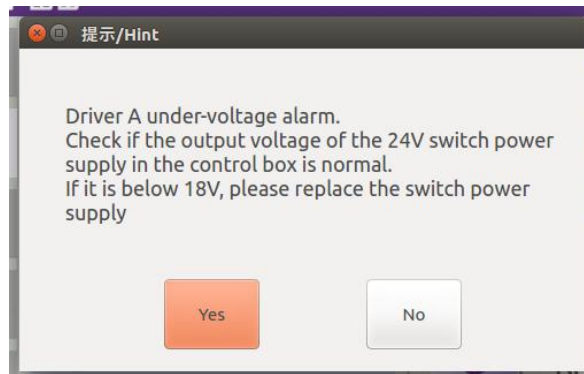
Time: Parameters that can be set are stock level detection delay time, feed acceleration time, feed deceleration time, pull wheel acceleration time, pull wheel deceleration time, and reservation.

Speed: Parameters that can be set are feed start speed, feed speed, pull-wheel start speed, pull-wheel run speed, pull-wheel reset speed.

Please read the safety instructions carefully first

9. Machine alarms and solutions

1、 When an abnormality occurs, the machine will stop working and prompt the alarm screen: (click OK to release the alarm).



2、 Alarm contents and solutions

serial numbe	Alarm name	icon	prescription
1	Pedal off alarm		Check if the foot pedal or connector is loose, if not, switch off and restart the machine;
2	Drive A out-of-tolerance alarm		1、 Check if the motor phase wire is disconnected or the plug is off, if not, please switch off and restart the machine; 2、 Check if the motor encoder wire is disconnected or the plug is off, if not, please switch off and restart the machine; 3、 Check for blocked motors or mechanical jams;
3	Drive A Storage Alarm		Restore factory settings whether to solve, if not, please replace the motherboard
4	Drive A overcurrent alarm		Check whether the motor phase wire is short-circuited, if not, please shut down and restart the machine
5	Drive A overvoltage alarm		for the time being
6	Drive A undervoltage alarm		Check whether the 24V switching power supply of the electric control box is normal, if it is lower than 18V, please replace the switching power supply.
7	Drive B overdrive alarm		1、 Check if the motor phase wire is disconnected or the plug is off, if not, please switch off and restart the machine; 2、 Check if the motor encoder wire is

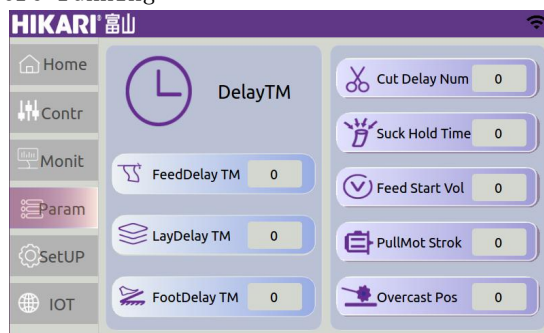
Please read the safety instructions carefully fist

			disconnected or the plug is off, if not, please switch off and restart the machine; 3、 Check for blocked motors or mechanical jams;
8	Drive B overcurrent alarm		Check whether the motor phase wire is short-circuited, if not, please shut down and restart the machine
9	Drive B undervoltage alarm		Check whether the output voltage of 24V switching power supply of electric control box is normal, if it is lower than 18V, please replace the switching power supply.
10	Unknown drive alarm		for the time being

10.Description of device adjustments

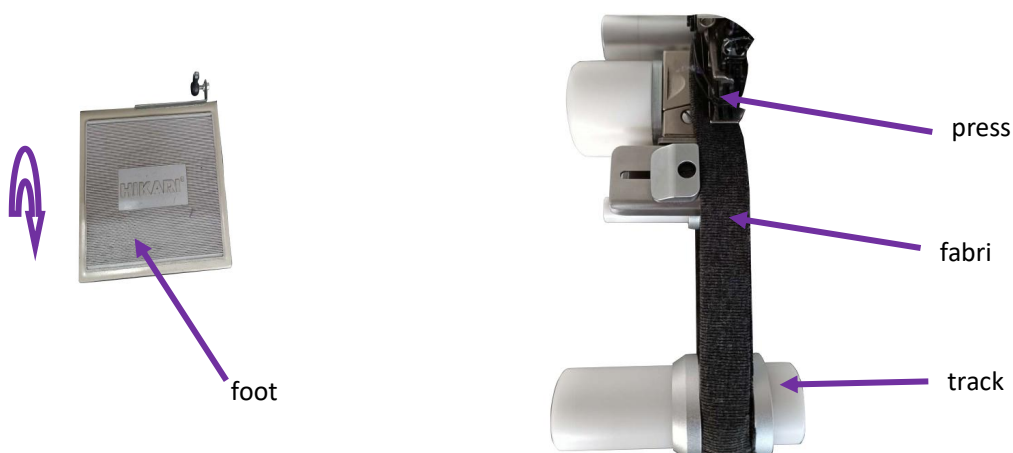
➤ Step-by-step instructions for starting automatic loading on

1. Turn on the power switch, such as the display page as shown below, need to be reset, before running



Tap the foot pedal backwards, presser foot raised, fabric placed on the roller in the middle of the stopper ring where the fabric is placed and shielded from the photoeye (refer to the picture below)

Make sure the placement is correct before starting the run



Please read the safety instructions carefully first

➤ Rear Tension Wheel Component Adjustment Procedure Description:

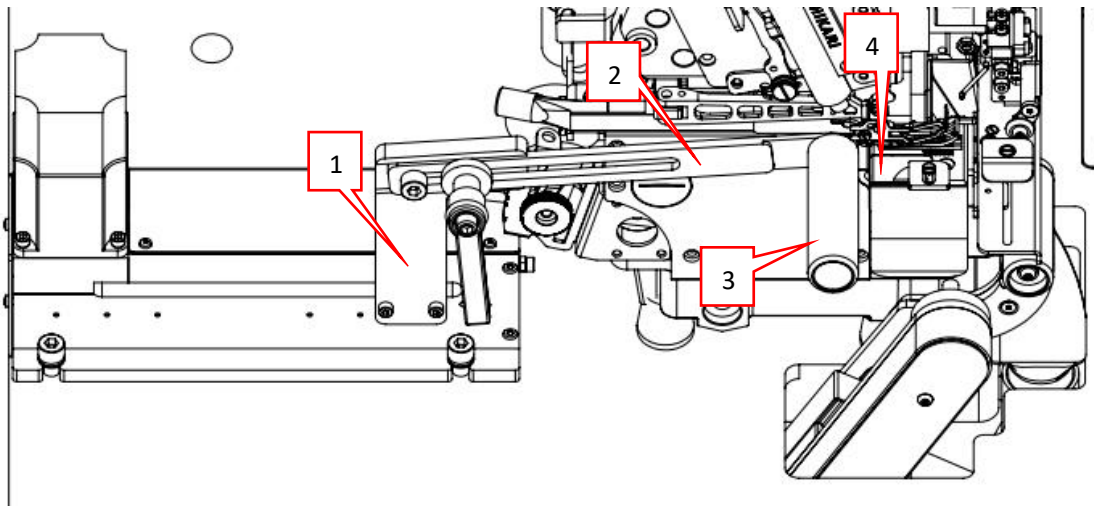
Click



to access the following schematic screen



Click on and to control the Laren motor for forward and reverse rotation.

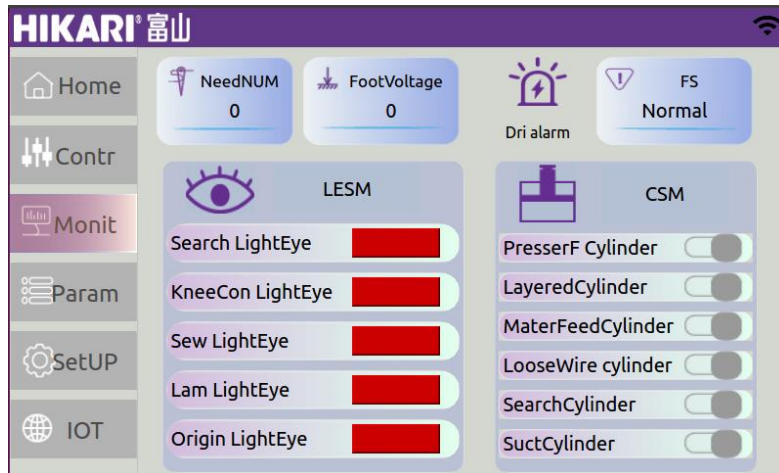


Control the rear pull wheel motor to move piece 1 to the rightmost side, piece 2 as shown in the figure after installation so that piece 3 and piece 4 side distance 4mm-6mm

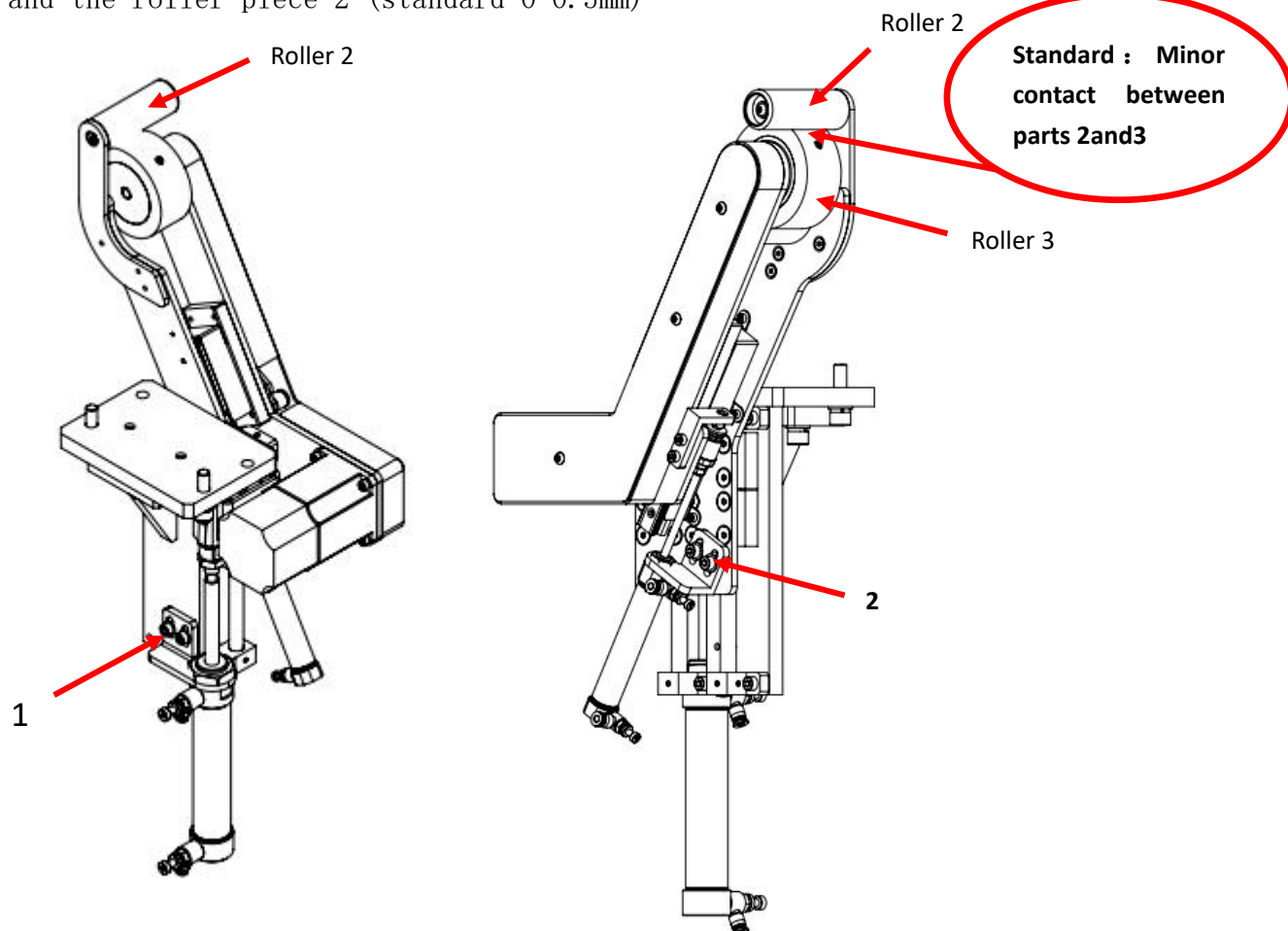
Please read the safety instructions carefully first

➤ Lower spreader wheel component adjustment

After clicking the button to the right of the pull-down cylinder to change "Off" to "On", click the button to the right of the stock-seeking cylinder to change "Off" to "On. "



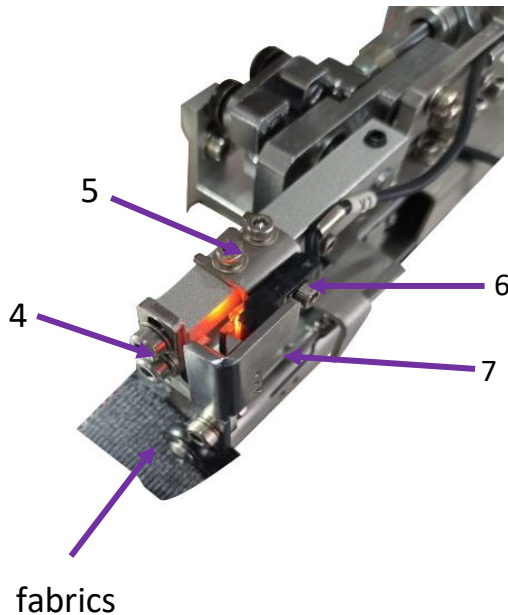
Loosen the screw piece 1 to adjust the height of the roller 2, loosen the screw piece 2 to adjust the spacing distance between the roller piece 3 and the roller piece 2 (standard 0-0.5mm)



Please read the safety instructions carefully first

➤ Steps for adjusting the sensitivity of stock level detection

1. Loosen the screw 4, adjust the height of the stock detection up and down, the standard distance is 1mm.
2. Loosen the screw 5, back and forth adjustment of the detection unit position response time, the standard distance: the distance between the sensor piece 6 and the sensor piece 7 1mm



➤ Sewing photoeye sensitivity adjustment method:

Possible scenarios requiring adjustment of sewing photoeye sensitivity:

1. The default factory settings can be applied to most fabrics. If you need to sew ultra-thin material, you may need to adjust the photoeye detection threshold, otherwise the fabric may not be detected.
2. If the fabric to be sewn has serious dust accumulation, in order to guarantee the stability of the sewing photo eye detection, the photo eye emission power needs to be adjusted appropriately to achieve the best detection effect.

This device has a factory-set photoeye detection threshold of 70 for sewing; the default value for emitted power is 55 per cent

In the absence of fabric, the "reception" value is around 80, which is greater than the "threshold".

If there is a fabric cover, the reception value is normally less than 20, if the fabric material is too thin, the reception value will be higher than 20, then as long as it is less than the "threshold" can be, in principle, need to be smaller than the threshold value of "10", this time, sewing photoeye detection is in a stable state.

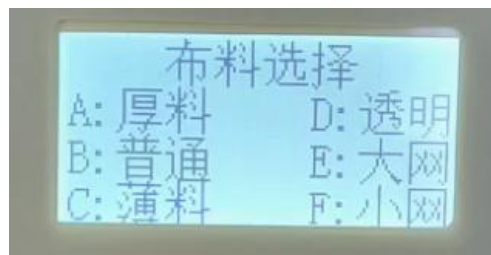
Please read the safety instructions carefully first

Adjust the sensitivity of the sewing photoeye on the operation panel of the following electronic control as follows:

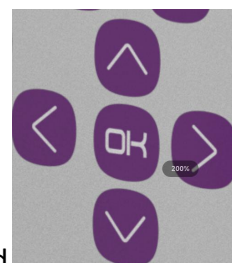
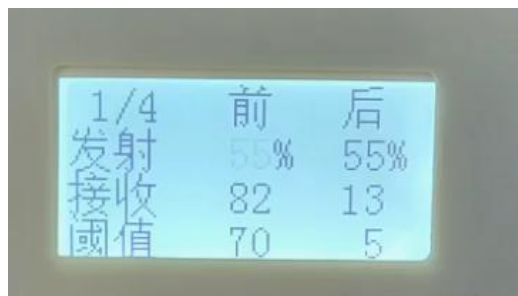


1. Click the  button twice

The first time you click to enter the fabric selection page, you can choose "B:Normal" by default.



Second click to enter the photoeye sensitivity adjustment page



The "left and right" buttons on the directional keyboard can be used to adjust the selection of the parameter to be modified. The value of the selected item can be adjusted using the "Up Down" button.



富山IoT



微信公众号



抖音官方号

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