

WR58LJ facility Integral employ directionsV1.1

1. Safety instruction

Please read the operation manual and related sewing machinery datasheet carefully before correct use.

1.1 (1) Power voltage and frequency: please refer to motor and control box nameplate.

(2) Interference from electromagnetic wave: please keep far away strong magnetic or high radiation environment in order to avoid obstructions and make to misoperation.

(3) Grounding: to avoid the noise obstructions or leakage of electricity accident(including sewing machine, motor, control box and positioner).

1.2 Please make sure power off at least 1min and then can open control box cover, because there are dangerous high voltage.

1.3 Please turn off the power while repairing or wearing needle in order to protect operator's safety.

1.4 ⚠ Used where potential dangers exist.

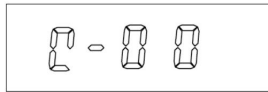
⚡ Used where high voltage and electric danger exist.

1.5 Product warranty period of one year on condition that this machine is operated correctly and no man-made damage.

2. Instructions for Operation Box

2.1 key functional specification

| No | Keys | Functions |
|----|------|------------------------|
| 1 | P | Function keys |
| 2 | S | Save button |
| 3 | ▲/▼ | Add key / Minus key |
| 4 | M | Preset sewing |
| 5 | ⬆ | needle up and down bit |



Left the first display: on behalf of the motor rotation direction

Left third display: the slow start function (0 mark as off; 1 mark as open)

Left fourth display: mark as up and down the needle position function (0 mark as up the needle; 1 mark as down the needle)

2.2 Monitor mode

Standby, press the "S" key + "▲" key into the monitoring status, press ▲ / ▼ key to change monitor serial number, monitor value can not be modified. Specific display content:

| show frame numbers | Item Name | unit | show frame numbers | Item Name | unit |
|--------------------|------------------------|-------|--------------------|---|-------|
| JJ | Plan number | piece | U6 | Motor initial Angle | limit |
| U1 | speed of motor control | rpm | U7 | Master control program version/ Head type | / |
| U2 | Motor Current | 0.01A | U8 | Head type/ Master control program version | / |
| U3 | Motor Voltage | V | U9 | Dsp no | / |
| U4 | Pedal voltage | 0.01V | vEr | Operation box version of the program | / |
| U5 | Mechanical Angle with | limit | TYPE | Software no | / |

Press the S key to enter to a specific value, press P to exit and return to the standby state.

3. Gearing and adjustment

1. Please press the P key for more than 3 seconds at the default interface.

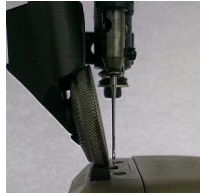
2. Press the P key for seconds into the parameter.

3. Select the No.75 parameter, run machine at 200rpm speed.

4. Stop sewing machine, after running for several turns.

5. Check the position of the needle, and then turn the hand wheel till the needle's point touches the board (as shown in the right figure, and the value of the No.75 will change at the same time) Step the pedal again and check that if the needle's point touches the board after the machine stopped, if not, adjust the hand wheel again.

6. Press the S key, and then end the operation.



4. Parameter list of lockstitch sewing machine

| No | Project | Content | Setting range | The default value | Level |
|----|--|---|----------------|-------------------|-------|
| 1 | Sewing speed | Set sewing speed | 200~3000rpm | 2000 | I |
| 2 | Soft-start function | 1: Soft start stitches | 1~9 | 1 | I |
| 4 | Fixed-length seam sewing speed | Set fixed-length seam sewing speed | 200~3000rpm | 1500 | I |
| 21 | soft start speed 1 | speed of the 1 st needle of soft start | 100~3000rpm | 400 | I |
| 22 | soft start speed 2 | speed of the 2 nd needle of soft start | 100~3000rpm | 1000 | I |
| 23 | soft start speed 3 | speed of the 3 rd needle of soft start | 100~3000rpm | 1500 | I |
| 27 | Power on and positioning | 0: unavailable 1: available | 0/1 | 0 | I |
| 28 | signal mode for turn/lift switch | Setting of signal mode of turn/lift switch of machine head 0: always open 1: always close 2: forbid a protection | 0/1/2 | 0 | I |
| 41 | Low speed | The lowest speed of pedal | 100~500rpm | 200 | I |
| 42 | Pedal curve selection | Pedal speed adjustment 0: normal 1: Slow acceleration 2: Quick acceleration | 0/1/2 | 0 | I |
| 62 | Pedal travel upon start | Pedal position upon start Travel relative to medium pedal | 10~50(0.1°) | 40 | II |
| 63 | Pedal travel upon acceleration | Pedal position upon start acceleration Travel relative to medium pedal | 10~100(0.1°) | 55 | II |
| 64 | Pedal travel at highest rotation speed | Pedal position at highest rotating speed Travel relative to medium pedal | 10~150(0.1°) | 110 | II |
| 67 | Pedal travel 1 upon thread trimming | Pedal position upon start trimming without presser foot Travel relative to medium pedal | -100~-10(0.1°) | -30 | II |
| 69 | Down needle positioning position | To adjust down needle position | 0~240° | 60 | I |
| 75 | Needle position adjustment | Needle position adjustment | 0~240° | 105 | I |
| 79 | return to factory-set parameter | 5: restore the current level factory parameters 8: restore the current level and sewing factory parameter set According to S button, select yes, then press the S key execution | 0~15 | 0 | I |
| 80 | highest speed of sewing | highest speed of sewing | 300~3000 | 3000 | II |
| 83 | Aggravating function | Needle wear through cloth when used 0: invalid; 1~15 strength regulation | 0~15 | 0 | II |
| 93 | The neutral position of the pedal | Trimming the neutral position of the pedal | -15~15(0.1) | 0 | II |

5. Error Code Table

| Codes | Contents | Checking and treatment | Codes | Contents | Checking and treatment |
|-------|---|--|-------|------------------------------------|--|
| E1 | Over-current of hardware | Check if it is well earthed Whether the damage to the device driver | E10 | Low voltage runtime | Check if it is well earthed. Current detection loop system is working properly |
| E2 | Whether the damage to the device driver | Check if it is well earthed Current detection loop system is working properly | E11 | HALLA signal loss | Check the motor signal cord |
| E3 | System voltage is too high | System into line voltage is too high | E12 | Motor overload | Check the sewing machine is not jammed. Actual operating excessively frequent acceleration and deceleration |
| E4 | System voltage is too low | System into line voltage is too low | E13 | EEPROM error | seek technical support |
| E5 | High voltage runtime | System into line voltage is too high | E14 | Current detection of non-normal | seek technical support |
| E6 | Needle stop signal failure | Check if the needle connector is loose | E15 | Pedal zero point exceeds the range | Pedal zero point exceeds the setting range |
| E7 | Motor HALL Signal failure | Check the motor connector for poor connection. | E16 | OZ circuit of non-normal | seek technical support |
| E8 | Locked rotor failure of motor | Check if the motor wire is well connected, and if it is overloaded | E17 | Motor reverse | Check motor phase sequence and signal lines |
| E9 | Over-speed failure | Check if the motor wire connection is correct | E18 | motor angle failure | Check motor phase sequence and signal lines Check whether the motor is stuck |

Note: If the above according to check the project cannot rule out fault, please seek technical support.