WR58L High series manual V1.2

1. Safety instruction

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

- 1.1 (1) Power voltage and frequence: 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(inculding 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 operater's safty,

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	ae.
2.System parameter table	

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63 Pedal travel upon acceleration Pedal position to Travel relative to Pedal position in Pedal position in Pedal position in Pedal position in Medium pedal medium pedal position in Medium pedal pedal position in Medium pedal pedal position in Medium pedal pe	upon start			
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64 Pedal travel at highest rotation speed Pedal position a medium pedal		10~100	50	II
i i i i i i i i i i i i i i i i i i i	at highest rotating speed Travel relative t	to 10~150	110	II
Padal position	upon pedal lift	10 100	+ 110	
Travel relative t	o medium pedal	-100~-10	-30	II
Pedal travel fr	rom presser foot lowering position t			
66 Pedal travel upon presser foot lowering neutral position Travel relative t	ı o medium pedal	5~50	10	II
Pedal position (upon start trimming without presser foo		T	
	o medium pedal	-100~-10	-30	II
Pedal position	upon start thread trimming with presse			
68 Pedal travel 2 upon tread trimming foot function Travel relative t	o medium pedal	-100~-10	-60	II
	needle position	0~240	60	I
, ,,	1: Enable	0/1	0	I
71 Reversal of needle lift angle Reversal of needle	dle lift angle	0.000		I
75 Needle position adjustment Needle position	n adjustment	0~90°	45	I
76 Stop needle position minor adjustment Stop needle position	sition minor adjustment	0~90° 0~240°	_	-
77 Needle bar maximum angle Needle bar max	,		45	I
		0~240° 90~110 270~360	45 214 100 290	I
	g reverse 1: Supplementary needle	0~240° 90~110	45 214 100	+
79 return to factory-set parameter set	g reverse 1: Supplementary needle urrent level factory parameters urrent level and sewing factory paramete	0~240° 90~110 270~360 0/1	45 214 100 290	I
According to S	urrent level factory parameters urrent level and sewing factory paramete	0~240° 90~110 270~360 0/1 ter 0~15	45 214 100 290	I
execution	urrent level factory parameters	0~240° 90~110 270~360 0/1 ter 0~15	45 214 100 290 0	I
80 highest speed of sewing highest speed of 82 Set period of use 0: Disable; 1-	urrent level factory parameters urrent level and sewing factory paramete button, select yes, then press the S ke	0~240° 90~110 270~360 0/1 eer 0~15	45 214 100 290 0	I
	urrent level factory parameters urrent level and sewing factory paramete button, select yes, then press the S ke of sewing	0~240° 90~110 270~360 0/1 eer 0~15 200~3500spm	45 214 100 290 0	I
Aggravating function/ Needle wear the	urrent level factory parameters urrent level and sewing factory paramete button, select yes, then press the S ke	0~240° 90~110 270~360 0/1 ter 0~15 200~3500spm 0~1000	45 214 100 290 0	I I II II
09	urrent level factory parameters urrent level and sewing factory paramete button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit)	0~240° 90~110 270~360 0/1 eer 0~15 200~3500spm	45 214 100 290 0	I
	urrent level factory parameters urrent level and sewing factory paramete button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit) rough cloth when used 5 strength regulation	0~240° 90~110 270~360 0/1 ter 0~15 200~3500spm 0~1000	45 214 100 290 0	I I II II
Machine needle emphasis function 0: invalid; 1 ~ 1 84 Reduce noise 0~15 Reduce 85 Cutting magnet pull angle Cutting magnet	urrent level factory parameters urrent level and sewing factory paramete button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit) rough cloth when used 5 strength regulation noise t pull angle	0~240° 90~110 270~360 0/1 ter 0~15 ey 200~3500spm 0~1000 0~15 0~15 150~200	45 214 100 290 0 0 2500 0 0 0	I I II II II II
83 Machine needle emphasis function 0: invalid; 1 ~ 1 84 Reduce noise 0~15 Reduce 85 Cutting magnet pull angle Cutting magnet 86 Power angle of shear line To set power angle	urrent level factory parameters urrent level and sewing factory paramete button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit) rough cloth when used 5 strength regulation noise t pull angle ngle of shear line	0~240° 90~110 270~360 0/1 ter 0~15 ey 200~3500spm 0~1000 0~15 0~15 150~200 200~300	45 214 100 290 0 0 2500 0 0 0 0 60 260	I I II
83 Machine needle emphasis function 0: invalid; 1 ~ 1 84 Reduce noise 0 ~ 15 Reduce 85 Cutting magnet pull angle Cutting magnet 86 Power angle of shear line To set power angle 87 Cutting magnet release angle Cutting magnet	urrent level factory parameters urrent level and sewing factory parameter button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit) rough cloth when used 5 strength regulation noise t pull angle ngle of shear line t release angle	0~240° 90~110 270~360 0/1 ter 0~15 ey 200~3500spm 0~1000 0~15 150~200 200~300 300~360	45 214 100 290 0 0 2500 0 0 0 0 60 260 340	I I II
83 Machine needle emphasis function 0: invalid; 1 ~ 1 84 Reduce noise 0 ~ 15 Reduce 85 Cutting magnet pull angle Cutting magnet 86 Power angle of shear line To set power angle 87 Cutting magnet release angle Cutting magnet 88 Loose magnet pull angle Loose magnet pull angle	urrent level factory parameters urrent level and sewing factory parameter button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit) rough cloth when used 5 strength regulation noise t pull angle ngle of shear line t release angle bull angle	0~240° 90~110 270~360 0/1 ter 0~15 ey 200~3500spm 0~1000 0~15 150~200 200~300 300~360 150~250	45 214 100 290 0 0 2500 0 0 0 60 260 340 300	I I I I I I I I I I I I I I I I I I I
Machine needle emphasis function 0: invalid; 1 ~ 1	urrent level factory parameters urrent level and sewing factory parameter button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit) rough cloth when used 5 strength regulation noise t pull angle ngle of shear line t release angle bull angle on angle	0~240° 90~110 270~360 0/1 ter 0~15 ey 200~3500spm 0~1000 0~15 150~200 200~300 300~360 150~250 270~360	45 214 100 290 0 0 2500 0 0 0 0 0 60 260 340 300 320	I I I I I I I I I I I I I I I I I I I
Machine needle emphasis function 0: invalid; 1 ~ 1	urrent level factory parameters urrent level and sewing factory parameter button, select yes, then press the S ke of sewing ~ 1000(Take hours as a unit) rough cloth when used 5 strength regulation noise t pull angle ngle of shear line t release angle bull angle on angle	0~240° 90~110 270~360 0/1 ter 0~15 ey 200~3500spm 0~1000 0~15 150~200 200~300 300~360 150~250	45 214 100 290 0 0 2500 0 0 0 60 260 340 300	I I I I I I I I I I I I I I I I I I I

3. System Info

Operation panel default mode, press the button at the same time in P made sewing needle trigger select key, enter the system monitoring state through the +-key choose need to look at the project, according to the S button

ter/	exit the select	tea projects suci	n as the need to	ex	it monitoring in	terrace, according	to P keys can be
	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	1
	U3	Motor Voltage	V		U9	Dsp no	1
	U4	Pedal voltage	0.01V		vEr	Operation box version of the program	/
	U5	Mechanical Angle with	limit		TYPE	Software no	1

4.Operation box use

Sating reinforcing -sewing W Execute starting reinforcing-sewing 2 times, to and fro.				
Execute sharing temotrumy-sewing 2 times, to and fro. Execute anding reinforcing Fernforcing Fernforc	Function	Button	Described	
Execute ending reinforcing-sewing 2 times, to and fro. 1. Press resealls ahead for automatic sewing, to and fro, which is set at D and can reach 1 Stines (F). 2. Continuous reinforcing-sewing is in trigger mode by default, treadle doesn' the reach 1 Stines (F). 3. Previous ending reinforcing-sewing is in trigger mode by default, treadle doesn' the read to be kept being pressed, and corresponding trigger light of preset sewing is solid it. 3. Previous ending reinforcing-sewing setting is invalid if this function is valid in the sewing at Cinc H sections in the treadle doesn' 1 need to be kept being reserved and the system will automatically conduct sewing at Cinc H sections in the treadle doesn' 1 need to be kept being trigger mode by default. 1. The metal trigger mode by default continuous reinforcing-sewing mode means that it is set the needle position shortcut keys. Key is effective for needle, The cancel key function is set to stop pin. 1. The middle presser foot set shortcut keys: set or cancel the presser foot function. 2. Set the needle position shortcut keys: set or cancel the presser foot function. 3. Soft start to set shortcut keys: set or cancel the presser foot function. 3. Soft start to set shortcut keys: set or cancel the presser foot function. 4. Limplementation of this key, crualising swirch display 3 pin number to set the display value upper end.A. B. C. Depriod of pin number, light corresponding level; 3. Choice seving setting interface, the user can press the button P to enter the Parameter in the parameter in the parameter list will display. 4. Lintering different parameter level 3. On the sewing setting interface, the user can press the button P to enter the Parameter in the parameter in the parameters in the para	reinforcing -sewing	141	Execute starting reinforcing-sewing 2 times, to and fro.	
continuous reinforcing-sewing is in trigger mode by default, treadle doesn't need to be kept being pressed, and corresponding trigger light of preset sewing is a previous ending reinforcing-sewing setting is invalid; if this function is valid. J. Frevious ending reinforcing-sewing setting is invalid; if this function is valid. I. For preset sewing. Trigger treadle and the system will automatically conduct severally of the continuous reinforcing-sewing mode means that it is trigger mode by default. The middle pressed 2.Solid light for continuous reinforcing-sewing mode means that it is trigger mode by default. Set or cancel thread-cutting function. Set the needle position shortcut keys, Key is effective for needle, The cancel key function is set to stop pin. The middle presser foot to set shortcut keys: set or cancel the pedal soft start function. Shear line presser foot to set shortcut keys: set or cancel the pedal soft start function. Soft start to set shortcut keys: set or cancel the pedal soft start function. I. Implementation of this key, circulating switch display 3 pin number to set the display value upper end. S. C. Deriod of pin number. Light corresponding level; 2. Corresponding to A period of pin number. Light corresponding level; 2. Corresponding to A period of pin number. Light corresponding level; 2. Corresponding to A period of pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C pin number, can set range of — 15 needle, B paragraph C p	reinforcing	M	Execute ending reinforcing-sewing 2 times, to and fro.	
thread-cutting Needle position Needle position The middle presser foot Presser foot to set shortcut keys: set or cancel the presser foot function. The middle pressure foot Shart line and presser foot set shortcut keys: set or cancel the presser foot function. Soft start Soft start to set shortcut keys: set or cancel the pedal soft start function. The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. Soft start Soft start to set shortcut keys: set or cancel the pedal soft start function. Timplementation of this key, circulating switch display 3 pin number to set the display value upper end.A. B. C. Depriod of pin number, light corresponding level; lower extreme.G. Heroid of pin number, light corresponding level; lower extreme.G. Heroid of pin number, light corresponding level; lower extreme.G. Heroid of pin number, light corresponding level; lower extreme.G. Heroid of pin number, can set range of 15 needle, among them, the liquid crystal display A B C D E F on each for 10 11 12 13 14 15 sitches. 1.Entering different parameter level On the sewing setting interface, the user can press the button P to enter the Parameter Interface, after entering the right maintenance password, then the user can press the button P to enter the Parameter interface, and the level and Level II parameters in the parameter list will display. Parameter setting Principle of the sewing setting interface, the user can keep pressing the button F or a few seconds to enter the Parameter setting on the sewing setting interface, the user can keep pressing the button F or a few seconds to enter the Parameter setting on the sewing setting interface, the user can keep pressing the button F or a few seconds to enter the Parameter setting on the sewing setting interface, the user can keep pressing the button F or a few seconds to enter the Parameter setting on the sewing setting interface, and press the button on be parameter list will display. Parameter setting On the sewing set be butt	reinforcing		reach 15times.(F) 2. Continuous reinforcing-sewing is in trigger mode by default, treadle doesn' t need to be kept being pressed, and corresponding trigger light of preset sewing is solid lit. 3. Previous ending reinforcing-sewing setting is invalid if this function is valid.	
Needle position Needle position The middle presser foot to set shortcut keys: set or cancel the presser foot function. The middle presser foot The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. Soft start Soft start to set shortcut keys: set or cancel trimmer and presser foot function. Soft start to set shortcut keys: set or cancel trimmer and presser foot function. Soft start to set shortcut keys: set or cancel trimmer and presser foot function. Limplementation of this key, circulating switch display 3 pin number to set the display value upper end.4. B. C. Deriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower extreme.6. HPeriod of pin number. Light corresponding level; lower love level. HPeriod of pin number. Light level. HPeriod of pin number. Light level.6. HPeriod of pin number. Light level.6. HPeriod of pin number. Light level.6. H		0	1.For preset sewing. Trigger treadle and the system will automatically conduct sewing at E, F, G, H sections; the treadle doesn't need to be kept being pressed.2.Solid light for continuous reinforcing-sewing mode means that it is trigger mode by default.	
The middle pressure presser foot to set shortcut keys: set or cancel the presser foot function. Shear line pressure line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. Soft start Soft start to set shortcut keys: set or cancel the pedal soft start function. Implementation of this key, circulating switch display 3 pin number to set the display value upper end.A. B. C. DPeriod of pin number.Light corresponding level; lower extremes. Heriod of pin number.Light corresponding level; lower extremes to A Depriod of pin number.Light corresponding level; lower extremes. Heriod of pin number, can set range of -15 needle. B paragraph C pin number, can set range of -15 needle, among them, the liquid crystal display A B C D E F on each for 10 11 12 13 14 15 stitches. 1.Entering different parameter level On the sewing setting interface, the user can beep pressing the button for a few seconds to enter the Password En Interface, and the Level I and Level I parameters in the parameter list will display. On the sewing setting interface, the user can keep pressing the button P for a few seconds to enter the Password En Interface, and press the button combination of "burst button + soft start button" to enter the Password En Interface, and press the button combination of "burst button + soft start button" to enter the Password En Interface. Here en indicators (respectively are Indicators 15, 23 and 53 from the roget interface (mistakes have stays 51 state), and at the same time 52 light, prompting the input new password and click confirms 35 key input again the light is the new password, according to 5 key after two input if consistent, the nest success, return to para interfacelf the new password again. If the user presses the button P, the user will be brought back to the interface the tree indicato			Set or cancel thread-cutting function.	
Presser foot to set shortcut keys: set or cancel the presser foot function. Soft start The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. Soft start Soft start to set shortcut keys: set or cancel the pedal soft start function. 1.Implementation of this key, circulating switch display 3 pin number to set the display value upper end.A. B. C. Deriod of pin number, Light corresponding level; lower extreme: G. HPeriod of pin number, Light corresponding level; lower extreme: G. HPeriod of pin number, Light corresponding level; lower extreme: G. HPeriod of pin number, can set range 0. ~ 15 needle, B paragraph C pin number, can set range 1. Intering different parameter level On the sewing setting interface, the user can press the button P to enter the Parameter Interface, after entering the right maintenance password, then the user can press the button P to enter the Password Enterface, and press the level In parameters in the parameter list will display. 2. Password setting Parameter Setting Parameter Setting Parameter Setting The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. The shear line and presser foot set shortcut keys: set or cancel the level; place for fine password in the password and cline in the password in the password and cline in the password in the password in the password in the password in the pa		\$₽	Set the needle position shortcut keys, Key is effective for needle, The cancel key function is set to stop pin。.	PS
The shear line and presser foot set shortcut keys: set or cancel trimmer and presser foot function. Soft start	presser	<u><u>+</u></u>	Presser foot to set shortcut keys: set or cancel the presser foot function.	0
Pinnumber set/check choice 1. Implementation of this key, circulating switch display 3 pin number to set the display value upper end:A, B, C, DPeriod of pin number, Light corresponding level; Middleend:E, Preriod of pin number, Light corresponding level; ower extreme.G, HPeriod of pin number, Light corresponding level; 2. Corresponding to A D period of pin number, can set range 0 ~ 15 needle, B paragraph C pin number, can set range 1 to level; 2. Corresponding to A D period of pin number, can set range 0 ~ 15 needle, B paragraph C pin number, can set range 1 to level; 2. Corresponding to A D period of pin number, can set range 0 ~ 15 needle, B paragraph C pin number, can set range 1 to level; 2. Corresponding to A D period of pin number, can set range 1 to level; 2. Corresponding to A D period of pin number, can set range 2 ~ 15 needle, B paragraph C pin number, can set range 2 corresponding to A D period of pin number, can set range 3 to level; 2. Corresponding to the sewing setting interface, the user can press the button for a few seconds to enter the Password En Interface. After entering the right maintenance password, then the user can press the button P to enter the Password En Interface, now the Level 1 and Level 1 parameters in the parameter list will display. 2. Password setting interface, the user can keep pressing the button P for a few seconds to enter the Password Rendering 1 to the password and six from left to right/before three lamp, among one is on) corresponding to the button S indicates the current status. S1 lights up, old password lamp and password again and the password and click confirm S1 S key input again therface. In the three indicators (respectively are Indicator S1, S2 and S3 from left to right/before three lamp, among one is on) corresponding to the button S indicates the current status. S1 lights up, old password again. If the user password and click confirm S1 S key input again interface. If the new password setting interface the password setting interface the password setting	pressure	<u>₩±1</u>	The shear line and presser foot set shortcut keys: set or cancel trimmer and presser	foot function.
Middleend:E. FPeriod of pin number, Light corresponding level; 2.Corresponding to A D period of pin number, can set range 0 ~ 15 needle, B paragraph C pin number, can set range 1 needle, among them, the liquid crystal display A B C D E F on each for 10 11 12 13 14 15 stitches. 1.Entering different parameter level On the sewing setting interface, the user can press the button P to enter the Parameter Interface, then the L parameters in the parameter list will display. On the sewing setting interface, the user can keep pressing the button for a few seconds to enter the Password Entherface. After entering the right maintenance password, then the user can press the button P to enter the Password Entherface. Gow the Level I and Level II parameters in the parameter list will display. 2. Password setting On the sewing setting interface, the user can keep pressing the button P for a few seconds to enter the Password Entherface, now the Level I and Level II parameters in the parameter list will display. 2. Password setting On the sewing setting interface, the user can keep pressing the button P for a few seconds to enter the Password Resinterface. The three indicators (respectively are Indicator 51, 52 and 53 from left to right/before three lamp, among one is on) corresponding to the button S indicates the current status. S1 lights up, old password input, ending the combination trigger key + tangent key, if the correct password into the password reset interface (mistakes have stays 1 state), and at the same time 52 light, prompting the input new password and click confirm 33 S key input again the light is the new password, according to S key after two input if consistent, then set success, return to parameters and no modification will be saved. You can choose from the numbers of 0 to 9 or the letters of A to F for single character of the password. Please do keep the new password in mind. Set or cancel the teaching function. The number of needles sewing set, Set up a total of 15 segment needle number P1~PF. Speed	Soft start	\bigcirc	, '	
On the sewing setting interface, the user can press the button P to enter the Parameter Interface, then the L parameters in the parameter list will display. On the sewing setting interface, the user can keep pressing the button for a few seconds to enter the Password Enfinterface, now the Level I and Level II parameters in the parameter list will display. 2. Password setting On the sewing setting interface, the user can keep pressing the button P for a few seconds to enter the Password Enfinterface, now the Level II parameters in the parameter list will display. 2. Password setting On the sewing setting interface, the user can keep pressing the button P for a few seconds to enter the Password Enforcement of the password setting interface, the user can keep pressing the button P for a few seconds to enter the Password Enforcement of the password setting interface, the user can keep pressing the button P for a few seconds to enter the Password Enforcement of the password setting interface, the user can keep pressing the button P for a few seconds to enter the Password Enforcement of the password setting interface, the user can keep pressing the button P for a few seconds to enter the Password Enforcement of the password interface, and press the button C interface, and press th	set/check	\square	I Middleend: F. FPeriod of hin himber Light corresponding level:	
Sewing set program The number of needles sewing set, Set up a total of 15 segment needle number P1~PF. Speed down. Keeping pressing to lower speed, the display will automatically switch to speed set. Simple seam, free effective.	parameter setting	\mathbb{P}	On the sewing setting interface, the user can press the button P to enter the I parameters in the parameter is will display. On the sewing setting interface, the user can keep pressing the button for a few se Interface. After entering the right maintenance password, then the user can press Interface, now the Level I and Level II parameters in the parameter list will display. 2.Password setting On the sewing setting interface, the user can keep pressing the button P for a few se Interface, and press the button combination of "burst button + soft start butto Interface. The three indicators (respectively are Indicator S1, S2 and S3 from left to one is on) corresponding to the button S indicates the current status. S1 lights up combination trigger key + tangent key, if the correct password into the password re S1 state), and at the same time S2 light, prompting the input new password and it the light is the new password, according to S key after two input if consistent, interfacelf the new passwords entered are not the same, the Indicator S1 will be on a user shall enter the old password again. If the user presses the button P, the user parameters and no modification will be saved. You can choose from the numbers of	the button P to enter the Parameter
speed key Speed down. Keeping pressing to lower speed, the display will automatically switch to speed set. Simple seam, free	Teaching function		Set or cancel the teaching function.	
speed key effective.		Fis	The number of needles sewing set, Set up a total of 15 segment needle number P1	~PF.
1 ' ' 1	speed key	€>(Speed down. Keeping pressing to lower speed, the display will automatically switch effective.	to speed set. Simple seam, free seam
Speed up. Keeping pressing to increase speed, the display will automatically switch to speed set.Simple seam, free effective.	эреей кеу)\$		to speed set.Simple seam, free seam

Teaching function:
In the long slot (a, four, program seam) mode, long press "T" one second, you can enter the teaching interface, this interface has buttons:
T key, two groups of add-substract key, fill needle key. Role is as follows:
Add-substract key 12: change teaching segments, segment numerical only to accumulate (into the next section teaching automatically save the last needle numerical reduction), '- key is invalid. Note: when the pedal operation, the key is invalid;
Add-substract key 34: modify teaching pin number, to stop running when the adjust pin number. Fill needle keys: press can manually fill needle, needle change.
T: exit show interface, complete the current segment number teaching (section numerical covering the original mode).
After the pedal shear line, will directly from the show and save the needle numerical, before returning to the fixed length of stitch pattern.

5.Standard needle stitch compensation adjustment

Starting reinforcing	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value.No.54		Forward sewing number Become less and shorter, Adjust the parameters to lower values No.54
-sewing No.54 No.55	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.55	1/1	Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.55
ending reinforcing	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher valueNo.57	1/	Forward sewing number Become less and shorter, Adjust the parameters to lower valuesNo.57
-sewing No.57 No.58	Reverse sewing and forward stitching joint		Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.58	1/1	Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.58
continuous reinforcing	Forward sewing and reverse stitching joint		Reverse stitch number Become less and shorter, To adjust the parameters to a higher value No.60	1/1/	Forward sewing number Become less and shorter, Adjust the parameters to lower valuesNo.60
-sewing No.60 No.61	Reverse sewing and forward stitching joint	V	Forward sewing number Become less and shorter, To adjust the parameters to a higher value No.61		Reverse stitch number Become less and shorter, Adjust the parameters to lower value No.61

Error	codes

Error Code	Contents	Possible reasons	Checking and treatment
E011 E012 E013 E014	Motor signal error	Motor position sensor signal failure	If electric engine plug is well contacted; if electric engine signal detecting device has been broken; if sewing machine handwheel correctly installed.
E015	Model type error	Unable identify operating box model type	Check operating box
E021 E022 E023	Motor overload	motor stall motor overload	If electric engine plug is well contacted; if machine head or thread-cutting mechanism has been blocked completely;f materials are too thick; Electrical signal detection signal whether the normal
E101	Hardware drivers fault	Current detection abnormal Driving hardware error	Current detection loop system is working properly; Whether the damage to the device driver.
E111 E112	Voltage too high	High input voltage Brake circuit fault Voltage detection error	System into line voltage is too high; Braking resistance are working properly; System voltage detection circuit are working properl
E121 E122	Voltage too low	Actual low voltage Voltage detection is wrong	If the voltage detection circuit are working proper if the voltage on the inlet wire is too low Whether the system voltage detection circuit the normal work.
E131	Current circuit fault	Current detection abnormal	Current detection loop system is working properly.
E133	Oz circuit fault	Oz circuit fault	Oz circuit system is working properly.
E151	Magnet circuit error	Over current magnet circuit	If machine head magnet suffers short circuit Electromagnet circuit is working properly.
E201	over current	Current detection error	Current detection loop system is working properly Electrical signal is normal.
E211 E212	Abnormal motor operation	Current or voltage detection error	If electric engine plug is well contacted; If electric engine signal is matched.
E301	Communication error	Sci circuit error	if operation box plug is well contacted; if operation box components are damaged.
E302	Operation inner failure	Sci circuit error	To check whether the operating box is damaged
E402	Pedal ID fault	Pedal verification fault	Pedal connection is loosen.
E403	Pedal zero position fault	The pedal zero position over range	The pedal is damaged or it is not under stop state when correction.
E501	Safety switch fault	Safety switch effective	Put down the head or check turned up switch.
P.oFF	Power off Display	Power off	Wait for power supply to resume.

Note: 1. Sewing abnormal action (speed electromagnet work abnormal) : in the control interface view model is

- 2. Turn up E501 fault when: sure it is normal to switch detection, temporary use can change the P-28
 - 3. If the above according to check the project cannot rule out fault, please seek technical support.

-1-