

Shanghai Fushan Precision Machinery Technology Co.

Instructions for use

Products covered: HSAT-K1A 【Automatic ring downer】

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Safety instructions Please read carefully first

----- Important Safety Matters -----

Note

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The contents of these instructions are for informational purposes only and are subject to change without notice.

We are not responsible for this information. We are also not responsible or liable for any errors or inaccuracies in these operating instructions.

HIKARI sewing machines always introduce the most advanced technology and maintain a policy of continuous improvement in the performance and specifications of these products. Therefore, we reserve the right to change specifications and designs without prior notice.

When using this sewing machine, basic safety measures must be observed, including the following items

1. Turn off the power switch or unplug the power cord immediately if any of the following conditions occur

1-1 When threading and changing shuttles for machine needles, bent needles, separators, etc.

1-2 When replacing needles, presser feet, needle plates, bent needles, separators, fabric feed teeth, needle protectors, holders, fabric guides, etc.

1-3 When repairing.

1-4 When the workplace is unoccupied or when leaving the workplace.

2. It is forbidden to touch parts or devices with the sewing machine switch energised by oiled hands.

3. Repairs, alterations and adjustments to the sewing machine in question should be carried out by specially trained technicians or specialists.

4. General maintenance and storage should be carried out by trained personnel.
5. The sewing machine should be cleaned regularly during its use.
6. For normal and safe operation, an earth wire should be installed. It should also be used in an environment that is not affected by strong noise sources such as high frequency welding machines.
7. Modifications and alterations to the sewing machine should be in accordance with the safety specifications and effective safety measures should be taken. Furthermore, we are not responsible for the relevant modifications and alterations.

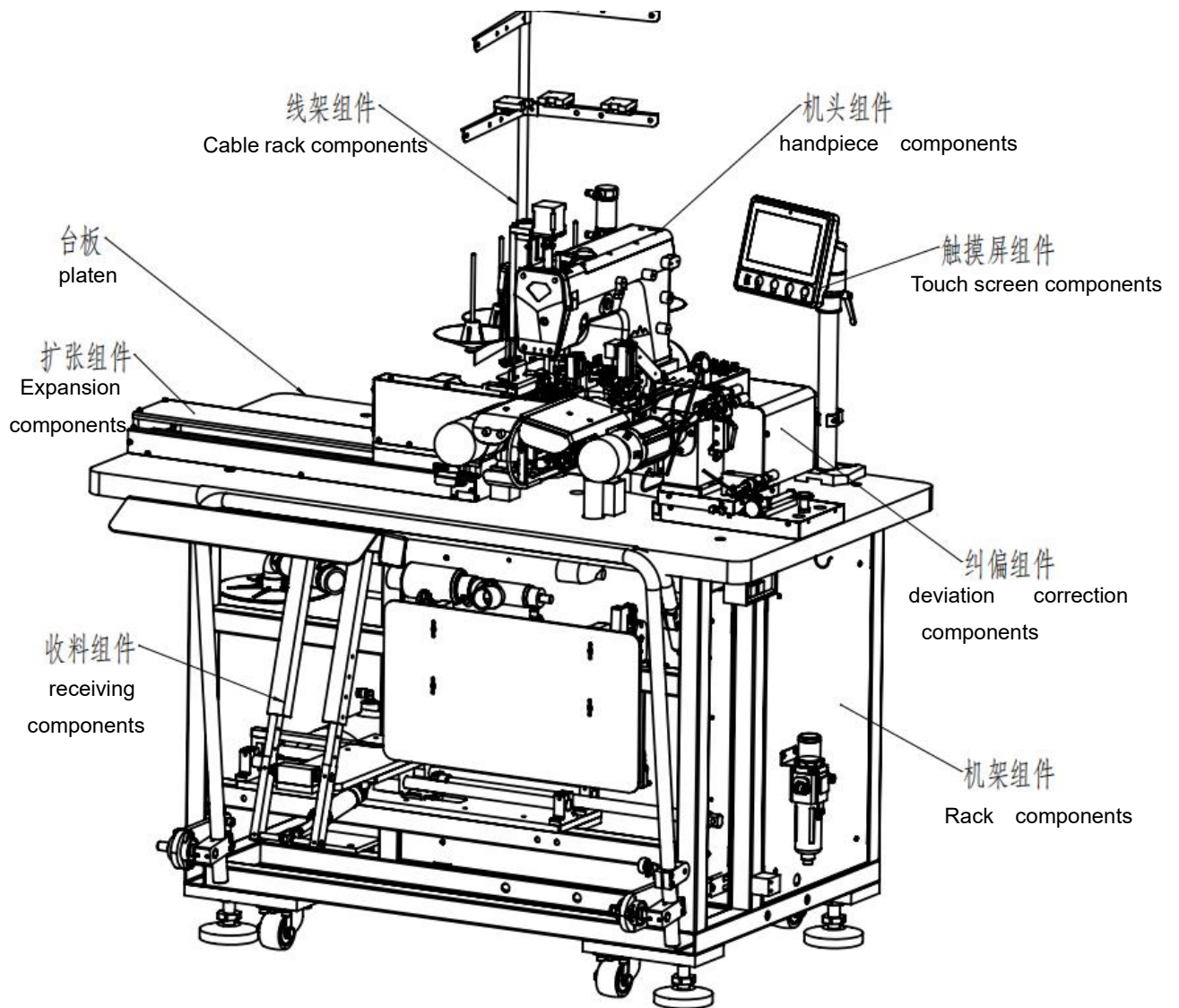
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—. Product performance indicators

Performance indicators for automatic ring downers			
	Projects	Scope	Remarks
Craftsmanship Indicators	Range of hemstitching	37-83cm	Folded in half (half circumference)
	Hem fold width	1.5-3.5cm	
	Pin position	5.6mm as standard	Optional 4.0/4.8/6.4mm
	Needle pitch	0.8mm - 4.5mm	
	Lockstitch function	Standard	
	Inverted share function	Standard	
	Photo-eye sensor for automatic seam opening	Standard	
	Automatic take-up function	Standard	
	Automatic wire break detection	Standard	
	IOT functions	Standard	
System Parameters	Rotational speed	4000 rpm	
	Presser foot height	7mm	
	Support for panel program upgrade method	USB flash drive	
	Touch screen language display	Chinese/ English	
	Supply voltage range	220V/50HZ± 10%	
	Power rating	1100W	
	Operating ambient temperature	-15°C to 50°C	
	Humidity of the working environment	35% to 95% (no condensation)	
	Rated air pressure	0.6mpa	

二. Description of components



≡ About oil supply

1. Oils used

Please use our designated

(HIGH SPEED SEWING MACHINE OIL)

Or please use the same

(ESSOTEX SM22 (made by Exxon Mobi)).

2. Method of oil supply

Remove the cap from the oil supply

port 1 and refuel to the H line of the oil scale and

L line in the middle. After adding oil, close

the cap on the oil supply port 1.

3. Dosing of oil

The H and L lines on dipstick 2 indicate the

upper and lower oil levels Limit. To keep the

oil level constantly between the H and L lines,

Please Check often for attention to refuelling.

4. Oiling by hand

When adding oil by hand, be sure to turn off the power to the sewing machine by turning

Do this after the plug has been pressed down from the power plug.

When the sewing machine is first used, or if it has not been used for a long time

When restarting use, please make sure that the

needle bar 3. bent needle shaft 4, etc.

Add 2-3 drops of oil with the oil filler.

5. Check the circulation of the oil

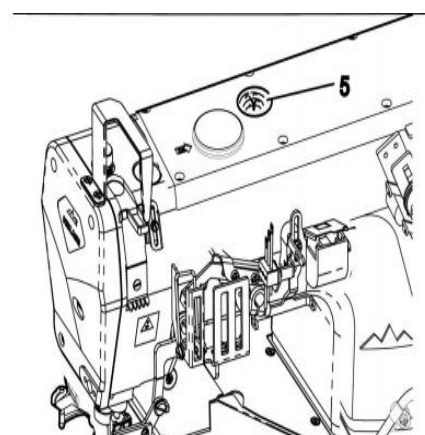
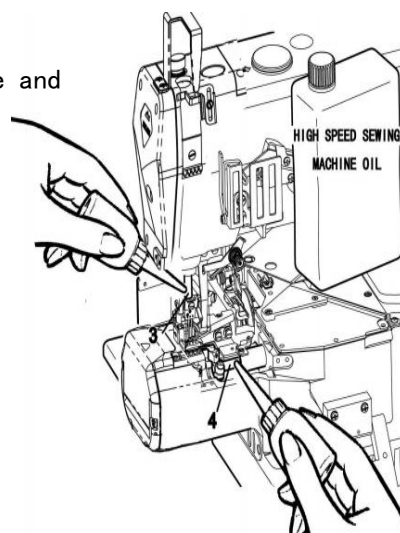
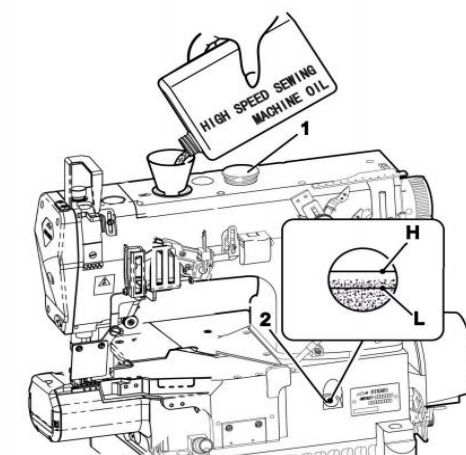
Please press the sewing machine pedal after

filling the oil to make the sewing machine run

Turn and check that the oil is circulating well

through the oil window 5. ● Always switch off the power switch and remove

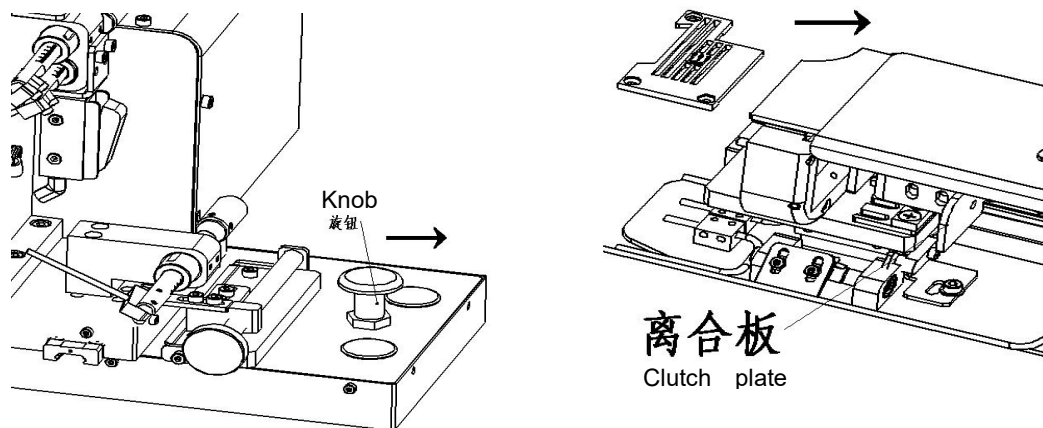
the power plug from the socket before carrying out the following operations.



四、 Ways of threading

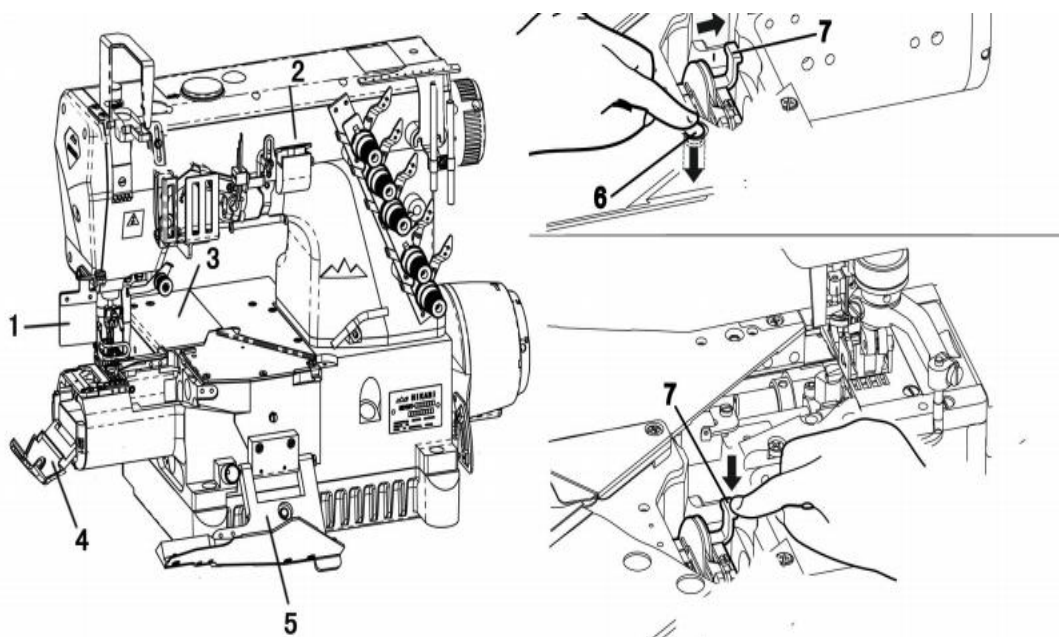
When threading, always turn off the power to the sewing machine and press the plug off the power plug before proceeding.

1. Pull up the knob to the right and move it to the bottom. After wearing the present, move the device to the right to the original position and press the knob to lock it.
2. When threading the bottom line, the clutch plate moves to the right and after threading the present, push the suction to the left.

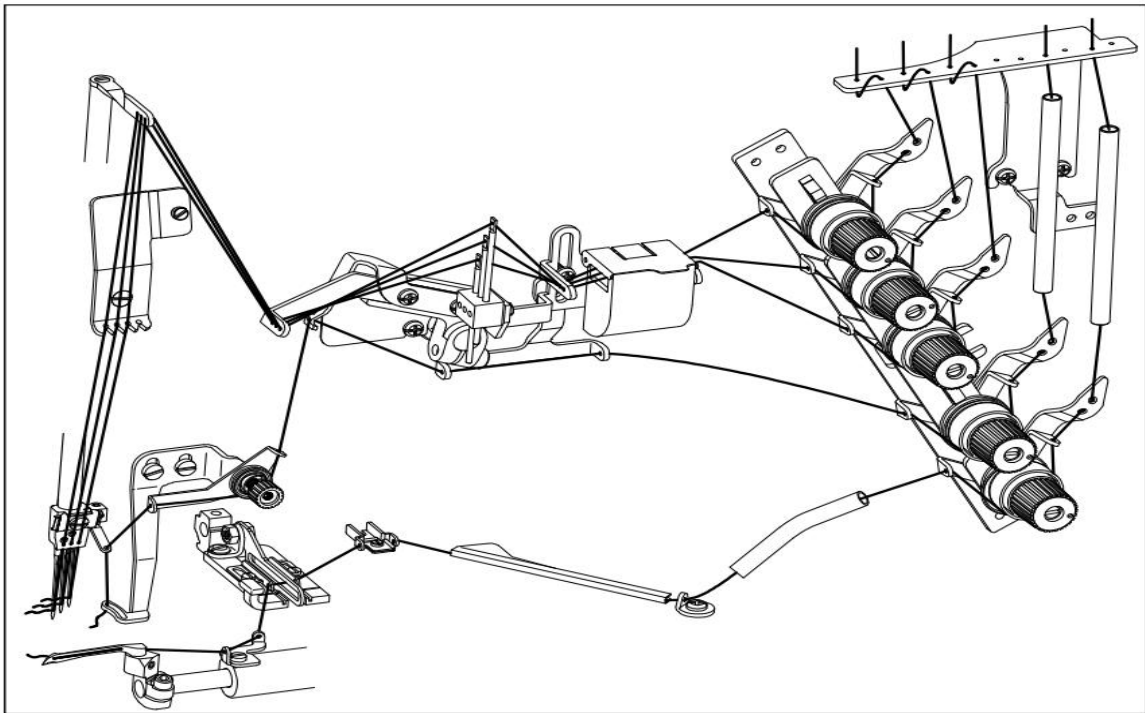


3. Please open protective goggles 1 and covers 2, 3, 4 and 5

4. Press button 6, then the lower wire picker 7 will jump up. After threading, when you want to restore the original position, please press the lower wire picker 7 to do so.

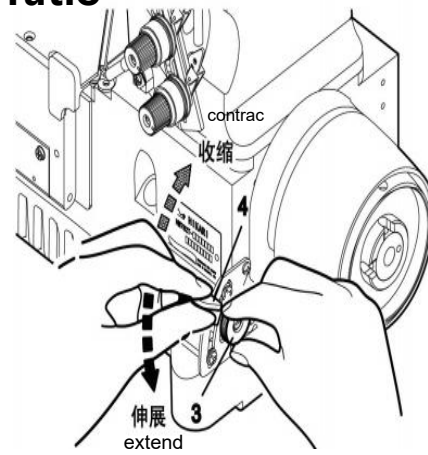


5. Threading diagram



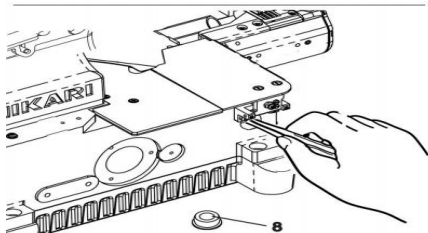
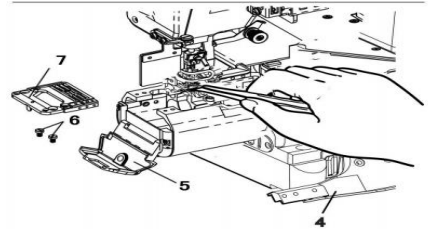
五、 Adjustment of the differential ratio

1. Loosen nut 3 and spanner 4 upwards, the differential ratio Larger, missed fabric will shrink up, bring spanner 4 down If the board is used, the differential ratio will become smaller and the sewn fabric will stretch.
2. After adjustment, tighten nut 3.



六、 Cleaning of machines

Always turn off the power to the sewing machine when you lightly sweep it. Do this after pressing the plug down from the power plug.



七. Replacement of machine needles

Always turn off the power to the sewing machine when you lightly sweep it. Do this after pressing the plug down from the power plug.

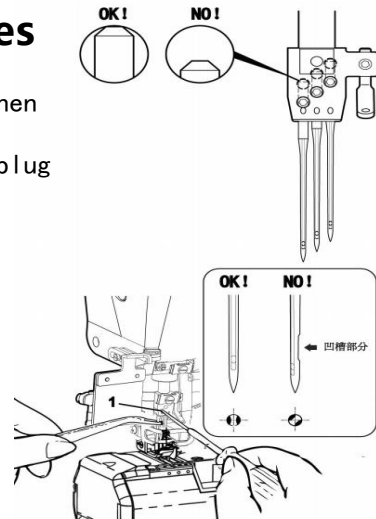
1. Please use a (1.5mm) hexagonal screwdriver to loosen the fixing screw 1.

2. Remove the old needle with the tweezers from the included tool kit.

3. Attach the needle with the groove towards the back of the sewing machine.

4. Using tweezers, insert the new needle deep into the chase of the hoop holder.

5. Then tighten the fixing screw 1 using a (1.5mm) hexagonal screwdriver.



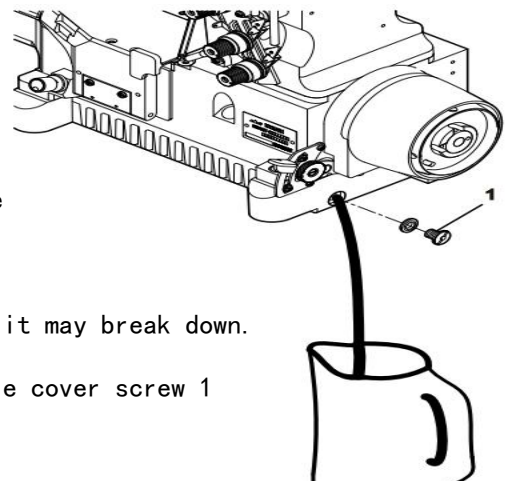
八. Oil change

Change the oil of the sewing machine once after 1 month of use. Then please change the oil every 6 months, if not change the oil

If the sewing machine continues to be used, it may break down.

1. Please remove the oil tank base drain hole cover screw 1 and drain the old oil.

2. After draining the oil, tighten the oil drainage hole cover screw 1.

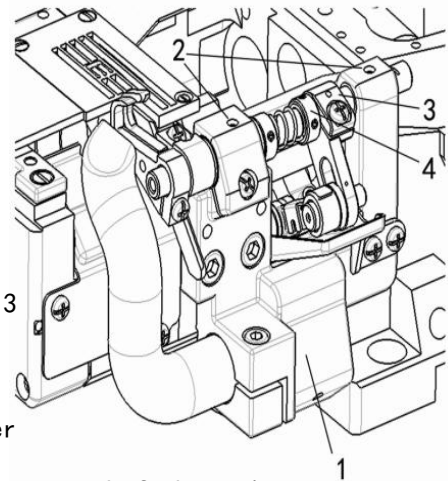


九. Adjustment of the cutting knife

With regard to the engagement pressure of the upper and lower knives, please refer to the following table when cutting fabric smoothly

Adjust the pressure as weakly as possible within the range of the Regulating Keep the connecting rod 3 in the correct mounting position, then adjust the Shaft The position of the hoop 4 to adjust the cutter

engagement force, allowing the rear locking 4 on the screw shaft hoop 4 moves to the left to become more strongly engaged and to the right The engagement force becomes weaker.



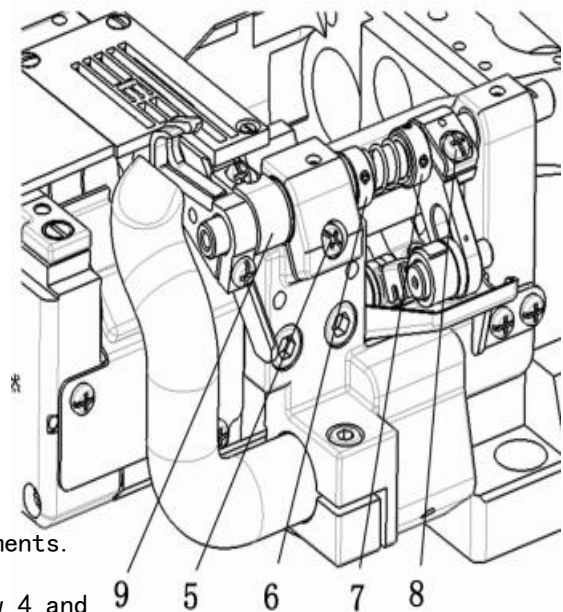
Adjustment of the left and right position of the lower cutter

1. Always switch off the sewing machine when making adjustments to the lower cutting table The power switch is unplugged from the socket and is operated by a special The industry technician carries out.

2. To adjust the cutter position of the fabric, move the cutter from side to side Block 5 to carry out.

3. To adjust, first loosen, screw 5, screw 8, and and the screws on the shaft fixing 6, 7, then move the cutter holder 9 to make adjustments.

4. After adjustment, retighten screw 5, screw 4 and



Shaft fixing screws. Be careful to keep the left end of the moving knife at an appropriate distance from the discharge tube after adjustment. When the distance is right.

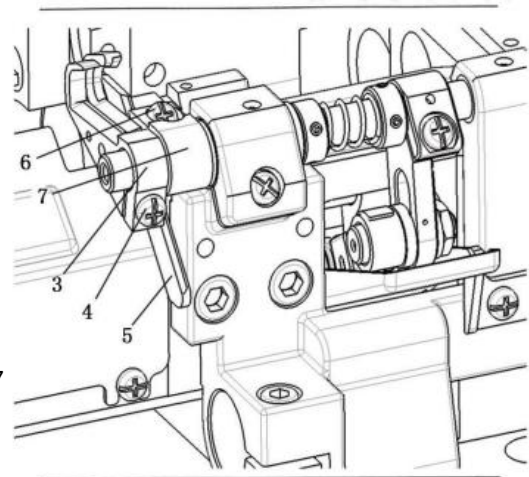
Knife replacement

Lower cutter change

1. Please loosen screws 4 and 6 and move the tool holder 3 to the left. Move, then remove the old undercut 5.

2. Remove the new lower cutter 5 and insert it into the slot in the lower cutter holder 7 so that the lower blade of knife 5 is on

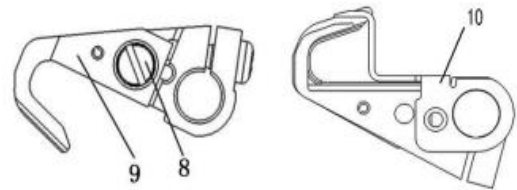
the same level as the plane of the needle plate. Then Fasten screws 4 and 6.



Change of upper cutter

1. Loosen the screw 4 and remove the upper blade holder 3. Screw 8 removes the old upper blade 9.

2. Take the new upper cutter 9 and place it on the upper cutter holder 3, against its pin hole and screw hole, then lock the screw 8.

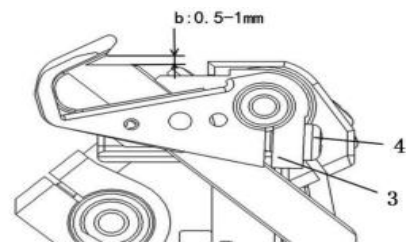


3. When sewing with thick material, it is recommended that the cutter guard 10 be removed underneath to prevent any blockage of cloth shavings.

Knife engagement adjustment

Please turn the drive handwheel and set the upper cutter to the lowest position. Please adjust correctly for the engagement of the upper and lower cutter inch b to 0.5 mm as shown. to adjust,

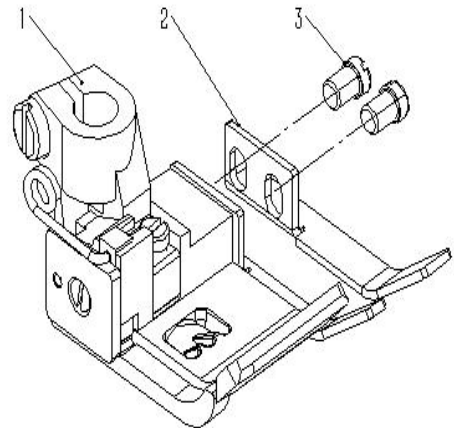
loosen Move screw 4 and move seat 3 up and down, after adjustment, tighten Solid screw.



✦ Adjustment of hem width

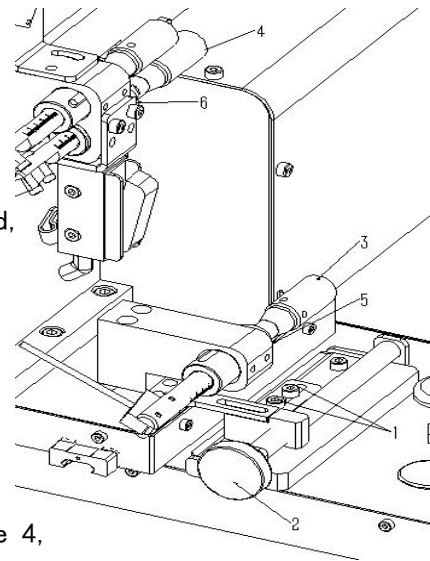
Presser foot stopper replacement

1. Remove the presser foot piece 1 on the machine.
2. Unscrew the screwed parts 3 and replace the presser foot retainer 2 with the size used.



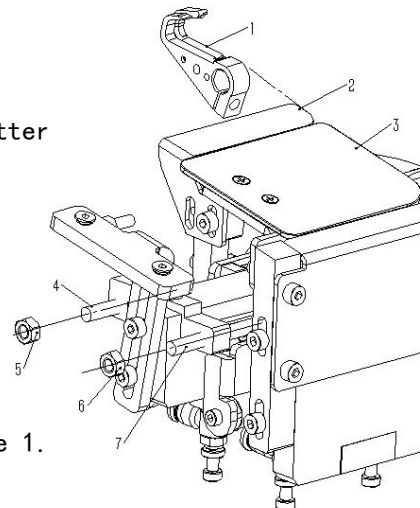
Basis adjustment for hem width

1. Screwdriver loosens part 1, rotates part 2. left hem width changes Narrower, wider right-handed, rotated to a 0.3mm difference in presser foot stop Distances.
2. If the hem width has changed after adjustment of part 2, the screw should be loosened Adjust the fabric cutting edge at a distance from handle piece 4, while loosening the screw Staple piece 5, adjustment piece 5, so that the intermediate sensor photoelectricity is tangled with the fabric edge The offset sensor light points are 5 mm apart, and then the fixing screws 5, and 6.



Hem width layering plate adjustment

1. After adjusting the hem width reference, the cutter piece 1 is connected to the layering Plate piece 2, piece 3 need to be aligned.
2. Adjustment method, loosen nut piece 5 and piece 6. adjustment screw Piece 4 and piece 7, flush with its piece 2 and piece 3 and cutter piece 1.



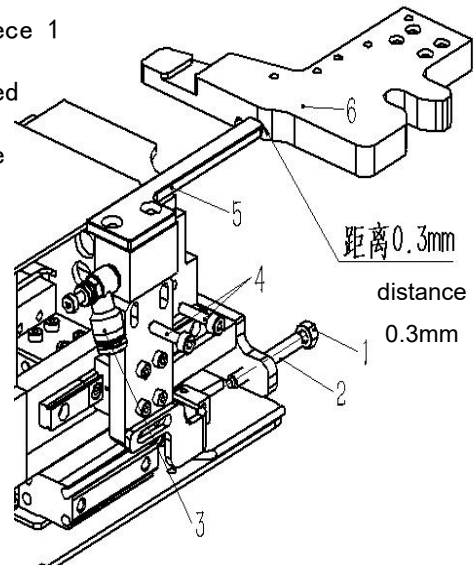
十一、Adjustment of inverted strand components

1. After adjusting the hem width, loosen nut piece 1 and adjust the limit. The front end of the inverted plate member 5 is located at a distance from the side of the member 6.

0.3mm away.

2. Loosen the screw piece 4 and adjust the height of the inverted strand plate, piece 5, up and down.

3. Speed control valve piece 3, with high air pressure to the left and low air pressure to the right.



十二、Description of the operating interface

1. Machine working interface (main interface)

After switching on, when the middle of the display appears

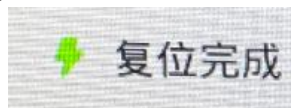


and the upper middle part **⚡ 机器待机, 请复位** appears,

click on the reset button to reset before proceeding.

When the reset is complete and successful, the wording will appear in the upper middle

section of the main **🔋 复位完成** page.



Interface after reset is complete

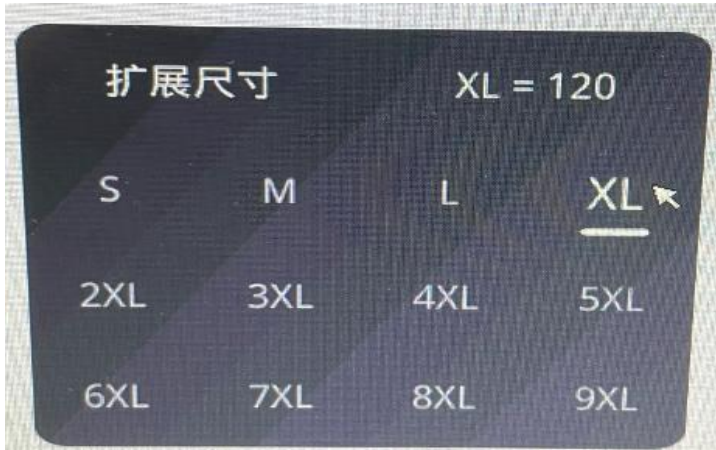


Six functional broad category toggle buttons

1. Main interface buttons
2. Control buttons
3. Monitor button
4. Parameters button
5. Settings button
6. IOT button



Main screen – Extended size setting module



Main interface – production style switching (10 models in total)



Main screen – start, stop, reset buttons



Main screen – at preset yield



Main screen – at the stock level value setting



Main interface – Threading switch



Main screen ---- Receiving function switch



Main screen ---- Dialing stock function switch



Main interface ---- Laser switch function switch



2. Control buttons

Clicking on the control buttons on the left-hand side displays three switchable pages for cylinder control, motor control and head control.

(1) Cylinder control

15 groups of cylinders can be controlled individually



(2) Motor control

6 motors can be controlled individually in forward and reverse, the cutter motor is not reversible.



(3) Head control

Changeable head speed and presser foot cylinder operation



3、Monitoring interface

Monitoring of all signals on the machine



4、Parameter interface

5、Frequently used parameters can be changed

HIKARI	
主界面	0:启缝位置 0 7:压脚压力初始高度 0
控制	1:缝纫速度 0 8:倒股吹气时间 0
监控	2:送料轮配速 0 9:倒股关闭吹气时间 0
参数	3:启缝慢针数 0 10:面料扩张距离 0
设置	4:结束重合针数 0 11:送料开关 0
IoT	5:结束慢针数 0 12:送料距离 0
	6:分层气缸延迟针数 0

0:Opening seam distance: stock opening seam position, value increases to the left and decreases to the right. Unit (mm)

1:Sewing speed: The sewing speed of the machine head

2:Feed wheel speed: the speed of the feed wheel rotation distance and the machine head stitch distance (associated with the end stitch overlap).

3:Slow Start Stitches: the number of slow start stitches for sewing.

4:End overlap stitches: The number of stitches overlapped at the end of the sewing seam.

5:End Slow Stitches: The number of slow stop stitches at the end of sewing.

6:Number of delayed stitches in the layering cylinder: number of delayed stitches for the exit of the layering plate.

7: Initial height of presser foot pressure: Presser foot pressure adjustment.

8:Inverted strand blowing time: set the inverted strand stick out blowing retention time, unit (ms)

9: Toggle strand off blow time: set the inverted strand bar retracted blow retention time, unit (ms)

10:Fabric Expansion Distance: Left Expansion Wheel Bracing Distance Adjustment.

11:Feed switch: [1] mode, for both sides of the strand stop position at the left and right feed wheels; [0] mode, strand stop position at the front of the presser foot.

12:Feed material distance: feed switch [1] mode, stock stop distance, the value increases to the left and decreases to the right.

5、Setting interface



Advanced parameters access screen password 3130321

Technical parameters to access the interface password 313321

Panel upgrade function: Use a USB stick to upgrade the panel program function.

Master control upgrade function: Use a USB stick to upgrade the master control program function.

Restore factory settings function: function to restore factory default parameters.

Run-in setting: carries out functions for the ageing of the machine for use.

Stepper drive: parameter reading function for each axis individually.

Remote upgrade: Internet remote upgrade function.

Alarm logging: History logging function for machine alarms.

Language switch: switch between English and Chinese functions in the interface.

Panel version: displays the panel program version number.

Motherboard version: Displays the motherboard program version number.

6. IOT interface

Machine status can be monitored



十三、Machine parameter setting interface

1. Advanced parameters ----- Start-up parameters screen



0: Number of strands: Set the number of strands for the top hem (default is 2 strands).

1: Idle Speed: Sets the value of the right wheel speed when running empty.

2: Reserved: reserved.

3: Reserved: Reserved.

4:Reserved: reserved.

5:Expansion speed: Set the fabric expansion speed limit value.

6:Extended position: Set the fabric extended position value.

7:Reserved: reserved.

8:Feed retraction distance: Set the length of the extended retraction when receiving the material.

9:Ventilation time of the spreader bar: sets the unit of ventilation time (ms ms) of the take-up spreader bar.

10:Take-up rod ventilation time: sets the unit of ventilation time (ms ms) for the take-up take-up rod

11:Reserved: reserved.

12:Fabric Expansion Distance: Left Expansion Wheel Bracing Distance Adjustment.

13:Receiving platform return time: the time at which the receiving mechanism is most returned to its final position.

3. Advanced parameters ---- sewing parameters interface

HIKARI®		启动参数	缝纫参数	纠偏参数	切刀参数	股位参数
主界面	0:启缝位置	0	7:多股位距离调整时间	0		
控制	1:缝纫速度	0	8:断线检测器1时间	0		
监控	2:送料轮配速	0	9:断线检测器2时间	0		
参数	3:启缝慢针数	0	10:断线检测器3时间	0		
设置	4:结束重合针数	0	11:断线检测器4时间	0		
IoT	5:结束慢针数	0	12:启缝断线检测开启针数	0		
	6:压脚压力初始高度	0	13:结束断线检测关闭针数	0		

0:Open seam distance: Set the value of the open seam position in mm.

1:Sewing speed: The sewing speed of the machine head

2:Feed wheel speed: the speed of the feed wheel rotation distance and the machine head stitch distance (associated with the end stitch overlap).

3:Slow Start Stitches: the number of slow start stitches for sewing.

4:End overlap stitches: The number of stitches overlapped at the end of the sewing seam.

5:End Slow Stitches: The number of slow stop stitches at the end of sewing.

6:Initial height of presser foot pressure: Presser foot pressure adjustment.

7:Multi-position distance adjustment time: Sewing multiposition distance blocking time

8: Disconnect detector 1 time: set the disconnect detector 1 delayed response time ms (setting to 0 will turn off disconnect detection 1)

9: Disconnect detector 2 time: set disconnect detector 2 delay response time ms (setting to 0 will turn off disconnect detection 2)

10:Disconnect detector 3 time: set the disconnect detector 3 delay response time ms (setting to 0 will turn off disconnect detection 3)

11:Disconnect detector 4 time: set the disconnect detector 4 delay response time ms (setting to 0 will turn off disconnect detection 4)

12:Start stitch breakage detection open stitches: shields the number of false alarms caused by slow start stitches.

13: End sewing stitch break detection off stitches: shields against false alarms caused by slow end sewing stitches.

4. Advanced parameters ---- deskew parameters interface

HIKARI®		启动参数	缝纫参数	纠偏参数	切刀参数	股位参数
主界面	0:启动外纠偏速度	0	7:送料开关	0		
控制	1:启动内纠偏速度	0	8:送料距离	0		
监控	2:结束外纠偏速度	0	9:结束右送轮配速比	0		
参数	3:结束内纠偏速度	0	10:误检结束延迟针数	0		
设置	4:纠偏过度停止针数	0	11:误检骨位延迟针数	0		
IoT	5:纠偏过度速度补偿	0	12:	0		
	6:分层气缸延迟针数	0	13:	0		

0: Start outward deflection speed: speed of the motor outward during the start sewing phase.

1: Start-up internal deflection speed: the speed at which the motor is turned inwards during the start-up sewing phase.

2: End outward deflection speed: the speed of the motor outward at the end of the sewing phase.

3: Ending in-correction speed: the speed at which the motor is turned inwards at the end of the sewing phase.

4: Number of over stitching stops: Number of stitches that are stopped when synchronising during the corrective switching process.

5: Excessive speed compensation for deflection: inward speed compensation for deflection during deflection switching.

6:First limit cylinder exit stitch: Number of exit stitches for the first limit cylinder layering.

7:Receiving switch: 1 for the cloth strand position to automatically turn to the left and right feeding when opening the receiving material, 0 for the cloth strand position to turn to the set receiving distance length.

8:Take-up distance: sets the distance the fabric strand moves when the take-up switch is closed.

9:End right feed wheel speed ratio: The photoeye is switched at the end of sewing, and the speed of the right feed wheel and the machine head is adjusted

10:False detection end delay stitch count: Set the value for switching the photo eye to the end sewing position, when the strand position is false detected, sewing can be stopped at this stitch count.

11:False detection of strand position delay stitch count: sets the value for switching the photo eye to the strand position so that sewing does not stop halfway through when the strand position is false detected.

12:Reserved: reserved.

13:Reserved: reserved.

5. Advanced parameters ---- cutter parameters interface

启动参数	缝纫参数	纠偏参数	切刀参数	股位参数
0:切刀低速	0	7:		0
1:切刀高速	0	8:		0
2:切刀开启时间	0	9:		0
3:过股切刀加速开关	0	10:		0
4:过股切刀加速距离	0	11:		0
5:过股切刀减速距离	0	12:		0
6:结束缝纫切刀关闭距离	0	13:		0

- 0:Cutter low speed:** Sets the speed value for cutter low speed.
- 1:Cutting knife high speed:** Set the speed value of the cutting knife high speed.
- 2:Cutter opening time:** Set the time for the cutter to open.
- 3:Over-strand cutter acceleration switch:** set the function of whether the cutter over-strand should be accelerated or not.
- 4:Over-strand cutter acceleration distance:** set the distance at which the cutter will accelerate over the strand.
- 5:Over strand cutter deceleration distance:** set the distance at which the cutter will decelerate after passing over the strand.
- 6:End of sewing cutter closing distance:** the distance at which the cutter closes after the end of sewing.

6. Advanced Parameters ---- Unit Position Parameters Interface

启动参数	缝纫参数	纠偏参数	切刀参数	股位参数
0:压脚初始高度	0	7:过股压脚压力变化关闭距离	0	
1:启缝压脚压力变化开关	0	8:结束压脚压力变化开关	0	
2:启缝压脚压力变化高度	0	9:结束压脚压力变化高度	0	
3:启缝压脚压力变化关闭距离	0	10:结束压脚压力变化开启距离	0	
4:过股压脚压力变化开关	0	11:结束压脚压力变化关闭距离	0	
5:过股压脚压力变化高度	0	12:接股吹气时间	0	
6:过股压脚压力变化开启距离	0	13:接股关闭吹气时间	0	

- 0:Presser foot initial height:** sets the initial height of the presser foot.
- 1: Presser foot pressure change switch:** Sets whether the presser foot pressure change switch opens when the seam is opened.
- 2:Presser foot pressure change height:** Set the height of the presser foot change when the seam is opened.
- 3:Presser foot pressure variation closing distance:** Set the distance at which the presser foot pressure variation closes when the seam is opened.
- 4:Presser foot pressure change switch for overstrike:** Set whether the presser foot pressure change switch is open during overstrike.

5:Over-strand presser foot pressure change height: Set the height at which the presser foot changes during over-stranding.

6:Over-strand presser foot pressure change opening distance: Set the opening distance of the presser foot pressure change before the over-strand.

7:Closing distance for change in presser foot pressure after passing the strand: Set the closing distance for change in presser foot pressure after passing the strand.

8:End presser foot pressure change switch: Sets whether the presser foot pressure change switch opens at the end of sewing.

9:End presser foot pressure change height: sets the height of the presser foot change at the end of sewing.

10:End presser foot pressure change opening distance: Sets the opening distance for the presser foot pressure change at the end of sewing.

11:End presser foot pressure change closing distance: Sets the closing distance for the presser foot pressure change at the end of sewing.

12:Paddle blowing time: Set the time in (ms) for the paddle device to extend.

13:Toggle off blow time: Set the time for the toggle unit to blow, in (ms)

7. Technical data ---- first page of the parameter screen

第一页	第二页	第三页	第四页
股位检测值	0	纠偏电机最大速度	0
右轮电机最大速度	0	压力扩展伸缩补偿	0
左轮电机最大速度	0	右轮直径	0
扩展电机最大速度	0	左轮直径	0
压脚压力电机最大速度	0	左轮速度百分比	0
			退出

Share level detection value: threshold parameter for share level detection.

Maximum speed of the right wheel motor: Maximum speed parameter of the right wheel motor.

Maximum speed of the left wheel motor: Maximum speed parameter of the left wheel motor.

Extended motor maximum speed: Extends the maximum motor speed parameter.

Presser foot pressure motor maximum speed: parameter for maximum speed of the presser foot motor.

Maximum speed of the deflection motor: Maximum speed parameter of the deflection motor.

Pressure extension expansion compensation: Expansion compensation value for pressure sensor condition.

Diameter of the right wheel: diameter parameter mm of the right wheel.

Diameter of the left wheel: diameter parameter mm of the left wheel.

Left wheel speed percentage: the left wheel speed is taken as a percentage parameter of the right wheel speed.

8. Technical data ----- page 2 parameter screen

第一页	第二页	第三页	第四页
软启动速度	0	停车低速针距补偿百分比	0
启缝低速针距补偿百分比	0	软停止速度	0
启缝低速针距补偿针数	0	缝绉速度针距补偿千分比	0
过股针距补偿开启针数	0		0
过股针距补偿百分比	0		0
			退出

Soft Start Speed: The speed parameter for the soft start of the head. This parameter is the minimum speed target value for soft start during operation.

Stitch length compensation percentage at low speed: percentage compensation of the stitch length at low speed.

Number of stitches to compensate for low stitch speed: Number of stitches to compensate for low stitch speed.

Number of open stitches for overstretch compensation: Number of open stitches for overstretch compensation.

Overstretch compensation percentage: Percentage parameter for overstretch compensation.

Stop Low Pitch Compensation Percentage: Percentage parameter for stop low pitch compensation.

Soft stop speed: speed parameter for the end of the soft stop.

Thousandths of a second: Thousands of a second for sewing speed and stitch compensation.

十四、Machine alarms and solutions

1. Machine Alarm

In the event of an abnormality, the machine will stop working and prompt an alarm screen: (click the OK button to lift the alarm).



2. Alarm content and solution

Serial number	Alarm name	Solutions
1	Wire break sensor 1 detects a wire break signal	1. Please check the wire set 1. 2. Please check that the disconnect sensor light is on, if not, please check that the disconnect connector connection wire is correct and reliable.
2	Wire break sensor 2 detects a wire break signal	1. Please check the wire set 2. 2. Please check that the disconnection sensor light is on, if not, please check that the disconnection connector connection wire is correct and reliable.
3	Wire break sensor 3 detects a wire break signal	1. Please check the wire set 3. 2. Please check that the disconnect sensor light is on, if not, please check that the disconnect connector connection wire is correct and reliable.
4	Wire break sensor 4 detects a wire break signal	1. Please check the wire set 4. 2. Please check that the disconnect sensor light is on, if not, please check that the disconnect connector connection wire is correct and reliable.
5	Right feed motor drive alarm	Please check whether the green light of the power supply of the right feeding motor driver is on properly. 1. Green light is on, check whether the red etc. flashes several times, corresponding to the corresponding alarm. Check whether the phase and encoder lines are connected correctly and reliably. 2. If the green light is not on, check whether the power supply line of the drive board is connected correctly and reliably.

<p>6</p>	<p>Deflection motor drive alarm</p>	<p>Please check whether the green light of the power supply of the guiding motor driver lights up normally. 1. The green light is on, check whether the red etc. flashes several times, corresponding to the corresponding alarm. Check whether the phase line is connected correctly and reliably. 2. If the green light is not on, check whether the power supply line of the driver board is connected correctly and reliably.</p>
<p>7</p>	<p>Presser foot motor drive alarm</p>	<p>Please check whether the green light of the power supply of the presser foot motor driver lights up normally. 1. The green light is on, check whether the red etc. flashes several times, corresponding to the corresponding alarm. Check whether the phase line is connected correctly and reliably. 2. If the green light is not on, check whether the power supply line of the driver board is connected correctly and reliably.</p>
<p>8</p>	<p>Left feed motor drive alarm</p>	<p>Please check if the green light of the power supply of the left feeding motor driver is on properly. 1. Green light is on, check if the red etc. flashes several times, corresponding to the corresponding alarm. Check whether the phase and encoder lines are connected correctly and reliably. 2. If the green light is not on, check whether the power supply line of the drive board is connected correctly and reliably.</p>
<p>9</p>	<p>Extended motor drive alarm</p>	<p>Please check if the green light of the power supply of the extension motor driver is on properly 1. Green light is on, check if the red etc. flashes several times, corresponding to the corresponding alarm. Check whether the phase and encoder lines are connected correctly and reliably. 2.</p>

		If the green light is not on, check whether the power supply line of the drive board is connected correctly and reliably.
10	Cutter motor drive alarm	Check whether the cutter motor reset by action, 1 no action, then check the drive power supply and alarm code, motor and the corresponding connection line. 2. have action, then into the input control interface, select the cutter motor forward, then select the cutter motor reverse. Observe whether the cutter motor can be controlled forward and reverse.
11	No cloth alarm is released when the start button is pressed	Please release the cloth before starting.
12	Presser foot motor reset failure alarm	Check whether the presser foot motor has been reset, 1, no action, then check the drive, motor and the corresponding connection line. 2, there is action, then into the input detection interface, with metal contact presser foot motor home sensor, and observe the presser foot motor home signal has not changed. No change and then check whether the presser foot motor origin photo eye connection line is connected reliably and correctly.
13	Extension motor reset failure alarm	Check if there is any action when the extension motor is reset. 1. If there is no action, check the drive, motor and the corresponding connection line. 2. If there is action, enter the input detection interface, touch the extension motor home sensor with metal and observe if there is any

		change in the extension motor home signal. If there is no change, then check whether the expansion motor home photo eye connection line is connected reliably and correctly.
14	No movement alarm on the head	1. check if the head is on. 2. check if the power supply to the head is normal. 3. check if there are any alarms on the head. 4. check if the connection cable between the main control and the head is connected properly.
15	Number of sewn pieces reached	The number of pieces sewn has reached the preset value, please reset the number of pieces sewn.
16	Pressing the start button without resetting the power on	The power-up first needs to be reset before it can be started.