

Automatic Thread

P54 Thread Trummang (ms) P55 Thread Wiping Action Time (ms)

Power On and Positioning

Hold Time of Presser Foo

P58 Up Needle Position Adjus

P59 Down Needle Position Adjustment

P64 Running Time of Testing B and

Machine Protection Switch Selection

P72 Up Needle Position Adjustment 0-1799

P70 The Factory Type Selection P71 Presser Foot Release Operation Duty Cycle (%)

P73 Down Needle Position Adjustment

P60 Testing Speed (rpm) P61 Testing A

P62 Testing B P63 Testing C

P56

P43 Direction of Motor Rotation CCW/CW CCW CCW Counter

ON ON: ON OFF: OFF

DN UP: ON DN: OFF DN UP: ON DN: OFF Display the quan

3.2 Technician Parameter (Press P key to enter)

 P46
 Motor Step with A Reverse Angle after Trimming Function
 ON'OFF
 OFF
 OFF

 P47
 Adjust the Reverse Angle When Motor Skop after Trimming
 50-200
 160
 Adjusting at reverse direction after trimming.

 P48
 The Minimum Speed Limit
 100-500
 210
 Adjusting at reverse direction after trimming.

 Image: symplectic symplecter symplecter symplecter symplecter symplecter sym

10-990 200 Completion of the thread trimming action required tim

10-990 30 Completion of the thread wiping action required time

1-120 10 Forced shut-down after hold time.

0-2 1 Disable 1: Testing zero signal 2: Testing positive signal

36 36: R5 type

0-40 2 The buffer force of presser foot release operation

0: always not to find the up needle position 0-2 2 1: always to find the up needle position 2: If the motor is not into the up needle position, it will find the up needle p

 0-1799
 1360

 0.179
 1360
 when the value mecrasus.

 100-4000
 2000
 Setting toping speed.

 00-COFF
 OFF
 After setting A, continuous running at the speed of [P60 TV]

 0NOFF
 OFF
 Offsetion of Testing B, after setting press.

 0NOFF
 OFfsetion of Testing C, after setting press.
 If the speed secard #

 0NOFF
 OFfsetion of Testing C, after setting press.
 100 set the speed secard #

 0NOFF
 OFfsetion of Testing C, after setting press.
 100 set the speed secard #

 0NOFF
 OFfsetion of Testing B and C

in position adjustment, the needle will advance stop when the v

 P44
 The Rate of Normal Stop
 1-50
 16
 Adjustment of efforts while machine stop.

 P45
 Back-tacking operation Duty
 1-50
 30
 Back-tacking operation in duty cycle to save of the Stop with A Reverse

 P46
 More Stop with A Reverse
 ON-DEE
 DE
 ON-DEE
 DE

 P48
 The Minimum Speed Limit (rgm)
 100-500
 210
 Adjust me humanon -p--(rgm)

 P49
 Theed Trimming Speed (rgm)
 100-500
 250
 Adjust thread trimming upeed P5 Full Organ (rm)

 P5
 Full Organ (rm)
 10-900
 200

 P51
 Presser Fost Lifter Operation Tu-s-, Cvele (%)
 10-40
 2.5
 Presser fost lifter operatio in the tu-s-, we turn, with atti

stment 0-1799 460

P65 Stop Time of Testing B and C 1-250 20 Setting stop time of testing B and C

0-1799

N01 The control system ver N02 The panel version nur N03 Speed N04 The pedal AD N05 The mechanical angle(N06 The mechanical angle(N07 Bushar voltage AD N12 Kneeling device positi

1-50 30 Back-tacking operate in duty cycle to save electricity and protect the electromagnet from over-heat.

10-40 25 Presser foot lifter operate in duty cycle to save electricity and protect the electromagnet from over-heat

P76	Back-tacking Operation Time to Full Output (ms)	10-990	200	Back tacking start action, full output action times.
P78	The Start Angle of Thread Clamping	10-150	110	Positioning angle when start clipping.
P79	The Stop Angle of Thread	160-359	280	Positioning angle when finish clipping.
P80	Clamping The Start Angle of Thread	5-359	18	Shear line infeed id angle setting(under defined as 0°)
P80	Trimming The Angle of the Motor Start to	3-339	18	Snear line inteed to angle setting(under defined as 0)
P81	Increase Torque When Thread Trimming	5-359	140	Torque angle of thread trimming setting (Down position as 0° .
P82	The Stop Angle of Thread Trimming	5-359	172	Feeder back angle of thread trimming setting Down position as 0° .
P83	The Stopping Distance	10-100	33	
P84	The Angle of the Motor Start to Increase Torque When Sewing	0-359	9	
P85	The Angle of the Motor Stop to Increase Torque When Sewing	0-359	57	
P86	The Distance of Up and Down Position	100-1700	900	
P88	The Thread Sweep Back Times	10-990	30	
P89	Alternating Current (AC) Over-voltage Value Set	500-1023	880	
P92	Correct the Electrical Angle of Motor	0-479	445	Reading the initial angle of encoder, the factory default was set, please do not change the value value cannot be changed manually, random change it will result the control loss and motor abe damaged).
P109	The Delay Time Before Thread Sweep	5-990	5	
P110	Trimming Back Delay Time	10-990	60	It only works when thread sweep off, if thread sweep on it will execute delay time before threa
P113	The Periodic Signal of Solenoid Full Output	0-100	95	
P116	The Hook Thread Mode with Clamp Function without Any Thrum the First Stitch Speed	100-800	150	
P117	The Delay Time of the Presser Foot Release Damping Force (ms)	0-990	12	
P118	Disconnection Thread Testing Function	0-1	1	0: OFF 1: ON
P119	Electromagnet Over-current Protection Selection	0-1	0	0: OFF 1: ON
P122	The number of break stitches to stops	0-10	3	If more than setting stitches but still didn't detect the thread, the sewing machine will stop alarm.
P123	Disconnection Thread Testing Alarm Duration	0-2500	5	
P124	Reset			
P125	The Number of Times For Piecework Trimming	1-9	1	Trimming number of times as setting number of times, piecework add 1.
P126	Bobbin Total Stitches Setting	0-9999	2000	when the P127 turn on, the machine working to setting stitches then alarm.
P127	Count Stitches Mode Selection	0-50	0	0: OFF 1: Count full reset but still running 2: Count full to stop machine
P130	Tighter Seam / Short-thread	0-3	2	2 Count tue to stop meetine 0. OFF 1: Skot-thread 2: Tighter sea 3: Tighter sea + short-thread
P131	Tight Seam Speed	100-1200	1000	
P132	Tight Seam Stitches Tight Seam Solenoid Action	0-10	2	
P133	Angle	20-330	115	Tight seam solenoid forward with the lower position start action angle.
P136	Start Back-tacking the First	0-1500	600	Invalid for parameter value as 0

1. Button Display and Operaing Instructions

Reset

Key

1

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1 X

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1.1 Key Description

Back-Tack

Back-Tacking / Needle Stop

tion Selection

Clamp Function Setting

Press Foot Lifting after

Trimming / Press Foot

Free Sewing / Thread

Continuous Back Seam

Shortcuts / Multi-section

unction Parameter Edi

Setting Speed Increase

Parameter Increase

Setting Speed Decre

Parameter Decrease

Left Selection Paramet

Content

Set Needle Shortcuts

Lifting after Pause

ning

nnection Thread Testing Function

wing

wing

End

Operaing Instructions	Right Selection Parameter Content Right selection parameter content
	Restore Factory Long-press 3 sec can restore factory setting.
	2 Control System After Installation Debugging
	2.1 Integrate Control Box Debugging 2.1.1: Enter to User Parameter Mode and Save.
	Long press \textcircled{P} key enter to User Parameter Mode. Press \textcircled{O} or \textcircled{O} to change parameter item, remove cursor, the corresponding digit value is flashing, then press \textcircled{O} or \textcircled{O} to modify this digit value, press
Indicate	Pkey, the whole parameter value is flashing, save the parameter. Press P key again to exit.
If click, execution starting back seam B segment or execution starting back seam (A, B segment) 1 Execution starting back seam (A, B segment) 2 times or turn off.	2.1.2: Enter to Technician Parameter Mode and Save Hold on P key to turn on the machine (show P27) enter to technician parameter mode. Press
I. If click, execution terminates back seam C segment or execution terminates back seam (C, D segment) I Execution terminates back seam (C, D segment) 2 times or turn off. I. If long-press, shift to the needle stop position after shift the sewing mode (Up position / Down position).	change parameter item, remove cursor, the corresponding digit value is flashing, then press \bigoplus or \bigcirc to modify this digit value, press $\widehat{\bigcirc}$ key, the whole parameter value is flashing, save parameter. Press $\widehat{\bigcirc}$ key again to exit.
If click, shift to clamp function (The corresponding icon lights, thread nipper function is turned on / the corresponding icon is not lit, no thread nipper function). If long-press, set used or cancelled disconnection thread testing function	 2.2 Soft start: P14 adjustment in user parameters, Parameter is ON, Parameter is Off (The default value). 2.3 Adjustment speed:
1. If click, when <u>Vik</u> icon is lighting, set used or cancelled press foot lifting after trimming function.	Upper key and lower key to adjustment speed. Press D to accelerate speed, press D to decelerate, each press the adjust vale is 50. For temporary adjust speed, the parameter in accordance with internal parameter of speed adjustment 01, 01
 If long-press, when ⁽¹⁾/_L icon is lighting, set used or cancelled press foot lifting after pause function. 	parameter is limited 4000 2.4 Adjust Up needle position setting
I. If click, shift to free sewing I. If long-press, set used or cancelled thread trimming function.	
I. If click, shift to continuous back seam model. If long-press, shift to multi-section set needle shortcuts.	
In normal mode, Long-press [P] key to enter User Parameter Mode. Press and hold [P] key, then turn on the power to enter Technician Parameter Mode.	Press (©) key to turn on machine, enter to tho PZ? needla up bar det will change as the hand-wheel position).
1. Speed adjust upper key 2. Parameter value increase key	the P72 needle up position adjustment parameter. the P72 needle down position will auto-adjustment). if don't save then press (P) key to exit parameter.
Speed adjust lower key. Z. Parameter value decrease key.	
Left selection parameter content	
2	3

P137 Start Back-tacking the Second Stitch Speed Limit 0		0-1500	800	Invalid for parameter value as 0	
P138 Start Back-tacking the Third Stitch Speed Limit		0-1500	1000	Invalid for parameter value as 0	
P139	Throad Sleaking When Start		0-1	0	0: OFF 1: ON
P140	-	Thread tension release mode 0-2			0: Thread tension release solenoid tension release 1: Trimming solenoid tension release
1140	P140 Thread tension release mode The Start Angle of Function that			0	2: After trimming because tension release mode (it not affect thread tension release action when trimming)
P141		lacking When Start	1-359	1	The start angle of function that thread slacking when start sewing. (as upper needle position angle)
P142	The Stop Angle of Function that		1-359	35	The stop angle of function that thread slacking when start sewing.
P151	Thread Heating Exertion		0-1	0	0: OFF 1: ON
P152	The Dela Hooking	ry Time of Thread	0-990	100	
P153	The Dur Hooking	ation Time of Thread	0-990	30	
P154	The Back Thread H	k Tracking Time of looking	0-990	30	
P155	Thread H Cycle (%	looking Operation Duty	0-100	90	
P156	Duty Cy	oot Lifter Operation cle When Start Sewing	0-100	30	
P157	The Start Angle of Function that P157 Presser Foot Lifting When Start Sewing		1-359	1	The start angle of function that presser foot lifting when start sewing.
P158	The Stop Angle of Function that		1-359	100	The stop angle of function that presser foot lifting when start sewing.
P159	Start Bac	k-tacking Presser Foot unction Switch	0-1	0	0: OFF 1: ON
4	Start Bac Output F	unction Switch ror Code List	t	0	1
4 Error	Start Bac Output F 4 Er	unction Switch	t		Measure
4 Error	Start Bac Output F	unction Switch ror Code List	t		Measure Turn off the machine, check the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service.
4 Error E	Start Bac Output F 4 Er	unction Switch ror Code List Problem de	t		Measure Turn off the machine, check the power supply voltage (Or whether encode the rated voltage of use). If there are still errors, please replace the control hox and call for customer service. Turn off the machine, check the power supply voltage. (Or whether under the rated voltage of use). If there are still errors, please replace the control hox and only for customer service.
4 Error El	Start Bac Output F 4 Er Code	unction Switch ror Code List Problem de Over-voltage	t		Measure Turn off the machine, check the power supply voltage (Or whether encode the rated voltage of use). If there are still errors, please replace the control hox and call for customer service. Turn off the machine, check the power supply voltage. (Or whether under the rated voltage of use). If there are still errors, please replace the control hox and only for customer service.
4 Error El El	Start Bac Output F 4 Er Code 01 02	unction Switch ror Code List Problem de Over-voltage Low-voltage	t		Measure Turn off the machine, chack the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, check the power supply voltage (Or whether under the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation panel in bad control to stat call for customer service.
4 Error El El	Start Bac Output F Code 01 02 03	unction Switch ror Code List Problem de Over-voltage Low-voltage CPU communication et	t		Measure Turn off the machine, check the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, check the power supply voltage (Or whether under the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation panel in the documection or is too boxe. To get it right and turn on £ If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the pedal in bdo somection or is too boxe. To get it right and turn on £ f there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if it is stuck. If it is stuck, you have to rule out the mechanical failure.
4 Error El El	Start Bac Output F Code 01 02 03	unction Switch ror Code List Problem de Over-voltage Low-voltage CPU communication et	t escription		Measure Turn off the machine, check the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, check the power supply voltage (Or whether under the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, please thecks if the operation panel in bad connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the podal in the connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the podal in the connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service. Turn the machine, hendwheel, check if it is stack. If it is stack, you have to rule out the mechanical failure. If connection well, check if the encoder and motor in bad connection or is too loose. If yes, please correct. If connection well, check if the power supply voltage is abnormal or sewing speed is too high. If yes, please adjust.
4 Error El El El	Start Bac Output F 4 Er • Code 01 02 03 05 05	unction Switch ror Code List Problem de Over-voltage Low-voltage CPU communication en Pedal connection error	ror	I I I I I I I I I I I I I I I I I I I	Measure Turn off the machine, check the power supply voltage. (Ar whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, heck the power supply voltage. (Ar whether made the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, henders explace the control box and call for customer service. Turn off the machine, please check if the operation pared in the doomecoint on its too boxe. To get it right and turn on. If there are still errors, please replace the control box and call for customer service. Turn off the machine, handwheid, deach if it is stack. If it is stack, you have to rule out the mechanical failure. If runn merum, check if the encoder and motor in had connection or is too boxe. To get it right and tur off the machine, handwheid, deach if it is stack. If it is stack. Supplement the second off the encoder and motor in had connection or is too boxe. To get it right and turn for numer, there, if the encoder and motor in had connection or is too losse. If yes, please correct. If runn mormat, there, if the encoder and motor in had connection or is too losse. If yes, please correct if there are still errors, please replace the control box and call for customer service. Bads-Tacking electromagnet response time is too long, you have only to restart the machine. If there are still errors, bester proposed time is too long, you have only to restart the machine.
4 Error El El El El	Start Bac Output F Code 01 02 03 05 07	Inetion Switch ror Code List Problem de Over-voltage Low-voltage CPU communication en Pedal connection error Motor locked-rotor error Manual reverse feeding	ror	i i i i i i i i i i i i i i i i i i i	Measure Turn off the machine, check the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, check if the operation panel in bad connection or is too loose. To get it right and turn on ff there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation panel in bad connection or is too loose. To get it right and turn on ff there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the podal in the connection or is too loose. To get it right and turn on ff there are still errors, please replace the control box and call for customer service. Turn the machine handwheel, check if it is stack. If it is stack, you have to rule out the mechanical failure. If turn normal, check if the power supply voltage is abnormal or serving speed is too high. If yes, please adjust. If there are still errors, please replace the control box and call for customer service. If the still errors, please replace the control box and connection or is too loose. To get it right and turn on fit there are still errors, please replace the control box and connection or sits too loose. If yes, please correct, if connection well, check if the power supply voltage is abnormal or serving speed is too high. If yes, please adjust. If there are still errors, please replace the control box and call for customer service. Extended the externation is too looy, you have only to restart the machine.
4 Enver	Start Bac Output F 4 Err 7 Code 01 02 03 05 07 08 08	Incrine Switch ror Code List Problem de Over-voltage Low-voltage CPU communication en Pedal connection error Motor locked-rotor error Manual reverse facéing 15 seconds	ror soperation m	ore than 1	Measure Turn off the machine, check the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, check if the operation panel in had connection or is too losse. To get it right and turn on if there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation panel in had connection or is too losse. To get it right and turn on if there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the pedal in the connection or is too losse. To get it right and turn on if there are still errors, please replace the control box and call for customer service. Turn the machine, handwheel, check if it is stack. If it is stack, you have to rule out the mechanical failure. If there are still errors, please replace the control box and call for customer service. If ronnection well, check if the power supply voltage is abnormal or seving speed is too high. If yes, please adjust - Takes Table customer service. The face still errors, please replace the control box and call for customer service. The still errors, please replace the control box and call for customer service. The still errors, please replace the control box and call for customer service. The still errors, please replace the control box and call for customer service. The still errors E-08 after restart the machine, check if the manual reverse feeding switch is tamped.
4 Error El El El El E E E	Start Bac Output F 4 Er Code 01 02 03 05 07 08 10 09	Inertion Switch ror Code List Problem de Over-voltage Low-voltage CPU communication en Pedal connection error Motor locked-rotor error Manual reverse feeding 15 seconds Solenoid over-current	ror soperation m	i i i i i i i i i i i i i i i i i i i	Measure Turn off the machine, check the power supply voltage. (Dr whether exceed the rated voltage of use), if there are still errors, please replace the control box and call for customer service. Turn off the machine, check the power supply voltage. (Dr whether mader the rated voltage of use), if there are still errors, please neghece the control box and call for customer service. Turn off the machine, please check if the pecation panel to had connection or is too bose. To get it right and turn on II there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the pecation panel to had connection or is too bose. To get it right and turn on. If there are still errors, please the control box and call for customer service. Turn the machine, handwhed, heck if it is stack. If it is stack, you have to rule out the mechanical failure. To mechanical failure. To mechanical failure. There are still errors, please neglence the control box and call for customer service. There are still errors, please the control box and call for customer service. There are still errors, please the control box and call for customer service. There are still errors, please the control box and call for customer service. There are still errors, please the control box and call for customer service. There are still errors, please the control box and call for customer service. There are still errors, please the control box and call for customer service. There are still errors, please the conder in bad connection or is too loss. To get it right and turn of the machine, please check the related circuit is abouted and maged. Turn of the machine, please check the related circuit is abouted or damaged. Turn of the machine, please check the related circuit is abouted or is a stoo. For still are strict. There are still errors, please replace the control box and call for customer service. There are still errors, please there there ender in add connection or is too loss. To get it right and tu
4 Error El El El El E E	Start Back School Schoo	Inction Switch Problem de Over-voltage Low-voltage CPU communication en Pedal connection error Motor locked-rotor error Manual reverse feeding 15 seconds Solenoid over-current Positioning signal error Encoder error Power supply	t roor g operation m	I I I I I I I I I I I I I I I I I I I	Measure Turn off the machine, check the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, check the power supply voltage (Or whether under the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the pedal in bud connection or is too boxe. To get it right and turn on if there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the pedal in bud connection or is too boxe. To get it right and turn on if there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the control box and call for customer service. Turn off the machine, please check if the control box and call for customer service. If there are still errors, please replace the control box and call for customer service. Turn the machine, check if the encoder and motor in bud connection or is too losse. If yes, please correct. If there are still errors, please replace the control box and call for customer service. Bask-Tacking electromagnet responses time is too long, you have only to restart the machine. If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the related circuit is shorted or damagnd. Turn off the machine, please check the related circuit is shorted or damagnd. Turn off the machine, please check if the related circuit is shorted or tamagnet. Turn off the machine, please check if the related recuit is borted or tamagnet. Turn off the machine, please check if the related recuit is borted or the customer service. Turn off the machine, please check if the related recuit is borted or tamagnet. Turn off the machine, please check if the related recuit is borted or tamagnet. Turn off the machine, please check if the related recu
4 Error Bi Bi Bi Bi E E E E E E	Start Bash and Compare F	Inertion Switch FOT COde List Problem de Over-voltage Low-voltage CPU communication en Pedal connection error Motor locked-rotor error Manual reverse feeding 15 seconds Solenoid over-current Positioning signal error Encoder error	t scription mor		Measure Turn off the machine, check the power supply voltage (Ar whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation pare in the dotter and the rated voltage of use). If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation pare in the dotter or sto boxes. To get it right and turn on. If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation pare in the dotter or sto boxes. To get it right and turn on. If there are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the operation pare in the adotterion or is to boxe. To get it right encoded and motor in had connection or is no boxe. To get it right and ture off the machine of the encoder and motor in bad connection or is to boxe. They, please correct. There are still errors, please replace the control box and call for customer service. Turn off the machine. These replace the control box and call for customer service. Turn off the machine. There are still errors, please replace the control box and call for customer service. Turn off the machine, please check if the nonucl serves the form service the ending solute is to ball. Turn off the machine, please check if the recoder in bad connection or is too lose. To get it right and turn on. If there are still errors, please endpect the encoded creating solute or too lose. To get it right and turn on. If there are still errors, please replace the control on and call for customer service. Turn off the machine, please check if the prover support or too lose. To get it right and turn on. If there are still errors, please replace the control on and call for customer service. Turn off the machine, please check if the prove support to a lose. To get it right and turn on.

5

	B Parameter	Dafir		
	5 rarameter	Dem	nuon	
3	3.1 User Parame	eter (T	urn o	n the machine long-press P key for 3 sec. to enter)
				 <i>,</i>
io. 01	Items	Range 200,5000	Default 4000	Description Maximum and of multi-communication
101 202	Maximum Sewing Speed (rpm) Set Accelerated Curve (%)	200-5000	4000	Maximum speed of machine sewing Set the acceleration slope
P03	Needle UP/DOWN	UP/DN	DN	UP: Needle Stops at Up Position
				DN: Needle Stops at Down Position
P04 P05	Start Back-tacking Speed (rpm) End Back-tacking Speed (rpm)	200-3200 200-3200	1800 1800	Set Start Back-Tacking Speed Set End Back-Tacking Speed
P06	Bar-tacking Speed (rpm)	200-3200	1800	Set Ena Back-1 acking Speed Set Repeat Bar-Tacking Speed
1 07	Soft Start Speed (rpm)	200-1500	400	Set Soft Start Speed
P08	Stitch Numbers for Soft Start	0-99	2	Soft Start Stitches Setting
209	Automatic Constant-stitch Sewing Speed (rpm)	200-4000	3500	Speed adjustment for automatic constant-stitch sewing
	Sewing Speed (rpm)			
P10	Automatic End Back-tacking	ON/OFF	ON	ON: After last seam of constant stitch sewing, it will automatic execute the End Back-Tacking sewing function. When turn on, the Stitch-Correction is invalid.
	Sewing			OFF: Automatic End Back-Tacking will not execute after last seam, but can be done by pedal manually.
P11				J: JUKI Mode (Press TB switch will activate reverse solenoid when either machine is stopped or running).
rll	Back-tacking Mode Selection	J/B	1	B: BROTHER Mode (Press TB switch will activate reverse solenoid only when machine is running).
	Start Back-tacking			A: Automatically perform actions
P12	Running Mode Selection	A/M	Α	M: Could be arbitrarily stop and start
	Ending mode of Start			CON: Start Back-Tacking is completed automatically continued for next action.
P13	Ending mode of Start Back-tacking	CON/STP	CON	CON: Start Back-Tacking is completed automatically continued for next action. STP: After the number of stitches is completed, stop automatically.
P14	Slow Start Function Selection	ON/OFF	OFF	on a subset of success sconformer, softwareners,
				0: half stitch;
P15	Mending stitch mode	0-2	2	1: one stitch;
P16	Back-tacking Speed Limit	0-3200	0	2: continuous half stitch. When the parameter is 0, the speed limit function is OFF.
	Start Back-tacking			
P18	Start Back-tacking Compensation 1	0-200	146	Stitch Balance for end back-tacking A section, 0~200 action gradually delay; the large value, the longer of the A section last stitch, and the shorter of the B section first stitch.
	Start Back-tacking			
P19	Compensation 2	0-200	156	Stitch Balance for end back-tacking B section, 0-200 action gradually delay; the large value, the longer of the B section first stitch.
P20	End Back-tacking	A/M	А	A: Automatically perform actions
	Running Mode Selection			M: Could be arbitrarily stop and start
P21	The Position of the Pedal for	30,1000	\$20	
P21	Running	30-1000	520	
P22	The Position of the Pedal for the	30-1000	420	
	Stop The position of the Pedal for			
P23	Lifting Presser Foot	30-1000	260	
P24	The position of the Pedal for	30-500	130	
P24	Thread Trimming	30-500	130	
P25	End Back-tacking	0,200	131	Stitch Balance for end back-tacking C section, 0-200 action gradually delay; the large value, the shorter of the C section first stitch.
	Compensation 3	0-200		and a second of the C second of the c second of the c second first sheet.
P26	End Back-tacking	0-200	156	Stitch Balance for end back-tacking D section, 0-200 action gradually delay; the large value, the longer of the C section last stitch, and the
r.20	Compensation 4	0-200	156	shorter of the D section first stitch.
	Bar-tacking Running Mode			A: Automatically perform actions
P28	Selection	A/M	А	M: Could be arbitrarily stop and start
	The Rate of Thread Trimming			
P29	The Rate of Thread Trimming Stop	1-50	24	
P30	The Strength of the Motor	0-100	0	
r.50	Torque When Sewing	0-100	U	
P31	The Strength of the Motor	0-100	40	
	Torque When Thread Trimming			
P32	Bar-tacking Compensation 5	0-200	131	Stitch Balance for start back-tacking A(C) section, 0-200 action gradually delay; the large value, the longer of the A(C) section last stitch;
				the shorter of the B(D) section first stitch.
				Stitch Balance for start back-tacking B(D) section, 0-200 action gradually delay; the large value, the longer of the B(D) section last stitch;
P33	Bar-tacking Compensation 6	0-200	156	the shorter of the C section first stitch.
	Constant-stitch Sewing			1: Automatically perform actions
P34	Running Mode Selection	0-1	1	0: Could be arbitrarily stop and start
235	Counting Mode Selection	0-1	0	0: Manual counting 1: Automatic counting
236	Thread Slacking Function	0-11	0	0: OFF
<i>.</i> 0	Selection	0-11	U	1-11:The strength of thread slacking
	Automatic Thread			0 : OFF
P37	Wiping Function / Automatic Thread	0-11	8	1: Automatic thread wiping Function
	Clamping Function Selection			2-11: Automatic thread clamping Function and the strength of automatic thread clamping.

